孔加工・螺纹加工工具

OSG Corporation

DRILLING THREADING TOOLS

2023-2024

标识种类 Guide of (Tool Specification) Icons

1 材质 Tool Materials

PCD 人造金刚石 Polycrystalline Diamond
刃部材料使用人造金刚石烧结体。

CARBIDE 硬质合金 Tungsten Carbide
刃部材料使用硬质合金。

SPH 超级含钴高速钢 Super Premium HSS
使用含有钴的材料。

XPM 高级粉末高速钢 High grade Powder Metallurgy HSS (XPM)
高级粉末高速钢

CPM 粉末高速钢 Powder Metallurgy HSS (CPM)
使用含有钴的材料。

HSS-Co 含钴高速钢 Cobalt HSS
使用含有钴的材料。

HSSE 含钒高速钢 High Vanadium HSS
使用部分含有钴的材料。

HSS 高速钢 HSS
使用部分含有钴的材料。

2 表面处理 Surface Treatment

EgiAs EgiAs 涂层 EgiAs Coating
高韧性 · 耐磨性优良。

WDI WDI涂层 WDI Coating
耐磨性 · 高温导热性。

WXS WXS涂层 WX Super Coating
氧化温度 1300℃起，超耐热超硬涂层

WXL WXL涂层 WXL Coating
具有优秀的耐磨损性和耐溶着性，适应广泛的加工材料。

WX WX涂层 (TiAlN 系涂层) WX (TiAlN) Coating
除传统特性外，还具有较好的耐氧化性，可实现高速加工。

FX FX涂层 (TiAlN 系涂层) FX (TiAlN) Coating
除传统特性外, 还具有较好的耐氧化性, 可实现高速加工。

V V 涂层 (复合多层涂层) V (composite multi-layered) Coating
耐溶着性 · 耐磨损性优良。

TiCN TiCN涂层 TiCN Coating
耐溶着性 · 耐磨性优良。

IchAda IchAda 涂层 IchAda Coating
具有优良的平滑性，耐磨损性、耐热性。

HR HR涂层 HR Coating
耐溶着性，耐磨损性优良。

TiN TiN涂层 TiN Coating
耐溶着性，耐磨损性优良。

DIA DIA 涂层 Diamond Coating
耐溶着性，耐磨损性优良。

DLC DLC涂层 DLC Coating
耐溶着性，耐磨损性优良。

DLC-IGUSS DLC-IGUSS 涂层 DLC-IGUSS Coating
耐溶着性，耐磨损性优良。

CrN CrN 涂层 CrN Coating
对铜加工有良好的耐磨性、耐溶着性。

SS Smooth 涂层 Smooth Coating
平滑性、耐磨损性、耐溶着性优良。

H 氧化处理 Steam Oxide
氧化处理防止溶着。

N 氮化处理 Nitride
实施氮化处理，提高耐磨性。

NZ 特殊表面处理 NZ Treatment

3 外径 · 直径的公差 Tolerance for drill diameter

h8
表示钻头直径的容许差。
Tolerance for drill diameter.

表示铰刀的外径。
Tolerance for reamer diameter.

4 柄部 Shank

SHANK h7
表示柄部精度。
Tolerance for shank diameter.

SHRINK FIT
也推荐热膨胀刀具系列。
Suitable for the shrink holder system.

5 螺旋角 Helix Angle

30°
表示钻头、丝锥排屑槽的螺旋角度。
Display helix angle of flute for drills and taps.

OSG 孔加工・螺纹加工工具 OSG Drilling/Threading Tools Catalogue

钻头 DRILLS P.10 ～
倒角钻 CHAMFERING P.325 ～
平头钻/沉孔 FLAT DRILLS/COUNTERBORING P.344 ～
铰刀 REAMER P.373 ～
丝锥 TAPS P.462 ～
量规 GAUGES P.870 ～
板牙工具 ROUND DIES P.972 ～
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索引 INDEX 产品索引表 CLASSIFIED BY ALPHABETICAL ORDER P.1018 ～

【别册】OSG 铣削加工工具 OSG Milling Tools Catalogue

- 硬质合金铣刀 CARBIDE END MILLS
- 高速钢立铣刀 HSS END MILLS
- 可转位式刀具 INDEXABLE TYPE CUTTERS

拆卸式工具保管库/电镀金刚石工具
REMOVABLE TOOL STORAGE CABINET / ELECTROPLATED DIAMOND TOOLS

使用商品目录之前 INFORMATION

本商品目录所登载的产品式样是2022年12月发表的。由于产品经常需要更新改良，本商品目录所登载的式样可能会有变动。另外，库存品有时会出现缺货的情况。废番记载为2022年12月的信息，本商品目录发刊后，可能有视情况废番的产品。

The information on tool specification and discontinued products on this catalogue is as of December 2022. Tool specification is subject to change without notice. Depending on the situation, some products may be sold out or get discontinued.

■ISO9001 認証取得 ISO9001 Certification
八名工場・新城工場・豊橋工場・大池工場
OSG was certified by ISO9001 for the quality management system at the following factories: Yana Factory, Shinshiro Factory, Toyohashi Factory, and Oike Factory.
JQA-2856

■ISO14001 認証取得 ISO14001 Certification
本社・八名工場・新城工場・豊橋工場・大池工場・
豊川工場・R&Dセンター・アカデミー
OSG was certified by ISO14001 for the environmental management system at the following factories and offices: Head Office,Yana Factory, Shinshiro Factory, Toyohashi Factory, Oike Factory, Honnogahara Center and Academy.
JQA-EM1088

ISO13399记号一览表《字母顺序》

Designation list conformed with ISO 13399 《In alphabetical order》

根据2019-2020 年版综合样本，如以下所示开始实行ISO13399 的尺寸记号。
符号以及符号相对应的内容如下表所示。

Starting from the 2019-2020 general catalog, designations based on the ISO 13399 standard will be applied.
Details corresponding to designations are listed in the chart below.

1.钻头·铰刀 Drill, Reamer

记　号	内　容	Descriptions
ADJLX	最大调整界限	adjustment limit maximum
APMX	最大切深	depth of cut maximum
CBDP	安装孔深	connection bore depth
CZC	连接尺寸	connection size code
DC	切削直径	cutting diameter
DCN	最小切削直径	cutting diameter minimum
DCON	连接直径	connection diameter
DCONMS	机械端连接直径	connection diameter machine side
DCONWS	工件端连接直径	connection diameter workpiece side
DCSFMS	接触面直径	contact surface diameter machine side
DCX	最大切削直径	cutting diameter maximum
DMIN	最小加工直径	minimum bore diameter
DN	颈径	neck diameter
HAND	切削方向	hand
KWW	键槽宽	keyway width
LCF	槽长	length chip flute
LF	功能长度	functional length
LH	颈长	head length
LPR	工具悬伸量长度	protruding length
LS	刀柄长度	shank length
LU	使用可能长度	usable length
OAL	全长	overall length
PL	顶端与肩部的尺寸差	point length
RE	圆弧角 R	corner radius
SIG	先端角	point angle
TCL	切削锥部长度	tap chamfer length
WF	功能宽度	functional width
ZEFP	径向有效切削刃数	peripheral effective cutting edge count

2.刀片 Insert

记　号	内　容	Descriptions
AN	主偏角后角	clearance angle major
HAND	切削方向	hand
IC	内接圆	inscribed circle diameter
L	切削刃长度	cutting edge length
LE	有效切削刃长度	cutting edge effective length
RE	刃角半径	corner radius
S	刀片厚度	insert thickness
TP	螺纹螺距	thread pitch
TPI	螺纹牙数 / 英寸	threads per inch
W1	刀片宽度	insert width

3. 螺纹铣刀 Thread Mill

记 号	内 容	Descriptions
APMX	最大切深	depth of cut maximum
BD	刀体直径	body diameter
CBDP	安装孔深	connection bore depth
DCD	钻头部直径	cutting diameter drilling part
DCON	连接直径	connection diameter
DCSFMS	接触面直径	contact surface diameter machine side
DCX	最大切削直径	cutting diameter maximum
DN	颈长	neck diameter
KWW	键槽宽	keyway width
LF	功能长度	functional length
LU	可用长度	usable length
OAL	全长	overall length
TP	螺纹螺距	thread pitch
TPI	螺纹牙数 / 英寸	threads per inch
ZEFP	径向有效切削刃数	peripheral effective cutting edge count

4. 丝锥 Tap

记 号	内 容	Descriptions
DCON	连接直径	connection diameter
DN	颈径	neck diameter
DRVS	四方部宽度	drive size
FHA	螺旋角角度	flute helix angle
LB	刀体长度	body length
LF	功能长度	functional length
LU	使用可能长度	usable length
NOF	刃数	flute count
TCL	切削锥部长度	tap chamfer length
THLGTH	螺纹长	thread length

1. 上表的记号遵循ISO13399。
2. 本样本使用ISO13399中未包含的部分符号。
3. 因为包括正在协商的符号，所以有可能需要更改或增加。

1. The designations in the above table conform to ISO 13399.
2. This catalog may contain some designations which are not included in ISO 13399.
3. Please note that some of the designations may be subject to changed based on updates from ISO 13399.

综合样本使用说明

G-LIST No. **DW1075**

硬质合金内冷油孔钻头 3D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (3D TYPE)

A The A Brand

ADO-3D

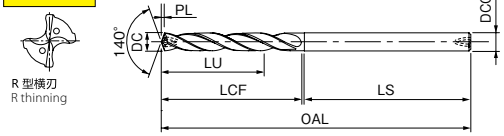
切削条件 Cutting Conditions | P.390

OSG GROUP（国内、海外）统一LIST No.

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

R Gash



单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8690200	2 - 3	6	12			51.2	0.4	●	7
8690210	2.1 - 3		13			50.3	0.4	●	7
8690220	2.2 - 3	7	14			49.5	0.4	●	7
8690230	2.3 - 3					49.7	0.4	●	7
8690240	2.4 - 3		15			48.9	0.4	●	7
8690250									

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8700450	4.5	14	27	80	6	49.2	0.8	●	26
8690460	4.6 - 5		28		5	50.3	0.8	●	19
8700460	4.6				6	48.4	0.8	●	26
8690470	4.7 - 5		29		5	49.4	0.9	●	20
8700470	4.7				6	47.6	0.9	●	26
8690									20

产品重量（g/支/包含盒子）

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C~0.25%	中碳素钢 Medium Carbon Steel C0.25~0.45%	高碳素钢 High Carbon Steel C0.45%~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel ~35 HRC	35~45 HRC	淬火钢 Quenched and Tempered Steel 45~50 HRC	50~62 HRC	62~70 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD SKS	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜合金 Copper Alloy Cu	变形铝 Aluminum AL	铸造铝合金 Aluminum Alloy Casting AC	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy AZ91D	金属基复合材料 (MMC) Metal Matrix Composites
ADO-3D	◎	◎	◎	◎	◎	○	○			○	○	◎	◎	○		○	○	○		○	

可对应的加工材质

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

OSG 最新情报，尽早入手！！

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或搜索“OSGCHINA”添加我司官微

（1） 可以第一时间获取我司新产品资讯；
（2） 可以了解我司最新的市场动态；
（3） 我司定期会在官微上发布一些技术专题。

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(双休日，节假日除外)

常年为客户提供技术解决方案。

- 难加工材料的切削条件选定!
- 深孔对应的长钻头用哪把合适?
- 螺纹检测用的量规选定方法?
- 加工中抑制振动的方法?
- 与广泛加工材料对应的丝锥?

OSG提供免费技术热线，在您遇到任何技术困难时请联系我们吧!

讲习会

OSG能为客户提供完整的道具培训。我们非常乐意分享我们丰富的加工经验，
在最大程度上为您提高加工效率。

■出差讲习会

根据客户定下的日期，地点，主题，我们可以进行讲习会对应。

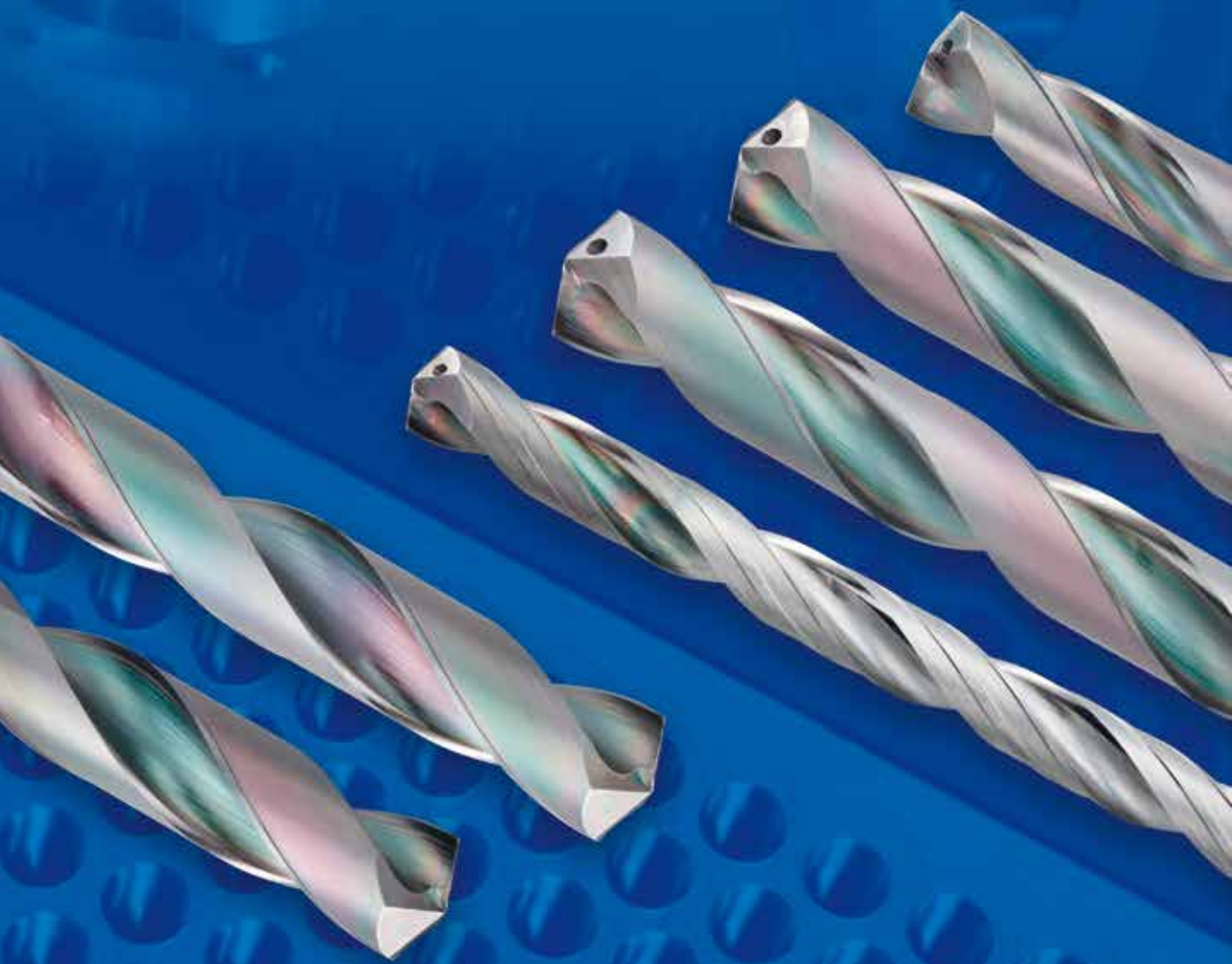
根据客户需要制作讲习内容。

shaping your dreams

High performance and versatile

AD • ADO

Solid and Coolant-Through Carbide Drills



The A Brand

shaping your dreams

Ultra-efficiency in deep-hole drilling applications

ADO-40D • 50D

Coolant-Through Carbide Drills

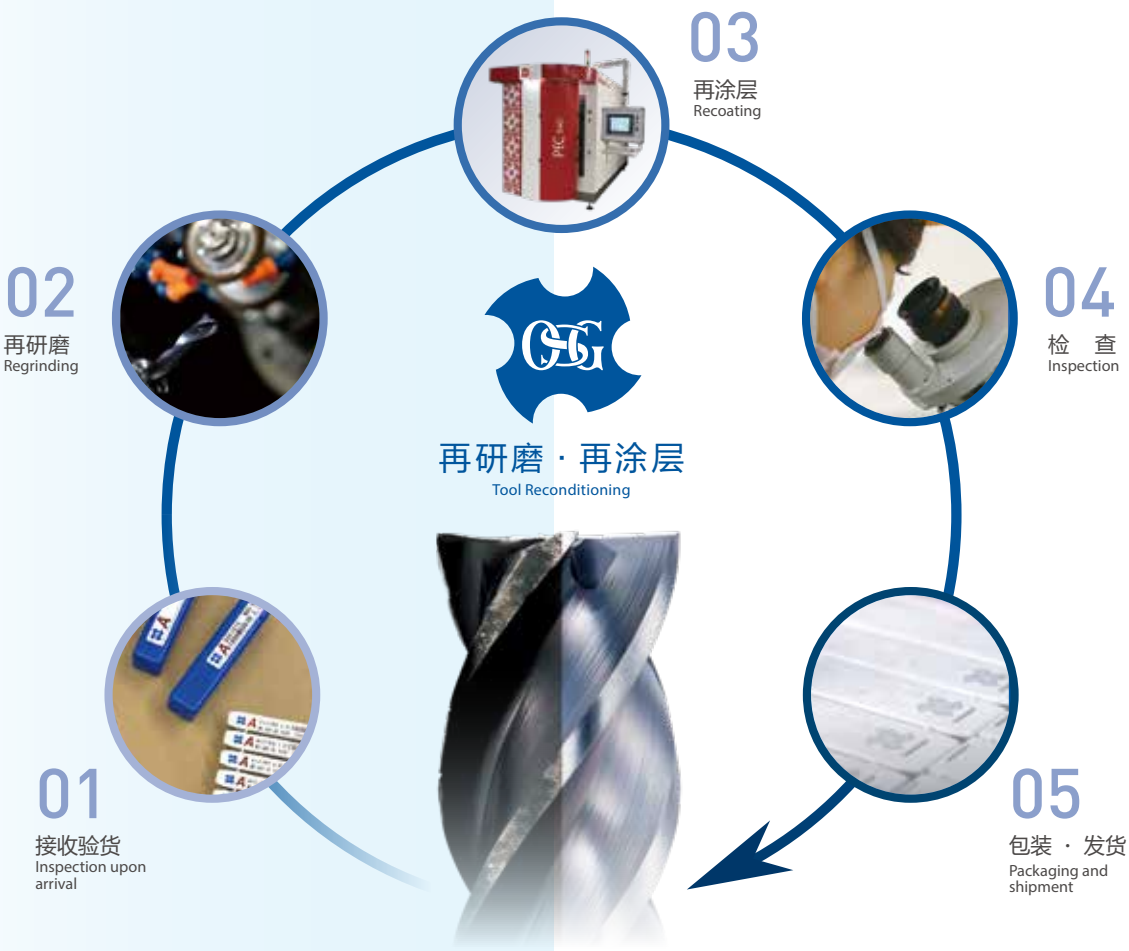
The A Brand

再研磨 · 再涂层

Tool Reconditioning

始终支持再研磨 ·再涂层

Coherent support system for tool reconditioning



OSG 是一家综合刀具制造商，拥有多年的刀具设计经验和涂层技术，能够最大限度实现与新品同等的切削性能和刀具寿命。

由于 OSG 的再研磨 · 再涂层是由本社集团公司对应，所以可一并接受处理。

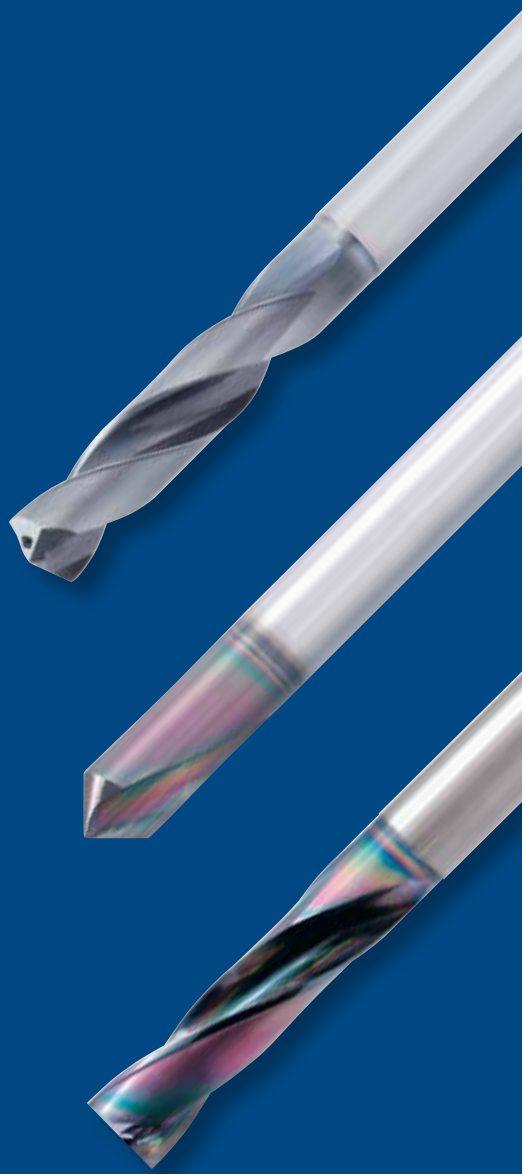
As a comprehensive cutting tool manufacturer with tool design and coating technology know-how cultivated over many years, OSG is capable of restoring used tools to like-new condition. Tool reconditioning is handled by OSG group companies with a coherent support system to enable a seamless process.

再研磨 · 再涂层促进了环境友好

Tool reconditioning promotes resource conservation and is environmentally friendly

无法再使用的工具的翻新和再利用，有助于节约资源和全球 环境保护活动。

Tool reconditioning contributes to resource conservation by bringing worn cutting tools back to life, which is environmentally friendly and sustainable.



钻头
DRILLS

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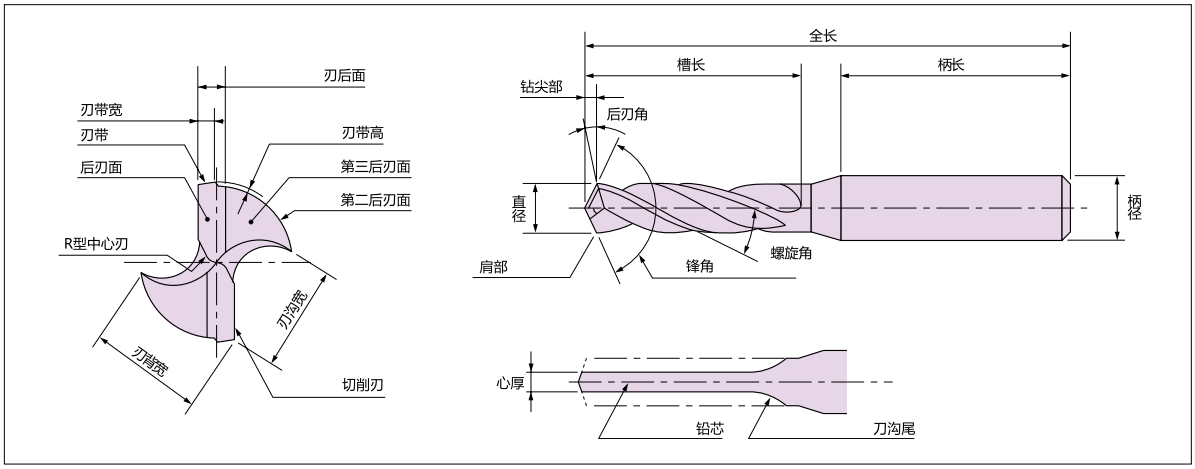
●本样本登载的产品，虽标有库存，但由于新材料、新产品的开发，更改废番的情况也有。
●式样，形状，表内数值也可能会有变动。

●The inventory status is indicated for respective products on this catalogue. However, the products may be improved or discontinued due to development of new materials and products, etc.
●Specifications, shapes, values in the tables, etc. are subject to change without prior notice.

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

钻头选型前言

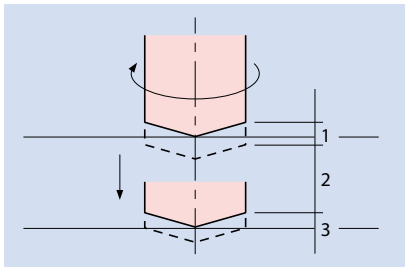
■各部分名称



■切屑的生成和排出

传统的麻花钻头在设计时考虑的是如何将呈连续卷曲状的切屑沿排屑槽排出。因此，较长的切屑容易缠绕在钻头上或机器主轴上，这样易发生危险。

而EX 黄金钻头能将切屑分断的细小均匀，不但提高了操作性和安全性，而且可应用在加工中心和自动化设备的无人作业中。



1. 吃入时　2. 中央　3. 退刀时

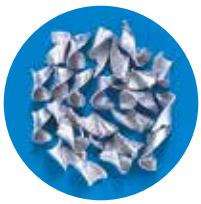
■黄金钻头和一般钻头的切屑比较

切削条件
钻头直径：EX-GDS　φ12
加工材料：S45C
切削油剂：水溶性切削油剂
切削速度：25m/min
进给速度：0.16㎜ /rev

EX- 黄金钻头　一般钻头

■切屑示例

SUS304
EX-SUS-GDR φ8.5
切削速度　18m/min
进 给 量　0.2㎜ /rev



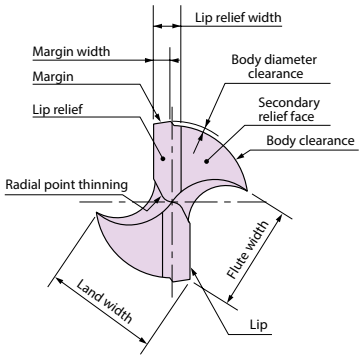
A7075
EX-SUS-GDR φ8.5
切削速度　50m/min
进 给 量　0.45㎜ /rev

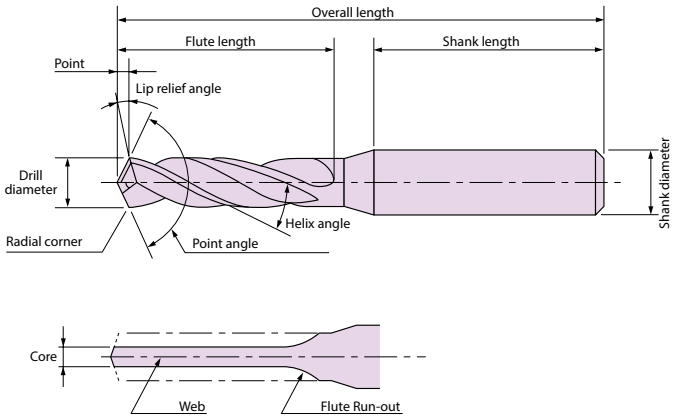
SCM440
VP-GDR φ8.5
切削速度　32m/min
进 给 量　0.24㎜ /rev

C1020(铜)
EX-SUS-GDR φ8.5
切削速度　32m/min
进 给 量　0.24㎜ /rev

INFORMATION FOR THE USER

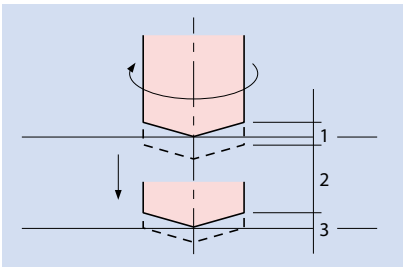
TERMINOLOGY





CHIP SHAPE

Conventional drills produce long curly chips, which can get tangled in the spindle or the workpiece. Thanks to it's unique point design, the EX-GOLD drill produces short, broken chips. This feature improves automated drilling operations as operators do not be need to beside the machine to manage chip ejection.



1. Top of hole　2. Middle of hole　3. Breakthrough

DIFFERENCES IN CHIP SHAPE

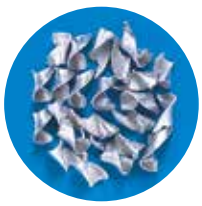
Cutting Conditions

Drill diameter : EX-GDS　ϕ 12
Work material : JIS S45C
Coolant: water-soluble oil
Speed : 25m/min.
Feed : 0.16mm/rev.

EX-GOLD drill　Conventional drill

CHIP SHAPES PRODUCED WITH EX-GOLD DRILL

SUS304
EX-SUS-GDR ϕ8.5
Speed : 18m/min
Feed : 0.2㎜ /rev



A7075
EX-SUS-GDR ϕ8.5
Speed : 50m/min
Feed : 0.45㎜ /rev

SCM440
VP-GDR ϕ8.5
Speed : 32m/min
Feed : 0.24㎜ /rev

C1020(Copper)
EX-SUS-GDR ϕ8.5
Speed : 32m/min
Feed : 0.24㎜ /rev

钻头选型基准表 DRILLS SELECTION CHART

2D以下 FOR DRILLING DEPTH ≦2D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	137	AD-2D		硬质合金钻头 2D型 Carbide Drill (2D type)	EgiAs	φ2～φ20	○
	141	AD-4D		硬质合金钻头 4D型 Carbide Drill (4D type)	EgiAs	φ2～φ20	○
	144	NEW ADO-MICRO 2D		小径内冷油孔硬质合金钻头 2D型 Small Diameter Carbide Drill with Internal Coolant Supply (2D type)	IchAda	φ0.7～φ2	○
	145	NEW ADO-MICRO 5D		小径内冷油孔硬质合金钻头 5D型 Small Diameter Carbide Drill with Internal Coolant Supply (5D type)	IchAda	φ0.7～φ2	○
	149	ADO-3D		硬质合金内冷油孔钻头 3D型 Carbide Drill with Internal Coolant Supply (3D type)	EgiAs	φ2～φ20	○
	153	ADO-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	φ2～φ20	○
	157	ADO-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	EgiAs	φ2～φ16	○
	172	ADO-PLT		超长刃钻头用硬质合金导向钻 Pilot Drill for Extra Long Drill	EgiAs	φ3.03~φ12.03	○
	173	ADO-SUS-3D		硬质合金内冷油孔钻头 3D型 Carbide Drill with Internal Coolant Supply (3D type)	WXL	φ2～φ20	○
	176	ADO-SUS-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	WXL	φ2～φ20	○
	180	ADO-SUS-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	WXL	φ2～φ12	○
	182	ADO-TRS-3D		3刃内冷油孔硬质合金钻头 3D型 3 Flutes Carbide Drill with Internal Coolant Supply (3D type)	EgiAs	φ3～φ20	○
	184	ADO-TRS-5D		3刃内冷油孔硬质合金钻头 5D型 3 Flutes Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	φ3～φ20	○
	191	UVM-DRL-5D		极小径硬质合金钻头 5D 型 Ultra Small Carbide Drill (5D type)	SS	φ0.02~φ0.09	○
	194	WX-MS-GDS		极小径·精密加工用硬质合金钻头 超短刃型 Carbide Stub for Byway and Precision Processing	WX	φ0.2～φ5	○
	203	NF-GDN		非铁金属加工用硬质合金钻头 中等刃长型 Carbide Medium for Non-Ferrous Metal	—	φ3～φ13	○
	208	FH-GDS		高硬度钢用硬质合金钻头 超短刃型 Carbide Stub for Hardened Steels	FX	φ0.3～φ2	○
	209	FH-GDN		高硬度钢用硬质合金钻头 中等刃长型 Carbide Medium for Hardened Steels	FX	φ0.3～φ2	○
	210	WH55-5D		高硬度钢(~55HRC)用硬质合金钻头 5D型 Carbide Drill for High Hardened Steel (~55HRC· 5D type)	WXS	φ2～φ12	○
	211	WHO55-5D		高硬度钢(~55HRC)用硬质合金内冷油孔钻头 5D型 Carbide Drill for High Hardened Steel with Internal Coolant Supply (~55HRC· 5D type)	WXS	φ3.3~φ12	○
	212	WH70-DRL		高硬度钢(~70HRC)用硬质合金钻头 Carbide Drill for High Hardened Steel (~70HRC)	WXS	φ2～φ12	○
	214	SH-DRL		高硬度钢用硬质合金钻头 Carbide Drill for High Hardened Steel	—	φ2.4~φ11.6	○
	344	ADF-2D		硬质合金平头钻 2D 型 Carbide Flat Drill (2D type)	EgiAs IchAda	φ0.2～φ20	○
	356	ADFLS-2D		硬质合金平头钻 长柄 2D型 Carbide Flat Drill · Long Shank (2D type)	EgiAs	φ3～φ20	○
	359	ADFO-3D		硬质合金内冷油孔平头钻 3D 型 Carbide Flat Drill with Internal Coolant Supply (3D type)	EgiAs	φ3～φ20	○

钻头选型基准表 DRILLS SELECTION CHART

2D以下 FOR DRILLING DEPTH ≦2D

◎=Best
○=Good

加工材料 WORK MATERIAL

低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基复合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

2D以下 FOR DRILLING DEPTH ≦2D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
可转位式钻头 Indexable Drills	221	PXD(PC)		可换头式钻头 (钢用) Exchangeable Head Drill (for Steel)	—	φ14~φ25.4	○
	223	PXD(KC)		可换头式钻头 (铸件用) Exchangeable Head Drill (for Cast Iron)	—	φ14~φ25.4	○
	225	PXD(NC)		可换头式钻头 (非铁金属用) Exchangeable Head Drill (for Nonferrous Metal)	—	φ14~φ25.4	○
	227	PHP		可转位式钻头 直柄型 Indexable Type Drill with Straight Shank	—	φ14~φ40	○
	229	P2D		可转位式直柄钻头 2D型 Indexable Type Drill with Straight Shank (2D type)	—	φ12~φ63	○
	231	P3D		可转位式直柄钻头 3D型 Indexable Type Drill with Straight Shank (3D type)	—	φ12~φ63	○
	233	P4D		可转位式直柄钻头 4D型 Indexable Type Drill with Straight Shank (4D type)	—	φ12~φ63	○
	235	P5D		可转位式直柄钻头 5D型 Indexable Type Drill with Straight Shank (5D type)	—	φ12~φ63	○
	239	NEW PDZ		可转位平头钻 Indexable Flat Drill	—	φ16~φ43	○
金刚石钻头 Diamond Drills	243	D-GDN		金刚石涂层硬质合金钻头 Diamond Coated Carbide	DIA	φ2~φ12	○
	248	D-STAD		CFRP用金刚石涂层硬质合金三角钻头 Diamond Coated Carbide Triple Angle Drill for Composite Material	DIA	φ2.502~9.55	○
	249	D-DAD		CFRP用金刚石涂层硬质合金双角钻头 Diamond Coated Carbide Double Angle Drill For Composite Material	DIA	φ2.502~9.55	○
	251	D-GDN90		CFRP用金刚石涂层硬质合金钻头 先端角90° Diamond Coated 90 Degree Point Angle Drill For Composites	DIA	φ2.502~9.55	○
VP 黄金钻头 VP-Gold Drills	253	VPH-GDS		调质钢用粉末高速钢超短刃型钻头 Powder Metallurgy Stub for Hardened Steel	V WDI	φ0.5~φ20	○
	261	VP-GDR		超级含钴高速钢标准刃长型钻头 Super Premium HSS Regular	V	φ1.8~φ32	○
	265	VP-HO-GDS		高速加工用粉末高速钢内冷油孔超短刃型钻头 Powder HSS Stub with Internal Coolant Supply for High Speed Processing	V	φ6~φ26	○
	268	VP-HO-GDR		高速加工用粉末高速钢内冷油孔钻头 Powder Metallurgy Regular for High Speed Processing with Internal Coolant Supply	V	φ6~φ32	○

钻头选型基准表 DRILLS SELECTION CHART

2D以下 FOR DRILLING DEPTH ≦2D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

2D以下 FOR DRILLING DEPTH ≦2D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
EX 黄金钻头 EX-Gold Drills	271	NEXUS-GDS		高速钢NEXUS钻头 超短刃型 NEXUS Drill Stub	WDI	ϕ1～ϕ12	
	272	NEXUS-GDR		高速钢NEXUS钻头 标准刃长型 NEXUS Drill Regular	WDI	ϕ2～ϕ12	
	273	EX-SUS-GDS		不锈钢·软钢用超短刃型钻头 Stub for Stainless and Mild Steels	TiN	ϕ0.5～ϕ32	
	281	EX-SUS-GDN		不锈钢·软钢用中等刃长型钻头 Medium for Stainless Steels	TiN	ϕ1～ϕ1.99	
	283	EX-SUS-GDR		不锈钢·软钢用标准刃长型钻头 Regular for Stainless and Mild Steels	TiN	ϕ2～ϕ32	
	289	MT-SUS-GDR		不锈钢·软钢用MT柄钻头 Regular with Morse Taper Shank for Stainless Steels	TiN	ϕ6～ϕ50	
	290	EX-GDS		一般加工用超短刃型钻头 Stub for General Applications	TiN	ϕ1～ϕ13	○
	293	EX-LS-GDS		一般加工用长柄超短刃型钻头 Stub with Long Shank for General Applications	TiN	ϕ2.5～ϕ10.8	○
	294	EX-GDN		一般加工用中等刃长型钻头 Medium for General Applications	TiN	ϕ0.5～ϕ6	○
	297	EX-GDR		一般加工用标准刃长型钻头 Regular for General Applications	TiN	ϕ2～ϕ32	○
	305	EX-HO-GDR		一般加工用内冷油孔标准刃长型钻头 Regular with Internal Coolant Supply for General Applications	TiN	ϕ6～ϕ40	○
	307	EX-MT-GDR		一般加工用MT柄标准刃长型钻头 Regular with Morse Taper Shank for General Applications	TiN	ϕ6～ϕ50	○
车床用钻头 Lathe Drills	316	V-MT-GDN		车床用钻头 For Lathe Machine	V	ϕ6～ϕ32	
钢筋用钻头 Steel Frame/Hard Drills	318	EX-MT-TDR		钢筋用钻头 For Steel Frame (Selections and Sheet Plates)	TiN	ϕ17.5～ϕ26	
	319	EX-H-DRL		清除折损丝锥用 EX Hard Drills for removing Taps	—	ϕ2～ϕ12	○
泛用型钻头 General-Purpose Drills	321	V-SDR		一般用途钻头 Regular	V	ϕ2～ϕ13	

钻头选型基准表 DRILLS SELECTION CHART

2D以下 FOR DRILLING DEPTH ≦2D

◎=Best
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加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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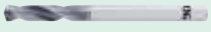
钻头选型基准表 DRILLS SELECTION CHART

3D以下 FOR DRILLING DEPTH ≦3D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	141	AD-4D		硬质合金钻头 4D型 Carbide Drill (4D type)	EgiAs	ϕ2～ϕ20	○
	145	NEW ADO-MICRO 5D		小径内冷油孔硬质合金钻头 5D型 Small Diameter Carbide Drill with Internal Coolant Supply (5D type)	IchAda	ϕ0.7～ϕ2	○
	149	ADO-3D		硬质合金内冷油孔钻头 3D型 Carbide Drill with Internal Coolant Supply (3D type)	EgiAs	ϕ2～ϕ20	○
	153	ADO-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	ϕ2～ϕ20	○
	157	ADO-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	EgiAs	ϕ2～ϕ16	○
	173	ADO-SUS-3D		硬质合金内冷油孔钻头 3D型 Carbide Drill with Internal Coolant Supply (3D type)	WXL	ϕ2～ϕ20	○
	176	ADO-SUS-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	WXL	ϕ2～ϕ20	○
	180	ADO-SUS-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	WXL	ϕ2～ϕ12	○
	182	ADO-TRS-3D		3刃内冷油孔硬质合金钻头 3D型 3 Flutes Carbide Drill with Internal Coolant Supply (3D type)	EgiAs	ϕ3～ϕ20	○
	184	ADO-TRS-5D		3刃内冷油孔硬质合金钻头 5D型 3 Flutes Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	ϕ3～ϕ20	○
	191	UVM-DRL-5D		极小径硬质合金钻头 5D 型 Ultra Small Carbide Drill (5D type)	SS	ϕ0.02～ϕ0.09	○
	194	WX-MS-GDS		极小径·精密加工用硬质合金超短刃型钻头 Carbide Stub for Byway and Precision Processing	WX	ϕ0.2～ϕ5	○
	203	NF-GDN		非铁金属加工用硬质合金中等刃长型钻头 Carbide Medium for Non-Ferrous Metal	—	ϕ3～ϕ13	○
	208	FH-GDS		高硬度钢用硬质合金超短刃型钻头 Carbide Stub for Hardened Steels	FX	ϕ0.3～ϕ2	○
	209	FH-GDN		高硬度钢用硬质合金中等刃长型钻头 Carbide Medium for Hardened Steels	FX	ϕ0.3～ϕ2	○
	210	WH55-5D		高硬度钢(~55HRC)用硬质合金钻头 5D型 Carbide Drill for High Hardened Steel (~55HRC· 5D type)	WXS	ϕ2～ϕ12	○
	211	WHO55-5D		高硬度钢(~55HRC)用硬质合金内冷油孔钻头 5D 型 Carbide Drill for High Hardened Steel with Internal Coolant Supply (~55HRC· 5D type)	WXS	ϕ3.3～ϕ12	○
	212	WH70-DRL		高硬度钢(~70HRC)用硬质合金钻头 Carbide Drill for High Hardened Steel (~70HRC)	WXS	ϕ2～ϕ12	○
	214	SH-DRL		高硬度钢用硬质合金钻头 Carbide Drill for High Hardened Steel	—	ϕ2.4～ϕ11.6	○
	359	ADFO-3D		硬质合金内冷油孔平头钻 3D型 Carbide Flat Drill with Internal Coolant Supply (3D type)	EgiAs	ϕ3～ϕ20	○

钻头选型基准表 DRILLS SELECTION CHART

3D以下 FOR DRILLING DEPTH ≦3D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

3D以下 FOR DRILLING DEPTH ≦3D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
可转位式钻头 Indexable Drills	221	PXD(PC)		可换头式钻头 (钢用) Exchangeable Head Drill (for Steel)	—	φ14~φ25.4	○
	223	PXD(KC)		可换头式钻头 (铸件用) Exchangeable Head Drill (for Cast Iron)	—	φ14~φ25.4	○
	225	PXD(NC)		可换头式钻头 (非铁金属用) Exchangeable Head Drill (for Nonferrous Metal)	—	φ14~φ25.4	○
	227	PHP		可转位式钻头 直柄型 Indexable Type Drill with Straight Shank	—	φ14~φ40	○
	231	P3D		可转位式直柄钻头 3D型 Indexable Type Drill with Straight Shank (3D type)	—	φ12~φ63	○
	233	P4D		可转位式直柄钻头 4D型 Indexable Type Drill with Straight Shank (4D type)	—	φ12~φ63	○
	235	P5D		可转位式直柄钻头 Indexable Type Drill with Straight Shank	—	φ12~φ63	○
	239	NEW PDZ		可转位平头钻 Indexable Flat Drill	—	φ16~φ43	○
金刚石钻头 Diamond Drills	243	D-GDN		金刚石涂层硬质合金钻头 Diamond Coated Carbide	DIA	φ2~φ12	○
	248	D-STAD		CFRP用金刚石涂层硬质合金三角钻头 Diamond Coated Carbide Triple Angle Drill for Composite Material	DIA	φ2.502~9.55	○
	249	D-DAD		CFRP用金刚石涂层硬质合金双角钻头 Diamond Coated Carbide Double Angle Drill For Composite Material	DIA	φ2.502~9.55	○
	251	D-GDN90		CFRP用金刚石涂层硬质合金钻头 先端角90° Diamond Coated 90 Degree Point Angle Drill For Composites	DIA	φ2.502~9.55	○
VP 黄金钻头 VP-Gold Drills	253	VPH-GDS		调质钢用粉末高速钢超短刃型钻头 Powder Metallurgy Stub for Hardened Steel	V WDI	φ0.5~φ20	○
	261	VP-GDR		超级含钴高速钢标准刃长型钻头 Super Premium HSS Regular	V	φ1.8~φ32	○
	265	VP-HO-GDS		高速加工用粉末高速钢内冷油孔超短刃型钻头 Powder HSS Stub with Internal Coolant Supply for High Speed Processing	V	φ6~φ26	○
	268	VP-HO-GDR		高速加工用粉末高速钢内冷油孔钻头 Powder Metallurgy Regular for High Speed Processing with Internal Coolant Supply	V	φ6~φ32	○

钻头选型基准表 DRILLS SELECTION CHART

3D以下 FOR DRILLING DEPTH ≦3D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基复合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

3D以下 FOR DRILLING DEPTH ≦3D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
EX 黄金钻头 EX-Gold Drills	271	NEXUS-GDS		高速钢NEXUS钻头 超短刃型 NEXUS Drill Stub	WDI	φ1～φ12	
	272	NEXUS-GDR		高速钢NEXUS钻头 标准刃长型 NEXUS Drill Regular	WDI	φ2～φ12	
	273	EX-SUS-GDS		不锈钢·软钢用超短刃型钻头 Stub for Stainless and Mild Steels	TiN	φ0.5～φ32	
	281	EX-SUS-GDN		不锈钢·软钢用中等刃长型钻头 Medium for Stainless Steels	TiN	φ1～φ1.99	
	283	EX-SUS-GDR		不锈钢·软钢用标准刃长型钻头 Regular for Stainless and Mild Steels	TiN	φ2～φ32	
	289	MT-SUS-GDR		不锈钢·软钢用MT柄钻头 Regular with Morse Taper Shank for Stainless Steels	TiN	φ6～φ50	
	290	EX-GDS		一般加工用超短刃型钻头 Stub for General Applications	TiN	φ1～φ13	○
	293	EX-LS-GDS		一般加工用长柄超短刃型钻头 Stub with Long Shank for General Applications	TiN	φ2.5～φ10.8	○
	294	EX-GDN		一般加工用中等刃长型钻头 Medium for General Applications	TiN	φ0.5～φ6	○
	297	EX-GDR		一般加工用标准刃长型钻头 Regular for General Applications	TiN	φ2～φ32	○
	305	EX-HO-GDR		一般加工用内冷油孔标准刃长型钻头 Regular with Internal Coolant Supply for General Applications	TiN	φ6～φ40	○
	307	EX-MT-GDR		一般加工用MT柄标准刃长型钻头 Regular with Morse Taper Shank for General Applications	TiN	φ6～φ50	○
车床用钻头 Lathe Drills	316	V-MT-GDN		车床用钻头 For Lathe Machine	V	φ6～φ32	
钢筋用钻头 Steel Frame/Hard Drills	318	EX-MT-TDR		钢筋用钻头 For Steel Frame (Selections and Sheet Plates)	TiN	φ17.5～φ26	
泛用型钻头 General-Purpose Drills	321	V-SDR		一般用途钻头 Regular	V	φ2～φ13	

钻头选型基准表 DRILLS SELECTION CHART

3D以下 FOR DRILLING DEPTH ≦3D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

4D以下 FOR DRILLING DEPTH ≦4D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	141	AD-4D		硬质合金钻头 4D型 Carbide Drill (4D type)	EgiAs	ϕ2～ϕ20	○
	145	NEW ADO-MICRO 5D		小径内冷油孔硬质合金钻头 5D型 Small Diameter Carbide Drill with Internal Coolant Supply (5D type)	IchAda	ϕ0.7～ϕ2	○
	153	ADO-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	ϕ2～ϕ20	○
	157	ADO-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	EgiAs	ϕ2～ϕ16	○
	176	ADO-SUS-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	WXL	ϕ2～ϕ20	○
	180	ADO-SUS-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	WXL	ϕ2～ϕ12	○
	184	ADO-TRS-5D		3刃内冷油孔硬质合金钻头 5D型 3 Flutes Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	ϕ3～ϕ20	○
	191	UVM-DRL-5D		极小径硬质合金钻头 5D型 Ultra Small Carbide Drill (5D type)	SS	ϕ0.02～ϕ0.09	○
	194	WX-MS-GDS		极小径·精密加工用硬质合金钻头 超短刃型 Carbide Stub for Byway and Precision Processing	WX	ϕ0.2～ϕ5	○
	203	NF-GDN		非铁金属加工用硬质合金钻头 中等刃长型 Carbide Medium for Non-Ferrous Metal	—	ϕ3～ϕ13	○
	208	FH-GDS		高硬度钢用硬质合金超短刃型钻头 Carbide Stub for Hardened Steels	FX	ϕ0.3～ϕ2	○
	209	FH-GDN		高硬度钢用硬质合金中等刃长型钻头 Carbide Medium for Hardened Steels	FX	ϕ0.3～ϕ2	○
	210	WH55-5D		高硬度钢(~55HRC)用硬质合金钻头 5D型 Carbide Drill for High Hardened Steel (~55HRC· 5D type)	WXS	ϕ2～ϕ12	○
	211	WHO55-5D		高硬度钢(~55HRC)用硬质合金内冷油孔钻头 5D型 Carbide Drill for High Hardened Steel with Internal Coolant Supply (~55HRC· 5D type)	WXS	ϕ3.3～ϕ12	○
可转位式钻头 Indexable Drills	221	PXD(PC)		可换头式钻头 (钢用) Exchangeable Head Drill (for Steel)	—	ϕ14～ϕ25.4	○
	223	PXD(KC)		可换头式钻头 (铸件用) Exchangeable Head Drill (for Cast Iron)	—	ϕ14～ϕ25.4	○
	225	PXD(NC)		可换头式钻头 (非铁金属用) Exchangeable Head Drill (for Nonferrous Metal)	—	ϕ14～ϕ25.4	○
	227	PHP		硬质合金可转位式钻头 直柄型 Indexable Type Drill with Straight Shank	—	ϕ14～ϕ40	○
	233	P4D		可转位式直柄钻头 4D型 Indexable Type Drill with Straight Shank (4D type)	—	ϕ12～ϕ63	○
	235	P5D		可转位式直柄钻头 Indexable Type Drill with Straight Shank	—	ϕ12～ϕ63	○

钻头选型基准表 DRILLS SELECTION CHART

4D以下 FOR DRILLING DEPTH ≦4D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基复合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

4D以下 FOR DRILLING DEPTH ≦4D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
金刚石钻头 Diamond Drills	243	D-GDN		金刚石涂层硬质合金钻头 Diamond Coated Carbide	DIA	ϕ2～ϕ12	○
	248	D-STAD		CFRP用金刚石涂层硬质合金三角钻头 Diamond Coated Carbide Triple Angle Drill for Composite Material	DIA	ϕ2.502~9.55	○
	249	D-DAD		CFRP用金刚石涂层硬质合金双角钻头 Diamond Coated Carbide Double Angle Drill For Composite Material	DIA	ϕ2.502~9.55	○
	251	D-GDN90		CFRP用金刚石涂层硬质合金钻头 先端角90° Diamond Coated 90 Degree Point Angle Drill For Composites	DIA	ϕ2.502~9.55	○
VP 黄金钻头 VP-Gold Drills	253	VPH-GDS		调质钢用粉末高速钢超短刃型钻头 Powder Metallurgy Stub for Hardened Steel	V WDI	ϕ0.5～ϕ20	○
	261	VP-GDR		超级含钴高速钢标准刃长型钻头 Super Premium HSS Regular	V	ϕ1.8～ϕ32	○
	268	VP-HO-GDR		高速加工用粉末高速钢内冷油孔钻头 Powder Metallurgy Regular for High Speed Processing with Internal Coolant Supply	V	ϕ6～ϕ32	○
EX 黄金钻头 EX-Gold Drills	271	NEXUS-GDS		高速钢NEXUS钻头超短刃型 NEXUS Drill Stub	WDI	ϕ1～ϕ12	
	272	NEXUS-GDR		高速钢NEXUS钻头标准刃长型 NEXUS Drill Regular	WDI	ϕ2～ϕ12	
	273	EX-SUS-GDS		不锈钢·软钢用超短刃型钻头 Stub for Stainless and Mild Steels	TiN	ϕ0.5～ϕ32	
	281	EX-SUS-GDN		不锈钢·软钢用中等刃长型钻头 Medium for Stainless Steels	TiN	ϕ1～ϕ1.99	
	283	EX-SUS-GDR		不锈钢·软钢用标准刃长型钻头 Regular for Stainless and Mild Steels	TiN	ϕ2～ϕ32	
	289	MT-SUS-GDR		不锈钢·软钢用MT柄钻头 Regular with Morse Taper Shank for Stainless Steels	TiN	ϕ6～ϕ50	
	290	EX-GDS		一般加工用超短刃型钻头 Stub for General Applications	TiN	ϕ1～ϕ13	○
	293	EX-LS-GDS		一般加工用长柄超短刃型钻头 Stub with Long Shank for General Applications	TiN	ϕ2.5~ϕ10.8	○
	294	EX-GDN		一般加工用中等刃长型钻头 Medium for General Applications	TiN	ϕ0.5～ϕ6	○
	297	EX-GDR		一般加工用标准刃长型钻头 Regular for General Applications	TiN	ϕ2～ϕ32	○
	305	EX-HO-GDR		一般加工用内冷油孔标准刃长型钻头 Regular with Internal Coolant Supply for General Applications	TiN	ϕ6～ϕ40	○
	307	EX-MT-GDR		一般加工用MT柄标准刃长型钻头 Regular with Morse Taper Shank for General Applications	TiN	ϕ6～ϕ50	○
车床用钻头 Lathe Drills	316	V-MT-GDN		车床用钻头 For Lathe Machine	V	ϕ6～ϕ32	
钢筋用钻头 Steel Frame/Hard Drills	318	EX-MT-TDR		钢筋用钻头 For Steel Frame (Selections and Sheet Plates)	TiN	ϕ17.5~ϕ26	
泛用型钻头 General-Purpose Drills	321	V-SDR		一般用途钻头 Regular	V	ϕ2～ϕ13	

钻头选型基准表 DRILLS SELECTION CHART

4D以下 FOR DRILLING DEPTH ≦4D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

5D以下 FOR DRILLING DEPTH ≦5D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	145	NEW ADO-MICRO 5D		小径内冷油孔硬质合金钻头 5D型 Small Diameter Carbide Drill with Internal Coolant Supply (5D type)	IchAda	ϕ0.7～ϕ2	○
	153	ADO-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	ϕ2～ϕ20	○
	157	ADO-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	EgiAs	ϕ2～ϕ16	○
	176	ADO-SUS-5D		硬质合金内冷油孔钻头 5D型 Carbide Drill with Internal Coolant Supply (5D type)	WXL	ϕ2～ϕ20	○
	180	ADO-SUS-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	WXL	ϕ2～ϕ12	○
	184	ADO-TRS-5D		3刃内冷油孔硬质合金钻头 5D型 3 Flutes Carbide Drill with Internal Coolant Supply (5D type)	EgiAs	ϕ3～ϕ20	○
	191	UVM-DRL-5D		极小径硬质合金钻头 5D型 Ultra Small Carbide Drill (5D type)	SS	ϕ0.02～ϕ0.09	○
	203	NF-GDN		非铁金属加工用硬质合金中等刃长型钻头 Carbide Medium for Non-Ferrous Metal	—	ϕ3～ϕ13	○
	209	FH-GDN		高硬度钢用硬质合金中等刃长型钻头 Carbide Medium for Hardened Steels	FX	ϕ0.3～ϕ2	○
	210	WH55-5D		高硬度钢 (~55HRC) 用硬质合金钻头 5D型 Carbide Drill for High Hardened Steel (～55HRC・5D type)	WXS	ϕ2～ϕ12	○
	211	WHO55-5D		高硬度钢 (~55HRC) 用硬质合金内冷油孔钻头 5D型 Carbide Drill for High Hardened Steel with Internal Coolant Supply (～55HRC・5D type)	WXS	ϕ3.3～ϕ12	○
可转位式钻头 Indexable Drills	221	PXD(PC)		可换头式钻头 (钢用) Exchangeable Head Drill (for Steel)	—	ϕ14～ϕ25.4	○
	223	PXD(KC)		可换头式钻头 (铸件用) Exchangeable Head Drill (for Cast Iron)	—	ϕ14～ϕ25.4	○
	225	PXD(NC)		可换头式钻头 (非铁金属用) Exchangeable Head Drill (for Nonferrous Metal)	—	ϕ14～ϕ25.4	○
	235	P5D		可换头式直柄钻头 Indexable Type Drill with Straight Shank	—	ϕ12～ϕ63	○
金刚石钻头 Diamond Drills	243	D-GDN		金刚石涂层硬质合金钻头 Diamond Coated Carbide	DIA	ϕ2～ϕ12	○
VP 黄金钻头 VP-Gold Drills	261	VP-GDR		超级含钴高速钢标准刃长型钻头 Super Premium HSS Regular	V	ϕ1.8～ϕ32	○
	270	VP-GDXL		粉末高速钢长刃型 Powder HSS Long	V	ϕ3～ϕ10	○
	268	VP-HO-GDR		高速加工用粉末高速钢内冷油孔钻头 Powder Metallurgy Regular for High Speed Processing with Internal Coolant Supply	V	ϕ6～ϕ32	○

钻头选型基准表 DRILLS SELECTION CHART

5D以下 FOR DRILLING DEPTH ≦5D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基复合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

5D以下 FOR DRILLING DEPTH ≦5D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
EX 黄金钻头 EX-Gold Drills	272	NEXUS-GDR		高速钢NEXUS钻头标准刃长型 NEXUS Drill Regular	WDI	φ2～φ12	
	281	EX-SUS-GDN		不锈钢·软钢用中等刃长型钻头 Medium for Stainless Steels	TiN	φ1～φ1.99	
	283	EX-SUS-GDR		不锈钢·软钢用标准刃长型钻头 Regular for Stainless and Mild Steels	TiN	φ2～φ32	
	289	MT-SUS-GDR		不锈钢·软钢用MT柄钻头 Regular with Morse Taper Shank for Stainless Steels	TiN	φ6～φ50	
	294	EX-GDN		一般加工用中等刃长型钻头 Medium for General Applications	TiN	φ0.5～φ6	◯
	297	EX-GDR		一般加工用标准刃长型钻头 Regular for General Applications	TiN	φ2～φ32	◯
	301	EX-GDXL		一般加工用长刃型钻头 Long for General Applications	TiN	φ2～φ13	◯
	305	EX-HO-GDR		一般加工用内冷油孔标准刃长型钻头 Regular with Internal Coolant Supply for General Applications	TiN	φ6～φ40	◯
	307	EX-MT-GDR		一般加工用MT柄标准刃长型钻头 Regular with Morse Taper Shank for General Applications	TiN	φ6～φ50	◯
车床用钻头 Lathe Drills	316	V-MT-GDN		车床用钻头 For Lathe Machine	V	φ6～φ32	
钢筋用钻头 Steel Frame/Hard Drills	318	EX-MT-TDR		钢筋用钻头 For Steel Frame (Selections and Sheet Plates)	TiN	φ17.5～φ26	

钻头选型基准表 DRILLS SELECTION CHART

5D以下 FOR DRILLING DEPTH ≦5D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
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钻头选型基准表 DRILLS SELECTION CHART

8D以下 FOR DRILLING DEPTH ≦8D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	146	NEW ADO-MICRO 12D		小径内冷油孔硬质合金钻头 12D型 Small Diameter Carbide Drill with Internal Coolant Supply (12D type)	IchAda	ϕ1～ϕ2	○
	157	ADO-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	EgiAs	ϕ2～ϕ16	○
	160	ADO-10D		硬质合金内冷油孔钻头 10D型 Carbide Drill with Internal Coolant Supply (10D type)	EgiAs	ϕ2～ϕ12.5	○
	180	ADO-SUS-8D		硬质合金内冷油孔钻头 8D型 Carbide Drill with Internal Coolant Supply (8D type)	WXL	ϕ2～ϕ12	○
	190	TRS-HO-10D		3刃内冷油孔硬质合金钻头 10D型 3 Flutes Carbide Drill with Internal Coolant Supply 10D type	WDI	ϕ5～ϕ12	○
	192	UVM-DRL-10D		极小径硬质合金钻头 10D型 Ultra Small Carbide Drill (10D type)	SS	ϕ0.02~ϕ0.09	○
	215	FHL-GDTS		高硬度钢用硬质合金3刃长颈型钻头 Carbide 3 Flutes Long Neck for Hardened Steels	FX	ϕ1～ϕ3	○
VP 黄金钻头 VP-Gold Drills	270	VP-GDXL		粉末高速钢长刃型钻头 Powder Metallurgy Long	V	ϕ3～ϕ10	○
EX 黄金钻头 EX-Gold Drills	301	EX-GDXL		一般加工用长刃型钻头 Long for General Applications	TiN	ϕ2～ϕ13	○
TDXL 钻头 TDXL Drills	310	TDXL-10D		高速钢超长刃型钻头 10D型 HSS Extra-Long Drill (10D type)	WXL	ϕ1.6～ϕ12	○

10D以下 FOR DRILLING DEPTH ≦10D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	146	NEW ADO-MICRO 12D		小径内冷油孔硬质合金钻头 12D型 Small Diameter Carbide Drill with Internal Coolant Supply (12D type)	IchAda	ϕ1～ϕ2	○
	160	ADO-10D		硬质合金内冷油孔钻头 10D型 Carbide Drill with Internal Coolant Supply (10D type)	EgiAs	ϕ2～ϕ12.5	○
	190	TRS-HO-10D		3刃内冷油孔硬质合金钻头 10D型 3 Flutes Carbide Drill with Internal Coolant Supply 10D type	WDI	ϕ5～ϕ12	○
	192	UVM-DRL-10D		极小径硬质合金钻头 10D型 Ultra Small Carbide Drill (10D type)	SS	ϕ0.02~ϕ0.09	○
	201	MRS-GDL		不锈钢加工用小径钻头 Micro Revolution Carbide Drill for Stainless	SS	ϕ0.5～ϕ3	○
	215	FHL-GDTS		高硬度钢用硬质合金3刃长颈型钻头 Carbide 3 Flutes Long Neck for Hardened Steels	FX	ϕ1～ϕ3	○
VP 黄金钻头 VP-Gold Drills	270	VP-GDXL		粉末高速钢长刃型钻头 Powder Metallurgy Long	V	ϕ3～ϕ10	○
EX 黄金钻头 EX-Gold Drills	301	EX-GDXL		一般加工用长刃型钻头 Long for General Applications	TiN	ϕ2～ϕ13	○
TDXL 钻头 TDXL Drills	310	TDXL-10D		高速钢超长刃型钻头 10D型 HSS Extra-Long Drill (10D type)	WXL	ϕ1.6～ϕ12	○

钻头选型基准表 DRILLS SELECTION CHART

8D以下 FOR DRILLING DEPTH≦8D

◎=Best
○=Good

加工材料 WORK MATERIAL

低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基复合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	
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○	◎	◎	◎							○	◎	◎			◎				◎	

* 不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

10D以下 FOR DRILLING DEPTH≦10D

加工材料 WORK MATERIAL

低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基复合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	
◎	◎	◎	◎	○					○*	○	◎	◎								
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* 不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

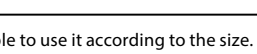
钻头选型基准表 DRILLS SELECTION CHART

15D以下 FOR DRILLING DEPTH ≦15D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	147	NEW ADO-MICRO 20D		小径内冷油孔硬质合金钻头 20D型 Small Diameter Carbide Drill with Internal Coolant Supply (20D type)	IchAda	ϕ1～ϕ2	○
	162	ADO-15D		硬质合金内冷油孔钻头 15D型 Carbide Drill with Internal Coolant Supply (15D type)	EgiAs	ϕ3～ϕ12.5	○
	205	CAO-GDXL		铜·铝加工用硬质合金内冷油孔超长刃型钻头 Carbide Extra Long for Copper Alloys and Aluminum Alloys with Internal Coolant Supply	—	ϕ3～ϕ10	○
	215	※ FHL-GDTS		高硬度钢用硬质合金3刃长颈型钻头 Carbide 3 Flutes Long Neck for Hardened Steels	FX	ϕ1～ϕ3	○
VP 黄金钻头 VP-Gold Drills	270	※ VP-GDXL		粉末高速钢长刃型钻头 Powder Metallurgy Long	V	ϕ3～ϕ10	○
EX 黄金钻头 EX-Gold Drills	301	※ EX-GDXL		一般加工用长刃型钻头 Long for General Applications	TiN	ϕ2～ϕ13	○
TDXL 钻头 TDXL Drills	312	TDXL-15D		高速钢超长刃型钻头 15D型 HSS Extra Long (15D type)	WXL	ϕ1.6～ϕ12	○

※ 中少数尺寸无法加工。　※：It is not possible to use it according to the size.

20D以下 FOR DRILLING DEPTH ≦20D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	147	NEW ADO-MICRO 20D		小径内冷油孔硬质合金钻头 20D型 Small Diameter Carbide Drill with Internal Coolant Supply (20D type)	IchAda	ϕ1～ϕ2	○
	164	ADO-20D		硬质合金内冷油孔钻头 20D型 Carbide Drill with Internal Coolant Supply (20D type)	EgiAs	ϕ3～ϕ12.5	○
	166	ADO-25D		硬质合金内冷油孔钻头 25D型 Carbide Drill with Internal Coolant Supply (25D type)	EgiAs	ϕ3～ϕ12	○
	205	CAO-GDXL		铜·铝加工用硬质合金内冷油孔超长刃型钻头 Carbide Extra Long for Copper Alloys and Aluminum Alloys with Internal Coolant Supply	—	ϕ4～ϕ10	○
	215	※ FHL-GDTS		高硬度钢用硬质合金3刃长颈型钻头 Carbide 3 Flutes Long Neck for Hardened Steels	FX	ϕ1～ϕ3	○
	217	FTO-M-GDXL		模具加工用内冷油孔硬质合金超长刃型钻头 Carbide Extra Long for Molds with Internal Coolant Supply	FX	ϕ10	○
	218	FTO-H-GDXL		高硬度模具用内冷油孔硬质合金超长刃型钻头 Carbide Extra Long Drill for Hard Mold Materials with Internal Coolant Supply	FX	ϕ6～ϕ10	○
EX 黄金钻头 EX-Gold Drills	301	※ EX-GDXL		一般加工用长刃型钻头 Long for General Applications	TiN	ϕ2～ϕ13	○
TDXL 钻头 TDXL Drills	314	TDXL-20D		高速钢超长刃型钻头 20D型 HSS Extra Long (20D type)	WXL	ϕ1.6～ϕ12	○

※中少数尺寸无法加工。　※：It is not possible to use it according to the size.

钻头选型基准表 DRILLS SELECTION CHART

15D以下 FOR DRILLING DEPTH≦15D

◎=Best
○=Good

加工材料 WORK MATERIAL

低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	
◎	◎	◎	◎	○					○*	○	◎	◎								
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○	◎	◎	◎							○	◎	◎			◎				◎	

* 不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

20D以下 FOR DRILLING DEPTH≦20D

◎=Best
○=Good

加工材料 WORK MATERIAL

低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	
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○	◎	◎	◎							○	◎	◎			◎				◎	

* 不建议加工奥氏体不锈钢。
*We don't recommend it for Austenitic Stainless Steel drilling.
※2 使用FTO-H-GDXL 的加工建议在55HRC 以下。
※2 We recommend 55HRC and under for the drilling process by FTO-H-GDXL.

钻头选型基准表 DRILLS SELECTION CHART

30D以下 FOR DRILLING DEPTH ≦30D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	148	NEW ADO-MICRO 30D		小径内冷油孔硬质合金钻头 30D型 Small Diameter Carbide Drill with Internal Coolant Supply (30D type)	IchAda	ϕ1～ϕ2	○
	168	ADO-30D		硬质合金内冷油孔钻头 30D型 Carbide Drill with Internal Coolant Supply (30D type)	EgiAs	ϕ3～ϕ10	○
	205	CAO-GDXL		铜·铝加工用硬质合金内冷油孔超长刃型钻头 Carbide Extra Long for Copper Alloys and Aluminum Alloys with Internal Coolant Supply	—	ϕ5～ϕ8	○

40D以下 FOR DRILLING DEPTH ≦40D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	170	NEW ADO-40D		硬质合金内冷油孔钻头 40D型 Carbide Drill with Internal Coolant Supply (40D type)	EgiAs	ϕ3～ϕ10	○

50D以下 FOR DRILLING DEPTH ≦50D

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	171	NEW ADO-50D		硬质合金内冷油孔钻头 50D型 Carbide Drill with Internal Coolant Supply (50D type)	EgiAs	ϕ3～ϕ8	○

钻头选型基准表 DRILLS SELECTION CHART

30D以下 FOR DRILLING DEPTH≦30D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	
◎	◎	◎	◎	○					○*	○	◎	◎								
													○	○	◎					

* 不建议加工奥氏体不锈钢。
*We don't recommend it for Austenitic Stainless Steel drilling.

40D以下 FOR DRILLING DEPTH≦40D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
◎	◎	◎	◎	○					○		◎	◎								

50D以下 FOR DRILLING DEPTH≦50D

◎=Best
○=Good

加工材料 WORK MATERIAL																					
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Mugnesium Alloy	金属基合材料(MMC) Metal Matrix Composite
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
◎	◎	◎	◎	○					○		◎	◎								

钻头选型基准表 DRILLS SELECTION CHART

中心钻可进行钻孔前的中心定位加工和倒角加工。中心定位加工可提高孔加工的位置精度，倒角加工可防止攻丝时在端面产生的毛刺，也可去除孔加工时产生的毛刺。

Starting Drills can perform both centering and chamfering. Centering improves drilling precision.
Chamfering prevents burrs on the end face during tapping and removes burrs that may occur during drilling.

锋角的使用区分 Classifying Starting Drills by Point Angle

■锋角90° .....
C倒角用，也可用于中心定位
Point angle: 90° .....
for 45 degree chamfering, for both centering and chamfering

■锋角120°，130° .....
使用钻头时的中心定位加工用 (图1, 2)
Point angle: 120°, 130° ...
for centering before drilling with Drill (See Fig. 1 and 2)

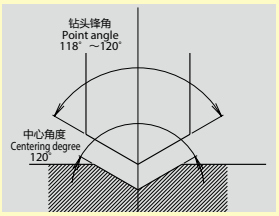

图1: 120°中心定位
Fig. 1 Centering: 120°

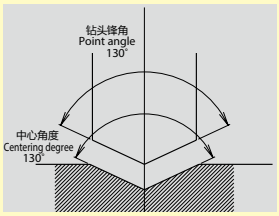

图2: 130°中心定位
Fig. 2 Centering: 130°

倒角 CHAMFERING　　中心定位用 CENTERING

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	325	AD-LDS		硬质合金 EgiAs 涂层 EgiAs Coated Carbide	EgiAs WXL	ϕ3 ~ ϕ12	○
	326	AD-LS-LDS		硬质合金 EgiAs 涂层 长柄型 EgiAs Coated Carbide with Long Shank	EgiAs	ϕ3 ~ ϕ12	○
	327	FX-LDS		硬质合金 FX 涂层 FX Coated Carbide	FX	ϕ0.5 ~ ϕ25	○
	336	FX-LS-LDS		硬质合金 FX 涂层长柄型 FX Coated Carbide with Long Shank	FX	ϕ16 ~ ϕ25	○
高速钢钻头 HSS Drills	328	NC-LDS		标准型 HSS General Type	—	ϕ3 ~ ϕ25	
	329	TIN-NC-LDS		TiN 涂层 TiN Coated HSS	TiN	ϕ3 ~ ϕ25	
	330	VP-LDS		V 涂层粉末高速钢 V Coated XPM	V	ϕ3 ~ ϕ25	○
	331	LS-NC-LDS		长柄型 HSS General Type with Long Shank	—	ϕ3 ~ ϕ25	
	332	VP-LS-LDS		V 涂层粉末高速钢长柄型 Coated XPM with Long Shank	V	ϕ3 ~ ϕ25	○
可转位式钻头 Indexable Drills	337	NEW PLDS		可转位中心钻 Centering and Chamfering Cutter	—	ϕ14.4, ϕ17.3	○

倒角用请参阅P.41。 See page 41 for countersinking.

钻头选型基准表 DRILLS SELECTION CHART

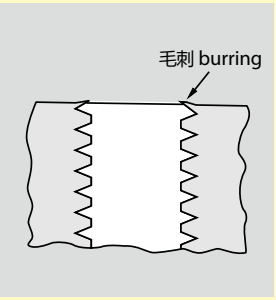

图 3
Fig. 3

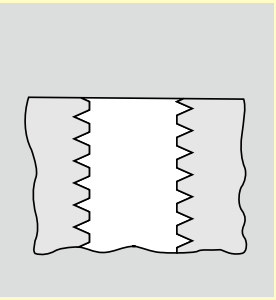

图 4：60°的倒角
Fig. 4 Chamfering: 60°

■锋角 60°.....
用挤压丝锥攻丝时的倒角
Point angle: 60° ..... for chamfering when tapping with Rolled Tap

挤压丝锥是利用金属塑性成型原理挤出内螺纹的。如果攻丝前在入口处不施以倒角处理，容易如图3一样产生毛刺，为了防止产生毛刺，推荐使用60°中心钻先进行倒角加工。

When a forming tap is used, and the entrance to the hole is not chamfered, burring is likely to occur (see Fig.3). Please used a starting drill with a 60 degree chamfer to avoid this problem.

倒角 CHAMFERING　　中心定位用 CENTERING

◎=Best
○=Good

加工材料 WORK MATERIAL																	
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	60~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
◎	◎	◎	◎	◎	○					◎	◎	◎	○		○	○	○
◎	◎	◎	◎	◎	○					◎	◎	◎	○		○	○	○
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钻头选型基准表 DRILLS SELECTION CHART

中心钻可进行钻孔前的中心定位加工和倒角加工。中心定位加工可提高孔加工的位置精度，倒角加工可防止攻丝时在端面产生的毛刺，也可去除孔加工时产生的毛刺。

Starting Drills can perform both centering and chamfering. Centering improves drilling precision.
Chamfering prevents burrs on the end face during tapping and removes burrs that may occur during drilling.

锋角的使用区分 Classifying Starting Drills by Point Angle

■锋角90° .....
C倒角用，也可用于中心定位
Point angle: 90° .....
for 45 degree chamfering, for both centering and chamfering

■锋角120°，130° .....
使用钻头时的中心定位加工用 (图1, 2)
Point angle: 120°, 130° ...
for centering before drilling with Drill (See Fig. 1 and 2)

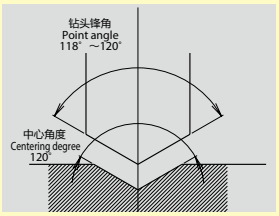

图1: 120°中心定位
Fig. 1 Centering: 120°

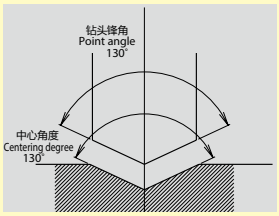

图2: 130°中心定位
Fig. 2 Centering: 130°

倒角 CHAMFERING　　倒角用 COUNTERSINKING

钻头名称 Name	登载页码 Page	商品记号 Tool Abbreviation	形状 Appearance	式样 Specification	涂层 Surface Treatment	库存范围 Stocked Size	含钴 Cobalt
硬质合金钻头 Carbide Drills	325	AD-LDS		硬质合金 EgiAs 涂层 EgiAs Coated Carbide	EgiAs WXL	φ3 ~φ12	○
	326	AD-LS-LDS		硬质合金 EgiAs 涂层长柄型 EgiAs Coated Carbide with Long Shank	EgiAs	φ3 ~φ12	○
	327	FX-LDS		硬质合金 FX 涂层 FX Coated Carbide	FX	φ0.5 ~φ25	○
	336	FX-LS-LDS		硬质合金 FX 涂层长柄型 FX Coated Carbide with Long Shank	FX	φ16 ~φ25	○
高速钢钻头 HSS Drills	328	NC-LDS		标准型 90° HSS General Type 90°	—	φ3 ~φ25	
				标准型 120°,130° HSS General Type120°,130°	—	φ3 ~φ25 (120°)	
	329	TIN-NC-LDS		TiN 涂层90° TiN Coated HSS 90°	TiN	φ3 ~φ25	
				TiN 涂层60° TiN Coated HSS 60°	TiN	φ3 ~φ12	
	330	VP-LDS		V 涂层粉末高速钢 V Coated XPM	V	φ3 ~φ25	○
	331	LS-NC-LDS		长柄型 HSS General Type with Long Shank	—	φ3 ~φ25	
	332	VP-LS-LDS		V 涂层粉末高速钢长柄型 V Coated XPM with Long Shank	V	φ3 ~φ25	○
可转位式钻头 Indexable Drills	337	NEW PLDS		可转位中心钻 Centering and Chamfering Cutter	—	φ14.4, φ17.3	○

中心定位用请参阅P.39。 See page 39 for centering.

钻头选型基准表 DRILLS SELECTION CHART

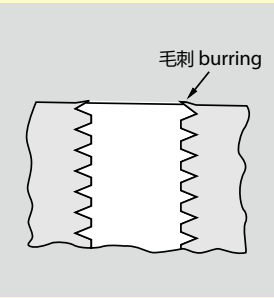

图 3
Fig. 3

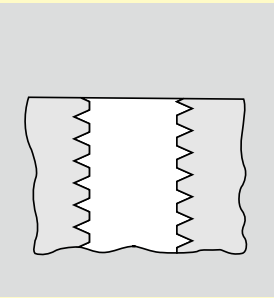

图 4：60°的倒角
Fig. 4 Chamfering: 60°

■锋角 60°.....
用挤压丝锥攻丝时的倒角
Point angle: 60° ..... for chamfering when tapping with Rolled Tap

挤压丝锥是利用金属塑性成型原理挤出内螺纹的。如果攻丝前在入口处不施以倒角处理，容易如图3一样产生毛刺，为了防止产生毛刺，推荐使用60°中心钻先进行倒角加工。

When a forming tap is used, and the entrance to the hole is not chamfered, burring is likely to occur (see Fig.3). Please used a starting drill with a 60 degree chamfer to avoid this problem.

倒角 CHAMFERING　　倒角用 COUNTERSINKING

◎=Best
○=Good

被削材 WORK MATERIAL																	
低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	60~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
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按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
UVM-DRL-5D	0.02 X 3	0.12	38	3	191
UVM-DRL-5D	0.02 X 3.175	0.12	38	3.175	191
UVM-DRL-10D	0.02 X 3	0.22	38	3	192
UVM-DRL-10D	0.02 X 3.175	0.22	38	3.175	192
UVM-DRL-5D	0.03 X 3	0.18	38	3	191
UVM-DRL-5D	0.03 X 3.175	0.18	38	3.175	191
UVM-DRL-10D	0.03 X 3	0.33	38	3	192
UVM-DRL-10D	0.03 X 3.175	0.33	38	3.175	192
UVM-DRL-5D	0.04 X 3	0.24	38	3	191
UVM-DRL-5D	0.04 X 3.175	0.24	38	3.175	191
UVM-DRL-10D	0.04 X 3	0.44	38	3	192
UVM-DRL-10D	0.04 X 3.175	0.44	38	3.175	192
UVM-DRL-5D	0.05 X 3	0.3	38	3	191
UVM-DRL-5D	0.05 X 3.175	0.3	38	3.175	191
UVM-DRL-10D	0.05 X 3	0.55	38	3	192
UVM-DRL-10D	0.05 X 3.175	0.55	38	3.175	192
UVM-DRL-5D	0.06 X 3.175	0.36	38	3.175	191
UVM-DRL-10D	0.06 X 3.175	0.66	38	3.175	192
UVM-DRL-5D	0.07 X 3.175	0.42	38	3.175	191
UVM-DRL-10D	0.07 X 3.175	0.77	38	3.175	192
UVM-DRL-5D	0.08 X 3	0.48	38	3	191
UVM-DRL-5D	0.08 X 3.175	0.48	38	3.175	191
UVM-DRL-10D	0.08 X 3	0.88	38	3	192
UVM-DRL-10D	0.08 X 3.175	0.88	38	3.175	192
UVM-DRL-5D	0.09 X 3.175	0.54	38	3.175	191
UVM-DRL-10D	0.09 X 3.175	0.99	38	3.175	192
WX-MS-GDS	0.21	1.5	38	3	194
WX-MS-GDS	0.22	1.5	38	3	194
WX-MS-GDS	0.23	1.5	38	3	194
WX-MS-GDS	0.24 X 3	1.5	38	3	194
ADF-2D	0.25	0.8	40	3	344

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WX-MS-GDS	0.25	1.5	38	3	194
WX-MS-GDS	0.26	1.5	38	3	194
WX-MS-GDS	0.27	1.5	38	3	194
WX-MS-GDS	0.28	1.5	38	3	194
WX-MS-GDS	0.29	1.5	38	3	194
ADF-2D	0.3	0.9	40	3	344
WX-MS-GDS	0.3	1.5	38	3	194
FH-GDS	0.3	1.6	38	3	208
FH-GDN	0.3	2.5	38	3	209
WX-MS-GDS	0.31	2	38	3	194
WX-MS-GDS	0.32	2	38	3	194
WX-MS-GDS	0.33	2	38	3	194
WX-MS-GDS	0.34	2	38	3	194
ADF-2D	0.35	1.1	40	3	344
WX-MS-GDS	0.35	2	38	3	194
WX-MS-GDS	0.36	2	38	3	194
WX-MS-GDS	0.37	2	38	3	194
WX-MS-GDS	0.38	2	38	3	194
WX-MS-GDS	0.39	2.5	38	3	194
ADF-2D	0.4	1.2	40	3	344
WX-MS-GDS	0.4	2.5	38	3	194
FH-GDS	0.4	2.6	38	3	208
FH-GDN	0.4	4	38	3	209
WX-MS-GDS	0.41	2.5	38	3	194
WX-MS-GDS	0.42	2.5	38	3	194
WX-MS-GDS	0.43	2.5	38	3	194
WX-MS-GDS	0.44	2.5	38	3	194
ADF-2D	0.45	1.4	40	3	344
WX-MS-GDS	0.45	2.5	38	3	194
WX-MS-GDS	0.46	2.5	38	3	194
WX-MS-GDS	0.47	2.5	38	3	194

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WX-MS-GDS	0.48	2.5	38	3	194
WX-MS-GDS	0.49	3	38	3	194
ADF-2D	0.5	1.7	40	3	344
EX-SUS-GDS	0.5	3	38	3	273
FH-GDS	0.5	3	38	3	208
VPH-GDS	0.5	3	38	3	253
WX-MS-GDS	0.5	3	38	3	194
FH-GDN	0.5	5	38	3	209
EX-GDN	0.5	6	38	3	294
MRS-GDL	0.5	6	42	3	201
EX-SUS-GDS	0.51	3	38	3	273
VPH-GDS	0.51	3	38	3	253
WX-MS-GDS	0.51	3	38	3	194
EX-GDN	0.51	6	38	3	294
EX-SUS-GDS	0.52	3	38	3	273
VPH-GDS	0.52	3	38	3	253
WX-MS-GDS	0.52	3	38	3	194
EX-GDN	0.52	6	38	3	294
EX-SUS-GDS	0.53	3	38	3	273
VPH-GDS	0.53	3	38	3	253
WX-MS-GDS	0.53	3	38	3	194
EX-GDN	0.53	6	38	3	294
EX-SUS-GDS	0.54	3.5	38	3	273
VPH-GDS	0.54	3.5	38	3	253
WX-MS-GDS	0.54	3.5	38	3	194
MRS-GDL	0.54	6.6	42	3	201
EX-GDN	0.54	7	39	3	294
ADF-2D	0.55	1.9	40	3	344
EX-SUS-GDS	0.55	3.5	38	3	273
VPH-GDS	0.55	3.5	38	3	253
WX-MS-GDS	0.55	3.5	38	3	194

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
MRS-GDL	0.55	6.6	42	3	201
EX-GDN	0.55	7	39	3	294
EX-SUS-GDS	0.56	3.5	38	3	273
VPH-GDS	0.56	3.5	38	3	253
WX-MS-GDS	0.56	3.5	38	3	194
EX-GDN	0.56	7	39	3	294
MRS-GDL	0.56	7.2	42	3	201
EX-SUS-GDS	0.57	3.5	38	3	273
VPH-GDS	0.57	3.5	38	3	253
WX-MS-GDS	0.57	3.5	38	3	194
EX-GDN	0.57	7	39	3	294
EX-SUS-GDS	0.58	3.5	38	3	273
VPH-GDS	0.58	3.5	38	3	253
WX-MS-GDS	0.58	3.5	38	3	194
EX-GDN	0.58	7	39	3	294
EX-SUS-GDS	0.59	3.5	38	3	273
VPH-GDS	0.59	3.5	38	3	253
WX-MS-GDS	0.59	3.5	38	3	194
EX-GDN	0.59	7	39	3	294
ADF-2D	0.6	2	40	3	344
EX-SUS-GDS	0.6	3.5	38	3	273
FH-GDS	0.6	3.5	38	3	208
VPH-GDS	0.6	3.5	38	3	253
WX-MS-GDS	0.6	3.5	38	3	194
FH-GDN	0.6	5.5	38	3	209
EX-GDN	0.6	7	39	3	294
MRS-GDL	0.6	7.2	42	3	201
EX-SUS-GDS	0.61	4	38	3	273
VPH-GDS	0.61	4	38	3	253
WX-MS-GDS	0.61	4	38	3	194
EX-GDN	0.61	7	39	3	294
EX-SUS-GDS	0.62	4	38	3	273
VPH-GDS	0.62	4	38	3	253
WX-MS-GDS	0.62	4	38	3	194
EX-GDN	0.62	7	39	3	294
EX-SUS-GDS	0.63	4	38	3	273
VPH-GDS	0.63	4	38	3	253
WX-MS-GDS	0.63	4	38	3	194
EX-GDN	0.63	7	39	3	294
MRS-GDL	0.63	7.8	46	3	201
EX-SUS-GDS	0.64	4	38	3	273
VPH-GDS	0.64	4	38	3	253
WX-MS-GDS	0.64	4	38	3	194
EX-GDN	0.64	7	39	3	294
MRS-GDL	0.64	7.8	46	3	201
ADF-2D	0.65	2.2	40	3	344
EX-SUS-GDS	0.65	4	38	3	273
VPH-GDS	0.65	4	38	3	253
WX-MS-GDS	0.65	4	38	3	194
EX-GDN	0.65	7	39	3	294
MRS-GDL	0.65	7.8	46	3	201
EX-SUS-GDS	0.66	4	38	3	273
VPH-GDS	0.66	4	38	3	253
WX-MS-GDS	0.66	4	38	3	194
EX-GDN	0.66	7	39	3	294
EX-SUS-GDS	0.67	4	38	3	273
VPH-GDS	0.67	4	38	3	253
WX-MS-GDS	0.67	4	38	3	194
EX-GDN	0.67	7	39	3	294
EX-SUS-GDS	0.68	4.5	38	3	273
VPH-GDS	0.68	4.5	38	3	253
WX-MS-GDS	0.68	4.5	38	3	194
EX-GDN	0.68	8	40	3	294
EX-SUS-GDS	0.69	4.5	38	3	273
VPH-GDS	0.69	4.5	38	3	253
WX-MS-GDS	0.69	4.5	38	3	194
EX-GDN	0.69	8	40	3	294
ADF-2D	0.7	2.4	40	3	344
ADO-MICRO2D	0.7	4.2	47	3	144
EX-SUS-GDS	0.7	4.5	38	3	273
FH-GDS	0.7	4.5	38	3	208
VPH-GDS	0.7	4.5	38	3	253
WX-MS-GDS	0.7	4.5	38	3	194
FH-GDN	0.7	7	38	3	209
ADO-MICRO5D	0.7	7	47	3	145
EX-GDN	0.7	8	40	3	294
MRS-GDL	0.7	8.4	46	3	201
ADF-2D	0.71	2.4	40	3	344
EX-SUS-GDS	0.71	4.5	38	3	273
VPH-GDS	0.71	4.5	38	3	253
WX-MS-GDS	0.71	4.5	38	3	194
EX-GDN	0.71	8	40	3	294
MRS-GDL	0.71	9	46	3	201
ADF-2D	0.72	2.4	40	3	344
EX-SUS-GDS	0.72	4.5	38	3	273
VPH-GDS	0.72	4.5	38	3	253
WX-MS-GDS	0.72	4.5	38	3	194
EX-GDN	0.72	8	40	3	294
MRS-GDL	0.72	9	46	3	201
EX-SUS-GDS	0.73	4.5	38	3	273
VPH-GDS	0.73	4.5	38	3	253
WX-MS-GDS	0.73	4.5	38	3	194
EX-GDN	0.73	8	40	3	294

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
MRS-GDL	0.73	9	46	3	201
ADF-2D	0.74	2.5	40	3	344
EX-SUS-GDS	0.74	4.5	38	3	273
VPH-GDS	0.74	4.5	38	3	253
WX-MS-GDS	0.74	4.5	38	3	194
EX-GDN	0.74	8	40	3	294
MRS-GDL	0.74	9	46	3	201
ADF-2D	0.75	2.6	40	3	344
EX-SUS-GDS	0.75	4.5	38	3	273
VPH-GDS	0.75	4.5	38	3	253
WX-MS-GDS	0.75	4.5	38	3	194
ADO-MICRO2D	0.75	4.5	47	3	144
ADO-MICRO5D	0.75	7.5	47	3	145
EX-GDN	0.75	8	40	3	294
MRS-GDL	0.75	9	46	3	201
EX-SUS-GDS	0.76	5	38	3	273
VPH-GDS	0.76	5	38	3	253
WX-MS-GDS	0.76	5	38	3	194
EX-GDN	0.76	8	40	3	294
EX-SUS-GDS	0.77	5	38	3	273
VPH-GDS	0.77	5	38	3	253
WX-MS-GDS	0.77	5	38	3	194
EX-GDN	0.77	8	40	3	294
EX-SUS-GDS	0.78	5	38	3	273
VPH-GDS	0.78	5	38	3	253
WX-MS-GDS	0.78	5	38	3	194
EX-GDN	0.78	8	40	3	294
EX-SUS-GDS	0.79	5	38	3	273
VPH-GDS	0.79	5	38	3	253
WX-MS-GDS	0.79	5	38	3	194
EX-GDN	0.79	8	40	3	294

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	0.8	2.7	40	3	344
ADO-MICRO2D	0.8	4.8	50	3	144
EX-SUS-GDS	0.8	5	38	3	273
FH-GDS	0.8	5	38	3	208
VPH-GDS	0.8	5	38	3	253
WX-MS-GDS	0.8	5	38	3	194
FH-GDN	0.8	7.5	42	3	209
EX-GDN	0.8	8	40	3	294
ADO-MICRO5D	0.8	8	50	3	145
MRS-GDL	0.8	9.6	46	3	201
ADF-2D	0.81	2.8	40	3	344
EX-SUS-GDS	0.81	5	38	3	273
VPH-GDS	0.81	5	38	3	253
WX-MS-GDS	0.81	5	38	3	194
EX-GDN	0.81	8	40	3	294
MRS-GDL	0.81	10.2	46	3	201
EX-SUS-GDS	0.82	5	38	3	273
VPH-GDS	0.82	5	38	3	253
WX-MS-GDS	0.82	5	38	3	194
EX-GDN	0.82	8	40	3	294
MRS-GDL	0.82	10.2	46	3	201
EX-SUS-GDS	0.83	5	38	3	273
VPH-GDS	0.83	5	38	3	253
WX-MS-GDS	0.83	5	38	3	194
EX-GDN	0.83	8	40	3	294
EX-SUS-GDS	0.84	5	38	3	273
VPH-GDS	0.84	5	38	3	253
WX-MS-GDS	0.84	5	38	3	194
EX-GDN	0.84	8	40	3	294
ADF-2D	0.85	2.9	40	3	344
EX-SUS-GDS	0.85	5	38	3	273

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	0.85	5	38	3	253
WX-MS-GDS	0.85	5	38	3	194
ADO-MICRO2D	0.85	5.1	50	3	144
EX-GDN	0.85	8	40	3	294
ADO-MICRO5D	0.85	8.5	50	3	145
EX-SUS-GDS	0.86	5.5	38	3	273
VPH-GDS	0.86	5.5	38	3	253
WX-MS-GDS	0.86	5.5	38	3	194
EX-SUS-GDS	0.87	5.5	38	3	273
VPH-GDS	0.87	5.5	38	3	253
WX-MS-GDS	0.87	5.5	38	3	194
EX-GDN	0.87	9	41	3	294
EX-SUS-GDS	0.88	5.5	38	3	273
VPH-GDS	0.88	5.5	38	3	253
WX-MS-GDS	0.88	5.5	38	3	194
EX-GDN	0.88	9	41	3	294
ADF-2D	0.89	3	40	3	344
EX-SUS-GDS	0.89	5.5	38	3	273
VPH-GDS	0.89	5.5	38	3	253
WX-MS-GDS	0.89	5.5	38	3	194
EX-GDN	0.89	9	41	3	294
ADF-2D	0.9	3.1	40	3	344
ADO-MICRO2D	0.9	5.4	50	3	144
EX-SUS-GDS	0.9	5.5	38	3	273
FH-GDS	0.9	5.5	38	3	208
VPH-GDS	0.9	5.5	38	3	253
WX-MS-GDS	0.9	5.5	38	3	194
FH-GDN	0.9	8.5	42	3	209
EX-GDN	0.9	9	41	3	294
ADO-MICRO5D	0.9	9	50	3	145
MRS-GDL	0.9	10.8	46	3	202

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	0.91	3.1	40	3	344
EX-SUS-GDS	0.91	5.5	38	3	273
VPH-GDS	0.91	5.5	38	3	253
WX-MS-GDS	0.91	5.5	38	3	194
EX-GDN	0.91	9	41	3	294
MRS-GDL	0.91	11.4	46	3	202
ADF-2D	0.92	3.1	40	3	344
EX-SUS-GDS	0.92	5.5	38	3	273
VPH-GDS	0.92	5.5	38	3	253
WX-MS-GDS	0.92	5.5	38	3	194
EX-GDN	0.92	9	41	3	294
MRS-GDL	0.92	11.4	46	3	202
EX-SUS-GDS	0.93	5.5	38	3	273
VPH-GDS	0.93	5.5	38	3	253
WX-MS-GDS	0.93	5.5	38	3	194
EX-GDN	0.93	9	41	3	294
EX-SUS-GDS	0.94	5.5	38	3	273
VPH-GDS	0.94	5.5	38	3	253
WX-MS-GDS	0.94	5.5	38	3	194
EX-GDN	0.94	9	41	3	294
ADF-2D	0.95	3.2	40	3	344
EX-SUS-GDS	0.95	5.5	38	3	273
VPH-GDS	0.95	5.5	38	3	253
WX-MS-GDS	0.95	5.5	38	3	194
ADO-MICRO2D	0.95	5.7	50	3	144
EX-GDN	0.95	9	41	3	294
ADO-MICRO5D	0.95	9.5	50	3	145
EX-SUS-GDS	0.96	6	38	3	273
VPH-GDS	0.96	6	38	3	253
WX-MS-GDS	0.96	6	38	3	194
EX-GDN	0.96	9	41	3	294

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	0.97	6	38	3	273
VPH-GDS	0.97	6	38	3	253
WX-MS-GDS	0.97	6	38	3	194
EX-GDN	0.97	9	41	3	294
EX-SUS-GDS	0.98	6	38	3	273
VPH-GDS	0.98	6	38	3	253
WX-MS-GDS	0.98	6	38	3	194
EX-GDN	0.98	9	41	3	294
EX-SUS-GDS	0.99	6	38	3	273
VPH-GDS	0.99	6	38	3	253
WX-MS-GDS	0.99	6	38	3	194
EX-GDN	0.99	9	41	3	294
ADF-2D	1	4	45	3	344
FHL-GDTS	1 X 20	5	57	3	215
EX-GDS	1	6	38	3	290
EX-SUS-GDS	1	6	38	3	273
FH-GDS	1	6	38	3	208
NEXUS-GDS	1	6	38	3	271
VPH-GDS	1	6	38	3	253
WX-MS-GDS	1	6	38	3	194
ADO-MICRO2D	1	6	53	3	144
EX-GDN	1	9	41	3	294
EX-SUS-GDN	1	9	41	3	281
FH-GDN	1	9	42	3	209
ADO-MICRO5D	1	10	55	3	145
MRS-GDL	1	12	46	3	202
ADO-MICRO12D	1	17	60	3	146
ADO-MICRO20D	1	24	68	3	147
ADO-MICRO30D	1	34	77	3	148
EX-SUS-GDS	1.01	6	38	3	273
VPH-GDS	1.01	6	38	3	253

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WX-MS-GDS	1.01	6	38	3	194
EX-GDN	1.01	9	41	3	294
EX-SUS-GDN	1.01	9	41	3	281
EX-SUS-GDS	1.02	6	38	3	273
VPH-GDS	1.02	6	38	3	253
WX-MS-GDS	1.02	6	38	3	194
EX-GDN	1.02	9	41	3	294
EX-SUS-GDN	1.02	9	41	3	281
EX-SUS-GDS	1.03	6	38	3	273
VPH-GDS	1.03	6	38	3	253
WX-MS-GDS	1.03	6	38	3	194
EX-GDN	1.03	9	41	3	294
EX-SUS-GDN	1.03	9	41	3	281
EX-SUS-GDS	1.04	6	38	3	273
VPH-GDS	1.04	6	38	3	253
WX-MS-GDS	1.04	6	38	3	194
EX-GDN	1.04	9	41	3	294
EX-SUS-GDN	1.04	9	41	3	281
EX-GDS	1.05	6	38	3	290
EX-SUS-GDS	1.05	6	38	3	273
VPH-GDS	1.05	6	38	3	253
WX-MS-GDS	1.05	6	38	3	194
EX-GDN	1.05	9	41	3	294
EX-SUS-GDN	1.05	9	41	3	281
EX-SUS-GDS	1.06	6	38	3	273
VPH-GDS	1.06	6	38	3	253
WX-MS-GDS	1.06	6	38	3	194
EX-GDN	1.06	9	41	3	294
EX-SUS-GDN	1.06	9	41	3	281
EX-SUS-GDS	1.07	7	39	3	273
VPH-GDS	1.07	7	39	3	253

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WX-MS-GDS	1.07	7	42	3	194
EX-GDN	1.07	11	43	3	294
EX-SUS-GDN	1.07	11	43	3	281
EX-SUS-GDS	1.08	7	39	3	273
VPH-GDS	1.08	7	39	3	253
WX-MS-GDS	1.08	7	42	3	194
EX-GDN	1.08	11	43	3	294
EX-SUS-GDN	1.08	11	43	3	281
ADF-2D	1.09	4.4	45	3	344
EX-SUS-GDS	1.09	7	39	3	273
VPH-GDS	1.09	7	39	3	253
WX-MS-GDS	1.09	7	42	3	194
EX-GDN	1.09	11	43	3	294
EX-SUS-GDN	1.09	11	43	3	281
ADF-2D	1.1	4.4	45	3	344
FHL-GDTS	1.1 X 20	5.5	57	3	215
ADO-MICRO2D	1.1	6.6	53	3	144
EX-GDS	1.1	7	39	3	290
EX-SUS-GDS	1.1	7	39	3	273
NEXUS-GDS	1.1	7	39	3	271
VPH-GDS	1.1	7	39	3	253
FH-GDS	1.1	7	42	3	208
WX-MS-GDS	1.1	7	42	3	194
FH-GDN	1.1	10.5	48	3	209
EX-GDN	1.1	11	43	3	294
EX-SUS-GDN	1.1	11	43	3	281
ADO-MICRO5D	1.1	11	55	3	145
MRS-GDL	1.1	13.2	50	3	202
ADO-MICRO12D	1.1	18.7	65	3	146
ADO-MICRO20D	1.1	26.4	75	3	147
ADO-MICRO30D	1.1	37.4	86	3	148

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	1.11	4.4	45	3	344
EX-SUS-GDS	1.11	7	39	3	273
VPH-GDS	1.11	7	39	3	253
WX-MS-GDS	1.11	7	42	3	194
EX-GDN	1.11	11	43	3	294
EX-SUS-GDN	1.11	11	43	3	281
MRS-GDL	1.11	13.8	50	3	202
ADF-2D	1.12	4.5	45	3	344
EX-SUS-GDS	1.12	7	39	3	273
VPH-GDS	1.12	7	39	3	253
WX-MS-GDS	1.12	7	42	3	194
EX-GDN	1.12	11	43	3	294
EX-SUS-GDN	1.12	11	43	3	281
MRS-GDL	1.12	13.8	50	3	202
EX-SUS-GDS	1.13	7	39	3	273
VPH-GDS	1.13	7	39	3	253
WX-MS-GDS	1.13	7	42	3	194
EX-GDN	1.13	11	43	3	294
EX-SUS-GDN	1.13	11	43	3	281
EX-SUS-GDS	1.14	7	39	3	273
VPH-GDS	1.14	7	39	3	253
WX-MS-GDS	1.14	7	42	3	194
EX-GDN	1.14	11	43	3	294
EX-SUS-GDN	1.14	11	43	3	281
EX-GDS	1.15	7	39	3	290
EX-SUS-GDS	1.15	7	39	3	273
VPH-GDS	1.15	7	39	3	253
WX-MS-GDS	1.15	7	42	3	194
EX-GDN	1.15	11	43	3	294
EX-SUS-GDN	1.15	11	43	3	281
MRS-GDL	1.15	13.8	50	3	202

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	1.16	7	39	3	273
VPH-GDS	1.16	7	39	3	253
WX-MS-GDS	1.16	7	42	3	194
EX-GDN	1.16	11	43	3	294
EX-SUS-GDN	1.16	11	43	3	281
EX-SUS-GDS	1.17	7	39	3	273
VPH-GDS	1.17	7	39	3	253
WX-MS-GDS	1.17	7	42	3	194
EX-GDN	1.17	11	43	3	294
EX-SUS-GDN	1.17	11	43	3	281
EX-SUS-GDS	1.18	7	39	3	273
VPH-GDS	1.18	7	39	3	253
WX-MS-GDS	1.18	7	42	3	194
EX-GDN	1.18	11	43	3	294
EX-SUS-GDN	1.18	11	43	3	281
EX-SUS-GDS	1.19	8	40	3	273
VPH-GDS	1.19	8	40	3	253
WX-MS-GDS	1.19	8	42	3	194
EX-GDN	1.19	12	44	3	294
EX-SUS-GDN	1.19	12	44	3	281
ADF-2D	1.2	4.8	45	3	344
FHL-GDTS	1.2 X 20	6.5	57	3	215
ADO-MICRO2D	1.2	7.2	53	3	144
EX-GDS	1.2	8	40	3	290
EX-SUS-GDS	1.2	8	40	3	273
NEXUS-GDS	1.2	8	40	3	271
VPH-GDS	1.2	8	40	3	253
FH-GDS	1.2	8	42	3	208
WX-MS-GDS	1.2	8	42	3	194
EX-GDN	1.2	12	44	3	294
EX-SUS-GDN	1.2	12	44	3	281

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
FH-GDN	1.2	12	48	3	209
ADO-MICRO5D	1.2	12	60	3	145
MRS-GDL	1.2	14.4	50	3	202
ADO-MICRO12D	1.2	20.4	65	3	146
ADO-MICRO20D	1.2	28.8	75	3	147
ADO-MICRO30D	1.2	40.8	86	3	148
EX-SUS-GDS	1.21	8	40	3	273
VPH-GDS	1.21	8	40	3	253
WX-MS-GDS	1.21	8	42	3	194
EX-GDN	1.21	12	44	3	294
EX-SUS-GDN	1.21	12	44	3	281
EX-SUS-GDS	1.22	8	40	3	273
VPH-GDS	1.22	8	40	3	253
WX-MS-GDS	1.22	8	42	3	194
EX-GDN	1.22	12	44	3	294
EX-SUS-GDN	1.22	12	44	3	281
EX-SUS-GDS	1.23	8	40	3	273
VPH-GDS	1.23	8	40	3	253
WX-MS-GDS	1.23	8	42	3	194
EX-GDN	1.23	12	44	3	294
EX-SUS-GDN	1.23	12	44	3	281
EX-SUS-GDS	1.24	8	40	3	273
VPH-GDS	1.24	8	40	3	253
WX-MS-GDS	1.24	8	42	3	194
EX-GDN	1.24	12	44	3	294
EX-SUS-GDN	1.24	12	44	3	281
ADF-2D	1.25	5	45	3	344
EX-GDS	1.25	8	40	3	290
EX-SUS-GDS	1.25	8	40	3	273
VPH-GDS	1.25	8	40	3	253
WX-MS-GDS	1.25	8	42	3	194

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDN	1.25	12	44	3	294
EX-SUS-GDN	1.25	12	44	3	281
ADF-2D	1.26	5	45	3	344
EX-SUS-GDS	1.26	8	40	3	273
VPH-GDS	1.26	8	40	3	253
WX-MS-GDS	1.26	8	42	3	194
EX-GDN	1.26	12	44	3	294
EX-SUS-GDN	1.26	12	44	3	281
ADF-2D	1.27	5.1	45	3	344
EX-SUS-GDS	1.27	8	40	3	273
VPH-GDS	1.27	8	40	3	253
WX-MS-GDS	1.27	8	42	3	194
EX-GDN	1.27	12	44	3	294
EX-SUS-GDN	1.27	12	44	3	281
MRS-GDL	1.27	15.6	50	3	202
ADF-2D	1.28	5.1	45	3	344
EX-SUS-GDS	1.28	8	40	3	273
VPH-GDS	1.28	8	40	3	253
WX-MS-GDS	1.28	8	42	3	194
EX-GDN	1.28	12	44	3	294
EX-SUS-GDN	1.28	12	44	3	281
MRS-GDL	1.28	15.6	50	3	202
ADF-2D	1.29	5.2	45	3	344
EX-SUS-GDS	1.29	8	40	3	273
VPH-GDS	1.29	8	40	3	253
WX-MS-GDS	1.29	8	42	3	194
EX-GDN	1.29	12	44	3	294
EX-SUS-GDN	1.29	12	44	3	281
MRS-GDL	1.29	15.6	50	3	202
ADF-2D	1.3	5.2	45	3	344
FHL-GDTS	1.3 × 20	6.5	57	3	215

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-MICRO2D	1.3	7.8	53	3	144
EX-GDS	1.3	8	40	3	290
EX-SUS-GDS	1.3	8	40	3	273
NEXUS-GDS	1.3	8	40	3	271
VPH-GDS	1.3	8	40	3	253
FH-GDS	1.3	8	42	3	208
WX-MS-GDS	1.3	8	42	3	194
EX-GDN	1.3	12	44	3	294
EX-SUS-GDN	1.3	12	44	3	281
FH-GDN	1.3	12	48	3	209
ADO-MICRO5D	1.3	13	60	3	145
MRS-GDL	1.3	15.6	50	3	202
ADO-MICRO12D	1.3	22.1	65	3	146
ADO-MICRO20D	1.3	31.2	75	3	147
ADO-MICRO30D	1.3	44.2	86	3	148
EX-SUS-GDS	1.31	8	40	3	273
VPH-GDS	1.31	8	40	3	253
WX-MS-GDS	1.31	8	42	3	194
EX-GDN	1.31	12	44	3	294
EX-SUS-GDN	1.31	12	44	3	281
EX-SUS-GDS	1.32	8	40	3	273
VPH-GDS	1.32	8	40	3	253
WX-MS-GDS	1.32	8	42	3	194
EX-GDN	1.32	12	44	3	294
EX-SUS-GDN	1.32	12	44	3	281
EX-SUS-GDS	1.33	9	41	3	273
VPH-GDS	1.33	9	41	3	253
WX-MS-GDS	1.33	9	42	3	194
EX-GDN	1.33	14	46	3	294
EX-SUS-GDN	1.33	14	46	3	281
EX-SUS-GDS	1.34	9	41	3	273

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	1.34	9	41	3	253
WX-MS-GDS	1.34	9	42	3	194
EX-GDN	1.34	14	46	3	295
EX-SUS-GDN	1.34	14	46	3	281
ADF-2D	1.35	5.4	45	3	344
EX-GDS	1.35	9	41	3	290
EX-SUS-GDS	1.35	9	41	3	273
VPH-GDS	1.35	9	41	3	253
WX-MS-GDS	1.35	9	42	3	194
EX-GDN	1.35	14	46	3	295
EX-SUS-GDN	1.35	14	46	3	281
EX-SUS-GDS	1.36	9	41	3	273
VPH-GDS	1.36	9	41	3	253
WX-MS-GDS	1.36	9	42	3	194
EX-GDN	1.36	14	46	3	295
EX-SUS-GDN	1.36	14	46	3	281
EX-SUS-GDS	1.37	9	41	3	273
VPH-GDS	1.37	9	41	3	253
WX-MS-GDS	1.37	9	42	3	194
EX-GDN	1.37	14	46	3	295
EX-SUS-GDN	1.37	14	46	3	281
EX-SUS-GDS	1.38	9	41	3	273
VPH-GDS	1.38	9	41	3	253
WX-MS-GDS	1.38	9	42	3	194
EX-GDN	1.38	14	46	3	295
EX-SUS-GDN	1.38	14	46	3	281
EX-SUS-GDS	1.39	9	41	3	273
VPH-GDS	1.39	9	41	3	253
WX-MS-GDS	1.39	9	42	3	194
EX-GDN	1.39	14	46	3	295
EX-SUS-GDN	1.39	14	46	3	281

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	1.4	5.6	45	3	344
FHL-GDTS	1.4 X 20	7.5	57	3	215
ADO-MICRO2D	1.4	8.4	53	3	144
EX-GDS	1.4	9	41	3	290
EX-SUS-GDS	1.4	9	41	3	273
NEXUS-GDS	1.4	9	41	3	271
VPH-GDS	1.4	9	41	3	253
FH-GDS	1.4	9	42	3	208
WX-MS-GDS	1.4	9	42	3	194
FH-GDN	1.4	13.5	48	3	209
EX-GDN	1.4	14	46	3	295
EX-SUS-GDN	1.4	14	46	3	281
ADO-MICRO5D	1.4	14	60	3	145
MRS-GDL	1.4	16.8	54	3	202
ADO-MICRO12D	1.4	23.8	70	3	146
ADO-MICRO20D	1.4	33.6	81	3	147
ADO-MICRO30D	1.4	47.6	95	3	148
EX-SUS-GDS	1.41	9	41	3	273
VPH-GDS	1.41	9	41	3	253
WX-MS-GDS	1.41	9	42	3	194
EX-GDN	1.41	14	46	3	295
EX-SUS-GDN	1.41	14	46	3	281
EX-SUS-GDS	1.42	9	41	3	273
VPH-GDS	1.42	9	41	3	253
WX-MS-GDS	1.42	9	42	3	194
EX-GDN	1.42	14	46	3	295
EX-SUS-GDN	1.42	14	46	3	281
EX-SUS-GDS	1.43	9	41	3	273
VPH-GDS	1.43	9	41	3	253
WX-MS-GDS	1.43	9	42	3	194
EX-GDN	1.43	14	46	3	295

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDN	1.43	14	46	3	281
ADF-2D	1.44	5.8	45	3	344
EX-SUS-GDS	1.44	9	41	3	273
VPH-GDS	1.44	9	41	3	253
WX-MS-GDS	1.44	9	42	3	194
EX-GDN	1.44	14	46	3	295
EX-SUS-GDN	1.44	14	46	3	281
ADF-2D	1.45	5.8	45	3	344
EX-GDS	1.45	9	41	3	290
EX-SUS-GDS	1.45	9	41	3	273
VPH-GDS	1.45	9	41	3	253
WX-MS-GDS	1.45	9	42	3	194
EX-GDN	1.45	14	46	3	295
EX-SUS-GDN	1.45	14	46	3	281
MRS-GDL	1.45	17.4	54	3	202
ADF-2D	1.46	5.8	45	3	344
EX-SUS-GDS	1.46	9	41	3	273
VPH-GDS	1.46	9	41	3	254
WX-MS-GDS	1.46	9	42	3	194
EX-GDN	1.46	14	46	3	295
EX-SUS-GDN	1.46	14	46	3	281
MRS-GDL	1.46	18	54	3	202
ADF-2D	1.47	5.9	45	3	344
EX-SUS-GDS	1.47	9	41	3	273
VPH-GDS	1.47	9	41	3	254
WX-MS-GDS	1.47	9	42	3	194
EX-GDN	1.47	14	46	3	295
EX-SUS-GDN	1.47	14	46	3	281
MRS-GDL	1.47	18	54	3	202
ADF-2D	1.48	5.9	45	3	344
EX-SUS-GDS	1.48	9	41	3	273

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	1.48	9	41	3	254
WX-MS-GDS	1.48	9	42	3	194
EX-GDN	1.48	14	46	3	295
EX-SUS-GDN	1.48	14	46	3	281
EX-SUS-GDS	1.49	9	41	3	273
VPH-GDS	1.49	9	41	3	254
WX-MS-GDS	1.49	9	42	3	194
EX-GDN	1.49	14	46	3	295
EX-SUS-GDN	1.49	14	46	3	281
ADF-2D	1.5	6	45	3	344
FHL-GDTS	1.5 X 20	7.5	57	3	215
EX-GDS	1.5	9	41	3	290
EX-SUS-GDS	1.5	9	41	3	273
NEXUS-GDS	1.5	9	41	3	271
VPH-GDS	1.5	9	41	3	254
FH-GDS	1.5	9	42	3	208
WX-MS-GDS	1.5	9	42	3	194
ADO-MICRO2D	1.5	9	53	3	144
FH-GDN	1.5	13.5	48	3	209
EX-GDN	1.5	14	46	3	295
EX-SUS-GDN	1.5	14	46	3	281
ADO-MICRO5D	1.5	15	60	3	145
MRS-GDL	1.5	18	54	3	202
ADO-MICRO12D	1.5	25.5	70	3	146
ADO-MICRO20D	1.5	36	81	3	147
ADO-MICRO30D	1.5	51	95	3	148
EX-SUS-GDS	1.51	10	42	3	273
VPH-GDS	1.51	10	42	3	254
WX-MS-GDS	1.51	10	42	3	194
EX-GDN	1.51	15	47	3	295
EX-SUS-GDN	1.51	15	47	3	281
MRS-GDL	1.51	18.6	54	3	202
EX-SUS-GDS	1.52	10	42	3	273
VPH-GDS	1.52	10	42	3	254
WX-MS-GDS	1.52	10	42	3	194
EX-GDN	1.52	15	47	3	295
EX-SUS-GDN	1.52	15	47	3	281
MRS-GDL	1.52	18.6	54	3	202
ADF-2D	1.53	6.1	45	3	344
EX-SUS-GDS	1.53	10	42	3	273
VPH-GDS	1.53	10	42	3	254
WX-MS-GDS	1.53	10	42	3	194
EX-GDN	1.53	15	47	3	295
EX-SUS-GDN	1.53	15	47	3	281
MRS-GDL	1.53	18.6	54	3	202
ADF-2D	1.54	6.2	45	3	344
EX-SUS-GDS	1.54	10	42	3	274
VPH-GDS	1.54	10	42	3	254
WX-MS-GDS	1.54	10	42	3	194
EX-GDN	1.54	15	47	3	295
EX-SUS-GDN	1.54	15	47	3	281
ADF-2D	1.55	6.2	45	3	344
EX-GDS	1.55	10	42	3	290
EX-SUS-GDS	1.55	10	42	3	274
VPH-GDS	1.55	10	42	3	254
WX-MS-GDS	1.55	10	42	3	194
EX-GDN	1.55	15	47	3	295
EX-SUS-GDN	1.55	15	47	3	281
MRS-GDL	1.55	18.6	54	3	202
ADF-2D	1.56	6.2	45	3	344
EX-SUS-GDS	1.56	10	42	3	274
VPH-GDS	1.56	10	42	3	254
WX-MS-GDS	1.56	10	42	3	194
EX-GDN	1.56	15	47	3	295
EX-SUS-GDN	1.56	15	47	3	281
MRS-GDL	1.56	19.2	54	3	202
ADF-2D	1.57	6.3	45	3	344
EX-SUS-GDS	1.57	10	42	3	274
VPH-GDS	1.57	10	42	3	254
WX-MS-GDS	1.57	10	42	3	194
EX-GDN	1.57	15	47	3	295
EX-SUS-GDN	1.57	15	47	3	281
MRS-GDL	1.57	19.2	54	3	202
ADF-2D	1.58	6.3	45	3	344
EX-SUS-GDS	1.58	10	42	3	274
VPH-GDS	1.58	10	42	3	254
WX-MS-GDS	1.58	10	42	3	194
EX-GDN	1.58	15	47	3	295
EX-SUS-GDN	1.58	15	47	3	281
EX-SUS-GDS	1.59	10	42	3	274
VPH-GDS	1.59	10	42	3	254
WX-MS-GDS	1.59	10	42	3	194
EX-GDN	1.59	15	47	3	295
EX-SUS-GDN	1.59	15	47	3	281
ADF-2D	1.6	6.4	45	3	344
FHL-GDTS	1.6 X 20	8.5	57	3	215
ADO-MICRO2D	1.6	9.6	53	3	144
EX-GDS	1.6	10	42	3	290
EX-SUS-GDS	1.6	10	42	3	274
FH-GDS	1.6	10	42	3	208
NEXUS-GDS	1.6	10	42	3	271
VPH-GDS	1.6	10	42	3	254
WX-MS-GDS	1.6	10	42	3	194

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDN	1.6	15	47	3	295
EX-SUS-GDN	1.6	15	47	3	281
FH-GDN	1.6	15	48	3	209
ADO-MICRO5D	1.6	16	60	3	145
MRS-GDL	1.6	19.2	54	3	202
TDXL	1.6 X 10D	26	70	1.57	310
ADO-MICRO12D	1.6	27.2	70	3	146
TDXL	1.6 X 15D	30	70	1.57	312
TDXL	1.6 X 20D	38	85	1.57	314
ADO-MICRO20D	1.6	38.4	81	3	147
ADO-MICRO30D	1.6	54.4	101	3	148
EX-SUS-GDS	1.61	10	42	3	274
VPH-GDS	1.61	10	42	3	254
WX-MS-GDS	1.61	10	42	3	194
EX-GDN	1.61	15	47	3	295
EX-SUS-GDN	1.61	15	47	3	281
EX-SUS-GDS	1.62	10	42	3	274
VPH-GDS	1.62	10	42	3	254
WX-MS-GDS	1.62	10	42	3	194
EX-GDN	1.62	15	47	3	295
EX-SUS-GDN	1.62	15	47	3	281
EX-SUS-GDS	1.63	10	42	3	274
VPH-GDS	1.63	10	42	3	254
WX-MS-GDS	1.63	10	42	3	194
EX-GDN	1.63	15	47	3	295
EX-SUS-GDN	1.63	15	47	3	281
EX-SUS-GDS	1.64	10	42	3	274
VPH-GDS	1.64	10	42	3	254
WX-MS-GDS	1.64	10	42	3	194
EX-GDN	1.64	15	47	3	295
EX-SUS-GDN	1.64	15	47	3	281

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDS	1.65	10	42	3	290
EX-SUS-GDS	1.65	10	42	3	274
VPH-GDS	1.65	10	42	3	254
WX-MS-GDS	1.65	10	42	3	194
EX-GDN	1.65	15	47	3	295
EX-SUS-GDN	1.65	15	47	3	281
EX-SUS-GDS	1.66	10	42	3	274
VPH-GDS	1.66	10	42	3	254
WX-MS-GDS	1.66	10	42	3	194
EX-GDN	1.66	15	47	3	295
EX-SUS-GDN	1.66	15	47	3	281
EX-SUS-GDS	1.67	10	42	3	274
VPH-GDS	1.67	10	42	3	254
WX-MS-GDS	1.67	10	42	3	194
EX-GDN	1.67	15	47	3	295
EX-SUS-GDN	1.67	15	47	3	281
EX-SUS-GDS	1.68	10	42	3	274
VPH-GDS	1.68	10	42	3	254
WX-MS-GDS	1.68	10	42	3	194
EX-GDN	1.68	15	47	3	295
EX-SUS-GDN	1.68	15	47	3	281
EX-SUS-GDS	1.69	10	42	3	274
VPH-GDS	1.69	10	42	3	254
WX-MS-GDS	1.69	10	42	3	194
EX-GDN	1.69	15	47	3	295
EX-SUS-GDN	1.69	15	47	3	281
ADF-2D	1.7	6.8	45	3	344
FHL-GDTS	1.7 X 20	8.5	57	3	215
EX-GDS	1.7	10	42	3	290
EX-SUS-GDS	1.7	10	42	3	274
FH-GDS	1.7	10	42	3	208

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
NEXUS-GDS	1.7	10	42	3	271
VPH-GDS	1.7	10	42	3	254
WX-MS-GDS	1.7	10	42	3	194
ADO-MICRO2D	1.7	10.2	53	3	144
EX-GDN	1.7	15	47	3	295
EX-SUS-GDN	1.7	15	47	3	281
FH-GDN	1.7	15	48	3	209
ADO-MICRO5D	1.7	17	60	3	145
MRS-GDL	1.7	20.4	58	3	202
ADO-MICRO12D	1.7	28.9	73	3	146
ADO-MICRO20D	1.7	40.8	88	3	147
ADO-MICRO30D	1.7	57.8	101	3	148
WX-MS-GDS	1.71	11	42	3	194
EX-SUS-GDS	1.71	11	43	3	274
VPH-GDS	1.71	11	43	3	254
EX-GDN	1.71	17	49	3	295
EX-SUS-GDN	1.71	17	49	3	281
WX-MS-GDS	1.72	11	42	3	194
EX-SUS-GDS	1.72	11	43	3	274
VPH-GDS	1.72	11	43	3	254
EX-GDN	1.72	17	49	3	295
EX-SUS-GDN	1.72	17	49	3	281
WX-MS-GDS	1.73	11	42	3	194
EX-SUS-GDS	1.73	11	43	3	274
VPH-GDS	1.73	11	43	3	254
EX-GDN	1.73	17	49	3	295
EX-SUS-GDN	1.73	17	49	3	281
WX-MS-GDS	1.74	11	42	3	194
EX-SUS-GDS	1.74	11	43	3	274
VPH-GDS	1.74	11	43	3	254
EX-GDN	1.74	17	49	3	295

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDN	1.74	17	49	3	281
ADF-2D	1.75	7	45	3	344
WX-MS-GDS	1.75	11	42	3	194
EX-GDS	1.75	11	43	3	290
EX-SUS-GDS	1.75	11	43	3	274
VPH-GDS	1.75	11	43	3	254
EX-GDN	1.75	17	49	3	295
EX-SUS-GDN	1.75	17	49	3	281
WX-MS-GDS	1.76	11	42	3	194
EX-SUS-GDS	1.76	11	43	3	274
VPH-GDS	1.76	11	43	3	254
EX-GDN	1.76	17	49	3	295
EX-SUS-GDN	1.76	17	49	3	281
WX-MS-GDS	1.77	11	42	3	194
EX-SUS-GDS	1.77	11	43	3	274
VPH-GDS	1.77	11	43	3	254
EX-GDN	1.77	17	49	3	295
EX-SUS-GDN	1.77	17	49	3	281
WX-MS-GDS	1.78	11	42	3	194
EX-SUS-GDS	1.78	11	43	3	274
VPH-GDS	1.78	11	43	3	254
EX-GDN	1.78	17	49	3	295
EX-SUS-GDN	1.78	17	49	3	281
WX-MS-GDS	1.79	11	42	3	194
EX-SUS-GDS	1.79	11	43	3	274
VPH-GDS	1.79	11	43	3	254
EX-GDN	1.79	17	49	3	295
EX-SUS-GDN	1.79	17	49	3	281
ADF-2D	1.8	7.2	45	3	344
FHL-GDTS	1.8 × 20	9.5	57	3	215
ADO-MICRO2D	1.8	10.8	53	3	144

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
FH-GDS	1.8	11	42	3	208
WX-MS-GDS	1.8	11	42	3	194
EX-GDS	1.8	11	43	3	290
EX-SUS-GDS	1.8	11	43	3	274
NEXUS-GDS	1.8	11	43	3	271
VPH-GDS	1.8	11	43	3	254
FH-GDN	1.8	16.5	48	3	209
EX-GDN	1.8	17	49	3	295
EX-SUS-GDN	1.8	17	49	3	281
ADO-MICRO5D	1.8	18	65	3	145
MRS-GDL	1.8	21.6	58	3	202
VP-GDR	1.8	22	54	3	261
TDXL	1.8 × 10D	26	75	1.77	310
ADO-MICRO12D	1.8	30.6	73	3	146
TDXL	1.8 × 15D	34	75	1.77	312
TDXL	1.8 × 20D	42	85	1.77	314
ADO-MICRO20D	1.8	43.2	88	3	147
ADO-MICRO30D	1.8	61.2	107	3	148
WX-MS-GDS	1.81	11	42	3	194
EX-SUS-GDS	1.81	11	43	3	274
NEXUS-GDS	1.81	11	43	3	271
VPH-GDS	1.81	11	43	3	254
EX-GDN	1.81	17	49	3	295
EX-SUS-GDN	1.81	17	49	3	281
MRS-GDL	1.81	22.2	58	3	202
ADF-2D	1.82	7.3	45	3	344
WX-MS-GDS	1.82	11	42	3	194
EX-SUS-GDS	1.82	11	43	3	274
VPH-GDS	1.82	11	43	3	254
EX-GDN	1.82	17	49	3	295
EX-SUS-GDN	1.82	17	49	3	281

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-GDR	1.82	22	54	3	261
MRS-GDL	1.82	22.2	58	3	201
ADF-2D	1.83	7.3	45	3	344
WX-MS-GDS	1.83	11	42	3	194
EX-SUS-GDS	1.83	11	43	3	274
NEXUS-GDS	1.83	11	43	3	271
VPH-GDS	1.83	11	43	3	254
EX-GDN	1.83	17	49	3	295
EX-SUS-GDN	1.83	17	49	3	281
MRS-GDL	1.83	22.2	58	3	201
ADF-2D	1.84	7.4	45	3	344
WX-MS-GDS	1.84	11	42	3	194
EX-SUS-GDS	1.84	11	43	3	274
VPH-GDS	1.84	11	43	3	254
EX-GDN	1.84	17	49	3	295
EX-SUS-GDN	1.84	17	49	3	281
ADF-2D	1.85	7.4	45	3	344
WX-MS-GDS	1.85	11	42	3	194
EX-GDS	1.85	11	43	3	290
EX-SUS-GDS	1.85	11	43	3	274
VPH-GDS	1.85	11	43	3	254
EX-GDN	1.85	17	49	3	295
EX-SUS-GDN	1.85	17	49	3	281
ADF-2D	1.86	7.4	45	3	344
WX-MS-GDS	1.86	11	42	3	194
EX-SUS-GDS	1.86	11	43	3	274
VPH-GDS	1.86	11	43	3	254
EX-GDN	1.86	17	49	3	295
EX-SUS-GDN	1.86	17	49	3	281
WX-MS-GDS	1.87	11	42	3	194
EX-SUS-GDS	1.87	11	43	3	274

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	1.87	11	43	3	254
EX-GDN	1.87	17	49	3	295
EX-SUS-GDN	1.87	17	49	3	281
WX-MS-GDS	1.88	11	42	3	194
EX-SUS-GDS	1.88	11	43	3	274
VPH-GDS	1.88	11	43	3	254
EX-GDN	1.88	17	49	3	295
EX-SUS-GDN	1.88	17	49	3	282
WX-MS-GDS	1.89	11	42	3	194
EX-SUS-GDS	1.89	11	43	3	274
VPH-GDS	1.89	11	43	3	254
EX-GDN	1.89	17	49	3	295
EX-SUS-GDN	1.89	17	49	3	282
ADF-2D	1.9	7.6	45	3	344
FHL-GDTS	1.9 X 20	9.5	57	3	215
FH-GDS	1.9	11	42	3	208
WX-MS-GDS	1.9	11	42	3	194
EX-GDS	1.9	11	43	3	290
EX-SUS-GDS	1.9	11	43	3	274
NEXUS-GDS	1.9	11	43	3	271
VPH-GDS	1.9	11	43	3	254
ADO-MICRO2D	1.9	11.4	53	3	144
FH-GDN	1.9	16.5	48	3	209
EX-GDN	1.9	17	49	3	295
EX-SUS-GDN	1.9	17	49	3	282
ADO-MICRO5D	1.9	19	65	3	145
MRS-GDL	1.9	22.8	58	3	201
ADO-MICRO12D	1.9	32.3	73	3	146
ADO-MICRO20D	1.9	45.6	88	3	147
ADO-MICRO30D	1.9	64.6	107	3	148
EX-SUS-GDS	1.91	12	44	3	274

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	1.91	12	44	3	254
WX-MS-GDS	1.91	12	50	3	194
EX-GDN	1.91	18	50	3	295
EX-SUS-GDN	1.91	18	50	3	282
EX-SUS-GDS	1.92	12	44	3	274
VPH-GDS	1.92	12	44	3	254
WX-MS-GDS	1.92	12	50	3	194
EX-GDN	1.92	18	50	3	295
EX-SUS-GDN	1.92	18	50	3	282
EX-SUS-GDS	1.93	12	44	3	274
VPH-GDS	1.93	12	44	3	254
WX-MS-GDS	1.93	12	50	3	194
EX-GDN	1.93	18	50	3	295
EX-SUS-GDN	1.93	18	50	3	282
EX-SUS-GDS	1.94	12	44	3	274
VPH-GDS	1.94	12	44	3	254
WX-MS-GDS	1.94	12	50	3	194
EX-GDN	1.94	18	50	3	295
EX-SUS-GDN	1.94	18	50	3	282
ADF-2D	1.95	7.8	45	3	344
EX-GDS	1.95	12	44	3	290
EX-SUS-GDS	1.95	12	44	3	274
VPH-GDS	1.95	12	44	3	254
WX-MS-GDS	1.95	12	50	3	194
EX-GDN	1.95	18	50	3	295
EX-SUS-GDN	1.95	18	50	3	282
EX-SUS-GDS	1.96	12	44	3	274
VPH-GDS	1.96	12	44	3	254
WX-MS-GDS	1.96	12	50	3	194
EX-GDN	1.96	18	50	3	295
EX-SUS-GDN	1.96	18	50	3	282

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	1.97	12	44	3	274
VPH-GDS	1.97	12	44	3	254
WX-MS-GDS	1.97	12	50	3	194
EX-GDN	1.97	18	50	3	295
EX-SUS-GDN	1.97	18	50	3	282
EX-SUS-GDS	1.98	12	44	3	274
VPH-GDS	1.98	12	44	3	254
WX-MS-GDS	1.98	12	50	3	194
EX-GDN	1.98	18	50	3	295
EX-SUS-GDN	1.98	18	50	3	282
MRS-GDL	1.98	24	58	3	201
EX-SUS-GDS	1.99	12	44	3	274
VPH-GDS	1.99	12	44	3	254
WX-MS-GDS	1.99	12	50	3	194
EX-GDN	1.99	18	50	3	295
EX-SUS-GDN	1.99	18	50	3	282
MRS-GDL	1.99	24	58	3	201
ED-DS	2	7	39	3	245
EX-H-DRL	2	10	30	2	319
ADF-2D	2	10	50	4	344
FHL-GDTS	2 X 30	10.5	65	3	215
WH70-DRL	2	12	42	3	212
EX-GDS	2	12	44	3	290
EX-SUS-GDS	2	12	44	3	274
NEXUS-GDS	2	12	44	3	271
VPH-GDS	2	12	44	3	254
FH-GDS	2	12	46	3	208
WX-MS-GDS	2	12	50	3	194
ADO-MICRO2D	2	12	58	3	144
ADO-3D	2-3	12	66	3	149
ADO-SUS-3D	2-3	12	66	3	173

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	2-3	14	62	3	137
AD-2D	2	14	62	4	137
EX-GDN	2	18	50	3	295
FH-GDN	2	18	50	3	209
D-GDN	2	18	54	3	243
WH55-5D	2	18	68	4	210
ADO-5D	2-3	18	70	3	153
ADO-SUS-5D	2-3	18	70	3	176
ADO-MICRO5D	2	20	65	3	145
AD-4D	2-3	20	66	3	141
AD-4D	2	20	66	4	141
ADO-8D	2-3	22	75	3	157
ADO-SUS-8D	2-3	22	75	3	180
V-SDR	2	24	49	2	321
EX-GDR	2	24	56	3	297
EX-SUS-GDR	2	24	56	3	283
NEXUS-GDR	2	24	56	3	272
VP-GDR	2	24	56	3	261
MRS-GDL	2	24	58	3	201
TDXL	2 X 10D	26	75	2	310
ADO-10D	2-3	26	75	3	160
ADO-MICRO12D	2	34	77	3	146
TDXL	2 X 15D	36	80	2	312
EX-GDXL	2	40	100	2	301
TDXL	2 X 20D	46	85	2	314
ADO-MICRO20D	2	48	95	3	147
EX-GDXL	2	50	100	2	301
ADO-MICRO30D	2	68	112	3	148
EX-SUS-GDS	2.01	12	44	3	274
VPH-GDS	2.01	12	44	3	254
EX-SUS-GDR	2.01	24	56	3	283

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	2.02	12	44	3	274
VPH-GDS	2.02	12	44	3	254
EX-SUS-GDR	2.02	24	56	3	283
EX-SUS-GDS	2.03	12	44	3	274
VPH-GDS	2.03	12	44	3	254
EX-SUS-GDR	2.03	24	56	3	283
EX-SUS-GDS	2.04	12	44	3	274
VPH-GDS	2.04	12	44	3	254
EX-SUS-GDR	2.04	24	56	3	283
EX-GDS	2.05	12	44	3	290
EX-SUS-GDS	2.05	12	44	3	274
VPH-GDS	2.05	12	44	3	254
WX-MS-GDS	2.05	12	50	3	194
EX-GDN	2.05	18	50	3	295
EX-GDR	2.05	24	56	3	297
EX-SUS-GDR	2.05	24	56	3	283
EX-SUS-GDS	2.06	12	44	3	274
VPH-GDS	2.06	12	44	3	254
EX-SUS-GDR	2.06	24	56	3	283
EX-SUS-GDS	2.07	12	44	3	274
VPH-GDS	2.07	12	44	3	254
EX-SUS-GDR	2.07	24	56	3	283
EX-SUS-GDS	2.08	12	44	3	274
VPH-GDS	2.08	12	44	3	254
EX-SUS-GDR	2.08	24	56	3	283
EX-SUS-GDS	2.09	12	44	3	274
VPH-GDS	2.09	12	44	3	254
EX-SUS-GDR	2.09	24	56	3	283
ADF-2D	2.1	10	50	4	344
WH70-DRL	2.1	12	42	3	212
EX-GDS	2.1	12	44	3	290

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	2.1	12	44	3	274
NEXUS-GDS	2.1	12	44	3	271
VPH-GDS	2.1	12	44	3	254
WX-MS-GDS	2.1	12	50	3	194
ADO-3D	2.1-3	13	66	3	149
ADO-SUS-3D	2.1-3	13	66	3	173
AD-2D	2.1-3	14	62	3	137
AD-2D	2.1	14	62	4	137
EX-GDN	2.1	18	50	3	295
ADO-5D	2.1-3	19	70	3	153
ADO-SUS-5D	2.1-3	19	70	3	176
AD-4D	2.1-3	20	66	3	141
AD-4D	2.1	20	66	4	141
V-SDR	2.1	24	49	2.1	321
EX-GDR	2.1	24	56	3	297
EX-SUS-GDR	2.1	24	56	3	283
VP-GDR	2.1	24	56	3	261
ADO-8D	2.1-3	24	75	3	157
ADO-SUS-8D	2.1-3	24	75	3	180
MRS-GDL	2.1	25.2	62	3	201
TDXL	2.1 X 10D	33	75	2.1	310
ADO-10D	2.1-3	33	75	3	160
TDXL	2.1 X 15D	38	80	2.1	312
EX-GDXL	2.1	40	100	2.1	301
TDXL	2.1 X 20D	50	90	2.1	314
EX-GDXL	2.1	50	100	2.1	301
EX-SUS-GDS	2.11	12	44	3	274
NEXUS-GDS	2.11	12	44	3	271
VPH-GDS	2.11	12	44	3	254
EX-SUS-GDR	2.11	24	56	3	283
EX-SUS-GDS	2.12	12	44	3	274

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	2.12	12	44	3	254
EX-SUS-GDR	2.12	24	56	3	283
MRS-GDL	2.12	25.8	62	3	201
EX-SUS-GDS	2.13	13	45	3	274
NEXUS-GDS	2.13	13	45	3	271
VPH-GDS	2.13	13	45	3	254
MRS-GDL	2.13	25.8	62	3	201
EX-SUS-GDR	2.13	27	59	3	283
EX-SUS-GDS	2.14	13	45	3	274
VPH-GDS	2.14	13	45	3	254
MRS-GDL	2.14	25.8	62	3	201
EX-SUS-GDR	2.14	27	59	3	283
EX-GDS	2.15	13	45	3	290
EX-SUS-GDS	2.15	13	45	3	274
VPH-GDS	2.15	13	45	3	254
WX-MS-GDS	2.15	13	50	3	194
EX-GDN	2.15	20	52	3	295
EX-GDR	2.15	27	59	3	297
EX-SUS-GDR	2.15	27	59	3	283
EX-SUS-GDS	2.16	13	45	3	274
VPH-GDS	2.16	13	45	3	254
EX-SUS-GDR	2.16	27	59	3	283
EX-SUS-GDS	2.17	13	45	3	274
VPH-GDS	2.17	13	45	3	254
EX-SUS-GDR	2.17	27	59	3	283
EX-SUS-GDS	2.18	13	45	3	274
VPH-GDS	2.18	13	45	3	254
EX-SUS-GDR	2.18	27	59	3	283
EX-SUS-GDS	2.19	13	45	3	274
VPH-GDS	2.19	13	45	3	254
EX-SUS-GDR	2.19	27	59	3	283

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	2.2	11	50	4	344
WH70-DRL	2.2	13	43	3	212
EX-GDS	2.2	13	45	3	290
EX-SUS-GDS	2.2	13	45	3	274
NEXUS-GDS	2.2	13	45	3	271
VPH-GDS	2.2	13	45	3	254
WX-MS-GDS	2.2	13	50	3	194
AD-2D	2.2-3	14	62	3	137
AD-2D	2.2	14	62	4	137
ADO-3D	2.2-3	14	66	3	149
ADO-SUS-3D	2.2-3	14	66	3	173
EX-GDN	2.2	20	52	3	295
AD-4D	2.2-3	20	66	3	141
AD-4D	2.2	20	66	4	141
ADO-5D	2.2-3	20	70	3	153
ADO-SUS-5D	2.2-3	20	70	3	176
ADO-8D	2.2-3	25	75	3	157
ADO-SUS-8D	2.2-3	25	75	3	180
MRS-GDL	2.2	26.4	62	3	201
V-SDR	2.2	27	53	2.2	321
EX-GDR	2.2	27	59	3	297
EX-SUS-GDR	2.2	27	59	3	283
VP-GDR	2.2	27	59	3	261
TDXL	2.2 X 10D	33	75	2.2	310
ADO-10D	2.2-3	33	75	3	160
TDXL	2.2 X 15D	40	80	2.2	312
EX-GDXL	2.2	40	100	2.2	301
EX-GDXL	2.2	50	100	2.2	301
TDXL	2.2 X 20D	52	90	2.2	314
EX-SUS-GDS	2.21	13	45	3	274
VPH-GDS	2.21	13	45	3	254

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	2.21	27	59	3	283
EX-SUS-GDS	2.22	13	45	3	274
VPH-GDS	2.22	13	45	3	254
EX-SUS-GDR	2.22	27	59	3	283
EX-SUS-GDS	2.23	13	45	3	274
VPH-GDS	2.23	13	45	3	254
EX-SUS-GDR	2.23	27	59	3	283
EX-SUS-GDS	2.24	13	45	3	274
VPH-GDS	2.24	13	45	3	254
EX-SUS-GDR	2.24	27	59	3	283
EX-GDS	2.25	13	45	3	290
EX-SUS-GDS	2.25	13	45	3	274
VPH-GDS	2.25	13	45	3	254
WX-MS-GDS	2.25	13	50	3	194
EX-GDN	2.25	20	52	3	295
EX-GDR	2.25	27	59	3	297
EX-SUS-GDR	2.25	27	59	3	283
EX-SUS-GDS	2.26	13	45	3	274
VPH-GDS	2.26	13	45	3	254
EX-SUS-GDR	2.26	27	59	3	283
EX-SUS-GDS	2.27	13	45	3	274
VPH-GDS	2.27	13	45	3	254
EX-SUS-GDR	2.27	27	59	3	283
EX-SUS-GDS	2.28	13	45	3	274
NEXUS-GDS	2.28	13	45	3	271
VPH-GDS	2.28	13	45	3	254
EX-SUS-GDR	2.28	27	59	3	283
EX-SUS-GDS	2.29	13	45	3	274
VPH-GDS	2.29	13	45	3	254
EX-SUS-GDR	2.29	27	59	3	283
MRS-GDL	2.29	27.6	62	3	201

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	2.3	11	50	4	344
WH70-DRL	2.3	13	43	3	212
EX-GDS	2.3	13	45	3	290
EX-SUS-GDS	2.3	13	45	3	274
NEXUS-GDS	2.3	13	45	3	271
VPH-GDS	2.3	13	45	3	254
WX-MS-GDS	2.3	13	50	3	194
AD-2D	2.3-3	14	62	3	137
AD-2D	2.3	14	62	4	137
ADO-3D	2.3-3	14	66	3	149
ADO-SUS-3D	2.3-3	14	66	3	173
EX-GDN	2.3	20	52	3	295
D-GDN	2.3	20	54	3	243
AD-4D	2.3-3	20	66	3	141
AD-4D	2.3	20	66	4	141
ADO-5D	2.3-3	21	70	3	153
ADO-SUS-5D	2.3-3	21	70	3	176
ADO-8D	2.3-3	26	75	3	157
ADO-SUS-8D	2.3-3	26	75	3	180
V-SDR	2.3	27	53	2.3	321
EX-GDR	2.3	27	59	3	297
EX-SUS-GDR	2.3	27	59	3	283
NEXUS-GDR	2.3	27	59	3	272
VP-GDR	2.3	27	59	3	261
MRS-GDL	2.3	27.6	62	3	201
TDXL	2.3 × 10D	33	75	2.3	310
ADO-10D	2.3-3	33	75	3	160
EX-GDXL	2.3	40	100	2.3	301
TDXL	2.3 × 15D	42	85	2.3	312
EX-GDXL	2.3	50	100	2.3	301
TDXL	2.3 × 20D	54	95	2.3	314

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	2.31	13	45	3	274
VPH-GDS	2.31	13	45	3	254
EX-SUS-GDR	2.31	27	59	3	283
MRS-GDL	2.31	28.2	62	3	201
ADF-2D	2.32	11	50	4	344
EX-SUS-GDS	2.32	13	45	3	274
VPH-GDS	2.32	13	45	3	254
EX-SUS-GDR	2.32	27	59	3	283
EX-SUS-GDS	2.33	13	45	3	274
VPH-GDS	2.33	13	45	3	254
EX-SUS-GDR	2.33	27	59	3	283
EX-SUS-GDS	2.34	13	45	3	274
VPH-GDS	2.34	13	45	3	254
EX-SUS-GDR	2.34	27	59	3	283
EX-GDS	2.35	13	45	3	290
EX-SUS-GDS	2.35	13	45	3	274
VPH-GDS	2.35	13	45	3	254
WX-MS-GDS	2.35	13	50	3	194
EX-GDN	2.35	20	52	3	295
EX-GDR	2.35	27	59	3	297
EX-SUS-GDR	2.35	27	59	3	283
EX-SUS-GDS	2.36	13	45	3	274
VPH-GDS	2.36	13	45	3	254
EX-SUS-GDR	2.36	27	59	3	283
EX-SUS-GDS	2.37	14	46	3	274
VPH-GDS	2.37	14	46	3	254
EX-SUS-GDR	2.37	30	62	3	283
EX-SUS-GDS	2.38	14	46	3	274
NEXUS-GDS	2.38	14	46	3	271
VPH-GDS	2.38	14	46	3	254
EX-SUS-GDR	2.38	30	62	3	283

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	2.39	14	46	3	274
VPH-GDS	2.39	14	46	3	254
MRS-GDL	2.39	28.8	62	3	201
EX-SUS-GDR	2.39	30	62	3	283
ADF-2D	2.4	12	50	4	344
WH70-DRL	2.4	14	44	3	212
EX-GDS	2.4	14	46	3	290
EX-SUS-GDS	2.4	14	46	3	274
NEXUS-GDS	2.4	14	46	3	271
VPH-GDS	2.4	14	46	3	254
WX-MS-GDS	2.4	14	50	3	194
AD-2D	2.4-3	14	62	3	137
AD-2D	2.4	14	62	4	137
ADO-3D	2.4-3	15	66	3	149
ADO-SUS-3D	2.4-3	15	66	3	173
AD-4D	2.4-3	20	66	3	141
AD-4D	2.4	20	66	4	141
EX-GDN	2.4	22	54	3	295
ADO-5D	2.4-3	22	70	3	153
ADO-SUS-5D	2.4-3	22	70	3	176
ADO-8D	2.4-3	27	75	3	157
ADO-SUS-8D	2.4-3	27	75	3	180
MRS-GDL	2.4	28.8	62	3	201
V-SDR	2.4	30	57	2.4	321
EX-GDR	2.4	30	62	3	297
EX-SUS-GDR	2.4	30	62	3	283
VP-GDR	2.4	30	62	3	261
TDXL	2.4 × 10D	33	75	2.4	310
ADO-10D	2.4-3	33	75	3	160
EX-GDXL	2.4	40	100	2.4	301
TDXL	2.4 × 15D	44	85	2.4	312

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	2.4	50	100	2.4	301
TDXL	2.4 X 20D	56	95	2.4	314
EX-SUS-GDS	2.41	14	46	3	274
VPH-GDS	2.41	14	46	3	254
MRS-GDL	2.41	29.4	66	3	201
EX-SUS-GDR	2.41	30	62	3	283
ADF-2D	2.42	12	50	4	344
EX-SUS-GDS	2.42	14	46	3	274
VPH-GDS	2.42	14	46	3	255
MRS-GDL	2.42	29.4	66	3	201
EX-SUS-GDR	2.42	30	62	3	283
EX-SUS-GDS	2.43	14	46	3	274
VPH-GDS	2.43	14	46	3	255
EX-SUS-GDR	2.43	30	62	3	283
EX-SUS-GDS	2.44	14	46	3	274
VPH-GDS	2.44	14	46	3	255
EX-SUS-GDR	2.44	30	62	3	283
EX-GDS	2.45	14	46	3	290
EX-SUS-GDS	2.45	14	46	3	274
VPH-GDS	2.45	14	46	3	255
WX-MS-GDS	2.45	14	50	3	194
EX-GDN	2.45	22	54	3	295
EX-GDR	2.45	30	62	3	297
EX-SUS-GDR	2.45	30	62	3	283
EX-SUS-GDS	2.46	14	46	3	274
VPH-GDS	2.46	14	46	3	255
EX-SUS-GDR	2.46	30	62	3	283
EX-SUS-GDS	2.47	14	46	3	274
VPH-GDS	2.47	14	46	3	255
EX-SUS-GDR	2.47	30	62	3	283
EX-SUS-GDS	2.48	14	46	3	274

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	2.48	14	46	3	255
EX-SUS-GDR	2.48	30	62	3	283
NEPTUNE	2.489	12.7	38.1	1/4-28UNF	252
EX-SUS-GDS	2.49	14	46	3	274
VPH-GDS	2.49	14	46	3	255
EX-SUS-GDR	2.49	30	62	3	283
ED-DS	2.5	9	41	3	245
ADF-2D	2.5	12	50	4	344
FHL-GDTS	2.5 X 30	13	65	3	215
WH70-DRL	2.5	14	44	3	212
EX-GDS	2.5	14	46	3	290
EX-SUS-GDS	2.5	14	46	3	274
NEXUS-GDS	2.5	14	46	3	271
VPH-GDS	2.5	14	46	3	255
WX-MS-GDS	2.5	14	50	3	194
AD-2D	2.5-3	14	62	3	137
AD-2D	2.5	14	62	4	137
EX-LS-GDS	2.5	14	100	2.5	293
EX-LS-GDS	2.5	14	120	2.5	293
EX-LS-GDS	2.5	14	150	2.5	293
ADO-3D	2.5-3	15	66	3	149
ADO-SUS-3D	2.5-3	15	66	3	173
AD-4D	2.5-3	20	66	3	141
AD-4D	2.5	20	66	4	141
D-GDN	2.5	22	54	3	243
EX-GDN	2.5	22	54	3	295
ADO-5D	2.5-3	23	70	3	153
ADO-SUS-5D	2.5-3	23	70	3	176
WH55-5D	2.5	23	73	4	210
ADO-8D	2.5-3	28	75	3	157
ADO-SUS-8D	2.5-3	28	75	3	180

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
V-SDR	2.5	30	57	2.5	321
EX-GDR	2.5	30	62	3	297
EX-SUS-GDR	2.5	30	62	3	283
NEXUS-GDR	2.5	30	62	3	272
VP-GDR	2.5	30	62	3	261
MRS-GDL	2.5	30	66	3	201
TDXL	2.5 X 10D	33	75	2.5	310
ADO-10D	2.5-3	33	75	3	160
TDXL	2.5 X 15D	46	85	2.5	312
EX-GDXL	2.5	50	100	2.5	301
TDXL	2.5 X 20D	58	100	2.5	314
D-DAD	2.502	15	50	2.502	249
D-GDN90	2.502	15	50	2.502	251
D-STAD	2.502	15	65	2.502	248
EX-SUS-GDS	2.51	14	46	3	274
VPH-GDS	2.51	14	46	3	255
EX-SUS-GDR	2.51	30	62	3	283
EX-SUS-GDS	2.52	14	46	3	274
VPH-GDS	2.52	14	46	3	255
EX-SUS-GDR	2.52	30	62	3	283
EX-SUS-GDS	2.53	14	46	3	274
VPH-GDS	2.53	14	46	3	255
EX-SUS-GDR	2.53	30	62	3	283
ADF-2D	2.54	12	50	4	344
EX-SUS-GDS	2.54	14	46	3	274
VPH-GDS	2.54	14	46	3	255
EX-SUS-GDR	2.54	30	62	3	283
EX-GDS	2.55	14	46	3	290
EX-SUS-GDS	2.55	14	46	3	274
VPH-GDS	2.55	14	46	3	255
WX-MS-GDS	2.55	14	50	3	194

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDN	2.55	22	54	3	295
EX-GDR	2.55	30	62	3	297
EX-SUS-GDR	2.55	30	62	3	283
MRS-GDL	2.55	30.6	66	3	201
EX-SUS-GDS	2.56	14	46	3	274
VPH-GDS	2.56	14	46	3	255
EX-SUS-GDR	2.56	30	62	3	283
MRS-GDL	2.56	31.2	66	3	201
EX-SUS-GDS	2.57	14	46	3	274
VPH-GDS	2.57	14	46	3	255
EX-SUS-GDR	2.57	30	62	3	283
MRS-GDL	2.57	31.2	66	3	201
ADF-2D	2.58	13	50	4	344
EX-SUS-GDS	2.58	14	46	3	275
VPH-GDS	2.58	14	46	3	255
EX-SUS-GDR	2.58	30	62	3	283
EX-SUS-GDS	2.59	14	46	3	275
VPH-GDS	2.59	14	46	3	255
EX-SUS-GDR	2.59	30	62	3	283
ADF-2D	2.6	13	50	4	344
WH70-DRL	2.6	14	44	3	212
EX-GDS	2.6	14	46	3	290
EX-SUS-GDS	2.6	14	46	3	275
NEXUS-GDS	2.6	14	46	3	271
VPH-GDS	2.6	14	46	3	255
WX-MS-GDS	2.6	14	50	3	194
AD-2D	2.6-3	14	62	3	137
AD-2D	2.6	14	62	4	137
ADO-3D	2.6-3	16	66	3	149
ADO-SUS-3D	2.6-3	16	66	3	173
AD-4D	2.6-3	20	66	3	141

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-4D	2.6	20	66	4	141
EX-GDN	2.6	22	54	3	295
ADO-5D	2.6-3	24	78	3	153
ADO-SUS-5D	2.6-3	24	78	3	176
ADO-8D	2.6-3	29	80	3	157
ADO-SUS-8D	2.6-3	29	80	3	180
V-SDR	2.6	30	57	2.6	321
EX-GDR	2.6	30	62	3	297
EX-SUS-GDR	2.6	30	62	3	283
NEXUS-GDR	2.6	30	62	3	272
VP-GDR	2.6	30	62	3	261
MRS-GDL	2.6	31.2	66	3	201
TDXL	2.6 × 10D	40	90	2.6	310
ADO-10D	2.6-3	40	90	3	160
TDXL	2.6 × 15D	48	100	2.6	312
EX-GDXL	2.6	50	100	2.6	301
TDXL	2.6 × 20D	60	110	2.6	314
EX-SUS-GDS	2.61	14	46	3	275
VPH-GDS	2.61	14	46	3	255
EX-SUS-GDR	2.61	30	62	3	283
EX-SUS-GDS	2.62	14	46	3	275
VPH-GDS	2.62	14	46	3	255
EX-SUS-GDR	2.62	30	62	3	283
EX-SUS-GDS	2.63	14	46	3	275
VPH-GDS	2.63	14	46	3	255
EX-SUS-GDR	2.63	30	62	3	283
EX-SUS-GDS	2.64	14	46	3	275
VPH-GDS	2.64	14	46	3	255
EX-SUS-GDR	2.64	30	62	3	283
EX-GDS	2.65	14	46	3	290
EX-SUS-GDS	2.65	14	46	3	275

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	2.65	14	46	3	255
WX-MS-GDS	2.65	14	50	3	194
ADO-3D	2.65-3	16	66	3	149
EX-GDN	2.65	22	54	3	295
ADO-5D	2.65-3	24	78	3	153
EX-GDR	2.65	30	62	3	297
EX-SUS-GDR	2.65	30	62	3	283
EX-SUS-GDS	2.66	16	48	3	275
VPH-GDS	2.66	16	48	3	255
EX-SUS-GDR	2.66	33	65	3	283
EX-SUS-GDS	2.67	16	48	3	275
VPH-GDS	2.67	16	48	3	255
EX-SUS-GDR	2.67	33	65	3	283
EX-SUS-GDS	2.68	16	48	3	275
VPH-GDS	2.68	16	48	3	255
EX-SUS-GDR	2.68	33	65	3	283
EX-SUS-GDS	2.69	16	48	3	275
VPH-GDS	2.69	16	48	3	255
EX-SUS-GDR	2.69	33	65	3	283
ADF-2D	2.7	13	50	4	344
AD-2D	2.7-3	14	62	3	137
AD-2D	2.7	14	62	4	137
WH70-DRL	2.7	16	46	3	212
EX-GDS	2.7	16	48	3	290
EX-SUS-GDS	2.7	16	48	3	275
NEXUS-GDS	2.7	16	48	3	271
VPH-GDS	2.7	16	48	3	255
WX-MS-GDS	2.7	16	50	3	194
ADO-3D	2.7-3	17	66	3	149
ADO-SUS-3D	2.7-3	17	66	3	173
AD-4D	2.7-3	20	66	3	141

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-4D	2.7	20	66	4	141
EX-GDN	2.7	25	57	3	295
ADO-5D	2.7-3	25	78	3	153
ADO-SUS-5D	2.7-3	25	78	3	176
ADO-8D	2.7-3	30	80	3	157
ADO-SUS-8D	2.7-3	30	80	3	180
MRS-GDL	2.7	32.4	66	3	201
V-SDR	2.7	33	61	2.7	321
EX-GDR	2.7	33	65	3	297
EX-SUS-GDR	2.7	33	65	3	283
VP-GDR	2.7	33	65	3	261
TDXL	2.7 × 10D	40	90	2.7	310
ADO-10D	2.7-3	40	90	3	160
EX-GDXL	2.7	50	100	2.7	301
TDXL	2.7 × 15D	50	100	2.7	312
TDXL	2.7 × 20D	64	115	2.7	314
EX-SUS-GDS	2.71	16	48	3	275
VPH-GDS	2.71	16	48	3	255
EX-SUS-GDR	2.71	33	65	3	283
EX-SUS-GDS	2.72	16	48	3	275
VPH-GDS	2.72	16	48	3	255
EX-SUS-GDR	2.72	33	65	3	283
EX-SUS-GDS	2.73	16	48	3	275
VPH-GDS	2.73	16	48	3	255
EX-SUS-GDR	2.73	33	65	3	283
EX-SUS-GDS	2.74	16	48	3	275
VPH-GDS	2.74	16	48	3	255
EX-SUS-GDR	2.74	33	65	3	283
EX-GDS	2.75	16	48	3	290
EX-SUS-GDS	2.75	16	48	3	275
VPH-GDS	2.75	16	48	3	255

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WX-MS-GDS	2.75	16	50	3	194
EX-GDN	2.75	25	57	3	295
EX-GDR	2.75	33	65	3	297
EX-SUS-GDR	2.75	33	65	3	283
ADF-2D	2.76	14	50	4	344
AD-2D	2.76	14	62	4	137
EX-SUS-GDS	2.76	16	48	3	275
NEXUS-GDS	2.76	16	48	3	271
VPH-GDS	2.76	16	48	3	255
ADO-5D	2.76-3	25	78	3	153
ADO-SUS-5D	2.76-3	25	78	3	176
EX-SUS-GDR	2.76	33	65	3	283
VP-GDR	2.76	33	65	3	261
EX-SUS-GDS	2.77	16	48	3	275
VPH-GDS	2.77	16	48	3	255
EX-SUS-GDR	2.77	33	65	3	283
MRS-GDL	2.77	33.6	66	3	201
ADF-2D	2.78	14	50	4	344
AD-2D	2.78	14	62	4	137
EX-SUS-GDS	2.78	16	48	3	275
NEXUS-GDS	2.78	16	48	3	271
VPH-GDS	2.78	16	48	3	255
ADO-5D	2.78-3	26	78	3	153
ADO-SUS-5D	2.78-3	26	78	3	176
EX-SUS-GDR	2.78	33	65	3	283
VP-GDR	2.78	33	65	3	261
MRS-GDL	2.78	33.6	66	3	201
EX-SUS-GDS	2.79	16	48	3	275
VPH-GDS	2.79	16	48	3	255
EX-SUS-GDR	2.79	33	65	3	283
MRS-GDL	2.79	33.6	66	3	201

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	2.8	14	50	4	344
AD-2D	2.8-3	14	62	3	137
AD-2D	2.8	14	62	4	137
WH70-DRL	2.8	16	46	3	212
EX-GDS	2.8	16	48	3	290
EX-SUS-GDS	2.8	16	48	3	275
NEXUS-GDS	2.8	16	48	3	271
VPH-GDS	2.8	16	48	3	255
WX-MS-GDS	2.8	16	50	3	194
ADO-3D	2.8-3	17	66	3	149
ADO-SUS-3D	2.8-3	17	66	3	173
AD-4D	2.8-3	20	66	3	141
AD-4D	2.8	20	66	4	141
EX-GDN	2.8	25	57	3	295
ADO-5D	2.8-3	26	78	3	153
ADO-SUS-5D	2.8-3	26	78	3	176
WH55-5D	2.8	27	73	4	210
ADO-8D	2.8-3	31	80	3	157
ADO-SUS-8D	2.8-3	31	80	3	180
V-SDR	2.8	33	61	2.8	321
EX-GDR	2.8	33	65	3	297
EX-SUS-GDR	2.8	33	65	3	283
NEXUS-GDR	2.8	33	65	3	272
VP-GDR	2.8	33	65	3	261
MRS-GDL	2.8	33.6	66	3	201
TDXL	2.8 × 10D	40	90	2.8	310
ADO-10D	2.8-3	40	90	3	160
EX-GDXL	2.8	50	100	2.8	301
TDXL	2.8 × 15D	50	100	2.8	312
TDXL	2.8 × 20D	66	115	2.8	314
EX-SUS-GDS	2.81	16	48	3	275

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	2.81	16	48	3	255
EX-SUS-GDR	2.81	33	65	3	283
EX-SUS-GDS	2.82	16	48	3	275
VPH-GDS	2.82	16	48	3	255
EX-SUS-GDR	2.82	33	65	3	283
EX-SUS-GDS	2.83	16	48	3	275
VPH-GDS	2.83	16	48	3	255
ADO-SUS-3D	2.83-3	17	66	3	173
ADO-SUS-5D	2.83-3	26	78	3	176
EX-SUS-GDR	2.83	33	65	3	283
EX-SUS-GDS	2.84	16	48	3	275
VPH-GDS	2.84	16	48	3	255
EX-SUS-GDR	2.84	33	65	3	283
EX-GDS	2.85	16	48	3	290
EX-SUS-GDS	2.85	16	48	3	275
VPH-GDS	2.85	16	48	3	255
WX-MS-GDS	2.85	16	50	3	194
EX-GDN	2.85	25	57	3	295
EX-GDR	2.85	33	65	3	297
EX-SUS-GDR	2.85	33	65	3	283
EX-SUS-GDS	2.86	16	48	3	275
VPH-GDS	2.86	16	48	3	255
EX-SUS-GDR	2.86	33	65	3	283
EX-SUS-GDS	2.87	16	48	3	275
VPH-GDS	2.87	16	48	3	255
ADO-SUS-3D	2.87-3	18	66	3	173
ADO-SUS-5D	2.87-3	26	78	3	176
EX-SUS-GDR	2.87	33	65	3	283
EX-SUS-GDS	2.88	16	48	3	275
VPH-GDS	2.88	16	48	3	255
EX-SUS-GDR	2.88	33	65	3	283

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	2.89	16	48	3	275
VPH-GDS	2.89	16	48	3	255
EX-SUS-GDR	2.89	33	65	3	283
ADF-2D	2.9	14	50	4	344
AD-2D	2.9-3	14	62	3	137
AD-2D	2.9	14	62	4	137
WH70-DRL	2.9	16	46	3	212
EX-GDS	2.9	16	48	3	290
EX-SUS-GDS	2.9	16	48	3	275
NEXUS-GDS	2.9	16	48	3	271
VPH-GDS	2.9	16	48	3	255
WX-MS-GDS	2.9	16	50	3	194
ADO-3D	2.9-3	18	66	3	149
ADO-SUS-3D	2.9-3	18	66	3	173
AD-4D	2.9-3	20	66	3	141
AD-4D	2.9	20	66	4	141
EX-GDN	2.9	25	57	3	295
ADO-5D	2.9-3	27	78	3	153
ADO-SUS-5D	2.9-3	27	78	3	176
ADO-8D	2.9-3	32	80	3	157
ADO-SUS-8D	2.9-3	32	80	3	180
V-SDR	2.9	33	61	2.9	321
EX-GDR	2.9	33	65	3	297
EX-SUS-GDR	2.9	33	65	3	283
VP-GDR	2.9	33	65	3	261
MRS-GDL	2.9	34.8	66	3	201
TDXL	2.9 × 10D	40	90	2.9	310
ADO-10D	2.9-3	40	90	3	160
EX-GDXL	2.9	50	100	2.9	301
TDXL	2.9 × 15D	54	105	2.9	312
TDXL	2.9 × 20D	68	120	2.9	314

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	2.91	16	48	3	275
VPH-GDS	2.91	16	48	3	255
EX-SUS-GDR	2.91	33	65	3	283
EX-SUS-GDS	2.92	16	48	3	275
VPH-GDS	2.92	16	48	3	255
EX-SUS-GDR	2.92	33	65	3	283
EX-SUS-GDS	2.93	16	48	3	275
VPH-GDS	2.93	16	48	3	255
EX-SUS-GDR	2.93	33	65	3	283
EX-SUS-GDS	2.94	16	48	3	275
VPH-GDS	2.94	16	48	3	255
EX-SUS-GDR	2.94	33	65	3	283
EX-GDS	2.95	16	48	3	290
EX-SUS-GDS	2.95	16	48	3	275
VPH-GDS	2.95	16	48	3	255
WX-MS-GDS	2.95	16	50	3	194
EX-GDN	2.95	25	57	3	295
EX-GDR	2.95	33	65	3	297
EX-SUS-GDR	2.95	33	65	3	283
EX-SUS-GDS	2.96	16	48	3	275
VPH-GDS	2.96	16	48	3	255
EX-SUS-GDR	2.96	33	65	3	283
EX-SUS-GDS	2.97	16	48	3	275
VPH-GDS	2.97	16	48	3	255
EX-SUS-GDR	2.97	33	65	3	283
EX-SUS-GDS	2.98	16	48	3	275
VPH-GDS	2.98	16	48	3	255
EX-SUS-GDR	2.98	33	65	3	283
EX-SUS-GDS	2.99	16	48	3	275
VPH-GDS	2.99	16	48	3	255
EX-SUS-GDR	2.99	33	65	3	283

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ED-DS	3	11	43	3	245
EX-H-DRL	3	15	40	3	319
ADFO-3D	3	15	55	4	359
ADF-2D	3	15	55	6	344
FHL-GDTS	3 × 30	15	65	3	215
ADFLS-2D	3	15	100	6	356
WH70-DRL	3	16	46	3	212
EX-GDS	3	16	48	3	290
EX-SUS-GDS	3	16	48	3	275
NEXUS-GDS	3	16	48	3	271
VPH-GDS	3	16	48	3	255
WX-MS-GDS	3	16	50	3	194
ADO-3D	3-3	18	66	3	149
ADO-SUS-3D	3-3	18	66	3	173
ADO-TRS-3D	3	18	66	3	182
AD-2D	3-3	20	66	3	137
AD-2D	3	20	66	4	137
EX-GDN	3	25	57	3	295
D-GDN	3	25	59	3	243
NF-GDN	3	25	59	3	203
ADO-5D	3-3	27	78	3	153
ADO-SUS-5D	3-3	27	78	3	176
ADO-TRS-5D	3	27	78	3	184
AD-4D	3-3	28	74	3	141
AD-4D	3	28	74	4	141
WH55-5D	3	29	78	6	210
V-SDR	3	33	61	3	321
EX-GDR	3	33	65	3	297
EX-SUS-GDR	3	33	65	3	283
NEXUS-GDR	3	33	65	3	272
VP-GDR	3	33	65	3	261

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-8D	3-3	33	80	3	157
ADO-SUS-8D	3-3	33	80	3	180
MRS-GDL	3	36	66	3	201
ADO-10D	3-3	40	90	3	160
TDXL	3 × 10D	40	90	3	310
TDXL	3 × 15D	54	105	3	312
EX-GDXL	3	55	100	3	301
VP-GDXL	3	55	100	3	270
ADO-15D	3-3	55	105	3	162
CAO-GDXL	3 × 15D	55	105	3	205
ADO-20D	3-3	70	120	3	164
TDXL	3 × 20D	70	120	3	314
EX-GDXL	3	75	150	3	301
ADO-25D	3-3	85	135	3	166
ADO-30D	3-3	100	150	3	168
EX-GDXL	3	100	200	3	301
ADO-40D	3	129	179	3	170
ADO-50D	3	159	209	3	171
EX-SUS-GDS	3.01	18	50	4	275
VPH-GDS	3.01	18	50	4	255
EX-SUS-GDR	3.01	36	68	4	283
EX-SUS-GDS	3.02	18	50	4	275
VPH-GDS	3.02	18	50	4	255
EX-SUS-GDR	3.02	36	68	4	283
ADFO-3D	3.03	15	55	4	359
ADF-2D	3.03	15	55	6	344
ADO-PLT	3.03-3	15	65	3	172
EX-SUS-GDS	3.03	18	50	4	275
VPH-GDS	3.03	18	50	4	255
EX-SUS-GDR	3.03	36	68	4	283
EX-SUS-GDS	3.04	18	50	4	275

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	3.04	18	50	4	255
EX-SUS-GDR	3.04	36	68	4	284
EX-GDS	3.05	18	50	4	290
EX-SUS-GDS	3.05	18	50	4	275
VPH-GDS	3.05	18	50	4	255
WX-MS-GDS	3.05	18	56	4	194
EX-GDN	3.05	27	59	4	295
EX-GDR	3.05	36	68	4	297
EX-SUS-GDR	3.05	36	68	4	284
EX-SUS-GDS	3.06	18	50	4	275
VPH-GDS	3.06	18	50	4	255
EX-SUS-GDR	3.06	36	68	4	284
EX-SUS-GDS	3.07	18	50	4	275
VPH-GDS	3.07	18	50	4	255
EX-SUS-GDR	3.07	36	68	4	284
EX-SUS-GDS	3.08	18	50	4	275
VPH-GDS	3.08	18	50	4	255
EX-SUS-GDR	3.08	36	68	4	284
EX-SUS-GDS	3.09	18	50	4	275
VPH-GDS	3.09	18	50	4	255
EX-SUS-GDR	3.09	36	68	4	284
ADFO-3D	3.1	15	55	4	359
ADF-2D	3.1	15	55	6	344
ADFLS-2D	3.1	15	100	6	356
WH70-DRL	3.1	18	48	4	212
EX-GDS	3.1	18	50	4	290
EX-SUS-GDS	3.1	18	50	4	275
NEXUS-GDS	3.1	18	50	4	271
VPH-GDS	3.1	18	50	4	255
WX-MS-GDS	3.1	18	56	4	194
ADO-3D	3.1	19	74	4	149

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	3.1	19	74	4	173
AD-2D	3.1	20	66	4	137
EX-GDN	3.1	27	59	4	295
NF-GDN	3.1	27	65	4	203
AD-4D	3.1	28	74	4	141
ADO-5D	3.1	28	86	4	153
ADO-SUS-5D	3.1	28	86	4	176
ADO-8D	3.1	34	95	4	157
ADO-SUS-8D	3.1	34	95	4	180
V-SDR	3.1	36	65	3.1	321
EX-GDR	3.1	36	68	4	297
EX-SUS-GDR	3.1	36	68	4	284
VP-GDR	3.1	36	68	4	261
TDXL	3.1 X 10D	45	100	3.1	310
ADO-10D	3.1	45	100	4	160
EX-GDXL	3.1	55	100	3.1	301
TDXL	3.1 X 15D	56	110	3.1	312
ADO-15D	3.1	60	125	4	162
TDXL	3.1 X 20D	72	125	3.1	314
EX-GDXL	3.1	75	150	3.1	301
ADO-20D	3.1	80	140	4	164
ADO-25D	3.1	95	165	4	166
EX-GDXL	3.1	100	200	3.1	301
ADO-30D	3.1	102	185	4	168
EX-SUS-GDS	3.11	18	50	4	275
VPH-GDS	3.11	18	50	4	255
EX-SUS-GDR	3.11	36	68	4	284
EX-SUS-GDS	3.12	18	50	4	275
VPH-GDS	3.12	18	50	4	255
EX-SUS-GDR	3.12	36	68	4	284
EX-SUS-GDS	3.13	18	50	4	275

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	3.13	18	50	4	255
EX-SUS-GDR	3.13	36	68	4	284
EX-SUS-GDS	3.14	18	50	4	275
VPH-GDS	3.14	18	50	4	255
EX-SUS-GDR	3.14	36	68	4	284
ADFO-3D	3.15	15	55	4	359
ADF-2D	3.15	15	55	6	344
EX-GDS	3.15	18	50	4	290
EX-SUS-GDS	3.15	18	50	4	275
VPH-GDS	3.15	18	50	4	255
WX-MS-GDS	3.15	18	56	4	194
ADO-3D	3.15	19	74	4	149
ADO-SUS-3D	3.15	19	74	4	173
EX-GDN	3.15	27	59	4	295
ADO-5D	3.15	29	86	4	153
ADO-SUS-5D	3.15	29	86	4	176
EX-GDR	3.15	36	68	4	297
EX-SUS-GDR	3.15	36	68	4	284
EX-SUS-GDS	3.16	18	50	4	275
VPH-GDS	3.16	18	50	4	255
EX-SUS-GDR	3.16	36	68	4	284
EX-SUS-GDS	3.17	18	50	4	275
VPH-GDS	3.17	18	50	4	255
EX-SUS-GDR	3.17	36	68	4	284
EX-SUS-GDS	3.18	18	50	4	275
VPH-GDS	3.18	18	50	4	255
EX-SUS-GDR	3.18	36	68	4	284
EX-SUS-GDS	3.19	18	50	4	275
VPH-GDS	3.19	18	50	4	255
EX-SUS-GDR	3.19	36	68	4	284
ADFO-3D	3.2	15	55	4	359

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	3.2	15	55	6	344
ADFLS-2D	3.2	15	100	6	356
WH70-DRL	3.2	18	48	4	212
EX-GDS	3.2	18	50	4	290
EX-SUS-GDS	3.2	18	50	4	275
NEXUS-GDS	3.2	18	50	4	271
VPH-GDS	3.2	18	50	4	255
WX-MS-GDS	3.2	18	56	4	194
AD-2D	3.2	20	66	4	137
ADO-3D	3.2	20	74	4	149
ADO-SUS-3D	3.2	20	74	4	173
EX-GDN	3.2	27	59	4	295
NF-GDN	3.2	27	65	4	203
AD-4D	3.2	28	74	4	141
ADO-5D	3.2	29	86	4	153
ADO-SUS-5D	3.2	29	86	4	176
ADO-8D	3.2	35	95	4	157
ADO-SUS-8D	3.2	35	95	4	180
V-SDR	3.2	36	65	3.2	321
EX-GDR	3.2	36	68	4	297
EX-SUS-GDR	3.2	36	68	4	284
VP-GDR	3.2	36	68	4	261
TDXL	3.2 X 10D	45	100	3.2	310
ADO-10D	3.2	45	100	4	160
EX-GDXL	3.2	55	100	3.2	301
TDXL	3.2 X 15D	58	110	3.2	312
ADO-15D	3.2	60	125	4	162
TDXL	3.2 X 20D	74	125	3.2	314
EX-GDXL	3.2	75	150	3.2	301
ADO-20D	3.2	80	140	4	164
ADO-25D	3.2	95	165	4	166

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	3.2	100	200	3.2	301
ADO-30D	3.2	105	185	4	168
EX-SUS-GDS	3.21	18	50	4	275
VPH-GDS	3.21	18	50	4	255
EX-SUS-GDR	3.21	36	68	4	284
EX-SUS-GDS	3.22	18	50	4	275
VPH-GDS	3.22	18	50	4	255
EX-SUS-GDR	3.22	36	68	4	284
EX-SUS-GDS	3.23	18	50	4	275
VPH-GDS	3.23	18	50	4	255
EX-SUS-GDR	3.23	36	68	4	284
EX-SUS-GDS	3.24	18	50	4	275
VPH-GDS	3.24	18	50	4	255
EX-SUS-GDR	3.24	36	68	4	284
EX-GDS	3.25	18	50	4	290
EX-SUS-GDS	3.25	18	50	4	275
NEXUS-GDS	3.25	18	50	4	271
VPH-GDS	3.25	18	50	4	255
WX-MS-GDS	3.25	18	56	4	194
EX-GDN	3.25	27	59	4	295
EX-GDR	3.25	36	68	4	297
EX-SUS-GDR	3.25	36	68	4	284
EX-SUS-GDS	3.26	18	50	4	275
VPH-GDS	3.26	18	50	4	255
ADO-SUS-3D	3.26(#30)	20	74	4	173
ADO-SUS-5D	3.26(#30)	29	86	4	176
EX-SUS-GDR	3.26	36	68	4	284
NEPTUNE	3.264	12.7	38.1	1/4-28UNF	252
EX-SUS-GDS	3.27	18	50	4	275
VPH-GDS	3.27	18	50	4	255
EX-SUS-GDR	3.27	36	68	4	284

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
D-STAD	3.277	20	70	3.277	248
D-DAD	3.277	20	76	3.277	249
D-GDN90	3.277	20	76	3.277	251
EX-SUS-GDS	3.28	18	50	4	275
VPH-GDS	3.28	18	50	4	255
EX-SUS-GDR	3.28	36	68	4	284
EX-SUS-GDS	3.29	18	50	4	275
VPH-GDS	3.29	18	50	4	255
EX-SUS-GDR	3.29	36	68	4	284
ADFO-3D	3.3	15	55	4	359
ADF-2D	3.3	15	55	6	344
ADFLS-2D	3.3	15	100	6	356
WH70-DRL	3.3	18	48	4	212
EX-GDS	3.3	18	50	4	290
EX-SUS-GDS	3.3	18	50	4	275
NEXUS-GDS	3.3	18	50	4	271
VPH-GDS	3.3	18	50	4	255
WX-MS-GDS	3.3	18	56	4	194
EX-LS-GDS	3.3	18	100	3.3	293
EX-LS-GDS	3.3	18	120	3.3	293
EX-LS-GDS	3.3	18	150	3.3	293
AD-2D	3.3	20	66	4	137
ADO-3D	3.3	20	74	4	149
ADO-SUS-3D	3.3	20	74	4	173
ADO-TRS-3D	3.3	20	74	4	182
D-GDN	3.3	27	59	4	243
EX-GDN	3.3	27	59	4	295
NF-GDN	3.3	27	65	4	203
AD-4D	3.3	28	74	4	141
ADO-5D	3.3	30	86	4	153
ADO-SUS-5D	3.3	30	86	4	176

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-TRS-5D	3.3	30	86	4	184
WH55-5D	3.3	32	78	6	210
WHO55-5D	3.3	32	78	6	211
V-SDR	3.3	36	65	3.3	321
EX-GDR	3.3	36	68	4	297
EX-SUS-GDR	3.3	36	68	4	284
NEXUS-GDR	3.3	36	68	4	272
VP-GDR	3.3	36	68	4	261
ADO-8D	3.3	36	95	4	157
ADO-SUS-8D	3.3	36	95	4	180
TDXL	3.3 × 10D	45	100	3.3	310
ADO-10D	3.3	45	100	4	160
EX-GDXL	3.3	55	100	3.3	301
VP-GDXL	3.3	55	100	3.3	270
TDXL	3.3 × 15D	60	110	3.3	312
ADO-15D	3.3	60	125	4	162
EX-GDXL	3.3	75	150	3.3	301
TDXL	3.3 × 20D	76	125	3.3	314
ADO-20D	3.3	80	140	4	164
ADO-25D	3.3	95	165	4	166
EX-GDXL	3.3	100	200	3.3	301
ADO-30D	3.3	109	185	4	168
EX-SUS-GDS	3.31	18	50	4	275
VPH-GDS	3.31	18	50	4	255
EX-SUS-GDR	3.31	36	68	4	284
EX-SUS-GDS	3.32	18	50	4	275
VPH-GDS	3.32	18	50	4	255
EX-SUS-GDR	3.32	36	68	4	284
EX-SUS-GDS	3.33	18	50	4	275
VPH-GDS	3.33	18	50	4	255
EX-SUS-GDR	3.33	36	68	4	284

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	3.34	18	50	4	275
VPH-GDS	3.34	18	50	4	255
EX-SUS-GDR	3.34	36	68	4	284
EX-GDS	3.35	18	50	4	290
EX-SUS-GDS	3.35	18	50	4	275
VPH-GDS	3.35	18	50	4	255
WX-MS-GDS	3.35	18	56	4	194
EX-GDN	3.35	27	59	4	295
EX-GDR	3.35	36	68	4	297
EX-SUS-GDR	3.35	36	68	4	284
EX-SUS-GDS	3.36	20	52	4	275
VPH-GDS	3.36	20	52	4	255
EX-SUS-GDR	3.36	39	71	4	284
EX-SUS-GDS	3.37	20	52	4	275
VPH-GDS	3.37	20	52	4	255
EX-SUS-GDR	3.37	39	71	4	284
EX-SUS-GDS	3.38	20	52	4	275
VPH-GDS	3.38	20	52	4	256
EX-SUS-GDR	3.38	39	71	4	284
EX-SUS-GDS	3.39	20	52	4	275
VPH-GDS	3.39	20	52	4	256
EX-SUS-GDR	3.39	39	71	4	284
ADFO-3D	3.4	16	55	4	359
ADF-2D	3.4	16	55	6	344
ADFLS-2D	3.4	16	100	6	356
WH70-DRL	3.4	20	50	4	212
EX-GDS	3.4	20	52	4	290
EX-SUS-GDS	3.4	20	52	4	275
NEXUS-GDS	3.4	20	52	4	271
VPH-GDS	3.4	20	52	4	256
WX-MS-GDS	3.4	20	56	4	194

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	3.4	20	66	4	137
ADO-3D	3.4	21	74	4	149
ADO-SUS-3D	3.4	21	74	4	173
AD-4D	3.4	28	74	4	141
EX-GDN	3.4	30	62	4	295
NF-GDN	3.4	30	65	4	203
ADO-5D	3.4	31	86	4	153
ADO-SUS-5D	3.4	31	86	4	176
WHO55-5D	3.4	32	78	6	211
ADO-8D	3.4	37	95	4	157
ADO-SUS-8D	3.4	37	95	4	180
V-SDR	3.4	39	70	3.4	321
EX-GDR	3.4	39	71	4	297
EX-SUS-GDR	3.4	39	71	4	284
NEXUS-GDR	3.4	39	71	4	272
VP-GDR	3.4	39	71	4	261
TDXL	3.4 × 10D	50	100	3.4	310
ADO-10D	3.4	50	100	4	160
EX-GDXL	3.4	55	100	3.4	301
TDXL	3.4 × 15D	62	115	3.4	312
ADO-15D	3.4	65	125	4	162
EX-GDXL	3.4	75	150	3.4	301
TDXL	3.4 × 20D	80	130	3.4	314
ADO-20D	3.4	85	140	4	164
EX-GDXL	3.4	100	200	3.4	301
ADO-25D	3.4	105	165	4	166
ADO-30D	3.4	112	185	4	168
EX-SUS-GDS	3.41	20	52	4	275
VPH-GDS	3.41	20	52	4	256
EX-SUS-GDR	3.41	39	71	4	284
EX-SUS-GDS	3.42	20	52	4	275

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	3.42	20	52	4	256
EX-SUS-GDR	3.42	39	71	4	284
EX-SUS-GDS	3.43	20	52	4	275
VPH-GDS	3.43	20	52	4	256
EX-SUS-GDR	3.43	39	71	4	284
EX-SUS-GDS	3.44	20	52	4	275
VPH-GDS	3.44	20	52	4	256
EX-SUS-GDR	3.44	39	71	4	284
EX-GDS	3.45	20	52	4	290
EX-SUS-GDS	3.45	20	52	4	275
VPH-GDS	3.45	20	52	4	256
WX-MS-GDS	3.45	20	56	4	194
EX-GDN	3.45	30	62	4	295
EX-GDR	3.45	39	71	4	297
EX-SUS-GDR	3.45	39	71	4	284
EX-SUS-GDS	3.46	20	52	4	275
VPH-GDS	3.46	20	52	4	256
EX-SUS-GDR	3.46	39	71	4	284
EX-SUS-GDS	3.47	20	52	4	275
VPH-GDS	3.47	20	52	4	256
EX-SUS-GDR	3.47	39	71	4	284
EX-SUS-GDS	3.48	20	52	4	275
VPH-GDS	3.48	20	52	4	256
EX-SUS-GDR	3.48	39	71	4	284
EX-SUS-GDS	3.49	20	52	4	275
VPH-GDS	3.49	20	52	4	256
WHO55-5D	3.49	32	78	6	211
EX-SUS-GDR	3.49	39	71	4	284
ED-DS	3.5	15	47	4	245
ADFO-3D	3.5	16	55	4	359
ADF-2D	3.5	16	55	6	344

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADFLS-2D	3.5	16	100	6	356
WH70-DRL	3.5	20	50	4	212
EX-GDS	3.5	20	52	4	290
EX-SUS-GDS	3.5	20	52	4	275
NEXUS-GDS	3.5	20	52	4	271
VPH-GDS	3.5	20	52	4	256
WX-MS-GDS	3.5	20	56	4	194
AD-2D	3.5	20	66	4	137
ADO-3D	3.5	21	74	4	149
ADO-SUS-3D	3.5	21	74	4	173
ADO-TRS-3D	3.5	21	74	4	182
AD-4D	3.5	28	74	4	141
EX-GDN	3.5	30	62	4	295
D-GDN	3.5	30	65	4	243
NF-GDN	3.5	30	65	4	203
WH55-5D	3.5	32	78	6	210
WHO55-5D	3.5	32	78	6	211
ADO-5D	3.5	32	86	4	153
ADO-SUS-5D	3.5	32	86	4	176
ADO-TRS-5D	3.5	32	86	4	184
V-SDR	3.5	39	70	3.5	321
EX-GDR	3.5	39	71	4	297
EX-SUS-GDR	3.5	39	71	4	284
NEXUS-GDR	3.5	39	71	4	272
VP-GDR	3.5	39	71	4	261
ADO-8D	3.5	39	95	4	157
ADO-SUS-8D	3.5	39	95	4	180
TDXL	3.5 X 10D	50	100	3.5	310
ADO-10D	3.5	50	100	4	160
EX-GDXL	3.5	55	100	3.5	301
VP-GDXL	3.5	55	100	3.5	270

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
TDXL	3.5 X 15D	64	115	3.5	312
ADO-15D	3.5	65	125	4	162
EX-GDXL	3.5	75	150	3.5	301
TDXL	3.5 X 20D	82	130	3.5	314
ADO-20D	3.5	85	140	4	164
EX-GDXL	3.5	100	200	3.5	301
ADO-25D	3.5	105	165	4	166
ADO-30D	3.5	116	185	4	168
EX-SUS-GDS	3.51	20	52	4	275
VPH-GDS	3.51	20	52	4	256
EX-SUS-GDR	3.51	39	71	4	284
EX-SUS-GDS	3.52	20	52	4	275
VPH-GDS	3.52	20	52	4	256
EX-SUS-GDR	3.52	39	71	4	284
ADFO-3D	3.53	16	55	4	359
ADF-2D	3.53	16	55	6	344
ADO-PLT	3.53	18	70	4	172
EX-SUS-GDS	3.53	20	52	4	275
VPH-GDS	3.53	20	52	4	256
EX-SUS-GDR	3.53	39	71	4	284
EX-SUS-GDS	3.54	20	52	4	275
VPH-GDS	3.54	20	52	4	256
EX-SUS-GDR	3.54	39	71	4	284
EX-GDS	3.55	20	52	4	290
EX-SUS-GDS	3.55	20	52	4	275
VPH-GDS	3.55	20	52	4	256
WX-MS-GDS	3.55	20	56	4	194
EX-GDP.56N	3.55	30	62	4	295
EX-GDR	3.55	39	71	4	297
EX-SUS-GDR	3.55	39	71	4	284
EX-SUS-GDS	3.56	20	52	4	275

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	3.56	20	52	4	256
EX-SUS-GDR	3.56	39	71	4	284
EX-SUS-GDS	3.57	20	52	4	275
VPH-GDS	3.57	20	52	4	256
EX-SUS-GDR	3.57	39	71	4	284
EX-SUS-GDS	3.58	20	52	4	275
VPH-GDS	3.58	20	52	4	256
EX-SUS-GDR	3.58	39	71	4	284
EX-SUS-GDS	3.59	20	52	4	275
VPH-GDS	3.59	20	52	4	256
EX-SUS-GDR	3.59	39	71	4	284
ADFO-3D	3.6	16	55	4	359
ADF-2D	3.6	16	55	6	344
ADFLS-2D	3.6	16	100	6	356
WH70-DRL	3.6	20	50	4	212
EX-GDS	3.6	20	52	4	290
EX-SUS-GDS	3.6	20	52	4	275
NEXUS-GDS	3.6	20	52	4	271
VPH-GDS	3.6	20	52	4	256
WX-MS-GDS	3.6	20	56	4	194
AD-2D	3.6	20	66	4	137
ADO-3D	3.6	22	74	4	149
ADO-SUS-3D	3.6	22	74	4	173
AD-4D	3.6	28	74	4	141
EX-GDN	3.6	30	62	4	295
NF-GDN	3.6	30	65	4	203
ADO-5D	3.6	33	86	4	153
ADO-SUS-5D	3.6	33	86	4	176
WHO55-5D	3.6	34	78	6	211
V-SDR	3.6	39	70	3.6	321
EX-GDR	3.6	39	71	4	297

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	3.6	39	71	4	284
VP-GDR	3.6	39	71	4	261
ADO-8D	3.6	40	95	4	157
ADO-SUS-8D	3.6	40	95	4	180
TDXL	3.6 X 10D	50	100	3.6	310
ADO-10D	3.6	50	100	4	160
EX-GDXL	3.6	55	100	3.6	301
ADO-15D	3.6	65	125	4	162
TDXL	3.6 X 15D	66	115	3.6	312
EX-GDXL	3.6	75	150	3.6	301
ADO-20D	3.6	85	140	4	164
EX-GDXL	3.6	100	200	3.6	301
ADO-25D	3.6	105	165	4	166
ADO-30D	3.6	116	185	4	168
EX-SUS-GDS	3.61	20	52	4	275
VPH-GDS	3.61	20	52	4	256
EX-SUS-GDR	3.61	39	71	4	284
EX-SUS-GDS	3.62	20	52	4	276
VPH-GDS	3.62	20	52	4	256
EX-SUS-GDR	3.62	39	71	4	284
EX-SUS-GDS	3.63	20	52	4	276
VPH-GDS	3.63	20	52	4	256
EX-SUS-GDR	3.63	39	71	4	284
EX-SUS-GDS	3.64	20	52	4	276
VPH-GDS	3.64	20	52	4	256
EX-SUS-GDR	3.64	39	71	4	284
EX-GDS	3.65	20	52	4	290
EX-SUS-GDS	3.65	20	52	4	276
NEXUS-GDS	3.65	20	52	4	271
VPH-GDS	3.65	20	52	4	256
WX-MS-GDS	3.65	20	56	4	194

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDN	3.65	30	62	4	295
EX-GDR	3.65	39	71	4	297
EX-SUS-GDR	3.65	39	71	4	284
ADFO-3D	3.66	16	55	4	359
ADF-2D	3.66	16	55	6	344
EX-SUS-GDS	3.66	20	52	4	276
VPH-GDS	3.66	20	52	4	256
AD-2D	3.66	20	66	4	137
ADO-TRS-3D	3.66	22	74	4	182
NF-GDN	3.66	30	65	4	203
ADO-5D	3.66	33	86	4	153
ADO-SUS-5D	3.66	33	86	4	176
ADO-TRS-5D	3.66	33	86	4	184
EX-SUS-GDR	3.66	39	71	4	284
VP-GDR	3.66	39	71	4	261
EX-SUS-GDS	3.67	20	52	4	276
NEXUS-GDS	3.67	20	52	4	271
VPH-GDS	3.67	20	52	4	256
EX-SUS-GDR	3.67	39	71	4	284
ADFO-3D	3.68	16	55	4	359
ADF-2D	3.68	16	55	6	344
EX-SUS-GDS	3.68	20	52	4	276
VPH-GDS	3.68	20	52	4	256
AD-2D	3.68	20	66	4	137
NF-GDN	3.68	30	65	4	203
ADO-5D	3.68	34	86	4	153
ADO-SUS-5D	3.68	34	86	4	176
EX-SUS-GDR	3.68	39	71	4	284
VP-GDR	3.68	39	71	4	261
EX-SUS-GDS	3.69	20	52	4	276
VPH-GDS	3.69	20	52	4	256

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	3.69	39	71	4	284
ADFO-3D	3.7	16	55	4	359
ADF-2D	3.7	16	55	6	344
ADFLS-2D	3.7	16	100	6	356
WH70-DRL	3.7	20	50	4	212
EX-GDS	3.7	20	52	4	290
EX-SUS-GDS	3.7	20	52	4	276
NEXUS-GDS	3.7	20	52	4	271
VPH-GDS	3.7	20	52	4	256
WX-MS-GDS	3.7	20	56	4	194
AD-2D	3.7	20	66	4	137
ADO-3D	3.7	23	74	4	149
ADO-SUS-3D	3.7	23	74	4	173
AD-4D	3.7	28	74	4	141
EX-GDN	3.7	30	62	4	295
NF-GDN	3.7	30	65	4	203
WHO55-5D	3.7	34	78	6	211
ADO-5D	3.7	34	86	4	153
ADO-SUS-5D	3.7	34	86	4	176
V-SDR	3.7	39	70	3.7	321
EX-GDR	3.7	39	71	4	297
EX-SUS-GDR	3.7	39	71	4	284
VP-GDR	3.7	39	71	4	261
ADO-8D	3.7	41	95	4	157
ADO-SUS-8D	3.7	41	95	4	180
TDXL	3.7 X 10D	50	100	3.7	310
ADO-10D	3.7	50	100	4	160
EX-GDXL	3.7	55	100	3.7	301
ADO-15D	3.7	65	125	4	162
TDXL	3.7 X 15D	68	120	3.7	312
EX-GDXL	3.7	75	150	3.7	301

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-20D	3.7	85	140	4	164
TDXL	3.7 X 20D	86	135	3.7	314
EX-GDXL	3.7	100	200	3.7	301
ADO-25D	3.7	105	165	4	166
ADO-30D	3.7	116	185	4	168
EX-SUS-GDS	3.71	20	52	4	276
VPH-GDS	3.71	20	52	4	256
EX-SUS-GDR	3.71	39	71	4	284
EX-SUS-GDS	3.72	20	52	4	276
VPH-GDS	3.72	20	52	4	256
EX-SUS-GDR	3.72	39	71	4	284
EX-SUS-GDS	3.73	20	52	4	276
VPH-GDS	3.73	20	52	4	256
ADO-SUS-3D	3.73	23	74	4	173
ADO-SUS-5D	3.73	34	86	4	176
EX-SUS-GDR	3.73	39	71	4	284
EX-SUS-GDS	3.74	20	52	4	276
VPH-GDS	3.74	20	52	4	256
EX-SUS-GDR	3.74	39	71	4	284
EX-GDS	3.75	20	52	4	290
EX-SUS-GDS	3.75	20	52	4	276
VPH-GDS	3.75	20	52	4	256
WX-MS-GDS	3.75	20	56	4	194
ADO-3D	3.75	23	74	4	149
ADO-SUS-3D	3.75	23	74	4	173
EX-GDN	3.75	30	62	4	295
ADO-5D	3.75	34	86	4	153
ADO-SUS-5D	3.75	34	86	4	176
EX-GDR	3.75	39	71	4	297
EX-SUS-GDR	3.75	39	71	4	284
EX-SUS-GDS	3.76	22	54	4	276

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	3.76	22	54	4	256
EX-SUS-GDR	3.76	43	75	4	284
EX-SUS-GDS	3.77	22	54	4	276
VPH-GDS	3.77	22	54	4	256
EX-SUS-GDR	3.77	43	75	4	284
EX-SUS-GDS	3.78	22	54	4	276
VPH-GDS	3.78	22	54	4	256
EX-SUS-GDR	3.78	43	75	4	284
EX-SUS-GDS	3.79	22	54	4	276
VPH-GDS	3.79	22	54	4	256
EX-SUS-GDR	3.79	43	75	4	284
ADFO-3D	3.8	19	60	4	359
ADF-2D	3.8	19	60	6	344
ADFLS-2D	3.8	19	100	6	356
WH70-DRL	3.8	22	52	4	212
EX-GDS	3.8	22	54	4	290
EX-SUS-GDS	3.8	22	54	4	276
NEXUS-GDS	3.8	22	54	4	271
VPH-GDS	3.8	22	54	4	256
WX-MS-GDS	3.8	22	56	4	194
ADO-3D	3.8	23	74	4	149
ADO-SUS-3D	3.8	23	74	4	173
AD-2D	3.8	24	66	4	137
EX-GDN	3.8	33	65	4	295
NF-GDN	3.8	33	65	4	203
ADO-5D	3.8	35	86	4	153
ADO-SUS-5D	3.8	35	86	4	176
AD-4D	3.8	36	74	4	141
WH55-5D	3.8	36	78	6	210
WHO55-5D	3.8	36	78	6	211
ADO-8D	3.8	42	95	4	157

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-8D	3.8	42	95	4	180
V-SDR	3.8	43	75	3.8	321
EX-GDR	3.8	43	75	4	297
EX-SUS-GDR	3.8	43	75	4	284
VP-GDR	3.8	43	75	4	261
TDXL	3.8 X 10D	50	100	3.8	310
ADO-10D	3.8	50	100	4	160
EX-GDXL	3.8	55	100	3.8	301
TDXL	3.8 X 15D	70	120	3.8	312
ADO-15D	3.8	75	125	4	162
EX-GDXL	3.8	75	150	3.8	301
TDXL	3.8 X 20D	88	140	3.8	314
ADO-20D	3.8	90	140	4	164
EX-GDXL	3.8	100	200	3.8	301
ADO-25D	3.8	115	165	4	166
ADO-30D	3.8	132	185	4	168
EX-SUS-GDS	3.81	22	54	4	276
VPH-GDS	3.81	22	54	4	256
EX-SUS-GDR	3.81	43	75	4	284
EX-SUS-GDS	3.82	22	54	4	276
VPH-GDS	3.82	22	54	4	256
EX-SUS-GDR	3.82	43	75	4	284
EX-SUS-GDS	3.83	22	54	4	276
VPH-GDS	3.83	22	54	4	256
EX-SUS-GDR	3.83	43	75	4	284
EX-SUS-GDS	3.84	22	54	4	276
VPH-GDS	3.84	22	54	4	256
EX-SUS-GDR	3.84	43	75	4	284
EX-GDS	3.85	22	54	4	290
EX-SUS-GDS	3.85	22	54	4	276
VPH-GDS	3.85	22	54	4	256

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WX-MS-GDS	3.85	22	56	4	194
EX-GDN	3.85	33	65	4	295
EX-GDR	3.85	43	75	4	297
EX-SUS-GDR	3.85	43	75	4	284
EX-SUS-GDS	3.86	22	54	4	276
VPH-GDS	3.86	22	54	4	256
EX-SUS-GDR	3.86	43	75	4	284
EX-SUS-GDS	3.87	22	54	4	276
VPH-GDS	3.87	22	54	4	256
EX-SUS-GDR	3.87	43	75	4	284
EX-SUS-GDS	3.88	22	54	4	276
VPH-GDS	3.88	22	54	4	256
EX-SUS-GDR	3.88	43	75	4	284
EX-SUS-GDS	3.89	22	54	4	276
VPH-GDS	3.89	22	54	4	256
EX-SUS-GDR	3.89	43	75	4	284
ADFO-3D	3.9	19	60	4	359
ADF-2D	3.9	19	60	6	344
ADFLS-2D	3.9	19	100	6	356
WH70-DRL	3.9	22	52	4	212
EX-GDS	3.9	22	54	4	290
EX-SUS-GDS	3.9	22	54	4	276
NEXUS-GDS	3.9	22	54	4	271
VPH-GDS	3.9	22	54	4	256
WX-MS-GDS	3.9	22	56	4	194
AD-2D	3.9	24	66	4	137
ADO-3D	3.9	24	74	4	149
ADO-SUS-3D	3.9	24	74	4	173
EX-GDN	3.9	33	65	4	296
NF-GDN	3.9	33	65	4	203
AD-4D	3.9	36	74	4	141

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WHO55-5D	3.9	36	78	6	211
ADO-5D	3.9	36	86	4	153
ADO-SUS-5D	3.9	36	86	4	176
V-SDR	3.9	43	75	3.9	321
EX-GDR	3.9	43	75	4	297
EX-SUS-GDR	3.9	43	75	4	284
VP-GDR	3.9	43	75	4	261
ADO-8D	3.9	43	95	4	157
ADO-SUS-8D	3.9	43	95	4	180
TDXL	3.9 × 10D	50	100	3.9	310
ADO-10D	3.9	50	100	4	160
EX-GDXL	3.9	55	100	3.9	301
TDXL	3.9 × 15D	70	120	3.9	312
ADO-15D	3.9	75	125	4	162
EX-GDXL	3.9	75	150	3.9	301
ADO-20D	3.9	90	140	4	164
EX-GDXL	3.9	100	200	3.9	301
ADO-25D	3.9	115	165	4	166
ADO-30D	3.9	132	185	4	168
EX-SUS-GDS	3.91	22	54	4	276
VPH-GDS	3.91	22	54	4	256
EX-SUS-GDR	3.91	43	75	4	284
EX-SUS-GDS	3.92	22	54	4	276
VPH-GDS	3.92	22	54	4	256
EX-SUS-GDR	3.92	43	75	4	284
EX-SUS-GDS	3.93	22	54	4	276
VPH-GDS	3.93	22	54	4	256
EX-SUS-GDR	3.93	43	75	4	284
EX-SUS-GDS	3.94	22	54	4	276
VPH-GDS	3.94	22	54	4	256
EX-SUS-GDR	3.94	43	75	4	284

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDS	3.95	22	54	4	290
EX-SUS-GDS	3.95	22	54	4	276
VPH-GDS	3.95	22	54	4	256
WX-MS-GDS	3.95	22	56	4	194
EX-GDN	3.95	33	65	4	296
EX-GDR	3.95	43	75	4	297
EX-SUS-GDR	3.95	43	75	4	284
EX-SUS-GDS	3.96	22	54	4	276
VPH-GDS	3.96	22	54	4	256
EX-SUS-GDR	3.96	43	75	4	284
EX-SUS-GDS	3.97	22	54	4	276
VPH-GDS	3.97	22	54	4	256
EX-SUS-GDR	3.97	43	75	4	284
EX-SUS-GDS	3.98	22	54	4	276
VPH-GDS	3.98	22	54	4	256
EX-SUS-GDR	3.98	43	75	4	284
EX-SUS-GDS	3.99	22	54	4	276
VPH-GDS	3.99	22	54	4	256
EX-SUS-GDR	3.99	43	75	4	284
ED-DS	4	17	49	4	245
ADFO-3D	4	19	60	4	359
ADF-2D	4	19	60	6	344
ADFLS-2D	4	19	100	6	356
EX-H-DRL	4	20	45	4	319
WH70-DRL	4	22	52	4	212
EX-GDS	4	22	54	4	290
EX-SUS-GDS	4	22	54	4	276
NEXUS-GDS	4	22	54	4	271
VPH-GDS	4	22	54	4	256
WX-MS-GDS	4	22	56	4	194
AD-2D	4	24	66	4	137

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	4	24	74	4	149
ADO-SUS-3D	4	24	74	4	173
ADO-TRS-3D	4	24	74	4	182
D-GDN	4	33	65	4	243
EX-GDN	4	33	65	4	296
NF-GDN	4	33	65	4	203
AD-4D	4	36	74	4	141
WH55-5D	4	36	78	6	210
WHO55-5D	4	36	78	6	211
ADO-5D	4	36	86	4	153
ADO-SUS-5D	4	36	86	4	176
ADO-TRS-5D	4	36	86	4	184
EX-GDR	4	43	75	4	297
EX-SUS-GDR	4	43	75	4	284
NEXUS-GDR	4	43	75	4	272
VP-GDR	4	43	75	4	261
V-SDR	4	43	75	4	321
ADO-8D	4	44	95	4	157
ADO-SUS-8D	4	44	95	4	180
ADO-10D	4	50	100	4	160
TDXL	4 × 10D	50	100	4	310
EX-GDXL	4	60	100	4	301
VP-GDXL	4	60	100	4	270
TDXL	4 × 15D	72	120	4	312
ADO-15D	4	75	125	4	162
CAO-GDXL	4 × 15D	75	125	4	205
EX-GDXL	4	80	150	4	301
VP-GDXL	4	80	150	4	270
ADO-20D	4	90	140	4	164
CAO-GDXL	4 × 20D	90	140	4	206
TDXL	4 × 20D	92	140	4	314

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	4	100	200	4	301
ADO-25D	4	115	165	4	166
ADO-30D	4	132	185	4	168
ADO-40D	4	172	222	4	170
ADO-50D	4	212	262	4	171
EX-SUS-GDS	4.01	22	66	6	276
VPH-GDS	4.01	22	66	6	256
EX-SUS-GDR	4.01	43	87	6	284
EX-SUS-GDS	4.02	22	66	6	276
VPH-GDS	4.02	22	66	6	256
EX-SUS-GDR	4.02	43	87	6	284
ADF-2D	4.03	19	60	6	344
ADO-PLT	4.03	20	70	4	172
ADFO-3D	4.03	21	60	6	359
EX-SUS-GDS	4.03	22	66	6	276
VPH-GDS	4.03	22	66	6	256
EX-SUS-GDR	4.03	43	87	6	284
EX-SUS-GDS	4.04	22	66	6	276
VPH-GDS	4.04	22	66	6	256
EX-SUS-GDR	4.04	43	87	6	284
WX-MS-GDS	4.05	22	64	5	194
EX-GDS	4.05	22	66	6	290
EX-SUS-GDS	4.05	22	66	6	276
VPH-GDS	4.05	22	66	6	256
EX-GDN	4.05	33	77	6	296
EX-GDR	4.05	43	87	6	297
EX-SUS-GDR	4.05	43	87	6	284
EX-SUS-GDS	4.06	22	66	6	276
VPH-GDS	4.06	22	66	6	256
EX-SUS-GDR	4.06	43	87	6	284
EX-SUS-GDS	4.07	22	66	6	276

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	4.07	22	66	6	256
EX-SUS-GDR	4.07	43	87	6	284
EX-SUS-GDS	4.08	22	66	6	276
VPH-GDS	4.08	22	66	6	256
EX-SUS-GDR	4.08	43	87	6	285
NEPTUNE	4.089	12.7	38.1	1/4-28UNF	252
EX-SUS-GDS	4.09	22	66	6	276
VPH-GDS	4.09	22	66	6	256
EX-SUS-GDR	4.09	43	87	6	285
ADF-2D	4.1	19	60	6	344
ADFLS-2D	4.1	19	100	6	356
ADFO-3D	4.1	21	60	6	359
WX-MS-GDS	4.1	22	64	5	194
EX-GDS	4.1	22	66	6	290
EX-SUS-GDS	4.1	22	66	6	276
NEXUS-GDS	4.1	22	66	6	271
VPH-GDS	4.1	22	66	6	256
AD-2D	4.1-5	24	66	5	137
AD-2D	4.1	24	66	6	137
WH70-DRL	4.1	25	68	5	212
ADO-3D	4.1-5	25	80	5	149
ADO-SUS-3D	4.1-5	25	80	5	173
ADO-3D	4.1	25	80	6	149
ADO-SUS-3D	4.1	25	80	6	173
NF-GDN	4.1	33	73	5	203
EX-GDN	4.1	33	77	6	296
AD-4D	4.1-5	36	74	5	141
AD-4D	4.1	36	74	6	141
ADO-5D	4.1-5	37	95	5	153
ADO-SUS-5D	4.1-5	37	95	5	176
ADO-5D	4.1	37	95	6	153

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	4.1	37	95	6	176
WHO55-5D	4.1	38	88	6	211
V-SDR	4.1	43	75	4.1	321
EX-GDR	4.1	43	87	6	297
EX-SUS-GDR	4.1	43	87	6	285
VP-GDR	4.1	43	87	6	261
ADO-8D	4.1-5	45	105	5	157
ADO-SUS-8D	4.1-5	45	105	5	180
ADO-8D	4.1	45	105	6	157
ADO-SUS-8D	4.1	45	105	6	180
TDXL	4.1 × 10D	55	115	4.1	310
ADO-10D	4.1-5	55	115	5	160
ADO-10D	4.1	55	115	6	160
EX-GDXL	4.1	60	100	4.1	301
TDXL	4.1 × 15D	74	135	4.1	312
ADO-15D	4.1-5	75	140	5	162
ADO-15D	4.1	75	140	6	162
EX-GDXL	4.1	80	150	4.1	301
TDXL	4.1 × 20D	96	155	4.1	314
ADO-20D	4.1-5	100	165	5	164
ADO-20D	4.1	100	165	6	164
EX-GDXL	4.1	100	200	4.1	301
ADO-25D	4.1-5	120	190	5	166
ADO-25D	4.1	120	190	6	166
ADO-30D	4.1-5	140	215	5	168
ADO-30D	4.1	140	215	6	168
D-STAD	4.102	25	75	4.102	248
D-DAD	4.102	25	80	4.102	249
D-GDN90	4.102	25	80	4.102	251
EX-SUS-GDS	4.11	22	66	6	276
VPH-GDS	4.11	22	66	6	256

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	4.11	43	87	6	285
EX-SUS-GDS	4.12	22	66	6	276
VPH-GDS	4.12	22	66	6	256
EX-SUS-GDR	4.12	43	87	6	285
EX-SUS-GDS	4.13	22	66	6	276
VPH-GDS	4.13	22	66	6	256
EX-SUS-GDR	4.13	43	87	6	285
EX-SUS-GDS	4.14	22	66	6	276
VPH-GDS	4.14	22	66	6	256
EX-SUS-GDR	4.14	43	87	6	285
WX-MS-GDS	4.15	22	64	5	194
EX-GDS	4.15	22	66	6	290
EX-SUS-GDS	4.15	22	66	6	276
VPH-GDS	4.15	22	66	6	256
EX-GDN	4.15	33	77	6	296
WHO55-5D	4.15	38	88	6	211
EX-GDR	4.15	43	87	6	297
EX-SUS-GDR	4.15	43	87	6	285
EX-SUS-GDS	4.16	22	66	6	276
VPH-GDS	4.16	22	66	6	256
EX-SUS-GDR	4.16	43	87	6	285
EX-SUS-GDS	4.17	22	66	6	276
VPH-GDS	4.17	22	66	6	256
EX-SUS-GDR	4.17	43	87	6	285
EX-SUS-GDS	4.18	22	66	6	276
VPH-GDS	4.18	22	66	6	256
EX-SUS-GDR	4.18	43	87	6	285
EX-SUS-GDS	4.19	22	66	6	276
VPH-GDS	4.19	22	66	6	256
EX-SUS-GDR	4.19	43	87	6	285
ADF-2D	4.2	21	60	6	344

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADFO-3D	4.2	21	60	6	359
ADFLS-2D	4.2	21	100	6	356
WX-MS-GDS	4.2	22	64	5	194
EX-GDS	4.2	22	66	6	290
EX-SUS-GDS	4.2	22	66	6	276
NEXUS-GDS	4.2	22	66	6	271
VPH-GDS	4.2	22	66	6	256
EX-LS-GDS	4.2	22	100	4.2	293
EX-LS-GDS	4.2	22	120	4.2	293
EX-LS-GDS	4.2	22	150	4.2	293
AD-2D	4.2-5	24	66	5	137
AD-2D	4.2	24	66	6	137
WH70-DRL	4.2	25	68	5	212
ADO-3D	4.2-5	26	80	5	149
ADO-SUS-3D	4.2-5	26	80	5	173
ADO-3D	4.2	26	80	6	149
ADO-SUS-3D	4.2	26	80	6	173
ADO-TRS-3D	4.2	26	80	6	182
D-GDN	4.2	33	73	5	243
NF-GDN	4.2	33	73	5	203
EX-GDN	4.2	33	77	6	296
AD-4D	4.2-5	36	74	5	141
AD-4D	4.2	36	74	6	141
WH55-5D	4.2	38	88	6	210
WHO55-5D	4.2	38	88	6	211
ADO-5D	4.2-5	38	95	5	153
ADO-SUS-5D	4.2-5	38	95	5	176
ADO-5D	4.2	38	95	6	153
ADO-SUS-5D	4.2	38	95	6	176
ADO-TRS-5D	4.2	38	95	6	184
V-SDR	4.2	43	75	4.2	321

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDR	4.2	43	87	6	297
EX-SUS-GDR	4.2	43	87	6	285
NEXUS-GDR	4.2	43	87	6	272
VP-GDR	4.2	43	87	6	261
ADO-8D	4.2-5	46	105	5	157
ADO-SUS-8D	4.2-5	46	105	5	180
ADO-8D	4.2	46	105	6	157
ADO-SUS-8D	4.2	46	105	6	180
TDXL	4.2 X 10D	55	115	4.2	310
ADO-10D	4.2-5	55	115	5	160
ADO-10D	4.2	55	115	6	160
EX-GDXL	4.2	60	100	4.2	301
VP-GDXL	4.2	60	100	4.2	270
ADO-15D	4.2-5	75	140	5	162
ADO-15D	4.2	75	140	6	162
TDXL	4.2 X 15D	76	135	4.2	312
EX-GDXL	4.2	80	150	4.2	301
VP-GDXL	4.2	80	150	4.2	270
TDXL	4.2 X 20D	98	155	4.2	314
ADO-20D	4.2-5	100	165	5	164
ADO-20D	4.2	100	165	6	164
EX-GDXL	4.2	100	200	4.2	301
ADO-25D	4.2-5	120	190	5	166
ADO-25D	4.2	120	190	6	166
ADO-30D	4.2-5	140	215	5	168
ADO-30D	4.2	140	215	6	168
EX-SUS-GDS	4.21	22	66	6	276
VPH-GDS	4.21	22	66	6	256
EX-SUS-GDR	4.21	43	87	6	285
EX-SUS-GDS	4.22	22	66	6	276
VPH-GDS	4.22	22	66	6	256

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	4.22	43	87	6	285
EX-SUS-GDS	4.23	22	66	6	276
VPH-GDS	4.23	22	66	6	256
EX-SUS-GDR	4.23	43	87	6	285
EX-SUS-GDS	4.24	22	66	6	276
VPH-GDS	4.24	22	66	6	256
EX-SUS-GDR	4.24	43	87	6	285
WX-MS-GDS	4.25	22	64	5	194
EX-GDS	4.25	22	66	6	290
EX-SUS-GDS	4.25	22	66	6	276
VPH-GDS	4.25	22	66	6	256
EX-GDN	4.25	33	77	6	296
EX-GDR	4.25	43	87	6	297
EX-SUS-GDR	4.25	43	87	6	285
EX-SUS-GDS	4.26	24	68	6	276
VPH-GDS	4.26	24	68	6	256
EX-SUS-GDR	4.26	47	91	6	285
EX-SUS-GDS	4.27	24	68	6	276
VPH-GDS	4.27	24	68	6	256
EX-SUS-GDR	4.27	47	91	6	285
EX-SUS-GDS	4.28	24	68	6	276
VPH-GDS	4.28	24	68	6	256
EX-SUS-GDR	4.28	47	91	6	285
EX-SUS-GDS	4.29	24	68	6	276
VPH-GDS	4.29	24	68	6	256
EX-SUS-GDR	4.29	47	91	6	285
ADF-2D	4.3	21	60	6	344
ADFO-3D	4.3	21	60	6	359
ADFLS-2D	4.3	21	100	6	356
WX-MS-GDS	4.3	24	64	5	194
AD-2D	4.3-5	24	66	5	137

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	4.3	24	66	6	137
EX-GDS	4.3	24	68	6	290
EX-SUS-GDS	4.3	24	68	6	276
NEXUS-GDS	4.3	24	68	6	271
VPH-GDS	4.3	24	68	6	256
ADO-3D	4.3-5	26	80	5	149
ADO-SUS-3D	4.3-5	26	80	5	173
ADO-3D	4.3	26	80	6	149
ADO-SUS-3D	4.3	26	80	6	173
WH70-DRL	4.3	28	68	5	212
NF-GDN	4.3	36	73	5	203
AD-4D	4.3-5	36	74	5	141
AD-4D	4.3	36	74	6	141
EX-GDN	4.3	36	80	6	296
ADO-5D	4.3-5	39	95	5	153
ADO-SUS-5D	4.3-5	39	95	5	176
ADO-5D	4.3	39	95	6	153
ADO-SUS-5D	4.3	39	95	6	176
WH055-5D	4.3	41	88	6	211
V-SDR	4.3	47	80	4.3	321
EX-GDR	4.3	47	91	6	297
EX-SUS-GDR	4.3	47	91	6	285
NEXUS-GDR	4.3	47	91	6	272
VP-GDR	4.3	47	91	6	261
ADO-8D	4.3-5	47	105	5	157
ADO-SUS-8D	4.3-5	47	105	5	180
ADO-8D	4.3	47	105	6	157
ADO-SUS-8D	4.3	47	105	6	180
EX-GDXL	4.3	60	100	4.3	301
TDXL	4.3 X 10D	60	115	4.3	310
ADO-10D	4.3-5	60	115	5	160

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-10D	4.3	60	115	6	160
TDXL	4.3 × 15D	78	140	4.3	312
EX-GDXL	4.3	80	150	4.3	301
ADO-15D	4.3-5	85	140	5	162
ADO-15D	4.3	85	140	6	162
TDXL	4.3 × 20D	100	160	4.3	314
EX-GDXL	4.3	100	200	4.3	301
ADO-20D	4.3-5	110	165	5	164
ADO-20D	4.3	110	165	6	164
ADO-25D	4.3-5	135	190	5	166
ADO-25D	4.3	135	190	6	166
ADO-30D	4.3-5	150	215	5	168
ADO-30D	4.3	150	215	6	168
EX-SUS-GDS	4.31	24	68	6	276
VPH-GDS	4.31	24	68	6	256
EX-SUS-GDR	4.31	47	91	6	285
EX-SUS-GDS	4.32	24	68	6	276
VPH-GDS	4.32	24	68	6	256
EX-SUS-GDR	4.32	47	91	6	285
EX-SUS-GDS	4.33	24	68	6	276
VPH-GDS	4.33	24	68	6	256
EX-SUS-GDR	4.33	47	91	6	285
EX-SUS-GDS	4.34	24	68	6	276
VPH-GDS	4.34	24	68	6	257
EX-SUS-GDR	4.34	47	91	6	285
WX-MS-GDS	4.35	24	64	5	194
EX-GDS	4.35	24	68	6	290
EX-SUS-GDS	4.35	24	68	6	276
VPH-GDS	4.35	24	68	6	257
EX-GDN	4.35	36	80	6	296
EX-GDR	4.35	47	91	6	297

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	4.35	47	91	6	285
EX-SUS-GDS	4.36	24	68	6	276
VPH-GDS	4.36	24	68	6	257
EX-SUS-GDR	4.36	47	91	6	285
EX-SUS-GDS	4.37	24	68	6	276
VPH-GDS	4.37	24	68	6	257
EX-SUS-GDR	4.37	47	91	6	285
EX-SUS-GDS	4.38	24	68	6	276
VPH-GDS	4.38	24	68	6	257
EX-SUS-GDR	4.38	47	91	6	285
EX-SUS-GDS	4.39	24	68	6	276
VPH-GDS	4.39	24	68	6	257
EX-SUS-GDR	4.39	47	91	6	285
ADF-2D	4.4	21	60	6	344
ADFO-3D	4.4	21	60	6	359
ADFLS-2D	4.4	21	100	6	356
WX-MS-GDS	4.4	24	64	5	194
AD-2D	4.4-5	24	66	5	137
AD-2D	4.4	24	66	6	137
EX-GDS	4.4	24	68	6	290
EX-SUS-GDS	4.4	24	68	6	276
NEXUS-GDS	4.4	24	68	6	271
VPH-GDS	4.4	24	68	6	257
ADO-3D	4.4-5	27	80	5	149
ADO-SUS-3D	4.4-5	27	80	5	173
ADO-3D	4.4	27	80	6	149
ADO-SUS-3D	4.4	27	80	6	173
WH70-DRL	4.4	28	68	5	212
NF-GDN	4.4	36	73	5	203
AD-4D	4.4-5	36	74	5	141
AD-4D	4.4	36	74	6	141

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDN	4.4	36	80	6	296
ADO-5D	4.4-5	40	95	5	153
ADO-SUS-5D	4.4-5	40	95	5	176
ADO-5D	4.4	40	95	6	153
ADO-SUS-5D	4.4	40	95	6	176
WHO55-5D	4.4	41	88	6	211
V-SDR	4.4	47	80	4.4	321
EX-GDR	4.4	47	91	6	297
EX-SUS-GDR	4.4	47	91	6	285
VP-GDR	4.4	47	91	6	261
ADO-8D	4.4-5	48	105	5	157
ADO-SUS-8D	4.4-5	48	105	5	180
ADO-8D	4.4	48	105	6	157
ADO-SUS-8D	4.4	48	105	6	180
EX-GDXL	4.4	60	100	4.4	301
TDXL	4.4 × 10D	60	115	4.4	310
ADO-10D	4.4-5	60	115	5	160
ADO-10D	4.4	60	115	6	160
TDXL	4.4 × 15D	80	140	4.4	312
EX-GDXL	4.4	80	150	4.4	301
ADO-15D	4.4-5	85	140	5	162
ADO-15D	4.4	85	140	6	162
EX-GDXL	4.4	100	200	4.4	301
ADO-20D	4.4-5	110	165	5	164
ADO-20D	4.4	110	165	6	164
ADO-25D	4.4-5	135	190	5	166
ADO-25D	4.4	135	190	6	166
ADO-30D	4.4-5	150	215	5	168
ADO-30D	4.4	150	215	6	168
EX-SUS-GDS	4.41	24	68	6	276
VPH-GDS	4.41	24	68	6	257

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	4.41	47	91	6	285
EX-SUS-GDS	4.42	24	68	6	276
VPH-GDS	4.42	24	68	6	257
EX-SUS-GDR	4.42	47	91	6	285
EX-SUS-GDS	4.43	24	68	6	276
VPH-GDS	4.43	24	68	6	257
EX-SUS-GDR	4.43	47	91	6	285
EX-SUS-GDS	4.44	24	68	6	276
VPH-GDS	4.44	24	68	6	257
EX-SUS-GDR	4.44	47	91	6	285
WX-MS-GDS	4.45	24	64	5	194
EX-GDS	4.45	24	68	6	290
EX-SUS-GDS	4.45	24	68	6	276
VPH-GDS	4.45	24	68	6	257
ADO-SUS-3D	4.45	27	80	6	173
EX-GDN	4.45	36	80	6	296
ADO-SUS-5D	4.45	41	95	6	176
EX-GDR	4.45	47	91	6	297
EX-SUS-GDR	4.45	47	91	6	285
EX-SUS-GDS	4.46	24	68	6	276
VPH-GDS	4.46	24	68	6	257
EX-SUS-GDR	4.46	47	91	6	285
EX-SUS-GDS	4.47	24	68	6	276
VPH-GDS	4.47	24	68	6	257
EX-SUS-GDR	4.47	47	91	6	285
EX-SUS-GDS	4.48	24	68	6	276
VPH-GDS	4.48	24	68	6	257
EX-SUS-GDR	4.48	47	91	6	285
EX-SUS-GDS	4.49	24	68	6	276
VPH-GDS	4.49	24	68	6	257
EX-SUS-GDR	4.49	47	91	6	285

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ED-DS	4.5	19	63	6	245
ADF-2D	4.5	21	60	6	344
ADFO-3D	4.5	21	60	6	359
ADFLS-2D	4.5	21	100	6	356
WX-MS-GDS	4.5	24	64	5	194
AD-2D	4.5-5	24	66	5	137
AD-2D	4.5	24	66	6	137
EX-GDS	4.5	24	68	6	290
EX-SUS-GDS	4.5	24	68	6	276
NEXUS-GDS	4.5	24	68	6	271
VPH-GDS	4.5	24	68	6	257
ADO-3D	4.5-5	27	80	5	149
ADO-SUS-3D	4.5-5	27	80	5	173
ADO-3D	4.5	27	80	6	149
ADO-SUS-3D	4.5	27	80	6	173
ADO-TRS-3D	4.5	27	80	6	182
WH70-DRL	4.5	28	68	5	212
D-GDN	4.5	36	73	5	243
NF-GDN	4.5	36	73	5	203
AD-4D	4.5-5	36	74	5	141
AD-4D	4.5	36	74	6	141
EX-GDN	4.5	36	80	6	296
WH55-5D	4.5	41	88	6	210
WHO55-5D	4.5	41	88	6	211
ADO-5D	4.5-5	41	95	5	153
ADO-SUS-5D	4.5-5	41	95	5	176
ADO-5D	4.5	41	95	6	153
ADO-SUS-5D	4.5	41	95	6	176
ADO-TRS-5D	4.5	41	95	6	184
V-SDR	4.5	47	80	4.5	321
EX-GDR	4.5	47	91	6	297

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	4.5	47	91	6	285
NEXUS-GDR	4.5	47	91	6	272
VP-GDR	4.5	47	91	6	261
ADO-8D	4.5-5	50	105	5	157
ADO-SUS-8D	4.5-5	50	105	5	180
ADO-8D	4.5	50	105	6	157
ADO-SUS-8D	4.5	50	105	6	180
EX-GDXL	4.5	60	100	4.5	301
VP-GDXL	4.5	60	100	4.5	270
TDXL	4.5 × 10D	60	115	4.5	310
ADO-10D	4.5-5	60	115	5	160
ADO-10D	4.5	60	115	6	160
EX-GDXL	4.5	80	150	4.5	301
VP-GDXL	4.5	80	150	4.5	270
TDXL	4.5 × 15D	82	140	4.5	312
ADO-15D	4.5-5	85	140	5	162
ADO-15D	4.5	85	140	6	162
EX-GDXL	4.5	100	200	4.5	301
TDXL	4.5 × 20D	104	165	4.5	314
ADO-20D	4.5-5	110	165	5	164
CAO-GDXL	4.5 × 20D	110	165	5	206
ADO-20D	4.5	110	165	6	164
ADO-25D	4.5-5	135	190	5	166
ADO-25D	4.5	135	190	6	166
ADO-30D	4.5-5	150	215	5	168
ADO-30D	4.5	150	215	6	168
EX-SUS-GDS	4.51	24	68	6	276
VPH-GDS	4.51	24	68	6	257
EX-SUS-GDR	4.51	47	91	6	285
EX-SUS-GDS	4.52	24	68	6	276
VPH-GDS	4.52	24	68	6	257

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	4.52	47	91	6	285
ADF-2D	4.53	21	60	6	344
ADFO-3D	4.53	21	60	6	359
ADO-PLT	4.53-5	23	75	5	172
EX-SUS-GDS	4.53	24	68	6	276
VPH-GDS	4.53	24	68	6	257
EX-SUS-GDR	4.53	47	91	6	285
EX-SUS-GDS	4.54	24	68	6	276
VPH-GDS	4.54	24	68	6	257
EX-SUS-GDR	4.54	47	91	6	285
WX-MS-GDS	4.55	24	64	5	194
EX-GDS	4.55	24	68	6	290
EX-SUS-GDS	4.55	24	68	6	276
VPH-GDS	4.55	24	68	6	257
EX-GDN	4.55	36	80	6	296
EX-GDR	4.55	47	91	6	297
EX-SUS-GDR	4.55	47	91	6	285
EX-SUS-GDS	4.56	24	68	6	276
VPH-GDS	4.56	24	68	6	257
EX-SUS-GDR	4.56	47	91	6	285
EX-SUS-GDS	4.57	24	68	6	276
VPH-GDS	4.57	24	68	6	257
EX-SUS-GDR	4.57	47	91	6	285
EX-SUS-GDS	4.58	24	68	6	276
VPH-GDS	4.58	24	68	6	257
EX-SUS-GDR	4.58	47	91	6	285
EX-SUS-GDS	4.59	24	68	6	276
NEXUS-GDS	4.59	24	68	6	271
VPH-GDS	4.59	24	68	6	257
EX-SUS-GDR	4.59	47	91	6	285
ADF-2D	4.6	21	60	6	344

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADFO-3D	4.6	21	60	6	359
ADFLS-2D	4.6	21	100	6	356
WX-MS-GDS	4.6	24	64	5	194
AD-2D	4.6-5	24	66	5	137
AD-2D	4.6	24	66	6	137
EX-GDS	4.6	24	68	6	290
EX-SUS-GDS	4.6	24	68	6	276
NEXUS-GDS	4.6	24	68	6	271
VPH-GDS	4.6	24	68	6	257
WH70-DRL	4.6	28	68	5	212
ADO-3D	4.6-5	28	80	5	149
ADO-SUS-3D	4.6-5	28	80	5	173
ADO-3D	4.6	28	80	6	149
ADO-SUS-3D	4.6	28	80	6	173
ADO-TRS-3D	4.6	28	80	6	182
NF-GDN	4.6	36	73	5	203
AD-4D	4.6-5	36	74	5	141
AD-4D	4.6	36	74	6	141
EX-GDN	4.6	36	80	6	296
ADO-5D	4.6-5	42	95	5	153
ADO-SUS-5D	4.6-5	42	95	5	176
ADO-5D	4.6	42	95	6	153
ADO-SUS-5D	4.6	42	95	6	176
ADO-TRS-5D	4.6	42	95	6	184
WHO55-5D	4.6	43	88	6	211
V-SDR	4.6	47	80	4.6	321
EX-GDR	4.6	47	91	6	297
EX-SUS-GDR	4.6	47	91	6	285
VP-GDR	4.6	47	91	6	261
ADO-8D	4.6-5	51	105	5	157
ADO-SUS-8D	4.6-5	51	105	5	180

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-8D	4.6	51	105	6	157
ADO-SUS-8D	4.6	51	105	6	180
EX-GDXL	4.6	60	100	4.6	301
TDXL	4.6 × 10D	60	115	4.6	310
ADO-10D	4.6-5	60	115	5	160
ADO-10D	4.6	60	115	6	160
EX-GDXL	4.6	80	150	4.6	301
TDXL	4.6 × 15D	84	145	4.6	312
ADO-15D	4.6-5	85	140	5	162
ADO-15D	4.6	85	140	6	162
EX-GDXL	4.6	100	200	4.6	301
TDXL	4.6 × 20D	106	165	4.6	314
ADO-20D	4.6-5	110	165	5	164
ADO-20D	4.6	110	165	6	164
ADO-25D	4.6-5	135	190	5	166
ADO-25D	4.6	135	190	6	166
ADO-30D	4.6-5	150	215	5	168
ADO-30D	4.6	150	215	6	168
EX-SUS-GDS	4.61	24	68	6	276
VPH-GDS	4.61	24	68	6	257
EX-SUS-GDR	4.61	47	91	6	285
ADF-2D	4.62	21	60	6	344
ADFO-3D	4.62	21	60	6	359
AD-2D	4.62	24	66	6	137
EX-SUS-GDS	4.62	24	68	6	276
VPH-GDS	4.62	24	68	6	257
NF-GDN	4.62	36	73	5	203
ADO-5D	4.62-5	42	95	5	153
ADO-SUS-5D	4.62-5	42	95	5	176
EX-SUS-GDR	4.62	47	91	6	285
VP-GDR	4.62	47	91	6	261

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	4.63	24	68	6	276
NEXUS-GDS	4.63	24	68	6	271
VPH-GDS	4.63	24	68	6	257
EX-SUS-GDR	4.63	47	91	6	285
ADF-2D	4.64	21	60	6	344
ADFO-3D	4.64	21	60	6	359
AD-2D	4.64	24	66	6	137
EX-SUS-GDS	4.64	24	68	6	276
VPH-GDS	4.64	24	68	6	257
NF-GDN	4.64	36	73	5	203
ADO-5D	4.64-5	42	95	5	153
ADO-SUS-5D	4.64-5	42	95	5	176
ADO-SUS-5D	4.64	42	95	6	176
EX-SUS-GDR	4.64	47	91	6	285
WX-MS-GDS	4.65	24	64	5	194
EX-GDS	4.65	24	68	6	290
EX-SUS-GDS	4.65	24	68	6	276
VPH-GDS	4.65	24	68	6	257
ADO-SUS-3D	4.65	28	80	6	173
EX-GDN	4.65	36	80	6	296
EX-GDR	4.65	47	91	6	297
EX-SUS-GDR	4.65	47	91	6	285
EX-SUS-GDS	4.66	24	68	6	277
VPH-GDS	4.66	24	68	6	257
EX-SUS-GDR	4.66	47	91	6	285
EX-SUS-GDS	4.67	24	68	6	277
VPH-GDS	4.67	24	68	6	257
EX-SUS-GDR	4.67	47	91	6	285
EX-SUS-GDS	4.68	24	68	6	277
VPH-GDS	4.68	24	68	6	257
EX-SUS-GDR	4.68	47	91	6	285

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	4.69	24	68	6	277
VPH-GDS	4.69	24	68	6	257
EX-SUS-GDR	4.69	47	91	6	285
ADF-2D	4.7	21	60	6	344
ADFO-3D	4.7	21	60	6	359
ADFLS-2D	4.7	21	100	6	356
WX-MS-GDS	4.7	24	64	5	194
AD-2D	4.7-5	24	66	5	137
AD-2D	4.7	24	66	6	137
EX-GDS	4.7	24	68	6	290
EX-SUS-GDS	4.7	24	68	6	277
NEXUS-GDS	4.7	24	68	6	271
VPH-GDS	4.7	24	68	6	257
WH70-DRL	4.7	28	68	5	212
ADO-3D	4.7-5	29	80	5	149
ADO-SUS-3D	4.7-5	29	80	5	173
ADO-3D	4.7	29	80	6	149
ADO-SUS-3D	4.7	29	80	6	173
NF-GDN	4.7	36	73	5	203
AD-4D	4.7-5	36	74	5	141
AD-4D	4.7	36	74	6	141
EX-GDN	4.7	36	80	6	296
WH055-5D	4.7	43	88	6	211
ADO-5D	4.7-5	43	95	5	153
ADO-SUS-5D	4.7-5	43	95	5	176
ADO-5D	4.7	43	95	6	153
ADO-SUS-5D	4.7	43	95	6	176
V-SDR	4.7	47	80	4.7	321
EX-GDR	4.7	47	91	6	297
EX-SUS-GDR	4.7	47	91	6	285
VP-GDR	4.7	47	91	6	261

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-8D	4.7-5	52	105	5	157
ADO-SUS-8D	4.7-5	52	105	5	180
ADO-8D	4.7	52	105	6	157
ADO-SUS-8D	4.7	52	105	6	180
TDXL	4.7 × 10D	60	115	4.7	310
ADO-10D	4.7-5	65	115	5	160
ADO-10D	4.7	65	115	6	160
EX-GDXL	4.7	80	150	4.7	301
ADO-15D	4.7-5	85	140	5	162
ADO-15D	4.7	85	140	6	162
TDXL	4.7 × 15D	86	145	4.7	312
EX-GDXL	4.7	100	200	4.7	301
ADO-20D	4.7-5	110	165	5	164
ADO-20D	4.7	110	165	6	164
ADO-25D	4.7-5	135	190	5	166
ADO-25D	4.7	135	190	6	166
ADO-30D	4.7-5	150	215	5	168
ADO-30D	4.7	150	215	6	168
EX-SUS-GDS	4.71	24	68	6	277
VPH-GDS	4.71	24	68	6	257
EX-SUS-GDR	4.71	47	91	6	285
EX-SUS-GDS	4.72	24	68	6	277
VPH-GDS	4.72	24	68	6	257
EX-SUS-GDR	4.72	47	91	6	285
EX-SUS-GDS	4.73	24	68	6	277
VPH-GDS	4.73	24	68	6	257
EX-SUS-GDR	4.73	47	91	6	285
EX-SUS-GDS	4.74	24	68	6	277
VPH-GDS	4.74	24	68	6	257
EX-SUS-GDR	4.74	47	91	6	285
WX-MS-GDS	4.75	24	64	5	194

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDS	4.75	24	68	6	290
EX-SUS-GDS	4.75	24	68	6	277
VPH-GDS	4.75	24	68	6	257
EX-GDN	4.75	36	80	6	296
EX-GDR	4.75	47	91	6	297
EX-SUS-GDR	4.75	47	91	6	285
EX-SUS-GDS	4.76	26	70	6	277
VPH-GDS	4.76	26	70	6	257
EX-SUS-GDR	4.76	52	96	6	285
EX-SUS-GDS	4.77	26	70	6	277
VPH-GDS	4.77	26	70	6	257
EX-SUS-GDR	4.77	52	96	6	285
EX-SUS-GDS	4.78	26	70	6	277
VPH-GDS	4.78	26	70	6	257
EX-SUS-GDR	4.78	52	96	6	285
EX-SUS-GDS	4.79	26	70	6	277
VPH-GDS	4.79	26	70	6	257
EX-SUS-GDR	4.79	52	96	6	285
ADF-2D	4.8	24	65	6	344
ADFO-3D	4.8	24	65	6	359
ADFLS-2D	4.8	24	100	6	356
WX-MS-GDS	4.8	26	64	5	194
EX-GDS	4.8	26	70	6	290
EX-SUS-GDS	4.8	26	70	6	277
NEXUS-GDS	4.8	26	70	6	271
VPH-GDS	4.8	26	70	6	257
AD-2D	4.8-5	28	66	5	137
AD-2D	4.8	28	66	6	137
ADO-3D	4.8-5	29	80	5	149
ADO-SUS-3D	4.8-5	29	80	5	173
ADO-3D	4.8	29	80	6	149

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	4.8	29	80	6	173
WH70-DRL	4.8	32	68	5	212
NF-GDN	4.8	39	73	5	203
EX-GDN	4.8	39	83	6	296
AD-4D	4.8-5	44	82	5	141
AD-4D	4.8	44	82	6	141
ADO-5D	4.8-5	44	95	5	153
ADO-SUS-5D	4.8-5	44	95	5	176
ADO-5D	4.8	44	95	6	153
ADO-SUS-5D	4.8	44	95	6	176
WH55-5D	4.8	45	88	6	210
WHO55-5D	4.8	45	88	6	211
V-SDR	4.8	52	86	4.8	321
EX-GDR	4.8	52	96	6	297
EX-SUS-GDR	4.8	52	96	6	285
VP-GDR	4.8	52	96	6	261
ADO-8D	4.8-5	53	105	5	157
ADO-SUS-8D	4.8-5	53	105	5	180
ADO-8D	4.8	53	105	6	157
ADO-SUS-8D	4.8	53	105	6	180
TDXL	4.8 X 10D	65	115	4.8	310
ADO-10D	4.8-5	65	115	5	160
ADO-10D	4.8	65	115	6	160
EX-GDXL	4.8	80	150	4.8	301
TDXL	4.8 X 15D	86	145	4.8	312
ADO-15D	4.8-5	90	140	5	162
ADO-15D	4.8	90	140	6	162
EX-GDXL	4.8	100	200	4.8	301
TDXL	4.8 X 20D	112	170	4.8	314
ADO-20D	4.8-5	115	165	5	164
ADO-20D	4.8	115	165	6	164

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-25D	4.8-5	140	190	5	166
ADO-25D	4.8	140	190	6	166
ADO-30D	4.8-5	165	215	5	168
ADO-30D	4.8	165	215	6	168
EX-SUS-GDS	4.81	26	70	6	277
VPH-GDS	4.81	26	70	6	257
EX-SUS-GDR	4.81	52	96	6	285
EX-SUS-GDS	4.82	26	70	6	277
VPH-GDS	4.82	26	70	6	257
EX-SUS-GDR	4.82	52	96	6	285
EX-SUS-GDS	4.83	26	70	6	277
VPH-GDS	4.83	26	70	6	257
EX-SUS-GDR	4.83	52	96	6	285
EX-SUS-GDS	4.84	26	70	6	277
VPH-GDS	4.84	26	70	6	257
EX-SUS-GDR	4.84	52	96	6	285
WX-MS-GDS	4.85	26	64	5	194
EX-GDS	4.85	26	70	6	290
EX-SUS-GDS	4.85	26	70	6	277
VPH-GDS	4.85	26	70	6	257
ADO-SUS-3D	4.85(#11)	29	80	6	173
EX-GDN	4.85	39	83	6	296
ADO-SUS-5D	4.85(#11)	44	95	6	176
EX-GDR	4.85	52	96	6	297
EX-SUS-GDR	4.85	52	96	6	285
NEPTUNE	4.851	12.7	38.1	1/4-28UNF	252
EX-SUS-GDS	4.86	26	70	6	277
VPH-GDS	4.86	26	70	6	257
EX-SUS-GDR	4.86	52	96	6	285
D-DAD	4.864	29	80	4.864	249
D-GDN90	4.864	29	80	4.864	251

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
STCH	4.864	32	83	4.864	250
D-STAD	4.864	39	89	4.864	248
EX-SUS-GDS	4.87	26	70	6	277
VPH-GDS	4.87	26	70	6	257
EX-SUS-GDR	4.87	52	96	6	285
EX-SUS-GDS	4.88	26	70	6	277
VPH-GDS	4.88	26	70	6	257
EX-SUS-GDR	4.88	52	96	6	285
EX-SUS-GDS	4.89	26	70	6	277
VPH-GDS	4.89	26	70	6	257
EX-SUS-GDR	4.89	52	96	6	285
ADF-2D	4.9	24	65	6	344
ADFO-3D	4.9	24	65	6	359
ADFLS-2D	4.9	24	100	6	356
WX-MS-GDS	4.9	26	64	5	194
EX-GDS	4.9	26	70	6	290
EX-SUS-GDS	4.9	26	70	6	277
NEXUS-GDS	4.9	26	70	6	271
VPH-GDS	4.9	26	70	6	257
AD-2D	4.9-5	28	66	5	137
AD-2D	4.9	28	66	6	137
ADO-3D	4.9-5	30	80	5	149
ADO-SUS-3D	4.9-5	30	80	5	173
ADO-3D	4.9	30	80	6	149
ADO-SUS-3D	4.9	30	80	6	173
WH70-DRL	4.9	32	68	5	212
NF-GDN	4.9	39	73	5	203
EX-GDN	4.9	39	83	6	296
AD-4D	4.9-5	44	82	5	141
AD-4D	4.9	44	82	6	141
WHO55-5D	4.9	45	88	6	211

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-5D	4.9-5	45	95	5	153
ADO-SUS-5D	4.9-5	45	95	5	176
ADO-5D	4.9	45	95	6	153
ADO-SUS-5D	4.9	45	95	6	176
V-SDR	4.9	52	86	4.9	321
EX-GDR	4.9	52	96	6	297
EX-SUS-GDR	4.9	52	96	6	285
VP-GDR	4.9	52	96	6	261
ADO-8D	4.9-5	54	105	5	157
ADO-SUS-8D	4.9-5	54	105	5	180
ADO-8D	4.9	54	105	6	157
ADO-SUS-8D	4.9	54	105	6	180
TDXL	4.9 X 10D	65	115	4.9	310
ADO-10D	4.9-5	65	115	5	160
ADO-10D	4.9	65	115	6	160
EX-GDXL	4.9	80	150	4.9	301
TDXL	4.9 X 15D	88	150	4.9	312
ADO-15D	4.9-5	90	140	5	162
ADO-15D	4.9	90	140	6	162
EX-GDXL	4.9	100	200	4.9	301
ADO-20D	4.9-5	115	165	5	164
ADO-20D	4.9	115	165	6	164
ADO-25D	4.9-5	140	190	5	166
ADO-25D	4.9	140	190	6	166
ADO-30D	4.9-5	165	215	5	168
ADO-30D	4.9	165	215	6	168
EX-SUS-GDS	4.91	26	70	6	277
VPH-GDS	4.91	26	70	6	257
EX-SUS-GDR	4.91	52	96	6	285
EX-SUS-GDS	4.92	26	70	6	277
VPH-GDS	4.92	26	70	6	257

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	4.92	52	96	6	285
EX-SUS-GDS	4.93	26	70	6	277
VPH-GDS	4.93	26	70	6	257
EX-SUS-GDR	4.93	52	96	6	285
EX-SUS-GDS	4.94	26	70	6	277
VPH-GDS	4.94	26	70	6	257
EX-SUS-GDR	4.94	52	96	6	285
WX-MS-GDS	4.95	26	64	5	194
EX-GDS	4.95	26	70	6	290
EX-SUS-GDS	4.95	26	70	6	277
VPH-GDS	4.95	26	70	6	257
EX-GDN	4.95	39	83	6	296
EX-GDR	4.95	52	96	6	297
EX-SUS-GDR	4.95	52	96	6	285
EX-SUS-GDS	4.96	26	70	6	277
VPH-GDS	4.96	26	70	6	257
EX-SUS-GDR	4.96	52	96	6	285
EX-SUS-GDS	4.97	26	70	6	277
VPH-GDS	4.97	26	70	6	257
EX-SUS-GDR	4.97	52	96	6	285
EX-SUS-GDS	4.98	26	70	6	277
VPH-GDS	4.98	26	70	6	257
EX-SUS-GDR	4.98	52	96	6	285
EX-SUS-GDS	4.99	26	70	6	277
VPH-GDS	4.99	26	70	6	257
EX-SUS-GDR	4.99	52	96	6	285
ED-DS	5	21	65	6	245
ADF-2D	5	24	65	6	344
ADFO-3D	5	24	65	6	359
ADFLS-2D	5	24	110	6	356
EX-H-DRL	5	25	50	5	319

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	5-5	25	80	5	149
ADO-SUS-3D	5-5	25	80	5	173
ADO-3D	5	25	80	6	149
ADO-SUS-3D	5	25	80	6	173
ADO-TRS-3D	5	25	80	6	182
WX-MS-GDS	5	26	64	5	194
EX-GDS	5	26	70	6	291
EX-SUS-GDS	5	26	70	6	277
NEXUS-GDS	5	26	70	6	271
VPH-GDS	5	26	70	6	257
EX-LS-GDS	5	26	100	5	293
EX-LS-GDS	5	26	120	5	293
EX-LS-GDS	5	26	150	5	293
EX-LS-GDS	5	26	200	5	293
AD-2D	5-5	28	66	5	137
AD-2D	5	28	66	6	137
WH70-DRL	5	32	68	5	212
D-GDN	5	39	73	5	243
NF-GDN	5	39	73	5	203
EX-GDN	5	39	83	6	296
AD-4D	5-5	44	82	5	141
AD-4D	5	44	82	6	141
WH55-5D	5	45	88	6	210
WHO55-5D	5	45	88	6	211
ADO-5D	5-5	45	95	5	153
ADO-SUS-5D	5-5	45	95	5	176
ADO-5D	5	45	95	6	153
ADO-SUS-5D	5	45	95	6	176
ADO-TRS-5D	5	45	95	6	184
V-SDR	5	52	86	5	321
EX-GDR	5	52	96	6	297

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	5	52	96	6	285
NEXUS-GDR	5	52	96	6	272
VP-GDR	5	52	96	6	261
ADO-8D	5-5	55	105	5	157
ADO-SUS-8D	5-5	55	105	5	180
ADO-8D	5	55	105	6	157
ADO-SUS-8D	5	55	105	6	180
ADO-10D	5-5	65	115	5	160
TDXL	5 X 10D	65	115	5	310
TRS-HO-10D	5	65	115	5	190
ADO-10D	5	65	115	6	160
EX-GDXL	5	85	150	5	301
VP-GDXL	5	85	150	5	270
ADO-15D	5-5	90	140	5	162
CAO-GDXL	5 X 15D	90	140	5	205
ADO-15D	5	90	140	6	162
TDXL	5 X 15D	90	150	5	312
EX-GDXL	5	105	200	5	301
VP-GDXL	5	105	200	5	270
ADO-20D	5-5	115	165	5	164
CAO-GDXL	5 X 20D	115	165	5	206
ADO-20D	5	115	165	6	164
TDXL	5 X 20D	116	175	5	314
EX-GDXL	5	130	250	5	301
ADO-25D	5-5	140	190	5	166
ADO-25D	5	140	190	6	166
EX-GDXL	5	160	250	5	301
ADO-30D	5-5	165	215	5	168
CAO-GDXL	5 X 30D	165	215	5	207
ADO-30D	5	165	215	6	168
ADO-40D	5	215	265	5	170

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-50D	5	265	315	5	171
EX-SUS-GDS	5.01	26	70	6	277
VPH-GDS	5.01	26	70	6	257
EX-SUS-GDR	5.01	52	96	6	285
EX-SUS-GDS	5.02	26	70	6	277
VPH-GDS	5.02	26	70	6	257
EX-SUS-GDR	5.02	52	96	6	285
ADF-2D	5.03	24	65	6	344
ADFO-3D	5.03	24	65	6	359
ADO-PLT	5.03-5	25	75	5	172
EX-SUS-GDS	5.03	26	70	6	277
VPH-GDS	5.03	26	70	6	257
EX-SUS-GDR	5.03	52	96	6	285
EX-SUS-GDS	5.04	26	70	6	277
VPH-GDS	5.04	26	70	6	257
EX-SUS-GDR	5.04	52	96	6	285
EX-GDS	5.05	26	70	6	291
EX-SUS-GDS	5.05	26	70	6	277
VPH-GDS	5.05	26	70	6	257
EX-GDN	5.05	39	83	6	296
EX-GDR	5.05	52	96	6	297
EX-SUS-GDR	5.05	52	96	6	285
EX-SUS-GDS	5.06	26	70	6	277
VPH-GDS	5.06	26	70	6	257
EX-SUS-GDR	5.06	52	96	6	285
EX-SUS-GDS	5.07	26	70	6	277
VPH-GDS	5.07	26	70	6	257
EX-SUS-GDR	5.07	52	96	6	285
EX-SUS-GDS	5.08	26	70	6	277
VPH-GDS	5.08	26	70	6	257
EX-SUS-GDR	5.08	52	96	6	285

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	5.09	26	70	6	277
VPH-GDS	5.09	26	70	6	257
EX-SUS-GDR	5.09	52	96	6	285
ADF-2D	5.1	24	65	6	344
ADFO-3D	5.1	24	65	6	359
ADFLS-2D	5.1	24	110	6	356
EX-GDS	5.1	26	70	6	291
EX-SUS-GDS	5.1	26	70	6	277
NEXUS-GDS	5.1	26	70	6	271
VPH-GDS	5.1	26	70	6	257
ADO-3D	5.1	26	82	6	149
ADO-SUS-3D	5.1	26	82	6	173
ADO-TRS-3D	5.1	26	82	6	182
AD-2D	5.1	28	66	6	137
WH70-DRL	5.1	32	74	6	212
EX-GDN	5.1	39	83	6	296
NF-GDN	5.1	39	83	6	203
ADO-5D	5.1	41	100	6	153
ADO-SUS-5D	5.1	41	100	6	176
ADO-TRS-5D	5.1	41	100	6	184
WH55-5D	5.1	42	92	6	210
WHO55-5D	5.1	42	92	6	211
AD-4D	5.1	44	82	6	141
V-SDR	5.1	52	86	5.1	321
EX-GDR	5.1	52	96	6	297
EX-SUS-GDR	5.1	52	96	6	285
NEXUS-GDR	5.1	52	96	6	272
VP-GDR	5.1	52	96	6	261
ADO-8D	5.1	56	115	6	157
ADO-SUS-8D	5.1	56	115	6	180
TDXL	5.1 X 10D	70	128	5.1	310

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-10D	5.1	70	128	6	160
EX-GDXL	5.1	85	150	5.1	301
VP-GDXL	5.1	85	150	5.1	270
TDXL	5.1 X 15D	92	150	5.1	312
ADO-15D	5.1	95	160	6	162
EX-GDXL	5.1	105	200	5.1	301
TDXL	5.1 X 20D	118	180	5.1	314
ADO-20D	5.1	120	190	6	164
ADO-25D	5.1	150	220	6	166
EX-GDXL	5.1	160	250	5.1	301
ADO-30D	5.1	180	250	6	168
EX-SUS-GDS	5.11	26	70	6	277
VPH-GDS	5.11	26	70	6	257
EX-SUS-GDR	5.11	52	96	6	285
EX-SUS-GDS	5.12	26	70	6	277
VPH-GDS	5.12	26	70	6	257
EX-SUS-GDR	5.12	52	96	6	286
EX-SUS-GDS	5.13	26	70	6	277
VPH-GDS	5.13	26	70	6	257
EX-SUS-GDR	5.13	52	96	6	286
EX-SUS-GDS	5.14	26	70	6	277
VPH-GDS	5.14	26	70	6	257
EX-SUS-GDR	5.14	52	96	6	286
EX-GDS	5.15	26	70	6	291
EX-SUS-GDS	5.15	26	70	6	277
VPH-GDS	5.15	26	70	6	257
EX-GDN	5.15	39	83	6	296
EX-GDR	5.15	52	96	6	297
EX-SUS-GDR	5.15	52	96	6	286
EX-SUS-GDS	5.16	26	70	6	277
VPH-GDS	5.16	26	70	6	257

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	5.16	52	96	6	286
EX-SUS-GDS	5.17	26	70	6	277
VPH-GDS	5.17	26	70	6	257
EX-SUS-GDR	5.17	52	96	6	286
EX-SUS-GDS	5.18	26	70	6	277
VPH-GDS	5.18	26	70	6	257
EX-SUS-GDR	5.18	52	96	6	286
EX-SUS-GDS	5.19	26	70	6	277
VPH-GDS	5.19	26	70	6	257
EX-SUS-GDR	5.19	52	96	6	286
ADF-2D	5.2	24	65	6	344
ADFO-3D	5.2	24	65	6	359
ADFLS-2D	5.2	24	110	6	356
EX-GDS	5.2	26	70	6	291
EX-SUS-GDS	5.2	26	70	6	277
NEXUS-GDS	5.2	26	70	6	271
VPH-GDS	5.2	26	70	6	257
ADO-3D	5.2	26	82	6	149
ADO-SUS-3D	5.2	26	82	6	173
ADO-TRS-3D	5.2	26	82	6	182
AD-2D	5.2	28	66	6	137
WH70-DRL	5.2	32	74	6	212
EX-GDN	5.2	39	83	6	296
NF-GDN	5.2	39	83	6	203
WHO55-5D	5.2	42	92	6	211
ADO-5D	5.2	42	100	6	153
ADO-SUS-5D	5.2	42	100	6	176
ADO-TRS-5D	5.2	42	100	6	184
AD-4D	5.2	44	82	6	141
V-SDR	5.2	52	86	5.2	321
EX-GDR	5.2	52	96	6	297

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	5.2	52	96	6	286
NEXUS-GDR	5.2	52	96	6	272
VP-GDR	5.2	52	96	6	261
ADO-8D	5.2	57	115	6	157
ADO-SUS-8D	5.2	57	115	6	180
TDXL	5.2 X 10D	70	128	5.2	310
ADO-10D	5.2	70	128	6	160
EX-GDXL	5.2	85	150	5.2	301
VP-GDXL	5.2	85	150	5.2	270
TDXL	5.2 X 15D	94	155	5.2	312
ADO-15D	5.2	95	160	6	162
EX-GDXL	5.2	105	200	5.2	301
VP-GDXL	5.2	105	200	5.2	270
TDXL	5.2 X 20D	120	180	5.2	314
ADO-20D	5.2	120	190	6	164
ADO-25D	5.2	150	220	6	166
EX-GDXL	5.2	160	250	5.2	301
ADO-30D	5.2	180	250	6	168
EX-SUS-GDS	5.21	26	70	6	277
VPH-GDS	5.21	26	70	6	257
EX-SUS-GDR	5.21	52	96	6	286
EX-SUS-GDS	5.22	26	70	6	277
VPH-GDS	5.22	26	70	6	257
EX-SUS-GDR	5.22	52	96	6	286
EX-SUS-GDS	5.23	26	70	6	277
VPH-GDS	5.23	26	70	6	257
EX-SUS-GDR	5.23	52	96	6	286
EX-SUS-GDS	5.24	26	70	6	277
VPH-GDS	5.24	26	70	6	257
EX-SUS-GDR	5.24	52	96	6	286
EX-GDS	5.25	26	70	6	291

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	5.25	26	70	6	277
VPH-GDS	5.25	26	70	6	257
ADO-3D	5.25	27	82	6	149
ADO-SUS-3D	5.25	27	82	6	173
EX-GDN	5.25	39	83	6	296
ADO-5D	5.25	42	100	6	153
ADO-SUS-5D	5.25	42	100	6	176
EX-GDR	5.25	52	96	6	297
EX-SUS-GDR	5.25	52	96	6	286
EX-SUS-GDS	5.26	26	70	6	277
VPH-GDS	5.26	26	70	6	257
EX-SUS-GDR	5.26	52	96	6	286
EX-SUS-GDS	5.27	26	70	6	277
VPH-GDS	5.27	26	70	6	257
EX-SUS-GDR	5.27	52	96	6	286
EX-SUS-GDS	5.28	26	70	6	277
VPH-GDS	5.28	26	70	6	257
EX-SUS-GDR	5.28	52	96	6	286
EX-SUS-GDS	5.29	26	70	6	277
VPH-GDS	5.29	26	70	6	257
EX-SUS-GDR	5.29	52	96	6	286
ADF-2D	5.3	24	65	6	344
ADFO-3D	5.3	24	65	6	359
ADFLS-2D	5.3	24	110	6	356
EX-GDS	5.3	26	70	6	291
EX-SUS-GDS	5.3	26	70	6	277
NEXUS-GDS	5.3	26	70	6	271
VPH-GDS	5.3	26	70	6	258
ADO-3D	5.3	27	82	6	149
ADO-SUS-3D	5.3	27	82	6	173
ADO-TRS-3D	5.3	27	82	6	182

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	5.3	28	66	6	137
WH70-DRL	5.3	32	74	6	212
EX-GDN	5.3	39	83	6	296
NF-GDN	5.3	39	83	6	203
ADO-5D	5.3	43	100	6	153
ADO-SUS-5D	5.3	43	100	6	176
ADO-TRS-5D	5.3	43	100	6	184
AD-4D	5.3	44	82	6	141
WHO55-5D	5.3	44	92	6	211
V-SDR	5.3	52	86	5.3	321
EX-GDR	5.3	52	96	6	297
EX-SUS-GDR	5.3	52	96	6	286
VP-GDR	5.3	52	96	6	261
ADO-8D	5.3	58	115	6	157
ADO-SUS-8D	5.3	58	115	6	180
TDXL	5.3 X 10D	70	128	5.3	310
ADO-10D	5.3	70	128	6	160
EX-GDXL	5.3	85	150	5.3	301
ADO-15D	5.3	95	160	6	162
TDXL	5.3 X 15D	96	155	5.3	312
EX-GDXL	5.3	105	200	5.3	301
ADO-20D	5.3	120	190	6	164
ADO-25D	5.3	150	220	6	166
EX-GDXL	5.3	160	250	5.3	301
ADO-30D	5.3	180	250	6	168
EX-SUS-GDS	5.31	28	72	6	277
VPH-GDS	5.31	28	72	6	258
EX-SUS-GDR	5.31	57	101	6	286
EX-SUS-GDS	5.32	28	72	6	277
VPH-GDS	5.32	28	72	6	258
EX-SUS-GDR	5.32	57	101	6	286

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	5.33	28	72	6	277
VPH-GDS	5.33	28	72	6	258
EX-SUS-GDR	5.33	57	101	6	286
EX-SUS-GDS	5.34	28	72	6	277
VPH-GDS	5.34	28	72	6	258
EX-SUS-GDR	5.34	57	101	6	286
EX-GDS	5.35	28	72	6	291
EX-SUS-GDS	5.35	28	72	6	277
VPH-GDS	5.35	28	72	6	258
EX-GDN	5.35	43	87	6	296
EX-GDR	5.35	57	101	6	297
EX-SUS-GDR	5.35	57	101	6	286
EX-SUS-GDS	5.36	28	72	6	277
VPH-GDS	5.36	28	72	6	258
EX-SUS-GDR	5.36	57	101	6	286
EX-SUS-GDS	5.37	28	72	6	277
VPH-GDS	5.37	28	72	6	258
EX-SUS-GDR	5.37	57	101	6	286
EX-SUS-GDS	5.38	28	72	6	277
VPH-GDS	5.38	28	72	6	258
EX-SUS-GDR	5.38	57	101	6	286
EX-SUS-GDS	5.39	28	72	6	277
VPH-GDS	5.39	28	72	6	258
EX-SUS-GDR	5.39	57	101	6	286
ADF-2D	5.4	27	65	6	344
ADFO-3D	5.4	27	65	6	359
ADO-3D	5.4	27	82	6	149
ADO-SUS-3D	5.4	27	82	6	173
ADO-TRS-3D	5.4	27	82	6	182
ADFLS-2D	5.4	27	110	6	356
AD-2D	5.4	28	66	6	137

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDS	5.4	28	72	6	291
EX-SUS-GDS	5.4	28	72	6	277
NEXUS-GDS	5.4	28	72	6	271
VPH-GDS	5.4	28	72	6	258
WH70-DRL	5.4	35	74	6	212
NF-GDN	5.4	43	83	6	203
EX-GDN	5.4	43	87	6	296
AD-4D	5.4	44	82	6	141
WH055-5D	5.4	44	92	6	211
ADO-5D	5.4	44	100	6	153
ADO-SUS-5D	5.4	44	100	6	176
ADO-TRS-5D	5.4	44	100	6	184
V-SDR	5.4	57	93	5.4	321
EX-GDR	5.4	57	101	6	297
EX-SUS-GDR	5.4	57	101	6	286
VP-GDR	5.4	57	101	6	261
ADO-8D	5.4	59	115	6	157
ADO-SUS-8D	5.4	59	115	6	180
TDXL	5.4 X 10D	78	128	5.4	310
ADO-10D	5.4	78	128	6	160
EX-GDXL	5.4	85	150	5.4	301
TDXL	5.4 X 15D	98	155	5.4	312
EX-GDXL	5.4	105	200	5.4	301
ADO-15D	5.4	110	160	6	162
ADO-20D	5.4	140	190	6	164
EX-GDXL	5.4	160	250	5.4	301
ADO-25D	5.4	170	220	6	166
ADO-30D	5.4	200	250	6	168
EX-SUS-GDS	5.41	28	72	6	277
VPH-GDS	5.41	28	72	6	258
EX-SUS-GDR	5.41	57	101	6	286

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	5.42	28	72	6	277
VPH-GDS	5.42	28	72	6	258
EX-SUS-GDR	5.42	57	101	6	286
EX-SUS-GDS	5.43	28	72	6	277
VPH-GDS	5.43	28	72	6	258
EX-SUS-GDR	5.43	57	101	6	286
EX-SUS-GDS	5.44	28	72	6	277
VPH-GDS	5.44	28	72	6	258
EX-SUS-GDR	5.44	57	101	6	286
EX-GDS	5.45	28	72	6	291
EX-SUS-GDS	5.45	28	72	6	277
VPH-GDS	5.45	28	72	6	258
EX-GDN	5.45	43	87	6	296
EX-GDR	5.45	57	101	6	297
EX-SUS-GDR	5.45	57	101	6	286
EX-SUS-GDS	5.46	28	72	6	277
VPH-GDS	5.46	28	72	6	258
EX-SUS-GDR	5.46	57	101	6	286
EX-SUS-GDS	5.47	28	72	6	277
VPH-GDS	5.47	28	72	6	258
EX-SUS-GDR	5.47	57	101	6	286
EX-SUS-GDS	5.48	28	72	6	277
NEXUS-GDS	5.48	28	72	6	271
VPH-GDS	5.48	28	72	6	258
EX-SUS-GDR	5.48	57	101	6	286
EX-SUS-GDS	5.49	28	72	6	277
VPH-GDS	5.49	28	72	6	258
EX-SUS-GDR	5.49	57	101	6	286
ED-DS	5.5	23	67	6	245
ADF-2D	5.5	27	65	6	344
ADFO-3D	5.5	27	65	6	359

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADFLS-2D	5.5	27	110	6	356
AD-2D	5.5	28	66	6	137
EX-GDS	5.5	28	72	6	291
EX-SUS-GDS	5.5	28	72	6	277
NEXUS-GDS	5.5	28	72	6	271
VPH-GDS	5.5	28	72	6	258
ADO-3D	5.5	28	82	6	149
ADO-SUS-3D	5.5	28	82	6	173
ADO-TRS-3D	5.5	28	82	6	182
WH70-DRL	5.5	35	74	6	212
D-GDN	5.5	43	83	6	243
NF-GDN	5.5	43	83	6	203
EX-GDN	5.5	43	87	6	296
AD-4D	5.5	44	82	6	141
WH55-5D	5.5	44	92	6	210
WHO55-5D	5.5	44	92	6	211
ADO-5D	5.5	44	100	6	153
ADO-SUS-5D	5.5	44	100	6	176
ADO-TRS-5D	5.5	44	100	6	184
V-SDR	5.5	57	93	5.5	321
EX-GDR	5.5	57	101	6	297
EX-SUS-GDR	5.5	57	101	6	286
NEXUS-GDR	5.5	57	101	6	272
VP-GDR	5.5	57	101	6	261
ADO-8D	5.5	61	115	6	157
ADO-SUS-8D	5.5	61	115	6	180
TDXL	5.5 X 10D	78	128	5.5	310
ADO-10D	5.5	78	128	6	160
TRS-HO-10D	5.5	78	128	6	190
EX-GDXL	5.5	85	150	5.5	301
VP-GDXL	5.5	85	150	5.5	270

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
TDXL	5.5 X 15D	100	155	5.5	312
EX-GDXL	5.5	105	200	5.5	301
VP-GDXL	5.5	105	200	5.5	270
ADO-15D	5.5	110	160	6	162
TDXL	5.5 X 20D	128	185	5.5	314
ADO-20D	5.5	140	190	6	164
CAO-GDXL	5.5 X 20D	140	190	6	206
EX-GDXL	5.5	160	250	5.5	301
ADO-25D	5.5	170	220	6	166
ADO-30D	5.5	200	250	6	168
CAO-GDXL	5.5 X 30D	200	250	6	207
EX-SUS-GDS	5.51	28	72	6	277
VPH-GDS	5.51	28	72	6	258
EX-SUS-GDR	5.51	57	101	6	286
ADF-2D	5.52	27	65	6	344
ADFO-3D	5.52	27	65	6	359
AD-2D	5.52	28	66	6	137
EX-SUS-GDS	5.52	28	72	6	277
VPH-GDS	5.52	28	72	6	258
NF-GDN	5.52	43	83	6	203
ADO-5D	5.52	45	100	6	153
ADO-SUS-5D	5.52	45	100	6	176
EX-SUS-GDR	5.52	57	101	6	286
VP-GDR	5.52	57	101	6	261
EX-SUS-GDS	5.53	28	72	6	277
VPH-GDS	5.53	28	72	6	258
ADO-PLT	5.53	28	80	6	172
EX-SUS-GDR	5.53	57	101	6	286
ADF-2D	5.54	27	65	6	344
ADFO-3D	5.54	27	65	6	359
AD-2D	5.54	28	66	6	138

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	5.54	28	72	6	277
VPH-GDS	5.54	28	72	6	258
NF-GDN	5.54	43	83	6	203
ADO-5D	5.54	45	100	6	153
ADO-SUS-5D	5.54	45	100	6	176
EX-SUS-GDR	5.54	57	101	6	286
VP-GDR	5.54	57	101	6	261
EX-GDS	5.55	28	72	6	291
EX-SUS-GDS	5.55	28	72	6	277
VPH-GDS	5.55	28	72	6	258
ADO-SUS-3D	5.55	28	82	6	173
EX-GDN	5.55	43	87	6	296
EX-GDR	5.55	57	101	6	297
EX-SUS-GDR	5.55	57	101	6	286
EX-SUS-GDS	5.56	28	72	6	277
VPH-GDS	5.56	28	72	6	258
WHO55-5D	5.56	46	92	6	211
EX-SUS-GDR	5.56	57	101	6	286
EX-SUS-GDS	5.57	28	72	6	277
VPH-GDS	5.57	28	72	6	258
EX-SUS-GDR	5.57	57	101	6	286
EX-SUS-GDS	5.58	28	72	6	277
VPH-GDS	5.58	28	72	6	258
EX-SUS-GDR	5.58	57	101	6	286
EX-SUS-GDS	5.59	28	72	6	277
VPH-GDS	5.59	28	72	6	258
EX-SUS-GDR	5.59	57	101	6	286
ADF-2D	5.6	27	65	6	344
ADFO-3D	5.6	27	65	6	359
ADFLS-2D	5.6	27	110	6	356
AD-2D	5.6	28	66	6	138

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDS	5.6	28	72	6	291
EX-SUS-GDS	5.6	28	72	6	277
NEXUS-GDS	5.6	28	72	6	271
VPH-GDS	5.6	28	72	6	258
ADO-3D	5.6	28	82	6	149
ADO-SUS-3D	5.6	28	82	6	173
ADO-TRS-3D	5.6	28	82	6	182
WH70-DRL	5.6	35	74	6	212
NF-GDN	5.6	43	83	6	203
EX-GDN	5.6	43	87	6	296
AD-4D	5.6	44	82	6	141
ADO-5D	5.6	45	100	6	153
ADO-SUS-5D	5.6	45	100	6	176
ADO-TRS-5D	5.6	45	100	6	184
WH055-5D	5.6	46	92	6	211
V-SDR	5.6	57	93	5.6	321
EX-GDR	5.6	57	101	6	297
EX-SUS-GDR	5.6	57	101	6	286
VP-GDR	5.6	57	101	6	261
ADO-8D	5.6	62	115	6	157
ADO-SUS-8D	5.6	62	115	6	180
TDXL	5.6 × 10D	78	128	5.6	310
ADO-10D	5.6	78	128	6	160
EX-GDXL	5.6	85	150	5.6	301
TDXL	5.6 × 15D	102	160	5.6	312
EX-GDXL	5.6	105	200	5.6	301
ADO-15D	5.6	110	160	6	162
ADO-20D	5.6	140	190	6	164
EX-GDXL	5.6	160	250	5.6	301
ADO-25D	5.6	170	220	6	166
ADO-30D	5.6	200	250	6	168

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	5.61	28	72	6	277
VPH-GDS	5.61	28	72	6	258
EX-SUS-GDR	5.61	57	101	6	286
EX-SUS-GDS	5.62	28	72	6	277
VPH-GDS	5.62	28	72	6	258
EX-SUS-GDR	5.62	57	101	6	286
EX-SUS-GDS	5.63	28	72	6	277
VPH-GDS	5.63	28	72	6	258
EX-SUS-GDR	5.63	57	101	6	286
EX-SUS-GDS	5.64	28	72	6	277
VPH-GDS	5.64	28	72	6	258
EX-SUS-GDR	5.64	57	101	6	286
EX-GDS	5.65	28	72	6	291
EX-SUS-GDS	5.65	28	72	6	277
VPH-GDS	5.65	28	72	6	258
EX-GDN	5.65	43	87	6	296
EX-GDR	5.65	57	101	6	297
EX-SUS-GDR	5.65	57	101	6	286
EX-SUS-GDS	5.66	28	72	6	277
VPH-GDS	5.66	28	72	6	258
EX-SUS-GDR	5.66	57	101	6	286
EX-SUS-GDS	5.67	28	72	6	277
VPH-GDS	5.67	28	72	6	258
EX-SUS-GDR	5.67	57	101	6	286
EX-SUS-GDS	5.68	28	72	6	277
VPH-GDS	5.68	28	72	6	258
EX-SUS-GDR	5.68	57	101	6	286
EX-SUS-GDS	5.69	28	72	6	277
VPH-GDS	5.69	28	72	6	258
EX-SUS-GDR	5.69	57	101	6	286
ADF-2D	5.7	27	65	6	344

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADFO-3D	5.7	27	65	6	359
ADFLS-2D	5.7	27	110	6	356
AD-2D	5.7	28	66	6	138
EX-GDS	5.7	28	72	6	291
EX-SUS-GDS	5.7	28	72	6	278
NEXUS-GDS	5.7	28	72	6	271
VPH-GDS	5.7	28	72	6	258
ADO-3D	5.7	29	82	6	149
ADO-SUS-3D	5.7	29	82	6	173
ADO-TRS-3D	5.7	29	82	6	182
WH70-DRL	5.7	35	74	6	212
NF-GDN	5.7	43	83	6	203
EX-GDN	5.7	43	87	6	296
AD-4D	5.7	44	82	6	141
WH055-5D	5.7	46	92	6	211
ADO-5D	5.7	46	100	6	153
ADO-SUS-5D	5.7	46	100	6	176
ADO-TRS-5D	5.7	46	100	6	184
V-SDR	5.7	57	93	5.7	321
EX-GDR	5.7	57	101	6	297
EX-SUS-GDR	5.7	57	101	6	286
VP-GDR	5.7	57	101	6	261
ADO-8D	5.7	63	115	6	157
ADO-SUS-8D	5.7	63	115	6	180
TDXL	5.7 × 10D	78	128	5.7	310
ADO-10D	5.7	78	128	6	160
EX-GDXL	5.7	85	150	5.7	301
TDXL	5.7 × 15D	104	165	5.7	312
EX-GDXL	5.7	105	200	5.7	301
ADO-15D	5.7	110	160	6	162
TDXL	5.7 × 20D	132	190	5.7	314

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-20D	5.7	140	190	6	164
EX-GDXL	5.7	160	250	5.7	301
ADO-25D	5.7	170	220	6	166
ADO-30D	5.7	200	250	6	168
EX-SUS-GDS	5.71	28	72	6	278
VPH-GDS	5.71	28	72	6	258
EX-SUS-GDR	5.71	57	101	6	286
EX-SUS-GDS	5.72	28	72	6	278
VPH-GDS	5.72	28	72	6	258
EX-SUS-GDR	5.72	57	101	6	286
EX-SUS-GDS	5.73	28	72	6	278
VPH-GDS	5.73	28	72	6	258
EX-SUS-GDR	5.73	57	101	6	286
EX-SUS-GDS	5.74	28	72	6	278
VPH-GDS	5.74	28	72	6	258
EX-SUS-GDR	5.74	57	101	6	286
EX-GDS	5.75	28	72	6	291
EX-SUS-GDS	5.75	28	72	6	278
VPH-GDS	5.75	28	72	6	258
EX-GDN	5.75	43	87	6	296
EX-GDR	5.75	57	101	6	297
EX-SUS-GDR	5.75	57	101	6	286
EX-SUS-GDS	5.76	28	72	6	278
VPH-GDS	5.76	28	72	6	258
EX-SUS-GDR	5.76	57	101	6	286
EX-SUS-GDS	5.77	28	72	6	278
VPH-GDS	5.77	28	72	6	258
EX-SUS-GDR	5.77	57	101	6	286
EX-SUS-GDS	5.78	28	72	6	278
VPH-GDS	5.78	28	72	6	258
EX-SUS-GDR	5.78	57	101	6	286

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	5.79	28	72	6	278
VPH-GDS	5.79	28	72	6	258
EX-SUS-GDR	5.79	57	101	6	286
ADF-2D	5.8	27	65	6	344
ADFO-3D	5.8	27	65	6	359
ADFLS-2D	5.8	27	110	6	356
AD-2D	5.8	28	66	6	138
EX-GDS	5.8	28	72	6	291
EX-SUS-GDS	5.8	28	72	6	278
NEXUS-GDS	5.8	28	72	6	271
VPH-GDS	5.8	28	72	6	258
ADO-3D	5.8	29	82	6	149
ADO-SUS-3D	5.8	29	82	6	173
ADO-TRS-3D	5.8	29	82	6	182
WH70-DRL	5.8	35	74	6	212
NF-GDN	5.8	43	83	6	203
EX-GDN	5.8	43	87	6	296
AD-4D	5.8	44	82	6	141
ADO-5D	5.8	47	100	6	153
ADO-SUS-5D	5.8	47	100	6	176
ADO-TRS-5D	5.8	47	100	6	184
WH55-5D	5.8	48	92	6	210
WHO55-5D	5.8	48	92	6	211
V-SDR	5.8	57	93	5.8	321
EX-GDR	5.8	57	101	6	297
EX-SUS-GDR	5.8	57	101	6	286
VP-GDR	5.8	57	101	6	261
ADO-8D	5.8	64	115	6	157
ADO-SUS-8D	5.8	64	115	6	180
TDXL	5.8 × 10D	78	128	5.8	310
ADO-10D	5.8	78	128	6	160

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	5.8	85	150	5.8	301
EX-GDXL	5.8	105	200	5.8	301
TDXL	5.8 × 15D	106	165	5.8	312
ADO-15D	5.8	110	160	6	162
TDXL	5.8 × 20D	134	200	5.8	314
ADO-20D	5.8	140	190	6	164
EX-GDXL	5.8	160	250	5.8	301
ADO-25D	5.8	170	220	6	166
ADO-30D	5.8	200	250	6	168
EX-SUS-GDS	5.81	28	72	6	278
VPH-GDS	5.81	28	72	6	258
EX-SUS-GDR	5.81	57	101	6	286
EX-SUS-GDS	5.82	28	72	6	278
VPH-GDS	5.82	28	72	6	258
EX-SUS-GDR	5.82	57	101	6	286
EX-SUS-GDS	5.83	28	72	6	278
VPH-GDS	5.83	28	72	6	258
EX-SUS-GDR	5.83	57	101	6	286
EX-SUS-GDS	5.84	28	72	6	278
VPH-GDS	5.84	28	72	6	258
EX-SUS-GDR	5.84	57	101	6	286
EX-GDS	5.85	28	72	6	291
EX-SUS-GDS	5.85	28	72	6	278
VPH-GDS	5.85	28	72	6	258
EX-GDN	5.85	43	87	6	296
EX-GDR	5.85	57	101	6	297
EX-SUS-GDR	5.85	57	101	6	286
EX-SUS-GDS	5.86	28	72	6	278
VPH-GDS	5.86	28	72	6	258
EX-SUS-GDR	5.86	57	101	6	286
EX-SUS-GDS	5.87	28	72	6	278

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	5.87	28	72	6	258
EX-SUS-GDR	5.87	57	101	6	286
EX-SUS-GDS	5.88	28	72	6	278
VPH-GDS	5.88	28	72	6	258
EX-SUS-GDR	5.88	57	101	6	286
EX-SUS-GDS	5.89	28	72	6	278
VPH-GDS	5.89	28	72	6	258
EX-SUS-GDR	5.89	57	101	6	286
ADF-2D	5.9	27	65	6	344
ADFO-3D	5.9	27	65	6	359
ADFLS-2D	5.9	27	110	6	356
AD-2D	5.9	28	66	6	138
EX-GDS	5.9	28	72	6	291
EX-SUS-GDS	5.9	28	72	6	278
NEXUS-GDS	5.9	28	72	6	271
VPH-GDS	5.9	28	72	6	258
ADO-3D	5.9	30	82	6	149
ADO-SUS-3D	5.9	30	82	6	173
ADO-TRS-3D	5.9	30	82	6	182
WH70-DRL	5.9	35	74	6	212
NF-GDN	5.9	43	83	6	203
EX-GDN	5.9	43	87	6	296
AD-4D	5.9	44	82	6	141
WH055-5D	5.9	48	92	6	211
ADO-5D	5.9	48	100	6	153
ADO-SUS-5D	5.9	48	100	6	176
ADO-TRS-5D	5.9	48	100	6	184
V-SDR	5.9	57	93	5.9	321
EX-GDR	5.9	57	101	6	297
EX-SUS-GDR	5.9	57	101	6	286
VP-GDR	5.9	57	101	6	261

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-8D	5.9	65	115	6	157
ADO-SUS-8D	5.9	65	115	6	180
TDXL	5.9 X 10D	78	128	5.9	310
ADO-10D	5.9	78	128	6	160
EX-GDXL	5.9	85	150	5.9	301
EX-GDXL	5.9	105	200	5.9	301
ADO-15D	5.9	110	160	6	162
ADO-20D	5.9	140	190	6	164
EX-GDXL	5.9	160	250	5.9	301
ADO-25D	5.9	170	220	6	166
ADO-30D	5.9	200	250	6	168
EX-SUS-GDS	5.91	28	72	6	278
VPH-GDS	5.91	28	72	6	258
EX-SUS-GDR	5.91	57	101	6	286
EX-SUS-GDS	5.92	28	72	6	278
VPH-GDS	5.92	28	72	6	258
EX-SUS-GDR	5.92	57	101	6	286
EX-SUS-GDS	5.93	28	72	6	278
VPH-GDS	5.93	28	72	6	258
EX-SUS-GDR	5.93	57	101	6	286
EX-SUS-GDS	5.94	28	72	6	278
VPH-GDS	5.94	28	72	6	258
EX-SUS-GDR	5.94	57	101	6	286
EX-GDS	5.95	28	72	6	291
EX-SUS-GDS	5.95	28	72	6	278
VPH-GDS	5.95	28	72	6	258
EX-GDN	5.95	43	87	6	296
EX-GDR	5.95	57	101	6	297
EX-SUS-GDR	5.95	57	101	6	286
EX-SUS-GDS	5.96	28	72	6	278
VPH-GDS	5.96	28	72	6	258

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	5.96	57	101	6	286
EX-SUS-GDS	5.97	28	72	6	278
VPH-GDS	5.97	28	72	6	258
EX-SUS-GDR	5.97	57	101	6	286
EX-SUS-GDS	5.98	28	72	6	278
VPH-GDS	5.98	28	72	6	258
EX-SUS-GDR	5.98	57	101	6	286
EX-SUS-GDS	5.99	28	72	6	278
VPH-GDS	5.99	28	72	6	258
EX-SUS-GDR	5.99	57	101	6	286
ED-DS	6	25	69	6	245
ADF-2D	6	27	65	6	344
ADFO-3D	6	27	65	6	359
ADFLS-2D	6	27	110	6	356
ADFLS-2D	6	27	110	6	356
AD-2D	6	28	66	6	138
EX-GDS	6	28	72	6	291
EX-SUS-GDS	6	28	72	6	278
NEXUS-GDS	6	28	72	6	271
VPH-GDS	6	28	72	6	258
VP-HO-GDS	6	28	72	6	265
EX-H-DRL	6	30	60	6	319
ADO-3D	6	30	82	6	149
ADO-SUS-3D	6	30	82	6	173
ADO-TRS-3D	6	30	82	6	182
WH70-DRL	6	35	74	6	212
D-GDN	6	43	83	6	243
NF-GDN	6	43	83	6	203
EX-GDN	6	43	87	6	296
V-MT-GDN	6	43	123	MT1	316
AD-4D	6	44	82	6	141

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WH55-5D	6	48	92	6	210
WHO55-5D	6	48	92	6	211
ADO-5D	6	48	100	6	153
ADO-SUS-5D	6	48	100	6	177
ADO-TRS-5D	6	48	100	6	184
V-SDR	6	57	93	6	321
EX-GDR	6	57	101	6	297
EX-HO-GDR	6	57	101	6	305
EX-SUS-GDR	6	57	101	6	286
NEXUS-GDR	6	57	101	6	272
VP-GDR	6	57	101	6	261
VP-HO-GDR	6	57	101	6	268
EX-MT-GDR	6	57	137	MT1	307
MT-SUS-GDR	6	57	137	MT1	289
ADO-8D	6	66	115	6	157
ADO-SUS-8D	6	66	115	6	180
ADO-10D	6	78	128	6	160
TDXL	6 X 10D	78	128	6	310
TRS-HO-10D	6	78	128	6	190
EX-GDXL	6	90	150	6	301
VP-GDXL	6	90	150	6	270
TDXL	6 X 15D	108	170	6	312
ADO-15D	6	110	160	6	162
CAO-GDXL	6 X 15D	110	160	6	205
EX-GDXL	6	110	200	6	301
VP-GDXL	6	110	200	6	270
TDXL	6 X 20D	138	200	6	314
ADO-20D	6	140	190	6	164
CAO-GDXL	6 X 20D	140	190	6	206
FTO-H-GDXL	6 X 20D	140	190	6	218
EX-GDXL	6	160	250	6	301

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-25D	6	170	220	6	166
ADO-30D	6	200	250	6	168
CAO-GDXL	6 X 30D	200	250	6	207
EX-GDXL	6	200	300	6	302
ADO-40D	6	258	308	6	170
ADO-50D	6	318	368	6	171
ADF-2D	6.03	30	70	6	344
ADFO-3D	6.03	30	70	8	359
ADO-PLT	6.03	30	80	6	172
EX-SUS-GDS	6.05	31	75	8	278
EX-GDR	6.05	63	107	8	297
EX-SUS-GDR	6.05	63	107	8	286
ADF-2D	6.1	30	70	6	344
ADFO-3D	6.1	30	70	8	359
VP-HO-GDS	6.1	31	75	6	265
EX-GDS	6.1	31	75	8	291
EX-SUS-GDS	6.1	31	75	8	278
NEXUS-GDS	6.1	31	75	8	271
VPH-GDS	6.1	31	75	8	258
ADO-3D	6.1-7	31	88	7	149
ADO-SUS-3D	6.1-7	31	88	7	173
ADO-3D	6.1	31	88	8	149
ADO-SUS-3D	6.1	31	88	8	173
ADO-TRS-3D	6.1	31	88	8	182
AD-2D	6.1-7	34	79	7	138
AD-2D	6.1	34	79	8	138
WH70-DRL	6.1	40	83	7	212
NF-GDN	6.1	47	90	7	203
ADO-5D	6.1-7	49	109	7	153
ADO-SUS-5D	6.1-7	49	109	7	177
ADO-5D	6.1	49	109	8	153

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	6.1	49	109	8	177
ADO-TRS-5D	6.1	49	109	8	184
AD-4D	6.1-7	53	91	7	141
AD-4D	6.1	53	91	8	141
V-SDR	6.1	63	101	6.1	321
EX-HO-GDR	6.1	63	107	6	305
EX-GDR	6.1	63	107	8	297
EX-SUS-GDR	6.1	63	107	8	286
VP-GDR	6.1	63	107	8	261
ADO-8D	6.1-7	67	125	7	157
ADO-SUS-8D	6.1-7	67	125	7	180
ADO-8D	6.1	67	125	8	157
ADO-SUS-8D	6.1	67	125	8	180
TDXL	6.1 X 10D	87	140	6.1	310
ADO-10D	6.1-7	87	140	7	160
ADO-10D	6.1	87	140	8	160
EX-GDXL	6.1	90	150	6.1	302
EX-GDXL	6.1	110	200	6.1	302
ADO-15D	6.1-7	120	175	7	162
ADO-15D	6.1	120	175	8	162
ADO-20D	6.1-7	155	210	7	164
ADO-20D	6.1	155	210	8	164
EX-GDXL	6.1	160	250	6.1	302
ADO-25D	6.1-7	190	250	7	166
ADO-25D	6.1	190	250	8	166
EX-GDXL	6.1	200	300	6.1	302
ADO-30D	6.1-7	215	280	7	168
ADO-30D	6.1	215	280	8	168
EX-SUS-GDS	6.15	31	75	8	278
EX-GDR	6.15	63	107	8	297
EX-SUS-GDR	6.15	63	107	8	286

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	6.2	30	70	6	344
ADFO-3D	6.2	30	70	8	359
VP-HO-GDS	6.2	31	75	6	265
EX-GDS	6.2	31	75	8	291
EX-SUS-GDS	6.2	31	75	8	278
NEXUS-GDS	6.2	31	75	8	271
VPH-GDS	6.2	31	75	8	258
ADO-3D	6.2-7	31	88	7	149
ADO-SUS-3D	6.2-7	31	88	7	173
ADO-3D	6.2	31	88	8	149
ADO-SUS-3D	6.2	31	88	8	173
ADO-TRS-3D	6.2	31	88	8	182
AD-2D	6.2-7	34	79	7	138
AD-2D	6.2	34	79	8	138
WH70-DRL	6.2	40	83	7	212
NF-GDN	6.2	47	90	7	203
ADO-5D	6.2-7	50	109	7	153
ADO-SUS-5D	6.2-7	50	109	7	177
ADO-5D	6.2	50	109	8	153
ADO-SUS-5D	6.2	50	109	8	177
ADO-TRS-5D	6.2	50	109	8	184
AD-4D	6.2-7	53	91	7	141
AD-4D	6.2	53	91	8	141
V-SDR	6.2	63	101	6.2	321
EX-HO-GDR	6.2	63	107	6	305
EX-GDR	6.2	63	107	8	297
EX-SUS-GDR	6.2	63	107	8	286
VP-GDR	6.2	63	107	8	261
ADO-8D	6.2-7	68	125	7	157
ADO-SUS-8D	6.2-7	68	125	7	180
ADO-8D	6.2	68	125	8	157

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-8D	6.2	68	125	8	180
TDXL	6.2 X 10D	87	140	6.2	310
ADO-10D	6.2-7	87	140	7	160
ADO-10D	6.2	87	140	8	160
EX-GDXL	6.2	90	150	6.2	302
EX-GDXL	6.2	110	200	6.2	302
TDXL	6.2 X 15D	112	170	6.2	312
ADO-15D	6.2-7	120	175	7	162
ADO-15D	6.2	120	175	8	162
ADO-20D	6.2-7	155	210	7	164
ADO-20D	6.2	155	210	8	164
EX-GDXL	6.2	160	250	6.2	302
ADO-25D	6.2-7	190	250	7	166
ADO-25D	6.2	190	250	8	166
EX-GDXL	6.2	200	300	6.2	302
ADO-30D	6.2-7	215	280	7	168
ADO-30D	6.2	215	280	8	168
EX-SUS-GDS	6.25	31	75	8	278
ADO-3D	6.25-7	32	88	7	149
ADO-SUS-3D	6.25-7	32	88	7	173
ADO-5D	6.25-7	50	109	7	153
ADO-SUS-5D	6.25-7	50	109	7	177
EX-GDR	6.25	63	107	8	297
EX-SUS-GDR	6.25	63	107	8	286
ADF-2D	6.3	30	70	6	344
ADFO-3D	6.3	30	70	8	359
VP-HO-GDS	6.3	31	75	6	265
EX-GDS	6.3	31	75	8	291
EX-SUS-GDS	6.3	31	75	8	278
NEXUS-GDS	6.3	31	75	8	271
VPH-GDS	6.3	31	75	8	258

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	6.3-7	32	88	7	149
ADO-SUS-3D	6.3-7	32	88	7	173
ADO-3D	6.3	32	88	8	149
ADO-SUS-3D	6.3	32	88	8	173
ADO-TRS-3D	6.3	32	88	8	182
AD-2D	6.3-7	34	79	7	138
AD-2D	6.3	34	79	8	138
WH70-DRL	6.3	40	83	7	212
NF-GDN	6.3	47	90	7	203
ADO-5D	6.3-7	51	109	7	153
ADO-SUS-5D	6.3-7	51	109	7	177
ADO-5D	6.3	51	109	8	153
ADO-SUS-5D	6.3	51	109	8	177
ADO-TRS-5D	6.3	51	109	8	184
AD-4D	6.3-7	53	91	7	141
AD-4D	6.3	53	91	8	141
V-SDR	6.3	63	101	6.3	321
EX-HO-GDR	6.3	63	107	6	305
EX-GDR	6.3	63	107	8	297
EX-SUS-GDR	6.3	63	107	8	286
VP-GDR	6.3	63	107	8	261
ADO-8D	6.3-7	69	125	7	157
ADO-SUS-8D	6.3-7	69	125	7	180
ADO-8D	6.3	69	125	8	157
ADO-SUS-8D	6.3	69	125	8	180
TDXL	6.3 X 10D	87	140	6.3	310
ADO-10D	6.3-7	87	140	7	160
ADO-10D	6.3	87	140	8	160
EX-GDXL	6.3	90	150	6.3	302
EX-GDXL	6.3	110	200	6.3	302
TDXL	6.3 X 15D	114	175	6.3	312

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-15D	6.3-7	120	175	7	162
ADO-15D	6.3	120	175	8	162
TDXL	6.3 × 20D	146	200	6.3	314
ADO-20D	6.3-7	155	210	7	164
ADO-20D	6.3	155	210	8	164
EX-GDXL	6.3	160	250	6.3	302
ADO-25D	6.3-7	190	250	7	166
ADO-25D	6.3	190	250	8	166
EX-GDXL	6.3	200	300	6.3	302
ADO-30D	6.3-7	215	280	7	168
ADO-30D	6.3	215	280	8	168
EX-SUS-GDS	6.35	31	75	8	278
ADO-SUS-3D	6.35(¼")-6.35	32	88	6.35	173
ADO-SUS-5D	6.35(¼")-6.35	52	109	6.35	177
EX-GDR	6.35	63	107	8	297
EX-SUS-GDR	6.35	63	107	8	286
D-DAD	6.375	38	94	6.375	249
D-GDN90	6.375	38	94	6.375	251
STCH	6.375	50	101	6.375	250
D-STAD	6.375	51	101	6.375	248
ADF-2D	6.4	30	70	6	344
ADFO-3D	6.4	30	70	8	359
VP-HO-GDS	6.4	31	75	6	265
EX-GDS	6.4	31	75	8	291
EX-SUS-GDS	6.4	31	75	8	278
NEXUS-GDS	6.4	31	75	8	271
VPH-GDS	6.4	31	75	8	258
ADO-3D	6.4-7	32	88	7	149
ADO-SUS-3D	6.4-7	32	88	7	173
ADO-3D	6.4	32	88	8	149
ADO-SUS-3D	6.4	32	88	8	173

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-TRS-3D	6.4	32	88	8	182
AD-2D	6.4-7	34	79	7	138
AD-2D	6.4	34	79	8	138
WH70-DRL	6.4	40	83	7	212
NF-GDN	6.4	47	90	7	203
ADO-5D	6.4-7	52	109	7	153
ADO-SUS-5D	6.4-7	52	109	7	177
ADO-5D	6.4	52	109	8	153
ADO-SUS-5D	6.4	52	109	8	177
ADO-TRS-5D	6.4	52	109	8	184
AD-4D	6.4-7	53	91	7	141
AD-4D	6.4	53	91	8	141
V-SDR	6.4	63	101	6.4	321
EX-HO-GDR	6.4	63	107	6	305
EX-GDR	6.4	63	107	8	297
EX-SUS-GDR	6.4	63	107	8	286
VP-GDR	6.4	63	107	8	261
ADO-8D	6.4-7	70	125	7	157
ADO-SUS-8D	6.4-7	70	125	7	180
ADO-8D	6.4	70	125	8	157
ADO-SUS-8D	6.4	70	125	8	180
TDXL	6.4 × 10D	87	140	6.4	310
ADO-10D	6.4-7	87	140	7	160
ADO-10D	6.4	87	140	8	160
EX-GDXL	6.4	90	150	6.4	302
EX-GDXL	6.4	110	200	6.4	302
ADO-15D	6.4-7	120	175	7	162
ADO-15D	6.4	120	175	8	162
ADO-20D	6.4-7	155	210	7	164
ADO-20D	6.4	155	210	8	164
EX-GDXL	6.4	160	250	6.4	302

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-25D	6.4-7	190	250	7	166
ADO-25D	6.4	190	250	8	166
EX-GDXL	6.4	200	300	6.4	302
ADO-30D	6.4-7	215	280	7	168
ADO-30D	6.4	215	280	8	168
EX-SUS-GDS	6.45	31	75	8	278
EX-GDR	6.45	63	107	8	297
EX-SUS-GDR	6.45	63	107	8	286
ED-DS	6.5	28	72	8	245
ADF-2D	6.5	30	70	6	344
ADFO-3D	6.5	30	70	8	359
ADFLS-2D	6.5	30	120	6	356
VP-HO-GDS	6.5	31	75	6	265
EX-GDS	6.5	31	75	8	291
EX-SUS-GDS	6.5	31	75	8	278
NEXUS-GDS	6.5	31	75	8	271
VPH-GDS	6.5	31	75	8	258
ADO-3D	6.5-7	33	88	7	149
ADO-SUS-3D	6.5-7	33	88	7	173
ADO-3D	6.5	33	88	8	149
ADO-SUS-3D	6.5	33	88	8	173
ADO-TRS-3D	6.5	33	88	8	182
AD-2D	6.5-7	34	79	7	138
AD-2D	6.5	34	79	8	138
WH70-DRL	6.5	40	83	7	212
D-GDN	6.5	47	87	7	243
NF-GDN	6.5	47	90	7	203
V-MT-GDN	6.5	47	127	MT1	316
WH55-5D	6.5	52	102	8	210
WHO55-5D	6.5	52	102	8	211
ADO-5D	6.5-7	52	109	7	154

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	6.5-7	52	109	7	177
ADO-5D	6.5	52	109	8	154
ADO-SUS-5D	6.5	52	109	8	177
ADO-TRS-5D	6.5	52	109	8	184
AD-4D	6.5-7	53	91	7	141
AD-4D	6.5	53	91	8	141
V-SDR	6.5	63	101	6.5	321
EX-HO-GDR	6.5	63	107	6	305
VP-HO-GDR	6.5	63	107	6	268
EX-GDR	6.5	63	107	8	297
EX-SUS-GDR	6.5	63	107	8	286
VP-GDR	6.5	63	107	8	261
EX-MT-GDR	6.5	63	143	MT1	307
MT-SUS-GDR	6.5	63	143	MT1	289
ADO-8D	6.5-7	72	125	7	157
ADO-SUS-8D	6.5-7	72	125	7	180
ADO-8D	6.5	72	125	8	157
ADO-SUS-8D	6.5	72	125	8	180
TDXL	6.5 X 10D	87	140	6.5	310
ADO-10D	6.5-7	87	140	7	160
TRS-HO-10D	6.5	87	140	7	190
ADO-10D	6.5	87	140	8	160
EX-GDXL	6.5	90	150	6.5	302
VP-GDXL	6.5	90	150	6.5	270
EX-GDXL	6.5	110	200	6.5	302
VP-GDXL	6.5	110	200	6.5	270
TDXL	6.5 X 15D	118	200	6.5	312
ADO-15D	6.5-7	120	175	7	162
CAO-GDXL	6.5 X 15D	120	175	7	205
ADO-15D	6.5	120	175	8	162
TDXL	6.5 X 20D	150	225	6.5	314

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-20D	6.5-7	155	210	7	164
ADO-20D	6.5	155	210	8	164
EX-GDXL	6.5	160	250	6.5	302
ADO-25D	6.5-7	190	250	7	166
ADO-25D	6.5	190	250	8	166
EX-GDXL	6.5	200	300	6.5	302
ADO-30D	6.5-7	215	280	7	168
ADO-30D	6.5	215	280	8	168
ADF-2D	6.53	30	70	6	344
ADFO-3D	6.53	30	70	8	359
ADO-PLT	6.53-7	33	85	7	172
EX-GDS	6.55	31	75	8	291
EX-SUS-GDS	6.55	31	75	8	278
EX-GDR	6.55	63	107	8	297
EX-SUS-GDR	6.55	63	107	8	286
ADF-2D	6.6	30	70	6	344
ADFO-3D	6.6	30	70	8	359
VP-HO-GDS	6.6	31	75	7	265
EX-GDS	6.6	31	75	8	291
EX-SUS-GDS	6.6	31	75	8	278
NEXUS-GDS	6.6	31	75	8	271
VPH-GDS	6.6	31	75	8	258
ADO-3D	6.6-7	33	88	7	150
ADO-SUS-3D	6.6-7	33	88	7	173
ADO-3D	6.6	33	88	8	150
ADO-SUS-3D	6.6	33	88	8	173
ADO-TRS-3D	6.6	33	88	8	182
AD-2D	6.6-7	34	79	7	138
AD-2D	6.6	34	79	8	138
WH70-DRL	6.6	40	83	7	212
NF-GDN	6.6	47	90	7	203

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-4D	6.6-7	53	91	7	141
AD-4D	6.6	53	91	8	141
ADO-5D	6.6-7	53	109	7	154
ADO-SUS-5D	6.6-7	53	109	7	177
ADO-5D	6.6	53	109	8	154
ADO-SUS-5D	6.6	53	109	8	177
ADO-TRS-5D	6.6	53	109	8	184
V-SDR	6.6	63	101	6.6	321
EX-HO-GDR	6.6	63	107	7	305
EX-GDR	6.6	63	107	8	297
EX-SUS-GDR	6.6	63	107	8	286
VP-GDR	6.6	63	107	8	261
ADO-8D	6.6-7	73	125	7	157
ADO-SUS-8D	6.6-7	73	125	7	180
ADO-8D	6.6	73	125	8	157
ADO-SUS-8D	6.6	73	125	8	180
TDXL	6.6 X 10D	87	140	6.6	310
ADO-10D	6.6-7	87	140	7	160
ADO-10D	6.6	87	140	8	160
EX-GDXL	6.6	90	150	6.6	302
EX-GDXL	6.6	110	200	6.6	302
ADO-15D	6.6-7	120	175	7	162
ADO-15D	6.6	120	175	8	162
TDXL	6.6 X 15D	120	200	6.6	312
ADO-20D	6.6-7	155	210	7	164
ADO-20D	6.6	155	210	8	164
EX-GDXL	6.6	160	250	6.6	302
ADO-25D	6.6-7	190	250	7	166
ADO-25D	6.6	190	250	8	166
EX-GDXL	6.6	200	300	6.6	302
ADO-30D	6.6-7	215	280	7	168

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-30D	6.6	215	280	8	168
EX-GDS	6.65	31	75	8	291
EX-SUS-GDS	6.65	31	75	8	278
EX-GDR	6.65	63	107	8	297
EX-SUS-GDR	6.65	63	107	8	286
ADF-2D	6.7	30	70	6	344
ADFO-3D	6.7	30	70	8	359
VP-HO-GDS	6.7	31	75	7	265
EX-GDS	6.7	31	75	8	291
EX-SUS-GDS	6.7	31	75	8	278
VPH-GDS	6.7	31	75	8	258
AD-2D	6.7-7	34	79	7	138
AD-2D	6.7	34	79	8	138
ADO-3D	6.7-7	34	88	7	150
ADO-SUS-3D	6.7-7	34	88	7	173
ADO-3D	6.7	34	88	8	150
ADO-SUS-3D	6.7	34	88	8	173
ADO-TRS-3D	6.7	34	88	8	182
WH70-DRL	6.7	40	83	7	212
NF-GDN	6.7	47	90	7	203
AD-4D	6.7-7	53	91	7	141
AD-4D	6.7	53	91	8	141
ADO-5D	6.7-7	54	109	7	154
ADO-SUS-5D	6.7-7	54	109	7	177
ADO-5D	6.7	54	109	8	154
ADO-SUS-5D	6.7	54	109	8	177
ADO-TRS-5D	6.7	54	109	8	184
V-SDR	6.7	63	101	6.7	321
EX-HO-GDR	6.7	63	107	7	305
EX-GDR	6.7	63	107	8	297
EX-SUS-GDR	6.7	63	107	8	286

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-GDR	6.7	63	107	8	261
ADO-8D	6.7-7	74	125	7	157
ADO-SUS-8D	6.7-7	74	125	7	180
ADO-8D	6.7	74	125	8	157
ADO-SUS-8D	6.7	74	125	8	180
TDXL	6.7 × 10D	87	140	6.7	310
ADO-10D	6.7-7	87	140	7	160
ADO-10D	6.7	87	140	8	160
EX-GDXL	6.7	90	150	6.7	302
EX-GDXL	6.7	110	200	6.7	302
ADO-15D	6.7-7	120	175	7	162
ADO-15D	6.7	120	175	8	162
ADO-20D	6.7-7	155	210	7	164
ADO-20D	6.7	155	210	8	164
EX-GDXL	6.7	160	250	6.7	302
ADO-25D	6.7-7	190	250	7	166
ADO-25D	6.7	190	250	8	166
EX-GDXL	6.7	200	300	6.7	302
ADO-30D	6.7-7	215	280	7	168
ADO-30D	6.7	215	280	8	168
EX-SUS-GDS	6.75	34	78	8	278
ADO-3D	6.75-7	34	88	7	150
ADO-SUS-3D	6.75-7	34	88	7	173
ADO-5D	6.75-7	54	109	7	154
ADO-SUS-5D	6.75-7	54	109	7	177
EX-GDR	6.75	69	113	8	297
EX-SUS-GDR	6.75	69	113	8	286
ADF-2D	6.8	30	70	6	344
ADFO-3D	6.8	30	70	8	359
ADFLS-2D	6.8	30	120	6	356
VP-HO-GDS	6.8	34	78	7	265

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDS	6.8	34	78	8	291
EX-SUS-GDS	6.8	34	78	8	278
NEXUS-GDS	6.8	34	78	8	271
VPH-GDS	6.8	34	78	8	258
AD-2D	6.8-7	34	79	7	138
AD-2D	6.8	34	79	8	138
ADO-3D	6.8-7	34	88	7	150
ADO-SUS-3D	6.8-7	34	88	7	173
ADO-3D	6.8	34	88	8	150
ADO-SUS-3D	6.8	34	88	8	173
ADO-TRS-3D	6.8	34	88	8	182
EX-LS-GDS	6.8	34	100	6.8	293
EX-LS-GDS	6.8	34	120	6.8	293
EX-LS-GDS	6.8	34	150	6.8	293
EX-LS-GDS	6.8	34	200	6.8	293
EX-LS-GDS	6.8	34	250	6.8	293
WH70-DRL	6.8	45	83	7	212
D-GDN	6.8	50	90	7	243
NF-GDN	6.8	52	90	7	203
V-MT-GDN	6.8	52	132	MT1	316
AD-4D	6.8-7	53	91	7	141
AD-4D	6.8	53	91	8	141
ADO-5D	6.8-7	55	109	7	154
ADO-SUS-5D	6.8-7	55	109	7	177
ADO-5D	6.8	55	109	8	154
ADO-SUS-5D	6.8	55	109	8	177
ADO-TRS-5D	6.8	55	109	8	184
WH55-5D	6.8	56	102	8	210
WHO55-5D	6.8	56	102	8	211
V-SDR	6.8	69	109	6.8	321
EX-HO-GDR	6.8	69	113	7	305

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDR	6.8	69	113	7	268
EX-GDR	6.8	69	113	8	297
EX-SUS-GDR	6.8	69	113	8	287
NEXUS-GDR	6.8	69	113	8	272
VP-GDR	6.8	69	113	8	261
EX-MT-GDR	6.8	69	149	MT1	307
MT-SUS-GDR	6.8	69	149	MT1	289
ADO-8D	6.8-7	75	125	7	157
ADO-SUS-8D	6.8-7	75	125	7	180
ADO-8D	6.8	75	125	8	157
ADO-SUS-8D	6.8	75	125	8	180
TDXL	6.8 X 10D	90	140	6.8	310
ADO-10D	6.8-7	90	140	7	160
ADO-10D	6.8	90	140	8	160
EX-GDXL	6.8	90	150	6.8	302
VP-GDXL	6.8	90	150	6.8	270
EX-GDXL	6.8	110	200	6.8	302
VP-GDXL	6.8	110	200	6.8	270
TDXL	6.8 X 15D	124	200	6.8	312
ADO-15D	6.8-7	125	175	7	162
ADO-15D	6.8	125	175	8	162
TDXL	6.8 X 20D	158	225	6.8	314
ADO-20D	6.8-7	160	210	7	164
ADO-20D	6.8	160	210	8	164
EX-GDXL	6.8	160	250	6.8	302
ADO-25D	6.8-7	200	250	7	166
ADO-25D	6.8	200	250	8	166
EX-GDXL	6.8	200	300	6.8	302
ADO-30D	6.8-7	230	280	7	168
ADO-30D	6.8	230	280	8	168
EX-SUS-GDS	6.85	34	78	8	278

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDR	6.85	69	113	8	297
EX-SUS-GDR	6.85	69	113	8	287
ADF-2D	6.9	30	70	6	344
ADFO-3D	6.9	30	70	8	359
ADFLS-2D	6.9	30	120	6	356
VP-HO-GDS	6.9	34	78	7	265
EX-GDS	6.9	34	78	8	291
EX-SUS-GDS	6.9	34	78	8	278
NEXUS-GDS	6.9	34	78	8	271
VPH-GDS	6.9	34	78	8	258
AD-2D	6.9-7	34	79	7	138
AD-2D	6.9	34	79	8	138
ADO-3D	6.9-7	35	88	7	150
ADO-SUS-3D	6.9-7	35	88	7	173
ADO-3D	6.9	35	88	8	150
ADO-SUS-3D	6.9	35	88	8	173
ADO-TRS-3D	6.9	35	88	8	182
WH70-DRL	6.9	45	83	7	212
NF-GDN	6.9	52	90	7	203
AD-4D	6.9-7	53	91	7	141
AD-4D	6.9	53	91	8	141
ADO-5D	6.9-7	56	109	7	154
ADO-SUS-5D	6.9-7	56	109	7	177
ADO-5D	6.9	56	109	8	154
ADO-SUS-5D	6.9	56	109	8	177
ADO-TRS-5D	6.9	56	109	8	184
V-SDR	6.9	69	109	6.9	321
EX-HO-GDR	6.9	69	113	7	305
EX-GDR	6.9	69	113	8	297
EX-SUS-GDR	6.9	69	113	8	287
NEXUS-GDR	6.9	69	113	8	272

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-GDR	6.9	69	113	8	261
ADO-8D	6.9-7	76	125	7	157
ADO-SUS-8D	6.9-7	76	125	7	180
ADO-8D	6.9	76	125	8	157
ADO-SUS-8D	6.9	76	125	8	180
TDXL	6.9 X 10D	90	140	6.9	310
ADO-10D	6.9-7	90	140	7	160
ADO-10D	6.9	90	140	8	160
EX-GDXL	6.9	90	150	6.9	302
VP-GDXL	6.9	90	150	6.9	270
EX-GDXL	6.9	110	200	6.9	302
ADO-15D	6.9-7	125	175	7	162
ADO-15D	6.9	125	175	8	162
TDXL	6.9 X 15D	126	200	6.9	312
ADO-20D	6.9-7	160	210	7	164
ADO-20D	6.9	160	210	8	164
TDXL	6.9 X 20D	160	230	6.9	314
EX-GDXL	6.9	160	250	6.9	302
ADO-25D	6.9-7	200	250	7	166
ADO-25D	6.9	200	250	8	166
EX-GDXL	6.9	200	300	6.9	302
ADO-30D	6.9-7	230	280	7	168
ADO-30D	6.9	230	280	8	168
EX-SUS-GDS	6.95	34	78	8	278
EX-GDR	6.95	69	113	8	297
EX-SUS-GDR	6.95	69	113	8	287
ED-DS	7	28	72	8	245
ADF-2D	7	30	70	6	344
ADFO-3D	7	30	70	8	359
ADFLS-2D	7	30	120	6	356
VP-HO-GDS	7	34	78	7	265

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDS	7	34	78	8	291
EX-SUS-GDS	7	34	78	8	278
NEXUS-GDS	7	34	78	8	271
VPH-GDS	7	34	78	8	258
AD-2D	7-7	34	79	7	138
AD-2D	7	34	79	8	138
EX-LS-GDS	7	34	120	7	293
EX-LS-GDS	7	34	150	7	293
EX-LS-GDS	7	34	200	7	293
EX-LS-GDS	7	34	250	7	293
EX-H-DRL	7	35	80	8	319
ADO-3D	7-7	35	88	7	150
ADO-SUS-3D	7-7	35	88	7	173
ADO-3D	7	35	88	8	150
ADO-SUS-3D	7	35	88	8	173
ADO-TRS-3D	7	35	88	8	182
WH70-DRL	7	45	83	7	212
D-GDN	7	50	90	7	243
NF-GDN	7	52	90	7	203
V-MT-GDN	7	52	132	MT1	316
AD-4D	7-7	53	91	7	141
AD-4D	7	53	91	8	141
WH55-5D	7	56	102	8	210
WHO55-5D	7	56	102	8	211
ADO-5D	7-7	56	109	7	154
ADO-SUS-5D	7-7	56	109	7	177
ADO-5D	7	56	109	8	154
ADO-SUS-5D	7	56	109	8	177
ADO-TRS-5D	7	56	109	8	184
V-SDR	7	69	109	7	321
EX-HO-GDR	7	69	113	7	305

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDR	7	69	113	7	268
EX-GDR	7	69	113	8	297
EX-SUS-GDR	7	69	113	8	287
NEXUS-GDR	7	69	113	8	272
VP-GDR	7	69	113	8	261
EX-MT-GDR	7	69	149	MT1	307
MT-SUS-GDR	7	69	149	MT1	289
ADO-8D	7-7	77	125	7	157
ADO-SUS-8D	7-7	77	125	7	180
ADO-8D	7	77	125	8	157
ADO-SUS-8D	7	77	125	8	180
ADO-10D	7-7	90	140	7	160
TDXL	7 × 10D	90	140	7	310
TRS-HO-10D	7	90	140	7	190
ADO-10D	7	90	140	8	160
EX-GDXL	7	90	150	7	302
VP-GDXL	7	90	150	7	270
EX-GDXL	7	110	200	7	302
VP-GDXL	7	110	200	7	270
ADO-15D	7-7	125	175	7	162
CAO-GDXL	7 × 15D	125	175	7	205
ADO-15D	7	125	175	8	162
TDXL	7 × 15D	126	200	7	312
ADO-20D	7-7	160	210	7	164
CAO-GDXL	7 × 20D	160	210	7	206
ADO-20D	7	160	210	8	164
EX-GDXL	7	160	250	7	302
TDXL	7 × 20D	162	230	7	314
ADO-25D	7-7	200	250	7	166
ADO-25D	7	200	250	8	166
EX-GDXL	7	200	300	7	302

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-30D	7-7	230	280	7	168
CAO-GDXL	7 × 30D	230	280	7	207
ADO-30D	7	230	280	8	168
ADFO-3D	7.03	30	70	8	359
ADF-2D	7.03	34	75	6	344
ADO-PLT	7.03-7	35	85	7	172
EX-SUS-GDS	7.05	34	78	8	278
EX-GDR	7.05	69	113	8	297
EX-SUS-GDR	7.05	69	113	8	287
ADF-2D	7.1	34	75	6	344
ADFO-3D	7.1	34	75	8	359
EX-GDS	7.1	34	78	8	291
EX-SUS-GDS	7.1	34	78	8	278
VPH-GDS	7.1	34	78	8	258
VP-HO-GDS	7.1	34	78	8	265
ADO-3D	7.1	36	94	8	150
ADO-SUS-3D	7.1	36	94	8	173
ADO-TRS-3D	7.1	36	94	8	182
AD-2D	7.1	41	79	8	138
WH70-DRL	7.1	45	94	8	212
NF-GDN	7.1	52	96	8	203
AD-4D	7.1	53	91	8	141
ADO-5D	7.1	57	118	8	154
ADO-SUS-5D	7.1	57	118	8	177
ADO-TRS-5D	7.1	57	118	8	184
V-SDR	7.1	69	109	7.1	321
EX-GDR	7.1	69	113	8	297
EX-HO-GDR	7.1	69	113	8	305
EX-SUS-GDR	7.1	69	113	8	287
VP-GDR	7.1	69	113	8	261
ADO-8D	7.1	78	140	8	157

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-8D	7.1	78	140	8	180
EX-GDXL	7.1	90	150	7.1	302
TDXL	7.1 X 10D	100	155	7.1	310
ADO-10D	7.1	100	155	8	160
EX-GDXL	7.1	110	200	7.1	302
TDXL	7.1 X 15D	128	200	7.1	312
ADO-15D	7.1	135	195	8	162
EX-GDXL	7.1	160	250	7.1	302
ADO-20D	7.1	170	230	8	164
EX-GDXL	7.1	200	300	7.1	302
ADO-25D	7.1	210	275	8	166
ADO-30D	7.1	250	315	8	168
EX-SUS-GDS	7.15	34	78	8	278
EX-GDR	7.15	69	113	8	297
EX-SUS-GDR	7.15	69	113	8	287
ADF-2D	7.2	34	75	6	344
ADFO-3D	7.2	34	75	8	359
EX-GDS	7.2	34	78	8	291
EX-SUS-GDS	7.2	34	78	8	278
VPH-GDS	7.2	34	78	8	258
VP-HO-GDS	7.2	34	78	8	265
ADO-3D	7.2	36	94	8	150
ADO-SUS-3D	7.2	36	94	8	173
ADO-TRS-3D	7.2	36	94	8	182
AD-2D	7.2	41	79	8	138
WH70-DRL	7.2	45	94	8	212
NF-GDN	7.2	52	96	8	203
AD-4D	7.2	53	91	8	141
ADO-5D	7.2	58	118	8	154
ADO-SUS-5D	7.2	58	118	8	177
ADO-TRS-5D	7.2	58	118	8	184

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
V-SDR	7.2	69	109	7.2	321
EX-GDR	7.2	69	113	8	298
EX-HO-GDR	7.2	69	113	8	305
EX-SUS-GDR	7.2	69	113	8	287
VP-GDR	7.2	69	113	8	261
ADO-8D	7.2	79	140	8	157
ADO-SUS-8D	7.2	79	140	8	181
EX-GDXL	7.2	90	150	7.2	302
TDXL	7.2 X 10D	100	155	7.2	310
ADO-10D	7.2	100	155	8	160
EX-GDXL	7.2	110	200	7.2	302
ADO-15D	7.2	135	195	8	162
EX-GDXL	7.2	160	250	7.2	302
ADO-20D	7.2	170	230	8	164
EX-GDXL	7.2	200	300	7.2	302
ADO-25D	7.2	210	275	8	166
ADO-30D	7.2	250	315	8	168
EX-SUS-GDS	7.25	34	78	8	278
ADO-3D	7.25	37	94	8	150
ADO-SUS-3D	7.25	37	94	8	173
ADO-5D	7.25	58	118	8	154
ADO-SUS-5D	7.25	58	118	8	177
EX-GDR	7.25	69	113	8	298
EX-SUS-GDR	7.25	69	113	8	287
ADF-2D	7.3	34	75	6	344
ADFO-3D	7.3	34	75	8	359
EX-GDS	7.3	34	78	8	291
EX-SUS-GDS	7.3	34	78	8	278
VPH-GDS	7.3	34	78	8	259
VP-HO-GDS	7.3	34	78	8	265
ADO-3D	7.3	37	94	8	150

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	7.3	37	94	8	173
ADO-TRS-3D	7.3	37	94	8	182
AD-2D	7.3	41	79	8	138
WH70-DRL	7.3	45	94	8	212
NF-GDN	7.3	52	96	8	203
AD-4D	7.3	53	91	8	141
ADO-5D	7.3	59	118	8	154
ADO-SUS-5D	7.3	59	118	8	177
ADO-TRS-5D	7.3	59	118	8	184
V-SDR	7.3	69	109	7.3	321
EX-GDR	7.3	69	113	8	298
EX-HO-GDR	7.3	69	113	8	305
EX-SUS-GDR	7.3	69	113	8	287
VP-GDR	7.3	69	113	8	261
ADO-8D	7.3	80	140	8	157
ADO-SUS-8D	7.3	80	140	8	181
EX-GDXL	7.3	90	150	7.3	302
TDXL	7.3 X 10D	100	155	7.3	310
ADO-10D	7.3	100	155	8	160
EX-GDXL	7.3	110	200	7.3	302
ADO-15D	7.3	135	195	8	162
EX-GDXL	7.3	160	250	7.3	302
ADO-20D	7.3	170	230	8	164
EX-GDXL	7.3	200	300	7.3	302
ADO-25D	7.3	210	275	8	166
ADO-30D	7.3	250	315	8	168
NEXUS-GDS	7.34	34	78	8	271
EX-SUS-GDR	7.34	69	113	8	287
EX-GDS	7.35	34	78	8	291
EX-SUS-GDS	7.35	34	78	8	278
EX-GDR	7.35	69	113	8	298

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	7.35	69	113	8	287
AD-2D	7.36	41	79	8	138
NF-GDN	7.36	52	96	8	203
ADO-5D	7.36	59	118	8	154
ADO-SUS-5D	7.36	59	118	8	177
EX-SUS-GDR	7.36	69	113	8	287
VP-GDR	7.36	69	113	8	261
NEXUS-GDS	7.38	34	78	8	271
ADO-TRS-3D	7.38	37	94	8	182
AD-2D	7.38	41	79	8	138
NF-GDN	7.38	52	96	8	203
ADO-5D	7.38	60	118	8	154
ADO-SUS-5D	7.38	60	118	8	177
ADO-TRS-5D	7.38	60	118	8	184
VP-GDR	7.38	69	113	8	261
ADF-2D	7.4	34	75	6	344
ADFO-3D	7.4	34	75	8	359
EX-GDS	7.4	34	78	8	291
EX-SUS-GDS	7.4	34	78	8	278
NEXUS-GDS	7.4	34	78	8	271
VPH-GDS	7.4	34	78	8	259
VP-HO-GDS	7.4	34	78	8	265
ADFLS-2D	7.4	34	130	6	356
ADO-3D	7.4	37	94	8	150
ADO-SUS-3D	7.4	37	94	8	173
ADO-TRS-3D	7.4	37	94	8	182
AD-2D	7.4	41	79	8	138
WH70-DRL	7.4	45	94	8	212
NF-GDN	7.4	52	96	8	203
AD-4D	7.4	53	91	8	141
ADO-5D	7.4	60	118	8	154

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	7.4	60	118	8	177
ADO-TRS-5D	7.4	60	118	8	184
V-SDR	7.4	69	109	7.4	321
EX-GDR	7.4	69	113	8	298
EX-HO-GDR	7.4	69	113	8	305
EX-SUS-GDR	7.4	69	113	8	287
VP-GDR	7.4	69	113	8	261
ADO-8D	7.4	81	140	8	157
ADO-SUS-8D	7.4	81	140	8	181
EX-GDXL	7.4	90	150	7.4	302
TDXL	7.4 × 10D	100	155	7.4	310
ADO-10D	7.4	100	155	8	161
EX-GDXL	7.4	110	200	7.4	302
ADO-15D	7.4	135	195	8	162
EX-GDXL	7.4	160	250	7.4	302
ADO-20D	7.4	170	230	8	164
EX-GDXL	7.4	200	300	7.4	302
ADO-25D	7.4	210	275	8	166
ADO-30D	7.4	250	315	8	168
EX-SUS-GDS	7.45	34	78	8	278
ADO-SUS-3D	7.45	38	94	8	173
ADO-SUS-5D	7.45	60	118	8	177
EX-GDR	7.45	69	113	8	298
EX-SUS-GDR	7.45	69	113	8	287
ED-DS	7.5	31	75	8	245
ADF-2D	7.5	34	75	6	344
ADFO-3D	7.5	34	75	8	359
EX-GDS	7.5	34	78	8	291
EX-SUS-GDS	7.5	34	78	8	278
NEXUS-GDS	7.5	34	78	8	271
VPH-GDS	7.5	34	78	8	259

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDS	7.5	34	78	8	265
ADFLS-2D	7.5	34	130	6	356
ADO-3D	7.5	38	94	8	150
ADO-SUS-3D	7.5	38	94	8	173
ADO-TRS-3D	7.5	38	94	8	182
AD-2D	7.5	41	79	8	138
WH70-DRL	7.5	45	94	8	212
D-GDN	7.5	52	92	8	243
NF-GDN	7.5	52	96	8	203
V-MT-GDN	7.5	52	132	MT1	316
AD-4D	7.5	53	91	8	141
ADO-5D	7.5	60	118	8	154
ADO-SUS-5D	7.5	60	118	8	177
ADO-TRS-5D	7.5	60	118	8	184
WH55-5D	7.5	60	118	8	210
WHO55-5D	7.5	60	118	8	211
V-SDR	7.5	69	109	7.5	321
EX-GDR	7.5	69	113	8	298
EX-HO-GDR	7.5	69	113	8	305
EX-SUS-GDR	7.5	69	113	8	287
VP-GDR	7.5	69	113	8	261
VP-HO-GDR	7.5	69	113	8	268
EX-MT-GDR	7.5	69	149	MT1	307
MT-SUS-GDR	7.5	69	149	MT1	289
ADO-8D	7.5	83	140	8	157
ADO-SUS-8D	7.5	83	140	8	181
EX-GDXL	7.5	90	150	7.5	302
VP-GDXL	7.5	90	150	7.5	270
TDXL	7.5 × 10D	100	155	7.5	310
ADO-10D	7.5	100	155	8	161
TRS-HO-10D	7.5	100	155	8	190

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	7.5	110	200	7.5	302
VP-GDXL	7.5	110	200	7.5	270
ADO-15D	7.5	135	195	8	162
TDXL	7.5 X 15D	136	205	7.5	312
EX-GDXL	7.5	160	250	7.5	302
ADO-20D	7.5	170	230	8	164
TDXL	7.5 X 20D	174	245	7.5	314
EX-GDXL	7.5	200	300	7.5	302
ADO-25D	7.5	210	275	8	166
ADO-30D	7.5	250	315	8	168
AD-2D	7.52	41	79	8	138
NF-GDN	7.52	56	96	8	203
ADO-5D	7.52	61	118	8	154
ADO-SUS-5D	7.52	61	118	8	177
EX-SUS-GDR	7.52	75	119	8	287
VP-GDR	7.52	75	119	8	261
AD-2D	7.54	41	79	8	138
NF-GDN	7.54	56	96	8	203
ADO-5D	7.54	61	118	8	154
ADO-SUS-5D	7.54	61	118	8	177
VP-GDR	7.54	75	119	8	261
EX-GDS	7.55	37	81	8	291
EX-SUS-GDS	7.55	37	81	8	278
ADO-SUS-3D	7.55	38	94	8	173
EX-GDR	7.55	75	119	8	298
EX-SUS-GDR	7.55	75	119	8	287
ADF-2D	7.6	34	75	6	344
ADFO-3D	7.6	34	75	8	359
EX-GDS	7.6	37	81	8	291
EX-SUS-GDS	7.6	37	81	8	278
VPH-GDS	7.6	37	81	8	259

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDS	7.6	37	81	8	265
ADO-3D	7.6	38	94	8	150
ADO-SUS-3D	7.6	38	94	8	173
ADO-TRS-3D	7.6	38	94	8	182
AD-2D	7.6	41	79	8	138
WH70-DRL	7.6	50	94	8	212
AD-4D	7.6	53	91	8	141
NF-GDN	7.6	56	96	8	203
ADO-5D	7.6	61	118	8	154
ADO-SUS-5D	7.6	61	118	8	177
ADO-TRS-5D	7.6	61	118	8	184
V-SDR	7.6	75	117	7.6	321
EX-GDR	7.6	75	119	8	298
EX-HO-GDR	7.6	75	119	8	305
EX-SUS-GDR	7.6	75	119	8	287
VP-GDR	7.6	75	119	8	261
ADO-8D	7.6	84	140	8	158
ADO-SUS-8D	7.6	84	140	8	181
TDXL	7.6 X 10D	105	155	7.6	310
ADO-10D	7.6	105	155	8	161
EX-GDXL	7.6	110	200	7.6	302
ADO-15D	7.6	145	195	8	163
EX-GDXL	7.6	160	250	7.6	302
ADO-20D	7.6	180	230	8	165
EX-GDXL	7.6	200	300	7.6	302
ADO-25D	7.6	225	275	8	167
ADO-30D	7.6	265	315	8	169
EX-GDS	7.65	37	81	8	291
EX-SUS-GDS	7.65	37	81	8	278
EX-GDR	7.65	75	119	8	298
EX-SUS-GDR	7.65	75	119	8	287

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	7.7	34	75	6	344
ADFO-3D	7.7	34	75	8	359
EX-GDS	7.7	37	81	8	291
EX-SUS-GDS	7.7	37	81	8	278
VPH-GDS	7.7	37	81	8	259
VP-HO-GDS	7.7	37	81	8	265
ADO-3D	7.7	39	94	8	150
ADO-SUS-3D	7.7	39	94	8	174
ADO-TRS-3D	7.7	39	94	8	182
AD-2D	7.7	41	79	8	138
WH70-DRL	7.7	50	94	8	212
AD-4D	7.7	53	91	8	141
NF-GDN	7.7	56	96	8	203
ADO-5D	7.7	62	118	8	154
ADO-SUS-5D	7.7	62	118	8	177
ADO-TRS-5D	7.7	62	118	8	184
V-SDR	7.7	75	117	7.7	321
EX-GDR	7.7	75	119	8	298
EX-HO-GDR	7.7	75	119	8	305
EX-SUS-GDR	7.7	75	119	8	287
VP-GDR	7.7	75	119	8	261
ADO-8D	7.7	85	140	8	158
ADO-SUS-8D	7.7	85	140	8	181
TDXL	7.7 X 10D	105	155	7.7	310
ADO-10D	7.7	105	155	8	161
EX-GDXL	7.7	110	200	7.7	302
ADO-15D	7.7	145	195	8	163
EX-GDXL	7.7	160	250	7.7	302
ADO-20D	7.7	180	230	8	165
EX-GDXL	7.7	200	300	7.7	302
ADO-25D	7.7	225	275	8	167

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-30D	7.7	265	315	8	169
EX-SUS-GDS	7.75	37	81	8	278
ADO-3D	7.75	39	94	8	150
ADO-SUS-3D	7.75	39	94	8	174
ADO-5D	7.75	62	118	8	154
ADO-SUS-5D	7.75	62	118	8	177
EX-GDR	7.75	75	119	8	298
EX-SUS-GDR	7.75	75	119	8	287
ADF-2D	7.8	34	75	6	344
ADFO-3D	7.8	34	75	8	359
ADFLS-2D	7.8	34	130	6	356
EX-GDS	7.8	37	81	8	291
EX-SUS-GDS	7.8	37	81	8	278
NEXUS-GDS	7.8	37	81	8	271
VPH-GDS	7.8	37	81	8	259
VP-HO-GDS	7.8	37	81	8	265
ADO-3D	7.8	39	94	8	150
ADO-SUS-3D	7.8	39	94	8	174
ADO-TRS-3D	7.8	39	94	8	182
AD-2D	7.8	41	79	8	138
WH70-DRL	7.8	50	94	8	212
AD-4D	7.8	53	91	8	141
NF-GDN	7.8	56	96	8	203
ADO-5D	7.8	63	118	8	154
ADO-SUS-5D	7.8	63	118	8	177
ADO-TRS-5D	7.8	63	118	8	184
WH55-5D	7.8	64	118	8	210
WHO55-5D	7.8	64	118	8	211
V-SDR	7.8	75	117	7.8	321
EX-GDR	7.8	75	119	8	298
EX-HO-GDR	7.8	75	119	8	305

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	7.8	75	119	8	287
VP-GDR	7.8	75	119	8	261
ADO-8D	7.8	86	140	8	158
ADO-SUS-8D	7.8	86	140	8	181
TDXL	7.8 × 10D	105	155	7.8	310
ADO-10D	7.8	105	155	8	161
EX-GDXL	7.8	110	200	7.8	302
ADO-15D	7.8	145	195	8	163
EX-GDXL	7.8	160	250	7.8	302
ADO-20D	7.8	180	230	8	165
EX-GDXL	7.8	200	300	7.8	302
ADO-25D	7.8	225	275	8	167
ADO-30D	7.8	265	315	8	169
EX-SUS-GDS	7.85	37	81	8	278
EX-GDR	7.85	75	119	8	298
EX-SUS-GDR	7.85	75	119	8	287
ADF-2D	7.9	34	75	6	344
ADFO-3D	7.9	34	75	8	359
EX-GDS	7.9	37	81	8	291
EX-SUS-GDS	7.9	37	81	8	278
NEXUS-GDS	7.9	37	81	8	271
VPH-GDS	7.9	37	81	8	259
VP-HO-GDS	7.9	37	81	8	265
ADO-3D	7.9	40	94	8	150
ADO-SUS-3D	7.9	40	94	8	174
ADO-TRS-3D	7.9	40	94	8	182
AD-2D	7.9	41	79	8	138
WH70-DRL	7.9	50	94	8	212
AD-4D	7.9	53	91	8	141
NF-GDN	7.9	56	96	8	203
ADO-5D	7.9	64	118	8	154

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	7.9	64	118	8	177
ADO-TRS-5D	7.9	64	118	8	184
V-SDR	7.9	75	117	7.9	321
EX-GDR	7.9	75	119	8	298
EX-HO-GDR	7.9	75	119	8	305
EX-SUS-GDR	7.9	75	119	8	287
VP-GDR	7.9	75	119	8	261
ADO-8D	7.9	87	140	8	158
ADO-SUS-8D	7.9	87	140	8	181
TDXL	7.9 × 10D	105	155	7.9	310
ADO-10D	7.9	105	155	8	161
EX-GDXL	7.9	110	200	7.9	302
ADO-15D	7.9	145	195	8	163
EX-GDXL	7.9	160	250	7.9	302
ADO-20D	7.9	180	230	8	165
EX-GDXL	7.9	200	300	7.9	302
ADO-25D	7.9	225	275	8	167
ADO-30D	7.9	265	315	8	169
EX-SUS-GDS	7.95	37	81	8	278
EX-GDR	7.95	75	119	8	298
EX-SUS-GDR	7.95	75	119	8	287
ADF-2D	8	34	75	8	344
ADFO-3D	8	34	75	8	359
ED-DS	8	34	78	8	245
ADFLS-2D	8	34	130	8	356
ADFLS-2D	8	34	130	8	356
EX-GDS	8	37	81	8	291
EX-SUS-GDS	8	37	81	8	278
NEXUS-GDS	8	37	81	8	271
VPH-GDS	8	37	81	8	259
VP-HO-GDS	8	37	81	8	265

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-H-DRL	8	40	80	8	319
ADO-3D	8	40	94	8	150
ADO-SUS-3D	8	40	94	8	174
ADO-TRS-3D	8	40	94	8	182
AD-2D	8	41	79	8	138
WH70-DRL	8	50	94	8	212
AD-4D	8	53	91	8	141
D-GDN	8	56	96	8	243
NF-GDN	8	56	96	8	203
V-MT-GDN	8	56	136	MT1	316
ADO-5D	8	64	118	8	154
ADO-SUS-5D	8	64	118	8	177
ADO-TRS-5D	8	64	118	8	184
WH55-5D	8	64	118	8	210
WHO55-5D	8	64	118	8	211
V-SDR	8	75	117	8	321
EX-GDR	8	75	119	8	298
EX-HO-GDR	8	75	119	8	305
EX-SUS-GDR	8	75	119	8	287
NEXUS-GDR	8	75	119	8	272
VP-GDR	8	75	119	8	261
VP-HO-GDR	8	75	119	8	268
EX-MT-GDR	8	75	155	MT1	307
MT-SUS-GDR	8	75	155	MT1	289
ADO-8D	8	88	140	8	158
ADO-SUS-8D	8	88	140	8	181
ADO-10D	8	105	155	8	161
TDXL	8 × 10D	105	155	8	310
TRS-HO-10D	8	105	155	8	190
EX-GDXL	8	115	200	8	302
VP-GDXL	8	115	200	8	270

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
TDXL	8 × 15D	144	215	8	312
ADO-15D	8	145	195	8	163
CAO-GDXL	8 × 15D	145	195	8	205
EX-GDXL	8	160	250	8	302
ADO-20D	8	180	230	8	165
CAO-GDXL	8 × 20D	180	230	8	206
FTO-H-GDXL	8 × 20D	180	230	8	218
TDXL	8 × 20D	184	255	8	314
EX-GDXL	8	200	300	8	302
ADO-25D	8	225	275	8	167
ADO-30D	8	265	315	8	169
CAO-GDXL	8 × 30D	265	315	8	207
ADO-40D	8	344	394	8	170
ADO-50D	8	424	474	8	171
ADF-2D	8.03	38	80	8	344
ADFO-3D	8.03	38	80	10	359
ADO-PLT	8.03	40	90	8	172
EX-SUS-GDS	8.05	37	87	10	278
EX-GDR	8.05	75	125	10	298
EX-SUS-GDR	8.05	75	125	10	287
VP-HO-GDS	8.1	37	87	9	265
EX-GDS	8.1	37	87	10	291
EX-SUS-GDS	8.1	37	87	10	278
NEXUS-GDS	8.1	37	87	10	271
VPH-GDS	8.1	37	87	10	259
ADF-2D	8.1	38	80	8	344
ADFO-3D	8.1	38	80	10	359
ADO-3D	8.1-9	41	101	9	150
ADO-SUS-3D	8.1-9	41	101	9	174
ADO-3D	8.1	41	101	10	150
ADO-SUS-3D	8.1	41	101	10	174

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-TRS-3D	8.1	41	101	10	182
AD-2D	8.1-9	47	89	9	138
AD-2D	8.1	47	89	10	138
WH70-DRL	8.1	50	101	9	212
NF-GDN	8.1	56	101	9	203
AD-4D	8.1-9	61	103	9	141
AD-4D	8.1	61	103	10	141
ADO-5D	8.1-9	65	128	9	154
ADO-SUS-5D	8.1-9	65	128	9	177
ADO-5D	8.1	65	128	10	154
ADO-SUS-5D	8.1	65	128	10	177
ADO-TRS-5D	8.1	65	128	10	184
V-SDR	8.1	75	117	8.1	321
EX-HO-GDR	8.1	75	125	9	305
EX-GDR	8.1	75	125	10	298
EX-SUS-GDR	8.1	75	125	10	287
VP-GDR	8.1	75	125	10	261
ADO-8D	8.1-9	89	150	9	158
ADO-SUS-8D	8.1-9	89	150	9	181
ADO-8D	8.1	89	150	10	158
ADO-SUS-8D	8.1	89	150	10	181
TDXL	8.1 × 10D	110	165	8.1	310
ADO-10D	8.1-9	110	165	9	161
ADO-10D	8.1	110	165	10	161
EX-GDXL	8.1	115	200	8.1	302
TDXL	8.1 × 15D	146	215	8.1	312
ADO-15D	8.1-9	155	210	9	163
ADO-15D	8.1	155	210	10	163
EX-GDXL	8.1	160	250	8.1	302
TDXL	8.1 × 20D	188	255	8.1	314
ADO-20D	8.1-9	195	260	9	165

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-20D	8.1	195	260	10	165
EX-GDXL	8.1	200	300	8.1	302
ADO-25D	8.1-9	240	305	9	167
ADO-25D	8.1	240	305	10	167
ADO-30D	8.1-9	280	350	9	169
ADO-30D	8.1	280	350	10	169
EX-SUS-GDS	8.15	37	87	10	278
EX-GDR	8.15	75	125	10	298
EX-SUS-GDR	8.15	75	125	10	287
VP-HO-GDS	8.2	37	87	9	265
EX-GDS	8.2	37	87	10	291
EX-SUS-GDS	8.2	37	87	10	278
NEXUS-GDS	8.2	37	87	10	271
VPH-GDS	8.2	37	87	10	259
ADF-2D	8.2	38	80	8	344
ADFO-3D	8.2	38	80	10	359
ADO-3D	8.2-9	41	101	9	150
ADO-SUS-3D	8.2-9	41	101	9	174
ADO-3D	8.2	41	101	10	150
ADO-SUS-3D	8.2	41	101	10	174
ADO-TRS-3D	8.2	41	101	10	182
AD-2D	8.2-9	47	89	9	138
AD-2D	8.2	47	89	10	138
WH70-DRL	8.2	50	101	9	212
NF-GDN	8.2	56	101	9	203
AD-4D	8.2-9	61	103	9	141
AD-4D	8.2	61	103	10	141
ADO-5D	8.2-9	66	128	9	154
ADO-SUS-5D	8.2-9	66	128	9	177
ADO-5D	8.2	66	128	10	154
ADO-SUS-5D	8.2	66	128	10	177

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-TRS-5D	8.2	66	128	10	184
V-SDR	8.2	75	117	8.2	321
EX-HO-GDR	8.2	75	125	9	305
EX-GDR	8.2	75	125	10	298
EX-SUS-GDR	8.2	75	125	10	287
VP-GDR	8.2	75	125	10	261
ADO-8D	8.2-9	90	150	9	158
ADO-SUS-8D	8.2-9	90	150	9	181
ADO-8D	8.2	90	150	10	158
ADO-SUS-8D	8.2	90	150	10	181
TDXL	8.2 X 10D	110	165	8.2	310
ADO-10D	8.2-9	110	165	9	161
ADO-10D	8.2	110	165	10	161
EX-GDXL	8.2	115	200	8.2	302
TDXL	8.2 X 15D	148	220	8.2	312
ADO-15D	8.2-9	155	210	9	163
ADO-15D	8.2	155	210	10	163
EX-GDXL	8.2	160	250	8.2	302
TDXL	8.2 X 20D	190	260	8.2	314
ADO-20D	8.2-9	195	260	9	165
ADO-20D	8.2	195	260	10	165
EX-GDXL	8.2	200	300	8.2	302
ADO-25D	8.2-9	240	305	9	167
ADO-25D	8.2	240	305	10	167
ADO-30D	8.2-9	280	350	9	169
ADO-30D	8.2	280	350	10	169
EX-SUS-GDS	8.25	37	87	10	278
ADO-3D	8.25-9	42	101	9	150
ADO-SUS-3D	8.25-9	42	101	9	174
ADO-5D	8.25-9	66	128	9	154
ADO-SUS-5D	8.25-9	66	128	9	177

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDR	8.25	75	125	10	298
EX-SUS-GDR	8.25	75	125	10	287
VP-HO-GDS	8.3	37	87	9	265
EX-GDS	8.3	37	87	10	291
EX-SUS-GDS	8.3	37	87	10	278
NEXUS-GDS	8.3	37	87	10	271
VPH-GDS	8.3	37	87	10	259
ADF-2D	8.3	38	80	8	344
ADFO-3D	8.3	38	80	10	359
ADO-3D	8.3-9	42	101	9	150
ADO-SUS-3D	8.3-9	42	101	9	174
ADO-3D	8.3	42	101	10	150
ADO-SUS-3D	8.3	42	101	10	174
ADO-TRS-3D	8.3	42	101	10	182
AD-2D	8.3-9	47	89	9	138
AD-2D	8.3	47	89	10	138
WH70-DRL	8.3	50	101	9	212
NF-GDN	8.3	56	101	9	203
AD-4D	8.3-9	61	103	9	141
AD-4D	8.3	61	103	10	141
ADO-5D	8.3-9	67	128	9	154
ADO-SUS-5D	8.3-9	67	128	9	177
ADO-5D	8.3	67	128	10	154
ADO-SUS-5D	8.3	67	128	10	177
ADO-TRS-5D	8.3	67	128	10	184
V-SDR	8.3	75	117	8.3	321
EX-HO-GDR	8.3	75	125	9	305
EX-GDR	8.3	75	125	10	298
EX-SUS-GDR	8.3	75	125	10	287
VP-GDR	8.3	75	125	10	261
ADO-8D	8.3-9	91	150	9	158

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-8D	8.3-9	91	150	9	181
ADO-8D	8.3	91	150	10	158
ADO-SUS-8D	8.3	91	150	10	181
TDXL	8.3 X 10D	110	165	8.3	310
ADO-10D	8.3-9	110	165	9	161
ADO-10D	8.3	110	165	10	161
EX-GDXL	8.3	115	200	8.3	302
ADO-15D	8.3-9	155	210	9	163
ADO-15D	8.3	155	210	10	163
EX-GDXL	8.3	160	250	8.3	302
ADO-20D	8.3-9	195	260	9	165
ADO-20D	8.3	195	260	10	165
EX-GDXL	8.3	200	300	8.3	302
ADO-25D	8.3-9	240	305	9	167
ADO-25D	8.3	240	305	10	167
ADO-30D	8.3-9	280	350	9	169
ADO-30D	8.3	280	350	10	169
EX-GDS	8.35	37	87	10	291
EX-SUS-GDS	8.35	37	87	10	278
EX-GDR	8.35	75	125	10	298
EX-SUS-GDR	8.35	75	125	10	287
VP-HO-GDS	8.4	37	87	9	265
EX-GDS	8.4	37	87	10	291
EX-SUS-GDS	8.4	37	87	10	278
NEXUS-GDS	8.4	37	87	10	271
VPH-GDS	8.4	37	87	10	259
ADF-2D	8.4	38	80	8	344
ADFO-3D	8.4	38	80	10	359
ADO-3D	8.4-9	42	101	9	150
ADO-SUS-3D	8.4-9	42	101	9	174
ADO-3D	8.4	42	101	10	150

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	8.4	42	101	10	174
ADO-TRS-3D	8.4	42	101	10	182
AD-2D	8.4-9	47	89	9	138
AD-2D	8.4	47	89	10	138
WH70-DRL	8.4	50	101	9	212
NF-GDN	8.4	56	101	9	203
AD-4D	8.4-9	61	103	9	141
AD-4D	8.4	61	103	10	141
ADO-5D	8.4-9	68	128	9	154
ADO-SUS-5D	8.4-9	68	128	9	177
ADO-5D	8.4	68	128	10	154
ADO-SUS-5D	8.4	68	128	10	177
ADO-TRS-5D	8.4	68	128	10	184
V-SDR	8.4	75	117	8.4	321
EX-HO-GDR	8.4	75	125	9	305
EX-GDR	8.4	75	125	10	298
EX-SUS-GDR	8.4	75	125	10	287
VP-GDR	8.4	75	125	10	261
ADO-8D	8.4-9	92	150	9	158
ADO-SUS-8D	8.4-9	92	150	9	181
ADO-8D	8.4	92	150	10	158
ADO-SUS-8D	8.4	92	150	10	181
TDXL	8.4 X 10D	110	165	8.4	310
ADO-10D	8.4-9	110	165	9	161
ADO-10D	8.4	110	165	10	161
EX-GDXL	8.4	115	200	8.4	302
ADO-15D	8.4-9	155	210	9	163
ADO-15D	8.4	155	210	10	163
EX-GDXL	8.4	160	250	8.4	302
ADO-20D	8.4-9	195	260	9	165
ADO-20D	8.4	195	260	10	165

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	8.4	200	300	8.4	302
ADO-25D	8.4-9	240	305	9	167
ADO-25D	8.4	240	305	10	167
ADO-30D	8.4-9	280	350	9	169
ADO-30D	8.4	280	350	10	169
EX-SUS-GDS	8.45	37	87	10	278
EX-GDR	8.45	75	125	10	298
EX-SUS-GDR	8.45	75	125	10	287
ED-DS	8.5	34	84	10	245
VP-HO-GDS	8.5	37	87	9	265
EX-GDS	8.5	37	87	10	291
EX-SUS-GDS	8.5	37	87	10	278
NEXUS-GDS	8.5	37	87	10	271
VPH-GDS	8.5	37	87	10	259
EX-LS-GDS	8.5	37	120	8.5	293
EX-LS-GDS	8.5	37	150	8.5	293
EX-LS-GDS	8.5	37	200	8.5	293
EX-LS-GDS	8.5	37	250	8.5	293
ADF-2D	8.5	38	80	8	344
ADFO-3D	8.5	38	80	10	359
ADFLS-2D	8.5	38	140	8	356
ADO-3D	8.5-9	43	101	9	150
ADO-SUS-3D	8.5-9	43	101	9	174
ADO-3D	8.5	43	101	10	150
ADO-SUS-3D	8.5	43	101	10	174
ADO-TRS-3D	8.5	43	101	10	182
AD-2D	8.5-9	47	89	9	138
AD-2D	8.5	47	89	10	138
WH70-DRL	8.5	50	101	9	212
D-GDN	8.5	56	96	9	243
NF-GDN	8.5	56	101	9	203

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
V-MT-GDN	8.5	56	139	MT1	316
AD-4D	8.5-9	61	103	9	142
AD-4D	8.5	61	103	10	142
ADO-5D	8.5-9	68	128	9	154
ADO-SUS-5D	8.5-9	68	128	9	177
ADO-5D	8.5	68	128	10	154
ADO-SUS-5D	8.5	68	128	10	177
ADO-TRS-5D	8.5	68	128	10	184
WH55-5D	8.5	68	128	10	210
WHO55-5D	8.5	68	128	10	211
V-SDR	8.5	75	117	8.5	321
EX-HO-GDR	8.5	75	125	9	305
VP-HO-GDR	8.5	75	125	9	268
EX-GDR	8.5	75	125	10	298
EX-SUS-GDR	8.5	75	125	10	287
NEXUS-GDR	8.5	75	125	10	272
VP-GDR	8.5	75	125	10	262
EX-MT-GDR	8.5	75	158	MT1	307
MT-SUS-GDR	8.5	75	158	MT1	289
ADO-8D	8.5-9	94	150	9	158
ADO-SUS-8D	8.5-9	94	150	9	181
ADO-8D	8.5	94	150	10	158
ADO-SUS-8D	8.5	94	150	10	181
TDXL	8.5 X 10D	110	165	8.5	310
ADO-10D	8.5-9	110	165	9	161
TRS-HO-10D	8.5	110	165	9	190
ADO-10D	8.5	110	165	10	161
EX-GDXL	8.5	115	200	8.5	302
VP-GDXL	8.5	115	200	8.5	270
TDXL	8.5 X 15D	154	225	8.5	313
ADO-15D	8.5-9	155	210	9	163

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-15D	8.5	155	210	10	163
EX-GDXL	8.5	160	250	8.5	302
ADO-20D	8.5-9	195	260	9	165
ADO-20D	8.5	195	260	10	165
TDXL	8.5 X 20D	196	265	8.5	315
EX-GDXL	8.5	200	300	8.5	302
ADO-25D	8.5-9	240	305	9	167
ADO-25D	8.5	240	305	10	167
ADO-30D	8.5-9	280	350	9	169
ADO-30D	8.5	280	350	10	169
ADF-2D	8.53	38	80	8	344
ADFO-3D	8.53	38	80	10	359
ADO-PLT	8.53-9	43	95	9	172
EX-GDS	8.55	40	90	10	291
EX-SUS-GDS	8.55	40	90	10	278
EX-GDR	8.55	81	131	10	298
EX-SUS-GDR	8.55	81	131	10	287
WHO55-5D	8.58	70	128	10	211
ADF-2D	8.6	38	80	8	344
ADFO-3D	8.6	38	80	10	359
ADFLS-2D	8.6	38	140	8	356
VP-HO-GDS	8.6	40	90	9	265
EX-GDS	8.6	40	90	10	291
EX-SUS-GDS	8.6	40	90	10	278
NEXUS-GDS	8.6	40	90	10	271
VPH-GDS	8.6	40	90	10	259
ADO-3D	8.6-9	43	101	9	150
ADO-SUS-3D	8.6-9	43	101	9	174
ADO-3D	8.6	43	101	10	150
ADO-SUS-3D	8.6	43	101	10	174
ADO-TRS-3D	8.6	43	101	10	182

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	8.6-9	47	89	9	138
AD-2D	8.6	47	89	10	138
WH70-DRL	8.6	57	101	9	212
NF-GDN	8.6	61	101	9	203
AD-4D	8.6-9	61	103	9	142
AD-4D	8.6	61	103	10	142
ADO-5D	8.6-9	69	128	9	154
ADO-SUS-5D	8.6-9	69	128	9	177
ADO-5D	8.6	69	128	10	154
ADO-SUS-5D	8.6	69	128	10	177
ADO-TRS-5D	8.6	69	128	10	184
V-SDR	8.6	81	125	8.6	321
EX-HO-GDR	8.6	81	131	9	305
VP-HO-GDR	8.6	81	131	9	268
EX-GDR	8.6	81	131	10	298
EX-SUS-GDR	8.6	81	131	10	287
NEXUS-GDR	8.6	81	131	10	272
VP-GDR	8.6	81	131	10	262
ADO-8D	8.6-9	95	150	9	158
ADO-SUS-8D	8.6-9	95	150	9	181
ADO-8D	8.6	95	150	10	158
ADO-SUS-8D	8.6	95	150	10	181
TDXL	8.6 X 10D	115	165	8.6	310
ADO-10D	8.6-9	115	165	9	161
ADO-10D	8.6	115	165	10	161
EX-GDXL	8.6	115	200	8.6	302
TDXL	8.6 X 15D	156	225	8.6	313
ADO-15D	8.6-9	160	210	9	163
ADO-15D	8.6	160	210	10	163
EX-GDXL	8.6	160	250	8.6	302
EX-GDXL	8.6	200	300	8.6	302

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-20D	8.6-9	210	260	9	165
ADO-20D	8.6	210	260	10	165
ADO-25D	8.6-9	255	305	9	167
ADO-25D	8.6	255	305	10	167
ADO-30D	8.6-9	300	350	9	169
ADO-30D	8.6	300	350	10	169
EX-GDS	8.65	40	90	10	291
EX-SUS-GDS	8.65	40	90	10	278
EX-GDR	8.65	81	131	10	298
EX-SUS-GDR	8.65	81	131	10	287
ADF-2D	8.7	38	80	8	344
ADFO-3D	8.7	38	80	10	359
VP-HO-GDS	8.7	40	90	9	265
EX-GDS	8.7	40	90	10	291
EX-SUS-GDS	8.7	40	90	10	278
NEXUS-GDS	8.7	40	90	10	271
VPH-GDS	8.7	40	90	10	259
ADO-3D	8.7-9	44	101	9	150
ADO-SUS-3D	8.7-9	44	101	9	174
ADO-3D	8.7	44	101	10	150
ADO-SUS-3D	8.7	44	101	10	174
ADO-TRS-3D	8.7	44	101	10	182
AD-2D	8.7-9	47	89	9	138
AD-2D	8.7	47	89	10	138
WH70-DRL	8.7	57	101	9	212
NF-GDN	8.7	61	101	9	203
AD-4D	8.7-9	61	103	9	142
AD-4D	8.7	61	103	10	142
ADO-5D	8.7-9	70	128	9	154
ADO-SUS-5D	8.7-9	70	128	9	177
ADO-5D	8.7	70	128	10	154

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	8.7	70	128	10	177
ADO-TRS-5D	8.7	70	128	10	184
WH55-5D	8.7	70	128	10	210
WHO55-5D	8.7	70	128	10	211
V-SDR	8.7	81	125	8.7	321
EX-HO-GDR	8.7	81	131	9	305
EX-GDR	8.7	81	131	10	298
EX-SUS-GDR	8.7	81	131	10	287
VP-GDR	8.7	81	131	10	262
ADO-8D	8.7-9	96	150	9	158
ADO-SUS-8D	8.7-9	96	150	9	181
ADO-8D	8.7	96	150	10	158
ADO-SUS-8D	8.7	96	150	10	181
TDXL	8.7 X 10D	115	165	8.7	311
ADO-10D	8.7-9	115	165	9	161
ADO-10D	8.7	115	165	10	161
EX-GDXL	8.7	115	200	8.7	302
ADO-15D	8.7-9	160	210	9	163
ADO-15D	8.7	160	210	10	163
EX-GDXL	8.7	160	250	8.7	302
EX-GDXL	8.7	200	300	8.7	302
ADO-20D	8.7-9	210	260	9	165
ADO-20D	8.7	210	260	10	165
ADO-25D	8.7	225	305	10	167
ADO-25D	8.7-9	255	305	9	167
ADO-30D	8.7-9	300	350	9	169
ADO-30D	8.7	300	350	10	169
EX-SUS-GDS	8.75	40	90	10	278
ADO-3D	8.75-9	44	101	9	150
ADO-SUS-3D	8.75-9	44	101	9	174
ADO-5D	8.75-9	70	128	9	154

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	8.75-9	70	128	9	177
EX-GDR	8.75	81	131	10	298
EX-SUS-GDR	8.75	81	131	10	287
ADF-2D	8.8	38	80	8	344
ADFO-3D	8.8	38	80	10	359
ADFLS-2D	8.8	38	140	8	356
VP-HO-GDS	8.8	40	90	9	265
EX-GDS	8.8	40	90	10	291
EX-SUS-GDS	8.8	40	90	10	278
NEXUS-GDS	8.8	40	90	10	271
VPH-GDS	8.8	40	90	10	259
EX-LS-GDS	8.8	41	120	8.8	293
EX-LS-GDS	8.8	41	150	8.8	293
EX-LS-GDS	8.8	41	200	8.8	293
EX-LS-GDS	8.8	41	250	8.8	293
ADO-3D	8.8-9	44	101	9	150
ADO-SUS-3D	8.8-9	44	101	9	174
ADO-3D	8.8	44	101	10	150
ADO-SUS-3D	8.8	44	101	10	174
ADO-TRS-3D	8.8	44	101	10	182
AD-2D	8.8-9	47	89	9	138
AD-2D	8.8	47	89	10	138
WH70-DRL	8.8	57	101	9	212
NF-GDN	8.8	61	101	9	203
AD-4D	8.8-9	61	103	9	142
AD-4D	8.8	61	103	10	142
V-MT-GDN	8.8	61	144	MT1	316
ADO-5D	8.8-9	71	128	9	154
ADO-SUS-5D	8.8-9	71	128	9	177
ADO-5D	8.8	71	128	10	154
ADO-SUS-5D	8.8	71	128	10	177

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-TRS-5D	8.8	71	128	10	184
WH55-5D	8.8	72	128	10	210
WHO55-5D	8.8	72	128	10	211
V-SDR	8.8	81	125	8.8	321
EX-HO-GDR	8.8	81	131	9	305
EX-GDR	8.8	81	131	10	298
EX-SUS-GDR	8.8	81	131	10	287
NEXUS-GDR	8.8	81	131	10	272
VP-GDR	8.8	81	131	10	262
EX-MT-GDR	8.8	81	164	MT1	307
ADO-8D	8.8-9	97	150	9	158
ADO-SUS-8D	8.8-9	97	150	9	181
ADO-8D	8.8	97	150	10	158
ADO-SUS-8D	8.8	97	150	10	181
TDXL	8.8 X 10D	115	165	8.8	311
ADO-10D	8.8-9	115	165	9	161
ADO-10D	8.8	115	165	10	161
EX-GDXL	8.8	115	200	8.8	302
ADO-15D	8.8-9	160	210	9	163
ADO-15D	8.8	160	210	10	163
TDXL	8.8 X 15D	160	230	8.8	313
EX-GDXL	8.8	160	250	8.8	302
EX-GDXL	8.8	200	300	8.8	302
ADO-20D	8.8-9	210	260	9	165
ADO-20D	8.8	210	260	10	165
ADO-25D	8.8-9	255	305	9	167
ADO-25D	8.8	255	305	10	167
ADO-30D	8.8-9	300	350	9	169
ADO-30D	8.8	300	350	10	169
EX-SUS-GDS	8.85	40	90	10	278
EX-GDR	8.85	81	131	10	298

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	8.85	81	131	10	287
ADF-2D	8.9	38	80	8	344
ADFO-3D	8.9	38	80	10	359
VP-HO-GDS	8.9	40	90	9	265
EX-GDS	8.9	40	90	10	291
EX-SUS-GDS	8.9	40	90	10	278
VPH-GDS	8.9	40	90	10	259
ADO-3D	8.9-9	45	101	9	150
ADO-SUS-3D	8.9-9	45	101	9	174
ADO-3D	8.9	45	101	10	150
ADO-SUS-3D	8.9	45	101	10	174
ADO-TRS-3D	8.9	45	101	10	182
AD-2D	8.9-9	47	89	9	138
AD-2D	8.9	47	89	10	138
WH70-DRL	8.9	57	101	9	212
NF-GDN	8.9	61	101	9	203
AD-4D	8.9-9	61	103	9	142
AD-4D	8.9	61	103	10	142
ADO-5D	8.9-9	72	128	9	154
ADO-SUS-5D	8.9-9	72	128	9	177
ADO-5D	8.9	72	128	10	154
ADO-SUS-5D	8.9	72	128	10	177
ADO-TRS-5D	8.9	72	128	10	184
V-SDR	8.9	81	125	8.9	321
EX-HO-GDR	8.9	81	131	9	305
EX-GDR	8.9	81	131	10	298
EX-SUS-GDR	8.9	81	131	10	287
VP-GDR	8.9	81	131	10	262
ADO-8D	8.9-9	98	150	9	158
ADO-SUS-8D	8.9-9	98	150	9	181
ADO-8D	8.9	98	150	10	158

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-8D	8.9	98	150	10	181
TDXL	8.9 X 10D	115	165	8.9	311
ADO-10D	8.9-9	115	165	9	161
ADO-10D	8.9	115	165	10	161
EX-GDXL	8.9	115	200	8.9	302
ADO-15D	8.9-9	160	210	9	163
ADO-15D	8.9	160	210	10	163
EX-GDXL	8.9	160	250	8.9	302
EX-GDXL	8.9	200	300	8.9	302
ADO-20D	8.9-9	210	260	9	165
ADO-20D	8.9	210	260	10	165
ADO-25D	8.9-9	255	305	9	167
ADO-25D	8.9	255	305	10	167
ADO-30D	8.9-9	300	350	9	169
ADO-30D	8.9	300	350	10	169
EX-SUS-GDS	8.95	40	90	10	278
EX-GDR	8.95	81	131	10	298
EX-SUS-GDR	8.95	81	131	10	287
ED-DS	9	37	87	10	245
ADF-2D	9	38	80	8	344
ADFO-3D	9	38	80	10	359
ADFLS-2D	9	38	140	8	356
VP-HO-GDS	9	40	90	9	265
EX-GDS	9	40	90	10	291
EX-SUS-GDS	9	40	90	10	278
NEXUS-GDS	9	40	90	10	271
VPH-GDS	9	40	90	10	259
EX-H-DRL	9	45	100	10	319
ADO-3D	9-9	45	101	9	150
ADO-SUS-3D	9-9	45	101	9	174
ADO-3D	9	45	101	10	150

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	9	45	101	10	174
ADO-TRS-3D	9	45	101	10	182
AD-2D	9-9	47	89	9	138
AD-2D	9	47	89	10	138
WH70-DRL	9	57	101	9	212
D-GDN	9	61	101	9	243
NF-GDN	9	61	101	9	203
AD-4D	9-9	61	103	9	142
AD-4D	9	61	103	10	142
V-MT-GDN	9	61	144	MT1	316
ADO-5D	9-9	72	128	9	154
ADO-SUS-5D	9-9	72	128	9	177
ADO-5D	9	72	128	10	154
ADO-SUS-5D	9	72	128	10	177
ADO-TRS-5D	9	72	128	10	184
WH55-5D	9	72	128	10	210
WHO55-5D	9	72	128	10	211
V-SDR	9	81	125	9	321
EX-HO-GDR	9	81	131	9	305
VP-HO-GDR	9	81	131	9	268
EX-GDR	9	81	131	10	298
EX-SUS-GDR	9	81	131	10	287
NEXUS-GDR	9	81	131	10	272
VP-GDR	9	81	131	10	262
EX-MT-GDR	9	81	164	MT1	307
MT-SUS-GDR	9	81	164	MT1	289
ADO-8D	9-9	99	150	9	158
ADO-SUS-8D	9-9	99	150	9	181
ADO-8D	9	99	150	10	158
ADO-SUS-8D	9	99	150	10	181
ADO-10D	9-9	115	165	9	161

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
TDXL	9 × 10D	115	165	9	311
TRS-HO-10D	9	115	165	9	190
ADO-10D	9	115	165	10	161
EX-GDXL	9	115	200	9	302
VP-GDXL	9	115	200	9	270
ADO-15D	9-9	160	210	9	163
CAO-GDXL	9 × 15D	160	210	9	205
ADO-15D	9	160	210	10	163
EX-GDXL	9	160	250	9	302
TDXL	9 × 15D	162	230	9	313
EX-GDXL	9	200	300	9	302
TDXL	9 × 20D	208	275	9	315
ADO-20D	9-9	210	260	9	165
CAO-GDXL	9 × 20D	210	260	9	206
ADO-20D	9	210	260	10	165
ADO-25D	9-9	255	305	9	167
ADO-25D	9	255	305	10	167
ADO-30D	9-9	300	350	9	169
ADO-30D	9	300	350	10	169
ADFO-3D	9.03	38	80	10	359
ADF-2D	9.03	42	85	8	344
ADO-PLT	9.03-9	45	95	9	172
EX-SUS-GDS	9.05	40	90	10	278
EX-GDR	9.05	81	131	10	298
EX-SUS-GDR	9.05	81	131	10	287
EX-GDS	9.1	40	90	10	291
EX-SUS-GDS	9.1	40	90	10	278
VPH-GDS	9.1	40	90	10	259
VP-HO-GDS	9.1	40	90	10	265
ADF-2D	9.1	42	85	8	344
ADFO-3D	9.1	42	85	10	359

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	9.1	46	106	10	150
ADO-SUS-3D	9.1	46	106	10	174
ADO-TRS-3D	9.1	46	106	10	182
AD-2D	9.1	47	89	10	138
WH70-DRL	9.1	57	106	10	212
AD-4D	9.1	61	103	10	142
NF-GDN	9.1	61	109	10	203
ADO-5D	9.1	73	136	10	154
ADO-SUS-5D	9.1	73	136	10	177
ADO-TRS-5D	9.1	73	136	10	184
V-SDR	9.1	81	125	9.1	321
EX-GDR	9.1	81	131	10	298
EX-HO-GDR	9.1	81	131	10	305
EX-SUS-GDR	9.1	81	131	10	287
VP-GDR	9.1	81	131	10	262
ADO-8D	9.1	100	160	10	158
ADO-SUS-8D	9.1	100	160	10	181
EX-GDXL	9.1	115	200	9.1	303
TDXL	9.1 × 10D	125	190	9.1	311
ADO-10D	9.1	125	190	10	161
EX-GDXL	9.1	160	250	9.1	303
ADO-15D	9.1	170	240	10	163
EX-GDXL	9.1	200	300	9.1	303
ADO-20D	9.1	220	290	10	165
ADO-25D	9.1	270	340	10	167
ADO-30D	9.1	315	390	10	169
EX-SUS-GDS	9.15	40	90	10	278
EX-GDR	9.15	81	131	10	298
EX-SUS-GDR	9.15	81	131	10	287
NEXUS-GDS	9.18	40	90	10	271
EX-GDS	9.2	40	90	10	291

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	9.2	40	90	10	278
NEXUS-GDS	9.2	40	90	10	271
VPH-GDS	9.2	40	90	10	259
VP-HO-GDS	9.2	40	90	10	265
ADF-2D	9.2	42	85	8	344
ADFO-3D	9.2	42	85	10	359
ADFLS-2D	9.2	42	150	8	356
ADO-3D	9.2	46	106	10	150
ADO-SUS-3D	9.2	46	106	10	174
ADO-TRS-3D	9.2	46	106	10	182
AD-2D	9.2	47	89	10	138
WH70-DRL	9.2	57	106	10	212
AD-4D	9.2	61	103	10	142
NF-GDN	9.2	61	109	10	203
ADO-5D	9.2	74	136	10	154
ADO-SUS-5D	9.2	74	136	10	177
ADO-TRS-5D	9.2	74	136	10	184
V-SDR	9.2	81	125	9.2	321
EX-GDR	9.2	81	131	10	298
EX-HO-GDR	9.2	81	131	10	305
EX-SUS-GDR	9.2	81	131	10	287
VP-GDR	9.2	81	131	10	262
ADO-8D	9.2	101	160	10	158
ADO-SUS-8D	9.2	101	160	10	181
EX-GDXL	9.2	115	200	9.2	303
TDXL	9.2 × 10D	125	190	9.2	311
ADO-10D	9.2	125	190	10	161
EX-GDXL	9.2	160	250	9.2	303
ADO-15D	9.2	170	240	10	163
EX-GDXL	9.2	200	300	9.2	303
ADO-20D	9.2	220	290	10	165

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-25D	9.2	270	340	10	167
ADO-30D	9.2	315	390	10	169
NEXUS-GDS	9.24	40	90	10	271
AD-2D	9.24	47	89	10	138
NF-GDN	9.24	61	109	10	203
ADO-5D	9.24	74	136	10	154
ADO-SUS-5D	9.24	74	136	10	177
EX-SUS-GDR	9.24	81	131	10	287
VP-GDR	9.24	81	131	10	262
EX-GDS	9.25	40	90	10	291
EX-SUS-GDS	9.25	40	90	10	278
ADO-3D	9.25	47	106	10	150
ADO-SUS-3D	9.25	47	106	10	174
ADO-TRS-3D	9.25	47	106	10	182
ADO-5D	9.25	74	136	10	154
ADO-SUS-5D	9.25	74	136	10	177
ADO-TRS-5D	9.25	74	136	10	184
EX-GDR	9.25	81	131	10	298
EX-SUS-GDR	9.25	81	131	10	287
AD-2D	9.26	47	89	10	138
NF-GDN	9.26	61	109	10	203
ADO-5D	9.26	75	136	10	154
ADO-SUS-5D	9.26	75	136	10	177
EX-SUS-GDR	9.26	81	131	10	287
VP-GDR	9.26	81	131	10	262
EX-GDS	9.3	40	90	10	291
EX-SUS-GDS	9.3	40	90	10	278
VPH-GDS	9.3	40	90	10	259
VP-HO-GDS	9.3	40	90	10	265
ADF-2D	9.3	42	85	8	344
ADFO-3D	9.3	42	85	10	359

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	9.3	47	89	10	139
ADO-3D	9.3	47	106	10	150
ADO-SUS-3D	9.3	47	106	10	174
ADO-TRS-3D	9.3	47	106	10	182
WH70-DRL	9.3	57	106	10	212
AD-4D	9.3	61	103	10	142
NF-GDN	9.3	61	109	10	203
ADO-5D	9.3	75	136	10	154
ADO-SUS-5D	9.3	75	136	10	177
ADO-TRS-5D	9.3	75	136	10	184
V-SDR	9.3	81	125	9.3	321
EX-GDR	9.3	81	131	10	298
EX-HO-GDR	9.3	81	131	10	305
EX-SUS-GDR	9.3	81	131	10	287
VP-GDR	9.3	81	131	10	262
ADO-8D	9.3	102	160	10	158
ADO-SUS-8D	9.3	102	160	10	181
EX-GDXL	9.3	115	200	9.3	303
TDXL	9.3 × 10D	125	190	9.3	311
ADO-10D	9.3	125	190	10	161
EX-GDXL	9.3	160	250	9.3	303
TDXL	9.3 × 15D	168	240	9.3	313
ADO-15D	9.3	170	240	10	163
EX-GDXL	9.3	200	300	9.3	303
ADO-20D	9.3	220	290	10	165
ADO-25D	9.3	270	340	10	167
ADO-30D	9.3	315	390	10	169
NEXUS-GDS	9.34	40	90	10	271
EX-SUS-GDR	9.34	81	131	10	287
EX-GDS	9.35	40	90	10	291
EX-SUS-GDS	9.35	40	90	10	278

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDR	9.35	81	131	10	298
EX-SUS-GDR	9.35	81	131	10	287
NEXUS-GDS	9.36	40	90	10	271
AD-2D	9.36	47	89	10	139
NF-GDN	9.36	61	109	10	203
ADO-5D	9.36	75	136	10	154
ADO-SUS-5D	9.36	75	136	10	177
EX-SUS-GDR	9.36	81	131	10	287
VP-GDR	9.36	81	131	10	262
AD-2D	9.38	47	89	10	139
ADO-TRS-3D	9.38	47	106	10	182
NF-GDN	9.38	61	109	10	203
ADO-5D	9.38	76	136	10	154
ADO-SUS-5D	9.38	76	136	10	177
ADO-TRS-5D	9.38	76	136	10	184
VP-GDR	9.38	81	131	10	262
EX-GDS	9.4	40	90	10	291
EX-SUS-GDS	9.4	40	90	10	278
VPH-GDS	9.4	40	90	10	259
VP-HO-GDS	9.4	40	90	10	265
ADF-2D	9.4	42	85	8	344
ADFO-3D	9.4	42	85	10	359
AD-2D	9.4	47	89	10	139
ADO-3D	9.4	47	106	10	150
ADO-SUS-3D	9.4	47	106	10	174
ADO-TRS-3D	9.4	47	106	10	182
WH70-DRL	9.4	57	106	10	212
AD-4D	9.4	61	103	10	142
NF-GDN	9.4	61	109	10	203
ADO-5D	9.4	76	136	10	154
ADO-SUS-5D	9.4	76	136	10	177

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-TRS-5D	9.4	76	136	10	184
V-SDR	9.4	81	125	9.4	321
EX-GDR	9.4	81	131	10	298
EX-HO-GDR	9.4	81	131	10	305
EX-SUS-GDR	9.4	81	131	10	287
VP-GDR	9.4	81	131	10	262
ADO-8D	9.4	103	160	10	158
ADO-SUS-8D	9.4	103	160	10	181
EX-GDXL	9.4	115	200	9.4	303
TDXL	9.4 X 10D	125	190	9.4	311
ADO-10D	9.4	125	190	10	161
EX-GDXL	9.4	160	250	9.4	303
ADO-15D	9.4	170	240	10	163
EX-GDXL	9.4	200	300	9.4	303
ADO-20D	9.4	220	290	10	165
ADO-25D	9.4	270	340	10	167
ADO-30D	9.4	315	390	10	169
EX-GDS	9.45	40	90	10	291
EX-SUS-GDS	9.45	40	90	10	278
EX-GDR	9.45	81	131	10	298
EX-SUS-GDR	9.45	81	131	10	287
ED-DS	9.5	37	87	10	245
EX-GDS	9.5	40	90	10	291
EX-SUS-GDS	9.5	40	90	10	278
NEXUS-GDS	9.5	40	90	10	271
VPH-GDS	9.5	40	90	10	259
VP-HO-GDS	9.5	40	90	10	265
ADF-2D	9.5	42	85	8	344
ADFO-3D	9.5	42	85	10	359
ADFLS-2D	9.5	42	150	8	356
AD-2D	9.5	47	89	10	139

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	9.5	48	106	10	150
ADO-SUS-3D	9.5	48	106	10	174
ADO-TRS-3D	9.5	48	106	10	182
WH70-DRL	9.5	57	106	10	212
AD-4D	9.5	61	103	10	142
D-GDN	9.5	61	105	10	243
NF-GDN	9.5	61	109	10	203
V-MT-GDN	9.5	61	144	MT1	316
ADO-5D	9.5	76	136	10	154
ADO-SUS-5D	9.5	76	136	10	177
ADO-TRS-5D	9.5	76	136	10	184
WH55-5D	9.5	76	136	10	210
WHO55-5D	9.5	76	136	10	211
V-SDR	9.5	81	125	9.5	321
EX-GDR	9.5	81	131	10	298
EX-HO-GDR	9.5	81	131	10	305
EX-SUS-GDR	9.5	81	131	10	287
VP-GDR	9.5	81	131	10	262
VP-HO-GDR	9.5	81	131	10	268
EX-MT-GDR	9.5	81	164	MT1	307
MT-SUS-GDR	9.5	81	164	MT1	289
ADO-8D	9.5	105	160	10	158
ADO-SUS-8D	9.5	105	160	10	181
EX-GDXL	9.5	115	200	9.5	303
VP-GDXL	9.5	115	200	9.5	270
TDXL	9.5 X 10D	125	190	9.5	311
ADO-10D	9.5	125	190	10	161
TRS-HO-10D	9.5	125	190	10	190
EX-GDXL	9.5	160	250	9.5	303
ADO-15D	9.5	170	240	10	163
TDXL	9.5 X 15D	172	240	9.5	313

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	9.5	200	300	9.5	303
ADO-20D	9.5	220	290	10	165
ADO-25D	9.5	270	340	10	167
ADO-30D	9.5	315	390	10	169
AD-2D	9.52	47	89	10	139
NF-GDN	9.52	65	109	10	203
ADO-5D	9.52	77	136	10	154
ADO-SUS-5D	9.52	77	136	10	177
EX-SUS-GDR	9.52	87	137	10	287
VP-GDR	9.52	87	137	10	262
AD-2D	9.54	47	89	10	139
NF-GDN	9.54	65	109	10	203
ADO-5D	9.54	77	136	10	154
ADO-SUS-5D	9.54	77	136	10	177
VP-GDR	9.54	87	137	10	262
EX-GDS	9.55	43	93	10	291
EX-SUS-GDS	9.55	43	93	10	278
ADO-SUS-3D	9.55	48	106	10	174
D-DAD	9.550	57	115	9.55	249
D-GDN90	9.550	57	115	9.55	251
D-STAD	9.550	76	126	9.55	248
EX-GDR	9.55	87	137	10	298
EX-SUS-GDR	9.55	87	137	10	287
ADF-2D	9.6	42	85	8	344
ADFO-3D	9.6	42	85	10	359
EX-GDS	9.6	43	93	10	291
EX-SUS-GDS	9.6	43	93	10	278
VPH-GDS	9.6	43	93	10	259
VP-HO-GDS	9.6	43	93	10	265
AD-2D	9.6	47	89	10	139
ADO-3D	9.6	48	106	10	150
ADO-SUS-3D	9.6	48	106	10	174
ADO-TRS-3D	9.6	48	106	10	182
AD-4D	9.6	61	103	10	142
WH70-DRL	9.6	63	106	10	212
NF-GDN	9.6	65	109	10	203
ADO-5D	9.6	77	136	10	154
ADO-SUS-5D	9.6	77	136	10	177
ADO-TRS-5D	9.6	77	136	10	184
V-SDR	9.6	87	133	9.6	321
EX-GDR	9.6	87	137	10	298
EX-HO-GDR	9.6	87	137	10	305
EX-SUS-GDR	9.6	87	137	10	287
VP-GDR	9.6	87	137	10	262
ADO-8D	9.6	106	160	10	158
ADO-SUS-8D	9.6	106	160	10	181
EX-GDXL	9.6	115	200	9.6	303
TDXL	9.6 X 10D	130	190	9.6	311
ADO-10D	9.6	130	190	10	161
EX-GDXL	9.6	160	250	9.6	303
ADO-15D	9.6	180	240	10	163
EX-GDXL	9.6	200	300	9.6	303
ADO-20D	9.6	230	290	10	165
ADO-25D	9.6	280	340	10	167
ADO-30D	9.6	330	390	10	169
EX-GDS	9.65	43	93	10	291
EX-SUS-GDS	9.65	43	93	10	278
EX-GDR	9.65	87	137	10	298
EX-SUS-GDR	9.65	87	137	10	287
ADF-2D	9.7	42	85	8	344
ADFO-3D	9.7	42	85	10	359
EX-GDS	9.7	43	93	10	291
EX-SUS-GDS	9.7	43	93	10	279
VPH-GDS	9.7	43	93	10	259
VP-HO-GDS	9.7	43	93	10	265
AD-2D	9.7	47	89	10	139
ADO-3D	9.7	49	106	10	150
ADO-SUS-3D	9.7	49	106	10	174
ADO-TRS-3D	9.7	49	106	10	182
AD-4D	9.7	61	103	10	142
WH70-DRL	9.7	63	106	10	212
NF-GDN	9.7	65	109	10	203
ADO-5D	9.7	78	136	10	154
ADO-SUS-5D	9.7	78	136	10	177
ADO-TRS-5D	9.7	78	136	10	184
V-SDR	9.7	87	133	9.7	321
EX-GDR	9.7	87	137	10	298
EX-HO-GDR	9.7	87	137	10	305
EX-SUS-GDR	9.7	87	137	10	287
VP-GDR	9.7	87	137	10	262
ADO-8D	9.7	107	160	10	158
ADO-SUS-8D	9.7	107	160	10	181
EX-GDXL	9.7	115	200	9.7	303
TDXL	9.7 X 10D	130	190	9.7	311
ADO-10D	9.7	130	190	10	161
EX-GDXL	9.7	160	250	9.7	303
TDXL	9.7 X 15D	176	245	9.7	313
ADO-15D	9.7	180	240	10	163
EX-GDXL	9.7	200	300	9.7	303
ADO-20D	9.7	230	290	10	165
ADO-25D	9.7	280	340	10	167
ADO-30D	9.7	330	390	10	169
EX-SUS-GDS	9.75	43	93	10	279

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	9.75	49	106	10	150
ADO-SUS-3D	9.75	49	106	10	174
ADO-5D	9.75	78	136	10	154
ADO-SUS-5D	9.75	78	136	10	177
EX-GDR	9.75	87	137	10	298
EX-SUS-GDR	9.75	87	137	10	287
ADF-2D	9.8	42	85	8	344
ADFO-3D	9.8	42	85	10	359
ADFLS-2D	9.8	42	150	8	356
EX-GDS	9.8	43	93	10	291
EX-SUS-GDS	9.8	43	93	10	279
NEXUS-GDS	9.8	43	93	10	271
VPH-GDS	9.8	43	93	10	259
VP-HO-GDS	9.8	43	93	10	265
AD-2D	9.8	47	89	10	139
ADO-3D	9.8	49	106	10	150
ADO-SUS-3D	9.8	49	106	10	174
ADO-TRS-3D	9.8	49	106	10	182
AD-4D	9.8	61	103	10	142
WH70-DRL	9.8	63	106	10	212
NF-GDN	9.8	65	109	10	203
ADO-5D	9.8	79	136	10	154
ADO-SUS-5D	9.8	79	136	10	177
ADO-TRS-5D	9.8	79	136	10	184
WH55-5D	9.8	80	136	10	210
WHO55-5D	9.8	80	136	10	211
V-SDR	9.8	87	133	9.8	321
EX-GDR	9.8	87	137	10	298
EX-HO-GDR	9.8	87	137	10	305
EX-SUS-GDR	9.8	87	137	10	287
VP-GDR	9.8	87	137	10	262

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-8D	9.8	108	160	10	158
ADO-SUS-8D	9.8	108	160	10	181
EX-GDXL	9.8	115	200	9.8	303
TDXL	9.8 X 10D	130	190	9.8	311
ADO-10D	9.8	130	190	10	161
EX-GDXL	9.8	160	250	9.8	303
TDXL	9.8 X 15D	178	245	9.8	313
ADO-15D	9.8	180	240	10	163
EX-GDXL	9.8	200	300	9.8	303
ADO-20D	9.8	230	290	10	165
ADO-25D	9.8	280	340	10	167
ADO-30D	9.8	330	390	10	169
EX-SUS-GDS	9.85	43	93	10	279
EX-GDR	9.85	87	137	10	298
EX-SUS-GDR	9.85	87	137	10	287
ADF-2D	9.9	42	85	8	344
ADFO-3D	9.9	42	85	10	359
EX-GDS	9.9	43	93	10	291
EX-SUS-GDS	9.9	43	93	10	279
VPH-GDS	9.9	43	93	10	259
VP-HO-GDS	9.9	43	93	10	265
AD-2D	9.9	47	89	10	139
ADO-3D	9.9	50	106	10	150
ADO-SUS-3D	9.9	50	106	10	174
ADO-TRS-3D	9.9	50	106	10	182
AD-4D	9.9	61	103	10	142
WH70-DRL	9.9	63	106	10	212
NF-GDN	9.9	65	109	10	203
ADO-5D	9.9	80	136	10	154
ADO-SUS-5D	9.9	80	136	10	177
ADO-TRS-5D	9.9	80	136	10	184

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
V-SDR	9.9	87	133	9.9	321
EX-GDR	9.9	87	137	10	298
EX-HO-GDR	9.9	87	137	10	305
EX-SUS-GDR	9.9	87	137	10	287
VP-GDR	9.9	87	137	10	262
ADO-8D	9.9	109	160	10	158
ADO-SUS-8D	9.9	109	160	10	181
EX-GDXL	9.9	115	200	9.9	303
TDXL	9.9 X 10D	130	190	9.9	311
ADO-10D	9.9	130	190	10	161
EX-GDXL	9.9	160	250	9.9	303
ADO-15D	9.9	180	240	10	163
EX-GDXL	9.9	200	300	9.9	303
ADO-20D	9.9	230	290	10	165
ADO-25D	9.9	280	340	10	167
ADO-30D	9.9	330	390	10	169
EX-GDS	9.95	43	93	10	291
EX-SUS-GDS	9.95	43	93	10	279
EX-GDR	9.95	87	137	10	298
EX-SUS-GDR	9.95	87	137	10	287
WHO55-5D	9.97	80	136	10	211
ED-DS	10	40	90	10	245
ADF-2D	10	42	85	10	344
ADFO-3D	10	42	85	10	359
ADFLS-2D	10	42	150	10	356
ADFLS-2D	10	42	150	10	356
EX-GDS	10	43	93	10	291
EX-SUS-GDS	10	43	93	10	279
NEXUS-GDS	10	43	93	10	271
VPH-GDS	10	43	93	10	259
VP-HO-GDS	10	43	93	10	265

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	10	47	89	10	139
EX-H-DRL	10	50	100	10	319
ADO-3D	10	50	106	10	150
ADO-SUS-3D	10	50	106	10	174
ADO-TRS-3D	10	50	106	10	182
AD-4D	10	61	103	10	142
WH70-DRL	10	63	106	10	213
D-GDN	10	65	109	10	243
NF-GDN	10	65	109	10	203
V-MT-GDN	10	65	148	MT1	316
ADO-5D	10	80	136	10	154
ADO-SUS-5D	10	80	136	10	178
ADO-TRS-5D	10	80	136	10	184
WH55-5D	10	80	136	10	210
WHO55-5D	10	80	136	10	211
V-SDR	10	87	133	10	321
EX-GDR	10	87	137	10	298
EX-HO-GDR	10	87	137	10	305
EX-SUS-GDR	10	87	137	10	287
NEXUS-GDR	10	87	137	10	272
VP-GDR	10	87	137	10	262
VP-HO-GDR	10	87	137	10	269
EX-MT-GDR	10	87	170	MT1	307
MT-SUS-GDR	10	87	170	MT1	289
ADO-8D	10	110	160	10	158
ADO-SUS-8D	10	110	160	10	181
EX-GDXL	10	120	200	10	303
VP-GDXL	10	120	200	10	270
ADO-10D	10	130	190	10	161
TDXL	10 × 10D	130	190	10	311
TRS-HO-10D	10	130	190	10	190

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	10	160	250	10	303
ADO-15D	10	180	240	10	163
CAO-GDXL	10 × 15D	180	240	10	205
TDXL	10 × 15D	180	250	10	313
EX-GDXL	10	200	300	10	303
ADO-20D	10	230	290	10	165
CAO-GDXL	10 × 20D	230	290	10	206
FTO-H-GDXL	10 × 20D	230	290	10	218
TDXL	10 × 20D	230	300	10	315
ADO-25D	10	280	340	10	167
ADO-30D	10	330	390	10	169
ADO-40D	10	430	490	10	170
ADF-2D	10.03	46	90	10	344
ADFO-3D	10.03	46	90	12	359
ADO-PLT	10.03	50	100	10	172
EX-SUS-GDS	10.05	43	100	12	279
EX-GDR	10.05	87	144	12	298
EX-SUS-GDR	10.05	87	144	12	287
VP-HO-GDS	10.1	43	100	11	265
EX-GDS	10.1	43	100	12	291
EX-SUS-GDS	10.1	43	100	12	279
VPH-GDS	10.1	43	100	12	259
ADF-2D	10.1	46	90	10	344
ADFO-3D	10.1	46	90	12	359
ADO-3D	10.1-11	51	113	11	150
ADO-SUS-3D	10.1-11	51	113	11	174
ADO-3D	10.1	51	113	12	150
ADO-SUS-3D	10.1	51	113	12	174
ADO-TRS-3D	10.1	51	113	12	183
AD-2D	10.1-11	55	102	11	139
AD-2D	10.1	55	102	12	139

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WH70-DRL	10.1	63	113	11	213
NF-GDN	10.1	65	115	11	203
AD-4D	10.1-11	71	118	11	142
AD-4D	10.1	71	118	12	142
ADO-5D	10.1-11	81	146	11	154
ADO-SUS-5D	10.1-11	81	146	11	178
ADO-5D	10.1	81	146	12	154
ADO-SUS-5D	10.1	81	146	12	178
ADO-TRS-5D	10.1	81	146	12	185
V-SDR	10.1	87	133	10.1	321
EX-HO-GDR	10.1	87	144	11	305
EX-GDR	10.1	87	144	12	298
EX-SUS-GDR	10.1	87	144	12	287
VP-GDR	10.1	87	144	12	262
ADO-8D	10.1-11	111	182	11	158
ADO-SUS-8D	10.1-11	111	182	11	181
ADO-8D	10.1	111	182	12	158
ADO-SUS-8D	10.1	111	182	12	181
EX-GDXL	10.1	120	200	10.1	303
TDXL	10.1 × 10D	140	205	10.1	311
ADO-10D	10.1-11	140	205	11	161
ADO-10D	10.1	140	205	12	161
EX-GDXL	10.1	160	250	10.1	303
ADO-15D	10.1-11	190	260	11	163
ADO-15D	10.1	190	260	12	163
EX-GDXL	10.1	200	300	10.1	303
ADO-20D	10.1-11	250	310	11	165
ADO-20D	10.1	250	310	12	165
ADO-25D	10.1-11	310	370	11	167
ADO-25D	10.1	310	370	12	167
EX-SUS-GDS	10.15	43	100	12	279

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDR	10.15	87	144	12	298
EX-SUS-GDR	10.15	87	144	12	287
VP-HO-GDS	10.2	43	100	11	265
EX-GDS	10.2	43	100	12	291
EX-SUS-GDS	10.2	43	100	12	279
NEXUS-GDS	10.2	43	100	12	271
VPH-GDS	10.2	43	100	12	259
ADF-2D	10.2	46	90	10	344
ADFO-3D	10.2	46	90	12	359
ADO-3D	10.2-11	51	113	11	150
ADO-SUS-3D	10.2-11	51	113	11	174
ADO-3D	10.2	51	113	12	150
ADO-SUS-3D	10.2	51	113	12	174
ADO-TRS-3D	10.2	51	113	12	183
AD-2D	10.2-11	55	102	11	139
AD-2D	10.2	55	102	12	139
WH70-DRL	10.2	63	113	11	213
NF-GDN	10.2	65	115	11	203
AD-4D	10.2-11	71	118	11	142
AD-4D	10.2	71	118	12	142
ADO-5D	10.2-11	82	146	11	154
ADO-SUS-5D	10.2-11	82	146	11	178
ADO-5D	10.2	82	146	12	155
ADO-SUS-5D	10.2	82	146	12	178
ADO-TRS-5D	10.2	82	146	12	185
V-SDR	10.2	87	133	10.2	321
EX-HO-GDR	10.2	87	144	11	305
EX-GDR	10.2	87	144	12	298
EX-SUS-GDR	10.2	87	144	12	287
VP-GDR	10.2	87	144	12	262
ADO-8D	10.2-11	112	182	11	158

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-8D	10.2-11	112	182	11	181
ADO-8D	10.2	112	182	12	158
ADO-SUS-8D	10.2	112	182	12	181
EX-GDXL	10.2	120	200	10.2	303
TDXL	10.2 × 10D	140	205	10.2	311
ADO-10D	10.2-11	140	205	11	161
ADO-10D	10.2	140	205	12	161
EX-GDXL	10.2	160	250	10.2	303
ADO-15D	10.2-11	190	260	11	163
ADO-15D	10.2	190	260	12	163
EX-GDXL	10.2	200	300	10.2	303
ADO-20D	10.2-11	250	310	11	165
ADO-20D	10.2	250	310	12	165
ADO-25D	10.2-11	310	370	11	167
ADO-25D	10.2	310	370	12	167
EX-GDS	10.25	43	100	12	291
EX-SUS-GDS	10.25	43	100	12	279
ADO-3D	10.25-11	52	113	11	150
ADO-SUS-3D	10.25-11	52	113	11	174
ADO-5D	10.25-11	82	146	11	155
ADO-SUS-5D	10.25-11	82	146	11	178
EX-GDR	10.25	87	144	12	298
EX-SUS-GDR	10.25	87	144	12	287
VP-HO-GDS	10.3	43	100	11	265
EX-GDS	10.3	43	100	12	291
EX-SUS-GDS	10.3	43	100	12	279
NEXUS-GDS	10.3	43	100	12	271
VPH-GDS	10.3	43	100	12	259
EX-LS-GDS	10.3	43	120	10.3	293
EX-LS-GDS	10.3	43	150	10.3	293
EX-LS-GDS	10.3	43	200	10.3	293

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-LS-GDS	10.3	43	250	10.3	293
ADF-2D	10.3	46	90	10	344
ADFO-3D	10.3	46	90	12	359
ADFLS-2D	10.3	46	160	10	356
ADO-3D	10.3-11	52	113	11	150
ADO-SUS-3D	10.3-11	52	113	11	174
ADO-3D	10.3	52	113	12	150
ADO-SUS-3D	10.3	52	113	12	174
ADO-TRS-3D	10.3	52	113	12	183
AD-2D	10.3-11	55	102	11	139
AD-2D	10.3	55	102	12	139
WH70-DRL	10.3	63	113	11	213
D-GDN	10.3	65	109	11	243
NF-GDN	10.3	65	115	11	203
V-MT-GDN	10.3	65	148	MT1	316
AD-4D	10.3-11	71	118	11	142
AD-4D	10.3	71	118	12	142
ADO-5D	10.3-11	83	146	11	155
ADO-SUS-5D	10.3-11	83	146	11	178
ADO-5D	10.3	83	146	12	155
ADO-SUS-5D	10.3	83	146	12	178
ADO-TRS-5D	10.3	83	146	12	185
WH55-5D	10.3	84	146	12	210
WHO55-5D	10.3	84	146	12	211
V-SDR	10.3	87	133	10.3	321
EX-HO-GDR	10.3	87	144	11	305
VP-HO-GDR	10.3	87	144	11	269
EX-GDR	10.3	87	144	12	298
EX-SUS-GDR	10.3	87	144	12	287
NEXUS-GDR	10.3	87	144	12	272
VP-GDR	10.3	87	144	12	262

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-GDR	10.3	87	170	MT1	307
MT-SUS-GDR	10.3	87	170	MT1	289
ADO-8D	10.3-11	113	182	11	158
ADO-SUS-8D	10.3-11	113	182	11	181
ADO-8D	10.3	113	182	12	158
ADO-SUS-8D	10.3	113	182	12	181
EX-GDXL	10.3	120	200	10.3	303
TDXL	10.3 X 10D	140	205	10.3	311
ADO-10D	10.3-11	140	205	11	161
ADO-10D	10.3	140	205	12	161
EX-GDXL	10.3	160	250	10.3	303
ADO-15D	10.3-11	190	260	11	163
ADO-15D	10.3	190	260	12	163
EX-GDXL	10.3	200	300	10.3	303
ADO-20D	10.3-11	250	310	11	165
ADO-20D	10.3	250	310	12	165
ADO-25D	10.3-11	310	370	11	167
ADO-25D	10.3	310	370	12	167
EX-GDS	10.35	43	100	12	291
EX-SUS-GDS	10.35	43	100	12	279
EX-GDR	10.35	87	144	12	298
EX-SUS-GDR	10.35	87	144	12	287
VP-HO-GDS	10.4	43	100	11	265
EX-GDS	10.4	43	100	12	291
EX-SUS-GDS	10.4	43	100	12	279
NEXUS-GDS	10.4	43	100	12	271
VPH-GDS	10.4	43	100	12	259
ADF-2D	10.4	46	90	10	344
ADFO-3D	10.4	46	90	12	359
ADFLS-2D	10.4	46	160	10	356
ADO-3D	10.4-11	52	113	11	150

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	10.4-11	52	113	11	174
ADO-3D	10.4	52	113	12	150
ADO-SUS-3D	10.4	52	113	12	174
ADO-TRS-3D	10.4	52	113	12	183
AD-2D	10.4-11	55	102	11	139
AD-2D	10.4	55	102	12	139
WH70-DRL	10.4	63	113	11	213
NF-GDN	10.4	65	115	11	203
AD-4D	10.4-11	71	118	11	142
AD-4D	10.4	71	118	12	142
ADO-5D	10.4-11	84	146	11	155
ADO-SUS-5D	10.4-11	84	146	11	178
ADO-5D	10.4	84	146	12	155
ADO-SUS-5D	10.4	84	146	12	178
ADO-TRS-5D	10.4	84	146	12	185
V-SDR	10.4	87	133	10.4	322
EX-HO-GDR	10.4	87	144	11	305
EX-GDR	10.4	87	144	12	298
EX-SUS-GDR	10.4	87	144	12	287
NEXUS-GDR	10.4	87	144	12	272
VP-GDR	10.4	87	144	12	262
ADO-8D	10.4-11	114	182	11	158
ADO-SUS-8D	10.4-11	114	182	11	181
ADO-8D	10.4	114	182	12	158
ADO-SUS-8D	10.4	114	182	12	181
EX-GDXL	10.4	120	200	10.4	303
TDXL	10.4 X 10D	140	205	10.4	311
ADO-10D	10.4-11	140	205	11	161
ADO-10D	10.4	140	205	12	161
EX-GDXL	10.4	160	250	10.4	303
ADO-15D	10.4-11	190	260	11	163

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-15D	10.4	190	260	12	163
EX-GDXL	10.4	200	300	10.4	303
ADO-20D	10.4-11	250	310	11	165
ADO-20D	10.4	250	310	12	165
ADO-25D	10.4-11	310	370	11	167
ADO-25D	10.4	310	370	12	167
EX-SUS-GDS	10.45	43	100	12	279
EX-GDR	10.45	87	144	12	298
EX-SUS-GDR	10.45	87	144	12	287
ED-DS	10.5	40	97	12	245
VP-HO-GDS	10.5	43	100	11	265
EX-GDS	10.5	43	100	12	291
EX-SUS-GDS	10.5	43	100	12	279
NEXUS-GDS	10.5	43	100	12	271
VPH-GDS	10.5	43	100	12	259
EX-LS-GDS	10.5	43	120	10.5	293
EX-LS-GDS	10.5	43	150	10.5	293
EX-LS-GDS	10.5	43	200	10.5	293
EX-LS-GDS	10.5	43	250	10.5	293
ADF-2D	10.5	46	90	10	344
ADFO-3D	10.5	46	90	12	359
ADFLS-2D	10.5	46	160	10	356
ADO-3D	10.5-11	53	113	11	151
ADO-SUS-3D	10.5-11	53	113	11	174
ADO-3D	10.5	53	113	12	151
ADO-SUS-3D	10.5	53	113	12	174
ADO-TRS-3D	10.5	53	113	12	183
AD-2D	10.5-11	55	102	11	139
AD-2D	10.5	55	102	12	139
WH70-DRL	10.5	63	113	11	213
D-GDN	10.5	65	109	11	243

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
NF-GDN	10.5	65	115	11	203
V-MT-GDN	10.5	65	148	MT1	316
AD-4D	10.5-11	71	118	11	142
AD-4D	10.5	71	118	12	142
ADO-5D	10.5-11	84	146	11	155
ADO-SUS-5D	10.5-11	84	146	11	178
ADO-5D	10.5	84	146	12	155
ADO-SUS-5D	10.5	84	146	12	178
ADO-TRS-5D	10.5	84	146	12	185
WH55-5D	10.5	84	146	12	210
WHO55-5D	10.5	84	146	12	211
V-SDR	10.5	87	133	10.5	322
EX-HO-GDR	10.5	87	144	11	305
VP-HO-GDR	10.5	87	144	11	269
EX-GDR	10.5	87	144	12	298
EX-SUS-GDR	10.5	87	144	12	287
NEXUS-GDR	10.5	87	144	12	272
VP-GDR	10.5	87	144	12	262
EX-MT-GDR	10.5	87	170	MT1	307
MT-SUS-GDR	10.5	87	170	MT1	289
ADO-8D	10.5-11	116	182	11	158
ADO-SUS-8D	10.5-11	116	182	11	181
ADO-8D	10.5	116	182	12	158
ADO-SUS-8D	10.5	116	182	12	181
EX-GDXL	10.5	120	200	10.5	303
TDXL	10.5 × 10D	140	205	10.5	311
ADO-10D	10.5-11	140	205	11	161
TRS-HO-10D	10.5	140	205	11	190
ADO-10D	10.5	140	205	12	161
EX-GDXL	10.5	160	250	10.5	303
ADO-15D	10.5-11	190	260	11	163

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-15D	10.5	190	260	12	163
TDXL	10.5 × 15D	190	270	10.5	313
EX-GDXL	10.5	200	300	10.5	303
ADO-20D	10.5-11	250	310	11	165
ADO-20D	10.5	250	310	12	165
ADO-25D	10.5-11	310	370	11	167
ADO-25D	10.5	310	370	12	167
EX-GDS	10.55	43	100	12	291
EX-SUS-GDS	10.55	43	100	12	279
EX-GDR	10.55	87	144	12	298
EX-SUS-GDR	10.55	87	144	12	287
VP-HO-GDS	10.6	43	100	11	266
EX-GDS	10.6	43	100	12	291
EX-SUS-GDS	10.6	43	100	12	279
VPH-GDS	10.6	43	100	12	259
ADF-2D	10.6	46	90	10	344
ADFO-3D	10.6	46	90	12	359
ADO-3D	10.6-11	53	113	11	151
ADO-SUS-3D	10.6-11	53	113	11	174
ADO-3D	10.6	53	113	12	151
ADO-SUS-3D	10.6	53	113	12	174
ADO-TRS-3D	10.6	53	113	12	183
AD-2D	10.6-11	55	102	11	139
AD-2D	10.6	55	102	12	139
WH70-DRL	10.6	63	113	11	213
NF-GDN	10.6	65	115	11	203
AD-4D	10.6-11	71	118	11	142
AD-4D	10.6	71	118	12	142
ADO-5D	10.6-11	85	146	11	155
ADO-SUS-5D	10.6-11	85	146	11	178
ADO-5D	10.6	85	146	12	155

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	10.6	85	146	12	178
ADO-TRS-5D	10.6	85	146	12	185
V-SDR	10.6	87	133	10.6	322
EX-HO-GDR	10.6	87	144	11	305
EX-GDR	10.6	87	144	12	298
EX-SUS-GDR	10.6	87	144	12	287
VP-GDR	10.6	87	144	12	262
ADO-8D	10.6-11	117	182	11	158
ADO-SUS-8D	10.6-11	117	182	11	181
ADO-8D	10.6	117	182	12	158
ADO-SUS-8D	10.6	117	182	12	181
EX-GDXL	10.6	120	200	10.6	303
ADO-10D	10.6-11	140	205	11	161
ADO-10D	10.6	140	205	12	161
TDXL	10.6 × 10D	145	205	10.6	311
EX-GDXL	10.6	160	250	10.6	303
ADO-15D	10.6-11	190	260	11	163
ADO-15D	10.6	190	260	12	163
EX-GDXL	10.6	200	300	10.6	303
ADO-20D	10.6-11	250	310	11	165
ADO-20D	10.6	250	310	12	165
ADO-25D	10.6-11	310	370	11	167
ADO-25D	10.6	310	370	12	167
EX-GDS	10.65	47	104	12	291
EX-SUS-GDS	10.65	47	104	12	279
EX-GDR	10.65	94	151	12	298
EX-SUS-GDR	10.65	94	151	12	287
ADF-2D	10.7	46	90	10	344
ADFO-3D	10.7	46	90	12	359
VP-HO-GDS	10.7	47	104	11	266
EX-GDS	10.7	47	104	12	291

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	10.7	47	104	12	279
VPH-GDS	10.7	47	104	12	259
ADO-3D	10.7-11	54	113	11	151
ADO-SUS-3D	10.7-11	54	113	11	174
ADO-3D	10.7	54	113	12	151
ADO-SUS-3D	10.7	54	113	12	174
ADO-TRS-3D	10.7	54	113	12	183
AD-2D	10.7-11	55	102	11	139
AD-2D	10.7	55	102	12	139
WH70-DRL	10.7	71	113	11	213
NF-GDN	10.7	71	115	11	203
AD-4D	10.7-11	71	118	11	142
AD-4D	10.7	71	118	12	142
ADO-5D	10.7-11	86	146	11	155
ADO-SUS-5D	10.7-11	86	146	11	178
ADO-5D	10.7	86	146	12	155
ADO-SUS-5D	10.7	86	146	12	178
ADO-TRS-5D	10.7	86	146	12	185
V-SDR	10.7	94	142	10.7	322
EX-HO-GDR	10.7	94	151	11	305
EX-GDR	10.7	94	151	12	298
EX-SUS-GDR	10.7	94	151	12	287
VP-GDR	10.7	94	151	12	262
ADO-8D	10.7-11	118	182	11	158
ADO-SUS-8D	10.7-11	118	182	11	181
ADO-8D	10.7	118	182	12	158
ADO-SUS-8D	10.7	118	182	12	181
EX-GDXL	10.7	120	200	10.7	303
ADO-10D	10.7-11	140	205	11	161
ADO-10D	10.7	140	205	12	161
TDXL	10.7 X 10D	145	205	10.7	311

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	10.7	160	250	10.7	303
ADO-15D	10.7-11	200	260	11	163
ADO-15D	10.7	200	260	12	163
EX-GDXL	10.7	200	300	10.7	303
ADO-20D	10.7-11	250	310	11	165
ADO-20D	10.7	250	310	12	165
ADO-25D	10.7-11	310	370	11	167
ADO-25D	10.7	310	370	12	167
EX-SUS-GDS	10.75	47	104	12	279
ADO-3D	10.75-11	54	113	11	151
ADO-SUS-3D	10.75-11	54	113	11	174
ADO-5D	10.75-11	86	146	11	155
ADO-SUS-5D	10.75-11	86	146	11	178
EX-GDR	10.75	94	151	12	298
EX-SUS-GDR	10.75	94	151	12	287
ADF-2D	10.8	46	90	10	344
ADFO-3D	10.8	46	90	12	359
ADFLS-2D	10.8	46	160	10	356
VP-HO-GDS	10.8	47	104	11	266
EX-GDS	10.8	47	104	12	291
EX-SUS-GDS	10.8	47	104	12	279
VPH-GDS	10.8	47	104	12	259
EX-LS-GDS	10.8	47	120	10.8	293
EX-LS-GDS	10.8	47	150	10.8	293
EX-LS-GDS	10.8	47	200	10.8	293
EX-LS-GDS	10.8	47	250	10.8	293
ADO-3D	10.8-11	54	113	11	151
ADO-SUS-3D	10.8-11	54	113	11	174
ADO-3D	10.8	54	113	12	151
ADO-SUS-3D	10.8	54	113	12	174
ADO-TRS-3D	10.8	54	113	12	183

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	10.8-11	55	102	11	139
AD-2D	10.8	55	102	12	139
WH70-DRL	10.8	71	113	11	213
NF-GDN	10.8	71	115	11	203
AD-4D	10.8-11	71	118	11	142
AD-4D	10.8	71	118	12	142
ADO-5D	10.8-11	87	146	11	155
ADO-SUS-5D	10.8-11	87	146	11	178
ADO-5D	10.8	87	146	12	155
ADO-SUS-5D	10.8	87	146	12	178
ADO-TRS-5D	10.8	87	146	12	185
WH55-5D	10.8	88	146	12	210
WHO55-5D	10.8	88	146	12	211
V-SDR	10.8	94	142	10.8	322
EX-HO-GDR	10.8	94	151	11	305
EX-GDR	10.8	94	151	12	298
EX-SUS-GDR	10.8	94	151	12	287
VP-GDR	10.8	94	151	12	262
ADO-8D	10.8-11	119	182	11	158
ADO-SUS-8D	10.8-11	119	182	11	181
ADO-8D	10.8	119	182	12	158
ADO-SUS-8D	10.8	119	182	12	181
EX-GDXL	10.8	120	200	10.8	303
TDXL	10.8 X 10D	145	205	10.8	311
ADO-10D	10.8-11	145	205	11	161
ADO-10D	10.8	145	205	12	161
EX-GDXL	10.8	160	250	10.8	303
ADO-15D	10.8-11	200	260	11	163
ADO-15D	10.8	200	260	12	163
EX-GDXL	10.8	200	300	10.8	303
ADO-20D	10.8-11	250	310	11	165

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-20D	10.8	250	310	12	165
ADO-25D	10.8-11	310	370	11	167
ADO-25D	10.8	310	370	12	167
EX-SUS-GDS	10.85	47	104	12	279
EX-GDR	10.85	94	151	12	298
EX-SUS-GDR	10.85	94	151	12	287
ADF-2D	10.9	46	90	10	344
ADFO-3D	10.9	46	90	12	359
VP-HO-GDS	10.9	47	104	11	266
EX-GDS	10.9	47	104	12	291
EX-SUS-GDS	10.9	47	104	12	279
VPH-GDS	10.9	47	104	12	259
AD-2D	10.9-11	55	102	11	139
AD-2D	10.9	55	102	12	139
ADO-3D	10.9-11	55	113	11	151
ADO-SUS-3D	10.9-11	55	113	11	174
ADO-3D	10.9	55	113	12	151
ADO-SUS-3D	10.9	55	113	12	174
ADO-TRS-3D	10.9	55	113	12	183
WH70-DRL	10.9	71	113	11	213
NF-GDN	10.9	71	115	11	203
AD-4D	10.9-11	71	118	11	142
AD-4D	10.9	71	118	12	142
ADO-5D	10.9-11	88	146	11	155
ADO-SUS-5D	10.9-11	88	146	11	178
ADO-5D	10.9	88	146	12	155
ADO-SUS-5D	10.9	88	146	12	178
ADO-TRS-5D	10.9	88	146	12	185
V-SDR	10.9	94	142	10.9	322
EX-HO-GDR	10.9	94	151	11	305
EX-GDR	10.9	94	151	12	298

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	10.9	94	151	12	287
VP-GDR	10.9	94	151	12	262
ADO-8D	10.9-11	120	182	11	158
ADO-SUS-8D	10.9-11	120	182	11	181
ADO-8D	10.9	120	182	12	158
ADO-SUS-8D	10.9	120	182	12	181
EX-GDXL	10.9	120	200	10.9	303
TDXL	10.9 × 10D	145	205	10.9	311
ADO-10D	10.9-11	145	205	11	161
ADO-10D	10.9	145	205	12	161
EX-GDXL	10.9	160	250	10.9	303
ADO-15D	10.9-11	200	260	11	163
ADO-15D	10.9	200	260	12	163
EX-GDXL	10.9	200	300	10.9	303
ADO-20D	10.9-11	250	310	11	165
ADO-20D	10.9	250	310	12	165
ADO-25D	10.9-11	310	370	11	167
ADO-25D	10.9	310	370	12	167
EX-GDS	10.95	47	104	12	291
EX-SUS-GDS	10.95	47	104	12	279
EX-GDR	10.95	94	151	12	298
EX-SUS-GDR	10.95	94	151	12	287
ED-DS	11	40	97	12	245
ADF-2D	11	46	90	10	344
ADFO-3D	11	46	90	12	359
ADFLS-2D	11	46	160	10	356
VP-HO-GDS	11	47	104	11	266
EX-GDS	11	47	104	12	291
EX-SUS-GDS	11	47	104	12	279
NEXUS-GDS	11	47	104	12	271
VPH-GDS	11	47	104	12	259

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	11-11	55	102	11	139
AD-2D	11	55	102	12	139
EX-H-DRL	11	55	110	12	319
ADO-3D	11-11	55	113	11	151
ADO-SUS-3D	11-11	55	113	11	174
ADO-3D	11	55	113	12	151
ADO-SUS-3D	11	55	113	12	174
ADO-TRS-3D	11	55	113	12	183
WH70-DRL	11	71	113	11	213
D-GDN	11	71	115	11	244
NF-GDN	11	71	115	11	203
AD-4D	11-11	71	118	11	142
AD-4D	11	71	118	12	142
V-MT-GDN	11	71	154	MT1	316
ADO-5D	11-11	88	146	11	155
ADO-SUS-5D	11-11	88	146	11	178
ADO-5D	11	88	146	12	155
ADO-SUS-5D	11	88	146	12	178
ADO-TRS-5D	11	88	146	12	185
WH55-5D	11	88	146	12	210
WHO55-5D	11	88	146	12	211
V-SDR	11	94	142	11	322
EX-HO-GDR	11	94	151	11	305
VP-HO-GDR	11	94	151	11	269
EX-GDR	11	94	151	12	298
EX-SUS-GDR	11	94	151	12	287
NEXUS-GDR	11	94	151	12	272
VP-GDR	11	94	151	12	262
EX-MT-GDR	11	94	177	MT1	307
MT-SUS-GDR	11	94	177	MT1	289
EX-GDXL	11	120	200	11	303

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-8D	11-11	121	182	11	158
ADO-SUS-8D	11-11	121	182	11	181
ADO-8D	11	121	182	12	158
ADO-SUS-8D	11	121	182	12	181
ADO-10D	11-11	145	205	11	161
TDXL	11 X 10D	145	205	11	311
TRS-HO-10D	11	145	205	11	190
ADO-10D	11	145	205	12	161
EX-GDXL	11	160	250	11	303
ADO-15D	11-11	200	260	11	163
ADO-15D	11	200	260	12	163
TDXL	11 X 15D	200	280	11	313
EX-GDXL	11	200	300	11	303
ADO-20D	11-11	250	310	11	165
ADO-20D	11	250	310	12	165
TDXL	11 X 20D	254	350	11	315
ADO-25D	11-11	310	370	11	167
ADO-25D	11	310	370	12	167
ADFO-3D	11.03	46	90	12	359
ADF-2D	11.03	50	95	10	344
ADO-PLT	11.03-11	55	115	11	172
EX-SUS-GDS	11.05	47	104	12	279
EX-GDR	11.05	94	151	12	298
EX-SUS-GDR	11.05	94	151	12	287
EX-GDS	11.1	47	104	12	291
EX-SUS-GDS	11.1	47	104	12	279
VPH-GDS	11.1	47	104	12	259
VP-HO-GDS	11.1	47	104	12	266
ADF-2D	11.1	50	95	10	344
ADFO-3D	11.1	50	95	12	359
ADFLS-2D	11.1	50	170	10	356

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	11.1	55	102	12	139
ADO-3D	11.1	56	120	12	151
ADO-SUS-3D	11.1	56	120	12	174
ADO-TRS-3D	11.1	56	120	12	183
AD-4D	11.1	71	118	12	142
WH70-DRL	11.1	71	120	12	213
NF-GDN	11.1	71	126	12	203
ADO-5D	11.1	89	156	12	155
ADO-SUS-5D	11.1	89	156	12	178
ADO-TRS-5D	11.1	89	156	12	185
V-SDR	11.1	94	142	11.1	322
EX-GDR	11.1	94	151	12	298
EX-HO-GDR	11.1	94	151	12	305
EX-SUS-GDR	11.1	94	151	12	287
VP-GDR	11.1	94	151	12	262
EX-GDXL	11.1	120	200	11.1	303
ADO-8D	11.1	122	194	12	158
ADO-SUS-8D	11.1	122	194	12	181
TDXL	11.1 X 10D	155	215	11.1	311
ADO-10D	11.1	155	215	12	161
EX-GDXL	11.1	160	250	11.1	303
EX-GDXL	11.1	200	300	11.1	303
ADO-15D	11.1	210	280	12	163
ADO-20D	11.1	270	330	12	165
ADO-25D	11.1	340	400	12	167
EX-SUS-GDS	11.15	47	104	12	279
EX-GDR	11.15	94	151	12	298
EX-SUS-GDR	11.15	94	151	12	287
EX-GDS	11.2	47	104	12	291
EX-SUS-GDS	11.2	47	104	12	279
NEXUS-GDS	11.2	47	104	12	271

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	11.2	47	104	12	259
VP-HO-GDS	11.2	47	104	12	266
ADF-2D	11.2	50	95	10	344
ADFO-3D	11.2	50	95	12	359
AD-2D	11.2	55	102	12	139
ADO-3D	11.2	56	120	12	151
ADO-SUS-3D	11.2	56	120	12	174
ADO-TRS-3D	11.2	56	120	12	183
AD-4D	11.2	71	118	12	142
WH70-DRL	11.2	71	120	12	213
NF-GDN	11.2	71	126	12	203
ADO-5D	11.2	90	156	12	155
ADO-SUS-5D	11.2	90	156	12	178
ADO-TRS-5D	11.2	90	156	12	185
V-SDR	11.2	94	142	11.2	322
EX-GDR	11.2	94	151	12	298
EX-HO-GDR	11.2	94	151	12	305
EX-SUS-GDR	11.2	94	151	12	287
VP-GDR	11.2	94	151	12	262
EX-GDXL	11.2	120	200	11.2	303
ADO-8D	11.2	123	194	12	158
ADO-SUS-8D	11.2	123	194	12	181
TDXL	11.2 X 10D	155	215	11.2	311
ADO-10D	11.2	155	215	12	161
EX-GDXL	11.2	160	250	11.2	303
EX-GDXL	11.2	200	300	11.2	303
ADO-15D	11.2	210	280	12	163
ADO-20D	11.2	270	330	12	165
ADO-25D	11.2	340	400	12	167
AD-2D	11.22	55	102	12	139
NF-GDN	11.22	71	126	12	203

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-5D	11.22	90	156	12	155
ADO-SUS-5D	11.22	90	156	12	178
EX-SUS-GDR	11.22	94	151	12	287
VP-GDR	11.22	94	151	12	262
AD-2D	11.24	55	102	12	139
NF-GDN	11.24	71	126	12	203
ADO-5D	11.24	90	156	12	155
ADO-SUS-5D	11.24	90	156	12	178
EX-SUS-GDR	11.24	94	151	12	287
VP-GDR	11.24	94	151	12	262
EX-GDS	11.25	47	104	12	291
EX-SUS-GDS	11.25	47	104	12	279
ADO-TRS-3D	11.25	57	120	12	183
ADO-TRS-5D	11.25	90	156	12	185
EX-GDR	11.25	94	151	12	298
EX-SUS-GDR	11.25	94	151	12	287
EX-GDS	11.3	47	104	12	291
EX-SUS-GDS	11.3	47	104	12	279
VPH-GDS	11.3	47	104	12	259
VP-HO-GDS	11.3	47	104	12	266
ADF-2D	11.3	50	95	10	344
ADFO-3D	11.3	50	95	12	359
AD-2D	11.3	55	102	12	139
ADO-3D	11.3	57	120	12	151
ADO-SUS-3D	11.3	57	120	12	174
ADO-TRS-3D	11.3	57	120	12	183
AD-4D	11.3	71	118	12	142
WH70-DRL	11.3	71	120	12	213
NF-GDN	11.3	71	126	12	203
ADO-5D	11.3	91	156	12	155

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	11.3	91	156	12	178
ADO-TRS-5D	11.3	91	156	12	185
V-SDR	11.3	94	142	11.3	322
EX-GDR	11.3	94	151	12	298
EX-HO-GDR	11.3	94	151	12	305
EX-SUS-GDR	11.3	94	151	12	287
VP-GDR	11.3	94	151	12	262
EX-GDXL	11.3	120	200	11.3	303
ADO-8D	11.3	124	194	12	158
ADO-SUS-8D	11.3	124	194	12	181
TDXL	11.3 × 10D	155	215	11.3	311
ADO-10D	11.3	155	215	12	161
EX-GDXL	11.3	160	250	11.3	303
EX-GDXL	11.3	200	300	11.3	303
ADO-15D	11.3	210	280	12	163
ADO-20D	11.3	270	330	12	165
ADO-25D	11.3	340	400	12	167
EX-SUS-GDR	11.34	94	151	12	287
EX-GDS	11.35	47	104	12	291
EX-SUS-GDS	11.35	47	104	12	279
EX-GDR	11.35	94	151	12	298
EX-SUS-GDR	11.35	94	151	12	287
AD-2D	11.36	55	102	12	139
NF-GDN	11.36	71	126	12	203
ADO-5D	11.36	91	156	12	155
ADO-SUS-5D	11.36	91	156	12	178
EX-SUS-GDR	11.36	94	151	12	287
VP-GDR	11.36	94	151	12	262
AD-2D	11.38	55	102	12	139
ADO-TRS-3D	11.38	57	120	12	183

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
NF-GDN	11.38	71	126	12	203
ADO-5D	11.38	92	156	12	155
ADO-SUS-5D	11.38	92	156	12	178
ADO-TRS-5D	11.38	92	156	12	185
VP-GDR	11.38	94	151	12	262
EX-GDS	11.4	47	104	12	291
EX-SUS-GDS	11.4	47	104	12	279
VPH-GDS	11.4	47	104	12	259
VP-HO-GDS	11.4	47	104	12	266
ADF-2D	11.4	50	95	10	344
ADFO-3D	11.4	50	95	12	359
AD-2D	11.4	55	102	12	139
ADO-3D	11.4	57	120	12	151
ADO-SUS-3D	11.4	57	120	12	174
ADO-TRS-3D	11.4	57	120	12	183
AD-4D	11.4	71	118	12	142
WH70-DRL	11.4	71	120	12	213
NF-GDN	11.4	71	126	12	203
ADO-5D	11.4	92	156	12	155
ADO-SUS-5D	11.4	92	156	12	178
ADO-TRS-5D	11.4	92	156	12	185
V-SDR	11.4	94	142	11.4	322
EX-GDR	11.4	94	151	12	298
EX-HO-GDR	11.4	94	151	12	305
EX-SUS-GDR	11.4	94	151	12	288
VP-GDR	11.4	94	151	12	262
EX-GDXL	11.4	120	200	11.4	303
ADO-8D	11.4	125	194	12	158
ADO-SUS-8D	11.4	125	194	12	181
TDXL	11.4 × 10D	155	215	11.4	311

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-10D	11.4	155	215	12	161
EX-GDXL	11.4	160	250	11.4	303
EX-GDXL	11.4	200	300	11.4	303
ADO-15D	11.4	210	280	12	163
ADO-20D	11.4	270	330	12	165
ADO-25D	11.4	340	400	12	167
EX-SUS-GDS	11.45	47	104	12	279
EX-GDR	11.45	94	151	12	298
EX-SUS-GDR	11.45	94	151	12	288
ED-DS	11.5	44	101	12	245
EX-GDS	11.5	47	104	12	291
EX-SUS-GDS	11.5	47	104	12	279
NEXUS-GDS	11.5	47	104	12	271
VPH-GDS	11.5	47	104	12	259
VP-HO-GDS	11.5	47	104	12	266
ADF-2D	11.5	50	95	10	344
ADFO-3D	11.5	50	95	12	359
ADFLS-2D	11.5	50	170	10	356
AD-2D	11.5	55	102	12	139
ADO-3D	11.5	58	120	12	151
ADO-SUS-3D	11.5	58	120	12	174
ADO-TRS-3D	11.5	58	120	12	183
AD-4D	11.5	71	118	12	142
WH70-DRL	11.5	71	120	12	213
D-GDN	11.5	71	121	12	244
NF-GDN	11.5	71	126	12	203
V-MT-GDN	11.5	71	154	MT1	316
ADO-5D	11.5	92	156	12	155
ADO-SUS-5D	11.5	92	156	12	178
ADO-TRS-5D	11.5	92	156	12	185

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
WH55-5D	11.5	92	156	12	210
WHO55-5D	11.5	92	156	12	211
V-SDR	11.5	94	142	11.5	322
EX-GDR	11.5	94	151	12	298
EX-HO-GDR	11.5	94	151	12	305
EX-SUS-GDR	11.5	94	151	12	288
VP-GDR	11.5	94	151	12	262
VP-HO-GDR	11.5	94	151	12	269
EX-MT-GDR	11.5	94	177	MT1	307
MT-SUS-GDR	11.5	94	177	MT1	289
EX-GDXL	11.5	120	200	11.5	303
ADO-8D	11.5	127	194	12	158
ADO-SUS-8D	11.5	127	194	12	181
TDXL	11.5 X 10D	155	215	11.5	311
ADO-10D	11.5	155	215	12	161
TRS-HO-10D	11.5	155	215	12	190
EX-GDXL	11.5	160	250	11.5	303
EX-GDXL	11.5	200	300	11.5	303
TDXL	11.5 X 15D	208	290	11.5	313
ADO-15D	11.5	210	280	12	163
ADO-20D	11.5	270	330	12	165
ADO-25D	11.5	340	400	12	167
EX-GDS	11.55	47	104	12	291
EX-SUS-GDS	11.55	47	104	12	279
EX-GDR	11.55	94	151	12	298
EX-SUS-GDR	11.55	94	151	12	288
WHO55-5D	11.56	94	156	12	211
EX-GDS	11.6	47	104	12	291
EX-SUS-GDS	11.6	47	104	12	279
VPH-GDS	11.6	47	104	12	259

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDS	11.6	47	104	12	266
ADF-2D	11.6	50	95	10	344
ADFO-3D	11.6	50	95	12	359
AD-2D	11.6	55	102	12	139
ADO-3D	11.6	58	120	12	151
ADO-SUS-3D	11.6	58	120	12	174
ADO-TRS-3D	11.6	58	120	12	183
AD-4D	11.6	71	118	12	142
WH70-DRL	11.6	71	120	12	213
NF-GDN	11.6	71	126	12	203
ADO-5D	11.6	93	156	12	155
ADO-SUS-5D	11.6	93	156	12	178
ADO-TRS-5D	11.6	93	156	12	185
V-SDR	11.6	94	142	11.6	322
EX-GDR	11.6	94	151	12	298
EX-HO-GDR	11.6	94	151	12	305
EX-SUS-GDR	11.6	94	151	12	288
VP-GDR	11.6	94	151	12	262
EX-GDXL	11.6	120	200	11.6	303
ADO-8D	11.6	128	194	12	158
ADO-SUS-8D	11.6	128	194	12	181
TDXL	11.6 X 10D	155	215	11.6	311
ADO-10D	11.6	155	215	12	161
EX-GDXL	11.6	160	250	11.6	303
EX-GDXL	11.6	200	300	11.6	303
ADO-15D	11.6	210	280	12	163
ADO-20D	11.6	270	330	12	165
ADO-25D	11.6	340	400	12	167
EX-SUS-GDS	11.65	47	104	12	279
EX-GDR	11.65	94	151	12	298

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDR	11.65	94	151	12	288
EX-GDS	11.7	47	104	12	291
EX-SUS-GDS	11.7	47	104	12	279
VPH-GDS	11.7	47	104	12	259
VP-HO-GDS	11.7	47	104	12	266
ADF-2D	11.7	50	95	10	344
ADFO-3D	11.7	50	95	12	359
AD-2D	11.7	55	102	12	139
ADO-3D	11.7	59	120	12	151
ADO-SUS-3D	11.7	59	120	12	174
ADO-TRS-3D	11.7	59	120	12	183
AD-4D	11.7	71	118	12	142
WH70-DRL	11.7	71	120	12	213
NF-GDN	11.7	71	126	12	203
V-SDR	11.7	94	142	11.7	322
EX-GDR	11.7	94	151	12	298
EX-HO-GDR	11.7	94	151	12	305
EX-SUS-GDR	11.7	94	151	12	288
VP-GDR	11.7	94	151	12	262
ADO-5D	11.7	94	156	12	155
ADO-SUS-5D	11.7	94	156	12	178
ADO-TRS-5D	11.7	94	156	12	185
EX-GDXL	11.7	120	200	11.7	303
ADO-8D	11.7	129	194	12	158
ADO-SUS-8D	11.7	129	194	12	181
TDXL	11.7 × 10D	155	215	11.7	311
ADO-10D	11.7	155	215	12	161
EX-GDXL	11.7	160	250	11.7	303
EX-GDXL	11.7	200	300	11.7	303
ADO-15D	11.7	210	280	12	163

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-20D	11.7	270	330	12	165
ADO-25D	11.7	340	400	12	167
EX-SUS-GDS	11.75	47	104	12	279
EX-GDR	11.75	94	151	12	298
EX-SUS-GDR	11.75	94	151	12	288
EX-GDS	11.8	47	104	12	291
EX-SUS-GDS	11.8	47	104	12	279
VPH-GDS	11.8	47	104	12	259
VP-HO-GDS	11.8	47	104	12	266
ADF-2D	11.8	50	95	10	344
ADFO-3D	11.8	50	95	12	359
ADFLS-2D	11.8	50	170	10	356
AD-2D	11.8	55	102	12	139
ADO-3D	11.8	59	120	12	151
ADO-SUS-3D	11.8	59	120	12	174
ADO-TRS-3D	11.8	59	120	12	183
AD-4D	11.8	71	118	12	142
WH70-DRL	11.8	71	120	12	213
NF-GDN	11.8	71	126	12	203
V-SDR	11.8	94	142	11.8	322
EX-GDR	11.8	94	151	12	298
EX-HO-GDR	11.8	94	151	12	305
EX-SUS-GDR	11.8	94	151	12	288
VP-GDR	11.8	94	151	12	262
ADO-5D	11.8	95	156	12	155
ADO-SUS-5D	11.8	95	156	12	178
ADO-TRS-5D	11.8	95	156	12	185
WH55-5D	11.8	96	156	12	210
WHO55-5D	11.8	96	156	12	211
EX-GDXL	11.8	120	200	11.8	303

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-8D	11.8	130	194	12	158
ADO-SUS-8D	11.8	130	194	12	181
TDXL	11.8 × 10D	155	215	11.8	311
ADO-10D	11.8	155	215	12	161
EX-GDXL	11.8	160	250	11.8	303
EX-GDXL	11.8	200	300	11.8	303
ADO-15D	11.8	210	280	12	163
TDXL	11.8 × 15D	214	295	11.8	313
ADO-20D	11.8	270	330	12	165
ADO-25D	11.8	340	400	12	167
EX-SUS-GDS	11.85	51	108	12	279
EX-GDR	11.85	101	158	12	298
EX-SUS-GDR	11.85	101	158	12	288
ADF-2D	11.9	50	95	10	344
ADFO-3D	11.9	50	95	12	359
EX-GDS	11.9	51	108	12	291
EX-SUS-GDS	11.9	51	108	12	279
VPH-GDS	11.9	51	108	12	259
VP-HO-GDS	11.9	51	108	12	266
AD-2D	11.9	55	102	12	139
ADO-3D	11.9	60	120	12	151
ADO-SUS-3D	11.9	60	120	12	174
ADO-TRS-3D	11.9	60	120	12	183
AD-4D	11.9	71	118	12	142
WH70-DRL	11.9	76	120	12	213
NF-GDN	11.9	76	126	12	203
ADO-5D	11.9	96	156	12	155
ADO-SUS-5D	11.9	96	156	12	178
ADO-TRS-5D	11.9	96	156	12	185
V-SDR	11.9	101	151	11.9	322

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDR	11.9	101	158	12	298
EX-HO-GDR	11.9	101	158	12	305
EX-SUS-GDR	11.9	101	158	12	288
VP-GDR	11.9	101	158	12	262
EX-GDXL	11.9	120	200	11.9	303
ADO-8D	11.9	131	194	12	158
ADO-SUS-8D	11.9	131	194	12	181
TDXL	11.9 X 10D	155	215	11.9	311
ADO-10D	11.9	155	215	12	161
EX-GDXL	11.9	160	250	11.9	303
EX-GDXL	11.9	200	300	11.9	303
ADO-15D	11.9	215	280	12	163
ADO-20D	11.9	270	330	12	165
ADO-25D	11.9	340	400	12	167
EX-SUS-GDS	11.95	51	108	12	279
EX-GDR	11.95	101	158	12	298
EX-SUS-GDR	11.95	101	158	12	288
ED-DS	12	44	101	12	245
ADF-2D	12	50	95	12	344
ADFO-3D	12	50	95	12	359
ADFLS-2D	12	50	170	12	356
ADFLS-2D	12	50	170	12	356
EX-GDS	12	51	108	12	291
EX-SUS-GDS	12	51	108	12	279
NEXUS-GDS	12	51	108	12	271
VPH-GDS	12	51	108	12	259
VP-HO-GDS	12	51	108	12	266
AD-2D	12	55	102	12	139
EX-H-DRL	12	60	110	12	319
ADO-3D	12	60	120	12	151

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	12	60	120	12	174
ADO-TRS-3D	12	60	120	12	183
AD-4D	12	71	118	12	142
V-MT-GDN	12	71	154	MT1	316
WH70-DRL	12	76	120	12	213
D-GDN	12	76	126	12	244
NF-GDN	12	76	126	12	203
ADO-5D	12	96	156	12	155
ADO-SUS-5D	12	96	156	12	178
ADO-TRS-5D	12	96	156	12	185
WH55-5D	12	96	156	12	210
WHO55-5D	12	96	156	12	211
V-SDR	12	101	151	12	322
EX-GDR	12	101	158	12	298
EX-HO-GDR	12	101	158	12	305
EX-SUS-GDR	12	101	158	12	288
NEXUS-GDR	12	101	158	12	272
VP-GDR	12	101	158	12	262
VP-HO-GDR	12	101	158	12	269
EX-MT-GDR	12	101	184	MT1	307
MT-SUS-GDR	12	101	184	MT1	289
EX-GDXL	12	120	200	12	303
ADO-8D	12	132	194	12	158
ADO-SUS-8D	12	132	194	12	181
ADO-10D	12	155	215	12	161
TDXL	12 X 10D	155	215	12	311
TRS-HO-10D	12	155	215	12	190
EX-GDXL	12	160	250	12	303
EX-GDXL	12	200	300	12	303
ADO-15D	12	215	280	12	163

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
TDXL	12 X 15D	216	300	12	313
ADO-20D	12	270	330	12	165
TDXL	12 X 20D	276	350	12	315
ADO-25D	12	340	400	12	167
ADF-2D	12.03	56	100	12	344
ADFO-3D	12.03	56	100	14	359
ADO-PLT	12.03	60	120	12	172
EX-GDS	12.1	51	108	12	291
EX-SUS-GDS	12.1	51	108	12	279
VPH-GDS	12.1	51	108	12	259
VP-HO-GDS	12.1	51	111	16	266
ADF-2D	12.1	56	100	12	344
ADFO-3D	12.1	56	100	14	359
AD-2D	12.1	60	107	14	139
ADO-3D	12.1-13	61	128	13	151
ADO-SUS-3D	12.1-13	61	128	13	174
ADO-3D	12.1	61	128	14	151
ADO-SUS-3D	12.1	61	128	14	174
NF-GDN	12.1	76	128	12	203
AD-4D	12.1-13	77	124	13	142
AD-4D	12.1	77	124	14	142
EX-HO-GDR	12.1	80	140	16	305
ADO-5D	12.1-13	97	167	13	155
ADO-SUS-5D	12.1-13	97	167	13	178
ADO-5D	12.1	97	167	14	155
ADO-SUS-5D	12.1	97	167	14	178
V-SDR	12.1	101	151	12.1	322
EX-GDR	12.1	101	158	12	298
EX-SUS-GDR	12.1	101	158	12	288
VP-GDR	12.1	101	158	12	262

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	12.1	120	200	12.1	303
ADO-8D	12.1	133	206	14	158
EX-GDXL	12.1	160	250	12.1	303
EX-GDXL	12.1	200	300	12.1	303
EX-GDS	12.2	51	108	12	292
EX-SUS-GDS	12.2	51	108	12	279
VPH-GDS	12.2	51	108	12	260
VP-HO-GDS	12.2	51	111	16	266
ADF-2D	12.2	56	100	12	344
ADFO-3D	12.2	56	100	14	359
AD-2D	12.2	60	107	14	139
ADO-3D	12.2-13	61	128	13	151
ADO-SUS-3D	12.2-13	61	128	13	174
ADO-3D	12.2	61	128	14	151
ADO-SUS-3D	12.2	61	128	14	174
NF-GDN	12.2	76	128	12	203
AD-4D	12.2-13	77	124	13	142
AD-4D	12.2	77	124	14	142
EX-HO-GDR	12.2	80	140	16	305
ADO-5D	12.2-13	98	167	13	155
ADO-SUS-5D	12.2-13	98	167	13	178
ADO-5D	12.2	98	167	14	155
ADO-SUS-5D	12.2	98	167	14	178
V-SDR	12.2	101	151	12.2	322
EX-GDR	12.2	101	158	12	298
EX-SUS-GDR	12.2	101	158	12	288
VP-GDR	12.2	101	158	12	262
EX-GDXL	12.2	120	200	12.2	303
ADO-8D	12.2	134	206	14	158
EX-GDXL	12.2	160	250	12.2	303

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	12.2	200	300	12.2	303
EX-GDS	12.3	51	108	12	292
EX-SUS-GDS	12.3	51	108	12	279
VPH-GDS	12.3	51	108	12	260
VP-HO-GDS	12.3	51	111	16	266
ADF-2D	12.3	56	100	12	344
ADFO-3D	12.3	56	100	14	359
AD-2D	12.3	60	107	14	139
ADO-3D	12.3-13	62	128	13	151
ADO-SUS-3D	12.3-13	62	128	13	174
ADO-3D	12.3	62	128	14	151
ADO-SUS-3D	12.3	62	128	14	174
NF-GDN	12.3	76	128	12	203
AD-4D	12.3-13	77	124	13	142
AD-4D	12.3	77	124	14	142
EX-HO-GDR	12.3	80	140	16	305
ADO-5D	12.3-13	99	167	13	155
ADO-SUS-5D	12.3-13	99	167	13	178
ADO-5D	12.3	99	167	14	155
ADO-SUS-5D	12.3	99	167	14	178
V-SDR	12.3	101	151	12.3	322
EX-GDR	12.3	101	158	12	298
EX-SUS-GDR	12.3	101	158	12	288
VP-GDR	12.3	101	158	12	262
EX-GDXL	12.3	120	200	12.3	303
ADO-8D	12.3	135	206	14	158
EX-GDXL	12.3	160	250	12.3	303
EX-GDXL	12.3	200	300	12.3	303
EX-GDS	12.4	51	108	12	292
EX-SUS-GDS	12.4	51	108	12	279

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	12.4	51	108	12	260
VP-HO-GDS	12.4	51	111	16	266
ADF-2D	12.4	56	100	12	344
ADFO-3D	12.4	56	100	14	359
AD-2D	12.4	60	107	14	139
ADO-3D	12.4-13	62	128	13	151
ADO-SUS-3D	12.4-13	62	128	13	174
ADO-3D	12.4	62	128	14	151
ADO-SUS-3D	12.4	62	128	14	174
NF-GDN	12.4	76	128	12	203
AD-4D	12.4-13	77	124	13	142
AD-4D	12.4	77	124	14	142
EX-HO-GDR	12.4	80	140	16	305
ADO-5D	12.4-13	100	167	13	155
ADO-SUS-5D	12.4-13	100	167	13	178
ADO-5D	12.4	100	167	14	155
ADO-SUS-5D	12.4	100	167	14	178
V-SDR	12.4	101	151	12.4	322
EX-GDR	12.4	101	158	12	298
EX-SUS-GDR	12.4	101	158	12	288
VP-GDR	12.4	101	158	12	262
EX-GDXL	12.4	120	200	12.4	303
ADO-8D	12.4	136	206	14	158
EX-GDXL	12.4	160	250	12.4	303
EX-GDXL	12.4	200	300	12.4	303
ED-DS	12.5	48	105	12	245
EX-GDS	12.5	51	108	12	292
EX-SUS-GDS	12.5	51	108	12	279
VPH-GDS	12.5	51	108	12	260
VP-HO-GDS	12.5	51	111	16	266

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADF-2D	12.5	56	100	12	344
ADFO-3D	12.5	56	100	14	359
ADFLS-2D	12.5	56	180	12	356
AD-2D	12.5	60	107	14	139
ADO-3D	12.5-13	63	128	13	151
ADO-SUS-3D	12.5-13	63	128	13	174
ADO-3D	12.5	63	128	14	151
ADO-SUS-3D	12.5	63	128	14	174
ADO-TRS-3D	12.5	63	128	14	183
NF-GDN	12.5	76	128	12	203
V-MT-GDN	12.5	76	159	MT1	316
AD-4D	12.5-13	77	124	13	142
AD-4D	12.5	77	124	14	142
EX-HO-GDR	12.5	80	140	16	305
ADO-5D	12.5-13	100	167	13	155
ADO-SUS-5D	12.5-13	100	167	13	178
ADO-5D	12.5	100	167	14	155
ADO-SUS-5D	12.5	100	167	14	178
ADO-TRS-5D	12.5	100	167	14	185
V-SDR	12.5	101	151	12.5	322
EX-GDR	12.5	101	158	12	298
EX-SUS-GDR	12.5	101	158	12	288
VP-GDR	12.5	101	158	12	262
VP-HO-GDR	12.5	101	161	16	269
EX-MT-GDR	12.5	101	184	MT1	307
MT-SUS-GDR	12.5	101	184	MT1	289
EX-GDXL	12.5	120	200	12.5	303
ADO-8D	12.5-13	138	206	13	158
ADO-8D	12.5	138	206	14	158
ADO-10D	12.5	155	215	14	161

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	12.5	160	250	12.5	303
EX-GDXL	12.5	200	300	12.5	303
ADO-15D	12.5	225	290	14	163
ADO-20D	12.5	280	330	14	165
EX-GDS	12.6	51	108	12	292
EX-SUS-GDS	12.6	51	108	12	279
VPH-GDS	12.6	51	108	12	260
VP-HO-GDS	12.6	51	111	16	266
ADF-2D	12.6	56	100	12	344
ADFO-3D	12.6	56	100	14	359
AD-2D	12.6	60	107	14	139
ADO-3D	12.6-13	63	128	13	151
ADO-SUS-3D	12.6-13	63	128	13	174
ADO-3D	12.6	63	128	14	151
ADO-SUS-3D	12.6	63	128	14	174
NF-GDN	12.6	76	128	12	203
AD-4D	12.6-13	77	124	13	142
AD-4D	12.6	77	124	14	142
EX-HO-GDR	12.6	85	145	16	305
V-SDR	12.6	101	151	12.6	322
EX-GDR	12.6	101	158	12	298
EX-SUS-GDR	12.6	101	158	12	288
VP-GDR	12.6	101	158	12	262
ADO-5D	12.6-13	101	167	13	155
ADO-SUS-5D	12.6-13	101	167	13	178
ADO-5D	12.6	101	167	14	155
ADO-SUS-5D	12.6	101	167	14	178
EX-GDXL	12.6	120	200	12.6	303
ADO-8D	12.6	139	206	14	158
EX-GDXL	12.6	160	250	12.6	304

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	12.6	200	300	12.6	304
EX-GDS	12.7	51	108	12	292
EX-SUS-GDS	12.7	51	108	12	279
VPH-GDS	12.7	51	108	12	260
VP-HO-GDS	12.7	51	111	16	266
ADF-2D	12.7	56	100	12	344
ADFO-3D	12.7	56	100	14	359
AD-2D	12.7	60	107	14	139
ADO-3D	12.7-13	64	128	13	151
ADO-SUS-3D	12.7-13	64	128	13	174
ADO-3D	12.7	64	128	14	151
ADO-SUS-3D	12.7	64	128	14	174
NF-GDN	12.7	76	128	12	203
AD-4D	12.7-13	77	124	13	142
AD-4D	12.7	77	124	14	142
EX-HO-GDR	12.7	85	145	16	305
V-SDR	12.7	101	151	12.7	322
EX-GDR	12.7	101	158	12	298
EX-SUS-GDR	12.7	101	158	12	288
VP-GDR	12.7	101	158	12	262
ADO-5D	12.7-13	102	167	13	155
ADO-SUS-5D	12.7-13	102	167	13	178
ADO-5D	12.7	102	167	14	155
ADO-SUS-5D	12.7	102	167	14	178
EX-GDXL	12.7	120	200	12.7	304
ADO-8D	12.7	140	206	14	158
EX-GDXL	12.7	160	250	12.7	304
EX-GDXL	12.7	200	300	12.7	304
ADO-3D	12.75-13	64	128	13	151
ADO-SUS-3D	12.75-13	64	128	13	174

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	12.75-13	102	167	13	178
ADO-5D	12.75-13	103	167	13	155
EX-GDS	12.8	51	108	12	292
EX-SUS-GDS	12.8	51	108	12	279
VPH-GDS	12.8	51	108	12	260
VP-HO-GDS	12.8	51	111	16	266
ADF-2D	12.8	56	100	12	344
ADFO-3D	12.8	56	100	14	359
AD-2D	12.8	60	107	14	139
ADO-3D	12.8-13	64	128	13	151
ADO-SUS-3D	12.8-13	64	128	13	174
ADO-3D	12.8	64	128	14	151
ADO-SUS-3D	12.8	64	128	14	174
NF-GDN	12.8	76	128	12	203
AD-4D	12.8-13	77	124	13	142
AD-4D	12.8	77	124	14	142
EX-HO-GDR	12.8	85	145	16	305
V-SDR	12.8	101	151	12.8	322
EX-GDR	12.8	101	158	12	299
EX-SUS-GDR	12.8	101	158	12	288
VP-GDR	12.8	101	158	12	262
ADO-5D	12.8-13	103	167	13	155
ADO-SUS-5D	12.8-13	103	167	13	178
ADO-5D	12.8	103	167	14	155
ADO-SUS-5D	12.8	103	167	14	178
EX-GDXL	12.8	120	200	12.8	304
ADO-8D	12.8	141	206	14	158
EX-GDXL	12.8	160	250	12.8	304
EX-GDXL	12.8	200	300	12.8	304
EX-GDS	12.9	51	108	12	292

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	12.9	51	108	12	279
VPH-GDS	12.9	51	108	12	260
VP-HO-GDS	12.9	51	111	16	266
ADF-2D	12.9	56	100	12	344
ADFO-3D	12.9	56	100	14	359
AD-2D	12.9	60	107	14	139
ADO-3D	12.9-13	65	128	13	151
ADO-SUS-3D	12.9-13	65	128	13	174
ADO-3D	12.9	65	128	14	151
ADO-SUS-3D	12.9	65	128	14	174
NF-GDN	12.9	76	128	12	203
AD-4D	12.9-13	77	124	13	142
AD-4D	12.9	77	124	14	142
EX-HO-GDR	12.9	85	145	16	305
V-SDR	12.9	101	151	12.9	322
EX-GDR	12.9	101	158	12	299
EX-SUS-GDR	12.9	101	158	12	288
VP-GDR	12.9	101	158	12	262
ADO-5D	12.9-13	104	167	13	155
ADO-SUS-5D	12.9-13	104	167	13	178
ADO-5D	12.9	104	167	14	155
ADO-SUS-5D	12.9	104	167	14	178
EX-GDXL	12.9	120	200	12.9	304
ADO-8D	12.9	142	206	14	158
EX-GDXL	12.9	160	250	12.9	304
EX-GDXL	12.9	200	300	12.9	304
ED-DS	13	48	105	12	245
EX-GDS	13	51	108	12	292
EX-SUS-GDS	13	51	108	12	279
VPH-GDS	13	51	108	12	260

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDS	13	51	111	16	266
ADF-2D	13	56	100	12	344
ADFO-3D	13	56	100	14	359
ADFLS-2D	13	56	180	12	356
AD-2D	13	60	107	14	139
ADO-3D	13-13	65	128	13	151
ADO-SUS-3D	13-13	65	128	13	174
ADO-3D	13	65	128	14	151
ADO-SUS-3D	13	65	128	14	174
ADO-TRS-3D	13	65	128	14	183
NF-GDN	13	76	128	12	203
V-MT-GDN	13	76	159	MT1	316
AD-4D	13-13	77	124	13	142
AD-4D	13	77	124	14	142
EX-HO-GDR	13	85	145	16	305
V-SDR	13	101	151	13	322
EX-GDR	13	101	158	12	299
EX-SUS-GDR	13	101	158	12	288
VP-GDR	13	101	158	12	262
VP-HO-GDR	13	101	161	16	269
EX-MT-GDR	13	101	184	MT1	308
MT-SUS-GDR	13	101	184	MT1	289
ADO-5D	13-13	104	167	13	155
ADO-SUS-5D	13-13	104	167	13	178
ADO-5D	13	104	167	14	155
ADO-SUS-5D	13	104	167	14	178
ADO-TRS-5D	13	104	167	14	185
EX-GDXL	13	120	200	13	304
ADO-8D	13-13	143	206	13	158
ADO-8D	13	143	206	14	159

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDXL	13	160	250	13	304
EX-GDXL	13	200	300	13	304
EX-SUS-GDS	13.1	51	111	16	279
VPH-GDS	13.1	51	111	16	260
VP-HO-GDS	13.1	51	111	16	266
ADF-2D	13.1	60	105	12	344
ADFO-3D	13.1	60	105	14	359
AD-2D	13.1	60	107	14	139
ADO-3D	13.1	66	134	14	151
ADO-SUS-3D	13.1	66	134	14	174
AD-4D	13.1	77	124	14	142
EX-HO-GDR	13.1	85	145	16	305
ADO-5D	13.1	105	176	14	155
ADO-SUS-5D	13.1	105	176	14	178
ADO-8D	13.1	144	218	14	159
EX-SUS-GDS	13.2	51	111	16	279
VPH-GDS	13.2	51	111	16	260
VP-HO-GDS	13.2	51	111	16	266
ADF-2D	13.2	60	105	12	344
ADFO-3D	13.2	60	105	14	359
AD-2D	13.2	60	107	14	139
ADO-3D	13.2	66	134	14	151
ADO-SUS-3D	13.2	66	134	14	175
AD-4D	13.2	77	124	14	142
EX-HO-GDR	13.2	85	145	16	305
ADO-5D	13.2	106	176	14	155
ADO-SUS-5D	13.2	106	176	14	178
ADO-8D	13.2	145	218	14	159
ADO-TRS-3D	13.25	67	134	14	183
ADO-5D	13.25	106	176	14	155

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	13.25	106	176	14	178
ADO-TRS-5D	13.25	106	176	14	185
EX-SUS-GDS	13.3	54	114	16	279
VPH-GDS	13.3	54	114	16	260
VP-HO-GDS	13.3	54	114	16	266
ADF-2D	13.3	60	105	12	344
ADFO-3D	13.3	60	105	14	359
AD-2D	13.3	60	107	14	139
ADO-3D	13.3	67	134	14	151
ADO-SUS-3D	13.3	67	134	14	175
ADO-TRS-3D	13.3	67	134	14	183
AD-4D	13.3	77	124	14	143
EX-HO-GDR	13.3	90	150	16	305
ADO-5D	13.3	107	176	14	155
ADO-SUS-5D	13.3	107	176	14	178
ADO-TRS-5D	13.3	107	176	14	185
ADO-8D	13.3	146	218	14	159
ADO-TRS-3D	13.38	67	134	14	183
ADO-TRS-5D	13.38	108	176	14	185
EX-SUS-GDS	13.4	54	114	16	279
VPH-GDS	13.4	54	114	16	260
VP-HO-GDS	13.4	54	114	16	266
ADF-2D	13.4	60	105	12	344
ADFO-3D	13.4	60	105	14	359
AD-2D	13.4	60	107	14	139
ADO-3D	13.4	67	134	14	151
ADO-SUS-3D	13.4	67	134	14	175
AD-4D	13.4	77	124	14	143
EX-HO-GDR	13.4	90	150	16	305
ADO-5D	13.4	108	176	14	155

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	13.4	108	176	14	178
ADO-8D	13.4	147	218	14	159
ADO-SUS-3D	13.43	68	134	14	175
ADO-SUS-5D	13.43	108	176	14	178
EX-SUS-GDS	13.5	54	114	16	279
VPH-GDS	13.5	54	114	16	260
VP-HO-GDS	13.5	54	114	16	266
ADF-2D	13.5	60	105	12	344
ADFO-3D	13.5	60	105	14	359
AD-2D	13.5	60	107	14	139
ADFLS-2D	13.5	60	190	12	356
ADO-3D	13.5	68	134	14	151
ADO-SUS-3D	13.5	68	134	14	175
ADO-TRS-3D	13.5	68	134	14	183
AD-4D	13.5	77	124	14	143
V-MT-GDN	13.5	80	163	MT1	316
EX-GDR	13.5	90	150	16	299
EX-HO-GDR	13.5	90	150	16	305
EX-SUS-GDR	13.5	106	166	16	288
VP-GDR	13.5	106	166	16	262
VP-HO-GDR	13.5	106	166	16	269
EX-MT-GDR	13.5	106	189	MT1	308
MT-SUS-GDR	13.5	106	189	MT1	289
ADO-5D	13.5	108	176	14	155
ADO-SUS-5D	13.5	108	176	14	178
ADO-TRS-5D	13.5	108	176	14	185
ADO-8D	13.5	149	218	14	159
ADO-SUS-3D	13.55	68	134	14	175
ADO-SUS-5D	13.55	109	176	14	178
EX-SUS-GDS	13.6	54	114	16	279

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	13.6	54	114	16	260
VP-HO-GDS	13.6	54	114	16	266
ADF-2D	13.6	60	105	12	344
ADFO-3D	13.6	60	105	14	359
AD-2D	13.6	60	107	14	139
ADO-3D	13.6	68	134	14	151
ADO-SUS-3D	13.6	68	134	14	175
AD-4D	13.6	77	124	14	143
EX-HO-GDR	13.6	90	150	16	305
ADO-5D	13.6	109	176	14	155
ADO-SUS-5D	13.6	109	176	14	178
ADO-8D	13.6	150	218	14	159
EX-SUS-GDS	13.7	54	114	16	279
VPH-GDS	13.7	54	114	16	260
VP-HO-GDS	13.7	54	114	16	266
ADF-2D	13.7	60	105	12	344
ADFO-3D	13.7	60	105	14	359
AD-2D	13.7	60	107	14	139
ADO-3D	13.7	69	134	14	151
ADO-SUS-3D	13.7	69	134	14	175
AD-4D	13.7	77	124	14	143
EX-HO-GDR	13.7	90	150	16	305
ADO-5D	13.7	110	176	14	155
ADO-SUS-5D	13.7	110	176	14	178
ADO-8D	13.7	151	218	14	159
EX-SUS-GDS	13.8	54	114	16	279
VPH-GDS	13.8	54	114	16	260
VP-HO-GDS	13.8	54	114	16	266
ADF-2D	13.8	60	105	12	344
ADFO-3D	13.8	60	105	14	359

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-2D	13.8	60	107	14	139
ADO-3D	13.8	69	134	14	151
ADO-SUS-3D	13.8	69	134	14	175
AD-4D	13.8	77	124	14	143
EX-HO-GDR	13.8	90	150	16	305
ADO-5D	13.8	111	176	14	155
ADO-SUS-5D	13.8	111	176	14	178
ADO-8D	13.8	152	218	14	159
EX-SUS-GDS	13.9	54	114	16	279
VPH-GDS	13.9	54	114	16	260
VP-HO-GDS	13.9	54	114	16	266
ADF-2D	13.9	60	105	12	344
ADFO-3D	13.9	60	105	14	359
AD-2D	13.9	60	107	14	140
ADO-3D	13.9	70	134	14	151
ADO-SUS-3D	13.9	70	134	14	175
AD-4D	13.9	77	124	14	143
EX-HO-GDR	13.9	90	150	16	305
ADO-5D	13.9	112	176	14	155
ADO-SUS-5D	13.9	112	176	14	178
ADO-8D	13.9	153	218	14	159
EX-SUS-GDS	14	54	114	16	279
VPH-GDS	14	54	114	16	260
VP-HO-GDS	14	54	114	16	266
ADF-2D	14	60	105	12	344
ADFO-3D	14	60	105	14	359
AD-2D	14	60	107	14	140
ADFLS-2D	14	60	190	12	356
ADO-3D	14	70	134	14	151
ADO-SUS-3D	14	70	134	14	175

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-TRS-3D	14	70	134	14	183
AD-4D	14	77	124	14	143
V-MT-GDN	14	80	163	MT1	316
EX-GDR	14	90	150	16	299
EX-HO-GDR	14	90	150	16	305
EX-SUS-GDR	14	106	166	16	288
VP-GDR	14	106	166	16	262
VP-HO-GDR	14	106	166	16	269
EX-MT-GDR	14	106	189	MT1	308
MT-SUS-GDR	14	106	189	MT1	289
ADO-5D	14	112	176	14	155
ADO-SUS-5D	14	112	176	14	178
ADO-TRS-5D	14	112	176	14	185
ADO-8D	14	154	218	14	159
EX-SUS-GDS	14.1	56	116	16	279
VPH-GDS	14.1	56	116	16	260
VP-HO-GDS	14.1	56	116	16	266
ADF-2D	14.1	64	110	12	344
ADFO-3D	14.1	64	110	16	359
AD-2D	14.1	65	115	16	140
ADO-3D	14.1-15	71	140	15	151
ADO-SUS-3D	14.1-15	71	140	15	175
ADO-3D	14.1	71	140	16	151
ADO-SUS-3D	14.1	71	140	16	175
ADO-TRS-3D	14.1	71	140	16	183
AD-4D	14.1-15	83	133	15	143
AD-4D	14.1	83	133	16	143
EX-HO-GDR	14.1	90	150	16	305
EX-GDR	14.1	95	155	16	299
EX-SUS-GDR	14.1	109	169	16	288

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDR	14.1	109	169	16	269
EX-MT-GDR	14.1	109	209	MT2	308
ADO-5D	14.1-15	113	185	15	155
ADO-SUS-5D	14.1-15	113	185	15	178
ADO-5D	14.1	113	185	16	155
ADO-SUS-5D	14.1	113	185	16	178
ADO-TRS-5D	14.1	113	185	16	185
ADO-8D	14.1	155	230	16	159
EX-SUS-GDS	14.2	56	116	16	279
VPH-GDS	14.2	56	116	16	260
VP-HO-GDS	14.2	56	116	16	266
ADF-2D	14.2	64	110	12	344
ADFO-3D	14.2	64	110	16	359
AD-2D	14.2	65	115	16	140
ADO-3D	14.2-15	71	140	15	151
ADO-SUS-3D	14.2-15	71	140	15	175
ADO-3D	14.2	71	140	16	151
ADO-SUS-3D	14.2	71	140	16	175
ADO-TRS-3D	14.2	71	140	16	183
AD-4D	14.2-15	83	133	15	143
AD-4D	14.2	83	133	16	143
EX-HO-GDR	14.2	95	155	16	305
EX-MT-GDR	14.2	109	209	MT2	308
ADO-5D	14.2-15	114	185	15	155
ADO-SUS-5D	14.2-15	114	185	15	178
ADO-5D	14.2	114	185	16	155
ADO-SUS-5D	14.2	114	185	16	178
ADO-TRS-5D	14.2	114	185	16	185
ADO-8D	14.2	156	230	16	159
EX-SUS-GDS	14.3	56	116	16	279

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	14.3	56	116	16	260
VP-HO-GDS	14.3	56	116	16	266
ADF-2D	14.3	64	110	12	344
ADFO-3D	14.3	64	110	16	359
AD-2D	14.3	65	115	16	140
ADO-3D	14.3-15	72	140	15	151
ADO-SUS-3D	14.3-15	72	140	15	175
ADO-3D	14.3	72	140	16	151
ADO-SUS-3D	14.3	72	140	16	175
ADO-TRS-3D	14.3	72	140	16	183
AD-4D	14.3-15	83	133	15	143
AD-4D	14.3	83	133	16	143
EX-HO-GDR	14.3	95	155	16	305
EX-MT-GDR	14.3	109	209	MT2	308
ADO-5D	14.3-15	115	185	15	155
ADO-SUS-5D	14.3-15	115	185	15	178
ADO-5D	14.3	115	185	16	156
ADO-SUS-5D	14.3	115	185	16	178
ADO-TRS-5D	14.3	115	185	16	185
ADO-8D	14.3	157	230	16	159
EX-SUS-GDS	14.4	56	116	16	279
VPH-GDS	14.4	56	116	16	260
VP-HO-GDS	14.4	56	116	16	266
ADF-2D	14.4	64	110	12	344
ADFO-3D	14.4	64	110	16	359
AD-2D	14.4	65	115	16	140
ADO-3D	14.4-15	72	140	15	151
ADO-SUS-3D	14.4-15	72	140	15	175
ADO-3D	14.4	72	140	16	151
ADO-SUS-3D	14.4	72	140	16	175

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
AD-4D	14.4-15	83	133	15	143
AD-4D	14.4	83	133	16	143
EX-HO-GDR	14.4	95	155	16	305
EX-MT-GDR	14.4	109	209	MT2	308
ADO-5D	14.4-15	116	185	15	156
ADO-SUS-5D	14.4-15	116	185	15	178
ADO-5D	14.4	116	185	16	156
ADO-SUS-5D	14.4	116	185	16	178
ADO-8D	14.4	158	230	16	159
EX-SUS-GDS	14.5	56	116	16	279
VPH-GDS	14.5	56	116	16	260
VP-HO-GDS	14.5	56	116	16	266
ADF-2D	14.5	64	110	12	344
ADFO-3D	14.5	64	110	16	359
ADFLS-2D	14.5	64	200	12	356
AD-2D	14.5	65	115	16	140
ADO-3D	14.5-15	73	140	15	151
ADO-SUS-3D	14.5-15	73	140	15	175
ADO-3D	14.5	73	140	16	151
ADO-SUS-3D	14.5	73	140	16	175
ADO-TRS-3D	14.5	73	140	16	183
AD-4D	14.5-15	83	133	15	143
AD-4D	14.5	83	133	16	143
V-MT-GDN	14.5	83	183	MT2	316
EX-GDR	14.5	95	155	16	299
EX-HO-GDR	14.5	95	155	16	305
EX-SUS-GDR	14.5	109	169	16	288
VP-GDR	14.5	109	169	16	262
VP-HO-GDR	14.5	109	169	16	269
EX-MT-GDR	14.5	109	209	MT2	308

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
MT-SUS-GDR	14.5	109	209	MT2	289
ADO-5D	14.5-15	116	185	15	156
ADO-SUS-5D	14.5-15	116	185	15	178
ADO-5D	14.5	116	185	16	156
ADO-SUS-5D	14.5	116	185	16	179
ADO-TRS-5D	14.5	116	185	16	185
ADO-8D	14.5	160	230	16	159
EX-SUS-GDS	14.6	56	116	16	279
VPH-GDS	14.6	56	116	16	260
VP-HO-GDS	14.6	56	116	16	266
ADF-2D	14.6	64	110	12	344
ADFO-3D	14.6	64	110	16	359
AD-2D	14.6	65	115	16	140
ADO-3D	14.6-15	73	140	15	152
ADO-SUS-3D	14.6-15	73	140	15	175
ADO-3D	14.6	73	140	16	152
ADO-SUS-3D	14.6	73	140	16	175
AD-4D	14.6-15	83	133	15	143
AD-4D	14.6	83	133	16	143
EX-HO-GDR	14.6	95	161	20	305
EX-MT-GDR	14.6	109	209	MT2	308
ADO-5D	14.6-15	117	185	15	156
ADO-SUS-5D	14.6-15	117	185	15	179
ADO-5D	14.6	117	185	16	156
ADO-SUS-5D	14.6	117	185	16	179
ADO-8D	14.6	161	230	16	159
EX-SUS-GDS	14.7	56	116	16	279
VPH-GDS	14.7	56	116	16	260
VP-HO-GDS	14.7	56	116	16	266
ADF-2D	14.7	64	110	12	344
ADFO-3D	14.7	64	110	16	359
AD-2D	14.7	65	115	16	140
ADO-3D	14.7-15	74	140	15	152
ADO-SUS-3D	14.7-15	74	140	15	175
ADO-3D	14.7	74	140	16	152
ADO-SUS-3D	14.7	74	140	16	175
AD-4D	14.7-15	83	133	15	143
AD-4D	14.7	83	133	16	143
EX-HO-GDR	14.7	95	161	20	305
EX-MT-GDR	14.7	109	209	MT2	308
ADO-5D	14.7-15	118	185	15	156
ADO-SUS-5D	14.7-15	118	185	15	179
ADO-5D	14.7	118	185	16	156
ADO-SUS-5D	14.7	118	185	16	179
ADO-8D	14.7	162	230	16	159
EX-SUS-GDS	14.8	56	116	16	279
VPH-GDS	14.8	56	116	16	260
VP-HO-GDS	14.8	56	116	16	266
ADF-2D	14.8	64	110	12	344
ADFO-3D	14.8	64	110	16	359
AD-2D	14.8	65	115	16	140
ADO-3D	14.8-15	74	140	15	152
ADO-SUS-3D	14.8-15	74	140	15	175
ADO-3D	14.8	74	140	16	152
ADO-SUS-3D	14.8	74	140	16	175
AD-4D	14.8-15	83	133	15	143
AD-4D	14.8	83	133	16	143
EX-HO-GDR	14.8	95	161	20	305
EX-MT-GDR	14.8	109	209	MT2	308
ADO-5D	14.8-15	119	185	15	156
ADO-SUS-5D	14.8-15	119	185	15	179
ADO-5D	14.8	119	185	16	156
ADO-SUS-5D	14.8	119	185	16	179
ADO-8D	14.8	163	230	16	159
EX-SUS-GDS	14.9	56	116	16	279
VPH-GDS	14.9	56	116	16	260
VP-HO-GDS	14.9	56	116	16	266
ADF-2D	14.9	64	110	12	344
ADFO-3D	14.9	64	110	16	359
AD-2D	14.9	65	115	16	140
ADO-3D	14.9-15	75	140	15	152
ADO-SUS-3D	14.9-15	75	140	15	175
ADO-3D	14.9	75	140	16	152
ADO-SUS-3D	14.9	75	140	16	175
AD-4D	14.9-15	83	133	15	143
AD-4D	14.9	83	133	16	143
EX-HO-GDR	14.9	95	161	20	305
EX-MT-GDR	14.9	109	209	MT2	308
ADO-5D	14.9-15	120	185	15	156
ADO-SUS-5D	14.9-15	120	185	15	179
ADO-5D	14.9	120	185	16	156
ADO-SUS-5D	14.9	120	185	16	179
ADO-8D	14.9	164	230	16	159
EX-SUS-GDS	15	56	116	16	279
VPH-GDS	15	56	116	16	260
VP-HO-GDS	15	56	116	16	266
ADF-2D	15	64	110	12	344
ADFO-3D	15	64	110	16	359
ADFLS-2D	15	64	200	12	356
AD-2D	15	65	115	16	140

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	15-15	75	140	15	152
ADO-SUS-3D	15-15	75	140	15	175
ADO-3D	15	75	140	16	152
ADO-SUS-3D	15	75	140	16	175
ADO-TRS-3D	15	75	140	16	183
AD-4D	15-15	83	133	15	143
AD-4D	15	83	133	16	143
V-MT-GDN	15	83	183	MT2	316
EX-GDR	15	95	161	20	299
EX-HO-GDR	15	95	161	20	305
EX-SUS-GDR	15	109	169	16	288
VP-GDR	15	109	169	16	262
VP-HO-GDR	15	109	169	16	269
EX-MT-GDR	15	109	209	MT2	308
MT-SUS-GDR	15	109	209	MT2	289
ADO-5D	15-15	120	185	15	156
ADO-SUS-5D	15-15	120	185	15	179
ADO-5D	15	120	185	16	156
ADO-SUS-5D	15	120	185	16	179
ADO-TRS-5D	15	120	185	16	185
ADO-8D	15	165	230	16	159
EX-SUS-GDS	15.1	58	118	16	279
VPH-GDS	15.1	58	118	16	260
VP-HO-GDS	15.1	58	118	16	266
AD-2D	15.1	65	115	16	140
ADF-2D	15.1	68	115	12	344
ADFO-3D	15.1	68	115	16	359
ADO-3D	15.1	76	145	16	152
ADO-SUS-3D	15.1	76	145	16	175
AD-4D	15.1	83	133	16	143

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-HO-GDR	15.1	100	166	20	305
EX-MT-GDR	15.1	112	212	MT2	308
ADO-5D	15.1	121	193	16	156
ADO-SUS-5D	15.1	121	193	16	179
ADO-8D	15.1	166	241	16	159
EX-SUS-GDS	15.2	58	118	16	279
VPH-GDS	15.2	58	118	16	260
VP-HO-GDS	15.2	58	118	16	266
AD-2D	15.2	65	115	16	140
ADF-2D	15.2	68	115	12	344
ADFO-3D	15.2	68	115	16	359
ADO-3D	15.2	76	145	16	152
ADO-SUS-3D	15.2	76	145	16	175
ADO-TRS-3D	15.2	76	145	16	183
AD-4D	15.2	83	133	16	143
EX-HO-GDR	15.2	100	166	20	305
EX-MT-GDR	15.2	112	212	MT2	308
ADO-5D	15.2	122	193	16	156
ADO-SUS-5D	15.2	122	193	16	179
ADO-TRS-5D	15.2	122	193	16	185
ADO-8D	15.2	167	241	16	159
ADO-5D	15.25	122	193	16	156
ADO-SUS-5D	15.25	122	193	16	179
EX-SUS-GDS	15.3	58	118	16	279
VPH-GDS	15.3	58	118	16	260
VP-HO-GDS	15.3	58	118	16	266
AD-2D	15.3	65	115	16	140
ADF-2D	15.3	68	115	12	344
ADFO-3D	15.3	68	115	16	359
ADO-3D	15.3	77	145	16	152

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	15.3	77	145	16	175
ADO-TRS-3D	15.3	77	145	16	183
AD-4D	15.3	83	133	16	143
EX-HO-GDR	15.3	100	166	20	305
EX-MT-GDR	15.3	112	212	MT2	308
ADO-5D	15.3	123	193	16	156
ADO-SUS-5D	15.3	123	193	16	179
ADO-TRS-5D	15.3	123	193	16	185
ADO-8D	15.3	168	241	16	159
EX-SUS-GDS	15.4	58	118	16	279
VPH-GDS	15.4	58	118	16	260
VP-HO-GDS	15.4	58	118	16	266
AD-2D	15.4	65	115	16	140
ADF-2D	15.4	68	115	12	344
ADFO-3D	15.4	68	115	16	359
ADO-3D	15.4	77	145	16	152
ADO-SUS-3D	15.4	77	145	16	175
AD-4D	15.4	83	133	16	143
EX-HO-GDR	15.4	100	166	20	305
EX-MT-GDR	15.4	112	212	MT2	308
ADO-5D	15.4	124	193	16	156
ADO-SUS-5D	15.4	124	193	16	179
ADO-8D	15.4	169	241	16	159
EX-SUS-GDS	15.5	58	118	16	279
VPH-GDS	15.5	58	118	16	260
VP-HO-GDS	15.5	58	118	16	266
AD-2D	15.5	65	115	16	140
ADF-2D	15.5	68	115	12	344
ADFO-3D	15.5	68	115	16	359
ADFLS-2D	15.5	68	210	12	356

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-3D	15.5	78	145	16	152
ADO-SUS-3D	15.5	78	145	16	175
ADO-TRS-3D	15.5	78	145	16	183
AD-4D	15.5	83	133	16	143
V-MT-GDN	15.5	85	185	MT2	316
EX-GDR	15.5	100	166	20	299
EX-HO-GDR	15.5	100	166	20	305
EX-SUS-GDR	15.5	112	172	16	288
VP-GDR	15.5	112	172	16	262
VP-HO-GDR	15.5	112	172	16	269
EX-MT-GDR	15.5	112	212	MT2	308
MT-SUS-GDR	15.5	112	212	MT2	289
ADO-5D	15.5	124	193	16	156
ADO-SUS-5D	15.5	124	193	16	179
ADO-TRS-5D	15.5	124	193	16	185
ADO-8D	15.5	171	241	16	159
ADO-SUS-3D	15.55	78	145	16	175
ADO-SUS-5D	15.55	125	193	16	179
EX-SUS-GDS	15.6	58	118	16	279
VPH-GDS	15.6	58	118	16	260
VP-HO-GDS	15.6	58	118	16	266
AD-2D	15.6	65	115	16	140
ADF-2D	15.6	68	115	12	344
ADFO-3D	15.6	68	115	16	359
ADO-3D	15.6	78	145	16	152
ADO-SUS-3D	15.6	78	145	16	175
AD-4D	15.6	83	133	16	143
EX-GDR	15.6	100	166	20	299
EX-HO-GDR	15.6	100	166	20	305
EX-SUS-GDR	15.6	112	172	16	288

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDR	15.6	112	172	16	269
EX-MT-GDR	15.6	112	212	MT2	308
ADO-5D	15.6	125	193	16	156
ADO-SUS-5D	15.6	125	193	16	179
ADO-8D	15.6	172	241	16	159
EX-SUS-GDS	15.7	58	118	16	279
VPH-GDS	15.7	58	118	16	260
VP-HO-GDS	15.7	58	118	16	266
AD-2D	15.7	65	115	16	140
ADF-2D	15.7	68	115	12	344
ADFO-3D	15.7	68	115	16	359
ADO-3D	15.7	79	145	16	152
ADO-SUS-3D	15.7	79	145	16	175
AD-4D	15.7	83	133	16	143
EX-HO-GDR	15.7	100	166	20	305
EX-MT-GDR	15.7	112	212	MT2	308
ADO-5D	15.7	126	193	16	156
ADO-SUS-5D	15.7	126	193	16	179
ADO-8D	15.7	173	241	16	159
EX-SUS-GDS	15.8	58	118	16	279
VPH-GDS	15.8	58	118	16	260
VP-HO-GDS	15.8	58	118	16	266
AD-2D	15.8	65	115	16	140
ADF-2D	15.8	68	115	12	344
ADFO-3D	15.8	68	115	16	359
ADO-3D	15.8	79	145	16	152
ADO-SUS-3D	15.8	79	145	16	175
AD-4D	15.8	83	133	16	143
EX-HO-GDR	15.8	100	166	20	305
EX-MT-GDR	15.8	112	212	MT2	308

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-5D	15.8	127	193	16	156
ADO-SUS-5D	15.8	127	193	16	179
ADO-8D	15.8	174	241	16	159
EX-SUS-GDS	15.9	58	118	16	279
VPH-GDS	15.9	58	118	16	260
VP-HO-GDS	15.9	58	118	16	266
AD-2D	15.9	65	115	16	140
ADF-2D	15.9	68	115	12	344
ADFO-3D	15.9	68	115	16	359
ADO-3D	15.9	80	145	16	152
ADO-SUS-3D	15.9	80	145	16	175
AD-4D	15.9	83	133	16	143
EX-HO-GDR	15.9	100	166	20	305
EX-MT-GDR	15.9	112	212	MT2	308
ADO-5D	15.9	128	193	16	156
ADO-SUS-5D	15.9	128	193	16	179
ADO-8D	15.9	175	241	16	159
EX-SUS-GDS	16	58	118	16	279
VPH-GDS	16	58	118	16	260
VP-HO-GDS	16	58	118	16	266
AD-2D	16	65	115	16	140
ADF-2D	16	68	115	16	344
ADFO-3D	16	68	115	16	359
ADFLS-2D	16	68	210	16	356
ADFLS-2D	16	68	210	16	356
ADO-3D	16	80	145	16	152
ADO-SUS-3D	16	80	145	16	175
ADO-TRS-3D	16	80	145	16	183
AD-4D	16	83	133	16	143
V-MT-GDN	16	85	185	MT2	316

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-GDR	16	100	166	20	299
EX-HO-GDR	16	100	166	20	305
EX-SUS-GDR	16	112	172	16	288
VP-GDR	16	112	172	16	262
VP-HO-GDR	16	112	172	16	269
EX-MT-GDR	16	112	212	MT2	308
MT-SUS-GDR	16	112	212	MT2	289
ADO-5D	16	128	193	16	156
ADO-SUS-5D	16	128	193	16	179
ADO-TRS-5D	16	128	193	16	185
ADO-8D	16	176	241	16	159
EX-SUS-GDS	16.1	60	126	20	279
VPH-GDS	16.1	60	126	20	260
VP-HO-GDS	16.1	60	126	20	266
EX-HO-GDR	16.1	106	172	20	305
EX-MT-GDR	16.1	115	215	MT2	308
EX-SUS-GDS	16.2	60	126	20	279
VPH-GDS	16.2	60	126	20	260
VP-HO-GDS	16.2	60	126	20	266
EX-HO-GDR	16.2	106	172	20	305
EX-MT-GDR	16.2	115	215	MT2	308
EX-SUS-GDS	16.3	60	126	20	279
VPH-GDS	16.3	60	126	20	260
VP-HO-GDS	16.3	60	126	20	266
EX-HO-GDR	16.3	106	172	20	305
EX-MT-GDR	16.3	115	215	MT2	308
EX-SUS-GDS	16.4	60	126	20	279
VPH-GDS	16.4	60	126	20	260
VP-HO-GDS	16.4	60	126	20	266
EX-HO-GDR	16.4	106	172	20	305
EX-MT-GDR	16.4	115	215	MT2	308
EX-SUS-GDS	16.5	60	126	20	279
VPH-GDS	16.5	60	126	20	260
VP-HO-GDS	16.5	60	126	20	266
AD-2D	16.5	73	123	18	140
ADF-2D	16.5	74	125	16	344
ADFO-3D	16.5	74	125	18	359
ADFLS-2D	16.5	74	220	16	356
ADO-3D	16.5-17	83	150	17	152
ADO-SUS-3D	16.5-17	83	150	17	175
ADO-3D	16.5	83	150	18	152
ADO-SUS-3D	16.5	83	150	18	175
ADO-TRS-3D	16.5	83	150	18	183
V-MT-GDN	16.5	88	188	MT2	316
AD-4D	16.5-17	93	143	17	143
AD-4D	16.5	93	143	18	143
EX-GDR	16.5	106	172	20	299
EX-HO-GDR	16.5	106	172	20	305
EX-SUS-GDR	16.5	115	181	20	288
VP-GDR	16.5	115	181	20	262
VP-HO-GDR	16.5	115	181	20	269
EX-MT-GDR	16.5	115	215	MT2	308
MT-SUS-GDR	16.5	115	215	MT2	289
ADO-SUS-5D	16.5-17	116	184	17	179
ADO-SUS-5D	16.5	116	184	18	179
ADO-5D	16.5-17	132	201	17	156
ADO-5D	16.5	132	201	18	156
ADO-TRS-5D	16.5	132	201	18	185
EX-SUS-GDS	16.6	60	126	20	279
VPH-GDS	16.6	60	126	20	260
VP-HO-GDS	16.6	60	126	20	266
EX-HO-GDR	16.6	106	172	20	305
EX-MT-GDR	16.6	115	215	MT2	308
EX-SUS-GDS	16.7	60	126	20	279
VPH-GDS	16.7	60	126	20	260
VP-HO-GDS	16.7	60	126	20	266
ADO-SUS-3D	16.7	84	150	18	175
EX-HO-GDR	16.7	106	172	20	305
EX-MT-GDR	16.7	115	215	MT2	308
ADO-SUS-5D	16.7	117	184	18	179
EX-SUS-GDS	16.8	60	126	20	279
VPH-GDS	16.8	60	126	20	260
VP-HO-GDS	16.8	60	126	20	266
EX-HO-GDR	16.8	106	172	20	306
EX-MT-GDR	16.8	115	215	MT2	308
EX-SUS-GDS	16.9	60	126	20	279
VPH-GDS	16.9	60	126	20	260
VP-HO-GDS	16.9	60	126	20	266
EX-HO-GDR	16.9	106	172	20	306
EX-MT-GDR	16.9	115	215	MT2	308
EX-SUS-GDS	17	60	126	20	279
VPH-GDS	17	60	126	20	260
VP-HO-GDS	17	60	126	20	266
AD-2D	17	73	123	18	140
ADF-2D	17	74	125	16	344
ADFO-3D	17	74	125	18	359
ADFLS-2D	17	74	220	16	356
ADO-3D	17-17	85	150	17	152
ADO-SUS-3D	17-17	85	150	17	175
ADO-3D	17	85	150	18	152

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-3D	17	85	150	18	175
ADO-TRS-3D	17	85	150	18	183
V-MT-GDN	17	88	188	MT2	316
AD-4D	17-17	93	143	17	143
AD-4D	17	93	143	18	143
EX-GDR	17	106	172	20	299
EX-HO-GDR	17	106	172	20	306
EX-SUS-GDR	17	115	181	20	288
VP-GDR	17	115	181	20	262
VP-HO-GDR	17	115	181	20	269
EX-MT-GDR	17	115	215	MT2	308
MT-SUS-GDR	17	115	215	MT2	289
ADO-SUS-5D	17-17	119	184	17	179
ADO-SUS-5D	17	119	184	18	179
ADO-5D	17-17	136	201	17	156
ADO-5D	17	136	201	18	156
ADO-TRS-5D	17	136	201	18	185
EX-SUS-GDS	17.1	62	128	20	279
VPH-GDS	17.1	62	128	20	260
VP-HO-GDS	17.1	62	128	20	266
EX-HO-GDR	17.1	112	178	20	306
EX-MT-GDR	17.1	118	218	MT2	308
EX-SUS-GDS	17.2	62	128	20	279
VPH-GDS	17.2	62	128	20	260
VP-HO-GDS	17.2	62	128	20	266
EX-HO-GDR	17.2	112	178	20	306
EX-MT-GDR	17.2	118	218	MT2	308
ADO-TRS-3D	17.25	87	155	18	183
ADO-TRS-5D	17.25	138	209	18	185
EX-SUS-GDS	17.3	62	128	20	279

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	17.3	62	128	20	260
VP-HO-GDS	17.3	62	128	20	266
ADO-SUS-3D	17.3	87	155	18	175
EX-HO-GDR	17.3	112	178	20	306
EX-MT-GDR	17.3	118	218	MT2	308
ADO-SUS-5D	17.3	122	191	18	179
EX-SUS-GDS	17.4	62	128	20	279
VPH-GDS	17.4	62	128	20	260
VP-HO-GDS	17.4	62	128	20	266
EX-HO-GDR	17.4	112	178	20	306
EX-MT-GDR	17.4	118	218	MT2	308
EX-SUS-GDS	17.5	62	128	20	279
VPH-GDS	17.5	62	128	20	260
VP-HO-GDS	17.5	62	128	20	266
AD-2D	17.5	73	123	18	140
ADF-2D	17.5	78	130	16	344
ADFO-3D	17.5	78	130	18	359
ADFLS-2D	17.5	78	230	16	356
ADO-3D	17.5	88	155	18	152
ADO-SUS-3D	17.5	88	155	18	175
ADO-TRS-3D	17.5	88	155	18	183
V-MT-GDN	17.5	90	190	MT2	316
AD-4D	17.5	93	143	18	143
EX-GDR	17.5	112	178	20	299
EX-HO-GDR	17.5	112	178	20	306
EX-SUS-GDR	17.5	118	184	20	288
VP-GDR	17.5	118	184	20	262
VP-HO-GDR	17.5	118	184	20	269
EX-MT-GDR	17.5	118	218	MT2	308
MT-SUS-GDR	17.5	118	218	MT2	289

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	17.5	123	191	18	179
ADO-5D	17.5	140	209	18	156
ADO-TRS-5D	17.5	140	209	18	185
EX-MT-TDR	17.5	140	260	MT3	318
ADO-SUS-3D	17.55	88	155	18	175
ADO-SUS-5D	17.55	123	191	18	179
EX-SUS-GDS	17.6	62	128	20	279
VPH-GDS	17.6	62	128	20	260
VP-HO-GDS	17.6	62	128	20	266
EX-GDR	17.6	112	178	20	299
EX-HO-GDR	17.6	112	178	20	306
EX-SUS-GDR	17.6	118	184	20	288
VP-HO-GDR	17.6	118	184	20	269
EX-MT-GDR	17.6	118	218	MT2	308
EX-SUS-GDS	17.7	62	128	20	279
VPH-GDS	17.7	62	128	20	260
VP-HO-GDS	17.7	62	128	20	266
EX-HO-GDR	17.7	112	178	20	306
EX-MT-GDR	17.7	118	218	MT2	308
EX-SUS-GDS	17.8	62	128	20	280
VPH-GDS	17.8	62	128	20	260
VP-HO-GDS	17.8	62	128	20	266
EX-HO-GDR	17.8	112	178	20	306
EX-MT-GDR	17.8	118	218	MT2	308
EX-SUS-GDS	17.9	62	128	20	280
VPH-GDS	17.9	62	128	20	260
VP-HO-GDS	17.9	62	128	20	266
EX-HO-GDR	17.9	112	178	20	306
EX-MT-GDR	17.9	118	218	MT2	308
EX-SUS-GDS	18	62	128	20	280

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	18	62	128	20	260
VP-HO-GDS	18	62	128	20	266
AD-2D	18	73	123	18	140
ADF-2D	18	78	130	16	344
ADFO-3D	18	78	130	18	359
ADFLS-2D	18	78	230	16	356
ADO-3D	18	90	155	18	152
ADO-SUS-3D	18	90	155	18	175
ADO-TRS-3D	18	90	155	18	183
V-MT-GDN	18	90	190	MT2	316
AD-4D	18	93	143	18	143
EX-GDR	18	112	178	20	299
EX-HO-GDR	18	112	178	20	306
EX-SUS-GDR	18	118	184	20	288
VP-GDR	18	118	184	20	262
VP-HO-GDR	18	118	184	20	269
EX-MT-GDR	18	118	218	MT2	308
MT-SUS-GDR	18	118	218	MT2	289
ADO-SUS-5D	18	126	191	18	179
EX-MT-TDR	18	140	260	MT3	318
ADO-5D	18	144	209	18	156
ADO-TRS-5D	18	144	209	18	185
EX-SUS-GDS	18.1	64	130	20	280
VPH-GDS	18.1	64	130	20	260
VP-HO-GDS	18.1	64	130	20	266
EX-HO-GDR	18.1	118	184	20	306
EX-MT-GDR	18.1	122	222	MT2	308
EX-SUS-GDS	18.2	64	130	20	280
VPH-GDS	18.2	64	130	20	260
VP-HO-GDS	18.2	64	130	20	266

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-HO-GDR	18.2	118	184	20	306
EX-MT-GDR	18.2	122	222	MT2	308
EX-SUS-GDS	18.3	64	130	20	280
VPH-GDS	18.3	64	130	20	260
VP-HO-GDS	18.3	64	130	20	266
EX-HO-GDR	18.3	118	184	20	306
EX-MT-GDR	18.3	122	222	MT2	308
EX-SUS-GDS	18.4	64	130	20	280
VPH-GDS	18.4	64	130	20	260
VP-HO-GDS	18.4	64	130	20	267
EX-HO-GDR	18.4	118	184	20	306
EX-MT-GDR	18.4	122	222	MT2	308
EX-SUS-GDS	18.5	64	130	20	280
VPH-GDS	18.5	64	130	20	260
VP-HO-GDS	18.5	64	130	20	267
AD-2D	18.5	79	131	20	140
ADF-2D	18.5	84	135	16	344
ADFO-3D	18.5	84	135	20	359
ADFLS-2D	18.5	84	240	16	356
ADO-3D	18.5-19	93	160	19	152
ADO-SUS-3D	18.5-19	93	160	19	175
ADO-3D	18.5	93	160	20	152
ADO-SUS-3D	18.5	93	160	20	175
ADO-TRS-3D	18.5	93	160	20	183
V-MT-GDN	18.5	93	193	MT2	316
AD-4D	18.5-19	101	153	19	143
AD-4D	18.5	101	153	20	143
EX-GDR	18.5	118	184	20	299
EX-HO-GDR	18.5	118	184	20	306
EX-SUS-GDR	18.5	122	188	20	288

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-GDR	18.5	122	188	20	262
VP-HO-GDR	18.5	122	188	20	269
EX-MT-GDR	18.5	122	222	MT2	308
MT-SUS-GDR	18.5	122	222	MT2	289
ADO-SUS-5D	18.5-19	130	198	19	179
ADO-SUS-5D	18.5	130	198	20	179
ADO-5D	18.5-19	148	217	19	156
ADO-5D	18.5	148	217	20	156
ADO-TRS-5D	18.5	148	217	20	185
EX-SUS-GDS	18.6	64	130	20	280
VPH-GDS	18.6	64	130	20	260
VP-HO-GDS	18.6	64	130	20	267
EX-HO-GDR	18.6	118	194	25	306
EX-MT-GDR	18.6	122	222	MT2	308
EX-SUS-GDS	18.7	64	130	20	280
VPH-GDS	18.7	64	130	20	260
VP-HO-GDS	18.7	64	130	20	267
ADO-SUS-3D	18.7	94	160	20	175
EX-HO-GDR	18.7	118	194	25	306
EX-MT-GDR	18.7	122	222	MT2	308
ADO-SUS-5D	18.7	131	198	20	179
EX-SUS-GDS	18.8	64	130	20	280
VPH-GDS	18.8	64	130	20	260
VP-HO-GDS	18.8	64	130	20	267
EX-HO-GDR	18.8	118	194	25	306
EX-MT-GDR	18.8	122	222	MT2	308
EX-SUS-GDS	18.9	64	130	20	280
VPH-GDS	18.9	64	130	20	260
VP-HO-GDS	18.9	64	130	20	267
EX-HO-GDR	18.9	118	194	25	306

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-GDR	18.9	122	222	MT2	308
EX-SUS-GDS	19	64	130	20	280
VPH-GDS	19	64	130	20	260
VP-HO-GDS	19	64	130	20	267
AD-2D	19	79	131	20	140
ADF-2D	19	84	135	16	344
ADFO-3D	19	84	135	20	359
ADFLS-2D	19	84	240	16	356
V-MT-GDN	19	93	193	MT2	316
ADO-3D	19-19	95	160	19	152
ADO-SUS-3D	19-19	95	160	19	175
ADO-3D	19	95	160	20	152
ADO-SUS-3D	19	95	160	20	175
ADO-TRS-3D	19	95	160	20	183
AD-4D	19-19	101	153	19	143
AD-4D	19	101	153	20	143
EX-GDR	19	118	194	25	299
EX-HO-GDR	19	118	194	25	306
EX-SUS-GDR	19	122	188	20	288
VP-GDR	19	122	188	20	262
VP-HO-GDR	19	122	188	20	269
EX-MT-GDR	19	122	222	MT2	308
MT-SUS-GDR	19	122	222	MT2	289
ADO-SUS-5D	19-19	133	198	19	179
ADO-SUS-5D	19	133	198	20	179
EX-MT-TDR	19	145	265	MT3	318
ADO-5D	19-19	152	217	19	156
ADO-5D	19	152	217	20	156
ADO-TRS-5D	19	152	217	20	185
EX-SUS-GDS	19.1	66	132	20	280

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VPH-GDS	19.1	66	132	20	260
VP-HO-GDS	19.1	66	132	20	267
EX-HO-GDR	19.1	125	201	25	306
EX-MT-GDR	19.1	125	225	MT2	308
EX-SUS-GDS	19.2	66	132	20	280
VPH-GDS	19.2	66	132	20	260
VP-HO-GDS	19.2	66	132	20	267
EX-HO-GDR	19.2	125	201	25	306
EX-MT-GDR	19.2	125	225	MT2	308
ADO-TRS-3D	19.25	97	165	20	183
ADO-TRS-5D	19.25	154	225	20	185
EX-SUS-GDS	19.3	66	132	20	280
VPH-GDS	19.3	66	132	20	260
VP-HO-GDS	19.3	66	132	20	267
ADO-SUS-3D	19.3	97	165	20	175
EX-HO-GDR	19.3	125	201	25	306
EX-MT-GDR	19.3	125	225	MT2	308
ADO-SUS-5D	19.3	136	205	20	179
EX-SUS-GDS	19.4	66	132	20	280
VPH-GDS	19.4	66	132	20	260
VP-HO-GDS	19.4	66	132	20	267
EX-HO-GDR	19.4	125	201	25	306
EX-MT-GDR	19.4	125	225	MT2	308
EX-SUS-GDS	19.5	66	132	20	280
VPH-GDS	19.5	66	132	20	260
VP-HO-GDS	19.5	66	132	20	267
AD-2D	19.5	79	131	20	140
ADF-2D	19.5	88	140	16	344
ADFO-3D	19.5	88	140	20	359
ADFLS-2D	19.5	88	250	16	356

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
V-MT-GDN	19.5	96	196	MT2	316
ADO-3D	19.5	98	165	20	152
ADO-SUS-3D	19.5	98	165	20	175
ADO-TRS-3D	19.5	98	165	20	183
AD-4D	19.5	101	153	20	143
EX-SUS-GDR	19.5	125	191	20	288
VP-GDR	19.5	125	191	20	262
VP-HO-GDR	19.5	125	191	20	269
EX-GDR	19.5	125	201	25	299
EX-HO-GDR	19.5	125	201	25	306
EX-MT-GDR	19.5	125	225	MT2	308
MT-SUS-GDR	19.5	125	225	MT2	289
ADO-SUS-5D	19.5	137	205	20	179
ADO-5D	19.5	156	225	20	156
ADO-TRS-5D	19.5	156	225	20	185
ADO-SUS-3D	19.55	98	165	20	175
ADO-SUS-5D	19.55	137	205	20	179
EX-SUS-GDS	19.6	66	132	20	280
VPH-GDS	19.6	66	132	20	260
VP-HO-GDS	19.6	66	132	20	267
EX-SUS-GDR	19.6	125	191	20	288
VP-HO-GDR	19.6	125	191	20	269
EX-GDR	19.6	125	201	25	299
EX-HO-GDR	19.6	125	201	25	306
EX-MT-GDR	19.6	125	225	MT2	308
EX-SUS-GDS	19.7	66	132	20	280
VPH-GDS	19.7	66	132	20	260
VP-HO-GDS	19.7	66	132	20	267
EX-HO-GDR	19.7	125	201	25	306
EX-MT-GDR	19.7	125	225	MT2	308

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-SUS-GDS	19.8	66	132	20	280
VPH-GDS	19.8	66	132	20	260
VP-HO-GDS	19.8	66	132	20	267
EX-HO-GDR	19.8	125	201	25	306
EX-MT-GDR	19.8	125	225	MT2	308
EX-SUS-GDS	19.9	66	132	20	280
VPH-GDS	19.9	66	132	20	260
VP-HO-GDS	19.9	66	132	20	267
EX-HO-GDR	19.9	125	201	25	306
EX-MT-GDR	19.9	125	225	MT2	308
EX-SUS-GDS	20	66	132	20	280
VPH-GDS	20	66	132	20	260
VP-HO-GDS	20	66	132	20	267
AD-2D	20	79	131	20	140
ADF-2D	20	88	140	20	344
ADFO-3D	20	88	140	20	359
ADFLS-2D	20	88	250	20	356
ADFLS-2D	20	88	250	20	356
V-MT-GDN	20	96	196	MT2	316
ADO-3D	20	100	165	20	152
ADO-SUS-3D	20	100	165	20	175
ADO-TRS-3D	20	100	165	20	183
AD-4D	20	101	153	20	143
EX-SUS-GDR	20	125	191	20	288
VP-GDR	20	125	191	20	262
VP-HO-GDR	20	125	191	20	269
EX-GDR	20	125	201	25	299
EX-HO-GDR	20	125	201	25	306
EX-MT-GDR	20	125	225	MT2	308
MT-SUS-GDR	20	125	225	MT2	289

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
ADO-SUS-5D	20	140	205	20	179
EX-MT-TDR	20	150	270	MT3	318
ADO-5D	20	160	225	20	156
ADO-TRS-5D	20	160	225	20	185
EX-MT-GDR	20.1	128	228	MT2	308
EX-MT-GDR	20.2	128	228	MT2	308
EX-MT-GDR	20.3	128	228	MT2	308
EX-MT-GDR	20.4	128	228	MT2	308
EX-SUS-GDS	20.5	68	144	25	280
VP-HO-GDS	20.5	68	144	25	267
V-MT-GDN	20.5	98	198	MT2	316
EX-GDR	20.5	128	204	25	299
EX-HO-GDR	20.5	128	204	25	306
EX-SUS-GDR	20.5	128	204	25	288
VP-GDR	20.5	128	204	25	262
VP-HO-GDR	20.5	128	204	25	269
EX-MT-GDR	20.5	128	228	MT2	308
MT-SUS-GDR	20.5	128	228	MT2	289
EX-MT-GDR	20.6	128	228	MT2	308
EX-MT-GDR	20.7	128	228	MT2	308
EX-MT-GDR	20.8	128	228	MT2	308
EX-MT-GDR	20.9	128	228	MT2	308
EX-SUS-GDS	21	68	144	25	280
VP-HO-GDS	21	68	144	25	267
V-MT-GDN	21	98	198	MT2	316
EX-GDR	21	128	204	25	299
EX-HO-GDR	21	128	204	25	306
EX-SUS-GDR	21	128	204	25	288
VP-GDR	21	128	204	25	262
VP-HO-GDR	21	128	204	25	269

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-GDR	21	128	228	MT2	308
MT-SUS-GDR	21	128	228	MT2	289
EX-GDR	21.1	128	204	25	299
VP-HO-GDR	21.1	128	204	25	269
EX-MT-GDR	21.1	128	228	MT2	308
EX-HO-GDR	21.1	132	208	25	306
EX-MT-GDR	21.2	128	228	MT2	308
EX-MT-GDR	21.3	132	232	MT2	308
EX-MT-GDR	21.4	132	232	MT2	308
EX-SUS-GDS	21.5	70	146	25	280
VP-HO-GDS	21.5	70	146	25	267
V-MT-GDN	21.5	101	201	MT2	316
EX-GDR	21.5	132	208	25	299
EX-HO-GDR	21.5	132	208	25	306
EX-SUS-GDR	21.5	132	208	25	288
VP-GDR	21.5	132	208	25	262
VP-HO-GDR	21.5	132	208	25	269
EX-MT-GDR	21.5	132	232	MT2	308
MT-SUS-GDR	21.5	132	232	MT2	289
EX-MT-TDR	21.5	160	280	MT3	318
EX-MT-GDR	21.6	132	232	MT2	308
EX-MT-GDR	21.7	132	232	MT2	308
EX-MT-GDR	21.8	132	232	MT2	308
EX-MT-GDR	21.9	132	232	MT2	308
EX-SUS-GDS	22	70	146	25	280
VP-HO-GDS	22	70	146	25	267
V-MT-GDN	22	101	201	MT2	316
EX-GDR	22	132	208	25	299
EX-HO-GDR	22	132	208	25	306
EX-SUS-GDR	22	132	208	25	288

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-GDR	22	132	208	25	262
VP-HO-GDR	22	132	208	25	269
EX-MT-GDR	22	132	232	MT2	308
MT-SUS-GDR	22	132	232	MT2	289
EX-MT-TDR	22	160	280	MT3	318
EX-MT-GDR	22.1	132	232	MT2	308
EX-MT-GDR	22.2	132	232	MT2	308
EX-MT-GDR	22.3	132	232	MT2	308
EX-MT-GDR	22.4	132	232	MT2	308
EX-SUS-GDS	22.5	72	148	25	280
VP-HO-GDS	22.5	72	148	25	267
V-MT-GDN	22.5	101	201	MT2	316
EX-GDR	22.5	136	212	25	299
EX-HO-GDR	22.5	136	212	25	306
EX-SUS-GDR	22.5	136	212	25	288
VP-GDR	22.5	136	212	25	262
VP-HO-GDR	22.5	136	212	25	269
EX-MT-GDR	22.5	136	236	MT2	308
MT-SUS-GDR	22.5	136	236	MT2	289
EX-MT-GDR	22.6	136	236	MT2	308
EX-MT-GDR	22.7	136	236	MT2	308
EX-MT-GDR	22.8	136	236	MT2	308
EX-MT-GDR	22.9	136	236	MT2	308
EX-SUS-GDS	23	72	148	25	280
VP-HO-GDS	23	72	148	25	267
V-MT-GDN	23	101	201	MT2	316
EX-GDR	23	136	212	25	299
EX-HO-GDR	23	136	212	25	306
EX-SUS-GDR	23	136	212	25	288
VP-GDR	23	136	212	25	262

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDR	23	136	212	25	269
EX-MT-GDR	23	136	236	MT2	308
MT-SUS-GDR	23	136	236	MT2	289
EX-MT-GDR	23.1	136	256	MT3	308
EX-MT-GDR	23.2	136	256	MT3	308
EX-MT-GDR	23.3	136	256	MT3	308
EX-MT-GDR	23.4	136	256	MT3	308
EX-SUS-GDS	23.5	72	148	25	280
VP-HO-GDS	23.5	72	148	25	267
V-MT-GDN	23.5	104	224	MT3	316
EX-GDR	23.5	136	212	25	300
EX-HO-GDR	23.5	136	212	25	306
EX-SUS-GDR	23.5	136	212	25	288
VP-GDR	23.5	136	212	25	262
VP-HO-GDR	23.5	136	212	25	269
EX-MT-GDR	23.5	136	256	MT3	308
MT-SUS-GDR	23.5	136	256	MT3	289
EX-MT-TDR	23.5	165	285	MT3	318
EX-MT-GDR	23.6	136	256	MT3	308
EX-MT-GDR	23.7	140	260	MT3	309
EX-MT-GDR	23.8	140	260	MT3	309
EX-MT-GDR	23.9	140	260	MT3	309
EX-SUS-GDS	24	75	151	25	280
VP-HO-GDS	24	75	151	25	267
V-MT-GDN	24	108	228	MT3	316
EX-SUS-GDR	24	140	216	25	288
VP-GDR	24	140	216	25	262
VP-HO-GDR	24	140	216	25	269
EX-GDR	24	140	220	32	300
EX-HO-GDR	24	140	220	32	306

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-GDR	24	140	260	MT3	309
MT-SUS-GDR	24	140	260	MT3	289
EX-MT-TDR	24	165	285	MT3	318
EX-MT-GDR	24.1	140	260	MT3	309
EX-MT-GDR	24.2	140	260	MT3	309
EX-MT-GDR	24.3	140	260	MT3	309
EX-MT-GDR	24.4	140	260	MT3	309
EX-SUS-GDS	24.5	75	151	25	280
VP-HO-GDS	24.5	75	151	25	267
V-MT-GDN	24.5	108	228	MT3	316
EX-SUS-GDR	24.5	140	216	25	288
VP-GDR	24.5	140	216	25	263
VP-HO-GDR	24.5	140	216	25	269
EX-GDR	24.5	140	220	32	300
EX-HO-GDR	24.5	140	220	32	306
EX-MT-GDR	24.5	140	260	MT3	309
MT-SUS-GDR	24.5	140	260	MT3	289
EX-MT-GDR	24.6	140	260	MT3	309
EX-MT-GDR	24.7	140	260	MT3	309
EX-MT-GDR	24.8	140	260	MT3	309
EX-MT-GDR	24.9	140	260	MT3	309
EX-SUS-GDS	25	75	151	25	280
VP-HO-GDS	25	75	151	25	267
V-MT-GDN	25	108	228	MT3	316
EX-SUS-GDR	25	140	216	25	288
VP-GDR	25	140	216	25	263
VP-HO-GDR	25	140	216	25	269
EX-GDR	25	140	220	32	300
EX-HO-GDR	25	140	220	32	306
EX-MT-GDR	25	140	260	MT3	309

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
MT-SUS-GDR	25	140	260	MT3	289
EX-MT-TDR	25	165	285	MT3	318
EX-MT-GDR	25.1	145	265	MT3	309
EX-MT-GDR	25.2	145	265	MT3	309
EX-MT-GDR	25.3	145	265	MT3	309
EX-MT-GDR	25.4	145	265	MT3	309
EX-SUS-GDS	25.5	78	158	32	280
VP-HO-GDS	25.5	78	158	32	267
V-MT-GDN	25.5	112	232	MT3	316
EX-GDR	25.5	145	225	32	300
EX-HO-GDR	25.5	145	225	32	306
EX-SUS-GDR	25.5	145	225	32	288
VP-GDR	25.5	145	225	32	263
VP-HO-GDR	25.5	145	225	32	269
EX-MT-GDR	25.5	145	265	MT3	309
MT-SUS-GDR	25.5	145	265	MT3	289
EX-MT-GDR	25.6	145	265	MT3	309
EX-MT-GDR	25.7	145	265	MT3	309
EX-MT-GDR	25.8	145	265	MT3	309
EX-MT-GDR	25.9	145	265	MT3	309
EX-SUS-GDS	26	78	158	32	280
VP-HO-GDS	26	78	158	32	267
V-MT-GDN	26	112	232	MT3	316
EX-GDR	26	145	225	32	300
EX-HO-GDR	26	145	225	32	306
EX-SUS-GDR	26	145	225	32	288
VP-GDR	26	145	225	32	263
VP-HO-GDR	26	145	225	32	269
EX-MT-GDR	26	145	265	MT3	309
MT-SUS-GDR	26	145	265	MT3	289

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-TDR	26	165	285	MT3	318
EX-MT-GDR	26.1	145	265	MT3	309
EX-MT-GDR	26.2	145	265	MT3	309
EX-MT-GDR	26.3	145	265	MT3	309
EX-MT-GDR	26.4	145	265	MT3	309
EX-SUS-GDS	26.5	78	158	32	280
V-MT-GDN	26.5	112	232	MT3	316
EX-GDR	26.5	145	225	32	300
EX-HO-GDR	26.5	145	225	32	306
EX-SUS-GDR	26.5	145	225	32	288
VP-GDR	26.5	145	225	32	263
VP-HO-GDR	26.5	145	225	32	269
EX-MT-GDR	26.5	145	265	MT3	309
MT-SUS-GDR	26.5	145	265	MT3	289
EX-MT-GDR	26.6	150	270	MT3	309
EX-MT-GDR	26.7	150	270	MT3	309
EX-MT-GDR	26.8	150	270	MT3	309
EX-MT-GDR	26.9	150	270	MT3	309
EX-SUS-GDS	27	81	161	32	280
V-MT-GDN	27	116	236	MT3	316
EX-GDR	27	150	230	32	300
EX-HO-GDR	27	150	230	32	306
EX-SUS-GDR	27	150	230	32	288
VP-GDR	27	150	230	32	263
VP-HO-GDR	27	150	230	32	269
EX-MT-GDR	27	150	270	MT3	309
MT-SUS-GDR	27	150	270	MT3	289
EX-MT-GDR	27.1	150	270	MT3	309
EX-MT-GDR	27.2	150	270	MT3	309
EX-MT-GDR	27.3	150	270	MT3	309

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-GDR	27.4	150	270	MT3	309
EX-SUS-GDS	27.5	81	161	32	280
V-MT-GDN	27.5	116	236	MT3	316
EX-HO-GDR	27.5	150	230	32	306
EX-MT-GDR	27.5	150	270	MT3	309
MT-SUS-GDR	27.5	150	270	MT3	289
EX-MT-GDR	27.6	150	270	MT3	309
EX-MT-GDR	27.7	150	270	MT3	309
EX-MT-GDR	27.8	150	270	MT3	309
EX-MT-GDR	27.9	150	270	MT3	309
EX-SUS-GDS	28	81	161	32	280
V-MT-GDN	28	116	236	MT3	316
EX-GDR	28	150	230	32	300
EX-HO-GDR	28	150	230	32	306
EX-SUS-GDR	28	150	230	32	288
VP-GDR	28	150	230	32	263
VP-HO-GDR	28	150	230	32	269
EX-MT-GDR	28	150	270	MT3	309
MT-SUS-GDR	28	150	270	MT3	289
EX-MT-GDR	28.1	155	275	MT3	309
EX-MT-GDR	28.2	155	275	MT3	309
EX-MT-GDR	28.3	155	275	MT3	309
EX-MT-GDR	28.4	155	275	MT3	309
EX-SUS-GDS	28.5	84	164	32	280
V-MT-GDN	28.5	120	240	MT3	316
EX-HO-GDR	28.5	155	235	32	306
EX-MT-GDR	28.5	155	275	MT3	309
MT-SUS-GDR	28.5	155	275	MT3	289
EX-MT-GDR	28.6	155	275	MT3	309
EX-MT-GDR	28.7	155	275	MT3	309

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-GDR	28.8	155	275	MT3	309
EX-MT-GDR	28.9	155	275	MT3	309
EX-SUS-GDS	29	84	164	32	280
V-MT-GDN	29	120	240	MT3	316
EX-GDR	29	155	235	32	300
EX-HO-GDR	29	155	235	32	306
EX-SUS-GDR	29	155	235	32	288
VP-GDR	29	155	235	32	263
VP-HO-GDR	29	155	235	32	269
EX-MT-GDR	29	155	275	MT3	309
MT-SUS-GDR	29	155	275	MT3	289
EX-MT-GDR	29.1	155	275	MT3	309
EX-MT-GDR	29.2	155	275	MT3	309
EX-MT-GDR	29.3	155	275	MT3	309
EX-MT-GDR	29.4	155	275	MT3	309
EX-SUS-GDS	29.5	84	164	32	280
V-MT-GDN	29.5	120	240	MT3	316
EX-HO-GDR	29.5	155	235	32	306
EX-MT-GDR	29.5	155	275	MT3	309
MT-SUS-GDR	29.5	155	275	MT3	289
EX-MT-GDR	29.6	155	275	MT3	309
EX-MT-GDR	29.7	155	275	MT3	309
EX-MT-GDR	29.8	155	275	MT3	309
EX-MT-GDR	29.9	155	275	MT3	309
EX-SUS-GDS	30	84	164	32	280
V-MT-GDN	30	120	240	MT3	316
EX-GDR	30	155	235	32	300
EX-HO-GDR	30	155	235	32	306
EX-SUS-GDR	30	155	235	32	288
VP-GDR	30	155	235	32	263

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
VP-HO-GDR	30	155	235	32	269
EX-MT-GDR	30	155	275	MT3	309
MT-SUS-GDR	30	155	275	MT3	289
EX-SUS-GDS	30.5	87	167	32	280
V-MT-GDN	30.5	124	244	MT3	316
EX-HO-GDR	30.5	160	240	32	306
EX-MT-GDR	30.5	160	280	MT3	309
MT-SUS-GDR	30.5	160	280	MT3	289
EX-SUS-GDS	31	87	167	32	280
V-MT-GDN	31	124	244	MT3	316
EX-GDR	31	160	240	32	300
EX-HO-GDR	31	160	240	32	306
EX-SUS-GDR	31	160	240	32	288
VP-GDR	31	160	240	32	263
VP-HO-GDR	31	160	240	32	269
EX-MT-GDR	31	160	280	MT3	309
MT-SUS-GDR	31	160	280	MT3	289
EX-SUS-GDS	31.5	87	167	32	280
V-MT-GDN	31.5	124	244	MT3	316
EX-HO-GDR	31.5	160	240	32	306
EX-MT-GDR	31.5	160	280	MT3	309
MT-SUS-GDR	31.5	160	280	MT3	289
EX-SUS-GDS	32	90	170	32	280
V-MT-GDN	32	128	248	MT3	316
EX-GDR	32	165	245	32	300
EX-HO-GDR	32	165	245	32	306
EX-SUS-GDR	32	165	245	32	288
VP-GDR	32	165	245	32	263
VP-HO-GDR	32	165	245	32	269
EX-MT-GDR	32	165	285	MT3	309

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
MT-SUS-GDR	32	165	285	MT3	289
EX-MT-GDR	32.5	165	310	MT4	309
EX-HO-GDR	33	165	245	32	306
EX-MT-GDR	33	165	310	MT4	309
MT-SUS-GDR	33	165	310	MT4	289
EX-MT-GDR	33.5	165	310	MT4	309
EX-HO-GDR	34	170	260	40	306
EX-MT-GDR	34	170	315	MT4	309
MT-SUS-GDR	34	170	315	MT4	289
EX-MT-GDR	34.5	170	315	MT4	309
EX-HO-GDR	35	170	260	40	306
EX-MT-GDR	35	170	315	MT4	309
MT-SUS-GDR	35	170	315	MT4	289
EX-MT-GDR	35.5	170	315	MT4	309
EX-HO-GDR	36	175	265	40	306
EX-MT-GDR	36	175	320	MT4	309
MT-SUS-GDR	36	175	320	MT4	289
EX-MT-GDR	36.5	175	320	MT4	309
EX-HO-GDR	37	175	265	40	306
EX-MT-GDR	37	175	320	MT4	309
MT-SUS-GDR	37	175	320	MT4	289
EX-MT-GDR	37.5	175	320	MT4	309
EX-HO-GDR	38	180	270	40	306
EX-MT-GDR	38	180	325	MT4	309
MT-SUS-GDR	38	180	325	MT4	289
EX-MT-GDR	38.5	180	325	MT4	309
EX-HO-GDR	39	180	270	40	306
EX-MT-GDR	39	180	325	MT4	309
MT-SUS-GDR	39	180	325	MT4	289
EX-MT-GDR	39.5	180	325	MT4	309

按刃径分类的槽长表 FLUTE LENGTH BY DRILL DIAMETER

硬质合金钻头 / 高速钢钻头
CARBIDE DRILLS / HSS DRILLS

= 硬质合金钻头 Carbide Drills　= 高速钢钻头 HSS Drills　= 标准库存品 Standard stock item.

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-HO-GDR	40	180	270	40	306
EX-MT-GDR	40	180	325	MT4	309
MT-SUS-GDR	40	180	325	MT4	289
EX-MT-GDR	40.5	185	330	MT4	309
EX-MT-GDR	41	185	330	MT4	309
MT-SUS-GDR	41	185	330	MT4	289
EX-MT-GDR	41.5	185	330	MT4	309
EX-MT-GDR	42	185	330	MT4	309
MT-SUS-GDR	42	185	330	MT4	289
EX-MT-GDR	42.5	185	330	MT4	309
EX-MT-GDR	43	190	335	MT4	309
MT-SUS-GDR	43	190	335	MT4	289
EX-MT-GDR	43.5	190	335	MT4	309
EX-MT-GDR	44	190	335	MT4	309
MT-SUS-GDR	44	190	335	MT4	289
EX-MT-GDR	44.5	190	335	MT4	309
EX-MT-GDR	45	190	335	MT4	309
MT-SUS-GDR	45	190	335	MT4	289
EX-MT-GDR	45.5	195	340	MT4	309
EX-MT-GDR	46	195	340	MT4	309
MT-SUS-GDR	46	195	340	MT4	289
EX-MT-GDR	46.5	195	340	MT4	309
EX-MT-GDR	47	195	340	MT4	309
MT-SUS-GDR	47	195	340	MT4	289
EX-MT-GDR	47.5	195	340	MT4	309
EX-MT-GDR	48	200	345	MT4	309
MT-SUS-GDR	48	200	345	MT4	289
EX-MT-GDR	48.5	200	345	MT4	309
EX-MT-GDR	49	200	345	MT4	309
MT-SUS-GDR	49	200	345	MT4	289

品名 Abbreviation	直径 Drill Dia	槽长 LCF	全长 OAL	柄径 DCON	页码 Page
EX-MT-GDR	49.5	200	345	MT4	309
EX-MT-GDR	50	200	345	MT4	309
MT-SUS-GDR	50	200	345	MT4	289

G-LIST No. | DW1073

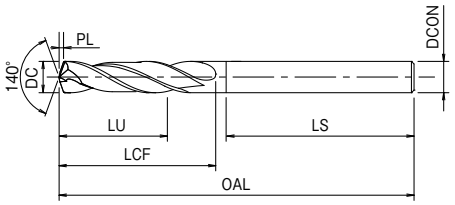
硬质合金钻头 2D 型
CARBIDE DRILL 2D TYPE

The A Brand

AD-2D

切削条件 Cutting Conditions | P.387

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8675200	2 - 3	10	14	62	3	37.9	0.4	●	5
8670200	2				4	36	0.4	●	9
8675210	2.1 - 3				3	37.9	0.4	●	6
8670210	2.1				4	36	0.4	●	9
8675220	2.2 - 3				3	37.9	0.4	●	6
8670220	2.2				4	36	0.4	●	9
8675230	2.3 - 3				3	37.9	0.4	●	6
8670230	2.3				4	36	0.4	●	9
8675240	2.4 - 3				3	37.9	0.4	●	6
8670240	2.4				4	36	0.4	●	9
8675250	2.5 - 3	9			3	37.9	0.5	●	6
8670250	2.5				4	36	0.5	●	9
8675260	2.6 - 3				3	37.9	0.5	●	6
8670260	2.6				4	36	0.5	●	9
8675270	2.7 - 3				3	37.9	0.5	●	7
8670270	2.7				4	36	0.5	●	9
8670276	2.76					36	0.5	●	9
8670278	2.78					36	0.5	●	9
8675280	2.8 - 3				3	37.9	0.5	●	7
8670280	2.8				4	36	0.5	●	9
8675290	2.9 - 3				3	37.9	0.5	●	7
8670290	2.9				4	36	0.5	●	9
8675300	3 - 3	14	20	66	3	37.9	0.5	●	7
8670300	3				4	36	0.5	●	10
8670310	3.1					36	0.6	●	10
8670320	3.2					36	0.6	●	10
8670330	3.3					36	0.6	●	10
8670340	3.4					36	0.6	●	10
8670350	3.5	13				36	0.6	●	11
8670360	3.6					36	0.7	●	11
8670366	3.66					36	0.7	●	11
8670368	3.68					36	0.7	●	11

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8670370	3.7	13	20	66	4	36	0.7	●	11
8670380	3.8	17	24			36	0.7	●	11
8670390	3.9					36	0.7	●	11
8670400	4	16				36	0.7	●	11
8675410	4.1 - 5				5	37.9	0.7	●	15
8670410	4.1				6	36	0.7	●	19
8675420	4.2 - 5				5	37.9	0.8	●	15
8670420	4.2				6	36	0.8	●	19
8675430	4.3 - 5				5	37.9	0.8	●	15
8670430	4.3				6	36	0.8	●	20
8675440	4.4 - 5				5	37.9	0.8	●	15
8670440	4.4				6	36	0.8	●	20
8675450	4.5 - 5	15			5	37.9	0.8	●	15
8670450	4.5				6	36	0.8	●	20
8675460	4.6 - 5				5	37.9	0.8	●	16
8670460	4.6				6	36	0.8	●	20
8670462	4.62					36	0.8	●	20
8670464	4.64					36	0.8	●	20
8675470	4.7 - 5				5	37.9	0.9	●	16
8670470	4.7				6	36	0.9	●	20
8675480	4.8 - 5	19	28		5	37.9	0.9	●	16
8670480	4.8				6	36	0.9	●	20
8675490	4.9 - 5				5	37.9	0.9	●	16
8670490	4.9				6	36	0.9	●	20
8675500	5 - 5	18			5	37.9	0.9	●	16
8670500	5				6	36	0.9	●	20
8670510	5.1					36	0.9	●	21
8670520	5.2					36	0.9	●	21
8670530	5.3					36	1	●	21
8670540	5.4					36	1	●	21
8670550	5.5	17				36	1	●	21
8670552	5.52					36	1	●	21

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直径 DC 5.54～9.26 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
AD-2D	◎	◎	◎	○	○							◎	◎								

上一页
FROM 直径 DC 2～5.52

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8670554	**5.54**					36	1	●	21
8670560	**5.6**					36	1	●	21
8670570	**5.7**	17	28	66	6	36	1	●	22
8670580	**5.8**					36	1.1	●	22
8670590	**5.9**					36	1.1	●	22
8670600	**6**	16				36	1.1	●	22
8675610	**6.1 - 7**				7	37.9	1.1	●	33
8670610	**6.1**				8	36	1.1	●	39
8675620	**6.2 - 7**				7	37.9	1.1	●	34
8670620	**6.2**	22			8	36	1.1	●	39
8675630	**6.3 - 7**				7	37.9	1.1	●	34
8670630	**6.3**				8	36	1.1	●	40
8675640	**6.4 - 7**				7	37.9	1.2	●	34
8670640	**6.4**				8	36	1.2	●	40
8675650	**6.5 - 7**				7	37.9	1.2	●	35
8670650	**6.5**		34		8	36	1.2	●	41
8675660	**6.6 - 7**				7	37.9	1.2	●	35
8670660	**6.6**				8	36	1.2	●	41
8675670	**6.7 - 7**	21		79	7	37.9	1.2	●	35
8670670	**6.7**				8	36	1.2	●	41
8675680	**6.8 - 7**				7	37.9	1.2	●	36
8670680	**6.8**				8	36	1.2	●	42
8675690	**6.9 - 7**				7	37.9	1.3	●	37
8670690	**6.9**				8	36	1.3	●	42
8675700	**7 - 7**	20			7	37.9	1.3	●	37
8670700	**7**					36	1.3	●	42
8670710	**7.1**					36	1.3	●	42
8670720	**7.2**					36	1.3	●	42
8670730	**7.3**	27	41		8	36	1.3	●	42
8670736	**7.36**					36	1.3	●	42
8670738	**7.38**					36	1.3	●	42
8670740	**7.4**					36	1.3	●	42

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8670750	**7.5**					36	1.4	●	43
8670752	**7.52**					36	1.4	●	43
8670754	**7.54**					36	1.4	●	43
8670760	**7.6**	26	41	79	8	36	1.4	●	43
8670770	**7.7**					36	1.4	●	44
8670780	**7.8**					36	1.4	●	44
8670790	**7.9**					36	1.4	●	44
8670800	**8**	25				36	1.5	●	69
8675810	**8.1 - 9**				9	41.9	1.5	●	60
8670810	**8.1**				10	40	1.5	●	69
8675820	**8.2 - 9**				9	41.9	1.5	●	61
8670820	**8.2**	31			10	40	1.5	●	69
8675830	**8.3 - 9**				9	41.9	1.5	●	62
8670830	**8.3**				10	40	1.5	●	69
8675840	**8.4 - 9**				9	41.9	1.5	●	62
8670840	**8.4**				10	40	1.5	●	70
8675850	**8.5 - 9**				9	41.9	1.5	●	62
8670850	**8.5**				10	40	1.5	●	71
8675860	**8.6 - 9**				9	41.9	1.6	●	63
8670860	**8.6**		47	89	10	40	1.6	●	71
8675870	**8.7 - 9**	30			9	41.9	1.6	●	63
8670870	**8.7**				10	40	1.6	●	71
8675880	**8.8 - 9**				9	41.9	1.6	●	64
8670880	**8.8**				10	40	1.6	●	72
8675890	**8.9 - 9**				9	41.9	1.6	●	64
8670890	**8.9**				10	40	1.6	●	72
8675900	**9 - 9**				9	41.9	1.6	●	65
8670900	**9**					40	1.6	●	73
8670910	**9.1**					40	1.7	●	73
8670920	**9.2**	29			10	40	1.7	●	74
8670924	**9.24**					40	1.7	●	74
8670926	**9.26**					40	1.7	●	74

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直径 DC 9.3～13.8 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1073**

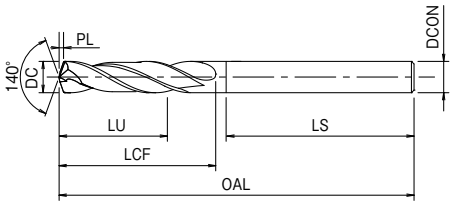
硬质合金钻头 2D 型
CARBIDE DRILL 2D TYPE

The A Brand

AD-2D

切削条件 Cutting Conditions | P.387

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

上一页
FROM 直径 DC 5.54～9.26

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8670930	**9.3**	29	47	89	10	40	1.7	●	74
8670936	**9.36**					40	1.7	●	75
8670938	**9.38**					40	1.7	●	75
8670940	**9.4**					40	1.7	●	76
8670950	**9.5**	28				40	1.7	●	76
8670952	**9.52**					40	1.7	●	74
8670954	**9.54**					40	1.7	●	74
8670960	**9.6**					40	1.7	●	77
8670970	**9.7**					40	1.8	●	77
8670980	**9.8**					40	1.8	●	77
8670990	**9.9**					40	1.8	●	78
8671000	**10**	27				40	1.8	●	78
8676010	**10.1 -11**	35	55	102	11	46.9	1.8	●	101
8671010	**10.1**				12	45	1.8	●	112
8676020	**10.2 -11**				11	46.9	1.9	●	101
8671020	**10.2**				12	45	1.9	●	114
8676030	**10.3 -11**				11	46.9	1.9	●	101
8671030	**10.3**				12	45	1.9	●	114
8676040	**10.4 -11**				11	46.9	1.9	●	103
8671040	**10.4**				12	45	1.9	●	114
8676050	**10.5 -11**	34			11	46.9	1.9	●	103
8671050	**10.5**				12	45	1.9	●	115
8676060	**10.6 -11**				11	46.9	1.9	●	104
8671060	**10.6**				12	45	1.9	●	115
8676070	**10.7 -11**				11	46.9	1.9	●	105
8671070	**10.7**				12	45	1.9	●	117
8676080	**10.8 -11**				11	46.9	2	●	106
8671080	**10.8**				12	45	2	●	117
8676090	**10.9 -11**				11	46.9	2	●	106
8671090	**10.9**				12	45	2	●	117
8676100	**11 -11**	33			11	46.9	2	●	107
8671100	**11**				12	45	2	●	117

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8671110	**11.1**	33	55	102	12	45	2	●	120
8671120	**11.2**					45	2	●	120
8671122	**11.22**					45	2	●	120
8671124	**11.24**					45	2	●	120
8671130	**11.3**					45	2.1	●	120
8671136	**11.36**					45	2.1	●	120
8671138	**11.38**					45	2.1	●	121
8671140	**11.4**					45	2.1	●	121
8671150	**11.5**	32				45	2.1	●	121
8671160	**11.6**					45	2.1	●	123
8671170	**11.7**					45	2.1	●	124
8671180	**11.8**					45	2.1	●	125
8671190	**11.9**					45	2.2	●	125
8671200	**12**	31				45	2.2	●	126
8671210	**12.1**	36	60	107	14	45	2.2	●	163
8671220	**12.2**					45	2.2	●	163
8671230	**12.3**					45	2.2	●	166
8671240	**12.4**					45	2.3	●	166
8671250	**12.5**	35				45	2.3	●	166
8671260	**12.6**					45	2.3	●	167
8671270	**12.7**					45	2.3	●	167
8671280	**12.8**					45	2.3	●	169
8671290	**12.9**					45	2.3	●	171
8671300	**13**	34				45	2.4	●	172
8671310	**13.1**					45	2.4	●	173
8671320	**13.2**					45	2.4	●	173
8671330	**13.3**					45	2.4	●	175
8671340	**13.4**					45	2.4	●	176
8671350	**13.5**	33				45	2.5	●	177
8671360	**13.6**					45	2.5	●	178
8671370	**13.7**					45	2.5	●	179
8671380	**13.8**					45	2.5	●	181

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直径 DC 13.9～20 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
AD-2D	◎	◎	◎	○	○							◎	◎								

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FROM 直径 **DC** 9.3～13.8

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8671390	**13.9**	33	60	107	14	45	2.5	●	182
8671400	**14**	32				45	2.5	●	183
8671410	**14.1**	37	65	115	16	48	2.6	●	228
8671420	**14.2**					48	2.6	●	230
8671430	**14.3**					48	2.6	●	231
8671440	**14.4**					48	2.6	●	233
8671450	**14.5**	36				48	2.6	●	234
8671460	**14.6**					48	2.7	●	235
8671470	**14.7**					48	2.7	●	236
8671480	**14.8**					48	2.7	●	238
8671490	**14.9**					48	2.7	●	239
8671500	**15**	35				48	2.7	●	240
8671510	**15.1**					48	2.7	●	241
8671520	**15.2**					48	2.8	●	244
8671530	**15.3**					48	2.8	●	244
8671540	**15.4**					48	2.8	●	245

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8671550	**15.5**	34	65	115	16	48	2.8	●	247
8671560	**15.6**					48	2.8	●	248
8671570	**15.7**					48	2.9	●	250
8671580	**15.8**					48	2.9	●	251
8671590	**15.9**					48	2.9	●	253
8671600	**16**	33				48	2.9	●	255
8671650	**16.5**	40	73	123	18	48	3	●	314
8671700	**17**	39				48	3.1	●	323
8671750	**17.5**	38				48	3.2	●	331
8671800	**18**	37				48	3.3	●	345
8671850	**18.5**	42	79	131	20	50	3.4	●	409
8671900	**19**	41				50	3.5	●	418
8671950	**19.5**	40				50	3.5	●	427
8672000	**20**	39				50	3.6	●	438

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1074**

硬质合金钻头 4D 型
CARBIDE DRILL 4D TYPE

The A Brand

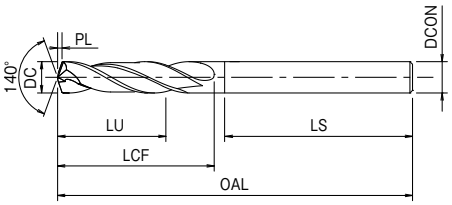
AD-4D

切削条件 Cutting Conditions | P.387

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

X 型横刃
X thinning
(DC≦4)

R 型横刃
R thinning
(4<DC)



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8677200	2 - 3	16	20	66	3	37.9	0.4	●	7
8672200	2				4	36	0.4	●	9
8677210	2.1 - 3				3	37.9	0.4	●	7
8672210	2.1				4	36	0.4	●	9
8677220	2.2 - 3				3	37.9	0.4	●	7
8672220	2.2				4	36	0.4	●	9
8677230	2.3 - 3				3	37.9	0.4	●	7
8672230	2.3				4	36	0.4	●	9
8677240	2.4 - 3				3	37.9	0.4	●	7
8672240	2.4				4	36	0.4	●	9
8677250	2.5 - 3	15			3	37.9	0.5	●	6
8672250	2.5				4	36	0.5	●	9
8677260	2.6 - 3				3	37.9	0.5	●	6
8672260	2.6				4	36	0.5	●	9
8677270	2.7 - 3				3	37.9	0.5	●	7
8672270	2.7				4	36	0.5	●	9
8677280	2.8 - 3				3	37.9	0.5	●	7
8672280	2.8				4	36	0.5	●	10
8677290	2.9 - 3				3	37.9	0.5	●	7
8672290	2.9				4	36	0.5	●	10
8677300	3 - 3	22	28	74	3	37.9	0.5	●	8
8672300	3				4	36	0.5	●	11
8672310	3.1					36	0.6	●	11
8672320	3.2					36	0.6	●	11
8672330	3.3					36	0.6	●	11
8672340	3.4					36	0.6	●	11
8672350	3.5	21				36	0.6	●	12
8672360	3.6					36	0.7	●	12
8672370	3.7					36	0.7	●	12
8672380	3.8	29	36			36	0.7	●	12
8672390	3.9					36	0.7	●	12
8672400	4	28				36	0.7	●	12
8677410	4.1 - 5				5	37.9	0.7	●	16
8672410	4.1				6	36	0.7	●	21
8677420	4.2 - 5				5	37.9	0.8	●	16
8672420	4.2				6	36	0.8	●	21
8677430	4.3 - 5				5	37.9	0.8	●	16
8672430	4.3				6	36	0.8	●	21
8677440	4.4 - 5				5	37.9	0.8	●	17
8672440	4.4				6	36	0.8	●	21
8677450	4.5 - 5	27			5	37.9	0.8	●	17
8672450	4.5				6	36	0.8	●	21
8677460	4.6 - 5				5	37.9	0.8	●	17
8672460	4.6				6	36	0.8	●	21
8677470	4.7 - 5				5	37.9	0.9	●	17
8672470	4.7				6	36	0.9	●	21
8677480	4.8 - 5	35	44	82	5	37.9	0.9	●	18
8672480	4.8				6	36	0.9	●	22
8677490	4.9 - 5				5	37.9	0.9	●	18
8672490	4.9				6	36	0.9	●	23

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8677500	5 - 5	34	44	82	5	37.9	0.9	●	19
8672500	5				6	36	0.9	●	23
8672510	5.1					36	0.9	●	23
8672520	5.2					36	0.9	●	24
8672530	5.3					36	1	●	24
8672540	5.4					36	1	●	24
8672550	5.5	33				36	1	●	25
8672560	5.6					36	1	●	25
8672570	5.7					36	1	●	25
8672580	5.8					36	1.1	●	26
8672590	5.9					36	1.1	●	26
8672600	6	32				36	1.1	●	26
8677610	6.1 - 7	41	53	91	7	37.9	1.1	●	35
8672610	6.1				8	36	1.1	●	40
8677620	6.2 - 7				7	37.9	1.1	●	35
8672620	6.2				8	36	1.1	●	41
8677630	6.3 - 7				7	37.9	1.1	●	35
8672630	6.3				8	36	1.1	●	41
8677640	6.4 - 7				7	37.9	1.2	●	35
8672640	6.4				8	36	1.2	●	42
8677650	6.5 - 7	40			7	37.9	1.2	●	36
8672650	6.5				8	36	1.2	●	42
8677660	6.6 - 7				7	37.9	1.2	●	36
8672660	6.6				8	36	1.2	●	42
8677670	6.7 - 7				7	37.9	1.2	●	37
8672670	6.7				8	36	1.2	●	43
8677680	6.8 - 7				7	37.9	1.2	●	37
8672680	6.8				8	36	1.2	●	44
8677690	6.9 - 7				7	37.9	1.3	●	38
8672690	6.9				8	36	1.3	●	44
8677700	7 - 7	39			7	37.9	1.3	●	38
8672700	7				8	36	1.3	●	44
8672710	7.1					36	1.3	●	45
8672720	7.2					36	1.3	●	45
8672730	7.3					36	1.3	●	45
8672740	7.4					36	1.3	●	46
8672750	7.5	38				36	1.4	●	46
8672760	7.6					36	1.4	●	47
8672770	7.7					36	1.4	●	48
8672780	7.8					36	1.4	●	48
8672790	7.9					36	1.4	●	49
8672800	8	37				36	1.5	●	49
8677810	8.1 - 9	45	61	103	9	41.9	1.5	●	65
8672810	8.1				10	40	1.5	●	74
8677820	8.2 - 9				9	41.9	1.5	●	66
8672820	8.2				10	40	1.5	●	74
8677830	8.3 - 9				9	41.9	1.5	●	66
8672830	8.3				10	40	1.5	●	74
8677840	8.4 - 9				9	41.9	1.5	●	66
8672840	8.4				10	40	1.5	●	76

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直径 DC 8.5～13.2 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
AD-4D	◎	◎	◎	○	○							◎	◎								

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FROM 直径 DC 2～8.4

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8677850	**8.5 - 9**	44	61	103	9	41.9	1.5	●	67
8672850	**8.5**				10	40	1.5	●	77
8677860	**8.6 - 9**				9	41.9	1.6	●	68
8672860	**8.6**				10	40	1.6	●	77
8677870	**8.7 - 9**				9	41.9	1.6	●	68
8672870	**8.7**				10	40	1.6	●	79
8677880	**8.8 - 9**				9	41.9	1.6	●	69
8672880	**8.8**				10	40	1.6	●	79
8677890	**8.9 - 9**				9	41.9	1.6	●	70
8672890	**8.9**				10	40	1.6	●	79
8677900	**9 - 9**	43			9	41.9	1.6	●	71
8672900	**9**				10	40	1.6	●	79
8672910	**9.1**					40	1.7	●	79
8672920	**9.2**					40	1.7	●	80
8672930	**9.3**					40	1.7	●	81
8672940	**9.4**					40	1.7	●	81
8672950	**9.5**	42				40	1.7	●	82
8672960	**9.6**					40	1.7	●	82
8672970	**9.7**					40	1.8	●	83
8672980	**9.8**					40	1.8	●	84
8672990	**9.9**					40	1.8	●	85
8673000	**10**	41				40	1.8	●	87
8678010	**10.1 - 11**	51	71	118	11	46.9	1.8	●	112
8673010	**10.1**				12	45	1.8	●	123
8678020	**10.2 - 11**				11	46.9	1.9	●	113
8673020	**10.2**				12	45	1.9	●	125
8678030	**10.3 - 11**				11	46.9	1.9	●	115
8673030	**10.3**				12	45	1.9	●	125
8678040	**10.4 - 11**				11	46.9	1.9	●	115
8673040	**10.4**				12	45	1.9	●	126
8678050	**10.5 - 11**	50			11	46.9	1.9	●	115
8673050	**10.5**				12	45	1.9	●	126
8678060	**10.6 - 11**				11	46.9	1.9	●	117
8673060	**10.6**				12	45	1.9	●	126
8678070	**10.7 - 11**				11	46.9	1.9	●	117
8673070	**10.7**				12	45	1.9	●	128
8678080	**10.8 - 11**				11	46.9	2	●	117

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8673080	**10.8**	50	71	118	12	45	2	●	129
8678090	**10.9 - 11**				11	46.9	2	●	118
8673090	**10.9**				12	45	2	●	129
8678100	**11 - 11**	49			11	46.9	2	●	120
8673100	**11**				12	45	2	●	131
8673110	**11.1**					45	2	●	132
8673120	**11.2**					45	2	●	133
8673130	**11.3**					45	2.1	●	134
8673140	**11.4**					45	2.1	●	134
8673150	**11.5**	48				45	2.1	●	136
8673160	**11.6**					45	2.1	●	135
8673170	**11.7**					45	2.1	●	137
8673180	**11.8**					45	2.1	●	139
8673190	**11.9**					45	2.2	●	139
8673200	**12**	47				45	2.2	●	141
8678210	**12.1 - 13**	53	77	124	13	45	2.2	●	163
8673210	**12.1**				14	45	2.2	●	177
8678220	**12.2 - 13**				13	45	2.2	●	164
8673220	**12.2**				14	45	2.2	●	177
8678230	**12.3 - 13**				13	45	2.2	●	165
8673230	**12.3**				14	45	2.2	●	178
8678240	**12.4 - 13**				13	45	2.3	●	168
8673240	**12.4**				14	45	2.3	●	179
8678250	**12.5 - 13**	52			13	45	2.3	●	168
8673250	**12.5**				14	45	2.3	●	183
8678260	**12.6 - 13**				13	45	2.3	●	168
8673260	**12.6**				14	45	2.3	●	183
8678270	**12.7 - 13**				13	45	2.3	●	170
8673270	**12.7**				14	45	2.3	●	183
8678280	**12.8 - 13**				13	45	2.3	●	171
8673280	**12.8**				14	45	2.3	●	184
8678290	**12.9 - 13**				13	45	2.3	●	173
8673290	**12.9**				14	45	2.3	●	184
8678300	**13 - 13**	51			13	45	2.4	●	175
8673300	**13**				14	45	2.4	●	189
8673310	**13.1**					45	2.4	●	186
8673320	**13.2**					45	2.4	●	191

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直径 DC 13.3～20 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

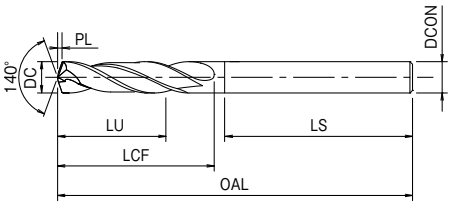
G-LIST No. | **DW1074**

硬质合金钻头 4D 型
CARBIDE DRILL 4D TYPE

The A Brand

AD-4D

切削条件 Cutting Conditions | P.387



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

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FROM 直径 DC 8.5～13.2

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8673330	**13.3**	51	77	124	14	45	2.4	●	193
8673340	**13.4**					45	2.4	●	193
8673350	**13.5**	50				45	2.5	●	195
8673360	**13.6**					45	2.5	●	195
8673370	**13.7**					45	2.5	●	197
8673380	**13.8**					45	2.5	●	200
8673390	**13.9**					45	2.5	●	200
8673400	**14**	49				45	2.5	●	203
8678410	**14.1 - 15**	55	83	133	15	48	2.6	●	228
8673410	**14.1**				16	48	2.6	●	247
8678420	**14.2 - 15**				15	48	2.6	●	230
8673420	**14.2**				16	48	2.6	●	249
8678430	**14.3 - 15**				15	48	2.6	●	231
8673430	**14.3**				16	48	2.6	●	249
8678440	**14.4 - 15**				15	48	2.6	●	234
8673440	**14.4**				16	48	2.6	●	250
8678450	**14.5 - 15**	54			15	48	2.6	●	236
8673450	**14.5**				16	48	2.6	●	255
8678460	**14.6 - 15**				15	48	2.7	●	238
8673460	**14.6**				16	48	2.7	●	254
8678470	**14.7 - 15**				15	48	2.7	●	240
8673470	**14.7**				16	48	2.7	●	254
8678480	**14.8 - 15**				15	48	2.7	●	241
8673480	**14.8**				16	48	2.7	●	258
8678490	**14.9 - 15**				15	48	2.7	●	243

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8673490	**14.9**	54	83	133	16	48	2.7	●	258
8678500	**15 - 15**	53			15	48	2.7	●	243
8673500	**15**				16	48	2.7	●	260
8673510	**15.1**					48	2.7	●	262
8673520	**15.2**					48	2.8	●	262
8673530	**15.3**					48	2.8	●	264
8673540	**15.4**					48	2.8	●	265
8673550	**15.5**	52				48	2.8	●	268
8673560	**15.6**					48	2.8	●	270
8673570	**15.7**					48	2.9	●	272
8673580	**15.8**					48	2.9	●	273
8673590	**15.9**					48	2.9	●	276
8673600	**16**	51				48	2.9	●	278
8678650	**16.5 - 17**	60	93	143	17	48	3	●	316
8673650	**16.5**				18	48	3	●	334
8678700	**17 - 17**	59	93		17	48	3.1	●	326
8673700	**17**					48	3.1	●	346
8673750	**17.5**	58			18	48	3.2	●	356
8673800	**18**	57				48	3.3	●	366
8678850	**18.5 - 19**	64	101	153	19	50	3.4	●	415
8673850	**18.5**				20	50	3.4	●	436
8678900	**19 - 19**	63			19	50	3.5	●	434
8673900	**19**				20	50	3.5	●	448
8673950	**19.5**	62				50	3.5	●	465
8674000	**20**	61				50	3.6	●	476

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
AD-4D	◎	◎	◎	○	○							◎	◎								

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **DW1116** NEW

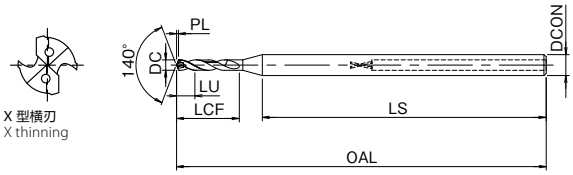
小径内冷油孔硬质合金钻头2D型

SMALL DIAMETER CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (2D TYPE)

The A Brand

ADO-MICRO 2D

切削条件 Cutting Conditions | P.388



CARBIDE | IchAda | +0.001~+0.010 | 约30° ABOUT 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732001	**0.7**	1.4	4.2	47	3	38.5	0.1	●	7
8732002	**0.75**	1.5	4.5			38.3	0.1	●	7
8732003	**0.8**	1.6	4.8	50		41.1	0.1	●	7
8732004	**0.85**	1.7	5.1			40.9	0.2	●	7
8732005	**0.9**	1.8	5.4			40.7	0.2	●	7
8732006	**0.95**	1.9	5.7			40.5	0.2	●	7
8732007	**1**	2	6	53		42.8	0.2	●	7
8732008	**1.1**	2.2	6.6			42.4	0.2	●	7
8732009	**1.2**	2.4	7.2			41.9	0.2	●	7

1. 可作为长刃型(ADO-MICRO 12D、20D、30D) 的导向孔用钻头来使用。

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732010	**1.3**	2.6	7.8	53	3	41.5	0.2	●	7
8732011	**1.4**	2.8	8.4			41.1	0.3	●	7
8732012	**1.5**	3	9			40.7	0.3	●	7
8732013	**1.6**	3.2	9.6			40.3	0.3	●	7
8732014	**1.7**	3.4	10.2			39.9	0.3	●	7
8732015	**1.8**	3.6	10.8			39.5	0.3	●	7
8732016	**1.9**	3.8	11.4			39	0.3	●	7
8732017	**2**	4	12	58		43.6	0.4	●	7

1. Can be used as a guide hole drill for long type drills (ADO-MICRO 12D, 20D and 30D).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-MICRO 2D	◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

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

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

△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **DW1117** NEW

小径内冷油孔硬质合金钻头5D型

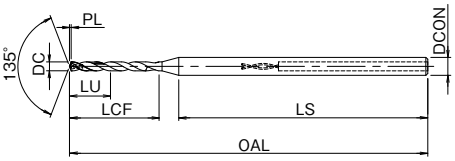
SMALL DIAMETER CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (5D TYPE)

The A Brand

ADO-MICRO 5D

切削条件 Cutting Conditions | P.388

X 型横刃
X thinning



CARBIDE | IchAda | 0~ -0.009 | 约30° ABOUT 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732018	**0.7**	3.5	7	47	3	35.7	0.1	●	7
8732019	**0.75**	3.8	7.5			35.3	0.2	●	7
8732020	**0.8**	4	8	50		37.9	0.2	●	7
8732021	**0.85**	4.3	8.5			37.5	0.2	●	7
8732022	**0.9**	4.5	9			37.1	0.2	●	7
8732023	**0.95**	4.8	9.5			36.7	0.2	●	7
8732024	**1**	5	10	55		40.8	0.2	●	7
8732025	**1.1**	5.5	11			40	0.2	●	7
8732026	**1.2**	6	12	60		44.1	0.2	●	7

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732027	**1.3**	6.5	13	60	3	43.3	0.3	●	7
8732028	**1.4**	7	14			42.5	0.3	●	7
8732029	**1.5**	7.5	15			41.7	0.3	●	7
8732030	**1.6**	8	16			40.9	0.3	●	7
8732031	**1.7**	8.5	17			40.1	0.4	●	7
8732032	**1.8**	9	18	65		44.3	0.4	●	8
8732033	**1.9**	9.5	19			43.4	0.4	●	8
8732034	**2**	10	20			42.6	0.4	●	8

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-MICRO 5D	◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DW1118** NEW

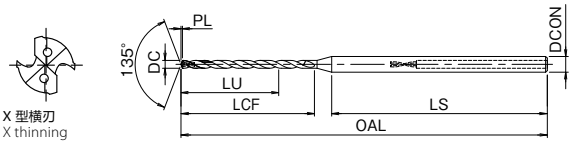
小径内冷油孔硬质合金钻头12D型

SMALL DIAMETER CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (12D TYPE)

The A Brand

ADO-MICRO 12D

切削条件 Cutting Conditions | P.389



CARBIDE | IchAda | 0~-0.009 | 约30° ABOUT 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732035	**1**	12	17	60	3	38.8	0.2	●	8
8732036	**1.1**	13.2	18.7	65		42.3	0.2	●	8
8732037	**1.2**	14.4	20.4			40.7	0.2	●	8
8732038	**1.3**	15.6	22.1			39.2	0.3	●	8
8732039	**1.4**	16.8	23.8	70		42.7	0.3	●	8
8732040	**1.5**	18	25.5			41.2	0.3	●	8

1. 推荐使用ADO-MICRO 2D 作为导向孔用钻头。

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732041	**1.6**	19.2	27.2	70	3	39.7	0.3	●	8
8732042	**1.7**	20.4	28.9	73		41.2	0.4	●	8
8732043	**1.8**	21.6	30.6			39.7	0.4	●	8
8732044	**1.9**	22.8	32.3			38.1	0.4	●	8
8732045	**2**	24	34	77		40.6	0.4	●	8

1. ADO-MICRO 2D is the recommended pilot hole drill.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-MICRO 12D	◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1119 NEW

小径内冷油孔硬质合金钻头20D型

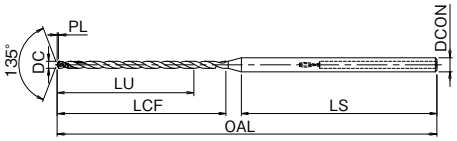
SMALL DIAMETER CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (20D TYPE)

The A Brand

ADO-MICRO 20D

切削条件 Cutting Conditions | P.389

X 型横刃
X thinning



CARBIDE | IchAda | 0~-0.009 | 约30° ABOUT 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732046	**1**	20	24	68	3	39.8	0.2	●	8
8732047	**1.1**	22	26.4	75		44.6	0.2	●	8
8732048	**1.2**	24	28.8			42.3	0.2	●	8
8732049	**1.3**	26	31.2			40.1	0.3	●	10
8732050	**1.4**	28	33.6	81		43.9	0.3	●	10
8732051	**1.5**	30	36			41.7	0.3	●	10

1. 推荐使用ADO-MICRO 2D 作为导向孔用钻头。

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732052	**1.6**	32	38.4	81	3	39.5	0.3	●	10
8732053	**1.7**	34	40.8	88		44.3	0.4	●	10
8732054	**1.8**	36	43.2			42.1	0.4	●	10
8732055	**1.9**	38	45.6			39.8	0.4	●	10
8732056	**2**	40	48	95		44.6	0.4	●	10

1. ADO-MICRO 2D is the recommended pilot hole drill.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-MICRO 20D	◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1120 NEW

小径内冷油孔硬质合金钻头30D型

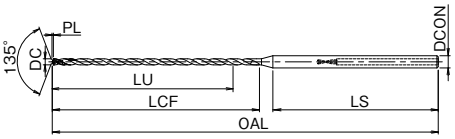
SMALL DIAMETER CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (30D TYPE)

The A Brand

ADO-MICRO 30D

切削条件 Cutting Conditions | P.389

X 型横刃
X thinning



CARBIDE | IchAda | 0~ -0.009 | 约30° ABOUT 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732057	**1**	30	34	77	3	38.8	0.2	●	8
8732058	**1.1**	33	37.4	86		44.6	0.2	●	10
8732059	**1.2**	36	40.8			41.3	0.2	●	10
8732060	**1.3**	39	44.2			38.1	0.3	●	10
8732061	**1.4**	42	47.6	95		43.9	0.3	●	10
8732062	**1.5**	45	51			40.7	0.3	●	10

1. 推荐使用ADO-MICRO 2D 作为导向孔用钻头。

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8732063	**1.6**	48	54.4	101	3	43.5	0.3	●	10
8732064	**1.7**	51	57.8			40.3	0.4	●	10
8732065	**1.8**	54	61.2	107		43.1	0.4	●	10
8732066	**1.9**	57	64.6			39.8	0.4	●	10
8732067	**2**	60	68	112		41.6	0.4	●	10

1. ADO-MICRO 2D is the recommended pilot hole drill.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~ 35 HRC	35 ~ 45 HRC	45 ~ 50 HRC	50 ~ 62 HRC	62 ~ 70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-MICRO 30D	◎	◎	○	◎	○					◎		◎	○	○	○	◎	◎	○		○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1075

硬质合金内冷油孔钻头 3D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (3D TYPE)

The A Brand

ADO-3D

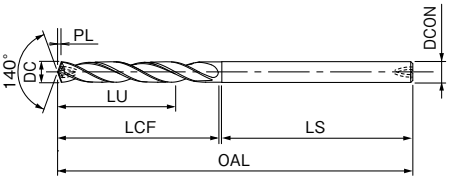
切削条件 Cutting Conditions | P.390

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

R Gash

R 型横刃
R thinning



单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8690200	2 - 3	6	12	66	3	51.2	0.4	●	7
8690210	2.1 - 3	7	13			50.3	0.4	●	7
8690220	2.2 - 3		14			49.5	0.4	●	7
8690230	2.3 - 3					49.7	0.4	●	7
8690240	2.4 - 3	8	15			48.9	0.4	●	7
8690250	2.5 - 3					49.1	0.5	●	7
8690260	2.6 - 3		16			48.3	0.5	●	7
8690265	2.65 - 3					48.3	0.5	●	7
8690270	2.7 - 3	9	17			47.4	0.5	●	7
8690280	2.8 - 3					47.6	0.5	●	7
8690290	2.9 - 3		18			46.8	0.5	●	7
8690300	3 - 3					47	0.5	●	7
8690310	3.1	10	19	74	4	52.3	0.6	●	13
8690315	3.15					52.4	0.6	●	13
8690320	3.2		20			51.5	0.6	●	13
8690330	3.3					51.7	0.6	●	13
8690340	3.4	11	21			50.9	0.6	●	13
8690350	3.5					51.1	0.6	●	13
8690360	3.6		22			50.3	0.7	●	13
8690370	3.7	12	23			49.4	0.7	●	13
8690375	3.75					49.5	0.7	●	13
8690380	3.8					49.6	0.7	●	13
8690390	3.9		24			48.8	0.7	●	13
8690400	4					49	0.7	●	13
8690410	4.1 - 5	13	25	80	5	52.3	0.7	●	19
8700410	4.1				6	50.5	0.7	●	26
8690420	4.2 - 5		26		5	51.5	0.8	●	19
8700420	4.2				6	49.6	0.8	●	26
8690430	4.3 - 5				5	51.7	0.8	●	19
8700430	4.3				6	49.8	0.8	●	26
8690440	4.4 - 5	14	27		5	50.9	0.8	●	19
8700440	4.4				6	49	0.8	●	26
8690450	4.5 - 5				5	51.1	0.8	●	19

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8700450	4.5	14	27	80	6	49.2	0.8	●	26
8690460	4.6 - 5		28		5	50.3	0.8	●	19
8700460	4.6				6	48.4	0.8	●	26
8690470	4.7 - 5	15	29		5	49.4	0.9	●	20
8700470	4.7				6	47.6	0.9	●	26
8690480	4.8 - 5				5	49.6	0.9	●	20
8700480	4.8				6	47.8	0.9	●	26
8690490	4.9 - 5		30		5	48.8	0.9	●	20
8700490	4.9				6	46.9	0.9	●	26
8690500	5 - 5		25		5	54	0.9	●	21
8700500	5				6	52.1	0.9	●	27
8690510	5.1	16	26	82		53.3	0.9	●	27
8690520	5.2					53.5	0.9	●	28
8690525	5.25		27			52.6	1	●	28
8690530	5.3					52.7	1	●	28
8690540	5.4	17	28			52.9	1	●	28
8690550	5.5					52.1	1	●	28
8690560	5.6					52.3	1	●	28
8690570	5.7	18	29			51.4	1	●	28
8690580	5.8					51.6	1.1	●	28
8690590	5.9		30			50.8	1.1	●	29
8690600	6					51	1.1	●	29
8690610	6.1 - 7	19	31	88	7	56	1.1	●	38
8700610	6.1				8	52.5	1.1	●	49
8690620	6.2 - 7				7	56	1.1	●	38
8700620	6.2				8	52.6	1.1	●	49
8690625	6.25 - 7		32		7	55	1.1	●	39
8690630	6.3 - 7					55	1.1	●	39
8700630	6.3				8	51.8	1.1	●	49
8690640	6.4 - 7	20			7	55	1.2	●	40
8700640	6.4				8	52	1.2	●	49
8690650	6.5 - 7		33		7	54	1.2	●	40
8700650	6.5				8	51.2	1.2	●	50

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直径 DC 6.6～10.4 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-3D	◎	◎	◎	◎	◎	○	○			○	○	◎	◎	○		○	○	○		○	

上一页
FROM 直径 DC 2～6.5

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8690660	**6.6 - 7**	20	33	88	7	54	1.2	●	40
8700660	**6.6**				8	51.4	1.2	●	50
8690670	**6.7 - 7**	21	34		7	53	1.2	●	40
8700670	**6.7**				8	50.6	1.2	●	50
8690675	**6.75 - 7**				7	53	1.2	●	40
8690680	**6.8 - 7**					53	1.2	●	40
8700680	**6.8**				8	50.8	1.2	●	50
8690690	**6.9 - 7**		35		7	52	1.3	●	41
8700690	**6.9**				8	49.9	1.3	●	50
8690700	**7 - 7**				7	52	1.3	●	41
8700700	**7**				8	50.1	1.3	●	50
8690710	**7.1**	22	36	94		57	1.3	●	53
8690720	**7.2**					57	1.3	●	53
8690725	**7.25**		37			56	1.3	●	53
8690730	**7.3**					56	1.3	●	53
8690740	**7.4**	23	38			56	1.3	●	54
8690750	**7.5**					55	1.4	●	54
8690760	**7.6**					55	1.4	●	54
8690770	**7.7**	24	39			54	1.4	●	55
8690775	**7.75**					54	1.4	●	55
8690780	**7.8**					54	1.4	●	55
8690790	**7.9**		40			53	1.4	●	55
8690800	**8**					53	1.5	●	55
8690810	**8.1 - 9**	25	41	101	9	59	1.5	●	70
8700810	**8.1**				10	55.5	1.5	●	83
8690820	**8.2 - 9**				9	59	1.5	●	71
8700820	**8.2**				10	55.6	1.5	●	84
8690825	**8.25 - 9**		42		9	58	1.5	●	71
8690830	**8.3 - 9**					58	1.5	●	71
8700830	**8.3**				10	54.8	1.5	●	84
8690840	**8.4 - 9**	26			9	58	1.5	●	71
8700840	**8.4**				10	55	1.5	●	84
8690850	**8.5 - 9**		43		9	57	1.5	●	71

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8700850	**8.5**	26	43	101	10	54.2	1.5	●	84
8690860	**8.6 - 9**				9	57	1.6	●	71
8700860	**8.6**				10	54.4	1.6	●	84
8690870	**8.7 - 9**	27	44		9	56	1.6	●	72
8700870	**8.7**				10	53.6	1.6	●	84
8690875	**8.75 - 9**				9	56	1.6	●	72
8690880	**8.8 - 9**					56	1.6	●	72
8700880	**8.8**				10	53.8	1.6	●	85
8690890	**8.9 - 9**		45		9	55	1.6	●	72
8700890	**8.9**				10	52.9	1.6	●	85
8690900	**9 - 9**				9	55	1.6	●	73
8700900	**9**				10	53.1	1.6	●	87
8690910	**9.1**	28	46	106		59	1.7	●	90
8690920	**9.2**					59	1.7	●	90
8690925	**9.25**		47			58	1.7	●	91
8690930	**9.3**					58	1.7	●	91
8690940	**9.4**	29	48			58	1.7	●	91
8690950	**9.5**					57	1.7	●	91
8690960	**9.6**					57	1.7	●	91
8690970	**9.7**	30	49			56	1.8	●	91
8690975	**9.75**					56	1.8	●	93
8690980	**9.8**					56	1.8	●	92
8690990	**9.9**		50			55	1.8	●	92
8691000	**10**					55	1.8	●	93
8691010	**10.1 -11**	31	51	113	11	61	1.8	●	116
8701010	**10.1**				12	57.5	1.8	●	132
8691020	**10.2 -11**				11	61	1.9	●	117
8701020	**10.2**				12	57.6	1.9	●	132
8691025	**10.25 -11**		52		11	60	1.9	●	117
8691030	**10.3 -11**					60	1.9	●	117
8701030	**10.3**				12	56.8	1.9	●	132
8691040	**10.4 -11**	32			11	60	1.9	●	118
8701040	**10.4**				12	57	1.9	●	134

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直径 DC 10.5～14.5 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1075**

硬质合金内冷油孔钻头 3D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (3D TYPE)

The A Brand

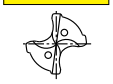
ADO-3D

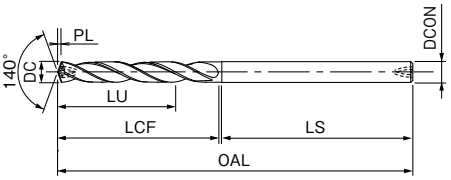
切削条件 Cutting Conditions | P.390

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

R Gash





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FROM 直径 DC 6.6～10.4

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8691050	10.5 -11	32	53	113	11	59	1.9	●	118
8701050	10.5				12	56.2	1.9	●	134
8691060	10.6 -11				11	59	1.9	●	118
8701060	10.6				12	56.4	1.9	●	134
8691070	10.7 -11	33	54		11	58	1.9	●	118
8701070	10.7				12	55.6	1.9	●	134
8691075	10.75 -11				11	58	2	●	118
8691080	10.8 -11					58	2	●	118
8701080	10.8				12	55.8	2	●	135
8691090	10.9 -11		55		11	57	2	●	119
8701090	10.9				12	54.9	2	●	135
8691100	11 -11				11	57	2	●	120
8701100	11				12	55.1	2	●	136
8691110	11.1	34	56	120		63	2	●	147
8691120	11.2					63	2	●	148
8691130	11.3		57			62	2.1	●	149
8691140	11.4	35				62	2.1	●	149
8691150	11.5		58			61	2.1	●	149
8691160	11.6					61	2.1	●	149
8691170	11.7	36	59			60	2.1	●	149
8691180	11.8					60	2.1	●	151
8691190	11.9		60			59	2.2	●	151
8691200	12					59	2.2	●	152
8691210	12.1 -13	37	61	128	13	66	2.2	●	183
8701210	12.1				14	62.5	2.2	●	204
8691220	12.2 -13				13	66	2.2	●	183
8701220	12.2				14	62.6	2.2	●	205
8691230	12.3 -13		62		13	65	2.2	●	184
8701230	12.3				14	61.8	2.2	●	205
8691240	12.4 -13	38			13	65	2.3	●	184
8701240	12.4				14	62	2.3	●	206
8691250	12.5 -13		63		13	64	2.3	●	184

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8701250	12.5	38	63	128	14	61.2	2.3	●	206
8691260	12.6 -13				13	64	2.3	●	184
8701260	12.6				14	61.4	2.3	●	207
8691270	12.7 -13	39	64		13	63	2.3	●	186
8701270	12.7				14	60.6	2.3	●	207
8691275	12.75 -13				13	63	2.3	●	187
8691280	12.8 -13					63	2.3	●	187
8701280	12.8				14	60.8	2.3	●	208
8691290	12.9 -13		65		13	62	2.3	●	187
8701290	12.9				14	59.9	2.3	●	207
8691300	13 -13				13	62	2.4	●	188
8701300	13				14	60.1	2.4	●	210
8691310	13.1	40	66	134		67	2.4	●	220
8691320	13.2					67	2.4	●	221
8691330	13.3		67			66	2.4	●	221
8691340	13.4	41				66	2.4	●	221
8691350	13.5		68			65	2.5	●	221
8691360	13.6					65	2.5	●	221
8691370	13.7	42	69			64	2.5	●	225
8691380	13.8					64	2.5	●	225
8691390	13.9		70			63	2.5	●	225
8691400	14					63	2.5	●	225
8691410	14.1 -15	43	71	140	15	68	2.6	●	260
8701410	14.1				16	64.5	2.6	●	287
8691420	14.2 -15				15	68	2.6	●	260
8701420	14.2				16	64.6	2.6	●	288
8691430	14.3 -15		72		15	67	2.6	●	263
8701430	14.3				16	63.8	2.6	●	288
8691440	14.4 -15	44			15	67	2.6	●	264
8701440	14.4				16	64	2.6	●	290
8691450	14.5 -15		73		15	66	2.6	●	264
8701450	14.5				16	63.2	2.6	●	291

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直径 DC 14.6～20 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-3D	◎	◎	◎	◎	◎	○	○			○	○	◎	◎	○		○	○	○		○	

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FROM 直径 **DC** **10.5～14.5**

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8691460	**14.6 -15**	44	73	140	15	66	2.7	●	266
8701460	**14.6**				16	63.4	2.7	●	291
8691470	**14.7 -15**	45	74		15	65	2.7	●	266
8701470	**14.7**				16	62.6	2.7	●	291
8691480	**14.8 -15**				15	65	2.7	●	266
8701480	**14.8**				16	62.8	2.7	●	293
8691490	**14.9 -15**		75		15	64	2.7	●	268
8701490	**14.9**				16	61.9	2.7	●	293
8691500	**15 -15**				15	64	2.7	●	270
8701500	**15**				16	62.1	2.7	●	295
8691510	**15.1**	46	76	145		68	2.7	●	305
8691520	**15.2**					68	2.8	●	305
8691530	**15.3**		77			67	2.8	●	305
8691540	**15.4**	47				67	2.8	●	309
8691550	**15.5**		78			66	2.8	●	310
8691560	**15.6**					66	2.8	●	312

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8691570	**15.7**	48	79	145	16	65	2.9	●	312
8691580	**15.8**					65	2.9	●	312
8691590	**15.9**		80			64	2.9	●	313
8691600	**16**					64	2.9	●	314
8691650	**16.5 -17**	50	83	150	17	66	3	●	362
8701650	**16.5**				18	63.2	3	●	383
8691700	**17 -17**	51	85		17	64	3.1	●	367
8701700	**17**				18	62.1	3.1	●	393
8691750	**17.5**	53	88	155	18	66	3.2	●	410
8691800	**18**	54	90			64	3.3	●	413
8691850	**18.5 -19**	56	93	160	19	66	3.4	●	464
8701850	**18.5**				20	63.2	3.4	●	500
8691900	**19 -19**	57	95		19	64	3.5	●	469
8701900	**19**				20	62.1	3.5	●	510
8691950	**19.5**	59	98	165		66	3.5	●	525
8692000	**20**	60	100			64	3.6	●	536

2021年10月以后生产的所有尺寸都将依次改为 **R Gash** 。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1076**

硬质合金内冷油孔钻头 5D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (5D TYPE)

The A Brand

ADO-5D

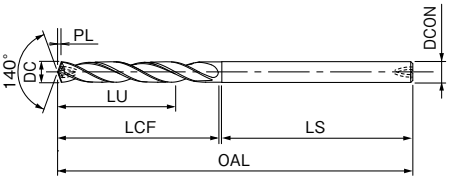
切削条件 Cutting Conditions | P.390

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

R Gash

R 型横刃
R thinning



单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8692200	2 - 3	10	18	70	3	49.2	0.4	●	7
8692210	2.1 - 3	11	19			48.3	0.4	●	7
8692220	2.2 - 3		20			47.5	0.4	●	7
8692230	2.3 - 3	12	21			46.7	0.4	●	7
8692240	2.4 - 3		22			45.9	0.4	●	7
8692250	2.5 - 3	13	23			45.1	0.5	●	7
8692260	2.6 - 3		24	78		52.3	0.5	●	8
8692265	2.65- 3	14				52.3	0.5	●	8
8692270	2.7 - 3		25			51.4	0.5	●	8
8692276	2.76- 3					51.6	0.5	●	8
8692278	2.78- 3		26			50.6	0.5	●	8
8692280	2.8 - 3					50.6	0.5	●	8
8692290	2.9 - 3	15	27			49.8	0.5	●	8
8692300	3 - 3					50	0.5	●	8
8692310	3.1	16	28	86	4	55.3	0.6	●	14
8692315	3.15		29			54.4	0.6	●	14
8692320	3.2					54.5	0.6	●	14
8692330	3.3	17	30			53.7	0.6	●	14
8692340	3.4		31			52.9	0.6	●	14
8692350	3.5	18	32			52.1	0.6	●	14
8692360	3.6		33			51.3	0.7	●	14
8692366	3.66	19				51.4	0.7	●	14
8692368	3.68					50.4	0.7	●	14
8692370	3.7		34			50.4	0.7	●	14
8692375	3.75					50.5	0.7	●	14
8692380	3.8		35			49.6	0.7	●	14
8692390	3.9	20	36			48.8	0.7	●	14
8692400	4					49	0.7	●	14
8692410	4.1 - 5	21	37	95	5	55.3	0.7	●	21
8702410	4.1				6	53.5	0.7	●	28
8692420	4.2 - 5		38		5	54.5	0.8	●	21
8702420	4.2				6	52.6	0.8	●	28
8692430	4.3 - 5	22	39		5	53.7	0.8	●	21
8702430	4.3				6	51.8	0.8	●	28
8692440	4.4 - 5		40		5	52.9	0.8	●	21
8702440	4.4				6	51	0.8	●	28

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8692450	4.5 - 5	23	41	95	5	52.1	0.8	●	21
8702450	4.5				6	50.2	0.8	●	28
8692460	4.6 - 5		42		5	51.3	0.8	●	21
8702460	4.6				6	49.4	0.8	●	28
8692462	4.62- 5	24			5	51.3	0.8	●	21
8692464	4.64- 5					51.3	0.8	●	21
8692470	4.7 - 5		43			50.4	0.9	●	22
8702470	4.7				6	48.6	0.9	●	28
8692480	4.8 - 5		44		5	49.6	0.9	●	22
8702480	4.8				6	47.8	0.9	●	28
8692490	4.9 - 5	25	45		5	48.8	0.9	●	22
8702490	4.9				6	46.9	0.9	●	29
8692500	5 - 5				5	49	0.9	●	22
8702500	5				6	47.1	0.9	●	29
8692510	5.1	26	41	100		56.3	0.9	●	31
8692520	5.2		42			55.5	0.9	●	31
8692525	5.25	27				55.6	1	●	31
8692530	5.3		43			54.7	1	●	31
8692540	5.4		44			53.9	1	●	31
8692550	5.5	28				54.1	1	●	32
8692552	5.52		45			53.1	1	●	32
8692554	5.54					53.1	1	●	32
8692560	5.6					53.3	1	●	32
8692570	5.7	29	46			52.4	1	●	32
8692580	5.8		47			51.6	1.1	●	32
8692590	5.9	30	48			50.8	1.1	●	32
8692600	6					51	1.1	●	32
8692610	6.1 - 7	31	49	109	7	59	1.1	●	44
8702610	6.1				8	55.5	1.1	●	56
8692620	6.2 - 7		50		7	58	1.1	●	44
8702620	6.2				8	54.6	1.1	●	56
8692625	6.25- 7	32			7	58	1.1	●	45
8692630	6.3 - 7		51			57	1.1	●	44
8702630	6.3				8	53.8	1.1	●	56
8692640	6.4 - 7		52		7	56	1.2	●	45
8702640	6.4				8	53	1.2	●	56

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直径 DC 6.5～10.2 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-5D	◎	◎	◎	◎	◎	○	○			○	○	◎	◎	○		○	○			○	

上一页
FROM 直径 DC 2～6.4

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8692650	**6.5 - 7**	33	52	109	7	56	1.2	●	46
8702650	**6.5**				8	53.2	1.2	●	56
8692660	**6.6 - 7**		53		7	55	1.2	●	46
8702660	**6.6**				8	52.4	1.2	●	56
8692670	**6.7 - 7**	34	54		7	54	1.2	●	46
8702670	**6.7**				8	51.6	1.2	●	56
8692675	**6.75- 7**				7	54	1.2	●	46
8692680	**6.8 - 7**		55			53	1.2	●	46
8702680	**6.8**				8	50.8	1.2	●	56
8692690	**6.9 - 7**	35	56		7	52	1.3	●	46
8702690	**6.9**				8	49.9	1.3	●	56
8692700	**7 - 7**				7	52	1.3	●	46
8702700	**7**				8	50.1	1.3	●	56
8692710	**7.1**	36	57	118		60	1.3	●	63
8692720	**7.2**		58			59	1.3	●	63
8692725	**7.25**	37				59	1.3	●	63
8692730	**7.3**		59			58	1.3	●	63
8692736	**7.36**					58	1.3	●	63
8692738	**7.38**		60			57	1.3	●	63
8692740	**7.4**					57	1.3	●	64
8692750	**7.5**	38				57	1.4	●	64
8692752	**7.52**		61			56	1.4	●	64
8692754	**7.54**					56	1.4	●	64
8692760	**7.6**					56	1.4	●	65
8692770	**7.7**	39	62			55	1.4	●	65
8692775	**7.75**					55	1.4	●	65
8692780	**7.8**		63			54	1.4	●	65
8692790	**7.9**	40	64			53	1.4	●	65
8692800	**8**					53	1.5	●	66
8692810	**8.1 - 9**	41	65	128	9	62	1.5	●	83
8702810	**8.1**				10	58.5	1.5	●	96
8692820	**8.2 - 9**		66		9	61	1.5	●	83
8702820	**8.2**				10	57.6	1.5	●	97
8692825	**8.25- 9**	42	67		9	61	1.5	●	84
8692830	**8.3 - 9**					60	1.5	●	84
8702830	**8.3**				10	56.8	1.5	●	97

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8692840	**8.4 - 9**	42	68	128	9	59	1.5	●	84
8702840	**8.4**				10	56	1.5	●	97
8692850	**8.5 - 9**	43			9	59	1.5	●	84
8702850	**8.5**				10	56.2	1.5	●	98
8692860	**8.6 - 9**		69		9	58	1.6	●	84
8702860	**8.6**				10	55.4	1.6	●	98
8692870	**8.7 - 9**	44	70		9	57	1.6	●	85
8702870	**8.7**				10	54.6	1.6	●	98
8692875	**8.75- 9**				9	57	1.6	●	86
8692880	**8.8 - 9**		71			56	1.6	●	86
8702880	**8.8**				10	53.8	1.6	●	98
8692890	**8.9 - 9**	45	72		9	55	1.6	●	85
8702890	**8.9**				10	52.9	1.6	●	98
8692900	**9 - 9**				9	55	1.6	●	87
8702900	**9**				10	53.1	1.6	●	100
8692910	**9.1**	46	73	136		62	1.7	●	108
8692920	**9.2**		74			61	1.7	●	108
8692924	**9.24**	47				61	1.7	●	108
8692925	**9.25**					61	1.7	●	108
8692926	**9.26**		75			60	1.7	●	108
8692930	**9.3**					60	1.7	●	109
8692936	**9.36**					60	1.7	●	109
8692938	**9.38**		76			59	1.7	●	109
8692940	**9.4**					59	1.7	●	109
8692950	**9.5**	48				59	1.7	●	110
8692952	**9.52**		77			58	1.7	●	110
8692954	**9.54**					58	1.7	●	110
8692960	**9.6**					58	1.7	●	110
8692970	**9.7**	49	78			57	1.8	●	109
8692975	**9.75**					57	1.8	●	110
8692980	**9.8**		79			56	1.8	●	110
8692990	**9.9**	50	80			55	1.8	●	110
8693000	**10**					55	1.8	●	110
8693010	**10.1 - 11**	51	81	146	11	64	1.8	●	138
8703010	**10.1**				12	60.5	1.8	●	156
8693020	**10.2 - 11**		82		11	63	1.9	●	139

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直径 DC 10.2～14.3 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash** 。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1076**

硬质合金内冷油孔钻头 5D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (5D TYPE)

The A Brand

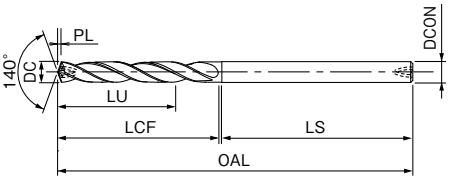
ADO-5D

切削条件 Cutting Conditions | P.390

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

R Gash



上一页 FROM 直径 DC 6.5～10.2

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8703020	**10.2**	51	82	146	12	59.6	1.9	●	156
8693025	**10.25- 11**				11	63	1.9	●	140
8693030	**10.3 - 11**		83			62	1.9	●	140
8703030	**10.3**	52			12	58.8	1.9	●	156
8693040	**10.4 - 11**		84		11	61	1.9	●	140
8703040	**10.4**				12	58	1.9	●	156
8693050	**10.5 - 11**		53		11	61	1.9	●	141
8703050	**10.5**				12	58.2	1.9	●	158
8693060	**10.6 - 11**	53	85		11	60	1.9	●	142
8703060	**10.6**				12	57.4	1.9	●	158
8693070	**10.7 - 11**		86		11	59	1.9	●	142
8703070	**10.7**				12	56.6	1.9	●	158
8693075	**10.75- 11**	54			11	59	2	●	142
8693080	**10.8 - 11**		87			58	2	●	143
8703080	**10.8**				12	55.8	2	●	159
8693090	**10.9 - 11**		88		11	57	2	●	143
8703090	**10.9**	55			12	54.9	2	●	159
8693100	**11 - 11**				11	57	2	●	144
8703100	**11**					55.1	2	●	160
8693110	**11.1**	56	89	156	12	66	2	●	174
8693120	**11.2**		90			65	2	●	177
8693122	**11.22**	57				65	2	●	178
8693124	**11.24**					65	2	●	178
8693130	**11.3**		91			64	2.1	●	176
8693136	**11.36**					64	2.1	●	180
8693138	**11.38**		92			63	2.1	●	180
8693140	**11.4**					63	2.1	●	177
8693150	**11.5**	58				63	2.1	●	178
8693160	**11.6**		93			62	2.1	●	179
8693170	**11.7**	59	94			61	2.1	●	179
8693180	**11.8**		95			60	2.1	●	180
8693190	**11.9**	60	96			59	2.2	●	181
8693200	**12**					59	2.2	●	181
8693210	**12.1 - 13**	61	97	167	13	69	2.2	●	217
8703210	**12.1**				14	65.5	2.2	●	240

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8693220	**12.2 - 13**	61	98	167	13	68	2.2	●	217
8703220	**12.2**				14	64.6	2.2	●	240
8693230	**12.3 - 13**	62	99		13	67	2.2	●	218
8703230	**12.3**				14	63.8	2.2	●	240
8693240	**12.4 - 13**		100		13	66	2.3	●	218
8703240	**12.4**				14	63	2.3	●	242
8693250	**12.5 - 13**	63			13	66	2.3	●	221
8703250	**12.5**				14	63.2	2.3	●	242
8693260	**12.6 - 13**		101		13	65	2.3	●	220
8703260	**12.6**				14	62.4	2.3	●	243
8693270	**12.7 - 13**	64	102		13	64	2.3	●	221
8703270	**12.7**				14	61.6	2.3	●	243
8693275	**12.75- 13**		103		13	63	2.3	●	224
8693280	**12.8 - 13**					63	2.3	●	223
8703280	**12.8**				14	60.8	2.3	●	243
8693290	**12.9 - 13**	65	104		13	62	2.3	●	224
8703290	**12.9**				14	59.9	2.3	●	245
8693300	**13 - 13**				13	62	2.4	●	225
8703300	**13**					60.1	2.4	●	246
8693310	**13.1**	66	105	176	14	70	2.4	●	263
8693320	**13.2**		106			69	2.4	●	264
8693325	**13.25**	67				69	2.4	●	264
8693330	**13.3**		107			68	2.4	●	263
8693340	**13.4**		108			67	2.4	●	265
8693350	**13.5**	68				67	2.5	●	269
8693360	**13.6**		109			66	2.5	●	269
8693370	**13.7**	69	110			65	2.5	●	269
8693380	**13.8**		111			64	2.5	●	270
8693390	**13.9**	70	112			63	2.5	●	271
8693400	**14**					63	2.5	●	273
8693410	**14.1 - 15**	71	113	185	15	71	2.6	●	318
8703410	**14.1**				16	67.5	2.6	●	344
8693420	**14.2 - 15**		114		15	70	2.6	●	318
8703420	**14.2**				16	66.6	2.6	●	345
8693430	**14.3 - 15**	72	115		15	69	2.6	●	318

下一页 直径 DC 14.3～20 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash** 。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-5D	◎	◎	◎	◎	◎	○	○			○	○	◎	◎	○		○	○			○	

上一页

FROM 直径 DC 10.2～14.3

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8703430	**14.3**		115		16	65.8	2.6	●	343
8693440	**14.4 - 15**	72	116		15	68	2.6	●	318
8703440	**14.4**				16	65	2.6	●	344
8693450	**14.5 - 15**	73			15	68	2.6	●	323
8703450	**14.5**				16	65.2	2.6	●	348
8693460	**14.6 - 15**		117		15	67	2.7	●	323
8703460	**14.6**				16	64.4	2.7	●	348
8693470	**14.7 - 15**	74	118	185	15	66	2.7	●	323
8703470	**14.7**				16	63.6	2.7	●	349
8693480	**14.8 - 15**		119		15	65	2.7	●	323
8703480	**14.8**				16	62.8	2.7	●	351
8693490	**14.9 - 15**	75	120		15	64	2.7	●	323
8703490	**14.9**				16	61.9	2.7	●	351
8693500	**15 - 15**				15	64	2.7	●	330
8703500	**15**				16	62.1	2.7	●	352
8693510	**15.1**	76	121	193		71	2.7	●	377
8693520	**15.2**		122			70	2.8	●	380
8693525	**15.25**	77				70	2.8	●	381
8693530	**15.3**		123			69	2.8	●	381
8693540	**15.4**		124			68	2.8	●	381

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8693550	**15.5**	78	124	193	16	68	2.8	●	381
8693560	**15.6**		125			67	2.8	●	400
8693570	**15.7**	79	126			66	2.9	●	385
8693580	**15.8**		127			65	2.9	●	387
8693590	**15.9**	80	128			64	2.9	●	390
8693600	**16**					64	2.9	●	391
8693650	**16.5 - 17**	83	132	201	17	68	3	●	453
8703650	**16.5**				18	65.2	3	●	478
8693700	**17 - 17**	85	136		17	64	3.1	●	455
8703700	**17**				18	62.1	3.1	●	485
8693750	**17.5**	88	140	209		68	3.2	●	519
8693800	**18**	90	144			64	3.3	●	528
8693850	**18.5 - 19**	93	148	217	19	68	3.4	●	593
8703850	**18.5**				20	65.2	3.4	●	629
8693900	**19 - 19**	95	152		19	64	3.5	●	600
8703900	**19**				20	62.1	3.5	●	640
8693950	**19.5**	98	156	225		68	3.5	●	679
8694000	**20**	100	160			64	3.6	●	691

2021年10月以后生产的所有尺寸都将依次改为 **R Gash** 。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1077

硬质合金内冷油孔钻头 8D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (8D TYPE)

The A Brand

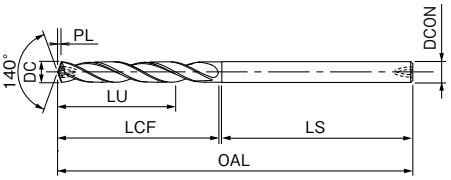
ADO-8D

切削条件 Cutting Conditions | P.390

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

R Gash



单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8694200	2 - 3	16	22	75	3	50.1	0.4	●	8
8694210	2.1 - 3	17	24			48.3	0.4	●	8
8694220	2.2 - 3	18	25			47.5	0.4	●	8
8694230	2.3 - 3	19	26			46.7	0.4	●	8
8694240	2.4 - 3	20	27			45.9	0.4	●	8
8694250	2.5 - 3		28			45.1	0.5	●	8
8694260	2.6 - 3	21	29	80		49.3	0.5	●	8
8694270	2.7 - 3	22	30			48.4	0.5	●	9
8694280	2.8 - 3	23	31			47.6	0.5	●	9
8694290	2.9 - 3	24	32			46.8	0.5	●	9
8694300	3 - 3		33			46	0.5	●	8
8694310	3.1	25	34	95	4	58.3	0.6	●	14
8694320	3.2	26	35			57.5	0.6	●	14
8694330	3.3	27	36			56.7	0.6	●	15
8694340	3.4	28	37			55.9	0.6	●	15
8694350	3.5		39			55	0.6	●	15
8694360	3.6	29	40			53.3	0.7	●	15
8694370	3.7	30	41			52.4	0.7	●	15
8694380	3.8	31	42			51.6	0.7	●	15
8694390	3.9	32	43			50.8	0.7	●	15
8694400	4		44			50	0.7	●	15
8694410	4.1 - 5	33	45	105	5	57.3	0.7	●	23
8704410	4.1				6	55.5	0.7	●	30
8694420	4.2 - 5	34	46		5	56.5	0.8	●	23
8704420	4.2				6	54.6	0.8	●	30
8694430	4.3 - 5	35	47		5	55.7	0.8	●	23
8704430	4.3				6	53.8	0.8	●	30
8694440	4.4 - 5	36	48		5	54.9	0.8	●	23
8704440	4.4				6	53	0.8	●	30
8694450	4.5 - 5		50		5	54	0.8	●	23
8704450	4.5				6	51.2	0.8	●	30
8694460	4.6 - 5	37	51		5	52.3	0.8	●	23
8704460	4.6				6	50.4	0.8	●	30
8694470	4.7 - 5	38	52		5	51.4	0.9	●	23
8704470	4.7				6	49.6	0.9	●	30
8694480	4.8 - 5	39	53		5	50.6	0.9	●	23
8704480	4.8				6	48.8	0.9	●	30
8694490	4.9 - 5	40	54		5	49.8	0.9	●	24

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8704490	4.9	40	54	105	6	47.9	0.9	●	30
8694500	5 - 5		55		5	49	0.9	●	24
8704500	5				6	47.1	0.9	●	30
8704510	5.1	41	56	115		56.3	0.9	●	34
8704520	5.2	42	57			55.5	0.9	●	34
8704530	5.3	43	58			54.7	1	●	34
8704540	5.4	44	59			53.9	1	●	35
8694550	5.5		61			52.1	1	●	34
8704560	5.6	45	62			51.3	1	●	35
8704570	5.7	46	63			50.4	1	●	36
8704580	5.8	47	64			49.6	1.1	●	36
8704590	5.9	48	65			48.8	1.1	●	37
8694600	6		66			48	1.1	●	36
8694610	6.1 - 7	49	67	125	7	57	1.1	●	49
8704610	6.1				8	53.5	1.1	●	60
8694620	6.2 - 7	50	68		7	56	1.1	●	50
8704620	6.2				8	52.6	1.1	●	60
8694630	6.3 - 7	51	69		7	55	1.1	●	50
8704630	6.3				8	51.8	1.1	●	60
8694640	6.4 - 7	52	70		7	54	1.2	●	50
8704640	6.4				8	51	1.2	●	60
8694650	6.5 - 7		72		7	52	1.2	●	49
8704650	6.5				8	49.2	1.2	●	60
8694660	6.6 - 7	53	73		7	51	1.2	●	51
8704660	6.6				8	48.4	1.2	●	60
8694670	6.7 - 7	54	74		7	50	1.2	●	51
8704670	6.7				8	47.6	1.2	●	60
8694680	6.8 - 7	55	75		7	49	1.2	●	52
8704680	6.8				8	46.8	1.2	●	60
8694690	6.9 - 7	56	76		7	48	1.3	●	52
8704690	6.9				8	45.9	1.3	●	60
8694700	7 - 7		77		7	47	1.3	●	52
8704700	7				8	45.1	1.3	●	60
8704710	7.1	57	78	140		61	1.3	●	71
8704720	7.2	58	79			60	1.3	●	72
8704730	7.3	59	80			59	1.3	●	72
8704740	7.4	60	81			58	1.3	●	72
8694750	7.5		83			56	1.4	●	72

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直径 DC 7.6～13 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-8D	◎	◎	◎	◎	◎	○	○			○	○	◎	◎	○		○	○			○	

上一页
FROM 直径 DC 2～7.5

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8704760	**7.6**	61	84	140	8	55	1.4	●	74
8704770	**7.7**	62	85			54	1.4	●	74
8704780	**7.8**	63	86			53	1.4	●	74
8704790	**7.9**	64	87			52	1.4	●	75
8694800	**8**		88			51	1.5	●	74
8694810	**8.1 - 9**	65	89	150	9	60	1.5	●	92
8704810	**8.1**				10	56.5	1.5	●	104
8694820	**8.2 - 9**	66	90		9	59	1.5	●	92
8704820	**8.2**				10	55.6	1.5	●	105
8694830	**8.3 - 9**	67	91		9	58	1.5	●	92
8704830	**8.3**				10	54.8	1.5	●	105
8694840	**8.4 - 9**	68	92		9	57	1.5	●	93
8704840	**8.4**				10	54	1.5	●	105
8694850	**8.5 - 9**		94		9	55	1.5	●	93
8704850	**8.5**				10	52.2	1.5	●	105
8694860	**8.6 - 9**	69	95		9	54	1.6	●	93
8704860	**8.6**				10	51.4	1.6	●	105
8694870	**8.7 - 9**	70	96		9	53	1.6	●	94
8704870	**8.7**				10	50.6	1.6	●	106
8694880	**8.8 - 9**	71	97		9	52	1.6	●	94
8704880	**8.8**				10	49.8	1.6	●	106
8694890	**8.9 - 9**	72	98		9	51	1.6	●	95
8704890	**8.9**				10	48.9	1.6	●	107
8694900	**9 - 9**		99		9	50	1.6	●	96
8704900	**9**				10	48.1	1.6	●	108
8704910	**9.1**	73	100	160		59	1.7	●	120
8704920	**9.2**	74	101			58	1.7	●	120
8704930	**9.3**	75	102			57	1.7	●	121
8704940	**9.4**	76	103			56	1.7	●	122
8694950	**9.5**		105			54	1.7	●	121
8704960	**9.6**	77	106			53	1.7	●	122
8704970	**9.7**	78	107			52	1.8	●	124
8704980	**9.8**	79	108			51	1.8	●	124
8704990	**9.9**	80	109			50	1.8	●	125
8695000	**10**		110			49	1.8	●	125
8695010	**10.1 - 11**	81	111	182	11	70	1.8	●	167
8705010	**10.1**				12	66.5	1.8	●	186
8695020	**10.2 - 11**	82	112		11	69	1.9	●	168
8705020	**10.2**	82	112	182	12	65.6	1.9	●	186
8695030	**10.3 - 11**	83	113		11	68	1.9	●	169
8705030	**10.3**				12	64.8	1.9	●	188
8695040	**10.4 - 11**	84	114		11	67	1.9	●	170
8705040	**10.4**				12	64	1.9	●	188
8695050	**10.5 - 11**		116		11	65	1.9	●	170
8705050	**10.5**				12	62.2	1.9	●	188
8695060	**10.6 - 11**	85	117		11	64	1.9	●	170
8705060	**10.6**				12	61.4	1.9	●	188
8695070	**10.7 - 11**	86	118		11	63	1.9	●	171
8705070	**10.7**				12	60.6	1.9	●	188
8695080	**10.8 - 11**	87	119		11	62	2	●	172
8705080	**10.8**				12	59.8	2	●	189
8695090	**10.9 - 11**	88	120		11	61	2	●	173
8705090	**10.9**				12	58.9	2	●	191
8695100	**11 - 11**		121		11	60	2	●	176
8705100	**11**				12	58.1	2	●	192
8705110	**11.1**	89	122	194		71	2	●	215
8705120	**11.2**	90	123			70	2	●	217
8705130	**11.3**	91	124			69	2.1	●	219
8705140	**11.4**	92	125			68	2.1	●	219
8695150	**11.5**		127			66	2.1	●	219
8705160	**11.6**	93	128			65	2.1	●	219
8705170	**11.7**	94	129			64	2.1	●	220
8705180	**11.8**	95	130			63	2.1	●	224
8705190	**11.9**	96	131			62	2.2	●	224
8695200	**12**		132			61	2.2	●	225
8705210	**12.1**	97	133	206	14	68.5	2.2	●	286
8705220	**12.2**	98	134			67.6	2.2	●	290
8705230	**12.3**	99	135			66.8	2.2	●	290
8705240	**12.4**	100	136			66	2.3	●	291
8695250	**12.5 - 13**		138		13	67	2.3	●	270
8705250	**12.5**				14	64.2	2.3	●	291
8705260	**12.6**	101	139			63.4	2.3	●	291
8705270	**12.7**	102	140			62.6	2.3	●	291
8705280	**12.8**	103	141			61.8	2.3	●	293
8705290	**12.9**	104	142			60.9	2.3	●	293
8695300	**13 - 13**		143		13	62	2.4	●	274

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直径 DC 13～16 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1077**

硬质合金内冷油孔钻头 8D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (8D TYPE)

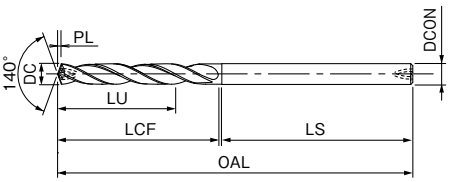
The A Brand

ADO-8D

切削条件 Cutting Conditions | P.390

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

R Gash



CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

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FROM 直径 DC 7.6～13

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8705300	**13**	104	143	206	14	60.1	2.4	●	296
8705310	**13.1**	105	144	218		73	2.4	●	325
8705320	**13.2**	106	145			72	2.4	●	326
8705330	**13.3**	107	146			71	2.4	●	327
8705340	**13.4**	108	147			70	2.4	●	329
8705350	**13.5**		149			68	2.5	●	330
8705360	**13.6**	109	150			67	2.5	●	330
8705370	**13.7**	110	151			66	2.5	●	331
8705380	**13.8**	111	152			65	2.5	●	334
8705390	**13.9**	112	153			64	2.5	●	336
8705400	**14**		154			63	2.5	●	336
8705410	**14.1**	113	155	230	16	70.5	2.6	●	415
8705420	**14.2**	114	156			69.6	2.6	●	418
8705430	**14.3**	115	157			68.8	2.6	●	420
8705440	**14.4**	116	158			68	2.6	●	421
8705450	**14.5**		160			66.2	2.6	●	421

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8705460	**14.6**	117	161	230	16	65.4	2.7	●	421
8705470	**14.7**	118	162			64.6	2.7	●	421
8705480	**14.8**	119	163			63.8	2.7	●	423
8705490	**14.9**	120	164			62.9	2.7	●	427
8705500	**15**		165			62.1	2.7	●	428
8705510	**15.1**	121	166	241		74	2.7	●	459
8705520	**15.2**	122	167			73	2.8	●	464
8705530	**15.3**	123	168			72	2.8	●	467
8705540	**15.4**	124	169			71	2.8	●	467
8705550	**15.5**		171			69	2.8	●	468
8705560	**15.6**	125	172			68	2.8	●	470
8705570	**15.7**	126	173			67	2.9	●	473
8705580	**15.8**	127	174			66	2.9	●	475
8705590	**15.9**	128	175			65	2.9	●	476
8705600	**16**		176			64	2.9	●	481

2021年10月以后生产的所有尺寸都将依次改为 **R Gash** 。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-8D	◎	◎	◎	◎	◎	○	○			○	○	◎	◎	○		○	○			○	

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

硬质合金内冷油孔钻头 10D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (10D TYPE)

The A Brand

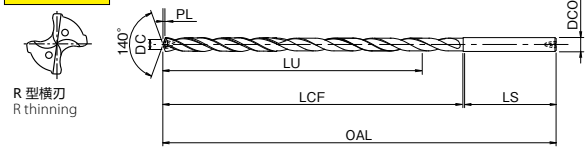
ADO-10D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140°$^{0}_{-4}$°。
Tolerance of the point angle is 140°$^{0}_{-4}$°

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8696200	2 - 3	20	26	75	3	40	0.4	●	7
8696210	2.1 - 3	21	33			40	0.4	●	7
8696220	2.2 - 3	22				40	0.4	●	7
8696230	2.3 - 3	23				40	0.4	●	7
8696240	2.4 - 3	24				40	0.4	●	7
8696250	2.5 - 3	25				40	0.5	●	8
8696260	2.6 - 3	26	40	90		40	0.5	●	9
8696270	2.7 - 3	27				40	0.5	●	9
8696280	2.8 - 3	28				40	0.5	●	9
8696290	2.9 - 3	29				40	0.5	●	9
8696300	3 - 3	30				50	0.5	●	9
8696310	3.1	31	45	100	4	50	0.6	●	14
8696320	3.2	32				50	0.6	●	14
8696330	3.3	33				50	0.6	●	14
8696340	3.4	34	50			48	0.6	●	14
8696350	3.5	35				48	0.6	●	14
8696360	3.6	36				48	0.7	●	14
8696370	3.7	37				48	0.7	●	15
8696380	3.8	38				48	0.7	●	15
8696390	3.9	39				48	0.7	●	15
8696400	4	40				50	0.7	●	15
8696410	4.1 - 5	41	55	115	5	58	0.7	●	24
8710410	4.1				6	48.3	0.7	●	29
8696420	4.2 - 5	42			5	58	0.8	●	24
8710420	4.2				6	48.4	0.8	●	29
8696430	4.3 - 5	43	60		5	53	0.8	●	22
8710430	4.3				6	48.4	0.8	●	29
8696440	4.4 - 5	44			5	53	0.8	●	24
8710440	4.4				6	48.5	0.8	●	29
8696450	4.5 - 5	45			5	53	0.8	●	23
8710450	4.5				6	48.6	0.8	●	29
8696460	4.6 - 5	46			5	53	0.8	●	24
8710460	4.6				6	48.7	0.8	●	29
8696470	4.7 - 5	47	65		5	48	0.9	●	24
8710470	4.7				6	46.8	0.9	●	29
8696480	4.8 - 5	48			5	48	0.9	●	—
8710480	4.8				6	46.9	0.9	●	30

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8696490	4.9 - 5	49	65	115	5	48	0.9	●	22
8710490	4.9				6	47	0.9	●	30
8696500	5 - 5	50			5	50	0.9	●	24
8710500	5				6	47	0.9	●	31
8710510	5.1	51	70	128		50	0.9	●	37
8710520	5.2	52				50	0.9	●	37
8710530	5.3	53				50	1	●	37
8710540	5.4	54	78			48	1	●	37
8696550	5.5	55				48	1	●	36
8710560	5.6	56				48	1	●	37
8710570	5.7	57				48	1	●	37
8710580	5.8	58				48	1.1	●	38
8710590	5.9	59				48	1.1	●	38
8696600	6	60				50	1.1	●	39
8696610	6.1 - 7	61	87	140	7	51	1.1	●	49
8710610	6.1				8	48.2	1.1	●	58
8696620	6.2 - 7	62			7	51	1.1	●	49
8710620	6.2				8	48.3	1.1	●	59
8696630	6.3 - 7	63			7	51	1.1	●	50
8710630	6.3				8	48.4	1.1	●	60
8696640	6.4 - 7	64			7	51	1.2	●	51
8710640	6.4				8	48.5	1.2	●	60
8696650	6.5 - 7	65			7	51	1.2	●	51
8710650	6.5				8	48.6	1.2	●	61
8696660	6.6 - 7	66			7	51	1.2	●	52
8710660	6.6				8	48.7	1.2	●	61
8696670	6.7 - 7	67			7	51	1.2	●	52
8710670	6.7				8	48.7	1.2	●	61
8696680	6.8 - 7	68	90		7	48	1.2	●	52
8710680	6.8				8	46.8	1.2	●	61
8696690	6.9 - 7	69			7	48	1.3	●	52
8710690	6.9				8	46.9	1.3	●	62
8696700	7 - 7	70			7	50	1.3	●	53
8710700	7				8	47	1.3	●	62
8710710	7.1	71	100	155		50	1.3	●	69
8710720	7.2	72				50	1.3	●	69
8710730	7.3	73				50	1.3	●	71

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直径 DC 7.4～12.5 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-10D	◎	◎	◎	◎	○					○*	○	◎	◎								

*不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1078

硬质合金内冷油孔钻头 10D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (10D TYPE)

The A Brand

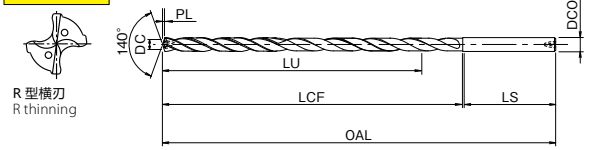
ADO-10D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140° $^{0°}_{-4°}$。
Tolerance of the point angle is 140° $^{0°}_{-4°}$

上一页

FROM 直径 DC 2～7.3

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8710740	**7.4**	74	100	155	8	50	1.3	●	72
8696750	**7.5**	75				53	1.4	●	72
8710760	**7.6**	76	105			48	1.4	●	72
8710770	**7.7**	77				48	1.4	●	72
8710780	**7.8**	78				48	1.4	●	73
8710790	**7.9**	79				48	1.4	●	73
8696800	**8**	80				50	1.5	●	75
8696810	**8.1 - 9**	81	110	165	9	53	1.5	●	87
8710810	**8.1**				10	48.2	1.5	●	100
8696820	**8.2 - 9**	82			9	53	1.5	●	89
8710820	**8.2**				10	48.3	1.5	●	100
8696830	**8.3 - 9**	83			9	53	1.5	●	89
8710830	**8.3**				10	48.4	1.5	●	102
8696840	**8.4 - 9**	84			9	53	1.5	●	92
8710840	**8.4**				10	48.4	1.5	●	103
8696850	**8.5 - 9**	85			9	53	1.5	●	93
8710850	**8.5**				10	48.5	1.5	●	105
8696860	**8.6 - 9**	86	115		9	48	1.6	●	91
8710860	**8.6**				10	46.6	1.6	●	103
8696870	**8.7 - 9**	87			9	48	1.6	●	92
8710870	**8.7**				10	46.7	1.6	●	106
8696880	**8.8 - 9**	88			9	48	1.6	●	93
8710880	**8.8**				10	46.8	1.6	●	107
8696890	**8.9 - 9**	89			9	48	1.6	●	94
8710890	**8.9**				10	46.9	1.6	●	108
8696900	**9 - 9**	90			9	50	1.6	●	95
8710900	**9**				10	47	1.6	●	108
8710910	**9.1**	91	125	190		60	1.7	●	128
8710920	**9.2**	92				60	1.7	●	132
8710930	**9.3**	93				60	1.7	●	132
8710940	**9.4**	94				60	1.7	●	132
8696950	**9.5**	95				63	1.7	●	133
8710960	**9.6**	96	130			58	1.7	●	131
8710970	**9.7**	97				58	1.8	●	134

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8710980	**9.8**	98	130	190	10	58	1.8	●	134
8710990	**9.9**	99				58	1.8	●	134
8697000	**10**	100				60	1.8	●	137
8697010	**10.1 - 11**	101	140	205	11	63	1.8	●	171
8711010	**10.1**				12	58.2	1.8	●	187
8697020	**10.2 - 11**	102			11	63	1.9	●	171
8711020	**10.2**				12	58.3	1.9	●	188
8697030	**10.3 - 11**	103			11	63	1.9	●	171
8711030	**10.3**				12	58.4	1.9	●	191
8697040	**10.4 - 11**	104			11	63	1.9	●	173
8711040	**10.4**				12	58.4	1.9	●	193
8697050	**10.5 - 11**	105			11	63	1.9	●	175
8711050	**10.5**				12	58.5	1.9	●	193
8697060	**10.6 - 11**	106			11	63	1.9	●	175
8711060	**10.6**				12	58.6	1.9	●	196
8697070	**10.7 - 11**	107			11	63	1.9	●	176
8711070	**10.7**				12	58.7	1.9	●	198
8697080	**10.8 - 11**	108	145		11	58	2	●	177
8711080	**10.8**				12	56.8	2	●	198
8697090	**10.9 - 11**	109			11	58	2	●	178
8711090	**10.9**				12	56.9	2	●	198
8697100	**11 - 11**	110			11	58	2	●	181
8711100	**11**				12	57	2	●	200
8711110	**11.1**	111	155	215		58	2	●	206
8711120	**11.2**	112				58	2	●	209
8711130	**11.3**	113				58	2.1	●	210
8711140	**11.4**	114				58	2.1	●	211
8711150	**11.5**	115				58	2.1	●	215
8711160	**11.6**	116				58	2.1	●	216
8711170	**11.7**	117				58	2.1	●	217
8711180	**11.8**	118				58	2.1	●	219
8711190	**11.9**	119				58	2.2	●	222
8697200	**12**	120				58	2.2	●	222
8711250	**12.5**	125			14	56.3	2.3	●	—

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All sizes after October 2021 production will be sequentially changed to **R Gash**.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-10D	◎	◎	◎	◎	○					○*	○	◎	◎								

* 不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

硬质合金内冷油孔钻头 15D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (15D TYPE)

The A Brand

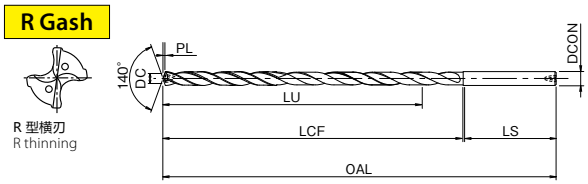
ADO-15D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140°$^{0}_{-4}$°。
Tolerance of the point angle is 140°$^{0}_{-4}$°

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8698300	3 - 3	45	55	105	3	50	0.5	●	12
8698310	3.1	47	60	125	4	63	0.6	●	18
8698320	3.2	48				63	0.6	●	18
8698330	3.3	50				63	0.6	●	19
8698340	3.4	51	65			58	0.6	●	19
8698350	3.5	53				58	0.6	●	19
8698360	3.6	54				58	0.7	●	19
8698370	3.7	56				58	0.7	●	19
8698380	3.8	57	75			48	0.7	●	19
8698390	3.9	59				48	0.7	●	19
8698400	4	60				50	0.7	●	19
8698410	4.1 - 5	62		140	5	63	0.7	●	28
8712410	4.1				6	45	0.7	●	33
8698420	4.2 - 5	63			5	63	0.8	●	29
8712420	4.2				6	45	0.8	●	33
8698430	4.3 - 5	65	85		5	53	0.8	●	29
8712430	4.3				6	45	0.8	●	33
8698440	4.4 - 5	66			5	53	0.8	●	29
8712440	4.4				6	45	0.8	●	33
8698450	4.5 - 5	68			5	53	0.8	●	28
8712450	4.5				6	45	0.8	●	34
8698460	4.6 - 5	69			5	53	0.8	●	29
8712460	4.6				6	45	0.8	●	34
8698470	4.7 - 5	71			5	53	0.9	●	29
8712470	4.7				6	45	0.9	●	35
8698480	4.8 - 5	72	90		5	48	0.9	●	29
8712480	4.8				6	45	0.9	●	35
8698490	4.9 - 5	74			5	48	0.9	●	29
8712490	4.9				6	45	0.9	●	35
8698500	5 - 5	75			5	50	0.9	●	29
8712500	5				6	45	0.9	●	36
8712510	5.1	77	95	160		63	0.9	●	44
8712520	5.2	78				63	0.9	●	44

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8712530	5.3	80	95	160	6	63	1	●	44
8712540	5.4	81	110			48	1	●	44
8698550	5.5	83				48	1	●	41
8712560	5.6	84				48	1	●	44
8712570	5.7	86				48	1	●	44
8712580	5.8	87				48	1.1	●	44
8712590	5.9	89				48	1.1	●	45
8698600	6	90				50	1.1	●	43
8698610	6.1 - 7	92	120	175	7	53	1.1	●	55
8712610	6.1				8	45	1.1	●	65
8698620	6.2 - 7	93			7	53	1.1	●	56
8712620	6.2				8	45	1.1	●	65
8698630	6.3 - 7	95			7	53	1.1	●	56
8712630	6.3				8	45	1.1	●	68
8698640	6.4 - 7	96			7	53	1.2	●	58
8712640	6.4				8	45	1.2	●	68
8698650	6.5 - 7	98			7	53	1.2	●	58
8712650	6.5				8	45	1.2	●	68
8698660	6.6 - 7	99			7	53	1.2	●	59
8712660	6.6				8	45	1.2	●	68
8698670	6.7 - 7	101			7	53	1.2	●	60
8712670	6.7				8	45	1.2	●	70
8698680	6.8 - 7	102	125		7	48	1.2	●	61
8712680	6.8				8	45	1.2	●	70
8698690	6.9 - 7	104			7	48	1.3	●	61
8712690	6.9				8	45	1.3	●	70
8698700	7 - 7	105			7	48	1.3	●	62
8712700	7					45	1.3	●	70
8712710	7.1	107	135	195	8	58	1.3	●	83
8712720	7.2	108				58	1.3	●	85
8712730	7.3	110				58	1.3	●	85
8712740	7.4	111				58	1.3	●	88
8698750	7.5	113				58	1.4	●	88

下一页 直径 DC 7.6～12.5 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-15D	◎	◎	◎	◎	○					○*	○	◎	◎								

*不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1079

硬质合金内冷油孔钻头 15D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (15D TYPE)

The A Brand

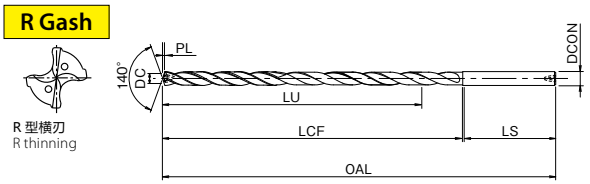
ADO-15D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140° $^{0°}_{-4°}$。
Tolerance of the point angle is 140° $^{0°}_{-4°}$

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FROM 直径 DC 3～7.5

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8712760	**7.6**	114	145	195	8	48	1.4	●	88
8712770	**7.7**	116				48	1.4	●	88
8712780	**7.8**	117				48	1.4	●	89
8712790	**7.9**	119				48	1.4	●	90
8698800	**8**	120				50	1.5	●	86
8698810	**8.1 - 9**	122	155	210	9	53	1.5	●	106
8712810	**8.1**				10	45	1.5	●	117
8698820	**8.2 - 9**	123			9	53	1.5	●	106
8712820	**8.2**				10	45	1.5	●	117
8698830	**8.3 - 9**	125			9	53	1.5	●	106
8712830	**8.3**				10	45	1.5	●	119
8698840	**8.4 - 9**	126			9	53	1.5	●	110
8712840	**8.4**				10	45	1.5	●	120
8698850	**8.5 - 9**	128			9	53	1.5	●	109
8712850	**8.5**				10	45	1.5	●	122
8698860	**8.6 - 9**	129	160		9	48	1.6	●	110
8712860	**8.6**				10	45	1.6	●	123
8698870	**8.7 - 9**	131			9	48	1.6	●	108
8712870	**8.7**				10	45	1.6	●	124
8698880	**8.8 - 9**	132			9	48	1.6	●	112
8712880	**8.8**				10	45	1.6	●	126
8698890	**8.9 - 9**	134			9	48	1.6	●	116
8712890	**8.9**				10	45	1.6	●	128
8698900	**9 - 9**	135			9	48	1.6	●	116
8712900	**9**				10	45	1.6	●	130
8712910	**9.1**	137	170	240		68	1.7	●	153
8712920	**9.2**	138				68	1.7	●	162
8712930	**9.3**	140				68	1.7	●	162
8712940	**9.4**	141				68	1.7	●	162
8698950	**9.5**	143				68	1.7	●	160
8712960	**9.6**	144	180			58	1.7	●	162
8712970	**9.7**	146				58	1.8	●	162
8712980	**9.8**	147				58	1.8	●	162

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8712990	**9.9**	149	180	240	10	58	1.8	●	163
8699000	**10**	150				60	1.8	●	165
8699010	**10.1 - 11**	152	190	260	11	68	1.8	●	206
8713010	**10.1**				12	45	1.8	●	212
8699020	**10.2 - 11**	153			11	68	1.9	●	206
8713020	**10.2**				12	45	1.9	●	216
8699030	**10.3 - 11**	155			11	68	1.9	●	206
8713030	**10.3**				12	45	1.9	●	218
8699040	**10.4 - 11**	156			11	68	1.9	●	214
8713040	**10.4**				12	45	1.9	●	222
8699050	**10.5 - 11**	158			11	68	1.9	●	208
8713050	**10.5**				12	45	1.9	●	223
8699060	**10.6 - 11**	159			11	68	1.9	●	213
8713060	**10.6**				12	45	1.9	●	226
8699070	**10.7 - 11**	161	200		11	58	1.9	●	213
8713070	**10.7**				12	45	1.9	●	225
8699080	**10.8 - 11**	162			11	58	2	●	207
8713080	**10.8**				12	45	2	●	227
8699090	**10.9 - 11**	164			11	58	2	●	215
8713090	**10.9**				12	45	2	●	231
8699100	**11 - 11**	165			11	58	2	●	216
8713100	**11**					45	2	●	231
8713110	**11.1**	167	210	280	12	68	2	●	260
8713120	**11.2**	168				68	2	●	261
8713130	**11.3**	170				68	2.1	●	263
8713140	**11.4**	171				68	2.1	●	265
8713150	**11.5**	173				68	2.1	●	272
8713160	**11.6**	174				68	2.1	●	273
8713170	**11.7**	176				68	2.1	●	276
8713180	**11.8**	177				68	2.1	●	277
8713190	**11.9**	179	215			63	2.2	●	280
8699200	**12**	180				63	2.2	●	275
8713250	**12.5**	188	225	290	14	61.3	2.3	●	356

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All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-15D	◎	◎	◎	◎	○					○*	○	◎	◎								

* 不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

硬质合金内冷油孔钻头 20D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (20D TYPE)

The A Brand

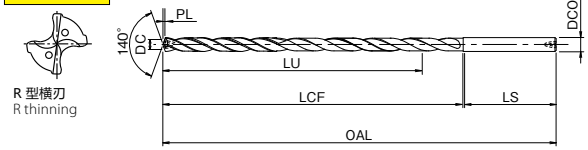
ADO-20D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140°$^{0}_{-4}$°。
Tolerance of the point angle is 140°$^{0}_{-4}$

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8706300	3 - 3	60	70	120	3	48	0.5	●	12
8706310	3.1	62	80	140	4	58	0.6	●	18
8706320	3.2	64				58	0.6	●	19
8706330	3.3	66				58	0.6	●	19
8706340	3.4	68	85			53	0.6	●	19
8706350	3.5	70				53	0.6	●	19
8706360	3.6	72				53	0.7	●	19
8706370	3.7	74				53	0.7	●	19
8706380	3.8	76	90			48	0.7	●	19
8706390	3.9	78				48	0.7	●	19
8706400	4	80				50	0.7	●	20
8706410	4.1 - 5	82	100	165	5	63	0.7	●	31
8714410	4.1				6	45	0.7	●	35
8706420	4.2 - 5	84			5	63	0.8	●	31
8714420	4.2				6	45	0.8	●	35
8706430	4.3 - 5	86	110		5	53	0.8	●	31
8714430	4.3				6	45	0.8	●	36
8706440	4.4 - 5	88			5	53	0.8	●	31
8714440	4.4				6	45	0.8	●	36
8706450	4.5 - 5	90			5	53	0.8	●	31
8714450	4.5				6	45	0.8	●	36
8706460	4.6 - 5	92			5	53	0.8	●	31
8714460	4.6				6	45	0.8	●	37
8706470	4.7 - 5	94			5	53	0.9	●	33
8714470	4.7				6	45	0.9	●	37
8706480	4.8 - 5	96	115		5	48	0.9	●	31
8714480	4.8				6	45	0.9	●	37
8706490	4.9 - 5	98			5	48	0.9	●	39
8714490	4.9				6	45	0.9	●	40
8706500	5 - 5	100			5	50	0.9	●	39
8714500	5				6	45	0.9	●	40
8714510	5.1	102	120	190		68	0.9	●	48
8714520	5.2	104				68	0.9	●	49

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8714530	5.3	106	120	190	6	68	1	●	49
8714540	5.4	108	140			48	1	●	49
8706550	5.5	110				48	1	●	46
8714560	5.6	112				48	1	●	49
8714570	5.7	114				48	1	●	49
8714580	5.8	116				48	1.1	●	49
8714590	5.9	118				48	1.1	●	49
8706600	6	120				50	1.1	●	53
8706610	6.1 - 7	122	155	210	7	53	1.1	●	63
8714610	6.1				8	45	1.1	●	75
8706620	6.2 - 7	124			7	53	1.1	●	64
8714620	6.2				8	45	1.1	●	75
8706630	6.3 - 7	126			7	53	1.1	●	66
8714630	6.3				8	45	1.1	●	75
8706640	6.4 - 7	128			7	53	1.2	●	68
8714640	6.4				8	45	1.2	●	77
8706650	6.5 - 7	130			7	53	1.2	●	68
8714650	6.5				8	45	1.2	●	79
8706660	6.6 - 7	132			7	53	1.2	●	70
8714660	6.6				8	45	1.2	●	79
8706670	6.7 - 7	134			7	53	1.2	●	71
8714670	6.7				8	45	1.2	●	80
8706680	6.8 - 7	136	160		7	48	1.2	●	70
8714680	6.8				8	45	1.2	●	82
8706690	6.9 - 7	138			7	48	1.3	●	72
8714690	6.9				8	45	1.3	●	82
8706700	7 - 7	140			7	48	1.3	●	72
8714700	7				8	45	1.3	●	82
8714710	7.1	142	170	230		58	1.3	●	93
8714720	7.2	144				58	1.3	●	95
8714730	7.3	146				58	1.3	●	97
8714740	7.4	148				58	1.3	●	99
8706750	7.5	150				58	1.4	●	99

下一页
直径 DC 7.6～12.5 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-20D	◎	◎	◎	◎	○					○*	○	◎	◎								

*不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1080

硬质合金内冷油孔钻头 20D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (20D TYPE)

The A Brand

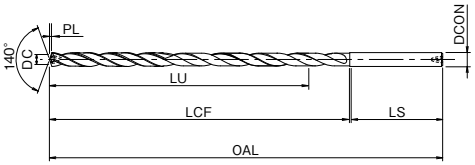
ADO-20D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140° $^{0°}_{-4°}$。
Tolerance of the point angle is 140° $^{0°}_{-4°}$

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FROM 直径 DC 3～7.5

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8714760	**7.6**	152	180	230	8	48	1.4	●	99
8714770	**7.7**	154				48	1.4	●	99
8714780	**7.8**	156				48	1.4	●	99
8714790	**7.9**	158				48	1.4	●	99
8706800	**8**	160				50	1.5	●	100
8706810	**8.1 - 9**	162	195	260	9	63	1.5	●	130
8714810	**8.1**				10	45	1.5	●	132
8706820	**8.2 - 9**	164			9	63	1.5	●	130
8714820	**8.2**				10	45	1.5	●	137
8706830	**8.3 - 9**	166			9	63	1.5	●	130
8714830	**8.3**				10	45	1.5	●	139
8706840	**8.4 - 9**	168			9	63	1.5	●	133
8714840	**8.4**				10	45	1.5	●	142
8706850	**8.5 - 9**	170			9	63	1.5	●	134
8714850	**8.5**				10	45	1.5	●	145
8706860	**8.6 - 9**	172	210		9	48	1.6	●	133
8714860	**8.6**				10	45	1.6	●	145
8706870	**8.7 - 9**	174			9	48	1.6	●	137
8714870	**8.7**				10	45	1.6	●	145
8706880	**8.8 - 9**	176			9	48	1.6	●	132
8714880	**8.8**				10	45	1.6	●	150
8706890	**8.9 - 9**	178			9	48	1.6	●	135
8714890	**8.9**				10	45	1.6	●	150
8706900	**9 - 9**	180			9	48	1.6	●	137
8714900	**9**				10	45	1.6	●	152
8714910	**9.1**	182	220	290		68	1.7	●	178
8714920	**9.2**	184				68	1.7	●	177
8714930	**9.3**	186				68	1.7	●	182
8714940	**9.4**	188				68	1.7	●	182
8706950	**9.5**	190				68	1.7	●	182
8714960	**9.6**	192	230			58	1.7	●	182
8714970	**9.7**	194				58	1.8	●	184
8714980	**9.8**	196				58	1.8	●	186

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8714990	**9.9**	198	230	290	10	58	1.8	●	189
8707000	**10**	200				58	1.8	●	190
8707010	**10.1 - 11**	202	250	310	11	58	1.8	●	226
8715010	**10.1**				12	45	1.8	●	235
8707020	**10.2 - 11**	204			11	58	1.9	●	226
8715020	**10.2**				12	45	1.9	●	238
8707030	**10.3 - 11**	206			11	58	1.9	●	226
8715030	**10.3**				12	45	1.9	●	241
8707040	**10.4 - 11**	208			11	58	1.9	●	227
8715040	**10.4**				12	45	1.9	●	245
8707050	**10.5 - 11**	210			11	58	1.9	●	227
8715050	**10.5**				12	45	1.9	●	248
8707060	**10.6 - 11**	212			11	58	1.9	●	232
8715060	**10.6**				12	45	1.9	●	253
8707070	**10.7 - 11**	214			11	58	1.9	●	235
8715070	**10.7**				12	45	1.9	●	255
8707080	**10.8 - 11**	216			11	58	2	●	237
8715080	**10.8**				12	45	2	●	263
8707090	**10.9 - 11**	218			11	58	2	●	244
8715090	**10.9**				12	45	2	●	263
8707100	**11 - 11**	220			11	58	2	●	244
8715100	**11**				12	45	2	●	263
8715110	**11.1**	222	270	330		58	2	●	301
8715120	**11.2**	224				58	2	●	311
8715130	**11.3**	226				58	2.1	●	314
8715140	**11.4**	228				58	2.1	●	314
8715150	**11.5**	230				58	2.1	●	319
8715160	**11.6**	232				58	2.1	●	321
8715170	**11.7**	234				58	2.1	●	328
8715180	**11.8**	236				58	2.1	●	332
8715190	**11.9**	238				58	2.2	●	336
8707200	**12**	240				58	2.2	●	332
8715250	**12.5**	250	280		14	46.3	2.3	●	—

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-20D	◎	◎	◎	◎	○					○*	○	◎	◎								

* 不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

硬质合金内冷油孔钻头 25D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (25D TYPE)

The A Brand

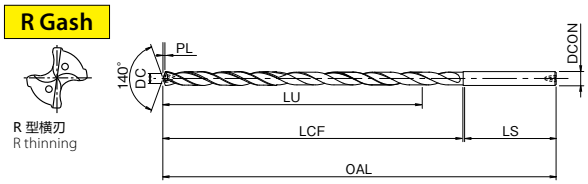
ADO-25D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140°$^{0}_{-4^\circ}$。
Tolerance of the point angle is 140°$^{0}_{-4^\circ}$

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8726300	3 - 3	75	85	135	3	48	0.5	●	13
8724310	3.1	78	95	165	4	68	0.6	●	21
8724320	3.2	80				68	0.6	●	21
8724330	3.3	83				68	0.6	●	21
8724340	3.4	85	105			58	0.6	●	21
8724350	3.5	88				58	0.6	●	21
8724360	3.6	90				58	0.7	●	21
8724370	3.7	93				58	0.7	●	21
8724380	3.8	95	115			48	0.7	●	21
8724390	3.9	98				48	0.7	●	21
8724400	4	100				48	0.7	●	22
8726410	4.1 - 5	103	120	190	5	68	0.7	●	33
8724410	4.1				6	45	0.7	●	—
8726420	4.2 - 5	105			5	68	0.8	●	34
8724420	4.2				6	45	0.8	●	—
8726430	4.3 - 5	108	135		5	53	0.8	●	32
8724430	4.3				6	45	0.8	●	36
8726440	4.4 - 5	110			5	53	0.8	●	33
8724440	4.4				6	45	0.8	●	37
8726450	4.5 - 5	113			5	53	0.8	●	34
8724450	4.5				6	45	0.8	●	37
8726460	4.6 - 5	115			5	53	0.8	●	33
8724460	4.6				6	45	0.8	●	38
8726470	4.7 - 5	118			5	53	0.9	●	34
8724470	4.7				6	45	0.9	●	40
8726480	4.8 - 5	120	140		5	48	0.9	●	34
8724480	4.8				6	45	0.9	●	48
8726490	4.9 - 5	123			5	48	0.9	●	35
8724490	4.9				6	45	0.9	●	—
8726500	5 - 5	125			5	48	0.9	●	37
8724500	5				6	45	0.9	●	41
8724510	5.1	128	150	220		68	0.9	●	54
8724520	5.2	130				68	0.9	●	54

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8724530	5.3	133	150	220	6	68	1	●	55
8724540	5.4	135	170			48	1	●	52
8724550	5.5	138				48	1	●	53
8724560	5.6	140				48	1	●	54
8724570	5.7	143				48	1	●	55
8724580	5.8	145				48	1.1	●	56
8724590	5.9	148				48	1.1	●	57
8724600	6	150				48	1.1	●	60
8726610	6.1 - 7	153	190	250	7	58	1.1	●	71
8724610	6.1				8	45	1.1	●	82
8726620	6.2 - 7	155			7	58	1.1	●	75
8724620	6.2				8	45	1.1	●	83
8726630	6.3 - 7	158			7	58	1.1	●	75
8724630	6.3				8	45	1.1	●	85
8726640	6.4 - 7	160			7	58	1.2	●	76
8724640	6.4				8	45	1.2	●	86
8726650	6.5 - 7	163			7	58	1.2	●	76
8724650	6.5				8	45	1.2	●	88
8726660	6.6 - 7	165			7	58	1.2	●	79
8724660	6.6				8	45	1.2	●	88
8726670	6.7 - 7	168			7	58	1.2	●	82
8724670	6.7				8	45	1.2	●	90
8726680	6.8 - 7	170	200		7	48	1.2	●	80
8724680	6.8				8	45	1.2	●	90
8726690	6.9 - 7	173			7	48	1.3	●	80
8724690	6.9				8	45	1.3	●	91
8726700	7 - 7	175			7	48	1.3	●	84
8724700	7				8	45	1.3	●	91
8724710	7.1	178	210	275		63	1.3	●	108
8724720	7.2	180				63	1.3	●	113
8724730	7.3	183				63	1.3	●	113
8724740	7.4	185				63	1.3	●	113
8724750	7.5	188				63	1.4	●	116

下一页 直径 DC 7.6～12 NEXT

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-25D	◎	◎	◎	◎	○					○*	○	◎	◎								

*不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1081

硬质合金内冷油孔钻头 25D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (25D TYPE)

The A Brand

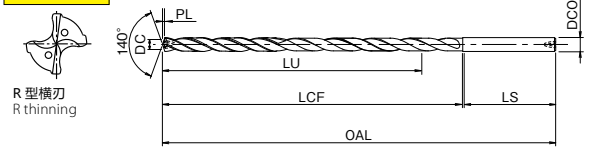
ADO-25D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140° $^{0°}_{-4°}$。
Tolerance of the point angle is 140° $^{0°}_{-4°}$

上一页
FROM 直径 DC 3～7.5

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8724760	**7.6**	190	225	275	8	48	1.4	●	110
8724770	**7.7**	193				48	1.4	●	113
8724780	**7.8**	195				48	1.4	●	113
8724790	**7.9**	198				48	1.4	●	116
8724800	**8**	200				48	1.5	●	120
8726810	**8.1 - 9**	203	240	305	9	63	1.5	●	138
8724810	**8.1**				10	45	1.5	●	148
8726820	**8.2 - 9**	205			9	63	1.5	●	141
8724820	**8.2**				10	45	1.5	●	150
8726830	**8.3 - 9**	208			9	63	1.5	●	144
8724830	**8.3**				10	45	1.5	●	153
8726840	**8.4 - 9**	210			9	63	1.5	●	145
8724840	**8.4**				10	45	1.5	●	154
8726850	**8.5 - 9**	213			9	63	1.5	●	150
8724850	**8.5**				10	45	1.5	●	159
8726860	**8.6 - 9**	215	255		9	48	1.6	●	146
8724860	**8.6**				10	45	1.6	●	160
8726870	**8.7 - 9**	218			9	48	1.6	●	149
8724870	**8.7**				10	45	1.6	●	161
8726880	**8.8 - 9**	220			9	48	1.6	●	149
8724880	**8.8**				10	45	1.6	●	164
8726890	**8.9 - 9**	223			9	48	1.6	●	151
8724890	**8.9**				10	45	1.6	●	165
8726900	**9 - 9**	225			9	48	1.6	●	156
8724900	**9**				10	45	1.6	●	168
8724910	**9.1**	228	270	340		68	1.7	●	195
8724920	**9.2**	230				68	1.7	●	198
8724930	**9.3**	233				68	1.7	●	226
8724940	**9.4**	235				68	1.7	●	205
8724950	**9.5**	238				68	1.7	●	205
8724960	**9.6**	240	280			58	1.7	●	201
8724970	**9.7**	243				58	1.8	●	230
8724980	**9.8**	245				58	1.8	●	207

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8724990	**9.9**	248	280	340	10	58	1.8	●	209
8725000	**10**	250				58	1.8	●	214
8727010	**10.1 -11**	253	310	370	11	58	1.8	●	271
8725010	**10.1**				12	45	1.8	●	262
8727020	**10.2 -11**	255			11	58	1.9	●	279
8725020	**10.2**				12	45	1.9	●	268
8727030	**10.3 -11**	258			11	58	1.9	●	277
8725030	**10.3**				12	45	1.9	●	271
8727040	**10.4 -11**	260			11	58	1.9	●	282
8725040	**10.4**				12	45	1.9	●	273
8727050	**10.5 -11**	263			11	58	1.9	●	284
8725050	**10.5**				12	45	1.9	●	279
8727060	**10.6 -11**	265			11	58	1.9	●	294
8725060	**10.6**				12	45	1.9	●	283
8727070	**10.7 -11**	268			11	58	1.9	●	272
8725070	**10.7**				12	45	1.9	●	287
8727080	**10.8 -11**	270			11	58	2	●	294
8725080	**10.8**				12	45	2	●	291
8727090	**10.9 -11**	273			11	58	2	●	302
8725090	**10.9**				12	45	2	●	296
8727100	**11 -11**	275			11	58	2	●	307
8725100	**11**				12	45	2	●	301
8725110	**11.1**	278	340	400		58	2	●	341
8725120	**11.2**	280				58	2	●	329
8725130	**11.3**	283				58	2.1	●	357
8725140	**11.4**	285				58	2.1	●	355
8725150	**11.5**	288				58	2.1	●	360
8725160	**11.6**	290				58	2.1	●	374
8725170	**11.7**	293				58	2.1	●	370
8725180	**11.8**	295				58	2.1	●	355
8725190	**11.9**	298				58	2.2	●	376
8725200	**12**	300				58	2.2	●	367

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-25D	◎	◎	◎	◎	○					○*	○	◎	◎								

* 不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

硬质合金内冷油孔钻头 30D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (30D TYPE)

The A Brand

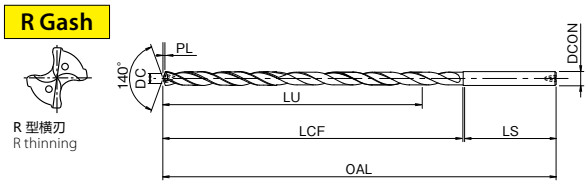
ADO-30D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140°$^{0}_{-4}$°。
Tolerance of the point angle is 140°$^{0}_{-4}$°

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8708300	3 - 3	90	100	150	3	50	0.5	●	14
8708310	3.1	93	102	185	4	81	0.6	●	23
8708320	3.2	96	105			78	0.6	●	23
8708330	3.3	99	109			74	0.6	●	24
8708340	3.4	102	112			71	0.6	●	24
8708350	3.5	105	116			67	0.6	●	24
8708360	3.6	108				67	0.7	●	24
8708370	3.7	111				67	0.7	●	24
8708380	3.8	114	132			51	0.7	●	30
8708390	3.9	117				51	0.7	●	30
8708400	4	120				51	0.7	●	30
8708410	4.1 - 5	123	140	215	5	73	0.7	●	39
8716410	4.1				6	45	0.7	●	42
8708420	4.2 - 5	126			5	73	0.8	●	40
8716420	4.2				6	45	0.8	●	43
8708430	4.3 - 5	129	150		5	63	0.8	●	40
8716430	4.3				6	45	0.8	●	44
8708440	4.4 - 5	132			5	63	0.8	●	40
8716440	4.4				6	45	0.8	●	44
8708450	4.5 - 5	135			5	63	0.8	●	40
8716450	4.5				6	45	0.8	●	45
8708460	4.6 - 5	138			5	63	0.8	●	40
8716460	4.6				6	45	0.8	●	45
8708470	4.7 - 5	141			5	63	0.9	●	40
8716470	4.7				6	45	0.9	●	47
8708480	4.8 - 5	144	165		5	48	0.9	●	40
8716480	4.8				6	45	0.9	●	47
8708490	4.9 - 5	147			5	48	0.9	●	45
8716490	4.9				6	45	0.9	●	47
8708500	5 - 5	150			5	50	0.9	●	48
8716500	5				6	45	0.9	●	49
8716510	5.1	153	180	250		68	0.9	●	58
8716520	5.2	156				68	0.9	●	59

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8716530	5.3	159	180	250	6	68	1	●	60
8716540	5.4	162	200			48	1	●	60
8708550	5.5	165				48	1	●	58
8716560	5.6	168				48	1	●	60
8716570	5.7	171				48	1	●	60
8716580	5.8	174				48	1.1	●	62
8716590	5.9	177				48	1.1	●	62
8708600	6	180				50	1.1	●	65
8708610	6.1 - 7	183	215	280	7	63	1.1	●	83
8716610	6.1				8	45	1.1	●	92
8708620	6.2 - 7	186			7	63	1.1	●	84
8716620	6.2				8	45	1.1	●	95
8708630	6.3 - 7	189			7	63	1.1	●	86
8716630	6.3				8	45	1.1	●	95
8708640	6.4 - 7	192			7	63	1.2	●	87
8716640	6.4				8	45	1.2	●	96
8708650	6.5 - 7	195			7	63	1.2	●	89
8716650	6.5				8	45	1.2	●	99
8708660	6.6 - 7	198			7	63	1.2	●	92
8716660	6.6				8	45	1.2	●	100
8708670	6.7 - 7	201			7	63	1.2	●	93
8716670	6.7				8	45	1.2	●	103
8708680	6.8 - 7	204	230		7	48	1.2	●	89
8716680	6.8				8	45	1.2	●	103
8708690	6.9 - 7	207			7	48	1.3	●	90
8716690	6.9				8	45	1.3	●	103
8708700	7 - 7	210			7	48	1.3	●	92
8716700	7				8	45	1.3	●	103
8716710	7.1	213	250	315		63	1.3	●	121
8716720	7.2	216				63	1.3	●	121
8716730	7.3	219				63	1.3	●	122
8716740	7.4	222				63	1.3	●	122
8708750	7.5	225				63	1.4	●	126

下一页 直径 DC 7.6 ~ 10 NEXT

2021年10月以后生产的所有尺寸都将依次改为 R Gash 。
All sizes after October 2021 production will be sequentially changed to R Gash.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~ 35 HRC	35 ~ 45 HRC	45 ~ 50 HRC	50 ~ 62 HRC	62 ~ 70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-30D	◎	◎	◎	◎	○					○*	○	◎	◎								

*不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1082

硬质合金内冷油孔钻头 30D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (30D TYPE)

The A Brand

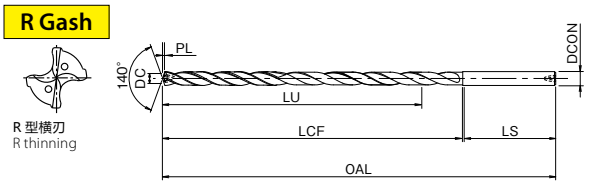
ADO-30D

切削条件 Cutting Conditions | P.391

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | e8 | 30° | SHRINK FIT

R Gash



先端角的公差为140° $^{0°}_{-4°}$。
Tolerance of the point angle is 140° $^{0°}_{-4°}$

上一页

FROM 直径 DC 3～7.5

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8716760	**7.6**	228	265	315	8	48	1.4	●	124
8716770	**7.7**	231				48	1.4	●	125
8716780	**7.8**	234				48	1.4	●	130
8716790	**7.9**	237				48	1.4	●	134
8708800	**8**	240				50	1.5	●	132
8708810	**8.1 - 9**	243	280	350	9	68	1.5	●	184
8716810	**8.1**				10	45	1.5	●	193
8708820	**8.2 - 9**	246			9	68	1.5	●	187
8716820	**8.2**				10	45	1.5	●	195
8708830	**8.3 - 9**	249			9	68	1.5	●	187
8716830	**8.3**				10	45	1.5	●	198
8708840	**8.4 - 9**	252			9	68	1.5	●	192
8716840	**8.4**				10	45	1.5	●	202
8708850	**8.5 - 9**	255			9	68	1.5	●	192
8716850	**8.5**				10	45	1.5	●	208
8708860	**8.6 - 9**	258	300		9	48	1.6	●	164
8716860	**8.6**				10	45	1.6	●	208
8708870	**8.7 - 9**	261			9	48	1.6	●	189

商品号 EDP No.	直径 - 柄径 DC - DCON	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8716870	**8.7**	261	300	350	10	45	1.6	●	208
8708880	**8.8 - 9**	264			9	48	1.6	●	197
8716880	**8.8**				10	45	1.6	●	208
8708890	**8.9 - 9**	267			9	48	1.6	●	192
8716890	**8.9**				10	45	1.6	●	212
8708900	**9 - 9**	270			9	48	1.6	●	197
8716900	**9**				10	45	1.6	●	215
8716910	**9.1**	273	315	390	10	73	1.7	●	257
8716920	**9.2**	276				73	1.7	●	257
8716930	**9.3**	279				73	1.7	●	257
8716940	**9.4**	282				73	1.7	●	257
8708950	**9.5**	285				73	1.7	●	256
8716960	**9.6**	288	330			58	1.7	●	257
8716970	**9.7**	291				58	1.8	●	258
8716980	**9.8**	294				58	1.8	●	258
8716990	**9.9**	297				58	1.8	●	258
8709000	**10**	300				58	1.8	●	266

2021年10月以后生产的所有尺寸都将依次改为 **R Gash**。
All sizes after October 2021 production will be sequentially changed to **R Gash**.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-30D	◎	◎	◎	◎	○					○*	○	◎	◎								

*不建议加工奥氏体不锈钢。 *We don't recommend it for Austenitic Stainless Steel drilling.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1114 NEW

硬质合金内冷油孔钻头 40D 型

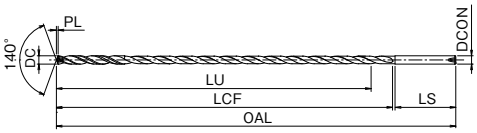
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (40D TYPE)

The A Brand

ADO-40D

切削条件 Cutting Conditions | P.392

R 型横刃
R thinning



先端角的公差为140°$^{0}_{-4}$°。
Tolerance of the point angle is 140°$^{0}_{-4}$°

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8717300	**3**	120	129	179	3	49	0.5	●	14
8717400	**4**	160	172	222	4	49	0.7	●	30
8717500	**5**	200	215	265	5	49	0.9	●	51

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8717600	**6**	240	258	308	6	49	1.1	●	76
8717800	**8**	320	344	394	8	49	1.5	●	178
8718000	**10**	400	430	490	10	59	1.8	●	328

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-40D	◎	◎	◎	◎	○					○		◎	◎								

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

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

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

△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1115 NEW

硬质合金内冷油孔钻头 50D 型

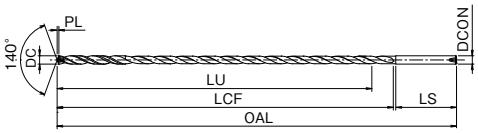
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY (50D TYPE)

The A Brand

ADO-50D

切削条件 Cutting Conditions | P.392

R 型横刃
R thinning



先端角的公差为140° $^{0°}_{-4°}$。

Tolerance of the point angle is 140° $^{0°}_{-4°}$

CARBIDE | EgiAs | e8 | 约25° ABOUT25° | SHRINK FIT

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。

Drills may have some discoloration, but it does not cause any performance problems.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8718300	**3**	150	159	209	3	49	0.5	●	18
8718400	**4**	200	212	262	4	49	0.7	●	33
8718500	**5**	250	265	315	5	49	0.9	●	58

商品号 EDP No.	直径 DC	有效槽长 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8718600	**6**	300	318	368	6	49	1.1	●	87
8718800	**8**	400	424	474	8	49	1.5	●	203

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-50D	◎	◎	◎	◎	○					○		◎	◎								

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

超长刃钻头用硬质合金导向钻

PILOT DRILL FOR EXTRA LONG DRILL

The A Brand

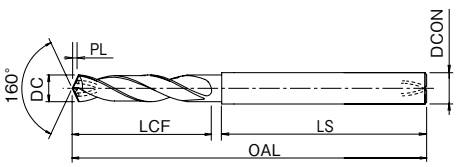
ADO-PLT

切削条件 Cutting Conditions | P.393

CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

X 型横刃
X thinning
(DC<4)

R 型横刃
R thinning
(4≦DC)



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration,
but it does not cause any performance problems.

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8688903	**3.03 - 3**	15	65	3	50	0.3	●	7
8688923	**3.53**	18	70	4	50.1	0.3	●	12
8688904	**4.03**	20			50	0.4	●	12
8688924	**4.53 - 5**	23	75	5	50.1	0.4	●	19
8688905	**5.03 - 5**	25			50	0.4	●	20
8688925	**5.53**	28	80	6	50.1	0.5	●	28
8688906	**6.03**	30			50	0.5	●	29
8688926	**6.53 - 7**	33	85	7	50.1	0.6	●	39

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8688907	**7.03 - 7**	35	85	7	50	0.6	●	40
8688908	**8.03**	40	90	8	50	0.7	●	55
8688928	**8.53 - 9**	43	95	9	51	0.8	●	68
8688909	**9.03 - 9**	45			50	0.8	●	70
8688910	**10.03**	50	100	10	50	0.9	●	90
8688911	**11.03 - 11**	55	115	11	60	1	●	126
8688912	**12.03**	60	120	12	60	1.1	●	161

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-PLT	○	◎	◎	◎	◎	○	○			○	○	◎	◎			○					

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1107

硬质合金内冷油孔钻头 3D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 3D TYPE

The A Brand

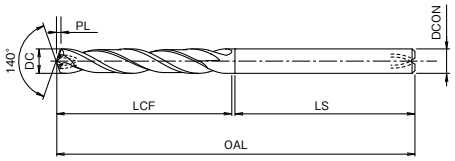
ADO-SUS-3D

切削条件 Cutting Conditions | P.394

采用重视切削锋利性的刃尖形状，新型沟槽形状，新型油孔形状 “MEGA COOLER”，即使是高效率条件下也能稳定加工并实现长寿命。

Stable performance and long tool life are possible even under high feed rates by featuring sharp cutting edges, new flute geometry, and the new coolant hole shape the "MEGA COOLER".

R 型横刃
R thinning



CARBIDE | WXL | h8 | 30° | SHRINK FIT

＊尺寸大于φ6的产品采用新型油孔。
＊New coolant hole shape applies only to diameter sizes over 6mm.

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8665200	2 - 3	12	66	3	51.1	0.4	●	7
8665210	2.1 - 3	13			50.3	0.4	●	7
8665220	2.2 - 3	14			49.5	0.4	●	7
8665230	2.3 - 3				49.7	0.4	●	7
8665240	2.4 - 3	15			48.9	0.4	●	7
8665250	2.5 - 3				49.1	0.5	●	7
8665260	2.6 - 3	16			48.3	0.5	●	7
8665270	2.7 - 3	17			47.4	0.5	●	7
8665280	2.8 - 3				47.6	0.5	●	13
8665283	2.83 - 3				47.7	0.5	●	13
8665287	2.87 - 3	18			46.8	0.5	●	13
8665290	2.9 - 3				46.8	0.5	●	13
8665300	3 - 3				47	0.5	●	13
8665310	3.1	19	74	4	52.3	0.6	●	13
8665315	3.15				52.4	0.6	●	13
8665320	3.2	20			51.5	0.6	●	13
8665326	3.26(#30)				51.6	0.6	●	13
8665330	3.3				51.7	0.6	●	13
8665340	3.4	21			50.9	0.6	●	13
8665350	3.5				51.1	0.6	●	13
8665360	3.6	22			50.3	0.7	●	13
8665370	3.7	23			49.4	0.7	●	13
8665373	3.73				49.5	0.7	●	13
8665375	3.75				49.5	0.7	●	13
8665380	3.8				49.6	0.7	●	13
8665390	3.9	24			48.8	0.7	●	13
8665400	4				49	0.7	●	13
8665410	4.1 - 5	25	80	5	52.3	0.7	●	19
8680410	4.1			6	50.5	0.7	●	26
8665420	4.2 - 5	26		5	51.5	0.8	●	19
8680420	4.2			6	49.6	0.8	●	26
8665430	4.3 - 5			5	51.7	0.8	●	19
8680430	4.3			6	49.8	0.8	●	25
8665440	4.4 - 5	27		5	50.9	0.8	●	19
8680440	4.4			6	49	0.8	●	25
8680445	4.45				49.1	0.8	●	26
8665450	4.5 - 5			5	51.1	0.8	●	19
8680450	4.5			6	49.2	0.8	●	26
8665460	4.6 - 5	28		5	50.3	0.8	●	19
8680460	4.6			6	48.4	0.8	●	26
8680465	4.65				48.5	0.8	●	26
8665470	4.7 - 5	29		5	49.4	0.9	●	19
8680470	4.7			6	47.6	0.9	●	26
8665480	4.8 - 5			5	49.6	0.9	●	20
8680480	4.8			6	47.8	0.9	●	26
8665485	4.85(#11)				47.9	0.9	●	25
8665490	4.9 - 5	30		5	48.8	0.9	●	20

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8680490	4.9	30	80	6	46.9	0.9	●	28
8665500	5 - 5	25		5	54	0.9	●	21
8680500	5				52.1	0.9	●	28
8665510	5.1	26	82	6	53.3	0.9	●	27
8665520	5.2				53.5	0.9	●	28
8665525	5.25	27			52.6	1	●	28
8665530	5.3				52.7	1	●	28
8665540	5.4				52.9	1	●	28
8665550	5.5	28			52.1	1	●	28
8680555	5.55				52.2	1	●	28
8665560	5.6				52.3	1	●	28
8665570	5.7	29			51.4	1	●	28
8665580	5.8				51.6	1.1	●	28
8665590	5.9	30			50.8	1.1	●	28
8665600	6				51	1.1	●	28
8665610	6.1 - 7	31	88	7	56	1.1	●	38
8680610	6.1			8	52.5	1.1	●	47
8665620	6.2 - 7			7	56	1.1	●	38
8680620	6.2			8	52.6	1.1	●	47
8665625	6.25 - 7	32		7	55	1.1	●	38
8665630	6.3 - 7				55	1.1	●	38
8680630	6.3			8	51.8	1.1	●	47
8665635	6.35(¼") - 6.35			6.35	55	1.2	●	33
8665640	6.4 - 7			7	55	1.2	●	39
8680640	6.4			8	52	1.2	●	47
8665650	6.5 - 7	33		7	54	1.2	●	39
8680650	6.5			8	51.2	1.2	●	47
8665660	6.6 - 7			7	54	1.2	●	39
8680660	6.6			8	51.4	1.2	●	47
8665670	6.7 - 7	34		7	53	1.2	●	39
8680670	6.7			8	50.6	1.2	●	47
8665675	6.75 - 7			7	53	1.2	●	39
8665680	6.8 - 7				53	1.2	●	39
8680680	6.8			8	50.8	1.2	●	47
8665690	6.9 - 7	35		7	52	1.3	●	39
8680690	6.9			8	49.9	1.3	●	47
8665700	7 - 7			7	52	1.3	●	39
8680700	7			8	50.1	1.3	●	47
8665710	7.1	36	94		57	1.3	●	51
8665720	7.2				57	1.3	●	51
8665725	7.25	37			56	1.3	●	51
8665730	7.3				56	1.3	●	51
8665740	7.4				56	1.3	●	51
8680745	7.45	38			55	1.4	●	51
8665750	7.5				55	1.4	●	51
8680755	7.55				55	1.4	●	52
8665760	7.6				55	1.4	●	51

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直径 DC 7.7～13.1 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-SUS-3D	○	◎	◎	◎						◎		○	○	◎		○	◎	◎		○	

上一页
FROM 直径 DC 2～7.6

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8665770	**7.7**	39	94	8	54	1.4	●	51
8665775	**7.75**				54	1.4	●	52
8665780	**7.8**				54	1.4	●	52
8665790	**7.9**	40			53	1.4	●	52
8665800	**8**				53	1.5	●	52
8665810	**8.1 - 9**	41	101	9	59	1.5	●	69
8680810	**8.1**			10	55.5	1.5	●	81
8665820	**8.2 - 9**			9	59	1.5	●	69
8680820	**8.2**			10	55.6	1.5	●	81
8665825	**8.25 - 9**	42		9	58	1.5	●	69
8665830	**8.3 - 9**				58	1.5	●	69
8680830	**8.3**			10	54.8	1.5	●	82
8665840	**8.4 - 9**			9	58	1.5	●	69
8680840	**8.4**			10	55	1.5	●	82
8665850	**8.5 - 9**	43		9	57	1.5	●	69
8680850	**8.5**			10	54.2	1.5	●	82
8665860	**8.6 - 9**			9	57	1.6	●	70
8680860	**8.6**			10	54.4	1.6	●	82
8665870	**8.7 - 9**	44		9	56	1.6	●	70
8680870	**8.7**			10	53.6	1.6	●	82
8665875	**8.75 - 9**			9	56	1.6	●	70
8665880	**8.8 - 9**				56	1.6	●	70
8680880	**8.8**			10	53.8	1.6	●	82
8665890	**8.9 - 9**	45		9	55	1.6	●	71
8680890	**8.9**			10	52.9	1.6	●	82
8665900	**9 - 9**			9	55	1.6	●	71
8680900	**9**			10	53.1	1.6	●	85
8665910	**9.1**	46	106		59	1.7	●	86
8665920	**9.2**				59	1.7	●	86
8665925	**9.25**	47			58	1.7	●	87
8665930	**9.3**				58	1.7	●	86
8665940	**9.4**				58	1.7	●	87
8665950	**9.5**	48			57	1.7	●	87
8680955	**9.55**				57	1.7	●	88
8665960	**9.6**				57	1.7	●	87
8665970	**9.7**	49			56	1.8	●	87
8665975	**9.75**				56	1.8	●	88
8665980	**9.8**				56	1.8	●	88
8665990	**9.9**	50			55	1.8	●	88
8666000	**10**				55	1.8	●	88
8666010	**10.1 - 11**	51	113	11	61	1.8	●	108
8681010	**10.1**			12	57.5	1.8	●	125
8666020	**10.2 - 11**			11	61	1.9	●	110
8681020	**10.2**			12	57.6	1.9	●	126
8666025	**10.25 - 11**	52		11	60	1.9	●	111
8666030	**10.3 - 11**				60	1.9	●	110
8681030	**10.3**			12	56.8	1.9	●	127

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8666040	**10.4 - 11**	52	113	11	60	1.9	●	110
8681040	**10.4**			12	57	1.9	●	127
8666050	**10.5 - 11**	53		11	59	1.9	●	112
8681050	**10.5**			12	56.2	1.9	●	127
8666060	**10.6 - 11**			11	59	1.9	●	111
8681060	**10.6**			12	56.4	1.9	●	129
8666070	**10.7 - 11**	54		11	58	1.9	●	111
8681070	**10.7**			12	55.6	1.9	●	127
8666075	**10.75 - 11**			11	58	2	●	113
8666080	**10.8 - 11**				58	2	●	113
8681080	**10.8**			12	55.8	2	●	128
8666090	**10.9 - 11**	55		11	57	2	●	112
8681090	**10.9**			12	54.9	2	●	128
8666100	**11 - 11**			11	57	2	●	113
8681100	**11**			12	55.1	2	●	130
8666110	**11.1**	56	120		63	2	●	138
8666120	**11.2**				63	2	●	139
8666130	**11.3**	57			62	2.1	●	139
8666140	**11.4**				62	2.1	●	139
8666150	**11.5**	58			61	2.1	●	140
8666160	**11.6**				61	2.1	●	140
8666170	**11.7**	59			60	2.1	●	139
8666180	**11.8**				60	2.1	●	140
8666190	**11.9**	60			59	2.2	●	140
8666200	**12**				59	2.2	●	142
8666210	**12.1 - 13**	61	128	13	66	2.2	●	174
8681210	**12.1**			14	62.5	2.2	●	194
8666220	**12.2 - 13**			13	66	2.2	●	174
8681220	**12.2**			14	62.6	2.2	●	196
8666230	**12.3 - 13**	62		13	65	2.2	●	176
8681230	**12.3**			14	61.8	2.2	●	196
8666240	**12.4 - 13**			13	65	2.3	●	176
8681240	**12.4**			14	62	2.3	●	196
8666250	**12.5 - 13**	63		13	64	2.3	●	175
8681250	**12.5**			14	61.2	2.3	●	195
8666260	**12.6 - 13**			13	64	2.3	●	176
8681260	**12.6**			14	61.4	2.3	●	197
8666270	**12.7 - 13**	64		13	63	2.3	●	177
8681270	**12.7**			14	60.6	2.3	●	195
8666275	**12.75 - 13**			13	63	2.3	●	177
8666280	**12.8 - 13**				63	2.3	●	177
8681280	**12.8**			14	60.8	2.3	●	197
8666290	**12.9 - 13**	65		13	62	2.3	●	178
8681290	**12.9**			14	59.9	2.3	●	198
8666300	**13 - 13**			13	62	2.4	●	179
8681300	**13**			14	60.1	2.4	●	198
8666310	**13.1**	66	134		67	2.4	●	206

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直径 DC 13.2～20 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1107**

硬质合金内冷油孔钻头 3D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 3D TYPE

The A Brand

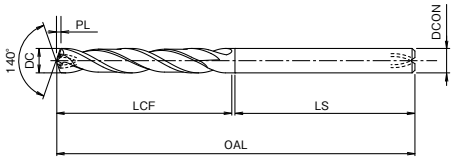
ADO-SUS-3D

切削条件 Cutting Conditions | P.394

采用重视切削锋利性的刃尖形状，新型沟槽形状，新型油孔形状 “MEGA COOLER”，即使是高效率条件下也能稳定加工并实现长寿命。

Stable performance and long tool life are possible even under high feed rates by featuring sharp cutting edges, new flute geometry, and the new coolant hole shape the "MEGA COOLER".

R 型横刃
R thinning



CARBIDE | WXL | h8 | 30° | SHRINK FIT

＊尺寸大于φ6的产品采用新型油孔。
＊New coolant hole shape applies only to diameter sizes over 6mm.

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FROM 直径 DC 7.7～13.1

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8666320	13.2	66	134	14	67	2.4	●	206
8666330	13.3	67			66	2.4	●	207
8666340	13.4				66	2.4	●	209
8681343	13.43	68			65	2.4	●	210
8666350	13.5				65	2.5	●	208
8681355	13.55				65	2.5	●	211
8666360	13.6				65	2.5	●	209
8666370	13.7	69			64	2.5	●	208
8666380	13.8				64	2.5	●	210
8666390	13.9	70			63	2.5	●	210
8666400	14				63	2.5	●	210
8666410	14.1 - 15	71	140	15	68	2.6	●	244
8681410	14.1			16	64.5	2.6	●	269
8666420	14.2 - 15			15	68	2.6	●	245
8681420	14.2			16	64.6	2.6	●	269
8666430	14.3 - 15	72		15	67	2.6	●	244
8681430	14.3			16	63.8	2.6	●	270
8666440	14.4 - 15			15	67	2.6	●	246
8681440	14.4			16	64	2.6	●	272
8666450	14.5 - 15	73		15	66	2.6	●	246
8681450	14.5			16	63.2	2.6	●	270
8666460	14.6 - 15			15	66	2.7	●	247
8681460	14.6			16	63.4	2.7	●	270
8666470	14.7 - 15	74		15	65	2.7	●	248
8681470	14.7			16	62.6	2.7	●	270
8666480	14.8 - 15			15	65	2.7	●	249
8681480	14.8			16	62.8	2.7	●	271
8666490	14.9 - 15	75		15	64	2.7	●	248
8681490	14.9			16	61.9	2.7	●	271
8666500	15 - 15			15	64	2.7	●	250
8681500	15			16	62.1	2.7	●	275

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8666510	15.1	76	145	16	68	2.7	●	281
8666520	15.2				68	2.8	●	283
8666530	15.3	77			67	2.8	●	282
8666540	15.4				67	2.8	●	283
8666550	15.5	78			66	2.8	●	283
8681555	15.55				66	2.8	●	288
8666560	15.6				66	2.8	●	284
8666570	15.7	79			65	2.9	●	285
8666580	15.8				65	2.9	●	286
8666590	15.9	80			64	2.9	●	286
8666600	16				64	2.9	●	288
8666650	16.5 - 17	83	150	17	66	3	●	331
8681650	16.5			18	63.2	3	●	357
8681670	16.7	84			62.6	3	●	358
8666700	17 - 17	85		17	64	3.1	●	337
8681700	17			18	62.1	3.1	●	360
8681730	17.3	87	155		67	3.1	●	378
8666750	17.5	88			66	3.2	●	374
8681755	17.55				66	3.2	●	381
8666800	18	90			64	3.3	●	383
8666850	18.5 - 19	93	160	19	66	3.4	●	428
8681850	18.5			20	63.2	3.4	●	458
8681870	18.7	94			62.6	3.4	●	460
8666900	19 - 19	95		19	64	3.5	●	432
8681900	19			20	62.1	3.5	●	465
8681930	19.3	97	165		67	3.5	●	490
8666950	19.5	98			66	3.5	●	477
8681955	19.55				66	3.6	●	491
8667000	20	100			64	3.6	●	488

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-SUS-3D	○	◎	◎	◎						◎		○	○	◎		○	◎	◎		○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

硬质合金内冷油孔钻头 5D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 5D TYPE

The A Brand

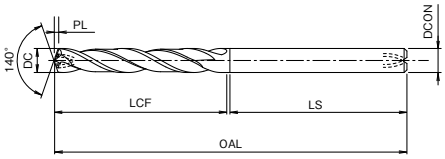
ADO-SUS-5D

切削条件 Cutting Conditions | P.394

采用重视切削锋利性的刃尖形状，新型沟槽形状，新型油孔形状 "MEGA COOLER"，即使是高效率条件下也能稳定加工并实现长寿命。

Stable performance and long tool life are possible even under high feed rates by featuring sharp cutting edges, new flute geometry, and the new coolant hole shape the "MEGA COOLER".

R 型横刃
R thinning



CARBIDE | WXL | h8 | 30° | SHRINK FIT

＊尺寸大于φ6的产品采用新型油孔。
＊New coolant hole shape applies only to diameter sizes over 6mm.

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8667200	2 - 3	18	70	3	49.1	0.4	●	7
8667210	2.1 - 3	19			48.3	0.4	●	7
8667220	2.2 - 3	20			47.5	0.4	●	7
8667230	2.3 - 3	21			46.7	0.4	●	7
8667240	2.4 - 3	22			45.9	0.4	●	8
8667250	2.5 - 3	23			45.1	0.5	●	8
8667260	2.6 - 3	24	78		52.3	0.5	●	8
8667270	2.7 - 3	25			51.4	0.5	●	8
8667276	2.76 - 3				51.6	0.5	●	8
8667278	2.78 - 3	26			50.6	0.5	●	8
8667280	2.8 - 3				50.6	0.5	●	8
8667283	2.83 - 3				50.7	0.5	●	8
8667287	2.87 - 3				50.8	0.5	●	8
8667290	2.9 - 3	27			49.8	0.5	●	8
8667300	3 - 3				50	0.5	●	8
8667310	3.1	28	86	4	55.3	0.6	●	14
8667315	3.15	29			54.4	0.6	●	14
8667320	3.2				54.5	0.6	●	14
8667326	3.26(#30)				54.6	0.6	●	14
8667330	3.3	30			53.7	0.6	●	14
8667340	3.4	31			52.9	0.6	●	14
8667350	3.5	32			52.1	0.6	●	14
8667360	3.6	33			51.3	0.7	●	14
8667366	3.66				51.4	0.7	●	14
8667368	3.68	34			50.4	0.7	●	14
8667370	3.7				50.4	0.7	●	14
8667373	3.73				50.5	0.7	●	14
8667375	3.75				50.5	0.7	●	14
8667380	3.8	35			49.6	0.7	●	14
8667390	3.9	36			48.8	0.7	●	14
8667400	4				49	0.7	●	14
8667410	4.1 - 5	37		5	55.3	0.7	●	14
8682410	4.1		95	6	53.5	0.7	●	28
8667420	4.2 - 5	38		5	54.5	0.8	●	22

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8682420	4.2	38	95	6	52.6	0.8	●	28
8667430	4.3 - 5	39		5	53.7	0.8	●	22
8682430	4.3			6	51.8	0.8	●	28
8667440	4.4 - 5	40		5	52.9	0.8	●	22
8682440	4.4			6	51	0.8	●	28
8682445	4.45	41			50.1	0.8	●	28
8667450	4.5 - 5			5	52.1	0.8	●	22
8682450	4.5			6	50.2	0.8	●	28
8667460	4.6 - 5	42		5	51.3	0.8	●	22
8682460	4.6			6	49.4	0.8	●	28
8667462	4.62 - 5			5	51.3	0.8	●	22
8667464	4.64 - 5				51.3	0.8	●	22
8682464	4.64			6	49.5	0.8	●	28
8667470	4.7 - 5	43		5	50.4	0.9	●	22
8682470	4.7			6	48.6	0.9	●	27
8667480	4.8 - 5	44		5	49.6	0.9	●	22
8682480	4.8			6	47.8	0.9	●	27
8667485	4.85(#11)				47.9	0.9	●	27
8667490	4.9 - 5	45		5	48.8	0.9	●	22
8682490	4.9			6	46.9	0.9	●	27
8667500	5 - 5			5	49	0.9	●	22
8682500	5			6	47.1	0.9	●	27
8667510	5.1	41	100		56.3	0.9	●	31
8667520	5.2	42			55.5	0.9	●	31
8667525	5.25				55.6	1	●	31
8667530	5.3	43			54.7	1	●	31
8667540	5.4	44			53.9	1	●	31
8667550	5.5				54.1	1	●	31
8667552	5.52	45			53.1	1	●	31
8667554	5.54				53.1	1	●	31
8667560	5.6				53.3	1	●	31
8667570	5.7	46			52.4	1	●	32
8667580	5.8	47			51.6	1.1	●	32
8667590	5.9	48			50.8	1.1	●	32

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直径 DC 6～9.9 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-SUS-5D	○	◎	◎	◎						◎		○	○	◎		○	◎	◎		○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DW1108**

硬质合金内冷油孔钻头 5D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 5D TYPE

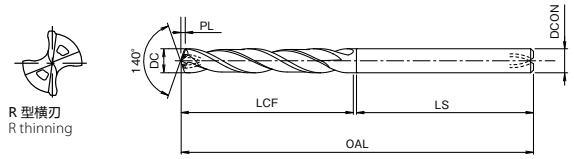
The A Brand

ADO-SUS-5D

切削条件 Cutting Conditions | P.394

采用重视切削锋利性的刃尖形状，新型沟槽形状，新型油孔形状 “MEGA COOLER”，即使是高效率条件下也能稳定加工并实现长寿命。

Stable performance and long tool life are possible even under high feed rates by featuring sharp cutting edges, new flute geometry, and the new coolant hole shape the "MEGA COOLER".



CARBIDE | WXL | h8 | 30° | SHRINK FIT

＊尺寸大于φ6的产品采用新型油孔。

＊New coolant hole shape applies only to diameter sizes over 6mm.

上一页
FROM 直径 DC 2～5.9

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8667600	6	48	100	6	51	1.1	●	32
8667610	6.1 - 7	49	109	7	59	1.1	●	43
8682610	6.1			8	55.5	1.1	●	52
8667620	6.2 - 7	50		7	58	1.1	●	43
8682620	6.2			8	54.6	1.1	●	52
8667625	6.25 - 7			7	58	1.1	●	43
8667630	6.3 - 7	51			57	1.1	●	43
8682630	6.3			8	53.8	1.1	●	52
8667635	6.35(¼") - 6.35	52		6.35	56	1.2	●	37
8667640	6.4 - 7			7	56	1.2	●	43
8682640	6.4			8	53	1.2	●	52
8667650	6.5 - 7			7	56	1.2	●	43
8682650	6.5			8	53.2	1.2	●	52
8667660	6.6 - 7	53		7	55	1.2	●	43
8682660	6.6			8	52.4	1.2	●	52
8667670	6.7 - 7	54		7	54	1.2	●	44
8682670	6.7			8	51.6	1.2	●	52
8667675	6.75 - 7			7	54	1.2	●	44
8667680	6.8 - 7	55			53	1.2	●	44
8682680	6.8			8	50.8	1.2	●	52
8667690	6.9 - 7	56		7	52	1.3	●	44
8682690	6.9			8	49.9	1.3	●	53
8667700	7 - 7			7	52	1.3	●	44
8682700	7			8	50.1	1.3	●	53
8667710	7.1	57	118		60	1.3	●	59
8667720	7.2	58			59	1.3	●	60
8667725	7.25				59	1.3	●	59
8667730	7.3	59			58	1.3	●	59
8667736	7.36				58	1.3	●	59
8667738	7.38	60			57	1.3	●	59
8667740	7.4				57	1.3	●	60
8682745	7.45				57	1.4	●	60
8667750	7.5				57	1.4	●	60
8667752	7.52	61			56	1.4	●	60
8667754	7.54				56	1.4	●	60
8667760	7.6				56	1.4	●	60
8667770	7.7	62			55	1.4	●	60
8667775	7.75				55	1.4	●	60
8667780	7.8	63			54	1.4	●	60
8667790	7.9	64			53	1.4	●	60

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8667800	8	64	128	8	53	1.5	●	61
8667810	8.1 - 9	65		9	62	1.5	●	80
8682810	8.1			10	58.5	1.5	●	93
8667820	8.2 - 9	66		9	61	1.5	●	80
8682820	8.2			10	57.6	1.5	●	93
8667825	8.25 - 9			9	61	1.5	●	81
8667830	8.3 - 9	67			60	1.5	●	80
8682830	8.3			10	56.8	1.5	●	93
8667840	8.4 - 9	68		9	59	1.5	●	80
8682840	8.4			10	56	1.5	●	93
8667850	8.5 - 9			9	59	1.5	●	81
8682850	8.5			10	56.2	1.5	●	94
8667860	8.6 - 9	69		9	58	1.6	●	82
8682860	8.6			10	55.4	1.6	●	95
8667870	8.7 - 9	70		9	57	1.6	●	82
8682870	8.7			10	54.6	1.6	●	95
8667875	8.75 - 9			9	57	1.6	●	83
8667880	8.8 - 9	71			56	1.6	●	82
8682880	8.8			10	53.8	1.6	●	95
8667890	8.9 - 9	72		9	55	1.6	●	82
8682890	8.9			10	52.9	1.6	●	95
8667900	9 - 9			9	55	1.6	●	83
8682900	9			10	53.1	1.6	●	95
8667910	9.1	73	136		62	1.7	●	100
8667920	9.2	74			61	1.7	●	102
8667924	9.24				61	1.7	●	104
8667925	9.25				61	1.7	●	104
8667926	9.26	75			60	1.7	●	101
8667930	9.3				60	1.7	●	101
8667936	9.36				60	1.7	●	102
8667938	9.38	76			59	1.7	●	101
8667940	9.4				59	1.7	●	101
8667950	9.5				59	1.7	●	103
8667952	9.52	77			58	1.7	●	101
8667954	9.54				58	1.7	●	103
8667960	9.6				58	1.7	●	103
8667970	9.7	78			57	1.8	●	103
8667975	9.75				57	1.8	●	105
8667980	9.8	79			56	1.8	●	104
8667990	9.9	80			55	1.8	●	103

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直径 DC 10～14.5 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-SUS-5D	○	◎	◎	◎						◎		○	○	◎		○	◎	◎		○	

上一页
FROM 直径 DC 6～9.9

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8668000	**10**	80	136	10	55	1.8	●	103
8668010	**10.1 - 11**	81	146	11	64	1.8	●	130
8683010	**10.1**			12	60.5	1.8	●	145
8668020	**10.2 - 11**	82		11	63	1.9	●	129
8683020	**10.2**			12	59.6	1.9	●	148
8668025	**10.25 - 11**			11	63	1.9	●	132
8668030	**10.3 - 11**	83			62	1.9	●	129
8683030	**10.3**			12	58.8	1.9	●	148
8668040	**10.4 - 11**	84		11	61	1.9	●	129
8683040	**10.4**			12	58	1.9	●	148
8668050	**10.5 - 11**			11	61	1.9	●	131
8683050	**10.5**			12	58.2	1.9	●	149
8668060	**10.6 - 11**	85		11	60	1.9	●	132
8683060	**10.6**			12	57.4	1.9	●	148
8668070	**10.7 - 11**	86		11	59	1.9	●	132
8683070	**10.7**			12	56.6	1.9	●	148
8668075	**10.75 - 11**			11	59	2	●	134
8668080	**10.8 - 11**	87			58	2	●	133
8683080	**10.8**			12	55.8	2	●	150
8668090	**10.9 - 11**	88		11	57	2	●	133
8683090	**10.9**			12	54.9	2	●	150
8668100	**11 - 11**			11	57	2	●	134
8683100	**11**			12	55.1	2	●	152
8668110	**11.1**	89	156		66	2	●	160
8668120	**11.2**	90			65	2	●	161
8668122	**11.22**				65	2	●	162
8668124	**11.24**				65	2	●	162
8668130	**11.3**	91			64	2.1	●	161
8668136	**11.36**				64	2.1	●	161
8668138	**11.38**	92			63	2.1	●	162
8668140	**11.4**				63	2.1	●	161
8668150	**11.5**				63	2.1	●	163
8668160	**11.6**	93			62	2.1	●	163
8668170	**11.7**	94			61	2.1	●	163
8668180	**11.8**	95			60	2.1	●	164
8668190	**11.9**	96			59	2.2	●	164
8668200	**12**				59	2.2	●	167
8668210	**12.1 - 13**	97	167	13	69	2.2	●	203
8683210	**12.1**			14	65.5	2.2	●	225
8668220	**12.2 - 13**	98		13	68	2.2	●	204

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8683220	**12.2**	98	167	14	64.6	2.2	●	225
8668230	**12.3 - 13**	99		13	67	2.2	●	205
8683230	**12.3**			14	63.8	2.2	●	226
8668240	**12.4 - 13**	100		13	66	2.3	●	206
8683240	**12.4**			14	63	2.3	●	226
8668250	**12.5 - 13**			13	66	2.3	●	207
8683250	**12.5**			14	63.2	2.3	●	228
8668260	**12.6 - 13**	101		13	65	2.3	●	206
8683260	**12.6**			14	62.4	2.3	●	227
8668270	**12.7 - 13**	102		13	64	2.3	●	208
8683270	**12.7**			14	61.6	2.3	●	228
8668275	**12.75 - 13**			13	64	2.3	●	209
8668280	**12.8 - 13**	103			63	2.3	●	208
8683280	**12.8**			14	60.8	2.3	●	230
8668290	**12.9 - 13**	104		13	62	2.3	●	209
8683290	**12.9**			14	59.9	2.3	●	230
8668300	**13 - 13**			13	62	2.4	●	210
8683300	**13**			14	60.1	2.4	●	228
8668310	**13.1**	105	176		70	2.4	●	243
8668320	**13.2**	106			69	2.4	●	244
8668325	**13.25**				69	2.4	●	244
8668330	**13.3**	107			68	2.4	●	244
8668340	**13.4**	108			67	2.4	●	244
8683343	**13.43**				67	2.4	●	248
8668350	**13.5**				67	2.5	●	247
8683355	**13.55**	109			66	2.5	●	249
8668360	**13.6**				66	2.5	●	246
8668370	**13.7**	110			65	2.5	●	246
8668380	**13.8**	111			64	2.5	●	248
8668390	**13.9**	112			63	2.5	●	249
8668400	**14**				63	2.5	●	251
8668410	**14.1 - 15**	113	185	15	71	2.6	●	293
8683410	**14.1**			16	67.5	2.6	●	317
8668420	**14.2 - 15**	114		15	70	2.6	●	293
8683420	**14.2**			16	66.6	2.6	●	317
8668430	**14.3 - 15**	115		15	69	2.6	●	293
8683430	**14.3**			16	65.8	2.6	●	317
8668440	**14.4 - 15**	116		15	68	2.6	●	288
8683440	**14.4**			16	65	2.6	●	315
8668450	**14.5 - 15**			15	68	2.6	●	297

下一页
直径 DC 14.5～20 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1108**

硬质合金内冷油孔钻头 5D 型

CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 5D TYPE

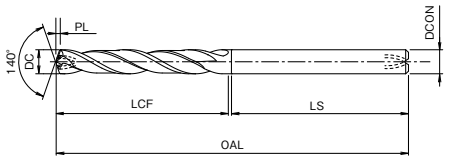
The A Brand

ADO-SUS-5D

切削条件 Cutting Conditions | P.394

采用重视切削锋利性的刃尖形状，新型沟槽形状，新型油孔形状 “MEGA COOLER”，即使是高效率条件下也能稳定加工并实现长寿命。

Stable performance and long tool life are possible even under high feed rates by featuring sharp cutting edges, new flute geometry, and the new coolant hole shape the "MEGA COOLER".



CARBIDE | WXL | h8 | 30° | SHRINK FIT

＊尺寸大于φ6的产品采用新型油孔。

＊New coolant hole shape applies only to diameter sizes over 6mm.

上一页

FROM 直径 DC 10～14.5

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8683450	**14.5**	116	185	16	65.2	2.6	●	316
8668460	**14.6 - 15**	117		15	67	2.7	●	294
8683460	**14.6**			16	64.4	2.7	●	317
8668470	**14.7 - 15**	118		15	66	2.7	●	297
8683470	**14.7**			16	63.6	2.7	●	316
8668480	**14.8 - 15**	119		15	65	2.7	●	296
8683480	**14.8**			16	62.8	2.7	●	319
8668490	**14.9 - 15**	120		15	64	2.7	●	297
8683490	**14.9**			16	61.9	2.7	●	319
8668500	**15 - 15**			15	64	2.7	●	300
8683500	**15**			16	62.1	2.7	●	322
8668510	**15.1**	121	193		71	2.7	●	340
8668520	**15.2**	122			70	2.8	●	343
8668525	**15.25**				70	2.8	●	343
8668530	**15.3**	123			69	2.8	●	341
8668540	**15.4**	124			68	2.8	●	342
8668550	**15.5**				68	2.8	●	345
8683555	**15.55**	125			67	2.8	●	349
8668560	**15.6**				67	2.8	●	348
8668570	**15.7**	126			66	2.9	●	347
8668580	**15.8**	127			65	2.9	●	347

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8668590	**15.9**	128	193	16	64	2.9	●	347
8668600	**16**				64	2.9	●	353
8668650	**16.5 - 17**	116	184	17	67	3	●	375
8683650	**16.5**			18	64.2	3	●	400
8683670	**16.7**	117			63.6	3	●	403
8668700	**17 - 17**	119		17	64	3.1	●	381
8683700	**17**			18	62.1	3.1	●	410
8683730	**17.3**	122	191		68	3.1	●	439
8668750	**17.5**	123			67	3.2	●	436
8683755	**17.55**				67	3.2	●	436
8668800	**18**	126			64	3.3	●	444
8668850	**18.5 - 19**	130	198	19	67	3.4	●	500
8683850	**18.5**			20	64.2	3.4	●	531
8683870	**18.7**	131			63.6	3.4	●	534
8668900	**19 - 19**	133		19	64	3.5	●	508
8683900	**19**			20	62.1	3.5	●	537
8683930	**19.3**	136	205		68	3.5	●	573
8668950	**19.5**	137			67	3.5	●	564
8683955	**19.55**				67	3.6	●	580
8669000	**20**	140			64	3.6	●	578

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-SUS-5D	○	◎	◎	◎						◎		○	○	◎		○	◎	◎		○	

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

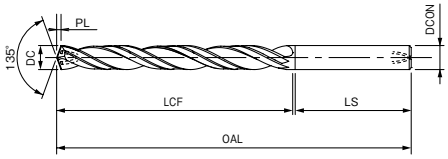
硬质合金内冷油孔钻头 8D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 8D TYPE

The A Brand

ADO-SUS-8D

切削条件 Cutting Conditions | P.394

R 型横刃
R thinning



CARBIDE | WXL | h8 | 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8686200	2 - 3	22	75	3	50.1	0.4	●	8
8686210	2.1 - 3	24			48.3	0.4	●	8
8686220	2.2 - 3	25			47.5	0.5	●	8
8686230	2.3 - 3	26			46.7	0.5	●	8
8686240	2.4 - 3	27			45.9	0.5	●	8
8686250	2.5 - 3	28			45.1	0.5	●	8
8686260	2.6 - 3	29	80		49.3	0.5	●	8
8686270	2.7 - 3	30			48.4	0.6	●	8
8686280	2.8 - 3	31			47.6	0.6	●	8
8686290	2.9 - 3	32			46.8	0.6	●	8
8686300	3 - 3	33			46	0.6	●	9
8684310	3.1	34	95	4	58.3	0.6	●	15
8684320	3.2	35			57.5	0.7	●	15
8684330	3.3	36			56.7	0.7	●	15
8684340	3.4	37			55.9	0.7	●	15
8684350	3.5	39			54.1	0.7	●	15
8684360	3.6	40			53.3	0.7	●	15
8684370	3.7	41			52.4	0.8	●	15
8684380	3.8	42			51.6	0.8	●	15
8684390	3.9	43			50.8	0.8	●	15
8684400	4	44			50	0.8	●	15
8686410	4.1 - 5	45	105	5	57.3	0.8	●	23
8684410	4.1			6	55.5	0.8	●	29
8686420	4.2 - 5	46		5	56.5	0.9	●	23
8684420	4.2			6	54.6	0.9	●	30
8686430	4.3 - 5	47		5	55.7	0.9	●	23
8684430	4.3			6	53.8	0.9	●	29
8686440	4.4 - 5	48		5	54.9	0.9	●	23
8684440	4.4			6	53	0.9	●	30
8686450	4.5 - 5	50		5	53.1	0.9	●	23
8684450	4.5			6	51.2	0.9	●	29
8686460	4.6 - 5	51		5	52.3	1	●	23
8684460	4.6			6	50.4	1	●	30
8686470	4.7 - 5	52		5	51.4	1	●	23
8684470	4.7			6	49.6	1	●	29
8686480	4.8 - 5	53		5	50.6	1	●	23

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8684480	4.8	53	105	6	48.8	1	●	29
8686490	4.9 - 5	54		5	49.8	1	●	23
8684490	4.9			6	47.9	1	●	29
8686500	5 - 5	55		5	49	1	●	23
8684500	5			6	47.1	1	●	29
8684510	5.1	56	115		56.3	1.1	●	34
8684520	5.2	57			55.5	1.1	●	34
8684530	5.3	58			54.7	1.1	●	34
8684540	5.4	59			53.9	1.1	●	34
8684550	5.5	61			52.1	1.1	●	34
8684560	5.6	62			51.3	1.2	●	34
8684570	5.7	63			50.4	1.2	●	34
8684580	5.8	64			49.6	1.2	●	35
8684590	5.9	65			48.8	1.2	●	35
8684600	6	66			48	1.2	●	35
8686610	6.1 - 7	67	125	7	57	1.3	●	48
8684610	6.1			8	53.5	1.3	●	59
8686620	6.2 - 7	68		7	56	1.3	●	48
8684620	6.2			8	52.6	1.3	●	59
8686630	6.3 - 7	69		7	55	1.3	●	49
8684630	6.3			8	51.8	1.3	●	59
8686640	6.4 - 7	70		7	54	1.3	●	49
8684640	6.4			8	51	1.3	●	59
8686650	6.5 - 7	72		7	52	1.3	●	49
8684650	6.5			8	49.2	1.3	●	59
8686660	6.6 - 7	73		7	51	1.4	●	49
8684660	6.6			8	48.4	1.4	●	57
8686670	6.7 - 7	74		7	50	1.4	●	49
8684670	6.7			8	47.6	1.4	●	58
8686680	6.8 - 7	75		7	49	1.4	●	50
8684680	6.8			8	46.8	1.4	●	58
8686690	6.9 - 7	76		7	48	1.4	●	50
8684690	6.9			8	45.9	1.4	●	58
8686700	7 - 7	77		7	47	1.4	●	50
8684700	7			8	45.1	1.4	●	59
8684710	7.1	78	140		61	1.5	●	68

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直径 DC 7.2～12 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-SUS-8D	○	◎	◎	◎						◎		○	○	◎		○	◎	◎		○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DW1109**

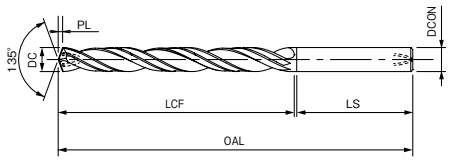
硬质合金内冷油孔钻头 8D 型
CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 8D TYPE

The A Brand

ADO-SUS-8D

切削条件 Cutting Conditions | P.394

R 型横刃
R thinning



CARBIDE | WXL | h8 | 30° | SHRINK FIT

上一页

FROM 直径 DC 2～7.1

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8684720	**7.2**	79	140	8	60	1.5	●	69
8684730	**7.3**	80			59	1.5	●	70
8684740	**7.4**	81			58	1.5	●	71
8684750	**7.5**	83			56	1.6	●	71
8684760	**7.6**	84			55	1.6	●	71
8684770	**7.7**	85			54	1.6	●	71
8684780	**7.8**	86			53	1.6	●	72
8684790	**7.9**	87			52	1.6	●	72
8684800	**8**	88			51	1.7	●	73
8686810	**8.1 - 9**	89	150	9	60	1.7	●	89
8684810	**8.1**			10	56.5	1.7	●	101
8686820	**8.2 - 9**	90		9	59	1.7	●	89
8684820	**8.2**			10	55.6	1.7	●	101
8686830	**8.3 - 9**	91		9	58	1.7	●	90
8684830	**8.3**			10	54.8	1.7	●	102
8686840	**8.4 - 9**	92		9	57	1.7	●	91
8684840	**8.4**			10	54	1.7	●	102
8686850	**8.5 - 9**	94		9	55	1.8	●	91
8684850	**8.5**			10	52.2	1.8	●	102
8686860	**8.6 - 9**	95		9	54	1.8	●	91
8684860	**8.6**			10	51.4	1.8	●	102
8686870	**8.7 - 9**	96		9	53	1.8	●	92
8684870	**8.7**			10	50.6	1.8	●	103
8686880	**8.8 - 9**	97		9	52	1.8	●	92
8684880	**8.8**			10	49.8	1.8	●	103
8686890	**8.9 - 9**	98		9	51	1.8	●	93
8684890	**8.9**			10	48.9	1.8	●	104
8686900	**9 - 9**	99		9	50	1.9	●	94
8684900	**9**			10	48.1	1.9	●	104
8684910	**9.1**	100	160		59	1.9	●	115
8684920	**9.2**	101			58	1.9	●	116
8684930	**9.3**	102			57	1.9	●	117
8684940	**9.4**	103			56	1.9	●	118
8684950	**9.5**	105			54	2	●	118
8684960	**9.6**	106			53	2	●	118

商品号 EDP No.	直径 - 柄径 DC - DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8684970	**9.7**	107	160	10	52	2	●	119
8684980	**9.8**	108			51	2	●	120
8684990	**9.9**	109			50	2.1	●	121
8685000	**10**	110			49	2.1	●	121
8687010	**10.1 - 11**	111	182	11	70	2.1	●	163
8685010	**10.1**			12	66.5	2.1	●	179
8687020	**10.2 - 11**	112		11	69	2.1	●	163
8685020	**10.2**			12	65.6	2.1	●	181
8687030	**10.3 - 11**	113		11	68	2.1	●	164
8685030	**10.3**			12	64.8	2.1	●	181
8687040	**10.4 - 11**	114		11	67	2.2	●	165
8685040	**10.4**			12	64	2.2	●	182
8687050	**10.5 - 11**	116		11	65	2.2	●	166
8685050	**10.5**			12	62.2	2.2	●	182
8687060	**10.6 - 11**	117		11	64	2.2	●	167
8685060	**10.6**			12	61.4	2.2	●	182
8687070	**10.7 - 11**	118		11	63	2.2	●	167
8685070	**10.7**			12	60.6	2.2	●	183
8687080	**10.8 - 11**	119		11	62	2.2	●	168
8685080	**10.8**			12	59.8	2.2	●	183
8687090	**10.9 - 11**	120		11	61	2.3	●	169
8685090	**10.9**			12	58.9	2.3	●	184
8687100	**11 - 11**	121		11	60	2.3	●	172
8685100	**11**			12	58.1	2.3	●	184
8685110	**11.1**	122	194		71	2.3	●	208
8685120	**11.2**	123			70	2.3	●	210
8685130	**11.3**	124			69	2.3	●	211
8685140	**11.4**	125			68	2.4	●	211
8685150	**11.5**	127			66	2.4	●	212
8685160	**11.6**	128			65	2.4	●	214
8685170	**11.7**	129			64	2.4	●	215
8685180	**11.8**	130			63	2.4	●	212
8685190	**11.9**	131			62	2.5	●	217
8685200	**12**	132			61	2.5	●	218

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-SUS-8D	○	◎	◎	◎						◎		○	○	◎		○	◎	◎		○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

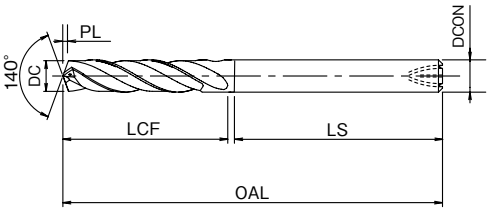
3刃内冷油孔硬质合金钻头 3D 型

3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 3D TYPE

The A Brand

ADO-TRS-3D

切削条件 Cutting Conditions | P.396



CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

涂层可能会有颜色不均的情况，但这并不影响刀具的性能。

Drills may have some discoloration, but it does not cause any performance problems.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8720300	**3**	18	66	3	47	0.5	●	9
8720330	**3.3**	20	74	4	51.7	0.6	●	12
8720350	**3.5**	21			51.1	0.6	●	12
8720366	**3.66**	22			50.4	0.7	●	12
8720400	**4**	24			49	0.7	●	13
8720420	**4.2**	26	80	6	49.6	0.8	●	25
8720450	**4.5**	27			49.2	0.8	●	25
8720460	**4.6**	28			48.4	0.8	●	25
8720500	**5**	25			52.1	0.9	●	27
8720510	**5.1**	26	82		53.3	0.9	●	–
8720520	**5.2**				53.5	0.9	●	28
8720530	**5.3**	27			52.7	1	●	–
8720540	**5.4**				52.9	1	●	–
8720550	**5.5**	28			52.1	1	●	–
8720560	**5.6**				52.3	1	●	28
8720570	**5.7**	29			51.4	1	●	–
8720580	**5.8**				51.6	1.1	●	–
8720590	**5.9**	30			50.8	1.1	●	–
8720600	**6**				51	1.1	●	–
8720610	**6.1**	31	88	8	52.5	1.1	●	–
8720620	**6.2**				52.6	1.1	●	–
8720630	**6.3**	32			51.8	1.1	●	–
8720640	**6.4**				52	1.2	●	–
8720650	**6.5**	33			51.2	1.2	●	–
8720660	**6.6**				51.4	1.2	●	–
8720670	**6.7**	34			50.6	1.2	●	–
8720680	**6.8**				50.8	1.2	●	–
8720690	**6.9**	35			49.9	1.3	●	–
8720700	**7**				50.1	1.3	●	–
8720710	**7.1**	36	94		57	1.3	●	–
8720720	**7.2**				57	1.3	●	–

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8720730	**7.3**	37	94	8	56	1.3	●	–
8720738	**7.38**				56	1.3	●	–
8720740	**7.4**				56	1.3	●	–
8720750	**7.5**	38			55	1.4	●	–
8720760	**7.6**				55	1.4	●	–
8720770	**7.7**	39			54	1.4	●	–
8720780	**7.8**				54	1.4	●	–
8720790	**7.9**	40			53	1.4	●	–
8720800	**8**				53	1.5	●	–
8720810	**8.1**	41	101	10	55.5	1.5	●	–
8720820	**8.2**				55.6	1.5	●	–
8720830	**8.3**	42			54.8	1.5	●	–
8720840	**8.4**				55	1.5	●	–
8720850	**8.5**	43			54.2	1.5	●	–
8720860	**8.6**				54.4	1.6	●	–
8720870	**8.7**	44			53.6	1.6	●	–
8720880	**8.8**				53.8	1.6	●	–
8720890	**8.9**	45			52.9	1.6	●	–
8720900	**9**				53.1	1.6	●	–
8720910	**9.1**	46	106		59	1.7	●	–
8720920	**9.2**				59	1.7	●	–
8720925	**9.25**	47			58	1.7	●	–
8720930	**9.3**				58	1.7	●	–
8720938	**9.38**				58	1.7	●	–
8720940	**9.4**				58	1.7	●	–
8720950	**9.5**	48			57	1.7	●	–
8720960	**9.6**				57	1.7	●	–
8720970	**9.7**	49			56	1.8	●	–
8720980	**9.8**				56	1.8	●	–
8720990	**9.9**	50			55	1.8	●	–
8721000	**10**				55	1.8	●	–

下一页
直径 DC 10.1～20 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-TRS-3D	◎	◎	◎	◎	◎	○	○			○		◎	◎				○				

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **DW1111**

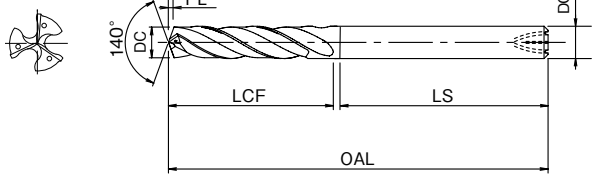
3刃内冷油孔硬质合金钻头 3D 型

3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 3D TYPE

The A Brand

ADO-TRS-3D

切削条件 Cutting Conditions | P.396



CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

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上一页 FROM 直径 DC 3～10

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8721010	**10.1**	51	113	12	57.5	1.8	●	–
8721020	**10.2**				57.6	1.9	●	–
8721030	**10.3**	52			56.8	1.9	●	–
8721040	**10.4**				57	1.9	●	–
8721050	**10.5**	53			56.2	1.9	●	–
8721060	**10.6**				56.4	1.9	●	–
8721070	**10.7**	54			55.6	1.9	●	–
8721080	**10.8**				55.8	2	●	–
8721090	**10.9**	55			54.9	2	●	–
8721100	**11**				55.1	2	●	–
8721110	**11.1**	56	120		63	2	●	–
8721120	**11.2**				63	2	●	–
8721125	**11.25**	57			62	2	●	–
8721130	**11.3**				62	2.1	●	–
8721138	**11.38**				62	2.1	●	–
8721140	**11.4**				62	2.1	●	–
8721150	**11.5**	58			61	2.1	●	–
8721160	**11.6**				61	2.1	●	–
8721170	**11.7**	59			60	2.1	●	–
8721180	**11.8**				60	2.1	●	–
8721190	**11.9**	60			59	2.2	●	149
8721200	**12**				59	2.2	●	–
8721250	**12.5**	63	128	14	61.2	2.3	●	–
8721300	**13**	65			60.1	2.4	●	203

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8721325	**13.25**	67	134	14	66	2.4	●	–
8721330	**13.3**				66	2.4	●	–
8721338	**13.38**				66	2.4	●	–
8721350	**13.5**	68			65	2.5	●	–
8721400	**14**	70			63	2.5	●	–
8721410	**14.1**	71	140	16	64.5	2.6	●	–
8721420	**14.2**				64.6	2.6	●	–
8721430	**14.3**	72			63.8	2.6	●	–
8721450	**14.5**	73			63.2	2.6	●	–
8721500	**15**	75			62.1	2.7	●	283
8721520	**15.2**	76	145		68	2.8	●	–
8721530	**15.3**	77			67	2.8	●	–
8721550	**15.5**	78			66	2.8	●	298
8721600	**16**	80			64	2.9	●	301
8721650	**16.5**	83	150	18	63.2	3	●	–
8721700	**17**	85			62.1	3.1	●	–
8721725	**17.25**	87	155		67	3.1	●	–
8721750	**17.5**	88			66	3.2	●	–
8721800	**18**	90			64	3.3	●	–
8721850	**18.5**	93	160	20	63.2	3.4	●	–
8721900	**19**	95			62.1	3.5	●	–
8721925	**19.25**	97	165		67	3.5	●	–
8721950	**19.5**	98			66	3.5	●	–
8722000	**20**	100			64	3.6	●	–

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-TRS-3D	◎	◎	◎	◎	◎	○	○			○		◎	◎				○				

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

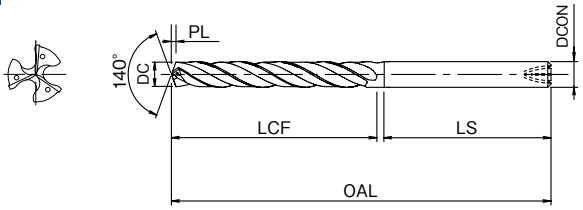
3刃内冷油孔硬质合金钻头 5D 型

3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 5D TYPE

The A Brand

ADO-TRS-5D

切削条件 Cutting Conditions | P.396



CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

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单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8722300	**3**	27	78	3	50	0.5	●	8
8722330	**3.3**	30	86	4	53.7	0.6	●	14
8722350	**3.5**	32			52.1	0.6	●	14
8722366	**3.66**	33			51.4	0.7	●	14
8722400	**4**	36			49	0.7	●	14
8722420	**4.2**	38	95	6	52.6	0.8	●	27
8722450	**4.5**	41			50.2	0.8	●	28
8722460	**4.6**	42			49.4	0.8	●	28
8722500	**5**	45			47.1	0.9	●	—
8722510	**5.1**	41	100		56.3	0.9	●	—
8722520	**5.2**	42			55.5	0.9	●	—
8722530	**5.3**	43			54.7	1	●	—
8722540	**5.4**	44			53.9	1	●	—
8722550	**5.5**				54.1	1	●	—
8722560	**5.6**	45			53.3	1	●	—
8722570	**5.7**	46			52.4	1	●	—
8722580	**5.8**	47			51.6	1.1	●	—
8722590	**5.9**	48			50.8	1.1	●	—
8722600	**6**				51	1.1	●	—
8722610	**6.1**	49	109	8	55.5	1.1	●	—
8722620	**6.2**	50			54.6	1.1	●	—
8722630	**6.3**	51			53.8	1.1	●	—
8722640	**6.4**	52			53	1.2	●	—
8722650	**6.5**				53.2	1.2	●	—
8722660	**6.6**	53			52.4	1.2	●	—
8722670	**6.7**	54			51.6	1.2	●	—
8722680	**6.8**	55			50.8	1.2	●	—
8722690	**6.9**	56			49.9	1.3	●	—
8722700	**7**				50.1	1.3	●	—
8722710	**7.1**	57	118		60	1.3	●	—
8722720	**7.2**	58			59	1.3	●	—

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8722730	**7.3**	59	118	8	58	1.3	●	—
8722738	**7.38**	60			57	1.3	●	—
8722740	**7.4**				57	1.3	●	—
8722750	**7.5**				57	1.4	●	—
8722760	**7.6**	61			56	1.4	●	—
8722770	**7.7**	62			55	1.4	●	—
8722780	**7.8**	63			54	1.4	●	64
8722790	**7.9**	64			53	1.4	●	—
8722800	**8**				53	1.5	●	—
8722810	**8.1**	65	128	10	58.5	1.5	●	—
8722820	**8.2**	66			57.6	1.5	●	—
8722830	**8.3**	67			56.8	1.5	●	—
8722840	**8.4**	68			56	1.5	●	—
8722850	**8.5**				56.2	1.5	●	—
8722860	**8.6**	69			55.4	1.6	●	—
8722870	**8.7**	70			54.6	1.6	●	—
8722880	**8.8**	71			53.8	1.6	●	—
8722890	**8.9**	72			52.9	1.6	●	—
8722900	**9**				53.1	1.6	●	—
8722910	**9.1**	73	136		62	1.7	●	—
8722920	**9.2**	74			61	1.7	●	—
8722925	**9.25**				61	1.7	●	—
8722930	**9.3**	75			60	1.7	●	—
8722938	**9.38**	76			59	1.7	●	—
8722940	**9.4**				59	1.7	●	—
8722950	**9.5**				59	1.7	●	—
8722960	**9.6**	77			58	1.7	●	—
8722970	**9.7**	78			57	1.8	●	—
8722980	**9.8**	79			56	1.8	●	—
8722990	**9.9**	80			55	1.8	●	—
8723000	**10**				55	1.8	●	—

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直径 DC 10.1～20 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-TRS-5D	◎	◎	◎	◎	◎	○				○		◎	◎								

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1112

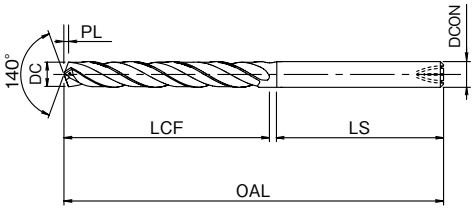
3刃内冷油孔硬质合金钻头 5D 型

3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 5D TYPE

The A Brand

ADO-TRS-5D

切削条件 Cutting Conditions | P.396



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CARBIDE | EgiAs | h8 | 30° | SHRINK FIT

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FROM 直径 DC 3～10

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8723010	**10.1**	81	146	12	60.5	1.8	●	–
8723020	**10.2**	82			59.6	1.9	●	–
8723030	**10.3**	83			58.8	1.9	●	–
8723040	**10.4**	84			58	1.9	●	–
8723050	**10.5**				58.2	1.9	●	–
8723060	**10.6**	85			57.4	1.9	●	–
8723070	**10.7**	86			56.6	1.9	●	–
8723080	**10.8**	87			55.8	2	●	–
8723090	**10.9**	88			54.9	2	●	–
8723100	**11**				55.1	2	●	–
8723110	**11.1**	89	156		66	2	●	–
8723120	**11.2**	90			65	2	●	–
8723125	**11.25**				65	2	●	–
8723130	**11.3**	91			64	2.1	●	–
8723138	**11.38**	92			63	2.1	●	–
8723140	**11.4**				63	2.1	●	–
8723150	**11.5**				63	2.1	●	–
8723160	**11.6**	93			62	2.1	●	–
8723170	**11.7**	94			61	2.1	●	–
8723180	**11.8**	95			60	2.1	●	–
8723190	**11.9**	96			59	2.2	●	–
8723200	**12**				59	2.2	●	–
8723250	**12.5**	100	167	14	63.2	2.3	●	–
8723300	**13**	104			60.1	2.4	●	–

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8723325	**13.25**	106	176	14	69	2.4	●	–
8723330	**13.3**	107			68	2.4	●	–
8723338	**13.38**	108			67	2.4	●	–
8723350	**13.5**				67	2.5	●	–
8723400	**14**	112			63	2.5	●	–
8723410	**14.1**	113	185	16	67.5	2.6	●	–
8723420	**14.2**	114			66.6	2.6	●	–
8723430	**14.3**	115			65.8	2.6	●	–
8723450	**14.5**	116			65.2	2.6	●	–
8723500	**15**	120			62.1	2.7	●	–
8723520	**15.2**	122	193		70	2.8	●	–
8723530	**15.3**	123			69	2.8	●	–
8723550	**15.5**	124			68	2.8	●	–
8723600	**16**	128			64	2.9	●	–
8723650	**16.5**	132	201	18	65.2	3	●	–
8723700	**17**	136			62.1	3.1	●	–
8723725	**17.25**	138	209		70	3.1	●	–
8723750	**17.5**	140			68	3.2	●	–
8723800	**18**	144			64	3.3	●	–
8723850	**18.5**	148	217	20	65.2	3.4	●	–
8723900	**19**	152			62.1	3.5	●	–
8723925	**19.25**	154	225		70	3.5	●	–
8723950	**19.5**	156			68	3.5	●	–
8724000	**20**	160			64	3.6	●	–

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADO-TRS-5D	◎	◎	◎	◎	◎	○				○		◎	◎								

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

3刃内冷油孔硬质合金钻头3D 型

3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 3D TYPE

The A Brand

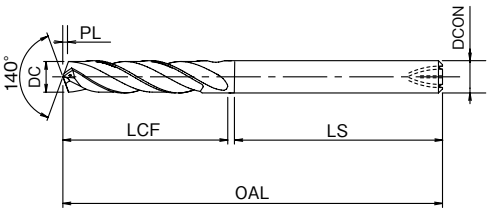
TRS-HO-3D

切削条件 Cutting Conditions | P.397

钢·铸铁加工，实现进给速度超过Vf=1,000mm/min。

High efficient processing of Steel & Cast Irons drilling feeds exceeding 1,000mm/min.

R 型横刃
R thinning



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。

Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | WDI | h8 | 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8660500	**5**	25	80	5	55	0.9	▲	22
8660510	**5.1**	26	82	6	53.3	0.9	▲	28
8660520	**5.2**				53.5	0.9	▲	28
8660550	**5.5**	28			52.1	1	▲	28
8660560	**5.6**				52.3	1	▲	28
8660570	**5.7**	29			51.4	1	▲	28
8660580	**5.8**				51.6	1.1	▲	28
8660600	**6**	30			51	1.1	▲	28
8660630	**6.3**	32	88	7	56	1.1	▲	39
8660640	**6.4**				56	1.2	▲	39
8660670	**6.7**	34			54	1.2	▲	39
8660690	**6.9**	35			53	1.3	▲	40
8660700	**7**				53	1.3	▲	40
8660720	**7.2**	36	94	8	57	1.3	▲	54
8660730	**7.3**	37			56	1.3	▲	53
8660750	**7.5**	38			55	1.4	▲	53
8660760	**7.6**	38			55	1.4	▲	53
8660780	**7.8**	39			54	1.4	▲	54

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8660790	**7.9**	40	94	8	53	1.4	▲	53
8660800	**8**				53	1.5	▲	54
8660810	**8.1**	41	101	9	60	1.5	▲	71
8660820	**8.2**				60	1.5	▲	72
8660840	**8.4**	42			59	1.5	▲	72
8660850	**8.5**	43			58	1.5	▲	72
8660860	**8.6**				58	1.6	▲	72
8660870	**8.7**	44			57	1.6	▲	72
8660880	**8.8**				57	1.6	▲	72
8660890	**8.9**	45			56	1.6	▲	72
8660910	**9.1**	46	106	10	59	1.7	▲	90
8660930	**9.3**	47			58	1.7	▲	91
8660940	**9.4**				58	1.7	▲	91
8660950	**9.5**	48			57	1.7	▲	91
8660980	**9.8**	49			56	1.8	▲	92
8660990	**9.9**	50			55	1.8	▲	92
8661010	**10.1**	51	113	11	62	1.8	▲	113

下一页
直径 DC 10.2～20 NEXT

▲=此产品已停止生产，由ADO-TRS-3D 替代。 **(ADO-TRS-3D：P.182)**

▲=These products have been stopped producing and replaced by ADO-TRS-3D. (ADO-TRS-3D : p.182)

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
TRS-HO-3D	◎	◎	◎	◎	◎	○	○			○		◎	◎				○				

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1034

3刃内冷油孔硬质合金钻头 3D 型

3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 3D TYPE

A The A Brand

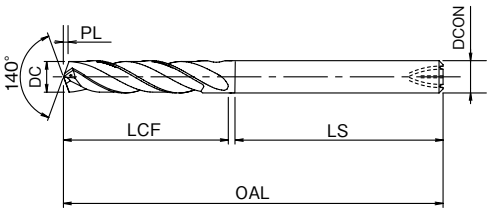
TRS-HO-3D

切削条件 Cutting Conditions | P.397

钢·铸铁加工，实现进给速度超过 Vf=1,000mm/min。

High efficient processing of Steel & Cast Irons drilling feeds exceeding 1,000mm/min.

R 型横刃
R thinning



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。

Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | WDI | h8 | 30° | SHRINK FIT

上一页
FROM 直径 DC 5～10.1

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8661020	**10.2**	51	113	11	62	1.9	▲	114
8661040	**10.4**	52			61	1.9	▲	114
8661050	**10.5**	53			60	1.9	▲	114
8661060	**10.6**				60	1.9	▲	114
8661070	**10.7**	54			59	1.9	▲	115
8661080	**10.8**				59	2	▲	115
8661090	**10.9**	55			58	2	▲	116
8661110	**11.1**	56	120	12	63	2	▲	144
8661120	**11.2**				63	2	▲	145
8661130	**11.3**	57			62	2.1	▲	144
8661140	**11.4**				62	2.1	▲	145
8661150	**11.5**	58			61	2.1	▲	146
8661180	**11.8**	59			60	2.1	▲	146
8661200	**12**	60			59	2.2	▲	147
8661220	**12.2**	61	128	13	67	2.2	△	183
8661230	**12.3**	62			66	2.2	△	183
8661240	**12.4**				66	2.3	△	183
8661250	**12.5**	63			65	2.3	▲	183
8661290	**12.9**	65			63	2.3	△	183
8661300	**13**				63	2.4	▲	184
8661330	**13.3**	67	134	14	67	2.4	▲	214
8661340	**13.4**				67	2.4	△	216
8661350	**13.5**	68			65	2.5	▲	216

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8661360	**13.6**	68	134	14	66	2.5	△	215
8661370	**13.7**	69			65	2.5	△	216
8661380	**13.8**				65	2.5	△	216
8661400	**14**	70			63	2.5	▲	217
8661410	**14.1**	71	140	15	69	2.6	▲	253
8661420	**14.2**				69	2.6	▲	253
8661430	**14.3**	72			68	2.6	▲	253
8661450	**14.5**	73			67	2.6	▲	257
8661470	**14.7**	74			66	2.7	△	255
8661480	**14.8**				66	2.7	△	256
8661500	**15**	75			65	2.7	▲	257
8661510	**15.1**	76	145	16	69	2.7	△	293
8661520	**15.2**				69	2.8	▲	293
8661540	**15.4**	77			68	2.8	△	294
8661550	**15.5**	78			66	2.8	▲	294
8661570	**15.7**	79			66	2.9	△	294
8661580	**15.8**				66	2.9	△	295
8661600	**16**	80			64	2.9	▲	297
8661650	**16.5**	83	150	17	67	3	▲	344
8661800	**18**	90	155	18	64	3.3	▲	389
8661850	**18.5**	93	160	19	67	3.4	▲	450
8661950	**19.5**	98	165	20	67	3.5	▲	498
8662000	**20**	100			65	3.6	▲	502

▲=此产品已停止生产，由ADO-TRS-3D 替代。 **(ADO-TRS-3D：P.182)**

▲=These products have been stopped producing and replaced by ADO-TRS-3D. (ADO-TRS-3D : p.182)

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
TRS-HO-3D	◎	◎	◎	◎	◎	○	○			○		◎	◎				○				

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

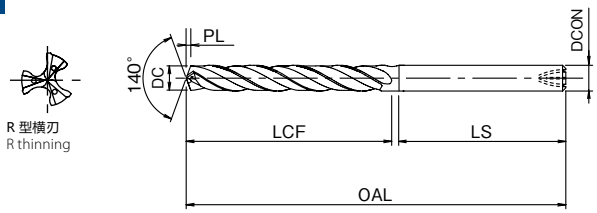
3刃内冷油孔硬质合金钻头 5D 型
3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 5D TYPE

The A Brand

TRS-HO-5D

切削条件 Cutting Conditions | P.397

钢·铸铁加工，实现进给速度超过Vf=1,000mm/min。
High efficient processing of Steel & Cast Irons drilling feeds exceeding 1,000mm/min.



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | WDI | h8 | 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8662520	**5.2**	42	100	6	55.5	0.9	▲	31
8662550	**5.5**	44			54.1	1	▲	32
8662560	**5.6**	45			53.3	1	▲	31
8662570	**5.7**	46			52.4	1	▲	31
8662600	**6**	48			51	1.1	▲	33
8662620	**6.2**	50	109	7	59	1.1	▲	44
8662630	**6.3**	51			58	1.1	▲	44
8662650	**6.5**	52			57	1.2	▲	44
8662660	**6.6**	53			56	1.2	▲	45
8662690	**6.9**	56			53	1.3	▲	46
8662720	**7.2**	58	118	8	59	1.3	▲	62
8662730	**7.3**	59			58	1.3	▲	63
8662740	**7.4**	60			57	1.3	▲	62
8662790	**7.9**	64			53	1.4	▲	63
8662810	**8.1**	65	128	9	63	1.5	▲	84

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8662820	**8.2**	66	128	9	61	1.5	▲	86
8662830	**8.3**	67			60	1.5	▲	85
8662840	**8.4**	68			59	1.5	▲	84
8662860	**8.6**	69			58	1.6	▲	85
8662870	**8.7**	70			57	1.6	▲	86
8662880	**8.8**	71			56	1.6	▲	86
8662920	**9.2**	74	136	10	61	1.7	▲	108
8662930	**9.3**	75			60	1.7	▲	108
8662940	**9.4**	76			59	1.7	▲	108
8662970	**9.7**	78			57	1.8	▲	109
8662980	**9.8**	79			56	1.8	▲	110
8662990	**9.9**	80			55	1.8	▲	111
8663000	**10**				55	1.8	▲	112
8663010	**10.1**	81	146	11	64	1.8	▲	137
8663020	**10.2**	82			63	1.9	▲	137

下一页
直径 DC 10.6～19.5 NEXT

▲=此产品已停止生产，由ADO-TRS-5D 替代。 **(ADO-TRS-5D：P.184)**
▲=These products have been stopped producing and replaced by ADO-TRS-5D. (ADO-TRS-5D : p.184)

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
TRS-HO-5D	◎	◎	◎	◎	◎	○				○		◎	◎								

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **DW1035**

3刃内冷油孔硬质合金钻头 5D 型

3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 5D TYPE

The A Brand

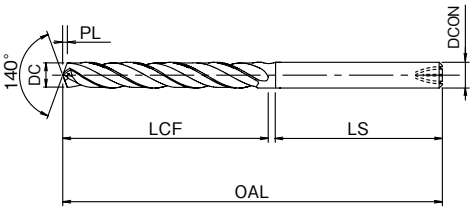
TRS-HO-5D

切削条件 Cutting Conditions | P.397

钢·铸铁加工，实现进给速度超过 Vf=1,000mm/min。

High efficient processing of Steel & Cast Irons drilling feeds exceeding 1,000mm/min.

R 型横刃
R thinning



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。

Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | WDI | h8 | 30° | SHRINK FIT

上一页

FROM 直径 DC 5.2～10.2

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8663060	**10.6**	85	146	11	60	1.9	▲	140
8663080	**10.8**	87			58	2	▲	140
8663090	**10.9**	88			57	2	▲	141
8663110	**11.1**	89	156	12	66	2	▲	173
8663120	**11.2**	90			65	2	▲	171
8663130	**11.3**	91			64	2.1	▲	172
8663140	**11.4**	92			63	2.1	▲	172
8663150	**11.5**				63	2.1	▲	174
8663170	**11.7**	94			61	2.1	▲	174
8663190	**11.9**	96			59	2.2	▲	175
8663210	**12.1**	97	167	13	69	2.2	△	217
8663220	**12.2**	98			68	2.2	△	217
8663240	**12.4**	100			66	2.3	△	217
8663250	**12.5**				66	2.3	▲	219
8663290	**12.9**	104			62	2.3	△	223
8663310	**13.1**	105	176	14	70	2.4	△	260
8663320	**13.2**	106			69	2.4	△	260
8663330	**13.3**	107			68	2.4	▲	261
8663340	**13.4**	108			67	2.4	△	261
8663380	**13.8**	111			64	2.5	△	262

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8663390	**13.9**	112	176	14	63	2.5	△	262
8663400	**14**				63	2.5	▲	262
8663410	**14.1**	113	185	15	71	2.6	▲	311
8663420	**14.2**	114			70	2.6	▲	311
8663440	**14.4**	116			68	2.6	△	311
8663450	**14.5**				68	2.6	▲	311
8663470	**14.7**	118			66	2.7	△	312
8663480	**14.8**	119			65	2.7	△	312
8663510	**15.1**	121	193	16	71	2.7	△	365
8663540	**15.4**	124			68	2.8	△	365
8663550	**15.5**				68	2.8	▲	366
8663570	**15.7**	126			66	2.9	△	362
8663590	**15.9**	128			64	2.9	△	366
8663600	**16**				64	2.9	▲	372
8663650	**16.5**	132	201	17	68	3	▲	437
8663700	**17**	136			64	3.1	▲	438
8663750	**17.5**	140	209	18	68	3.2	▲	498
8663800	**18**	144			64	3.3	▲	502
8663900	**19**	152	217	19	64	3.5	▲	565
8663950	**19.5**	156	225	20	68	3.5	▲	649

▲=此产品已停止生产，由ADO-TRS-5D 替代。**(ADO-TRS-5D：P.184)**

▲=These products have been stopped producing and replaced by ADO-TRS-5D. (ADO-TRS-5D : p.184)

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
TRS-HO-5D	◎	◎	◎	◎	◎	○				○		◎	◎								

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

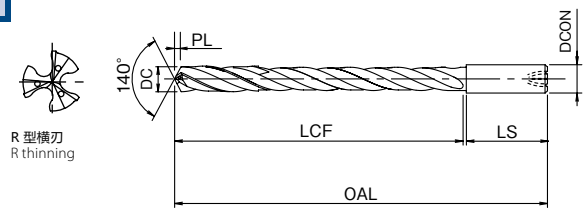
3刃内冷油孔硬质合金钻头 10D 型
3-FLUTE CARBIDE DRILL WITH INTERNAL COOLANT SUPPLY 10D TYPE

The A Brand

TRS-HO-10D

切削条件 Cutting Conditions | P.398

钢·铸铁加工，实现进给速度超过Vf=1,000mm/min。
High efficient processing of Steel & Cast Irons drilling feeds exceeding 1,000mm/min.



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | WDI | e8 | 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8664050	**5**	65	115	5	50	0.9	●	24
8664055	**5.5**	78	128	6	48	1	●	36
8664060	**6**				48	1.1	●	38
8664065	**6.5**	87	140	7	53	1.2	●	50
8664070	**7**	90			50	1.3	●	53
8664075	**7.5**	100	155	8	53	1.4	●	71
8664080	**8**	105			48	1.5	●	73
8664085	**8.5**	110	165	9	55	1.5	●	93

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8664090	**9**	115	165	9	50	1.6	●	96
8664095	**9.5**	125	190	10	65	1.7	●	134
8664100	**10**	130			58	1.8	●	137
8664105	**10.5**	140	205	11	65	1.9	●	173
8664110	**11**	145			60	2	●	177
8664115	**11.5**	155	215	12	60	2.1	●	206
8664120	**12**				58	2.2	●	217

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
TRS-HO-10D	◎	◎	◎	◎								◎	◎								

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

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

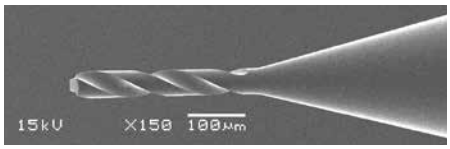
G-LIST No. | DW1016

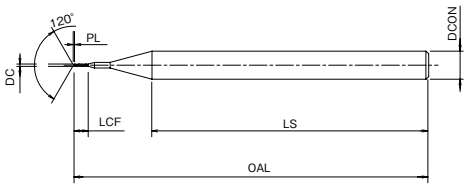
极小径UVM 钻头 5D 型

UVM ULTRA SMALL CARBIDE DRILL : 5D

UVM-DRL-5D

在前所未有的领域中加工极小径钻孔！ 最小径φ0.02 ！
Ultra micromachining now a reality! Smallest size : 0.02mm





SS | 0~-0.003 | SHANK h3

单位:mm Unit:mm

商品号 EDP No.	直径 × 柄径 DC × DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8589002	0.02 × 3	0.12	38	3	30.5	0.01	●	9
8589003	0.03 × 3	0.18			30.5	0.01	●	9
8589004	0.04 × 3	0.24			30.5	0.01	●	9
8589005	0.05 × 3	0.3			30.5	0.01	●	9
8589008	0.08 × 3	0.48			30.5	0.02	●	9
8589052	0.02 × 3.175	0.12		3.175	30.2	0.01	●	9
8589053	0.03 × 3.175	0.18			30.2	0.01	●	9

＊＝非标品

商品号 EDP No.	直径 × 柄径 DC × DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8589054	0.04 × 3.175	0.24	38	3.175	30.2	0.01	●	9
8589055	0.05 × 3.175	0.3			30.2	0.01	●	9
＊	0.06 × 3.175	0.36			30.2	0.02	＊	—
＊	0.07 × 3.175	0.42			30.2	0.02	＊	—
8589058	0.08 × 3.175	0.48			30.2	0.02	●	9
＊	0.09 × 3.175	0.54			30.2	0.03	＊	—

＊=Special order products.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镁合金 Machinable Ceramics
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
UVM-DRL-5D						○	◎	○		◎	○				○	○	○	◎

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

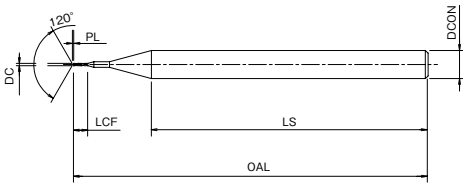
极小径UVM 钻头 10D 型

UVM ULTRA SMALL CARBIDE DRILL : 10D

UVM-DRL-10D

实现在前所未有的领域中进行极小径钻孔！ 最小径φ0.02！

Ultra micromachining now a reality! Smallest size : 0.02mm



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单位:mm Unit:mm

商品号 EDP No.	直径 × 柄径 DC × DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8589102	0.02 × 3	0.22	38	3	30.5	0.01	●	9
8589103	0.03 × 3	0.33			30.5	0.01	●	9
8589104	0.04 × 3	0.44			30.5	0.01	●	9
8589105	0.05 × 3	0.55			30.5	0.01	●	9
8589108	0.08 × 3	0.88			30.5	0.02	●	9
8589152	0.02 × 3.175	0.22		3.175	30.2	0.01	●	9
8589153	0.03 × 3.175	0.33			30.2	0.01	●	9

＊＝非标品

商品号 EDP No.	直径 × 柄径 DC × DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8589154	0.04 × 3.175	0.44	38	3.175	30.2	0.01	●	9
8589155	0.05 × 3.175	0.55			30.2	0.01	●	9
＊	0.06 × 3.175	0.66			30.2	0.02	＊	–
＊	0.07 × 3.175	0.77			30.2	0.02	＊	–
8589158	0.08 × 3.175	0.88			30.2	0.02	●	9
＊	0.09 × 3.175	0.99			30.2	0.03	＊	–

＊=Special order products.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镁合金 Machinable Ceramics
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
UVM-DRL-10D						○	◎	○		◎	○				○	○	○	◎

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

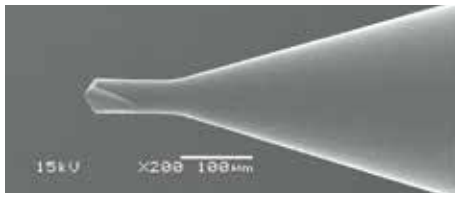
■标识说明请参考 P.1。 See p.1 for explanation of icons.

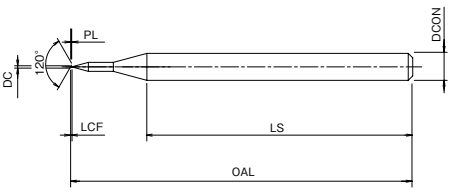
G-LIST No. | CW1014

极小径UVM中心钻
UVM ULTRA SMALL CARBIDE LEADING DRILL

UVM-LDS

与UVM-DRL一起使用，可以大幅提高孔加工精度。
Use together with UVM-DRL, to enable accurate drilling.





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单位:mm Unit:mm

商品号 EDP No.	颚X先端角X柄径 DC × SIG × DCON	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8589205	0.05×120°×3	0.075	38	3	30.5	0.01	●	9
*	0.03×120°×3.175	0.045			30.2	0.01	*	—
8589255	0.05×120°×3.175	0.075	38	3.175	30.2	0.01	●	9
*	0.1×120°×3.175	0.15			30.2	0.03	*	—

＊＝非标品
＊=Special order products.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镁合金 Machinable Ceramics
	C~0.25%	0.25~0.45%	0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
UVM-LDS						○	◎	○		◎					○	○	○	◎

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

极小径·精密加工用硬质合金超短刃型钻头

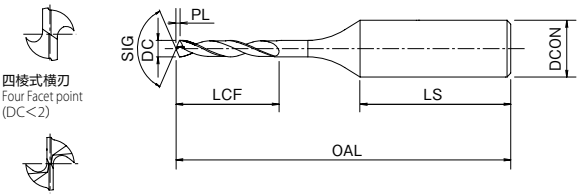
CARBIDE ULTRA SMALL SIZE FOR PRECISION OPERATION

WX-MS-GDS

切削条件 Cutting Conditions | P.399

本产品最适用于精密机器,IT 行业零配件的超精密钻孔加工。效率高,精度好!

WX-MS-GDS is capable of small size drilling operation efficiently in precision parts, components for IT industry, etc.



四棱式横刃
Four Facet point
(DC<2)

三面横向修磨型
Three-rake thinning
(2 ≦ DC)

CARBIDE | WX | 0~-0.01 | 26~32° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300020	**0.2**	1.5	38	3	33.1	0.04	140°	●	9
3300021	**0.21**				33.1	0.04		●	9
3300022	**0.22**				33.1	0.04		●	9
3300023	**0.23**				33.1	0.04		●	9
3300024	**0.24**				33.1	0.04		●	9
3300025	**0.25**				33.1	0.05		●	9
3300026	**0.26**				33.2	0.05		●	9
3300027	**0.27**				33.2	0.05		●	9
3300028	**0.28**				33.2	0.05		●	9
3300029	**0.29**				33.2	0.05		●	9
3300030	**0.3**				33.2	0.05		●	9
3300031	**0.31**	2			32.7	0.06		●	9
3300032	**0.32**				32.7	0.06		●	9
3300033	**0.33**				32.7	0.06		●	9
3300034	**0.34**				32.7	0.06		●	9
3300035	**0.35**				32.7	0.06		●	9
3300036	**0.36**				32.7	0.07		●	9
3300037	**0.37**				32.8	0.07		●	9
3300038	**0.38**				32.8	0.07		●	9
3300039	**0.39**	2.5			32.3	0.07		●	9
3300040	**0.4**				32.3	0.07		●	9
3300041	**0.41**				32.3	0.07		●	9
3300042	**0.42**				32.3	0.08		●	9
3300043	**0.43**				32.3	0.08		●	9

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300044	**0.44**	2.5	38	3	32.3	0.08	140°	●	9
3300045	**0.45**				32.3	0.08		●	9
3300046	**0.46**				32.3	0.08		●	9
3300047	**0.47**				32.3	0.09		●	9
3300048	**0.48**				32.3	0.09		●	9
3300049	**0.49**	3			31.9	0.09		●	9
3300050	**0.5**				31.9	0.09		●	9
3300051	**0.51**				31.9	0.09		●	9
3300052	**0.52**				31.9	0.09		●	9
3300053	**0.53**				31.9	0.1		●	9
3300054	**0.54**	3.5			31.4	0.1		●	9
3300055	**0.55**				31.4	0.1		●	9
3300056	**0.56**				31.4	0.1		●	9
3300057	**0.57**				31.4	0.1		●	9
3300058	**0.58**				31.4	0.11		●	9
3300059	**0.59**				31.4	0.11		●	9
3300060	**0.6**				31.4	0.11		●	9
3300061	**0.61**	4			31	0.11		●	9
3300062	**0.62**				31	0.11		●	9
3300063	**0.63**				31	0.11		●	9
3300064	**0.64**				31	0.12		●	9
3300065	**0.65**				31	0.12		●	9
3300066	**0.66**				31	0.12		●	9
3300067	**0.67**				31	0.12		●	9

下一页
直径 DC 0.68 ~ 1.09 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
WX-MS-GDS	◎	◎	○	○						○		○		◎	◎	○				○	

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

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Limited standard stock item

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Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1009

极小径·精密加工用硬质合金超短刃型钻头

CARBIDE ULTRA SMALL SIZE FOR PRECISION OPERATION

WX-MS-GDS

切削条件 Cutting Conditions | P.399

本产品最适用于精密机器,IT 行业零配件的超精密钻孔加工。效率高,精度好!

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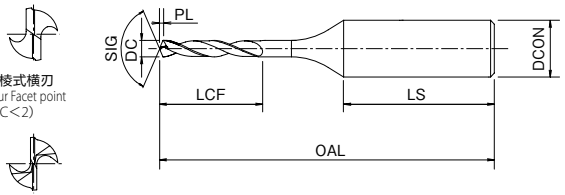

四棱式横刃
Four Facet point
(DC<2)

三面横向修磨型
Three-rake thinning
(2 ≦ DC)

CARBIDE | WX | 0~-0.01 | 26~32° | SHRINK FIT

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FROM 直径 DC 0.2～0.67

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300068	**0.68**	4.5	38	3	30.5	0.12	140°	●	9
3300069	**0.69**				30.5	0.13		●	9
3300070	**0.7**				30.5	0.13		●	9
3300071	**0.71**				30.5	0.13		●	9
3300072	**0.72**				30.6	0.13		●	9
3300073	**0.73**				30.6	0.13		●	9
3300074	**0.74**				30.6	0.13		●	9
3300075	**0.75**				30.6	0.14		●	9
3300076	**0.76**	5			30.1	0.14		●	9
3300077	**0.77**				30.1	0.14		●	9
3300078	**0.78**				30.1	0.14		●	9
3300079	**0.79**				30.1	0.14		●	9
3300080	**0.8**				30.1	0.15		●	9
3300081	**0.81**				30.1	0.15		●	9
3300082	**0.82**				30.1	0.15		●	9
3300083	**0.83**				30.1	0.15		●	9
3300084	**0.84**				30.2	0.15		●	9
3300085	**0.85**				30.2	0.15		●	9
3300086	**0.86**	5.5			29.7	0.16		●	9
3300087	**0.87**				29.7	0.16		●	9
3300088	**0.88**				29.7	0.16		●	9

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300089	**0.89**	5.5	38	3	29.7	0.16	140°	●	8
3300090	**0.9**				29.7	0.16		●	8
3300091	**0.91**				29.7	0.17		●	8
3300092	**0.92**				29.7	0.17		●	8
3300093	**0.93**				29.7	0.17		●	8
3300094	**0.94**				29.7	0.17		●	8
3300095	**0.95**				29.8	0.17		●	8
3300096	**0.96**	6			28.8	0.17		●	8
3300097	**0.97**				28.8	0.18		●	8
3300098	**0.98**				28.8	0.18		●	8
3300099	**0.99**				28.8	0.18		●	8
3300100	**1**				28.8	0.2		●	5
3300101	**1.01**				28.8	0.2		●	5
3300102	**1.02**				28.8	0.2		●	5
3300103	**1.03**				28.8	0.2		●	5
3300104	**1.04**				28.8	0.2		●	5
3300105	**1.05**				28.8	0.2		●	5
3300106	**1.06**				28.8	0.2		●	5
3300107	**1.07**	7	42		31.8	0.2		●	5
3300108	**1.08**				31.8	0.2		●	5
3300109	**1.09**				31.8	0.2		●	5

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直径 DC 1.1～1.51 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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Limited standard stock item

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Discontinued item

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加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
WX-MS-GDS	◎	◎	○	○						○		○		◎	◎	○				○	

上一页
FROM 直径 DC 0.68～1.09

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300110	**1.1**	7	42	3	31.9	0.2	140°	●	5
3300111	**1.11**				31.9	0.2		●	5
3300112	**1.12**				31.9	0.2		●	5
3300113	**1.13**				31.9	0.2		●	5
3300114	**1.14**				31.9	0.2		●	5
3300115	**1.15**				31.9	0.2		●	5
3300116	**1.16**				31.9	0.2		●	5
3300117	**1.17**				31.9	0.2		●	5
3300118	**1.18**				31.9	0.2		●	5
3300119	**1.19**	8			30.9	0.2		●	5
3300120	**1.2**				30.9	0.2		●	5
3300121	**1.21**				30.9	0.2		●	5
3300122	**1.22**				30.9	0.2		●	5
3300123	**1.23**				31	0.2		●	5
3300124	**1.24**				31	0.2		●	5
3300125	**1.25**				31	0.2		●	5
3300126	**1.26**				31	0.2		●	5
3300127	**1.27**				31	0.2		●	5
3300128	**1.28**				31	0.2		●	5
3300129	**1.29**				31	0.2		●	5
3300130	**1.3**				31	0.2		●	5

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300131	**1.31**	8	42	3	31	0.2	140°	●	5
3300132	**1.32**				31	0.2		●	5
3300133	**1.33**	9			30	0.2		●	5
3300134	**1.34**				30.1	0.2		●	5
3300135	**1.35**				30.1	0.2		●	5
3300136	**1.36**				30.1	0.2		●	5
3300137	**1.37**				30.1	0.2		●	5
3300138	**1.38**				30.1	0.3		●	5
3300139	**1.39**				30.1	0.3		●	5
3300140	**1.4**				30.1	0.3		●	5
3300141	**1.41**				30.1	0.3		●	5
3300142	**1.42**				30.1	0.3		●	5
3300143	**1.43**				30.1	0.3		●	5
3300144	**1.44**				30.1	0.3		●	5
3300145	**1.45**				30.2	0.3		●	5
3300146	**1.46**				30.2	0.3		●	5
3300147	**1.47**				30.2	0.3		●	5
3300148	**1.48**				30.2	0.3		●	5
3300149	**1.49**				30.2	0.3		●	5
3300150	**1.5**				30.2	0.3		●	5
3300151	**1.51**	10			29.2	0.3		●	5

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直径 DC 1.52～1.83 NEXT

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
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G-LIST No. | DW1009

极小径·精密加工用硬质合金超短刃型钻头

CARBIDE ULTRA SMALL SIZE FOR PRECISION OPERATION

WX-MS-GDS

切削条件 Cutting Conditions | P.399

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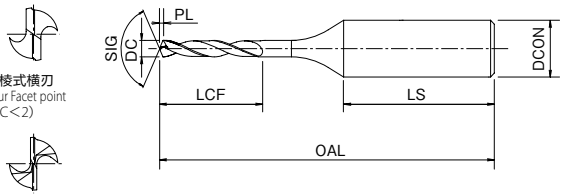

四棱式横刃
Four Facet point
(DC<2)

三面横向修磨型
Three-rake thinning
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CARBIDE | WX | 0~-0.01 | 26~32° | SHRINK FIT

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FROM 直径 DC 1.1 ~ 1.51

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300152	**1.52**	10	42	3	29.2	0.3	140°	●	5
3300153	**1.53**				29.2	0.3		●	5
3300154	**1.54**				29.2	0.3		●	5
3300155	**1.55**				29.2	0.3		●	5
3300156	**1.56**				29.2	0.3		●	5
3300157	**1.57**				29.3	0.3		●	5
3300158	**1.58**				29.3	0.3		●	5
3300159	**1.59**				29.3	0.3		●	5
3300160	**1.6**				29.3	0.3		●	5
3300161	**1.61**				29.3	0.3		●	5
3300162	**1.62**				29.3	0.3		●	5
3300163	**1.63**				29.3	0.3		●	5
3300164	**1.64**				29.3	0.3		●	5
3300165	**1.65**				29.3	0.3		●	5
3300166	**1.66**				29.3	0.3		●	5
3300167	**1.67**				29.3	0.3		●	5

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300168	**1.68**	10	42	3	29.4	0.3	140°	●	5
3300169	**1.69**				29.4	0.3		●	5
3300170	**1.7**				29.4	0.3		●	5
3300171	**1.71**	11			28.4	0.3		●	5
3300172	**1.72**				28.4	0.3		●	5
3300173	**1.73**				28.4	0.3		●	5
3300174	**1.74**				28.4	0.3		●	5
3300175	**1.75**				28.4	0.3		●	5
3300176	**1.76**				28.4	0.3		●	5
3300177	**1.77**				28.4	0.3		●	5
3300178	**1.78**				28.4	0.3		●	5
3300179	**1.79**				28.4	0.3		●	5
3300180	**1.8**				28.5	0.3		●	5
3300181	**1.81**				28.5	0.3		●	5
3300182	**1.82**				28.5	0.3		●	5
3300183	**1.83**				28.5	0.3		●	5

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直径 DC 1.84 ~ 2.65 NEXT

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	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
WX-MS-GDS	◎	◎	○	○						○		○		◎	◎	○				○	

上一页
FROM 直径 DC 1.52～1.83

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300184	**1.84**	11	42	3	28.5	0.3	140°	●	5
3300185	**1.85**				28.5	0.3		●	5
3300186	**1.86**				28.5	0.3		●	5
3300187	**1.87**				28.5	0.3		●	5
3300188	**1.88**				28.5	0.3		●	5
3300189	**1.89**				28.5	0.3		●	6
3300190	**1.9**				28.5	0.3		●	6
3300191	**1.91**	12	50		35.6	0.3		●	6
3300192	**1.92**				35.6	0.3		●	6
3300193	**1.93**				35.6	0.4		●	6
3300194	**1.94**				35.6	0.4		●	6
3300195	**1.95**				35.6	0.4		●	6
3300196	**1.96**				35.6	0.4		●	6
3300197	**1.97**				35.6	0.4		●	6
3300198	**1.98**				35.6	0.4		●	6

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300199	**1.99**	12	50	3	35.6	0.4	140°	●	6
3300200	**2**				35.1	0.4		●	6
3300205	**2.05**				35.2	0.4		●	6
3300210	**2.1**				35.3	0.4		●	6
3300215	**2.15**	13			34.4	0.4		●	6
3300220	**2.2**				34.5	0.4		●	6
3300225	**2.25**				34.6	0.4		●	6
3300230	**2.3**				34.7	0.4		●	6
3300235	**2.35**				34.8	0.4		●	6
3300240	**2.4**	14			33.9	0.6	130°	●	6
3300245	**2.45**				34	0.6		●	6
3300250	**2.5**				34.1	0.6		●	6
3300255	**2.55**				34.2	0.6		●	6
3300260	**2.6**				34.3	0.6		●	6
3300265	**2.65**				34.3	0.6		●	6

下一页
直径 DC 2.7～4.05 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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Discontinued item

G-LIST No. | **DW1009**

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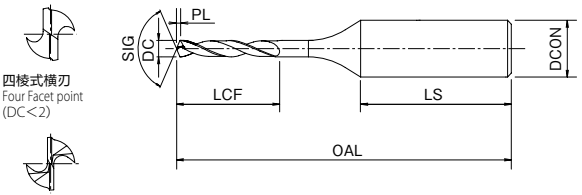


四棱式横刃
Four Facet point
(DC<2)

三面横向修磨型
Three-rake thinning
(2 ≦ DC)

CARBIDE | WX | 0~-0.01 | 26~32° | SHRINK FIT

上一页 FROM 直径 DC 1.84～2.65

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300270	**2.7**	16	50	3	32.5	0.6	130°	●	6
3300275	**2.75**				32.6	0.6		●	6
3300280	**2.8**				32.6	0.7		●	6
3300285	**2.85**				32.7	0.7		●	6
3300290	**2.9**				32.8	0.7		●	6
3300295	**2.95**				32.9	0.7		●	6
3300300	**3**				33	0.7		●	6
3300305	**3.05**	18	56	4	35.2	0.7		●	9
3300310	**3.1**				35.3	0.7		●	9
3300315	**3.15**				35.4	0.7		●	9
3300320	**3.2**				35.5	0.7		●	9
3300325	**3.25**				35.6	0.8		●	9
3300330	**3.3**				35.7	0.8		●	9
3300335	**3.35**				35.8	0.8		●	9

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300340	**3.4**	20	56	4	33.9	0.8	130°	●	9
3300345	**3.45**				34	0.8		●	9
3300350	**3.5**				34.1	0.8		●	9
3300355	**3.55**				34.2	0.8		●	9
3300360	**3.6**				34.3	0.8		●	9
3300365	**3.65**				34.4	0.9		●	9
3300370	**3.7**				34.5	0.9		●	9
3300375	**3.75**				34.6	0.9		●	9
3300380	**3.8**	22			32.6	0.9		●	9
3300385	**3.85**				32.7	0.9		●	9
3300390	**3.9**				32.8	0.9		●	9
3300395	**3.95**				32.9	0.9		●	9
3300400	**4**		64	5	33	0.9		●	10
3300405	**4.05**				39.2	0.9		●	14

下一页 直径 DC 4.1～5 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
WX-MS-GDS	◎	◎	○	○						○		○		◎	◎	○				○	

上一页

FROM 直径 **DC** 2.7～4.05

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300410	**4.1**	22	64	5	39.3	1	130°	●	14
3300415	**4.15**				39.4	1		●	15
3300420	**4.2**				39.5	1		●	15
3300425	**4.25**				39.6	1		●	15
3300430	**4.3**	24			37.7	1		●	15
3300435	**4.35**				37.8	1		●	15
3300440	**4.4**				37.9	1		●	15
3300445	**4.45**				38	1		●	15
3300450	**4.5**				38.1	1		●	15
3300455	**4.55**				38.2	1.1		●	15

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
3300460	**4.6**	24	64	5	38.3	1.1	130°	●	15
3300465	**4.65**				38.4	1.1		●	15
3300470	**4.7**				38.5	1.1		●	15
3300475	**4.75**				38.6	1.1		●	15
3300480	**4.8**	26			36.6	1.1		●	15
3300485	**4.85**				36.7	1.1		●	15
3300490	**4.9**				36.8	1.1		●	15
3300495	**4.95**				36.9	1.2		●	15
3300500	**5**				37	1.2		●	15

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1011**

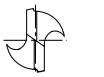
不锈钢加工用硬质合金小径钻头

MICRO REVOLUTION CARBIDE DRILL FOR STAINLESS

MRS-GDL

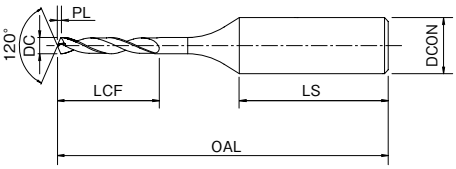
切削条件 Cutting Conditions | P.400

CARBIDE | SS | 0~-0.008 | 30° | SHRINK FIT



四棱式横刃
Four Facet point
(DC ≦ 1.15mm)

X 型横刃
X thinning
(1.2mm ≦ DC)



单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8577050	**0.5**	6	42	3	29.8	0.14	●	9
8577054	**0.54**	6.6			29.3	0.16	●	9
8577055	**0.55**				29.3	0.16	●	9
8577056	**0.56**	7.2			28.8	0.16	●	9
8577060	**0.6**				28.8	0.17	●	9
8577063	**0.63**	7.8	46		32.3	0.18	●	9
8577064	**0.64**				32.3	0.18	●	9
8577065	**0.65**				32.3	0.19	●	9
8577070	**0.7**	8.4			31.8	0.2	●	9
8577071	**0.71**	9			31.2	0.2	●	9
8577072	**0.72**				31.3	0.21	●	9
8577073	**0.73**				31.3	0.21	●	9
8577074	**0.74**				31.3	0.21	●	9
8577075	**0.75**				31.3	0.22	●	9
8577080	**0.8**	9.6			30.8	0.23	●	9
8577081	**0.81**	10.2			30.2	0.23	●	9
8577082	**0.82**				30.2	0.24	●	9
8577090	**0.9**	10.8			29.8	0.26	●	9
8577091	**0.91**	11.4			29.2	0.26	●	9
8577092	**0.92**				29.2	0.27	●	9
8577100	**1**	12			28.8	0.3	●	9
8577110	**1.1**	13.2	50		31.5	0.3	●	9

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8577111	**1.11**	13.8	50	3	30.8	0.3	●	9
8577112	**1.12**				30.8	0.3	●	9
8577115	**1.15**				30.9	0.3	●	9
8577120	**1.2**	14.4			30.4	0.3	●	9
8577127	**1.27**	15.6			29.3	0.4	●	9
8577128	**1.28**				29.3	0.4	●	9
8577129	**1.29**				29.4	0.4	●	9
8577130	**1.3**				29.4	0.4	●	9
8577140	**1.4**	16.8	54		32.4	0.4	●	9
8577145	**1.45**	17.4			31.9	0.4	●	9
8577146	**1.46**	18			31.3	0.4	●	9
8577147	**1.47**				31.3	0.4	●	9
8577150	**1.5**				31.4	0.4	●	9
8577151	**1.51**	18.6			30.8	0.4	●	9
8577152	**1.52**				30.8	0.4	●	9
8577153	**1.53**				30.8	0.4	●	9
8577155	**1.55**				30.8	0.4	●	9
8577156	**1.56**	19.2			30.3	0.5	●	9
8577157	**1.57**				30.3	0.5	●	9
8577160	**1.6**				30.3	0.5	●	9
8577170	**1.7**	20.4	58		33.3	0.5	●	9
8577180	**1.8**	21.6			33.7	0.5	●	9

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直径 DC 1.81～3 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
MRS-GDL										◎											

上一页

FROM 直径 **DC** 0.5～1.8

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8577181	**1.81**	22.2	58	3	33.1	0.5	●	9
8577182	**1.82**				33.1	0.5	●	9
8577183	**1.83**				33.1	0.5	●	9
8577190	**1.9**	22.8			32.6	0.5	●	9
8577198	**1.98**	24			31.6	0.6	●	9
8577199	**1.99**				31.6	0.6	●	9
8577200	**2**				31.6	0.6	●	9
8577210	**2.1**	25.2	62		34.6	0.6	●	5
8577212	**2.12**	25.8			34.1	0.6	●	5
8577213	**2.13**				34.1	0.6	●	10
8577214	**2.14**				34.1	0.6	●	5
8577220	**2.2**	26.4			33.6	0.6	●	5
8577229	**2.29**	27.6			32.6	0.7	●	10
8577230	**2.3**				32.6	0.7	●	5
8577231	**2.31**	28.2			32	0.7	●	8
8577239	**2.39**	28.8			31.6	0.7	●	10
8577240	**2.4**				31.6	0.7	●	10
8577241	**2.41**	29.4	66		35	0.7	●	6
8577242	**2.42**				35	0.7	●	6

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8577250	**2.5**	30	66	3	34.6	0.7	●	6
8577255	**2.55**	30.6			34.1	0.7	●	6
8577256	**2.56**	31.2			33.5	0.7	●	6
8577257	**2.57**				33.5	0.7	●	6
8577260	**2.6**				33.6	0.8	●	6
8577270	**2.7**	32.4			32.5	0.8	●	6
8577277	**2.77**	33.6			31.5	0.8	●	6
8577278	**2.78**				31.5	0.8	●	6
8577279	**2.79**				31.5	0.8	●	6
8577280	**2.8**				31.5	0.8	●	6
8577290	**2.9**	34.8			30.5	0.8	●	6
8577300	**3**	36			29.5	0.9	●	6

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1010

非铁金属加工用硬质合金中等刃长型

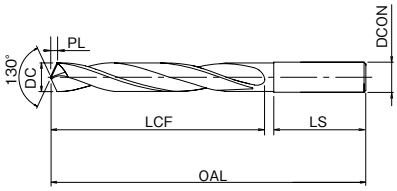
CARBIDE MEDIUM FOR NON-FERROUS METAL

NF-GDN

切削条件 Cutting Conditions | P.401

在汽车，航空行业中较多出现的铸铝、铝合金、变形铝的高速加工中，可以实现较好的性价比。

Will provides high cost performances on Aluminum Die-casting, Extruded Aluminum, Casted Aluminum which are commonly used for Automotive, Aerospace Industries.



CARBIDE | 0~-0.01 | 20° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8587300	**3**	25	59	3	32	0.7	●	7
8587310	**3.1**	27	65	4	36	0.7	●	9
8587320	**3.2**				36	0.7	●	10
8587330	**3.3**				36	0.8	●	10
8587340	**3.4**	30			33	0.8	●	10
8587350	**3.5**				33	0.8	●	10
8587360	**3.6**				33	0.8	●	10
8587366	**3.66**				33	0.9	●	10
8587368	**3.68**				33	0.9	●	10
8587370	**3.7**				33	0.9	●	10
8587380	**3.8**	33			30	0.9	●	10
8587390	**3.9**				30	0.9	●	10
8587400	**4**				30	0.9	●	10
8587410	**4.1**		73	5	38	1	●	17
8587420	**4.2**				38	1	●	17
8587430	**4.3**	36			35	1	●	16
8587440	**4.4**				35	1	●	16
8587450	**4.5**				35	1	●	17
8587460	**4.6**				35	1.1	●	17
8587462	**4.62**				35	1.1	●	17
8587464	**4.64**				35	1.1	●	17
8587470	**4.7**				35	1.1	●	17
8587480	**4.8**	39			32	1.1	●	17
8587490	**4.9**				32	1.1	●	17
8587500	**5**				32	1.2	●	17
8587510	**5.1**		83	6	42	1.2	●	26
8587520	**5.2**				42	1.2	●	26
8587530	**5.3**				42	1.2	●	27
8587540	**5.4**	43			38	1.3	●	27
8587550	**5.5**				38	1.3	●	27
8587552	**5.52**				38	1.3	●	27
8587554	**5.54**				38	1.3	●	27
8587560	**5.6**				38	1.3	●	27
8587570	**5.7**				38	1.3	●	27
8587580	**5.8**				38	1.4	●	27
8587590	**5.9**				38	1.4	●	27
8587600	**6**				38	1.4	●	28
8587610	**6.1**	47	90	7	41	1.4	●	36
8587620	**6.2**				41	1.4	●	36
8587630	**6.3**				41	1.5	●	36
8587640	**6.4**				41	1.5	●	36
8587650	**6.5**				41	1.5	●	38
8587660	**6.6**				41	1.5	●	38
8587670	**6.7**				41	1.6	●	38
8587680	**6.8**	52			36	1.6	●	38
8587690	**6.9**				36	1.6	●	38
8587700	**7**				36	1.6	●	38
8587710	**7.1**		96	8	42	1.7	●	49

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8587720	**7.2**	52	96	8	42	1.7	●	49
8587730	**7.3**				42	1.7	●	54
8587736	**7.36**				42	1.7	●	50
8587738	**7.38**				42	1.7	●	50
8587740	**7.4**				42	1.7	●	50
8587750	**7.5**				42	1.7	●	51
8587752	**7.52**	56			38	1.8	●	52
8587754	**7.54**				38	1.8	●	53
8587760	**7.6**				38	1.8	●	50
8587770	**7.7**				38	1.8	●	50
8587780	**7.8**				38	1.8	●	51
8587790	**7.9**				38	1.8	●	51
8587800	**8**				38	1.9	●	51
8587810	**8.1**		101	9	43	1.9	●	66
8587820	**8.2**				43	1.9	●	66
8587830	**8.3**				43	1.9	●	70
8587840	**8.4**				43	2	●	67
8587850	**8.5**				43	2	●	68
8587860	**8.6**	61			38	2	●	66
8587870	**8.7**				38	2	●	67
8587880	**8.8**				38	2.1	●	67
8587890	**8.9**				38	2.1	●	67
8587900	**9**				38	2.1	●	68
8587910	**9.1**		109	10	46	2.1	●	86
8587920	**9.2**				46	2.1	●	87
8587924	**9.24**				46	2.2	●	93
8587926	**9.26**				46	2.2	●	93
8587930	**9.3**				46	2.2	●	88
8587936	**9.36**				46	2.2	●	94
8587938	**9.38**				46	2.2	●	88
8587940	**9.4**				46	2.2	●	88
8587950	**9.5**				46	2.2	●	89
8587952	**9.52**	65			42	2.2	●	94
8587954	**9.54**				42	2.2	●	92
8587960	**9.6**				42	2.2	●	86
8587970	**9.7**				42	2.3	●	87
8587980	**9.8**				42	2.3	●	87
8587990	**9.9**				42	2.3	●	88
8588000	**10**				42	2.3	●	89
8588010	**10.1**		115	11	48	2.4	●	109
8588020	**10.2**				48	2.4	●	110
8588030	**10.3**				48	2.4	●	110
8588040	**10.4**				48	2.4	●	111
8588050	**10.5**				48	2.4	●	112
8588060	**10.6**				48	2.5	●	113
8588070	**10.7**	71			42	2.5	●	109
8588080	**10.8**				42	2.5	●	110
8588090	**10.9**				42	2.5	●	117

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直径 DC 11～13 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
NF-GDN												◎		○	◎	◎				◎	

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FROM 直径 **DC** 3～10.9

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8588100	**11**	71	115	11	42	2.6	●	112
8588110	**11.1**		126	12	53	2.6	●	144
8588120	**11.2**				53	2.6	●	145
8588122	**11.22**				53	2.6	●	152
8588124	**11.24**				53	2.6	●	152
8588130	**11.3**				53	2.6	●	146
8588136	**11.36**				53	2.6	●	153
8588138	**11.38**				53	2.7	●	154
8588140	**11.4**				53	2.7	●	147
8588150	**11.5**				53	2.7	●	149
8588160	**11.6**				53	2.7	●	149
8588170	**11.7**				53	2.7	●	150
8588180	**11.8**				53	2.8	●	152

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8588190	**11.9**	76	126	12	48	2.8	●	152
8588200	**12**				48	2.8	●	155
8588210	**12.1**		128		50	2.8	●	155
8588220	**12.2**				50	2.8	●	155
8588230	**12.3**				50	2.9	●	156
8588240	**12.4**				50	2.9	●	157
8588250	**12.5**				50	2.9	●	158
8588260	**12.6**				50	2.9	●	158
8588270	**12.7**				50	3	●	162
8588280	**12.8**				50	3	●	163
8588290	**12.9**				50	3	●	169
8588300	**13**				50	3	●	163

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1012

铜·铝加工用内冷油孔硬质合金超长刃型

CARBIDE EXTRA LONG DRILL FOR COPPER ALLOYS ALUMINUM ALLOYS WITH INTERNAL COOLANT SUPPLY

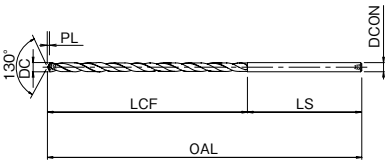
CAO-GDXL

切削条件 Cutting Conditions | P.402

15D-30D 的超深孔加工一气呵成。其加工效率和工具寿命为枪钻，高速钢钻头的数倍。

For non-step drilling deep holes from 15D ~ 30D. Greatly increases productivity and tool life compared to gun drills and HSS drills.

X 型横刃
X thinning



CARBIDE | h8 | 30° | SHRINK FIT

15D用 For 15D operation

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8567130	3 × 15D	55	105	3	50	0.7	●	10
8567140	4 × 15D	75	125	4	50	0.9	●	20
8567150	5 × 15D	90	140	5	50	1.2	●	31
8567160	6 × 15D	110	160	6	50	1.4	●	46
8567165	6.5 × 15D	120	175	7	50	1.5	●	60

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8567170	7 × 15D	125	175	7	50	1.6	●	62
8567180	8 × 15D	145	195	8	50	1.9	●	88
8567190	9 × 15D	160	210	9	50	2.1	●	115
8567200	10 × 15D	180	240	10	60	2.3	●	163

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
CAO-GDXL														○	○	◎					

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DW1012**

铜·铝加工用内冷油孔硬质合金超长刃型

CARBIDE EXTRA LONG DRILL FOR COPPER ALLOYS ALUMINUM ALLOYS WITH INTERNAL COOLANT SUPPLY

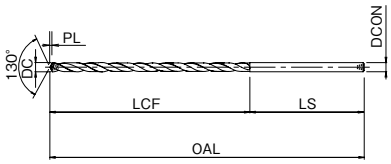
CAO-GDXL

切削条件 Cutting Conditions | P.402

15D-30D 的超深孔加工一气呵成。其加工效率和工具寿命为枪钻，高速钢钻头的数倍。

For non-step drilling deep holes from 15D ~ 30D. Greatly increases productivity and tool life compared to gun drills and HSS drills.

X 型横刃
X thinning



CARBIDE | h8 | 30° | SHRINK FIT

20D用 For 20D operation

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8567340	**4 × 20D**	90	140	4	50	0.9	●	21
8567345	**4.5 × 20D**	110	165	5	50	1	●	29
8567350	**5 × 20D**	115			50	1.2	●	33
8567355	**5.5 × 20D**	140	190	6	50	1.3	●	46
8567360	**6 × 20D**				50	1.4	●	51

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8567370	**7 × 20D**	160	210	7	50	1.6	●	72
8567380	**8 × 20D**	180	230	8	50	1.9	●	104
8567390	**9 × 20D**	210	260	9	50	2.1	●	136
8567400	**10 × 20D**	230	290	10	60	2.3	●	194

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
CAO-GDXL														○	○	◎					

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

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

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

△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1012

铜·铝加工用内冷油孔硬质合金超长刃型

CARBIDE EXTRA LONG DRILL FOR COPPER ALLOYS ALUMINUM ALLOYS WITH INTERNAL COOLANT SUPPLY

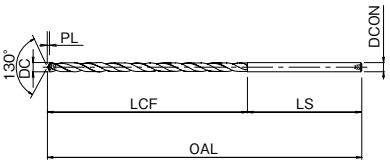
CAO-GDXL

切削条件 Cutting Conditions | P.402

15D-30D 的超深孔加工一气呵成。其加工效率和工具寿命为枪钻，高速钢钻头的数倍。

For non-step drilling deep holes from 15D ~ 30D. Greatly increases productivity and tool life compared to gun drills and HSS drills.

X 型横刃
X thinning



CARBIDE | h8 | 30° | SHRINK FIT

30D用 For 30D operation

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8567450	5 × 30D	165	215	5	50	1.2	●	43
8567455	5.5 × 30D	200	250	6	50	1.3	●	57
8567460	6 × 30D				50	1.4	●	66

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8567470	7 × 30D	230	280	7	50	1.6	●	91
8567480	8 × 30D	265	315	8	50	1.9	●	131

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
CAO-GDXL														○	○	◎					

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

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Discontinued item

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

高硬度钢用硬质合金超短刃型钻头
CARBIDE STUB FOR HARDENED STEELS

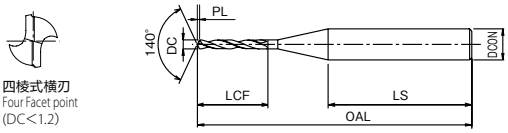
FH-GDS

切削条件 Cutting Conditions | P.403

专为淬火钢的小径孔加工而开发，特别是浅孔(3D左右）的高精度、高寿命加工。

This drill is developed for small size drilling in hardened steel. It is applied to shallow hole (around 3 × D) with high precision and long tool life.

CARBIDE | FX | h8 | 20° | SHRINK FIT



四棱式横刃
Four Facet point
(DC<1.2)

X 型横刃
X thinning
(1.2≦DC)

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8564030	**0.3**	1.6	38	3	31	0.05	●	9
8564040	**0.4**	2.6			30.2	0.07	●	9
8564050	**0.5**	3			29.8	0.09	●	9
8564060	**0.6**	3.5			29.5	0.11	●	9
8564070	**0.7**	4.5			28.7	0.13	●	9
8564080	**0.8**	5			27.9	0.15	●	9
8564090	**0.9**	5.5			27.6	0.16	●	9
8564100	**1**	6			27.3	0.2	●	5
8564110	**1.1**	7	42		30.5	0.2	●	5

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8564120	**1.2**	8	42	3	29.6	0.2	●	5
8564130	**1.3**				29.8	0.2	●	5
8564140	**1.4**	9			29	0.3	●	5
8564150	**1.5**				29.2	0.3	●	5
8564160	**1.6**	10			28.4	0.3	●	5
8564170	**1.7**				28.6	0.3	●	5
8564180	**1.8**	11			27.8	0.3	●	5
8564190	**1.9**				28	0.3	●	5
8564200	**2**	12	46		31.1	0.4	●	7

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
商品记号 Abbreviation	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
FH-GDS						○	◎	◎	○												

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1004

高硬度钢用硬质合金中等刃长型钻头

CARBIDE MEDIUM FOR HARDENED STEELS

FH-GDN

切削条件 Cutting Conditions | P.403

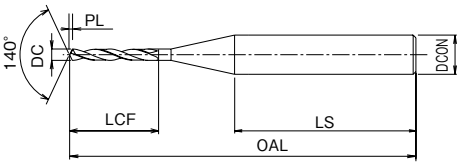
专为淬火钢的小径孔加工而开发，特别是深孔(7D左右)加工中可发挥出巨大威力。

This drill is developed for small size drilling in hardened steel. It is applied to deep hole (around 7 × D) .

CARBIDE | FX | h8 | 20° | SHRINK FIT

四棱式横刃
Four Facet point
(DC<1.2)

X 型横刃
X thinning
(1.2≦DC)



单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8562030	**0.3**	2.5			30	0.05	●	8
8562040	**0.4**	4			28.7	0.07	●	8
8562050	**0.5**	5	38		27.8	0.09	●	8
8562060	**0.6**	5.5			27.5	0.11	●	8
8562070	**0.7**	7		3	26.2	0.13	●	8
8562080	**0.8**	7.5			29.4	0.15	●	8
8562090	**0.9**	8.5	42		28.6	0.16	●	9
8562100	**1**	9			28.3	0.2	●	5
8562110	**1.1**	10.5	48		33	0.2	●	5

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8562120	**1.2**	12			31.6	0.2	●	5
8562130	**1.3**				31.8	0.2	●	5
8562140	**1.4**	13.5			30.5	0.3	●	5
8562150	**1.5**		48		30.7	0.3	●	5
8562160	**1.6**	15		3	29.4	0.3	●	5
8562170	**1.7**				29.6	0.3	●	5
8562180	**1.8**	16.5			28.3	0.3	●	5
8562190	**1.9**				28.5	0.3	●	5
8562200	**2**	18	50		29.1	0.4	●	6

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
FH-GDN						○	◎	◎	○												

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

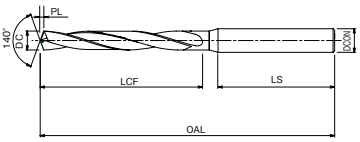
高硬度钢(~55HRC)用硬质合金钻头
FOR HIGH HARDENED STEELS (~55HRC)

WH55-5D

切削条件 Cutting Conditions | P.404

实现稳定的压铸模具的加工，最适合针对55HRC 高硬度钢的加工。
Possible stable diecast mold machining. Best for up to HRC55 steels.

R 型横刃
R thinning



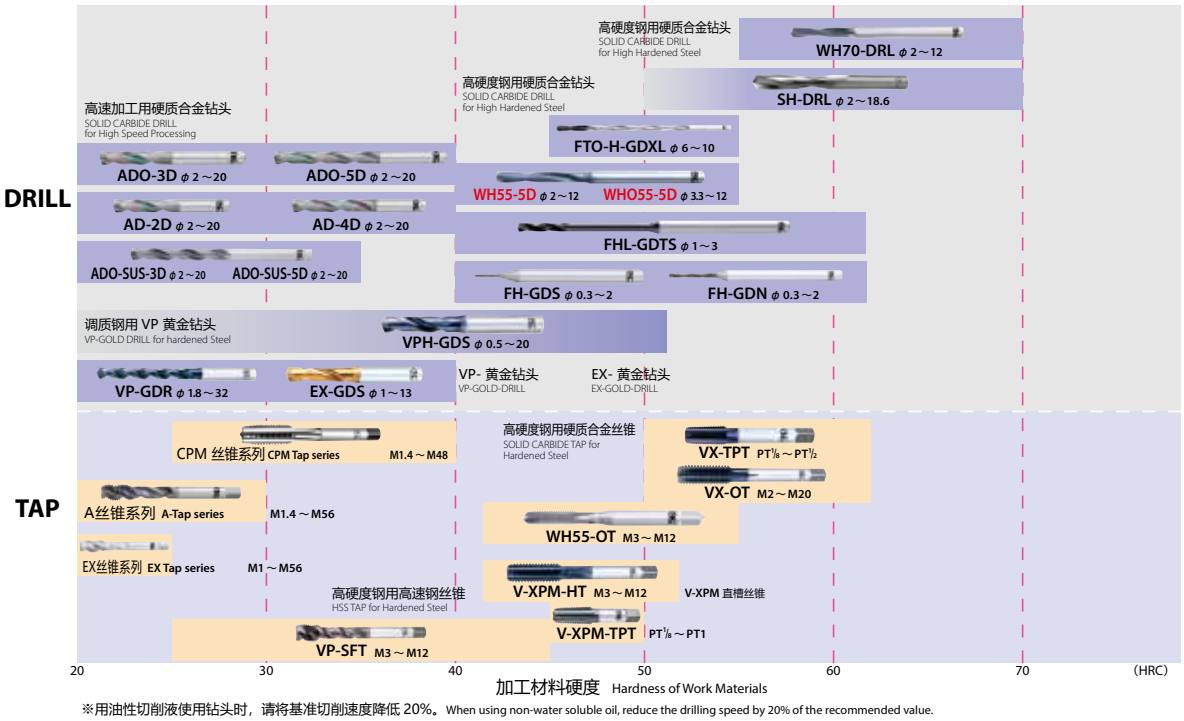
CARBIDE | WXS | h8 | 12~20° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3312200	**2**	18	68	4	44.3	0.4	●	10
3312250	**2.5**	23	73		45.2	0.5	●	12
3312280	**2.8**	27			41.8	0.5	●	12
3312300	**3**	29	78	6	41.4	0.5	●	22
3312330	**3.3**	32			39	0.6	●	22
3312350	**3.5**				39.3	0.6	●	22
3312380	**3.8**	36			35.9	0.7	●	22
3312400	**4**				36.3	0.7	●	22
3312420	**4.2**	38	88		44.6	0.8	●	26
3312450	**4.5**	41			42.2	0.8	●	26
3312480	**4.8**	45			38.8	0.9	●	26
3312500	**5**				39.1	0.9	●	26
3312510	**5.1**	42	92		46.3	0.9	●	26
3312550	**5.5**	44			45.1	1	●	30
3312580	**5.8**	48			41.6	1.1	●	30
3312600	**6**				42	1.1	●	31
3312650	**6.5**	52	102	8	45.2	1.2	●	52
3312680	**6.8**	56			41.8	1.2	●	53

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3312700	**7**	56	102	8	42.1	1.3	●	54
3312750	**7.5**	60	118		56	1.4	●	68
3312780	**7.8**	64			52	1.4	●	70
3312800	**8**				52	1.5	●	70
3312850	**8.5**	68	128	10	58	1.5	●	107
3312870	**8.7**	70			56	1.6	●	107
3312880	**8.8**	72			54	1.6	●	107
3312900	**9**				54	1.6	●	108
3312950	**9.5**	76	136		58	1.7	●	118
3312980	**9.8**	80			54	1.8	●	121
3313000	**10**				54	1.8	●	122
3313030	**10.3**	84	146	12	60	1.9	●	167
3313050	**10.5**				60	1.9	●	168
3313080	**10.8**	88			56	2	●	170
3313100	**11**				56	2	●	172
3313150	**11.5**	92	156		62	2.1	●	191
3313180	**11.8**	96			58	2.1	●	198
3313200	**12**				58	2.2	●	199

■孔加工工具选择指南 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1039

内冷油孔高硬度钢(~55HRC)用硬质合金钻头

FOR HIGH HARDENED STEELS WITH INTERNAL COOLANT SUPPLY (~55HRC)

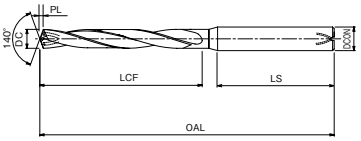
WHO55-5D

切削条件 Cutting Conditions | P.405

最适合针对55HRC 高硬度钢以及镍基合金的加工，内冷油孔的设计能实现更长的工具寿命。

Best for up to HRC55 steels and Nickel Alloys. Oil hole design gives longer tool life.

R 型横刃
R thinning



CARBIDE | WXS | h8 | 12~20° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3316330	**3.3**	32	78	6	39	0.6	●	22
3316340	**3.4**				39.1	0.6	●	22
3316349	**3.49**				39.3	0.6	●	22
3316350	**3.5**				39.3	0.6	●	22
3316360	**3.6**	34			37.5	0.7	●	22
3316370	**3.7**				37.7	0.7	●	22
3316380	**3.8**	36			35.9	0.7	●	22
3316390	**3.9**				36.1	0.7	●	22
3316400	**4**				36.3	0.7	●	22
3316410	**4.1**	38	88		44.5	0.7	●	25
3316415	**4.15**				44.5	0.8	●	25
3316420	**4.2**				44.6	0.8	●	25
3316430	**4.3**	41			41.8	0.8	●	25
3316440	**4.4**				42	0.8	●	25
3316450	**4.5**				42.2	0.8	●	25
3316460	**4.6**	43			40.4	0.8	●	25
3316470	**4.7**				40.6	0.9	●	25
3316480	**4.8**	45			38.8	0.9	●	26
3316490	**4.9**				38.9	0.9	●	26
3316500	**5**				39.1	0.9	●	26
3316510	**5.1**	42	92		46.3	0.9	●	29
3316520	**5.2**				46.5	0.9	●	29
3316530	**5.3**	44			44.7	1	●	29
3316540	**5.4**				44.9	1	●	29
3316550	**5.5**				45.1	1	●	29
3316556	**5.56**	46			43.2	1	●	30
3316560	**5.6**				43.3	1	●	30

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3316570	**5.7**	46	92	6	43.4	1	●	30
3316580	**5.8**	48			42	1.1	●	30
3316590	**5.9**				42	1.1	●	31
3316600	**6**				42	1.1	●	31
3316650	**6.5**	52	102	8	45.2	1.2	●	50
3316680	**6.8**	56			41.8	1.2	●	51
3316700	**7**				42.1	1.3	●	51
3316750	**7.5**	60	118		56	1.4	●	66
3316780	**7.8**	64			52	1.4	●	67
3316800	**8**				52	1.5	●	67
3316850	**8.5**	68	128	10	58	1.5	●	100
3316858	**8.58**	70			56	1.6	●	100
3316870	**8.7**				56	1.6	●	101
3316880	**8.8**	72			54	1.6	●	101
3316900	**9**				54	1.6	●	101
3316950	**9.5**	76	136		58	1.7	●	113
3316980	**9.8**	80			54	1.8	●	117
3316997	**9.97**				54	1.8	●	117
3317000	**10**				54	1.8	●	117
3317030	**10.3**	84	146	12	60	1.9	●	161
3317050	**10.5**				60	1.9	●	161
3317080	**10.8**	88			56	2	●	164
3317100	**11**				56	2	●	164
3317150	**11.5**	92	156		62	2.1	●	184
3317156	**11.56**	94			60	2.1	●	190
3317180	**11.8**	96			58	2.1	●	190
3317200	**12**				58	2.2	●	190

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel	淬火钢 Quenched and Tempered Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
WH55-5D						◎	◎	○													
WHO55-5D						◎	◎	○										◎			

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

高硬度钢(~70HRC)用硬质合金钻头
FOR HIGH HARDENED STEELS (~70HRC)

WH70-DRL

切削条件 Cutting Conditions | P.406

最适合55-70HRC 硬度材料的加工，有效的刃形设计，以及特殊的涂层，实现了超高硬度材料的稳定加工。

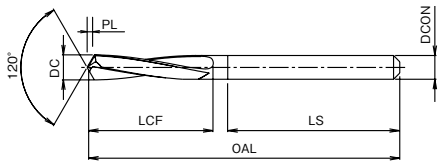
Best for HRC55 ~ 70 applications. The drill for Super Hard Steels with effective cutting edge design for stable machining and special coating for super hard steels.

CARBIDE | WXS | h8 | 12° | SHRINK FIT

X 型横刃
X thinning
(DC<2.4)

R+W 型横刃
R+W thinning
(4≦DC)

W 型横刃
W thinning
(2.4≦DC<4)



单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3318200	**2**	12	42	3	27.1	0.6	●	5
3318210	**2.1**				27.3	0.6	●	5
3318220	**2.2**	13	43		27.5	0.6	●	5
3318230	**2.3**				27.7	0.7	●	5
3318240	**2.4**	14	44		27.9	0.7	●	6
3318250	**2.5**				28.1	0.7	●	6
3318260	**2.6**				28.3	0.8	●	6
3318270	**2.7**	16	46		28.4	0.8	●	6
3318280	**2.8**				28.6	0.8	●	6
3318290	**2.9**				28.8	0.8	●	6
3318300	**3**				29	0.9	●	6
3318310	**3.1**	18	48	4	27.3	0.9	●	8
3318320	**3.2**				27.5	0.9	●	8
3318330	**3.3**				27.7	1	●	8
3318340	**3.4**	20	50		27.9	1	●	9
3318350	**3.5**				28.1	1	●	9
3318360	**3.6**				28.3	1	●	9
3318370	**3.7**				28.4	1.1	●	9
3318380	**3.8**	22	52		28.6	1.1	●	9
3318390	**3.9**				28.8	1.1	●	9
3318400	**4**				29	1.2	●	9
3318410	**4.1**	25	68	5	39.3	1.2	●	16
3318420	**4.2**				39.5	1.2	●	16
3318430	**4.3**	28			36.7	1.2	●	16
3318440	**4.4**				36.9	1.3	●	16
3318450	**4.5**				37.1	1.3	●	16
3318460	**4.6**				37.3	1.3	●	17
3318470	**4.7**				37.4	1.4	●	17
3318480	**4.8**	32			33.6	1.4	●	17
3318490	**4.9**				33.8	1.4	●	17
3318500	**5**				34	1.4	●	17
3318510	**5.1**		74	6	38.3	1.5	●	25
3318520	**5.2**				38.5	1.5	●	25
3318530	**5.3**				38.7	1.5	●	25
3318540	**5.4**	35			35.9	1.6	●	25
3318550	**5.5**				36.1	1.6	●	25
3318560	**5.6**				36.3	1.6	●	25
3318570	**5.7**				36.4	1.6	●	26
3318580	**5.8**				36.6	1.7	●	26
3318590	**5.9**				36.8	1.7	●	26

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3318600	**6**	35	74	6	37	1.7	●	26
3318610	**6.1**	40	83	7	41	1.8	●	36
3318620	**6.2**				41	1.8	●	36
3318630	**6.3**				41	1.8	●	36
3318640	**6.4**				41	1.8	●	37
3318650	**6.5**				41	1.9	●	38
3318660	**6.6**				41	1.9	●	38
3318670	**6.7**				41	1.9	●	38
3318680	**6.8**	45			36	2	●	38
3318690	**6.9**				36	2	●	38
3318700	**7**				36	2	●	38
3318710	**7.1**		94	8	47	2	●	53
3318720	**7.2**				47	2.1	●	53
3318730	**7.3**				47	2.1	●	53
3318740	**7.4**				47	2.1	●	53
3318750	**7.5**				47	2.2	●	53
3318760	**7.6**	50			42	2.2	●	53
3318770	**7.7**				42	2.2	●	53
3318780	**7.8**				42	2.3	●	54
3318790	**7.9**				42	2.3	●	54
3318800	**8**				42	2.3	●	55
3318810	**8.1**		101	9	49	2.3	●	72
3318820	**8.2**				49	2.4	●	72
3318830	**8.3**				49	2.4	●	72
3318840	**8.4**				49	2.4	●	73
3318850	**8.5**				49	2.5	●	73
3318860	**8.6**	57			42	2.5	●	73
3318870	**8.7**				42	2.5	●	73
3318880	**8.8**				42	2.5	●	73
3318890	**8.9**				42	2.6	●	73
3318900	**9**				42	2.6	●	74
3318910	**9.1**		106	10	47	2.6	●	90
3318920	**9.2**				47	2.7	●	90
3318930	**9.3**				47	2.7	●	91
3318940	**9.4**				47	2.7	●	91
3318950	**9.5**				47	2.7	●	91
3318960	**9.6**	63			41	2.8	●	91
3318970	**9.7**				41	2.8	●	91
3318980	**9.8**				41	2.8	●	92
3318990	**9.9**				41	2.9	●	92

下一页
直径 DC 10～12 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
WH70-DRL								◎	◎												

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1040

高硬度钢(~70HRC)用硬质合金钻头
FOR HIGH HARDENED STEELS (~70HRC)

WH70-DRL

切削条件 Cutting Conditions | P.406

最适合55-70HRC 硬度材料的加工，有效的刃形设计，以及特殊的涂层，实现了超高硬度材料的稳定加工。

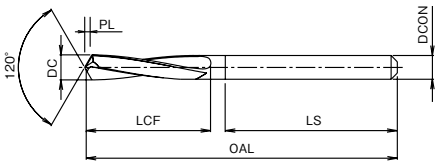
Best for HRC55 ~ 70 applications. The drill for Super Hard Steels with effective cutting edge design for stable machining and special coating for super hard steels.

CARBIDE | WXS | h8 | 12° | SHRINK FIT

X 型横刃
X thinning
(DC＜2.4)

R+W 型横刃
R＋W thinning
(4≦DC)

W 型横刃
W thinning
(2.4≦DC＜4)



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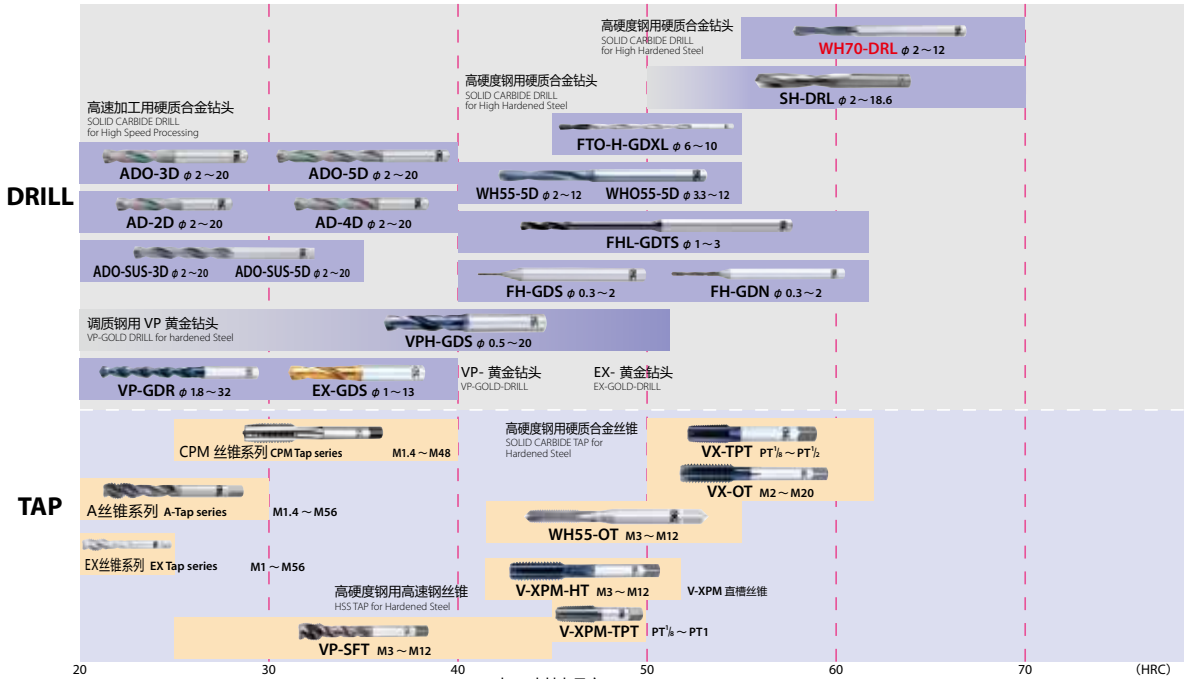
FROM 直径 DC 2～9.9

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3319000	**10**	63	106	10	41	2.9	●	93
3319010	**10.1**		113	11	48	2.9	●	114
3319020	**10.2**				48	2.9	●	115
3319030	**10.3**				48	3	●	116
3319040	**10.4**				48	3	●	116
3319050	**10.5**				48	3	●	117
3319060	**10.6**				48	3.1	●	119
3319070	**10.7**	71			40	3.1	●	114
3319080	**10.8**				40	3.1	●	115
3319090	**10.9**				40	3.1	●	116
3319100	**11**				40	3.2	●	117

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
3319110	**11.1**	71	120	12	47	3.2	●	143
3319120	**11.2**				47	3.2	●	143
3319130	**11.3**				47	3.3	●	144
3319140	**11.4**				47	3.3	●	147
3319150	**11.5**				47	3.3	●	147
3319160	**11.6**				47	3.3	●	148
3319170	**11.7**				47	3.4	●	148
3319180	**11.8**				47	3.4	●	150
3319190	**11.9**	76			42	3.4	●	147
3319200	**12**				42	3.5	●	149

■孔加工工具选择指南 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

高硬度钢用硬质合金钻头
FOR HIGH HARDENED STEELS

SH-DRL

切削条件 Cutting Conditions | P.407

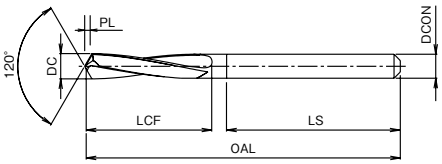
可在硬度高达70HRC的淬火钢上钻孔，而以前必须依靠放电加工。
The SH-DRL can drill quenched and tempered steels (up to 70HRC) that previously could only be drilled with electrical discharge.

CARBIDE | h8 | 12° | SHRINK FIT

X 型横刃
X thinning
(DC<2.4)

W 型横刃
W thinning
(2.4≦DC<4)

R+W 型横刃
R+W thinning
(4≦DC)



单位:mm Unit:mm

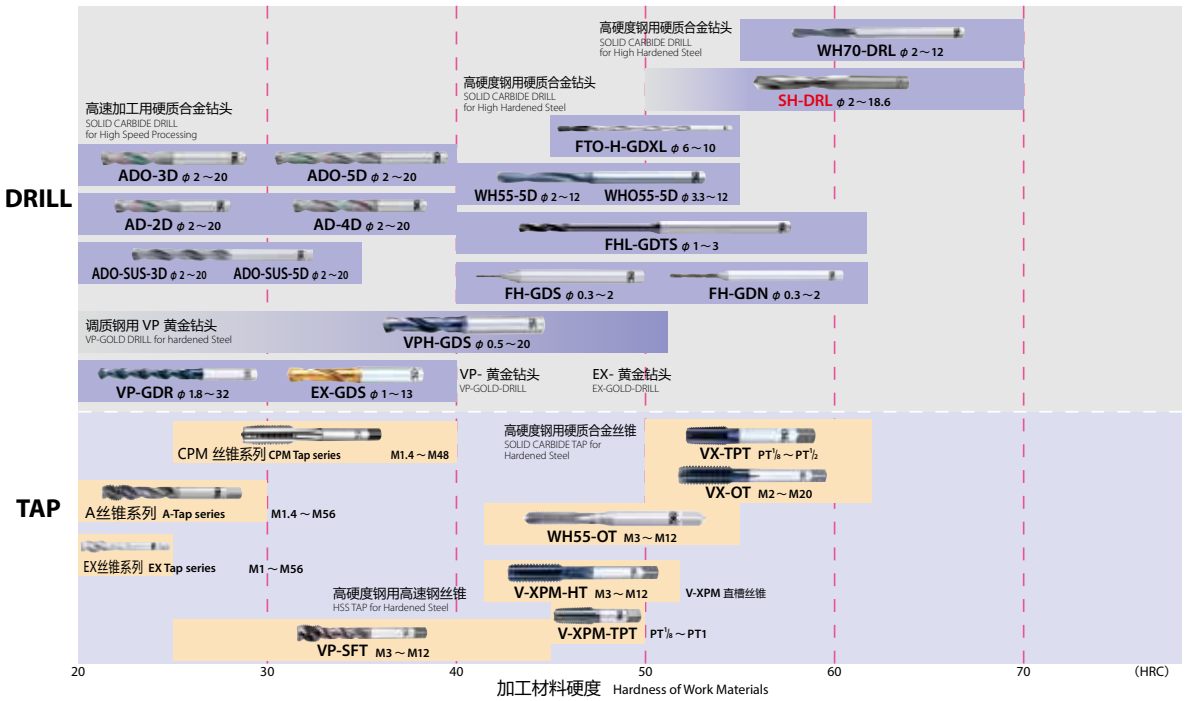
商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8560240	**2.4**	14	44	3	27.9	0.7	▲	5
8560280	**2.8**	16	46		28.6	0.8	▲	5
8560480	**4.8**	32	72	6	35.8	1.4	▲	23
8560590	**5.9**	35	75		37.8	1.7	▲	27
8560630	**6.3**	40	80	6.3	38	1.8	▲	31
8560640	**6.4**			6.4	38	1.8	▲	32
8560820	**8.2**	50	98	8.2	46	2.4	▲	64

▲=此产品已停止生产，由WH70-DRL 替代。

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8560880	**8.8**	57	105	8.8	46	2.5	▲	75
8560940	**9.4**			9.4	46	2.7	▲	87
8560970	**9.7**	63	111	9.7	46	2.8	▲	93
8561090	**10.9**	71	119	10.9	46	3.1	▲	127
8561130	**11.3**			11.3	46	3.3	▲	137
8561160	**11.6**			11.6	46	3.3	▲	145

▲=These products have been stopped producing and replaced by WH70-DRL.

■孔加工工具选择指南 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
SH-DRL								◎	◎												

库存记号 Inventory symbols
●=标准库存品
Standard stock item
○=准标准库存品(请确认库存。)
Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DW1005**

高硬度钢用硬质合金3刃长颈型钻头

CARBIDE 3 FLUTES LONG NECK FOR HARDENED STEELS

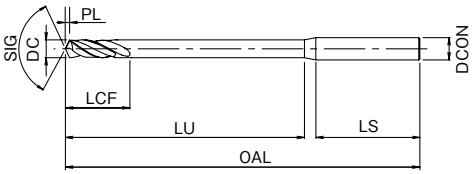
FHL-GDTS

切削条件 Cutting Conditions | P.408

以前，只能用放电加工来加工10~20D 的淬火钢深孔现在也能实现高精度加工，并大大缩短了总加工时间。

Made it possible to drill pre-hardened 10 ~ 20D deep hole with high precision and cut down the production time.

X 型横刃
X thinning



CARBIDE | FX | h8 | 25° | SHRINK FIT

1.2≦DC

单位:mm Unit:mm

商品号 EDP No.	直径 x 有效长 DC × LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8569010	**1 × 20**	5	57	3	32.3	0.2	140°	●	6
8569011	**1.1 × 20**	5.5			32.3	0.2		●	6
8569012	**1.2 × 20**	6.5			32.5	0.2		●	6
8569013	**1.3 × 20**				32.7	0.2		●	6
8569014	**1.4 × 20**	7.5			32.9	0.3		●	6
8569015	**1.5 × 20**				33.1	0.3		●	6
8569016	**1.6 × 20**	8.5			33.2	0.3		●	6

商品号 EDP No.	直径 x 有效长 DC × LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8569017	**1.7 × 20**	8.5	57	3	33.4	0.3	140°	●	6
8569018	**1.8 × 20**	9.5			33.6	0.3		●	6
8569019	**1.9 × 20**				33.9	0.3		●	6
8569020	**2 × 30**	10.5	65		32	0.4		●	7
8569025	**2.5 × 30**	13			32.9	0.5	120°	●	7
8569030	**3 × 30**	15			34	0.5		●	7

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

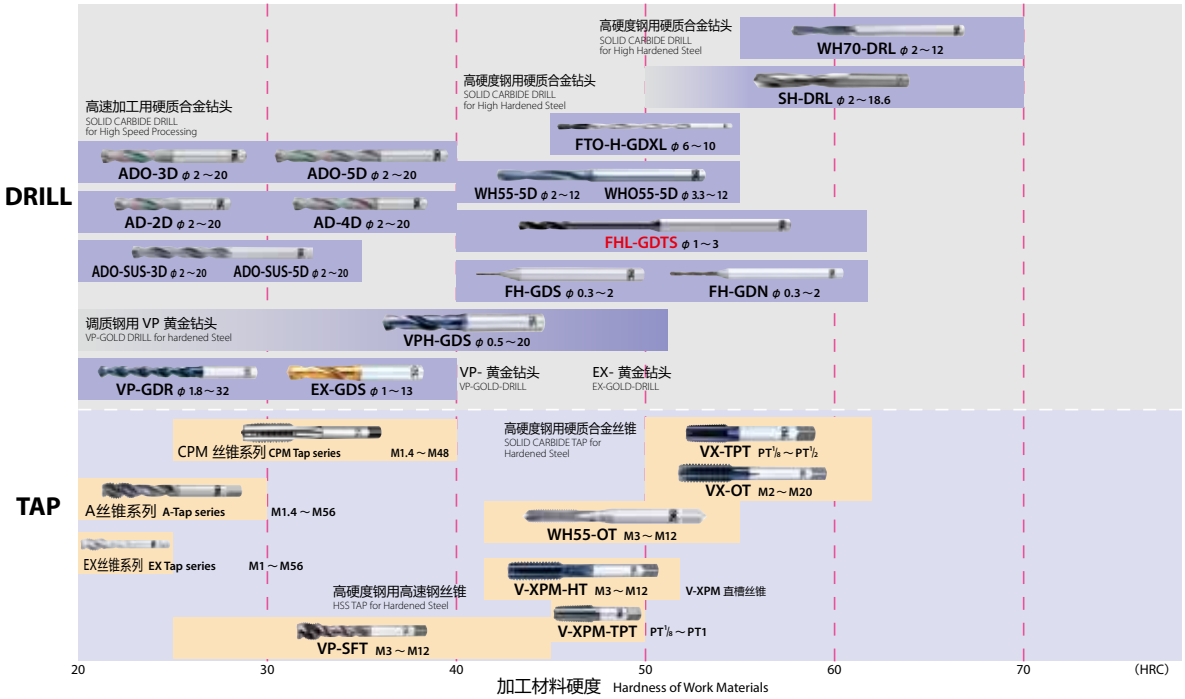
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
FHL-GDTS						○	◎	◎	○												

■孔加工工具选择指南 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1015

模具加工用内冷油孔硬质合金超长刃钻头

CARBIDE EXTRA LONG DRILL FOR MOLDS WITH INTERNAL COOLANT SUPPLY

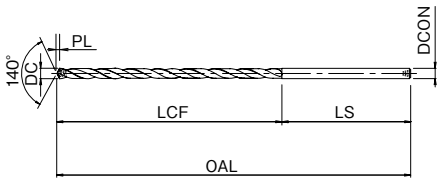
FTO-M-GDXL

切削条件 Cutting Conditions | P.409

实现稳定，长寿命，高效率的模具材料20D 超深孔加工。

Achieves stability, long tool life, and high efficiency when deep hole drilling up to 20D in die steels.

R 型横刃
R thinning



CARBIDE | FX | h8 | 30° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8568600	**10× 20D**	230	290	10	60	1.8	▲	204

▲=此产品已停止生产，由ADO-20D 替代。

▲=These products have been stopped producing and replaced by ADO-20D.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
FTO-M-GDXL	○	◎	◎	◎	◎	◎						◎	◎								

※ 使用FTO-H-GDXL 的加工建议在55HRC 以下。

※ We recommend 55HRC and under for the drilling process by FTO-H-GDXL.

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DW1014

高硬度模具加工用内冷油孔硬质合金超长刃钻头

CARBIDE EXTRA LONG DRILL FOR HARD MOLD MATERIALS WITH INTERNAL COOLANT SUPPLY

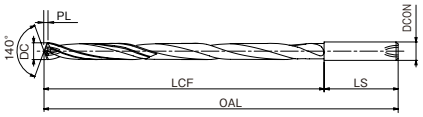
FTO-H-GDXL

切削条件 Cutting Conditions | P.410

实现稳定 · 长寿命 · 高效率的高硬度模具材料(45~55HRC)的20D 超深孔加工。

Achieves stability, long tool life, and high effciency when deep hole drilling up to 20D in hard mold ,materials (45 ~ 55HRC).

R 型横刃
R thinning



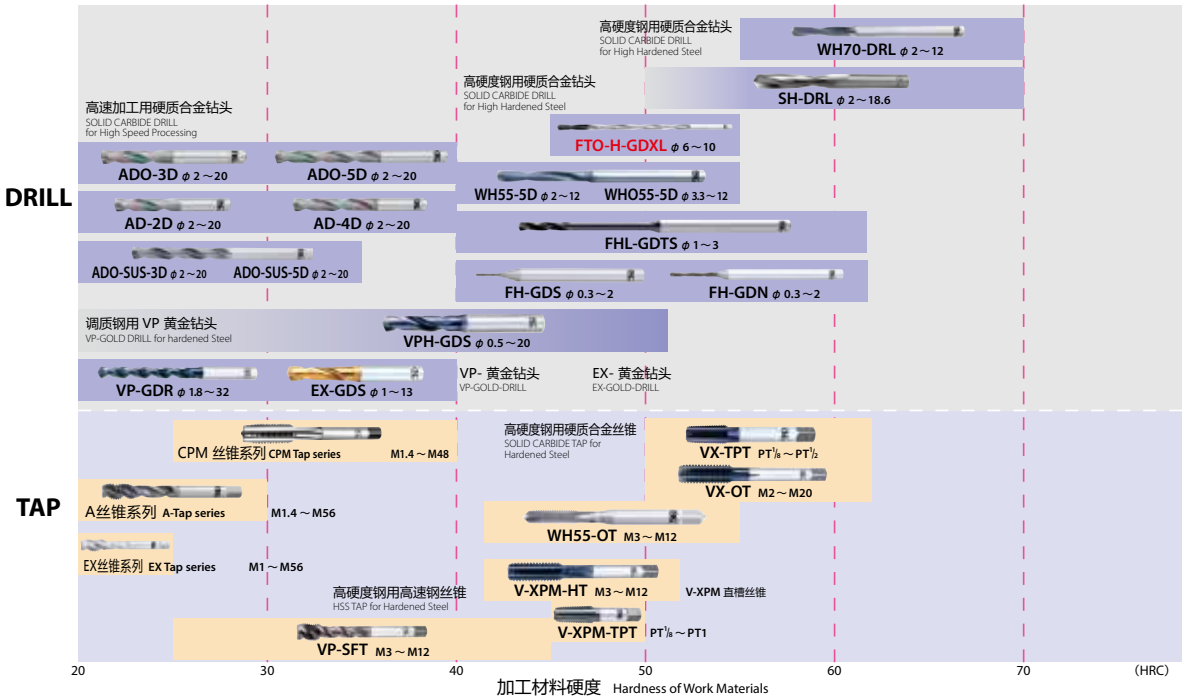
CARBIDE | FX | h8 | 15° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8568760	6× 20D	140	190	6	50	1.1	●	65
8568780	8× 20D	180	230	8	50	1.5	●	117

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8568800	10× 20D	230	290	10	60	1.8	●	228

■孔加工工具选择指南 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
FTO-H-GDXL							◎	◎※													

※ 使用FTO-H-GDXL 的加工建议在55HRC 以下。
※ We recommend 55HRC and under for the drilling process by FTO-H-GDXL.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | FL1077

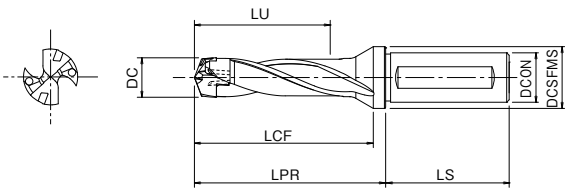
可换头式钻头
EXCHANGEABLE HEAD DRILL

PXDZ

切削条件 Cutting Conditions | P.411

对于大径切削及挤压丝锥的底孔等十分考究精度的加工可以达到与硬质合金整体式钻头同等的加工效率。

This product handles applications that require high precision, such as drilling large diameters or making pilot holes for thread-rolling taps, at carbide drills.



带内冷油孔 with Coolant Hole

3D用 For 3D Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	加工径 DC 最小 DCN	加工径 DC 最大 DCX	有效加工深度 LU	槽长 LCF	LPR	LS	柄径 DCON	DCSFMS	适用装卸工具 Driver	适用刀头 Applicable Head	库存 Stock
7831015	**PXDZ140-3D-113.5-16**	14	14.49	43	63.4	69.9	48	16	20	❶	①	●
7831016	**PXDZ145-3D-115.5-16**	14.5	14.99	44.5	65.5	72	48	16	20		②	
7831017	**PXDZ150-3D-119.5-20**	15	15.99	46.5	67.1	73.6	50	20	25		③	
7831018	**PXDZ160-3D-123.5-20**	16	16.99	49.5	71.7	78.2	50	20	25		④	
7831019	**PXDZ170-3D-128.5-20**	17	17.99	52.5	76.8	83.3	50	20	25		⑤	
7831020	**PXDZ180-3D-138.5-25**	18	18.99	55.5	81.4	87.9	56	25	32		⑥	
7831021	**PXDZ190-3D-142.5-25**	19	19.99	58.5	85.4	91.9	56	25	32	❷	⑦	
7831022	**PXDZ200-3D-146.5-25**	20	20.99	61.5	90.1	96.6	56	25	32		⑧	
7831023	**PXDZ210-3D-154.5-32**	21	21.99	64.5	94.7	101.2	60	32	42		⑨	
7831024	**PXDZ220-3D-158.5-32**	22	22.99	67.5	98.8	105.3	60	32	42		⑩	
7831025	**PXDZ230-3D-162.5-32**	23	23.99	70.5	103.4	109.9	60	32	42	❸	⑪	
7831026	**PXDZ240-3D-167.5-32**	24	24.99	73.5	108.4	114.9	60	32	42		⑫	
7831027	**PXDZ250-3D-170.5-32**	25	25.99	76.5	112	118.5	60	32	42		⑬	

PXDZ 的名称中有登记刀体的全长(未安装刀头时的长度)。
例) 商品号 :7831015
名称 : PXDZ140-3D-113.5-16
└刀体全长

PXDZ designation includes the total length of body (without head).
ex) EDP No. : 7831015
Designation : PXDZ140-3D-113.5-16
└total length of body

■零件 Accessories

装卸工具 Driver

	商品号 EDP No.	库存 Stock	名称 Designation	板厚 Sheet Thickness	适用刀头 Applicable Head
❶	**7808282**	●	**PXDP1400-1899**	**1.5**	① ～ ⑥
❷	**7808283**	●	**PXDP1900-2299**	**1.8**	⑦ ～ ⑩
❸	**7808284**	●	**PXDP2300-2699**	**2**	⑪ ～ ⑬

装卸工具请另购。
The drivers are sold separately from the cutters.

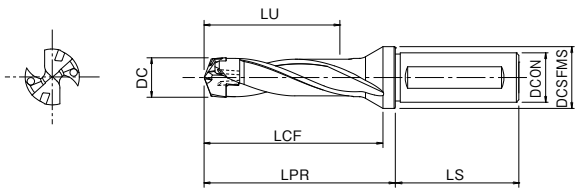
适用刀头请参考 P.221 ∽ P.226。See p.221 ～ P.226 for applicable heads.

●=标准库存品 ●=Standard stock item

可换头式钻头
EXCHANGEABLE HEAD DRILL

PXDZ

切削条件 Cutting Conditions | P.411



带内冷油孔 with Coolant Hole

5D用 For 5D Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	加工径 DC 最小 DCN	加工径 DC 最大 DCX	有效加工深度 LU	槽长 LCF	LPR	LS	柄径 DCON	DCSFMS	适用装卸工具 Driver	适用刀头 Applicable Head	库存 Stock
7831065	**PXDZ140-5D-141.5-16**	14	14.49	71.2	92.9	97.9	48	16	20	❶	①	●
7831066	**PXDZ145-5D-144.5-16**	14.5	14.99	73.7	96	101	48	16	20		②	
7831067	**PXDZ150-5D-149.5-20**	15	15.99	77.5	97.1	103.6	50	20	25		③	
7831068	**PXDZ160-5D-155.5-20**	16	16.99	82.5	103.7	110.2	50	20	25		④	
7831069	**PXDZ170-5D-162.5-20**	17	17.99	87.5	110.8	117.3	50	20	25		⑤	
7831070	**PXDZ180-5D-174.5-25**	18	18.99	92.5	117.4	123.9	56	25	32		⑥	
7831071	**PXDZ190-5D-180.5-25**	19	19.99	97.5	123.4	129.9	56	25	32	❷	⑦	
7831072	**PXDZ200-5D-186.5-25**	20	20.99	102.5	130.1	136.6	56	25	32		⑧	
7831073	**PXDZ210-5D-196.5-32**	21	21.99	107.5	136.7	143.2	60	32	42		⑨	
7831074	**PXDZ220-5D-202.5-32**	22	22.99	112.5	142.8	149.3	60	32	42		⑩	
7831075	**PXDZ230-5D-208.5-32**	23	23.99	117.5	149.4	155.9	60	32	42	❸	⑪	
7831076	**PXDZ240-5D-215.5-32**	24	24.99	122.5	156.4	162.9	60	32	42		⑫	
7831077	**PXDZ250-5D-220.5-32**	25	25.99	127.5	162	168.5	60	32	42		⑬	

PXDZ 的名称中有登记刀体的全长(未安装刀头时的长度)。
例) 商品号 :7831015
名称 : PXDZ140-3D-113.5-16
↑—刀体全长

PXDZ designation includes the total length of body (without head).
ex) EDP No. : 7831015
Designation : PXDZ140-3D-113.5-16
↑—total length of body

■零件 Accessories

装卸工具 Driver

	商品号 EDP No.	库存 Stock	名称 Designation	板厚 Sheet Thickness	适用刀头 Applicable Head
❶	7808282	●	PXDP1400-1899	1.5	① ～ ⑥
❷	7808283	●	PXDP1900-2299	1.8	⑦ ～ ⑩
❸	7808284	●	PXDP2300-2699	2	⑪ ～ ⑬

装卸工具请另购。
The drivers are sold separately from the cutters.

适用刀头请参考 P.221 ～ P.226。See p.221 ～ P.226 for applicable heads.

●=标准库存品 ●=Standard stock item

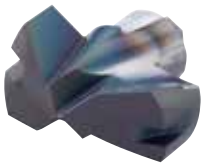
G-LIST No. | FL1079

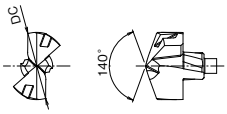
可换头式钻头用刀头
EXCHANGEABLE HEAD DRILL HEAD

PXD 刀头

切削条件 Cutting Conditions | P.411

专为钢加工用设计的刀头，最适合加工软钢～低·中碳素钢。
Heads designed for working with steel. Optimal for working with mild steel and low to medium carbon steel.





钢用(PC) For Steel (PC)

单位:mm Unit:mm

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
7831140		PXDH1400-PC	14	XP3425	●
	①	PXDH1410-PC	14.1		※
		PXDH1420-PC	14.2		
		PXDH1430-PC	14.3		
		PXDH1440-PC	14.4		
7831145		PXDH1450-PC	14.5		●
	②	PXDH1460-PC	14.6		※
		PXDH1470-PC	14.7		
		PXDH1480-PC	14.8		
		PXDH1490-PC	14.9		
7831351		PXDH1495-PC	14.95		●
7831150		PXDH1500-PC	15		
		PXDH1510-PC	15.1		※
		PXDH1520-PC	15.2		
7831352		PXDH1525-PC	15.25		●
	③	PXDH1530-PC	15.3		※
		PXDH1540-PC	15.4		
7831155		PXDH1550-PC	15.5		●
		PXDH1560-PC	15.6		※
		PXDH1570-PC	15.7		
		PXDH1580-PC	15.8		
		PXDH1590-PC	15.9		
7831160		PXDH1600-PC	16		●
		PXDH1610-PC	16.1		※
		PXDH1620-PC	16.2		
		PXDH1630-PC	16.3		
	④	PXDH1640-PC	16.4		
7831165		PXDH1650-PC	16.5		●
		PXDH1660-PC	16.6		※
7831167		PXDH1670-PC	16.7		●
		PXDH1680-PC	16.8		※
		PXDH1690-PC	16.9		
7831170		PXDH1700-PC	17		●
		PXDH1710-PC	17.1		※
		PXDH1720-PC	17.2		
7831353		PXDH1725-PC	17.25		●
		PXDH1730-PC	17.3		※
	⑤	PXDH1740-PC	17.4		
7831175		PXDH1750-PC	17.5		●
		PXDH1760-PC	17.6		※
		PXDH1770-PC	17.7		
		PXDH1780-PC	17.8		
		PXDH1790-PC	17.9		
7831180	⑥	PXDH1800-PC	18		●

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
		PXDH1810-PC	18.1	XP3425	
		PXDH1820-PC	18.2		※
		PXDH1830-PC	18.3		
		PXDH1840-PC	18.4		
7831185	⑥	PXDH1850-PC	18.5		●
		PXDH1860-PC	18.6		※
7831187		PXDH1870-PC	18.7		●
		PXDH1880-PC	18.8		※
		PXDH1890-PC	18.9		
7831190		PXDH1900-PC	19		●
		PXDH1910-PC	19.1		※
		PXDH1920-PC	19.2		
7831354		PXDH1925-PC	19.25		●
		PXDH1930-PC	19.3		※
	⑦	PXDH1940-PC	19.4		
7831195		PXDH1950-PC	19.5		●
		PXDH1960-PC	19.6		※
		PXDH1970-PC	19.7		
		PXDH1980-PC	19.8		
		PXDH1990-PC	19.9		
7831200		PXDH2000-PC	20		●
		PXDH2010-PC	20.1		※
		PXDH2020-PC	20.2		
		PXDH2030-PC	20.3		
		PXDH2040-PC	20.4		
7831205	⑧	PXDH2050-PC	20.5		●
		PXDH2060-PC	20.6		※
7831207		PXDH2070-PC	20.7		●
		PXDH2080-PC	20.8		※
		PXDH2090-PC	20.9		
7831210		PXDH2100-PC	21		●
		PXDH2110-PC	21.1		※
		PXDH2120-PC	21.2		
7831355		PXDH2125-PC	21.25		●
		PXDH2130-PC	21.3		※
	⑨	PXDH2140-PC	21.4		
7831215		PXDH2150-PC	21.5		●
		PXDH2160-PC	21.6		※
		PXDH2170-PC	21.7		
		PXDH2180-PC	21.8		
		PXDH2190-PC	21.9		
7831220		PXDH2200-PC	22		●
	⑩	PXDH2210-PC	22.1		※
		PXDH2220-PC	22.2		

※＝特别订制产品

※＝Special Order Item

蓝字＝ 切削丝锥底孔加工用
红字＝ 挤压丝锥底孔加工用

Blue = tap drill hole for cutting taps
Red = tap drill hole for forming taps
作为挤压丝锥底孔使用时请使用3D 型。
For tap drill hole of forming tap, 3D type should be used. (5D is not recommended)

下一页
直径 DC 22.3～25.4 NEXT

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
PXD 刀头 (PC)	◎	◎	◎	○	○							○	○								

上一页

FROM 直径 **DC** 14～22.2

单位:mm Unit:mm

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑩	**PXDH2230-PC**	22.3	XP3425	※
7831224	⑩	**PXDH2240-PC**	22.4	XP3425	●
7831225	⑩	**PXDH2250-PC**	22.5	XP3425	●
	⑩	**PXDH2260-PC**	22.6	XP3425	※
	⑩	**PXDH2270-PC**	22.7	XP3425	※
	⑩	**PXDH2280-PC**	22.8	XP3425	※
	⑩	**PXDH2290-PC**	22.9	XP3425	※
7831230	⑪	**PXDH2300-PC**	23	XP3425	●
	⑪	**PXDH2310-PC**	23.1	XP3425	※
	⑪	**PXDH2320-PC**	23.2	XP3425	※
7831356	⑪	**PXDH2325-PC**	23.25	XP3425	●
	⑪	**PXDH2330-PC**	23.3	XP3425	※
	⑪	**PXDH2340-PC**	23.4	XP3425	※
7831235	⑪	**PXDH2350-PC**	23.5	XP3425	●
	⑪	**PXDH2360-PC**	23.6	XP3425	※
	⑪	**PXDH2370-PC**	23.7	XP3425	※
	⑪	**PXDH2380-PC**	23.8	XP3425	※

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑪	**PXDH2390-PC**	23.9	XP3425	※
7831240	⑫	**PXDH2400-PC**	24	XP3425	●
	⑫	**PXDH2410-PC**	24.1	XP3425	※
	⑫	**PXDH2420-PC**	24.2	XP3425	※
	⑫	**PXDH2430-PC**	24.3	XP3425	※
	⑫	**PXDH2440-PC**	24.4	XP3425	※
7831245	⑫	**PXDH2450-PC**	24.5	XP3425	●
	⑫	**PXDH2460-PC**	24.6	XP3425	※
	⑫	**PXDH2470-PC**	24.7	XP3425	※
	⑫	**PXDH2480-PC**	24.8	XP3425	※
	⑫	**PXDH2490-PC**	24.9	XP3425	※
7831250	⑬	**PXDH2500-PC**	25	XP3425	●
	⑬	**PXDH2510-PC**	25.1	XP3425	※
	⑬	**PXDH2520-PC**	25.2	XP3425	※
	⑬	**PXDH2530-PC**	25.3	XP3425	※
7831254	⑬	**PXDH2540-PC**	25.4	XP3425	●

※＝特别订制产品

※＝Special Order Item

蓝字＝ 切削丝锥底孔加工用
红字＝ 挤压丝锥底孔加工用

Blue = tap drill hole for cutting taps
Red = tap drill hole for forming taps
作为挤压丝锥底孔使用时请使用3D 型。
For tap drill hole of forming tap, 3D type should be used. (5D is not recommended)

●=标准库存品 ●=Standard stock item

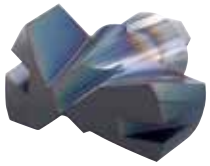
G-LIST No. | FL1079

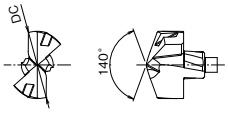
可换头式钻头用刀头
EXCHANGEABLE HEAD DRILL HEAD

PXD 刀头

切削条件 Cutting Conditions | P.411

专为铸件加工用设计的刀头，最适合加工铸铁 · 球墨铸铁。
Heads designed for working with casting. Optimal for working with cast iron and ductile cast iron.





铸件用(KC) For Casting (KC)

单位:mm Unit:mm

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
7831440	①	PXDH1400-KC	14	XP1425	●
		PXDH1410-KC	14.1		※
		PXDH1420-KC	14.2		
		PXDH1430-KC	14.3		
		PXDH1440-KC	14.4		
7831445	②	PXDH1450-KC	14.5		●
		PXDH1460-KC	14.6		※
		PXDH1470-KC	14.7		
		PXDH1480-KC	14.8		
		PXDH1490-KC	14.9		
7831450	③	PXDH1500-KC	15		●
		PXDH1510-KC	15.1		※
		PXDH1520-KC	15.2		
		PXDH1530-KC	15.3		
		PXDH1540-KC	15.4		
7831455		PXDH1550-KC	15.5		●
		PXDH1560-KC	15.6		※
		PXDH1570-KC	15.7		
		PXDH1580-KC	15.8		
		PXDH1590-KC	15.9		
7831460	④	PXDH1600-KC	16		●
		PXDH1610-KC	16.1		※
		PXDH1620-KC	16.2		
		PXDH1630-KC	16.3		
		PXDH1640-KC	16.4		
7831465		PXDH1650-KC	16.5		●
		PXDH1660-KC	16.6		※
7831467		PXDH1670-KC	16.7		●
		PXDH1680-KC	16.8		※
		PXDH1690-KC	16.9		
7831470	⑤	PXDH1700-KC	17		●
		PXDH1710-KC	17.1		※
		PXDH1720-KC	17.2		
		PXDH1730-KC	17.3		
		PXDH1740-KC	17.4		
7831475		PXDH1750-KC	17.5		●
		PXDH1760-KC	17.6		※
		PXDH1770-KC	17.7		
		PXDH1780-KC	17.8		
		PXDH1790-KC	17.9		
7831480	⑥	PXDH1800-KC	18		●
		PXDH1810-KC	18.1		※
		PXDH1820-KC	18.2		
		PXDH1830-KC	18.3		

※=特别订制产品
蓝字= 切削丝锥底孔加工用

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑥	PXDH1840-KC	18.4	XP1425	※
7831485		PXDH1850-KC	18.5		●
		PXDH1860-KC	18.6		※
7831487		PXDH1870-KC	18.7		●
		PXDH1880-KC	18.8		※
		PXDH1890-KC	18.9		
7831490	⑦	PXDH1900-KC	19		●
		PXDH1910-KC	19.1		※
		PXDH1920-KC	19.2		
		PXDH1930-KC	19.3		
		PXDH1940-KC	19.4		
7831495		PXDH1950-KC	19.5		●
		PXDH1960-KC	19.6		※
		PXDH1970-KC	19.7		
		PXDH1980-KC	19.8		
		PXDH1990-KC	19.9		
7831500	⑧	PXDH2000-KC	20		●
		PXDH2010-KC	20.1		※
		PXDH2020-KC	20.2		
		PXDH2030-KC	20.3		
		PXDH2040-KC	20.4		
7831505		PXDH2050-KC	20.5		●
		PXDH2060-KC	20.6		※
7831507		PXDH2070-KC	20.7		●
		PXDH2080-KC	20.8		※
		PXDH2090-KC	20.9		
7831510	⑨	PXDH2100-KC	21		●
		PXDH2110-KC	21.1		※
		PXDH2120-KC	21.2		
		PXDH2130-KC	21.3		
		PXDH2140-KC	21.4		
7831515		PXDH2150-KC	21.5		●
		PXDH2160-KC	21.6		※
		PXDH2170-KC	21.7		
		PXDH2180-KC	21.8		
		PXDH2190-KC	21.9		
7831520	⑩	PXDH2200-KC	22		●
		PXDH2210-KC	22.1		※
		PXDH2220-KC	22.2		
		PXDH2230-KC	22.3		
7831524		PXDH2240-KC	22.4		●
7831525		PXDH2250-KC	22.5		
		PXDH2260-KC	22.6		※
		PXDH2270-KC	22.7		

※=Special Order Item
Blue = tap drill hole for cutting taps

下一页
直径 DC 22.8～25.4 NEXT

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
PXD 刀头 (KC)	○	○	○	○	○							◎	◎								

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FROM 直径 **DC** 14～22.7

单位:mm Unit:mm

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑩	**PXDH2280-KC**	22.8	XP1425	※
		PXDH2290-KC	22.9		
7831530	⑪	**PXDH2300-KC**	23		●
		PXDH2310-KC	23.1		※
		PXDH2320-KC	23.2		
		PXDH2330-KC	23.3		
		PXDH2340-KC	23.4		
7831535		**PXDH2350-KC**	23.5		●
		PXDH2360-KC	23.6		※
		PXDH2370-KC	23.7		
		PXDH2380-KC	23.8		
		PXDH2390-KC	23.9		
7831540	⑫	**PXDH2400-KC**	24		●
		PXDH2410-KC	24.1		※

※=特别订制产品

蓝字= 切削丝锥底孔加工用

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑫	**PXDH2420-KC**	24.2	XP1425	※
		PXDH2430-KC	24.3		
		PXDH2440-KC	24.4		
7831545		**PXDH2450-KC**	24.5		●
		PXDH2460-KC	24.6		※
		PXDH2470-KC	24.7		
		PXDH2480-KC	24.8		
		PXDH2490-KC	24.9		
7831550	⑬	**PXDH2500-KC**	25		●
		PXDH2510-KC	25.1		※
		PXDH2520-KC	25.2		
		PXDH2530-KC	25.3		
7831554		**PXDH2540-KC**	25.4		●

※=Special Order Item

Blue = tap drill hole for cutting taps

●=标准库存品 ●=Standard stock item

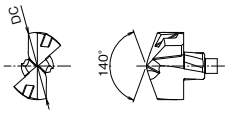
G-LIST No. | FL1079

可换头式钻头用刀头
EXCHANGEABLE HEAD DRILL HEAD

PXD 刀头

切削条件 Cutting Conditions | P.411

专为非铁金属加工用设计的刀头。最适合铝合金铸件等的加工。
Heads designed for working with nonferrous metals. Optimal for working with cast aluminum alloys.



非铁金属用(NC) For Nonferrous metals (NC)

单位:mm Unit:mm

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
7831740	①	PXDH1400-NC	14	CF225	●
		PXDH1410-NC	14.1		※
		PXDH1420-NC	14.2		
		PXDH1430-NC	14.3		
		PXDH1440-NC	14.4		
7831745	②	PXDH1450-NC	14.5		●
		PXDH1460-NC	14.6		※
		PXDH1470-NC	14.7		
		PXDH1480-NC	14.8		
		PXDH1490-NC	14.9		
7831750	③	PXDH1500-NC	15		●
		PXDH1510-NC	15.1		※
		PXDH1520-NC	15.2		
		PXDH1530-NC	15.3		
		PXDH1540-NC	15.4		
7831755		PXDH1550-NC	15.5		●
		PXDH1560-NC	15.6		※
		PXDH1570-NC	15.7		
		PXDH1580-NC	15.8		
		PXDH1590-NC	15.9		
7831760	④	PXDH1600-NC	16		●
		PXDH1610-NC	16.1		※
		PXDH1620-NC	16.2		
		PXDH1630-NC	16.3		
		PXDH1640-NC	16.4		
7831765		PXDH1650-NC	16.5		●
		PXDH1660-NC	16.6		※
7831767		PXDH1670-NC	16.7		●
		PXDH1680-NC	16.8		※
		PXDH1690-NC	16.9		
7831770	⑤	PXDH1700-NC	17		●
		PXDH1710-NC	17.1		※
		PXDH1720-NC	17.2		
		PXDH1730-NC	17.3		
		PXDH1740-NC	17.4		
7831775		PXDH1750-NC	17.5		●
		PXDH1760-NC	17.6		※
		PXDH1770-NC	17.7		
		PXDH1780-NC	17.8		
		PXDH1790-NC	17.9		
7831780	⑥	PXDH1800-NC	18		●
		PXDH1810-NC	18.1		※
		PXDH1820-NC	18.2		
		PXDH1830-NC	18.3		

※=特别订制产品
蓝字= 切削丝锥底孔加工用

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑥	PXDH1840-NC	18.4	CF225	※
7831785		PXDH1850-NC	18.5		●
		PXDH1860-NC	18.6		※
7831787		PXDH1870-NC	18.7		●
		PXDH1880-NC	18.8		※
		PXDH1890-NC	18.9		
7831790	⑦	PXDH1900-NC	19		●
		PXDH1910-NC	19.1		※
		PXDH1920-NC	19.2		
		PXDH1930-NC	19.3		
		PXDH1940-NC	19.4		
7831795		PXDH1950-NC	19.5		●
		PXDH1960-NC	19.6		※
		PXDH1970-NC	19.7		
		PXDH1980-NC	19.8		
		PXDH1990-NC	19.9		
7831800	⑧	PXDH2000-NC	20		●
		PXDH2010-NC	20.1		※
		PXDH2020-NC	20.2		
		PXDH2030-NC	20.3		
		PXDH2040-NC	20.4		
7831805		PXDH2050-NC	20.5		●
		PXDH2060-NC	20.6		※
7831807		PXDH2070-NC	20.7		●
		PXDH2080-NC	20.8		※
		PXDH2090-NC	20.9		
7831810	⑨	PXDH2100-NC	21		●
		PXDH2110-NC	21.1		※
		PXDH2120-NC	21.2		
		PXDH2130-NC	21.3		
		PXDH2140-NC	21.4		
7831815		PXDH2150-NC	21.5		●
		PXDH2160-NC	21.6		※
		PXDH2170-NC	21.7		
		PXDH2180-NC	21.8		
		PXDH2190-NC	21.9		
7831820	⑩	PXDH2200-NC	22		●
		PXDH2210-NC	22.1		※
		PXDH2220-NC	22.2		
		PXDH2230-NC	22.3		
7831824		PXDH2240-NC	22.4		●
7831825		PXDH2250-NC	22.5		
		PXDH2260-NC	22.6		※
		PXDH2270-NC	22.7		

※=Special Order Item
Blue = tap drill hole for cutting taps

下一页
直径 DC 22.8～25.4 NEXT

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
PXD 刀头 (NC)														○		◎					

上一页

FROM 直径 **DC** 14～22.7

单位:mm Unit:mm

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑩	**PXDH2280-NC**	22.8	CF225	※
		PXDH2290-NC	22.9		
7831830	⑪	**PXDH2300-NC**	23		●
		PXDH2310-NC	23.1		※
		PXDH2320-NC	23.2		
		PXDH2330-NC	23.3		
		PXDH2340-NC	23.4		
7831835		**PXDH2350-NC**	23.5		●
		PXDH2360-NC	23.6		※
		PXDH2370-NC	23.7		
		PXDH2380-NC	23.8		
		PXDH2390-NC	23.9		
7831840	⑫	**PXDH2400-NC**	24		●
		PXDH2410-NC	24.1		※

※=特别订制产品

蓝字= 切削丝锥底孔加工用

商品号 EDP No.		名称 Designation	直径 DC	材质 Grades	库存 Stock
	⑫	**PXDH2420-NC**	24.2	CF225	※
		PXDH2430-NC	24.3		
		PXDH2440-NC	24.4		
7831845		**PXDH2450-NC**	24.5		●
		PXDH2460-NC	24.6		※
		PXDH2470-NC	24.7		
		PXDH2480-NC	24.8		
		PXDH2490-NC	24.9		
7831850	⑬	**PXDH2500-NC**	25		●
		PXDH2510-NC	25.1		※
		PXDH2520-NC	25.2		
		PXDH2530-NC	25.3		
7831854		**PXDH2540-NC**	25.4		●

※=Special Order Item

Blue = tap drill hole for cutting taps

●=标准库存品 ●=Standard stock item

G-LIST No. | **FL1064**

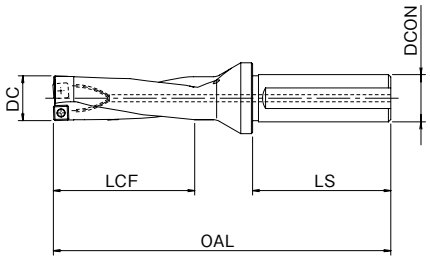
可转位式钻头
INDEXABLE DRILL

PHP

切削条件 Cutting Conditions | P.412

可转位式钻头，排屑性能流畅，加工效率高。4 角刀片的设计更能节省成本。

The indexable drill with superior chip ejection capabillity and high productivity. With 4 corners insert for cost savings.



带内冷油孔 with Coolant Hole

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	槽长 LCF	柄径 DCON	柄长 LS	适用刀片 Applicable Inserts	库存 Stock
7800100	**PHP140FS20M04-3D**	14	116	42	20	50	①	●
7800101	**PHP145FS20M04-3D**	14.5	119	45				
7800102	**PHP150FS20M04-3D**	15						
7800103	**PHP155FS20M04-3D**	15.5	122	48				
7800104	**PHP160FS20M04-3D**	16						
7800105	**PHP165FS20M05-3D**	16.5	125	51			②	
7800106	**PHP170FS20M05-3D**	17						
7800107	**PHP175FS25M05-3D**	17.5	134	54	25	56		
7800108	**PHP180FS25M05-3D**	18						
7800109	**PHP185FS25M06-3D**	18.5	137	57			③	
7800110	**PHP190FS25M06-3D**	19						
7800111	**PHP195FS25M06-3D**	19.5	140	60				
7800112	**PHP200FS25M06-3D**	20						
7800113	**PHP205FS25M06-3D**	20.5	143	63				
7800114	**PHP210FS25M07-3D**	21					④	
7800115	**PHP215FS25M07-3D**	21.5	146	66				
7800116	**PHP220FS25M07-3D**	22						
7800117	**PHP225FS25M07-3D**	22.5	149	69				
7800118	**PHP230FS25M07-3D**	23						
7800119	**PHP235FS32M07-3D**	23.5	156	72	32	60		
7800120	**PHP240FS32M07-3D**	24						
7800121	**PHP245FS32M08-3D**	24.5	159	75			⑤	
7800122	**PHP250FS32M08-3D**	25						
7800123	**PHP255FS32M08-3D**	25.5	162	78				
7800124	**PHP260FS32M08-3D**	26						
7800125	**PHP265FS32M08-3D**	26.5	165	81				
7800126	**PHP270FS32M08-3D**	27						
7800127	**PHP280FS32M08-3D**	28	168	84			⑥	
7800128	**PHP290FS32M10-3D**	29	171	87				
7800130	**PHP300FS32M10-3D**	30	179	90				
7800131	**PHP310FS32M10-3D**	31	182	93				
7800132	**PHP320FS32M10-3D**	32	185	96				
7800133	**PHP330FS40M10-3D**	33	196	99	40	68	⑦	
7800134	**PHP340FS40M10-3D**	34	199	102				
7800135	**PHP350FS40M12-3D**	35	202	105				
7800136	**PHP360FS40M12-3D**	36	205	108				
7800137	**PHP370FS40M12-3D**	37	218	111				
7800138	**PHP380FS40M12-3D**	38	221	114				
7800139	**PHP390FS40M12-3D**	39	224	117				
7800140	**PHP400FS40M12-3D**	40	227	120				

蓝字 = 切削丝锥底孔加工用

Blue = tap drill hole for cutting taps

适用的刀片及零件请参照 P.228 页。See p.228 for applicable inserts and accessories.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
PHP	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	○	○			

●=标准库存品 ●=Standard stock item

G-LIST No. | FW1006

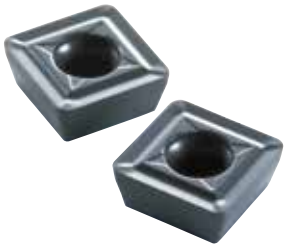
可转位式钻头
INDEXABLE DRILL

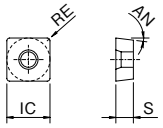
PHP 适用刀片

切削条件 Cutting Conditions | P.412

可转位式钻头，排屑性能流畅，加工效率高。4 角刀片的设计更能节省成本。

The indexable drill with superior chip ejection capabillity and high productivity. With 4 corners insert for cost savings.

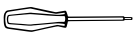




■PHP适用刀片 Available Inserts

	名称 Designation	切削刃数 Number of Cutting Edge	适用刀体 Applicable Body	刀片尺寸 Insert Size				涂层种类 Grade of Coated Materials	
				IC	厚度 S	后角 AN	RE	XP9040	XC9025
①	SCMT042204-DM	4	φ14～16	4.8	2.2	7°	0.4	7818001	7817001
②	SCMT052404-DM	4	φ16.5～18	5.4	2.4	7°	0.4	7818002	7817002
③	SCMT062806-DM	4	φ18.5～20.5	6.2	2.8	7°	0.6	7818003	7817003
④	SCMT073206-DM	4	φ21～24	7.2	3.2	7°	0.6	7818004	7817004
⑤	SCMT083608-DM	4	φ24.5～28	8.6	3.6	7°	0.8	7818005	7817005
⑥	SCMT104208-DM	4	φ29～34	10	4.2	7°	0.8	7818006	7817006
⑦	SCMT125008-DM	4	φ35～40	12.3	5	7°	0.8	7818007	7817007

■零件 Accessories

	商品号 EDP No.	库存 Stock	名称 Designation	适用刀片 Applicable Inserts			
固定螺丝 Clamping Screw	7808100	●	FS18538（Torx 6）	①	SCMT042204-DM	①	–
	7808102	●	FS20540（Torx 6）	②	SCMT052404-DM	②	–
	7808104	●	FS22550（Torx 7）	③	SCMT062806-DM	③	–
	7808108	●	FS25560（Torx 8）	④	SCMT073206-DM	④	–
	7808110	●	FS30573（Torx 8）	⑤	SCMT083608-DM	⑤	–
	7808111	●	FS35572（Torx 15）	⑥	SCMT104208-DM	⑥	–
	7808113	●	FS45510（Torx 20）	⑦	SCMT125008-DM	⑦	–
 扳手 Wrench	7808203	●	T6-D（Torx 6）	①	SCMT042204-DM	②	SCMT052404-DM
	7808204	●	T7-D（Torx 7）	③	SCMT062806-DM		–
	7808205	●	T8-D（Torx 8）	④	SCMT073206-DM	⑤	SCMT083608-DM
	7808208	●	T15-D（Torx 15）	⑥	SCMT104208-DM		–
	7808209	●	T20-D（Torx 20）	⑦	SCMT125008-DM		–

扳手请另购。 Please purchase the wrench separately from the cutter.

●=标准库存品 ●=Standard stock item

G-LIST No. | FL1082

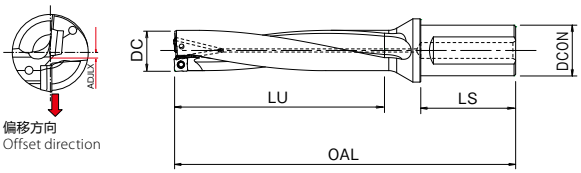
可转位式钻头 2D 型
INDEXABLE DRILL 2D TYPE

P2D

切削条件 Cutting Conditions | P.413

可稳定加工2D 孔的钻头。
It drills 2D holes in a stable manner.

■加工径最大偏移量
Max Offset Amount of Effective Dia.



带内冷油孔 with Coolant Hole

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7803180	P2D1200FS20M03	12	87	24	20	50	0.4	12.8	①	●
7803181	P2D1250FS20M03	12.5	88	25				13.3		
7803182	P2D1300FS20M03	13	89	26			0.3	13.6		
7803183	P2D1350FS20M03	13.5	90	27			0.2	13.9		
7803184	P2D1400FS20M03	14	91	28				14.4		
7803185	P2D1450FS20M03	14.5	92	29			0.1	14.7		
7803117	P2D1500FS20M04	15	95	30			0.4	15.8	②	
7803118	P2D1550FS20M04	15.5	96	31			0.3	16.1		
7803119	P2D1600FS20M04	16	97	32				16.6		
7803120	P2D1650FS20M04	16.5	98	33				17.1		
7803121	P2D1700FS20M05	17	102	34			0.6	18.2	③	
7803122	P2D1750FS20M05	17.5	103	35			0.5	18.5		
7803190	P2D1750FS25M05		109		25	56				
7803123	P2D1800FS25M05	18	110	36				19.0		
7803124	P2D1850FS25M05	18.5	111	37			0.4	19.3		
7803125	P2D1900FS25M06	19	112	38			0.6	20.2	④	
7803126	P2D1950FS25M06	19.5	113	39			0.5	20.5		
7803127	P2D2000FS25M06	20	114	40			0.4	20.8		
7803128	P2D2050FS25M06	20.5	115	41				21.3		
7803129	P2D2100FS25M07	21	121	42			0.6	22.2	⑤	
7803130	P2D2150FS25M07	21.5	122	43				22.7		
7803131	P2D2200FS25M07	22	123	44			0.5	23.0		
7803132	P2D2250FS25M07	22.5	124	45				23.5		
7803133	P2D2300FS25M07	23	125	46			0.4	23.8		
7803191	P2D2350FS25M07	23.5	126	47			0.3	24.1		
7803134	P2D2350FS32M07		130		32	60				
7803192	P2D2400FS25M07	24	127	48	25	56		24.6		
7803135	P2D2400FS32M07		131		32	60				
7803193	P2D2450FS25M07	24.5	128	49	25	56	0.2	24.9		
7803136	P2D2450FS32M07		132		32	60				
7803194	P2D2500FS25M08	25	129	50	25	56	0.7	26.4	⑥	
7803137	P2D2500FS32M08		133		32	60				
7803195	P2D2550FS25M08	25.5	130	51	25	56	0.6	26.7		
7803138	P2D2550FS32M08		134		32	60				
7803139	P2D2600FS32M08	26	135	52			0.5	27.0		
7803140	P2D2650FS32M08	26.5	136	53				27.5		
7803141	P2D2700FS32M08	27	137	54			0.4	27.8		
7803142	P2D2800FS32M08	28	139	56			0.3	28.6		
7803143	P2D2850FS32M08	28.5	140	57			0.2	28.9		

1. 扳手请另购。
蓝字 = 切削丝锥底孔加工用

1. The wrenches are sold separately from the cutters.
Blue = tap drill hole for cutting taps

下一页
外径 DC 29～63 NEXT

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
P2D	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	◎	○	○			

上一页
FROM 外径 DC 12～28.5

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7803144	**P2D2900FS32M09**	29	141	58	32	60	0.8	30.6	⑦	●
7803145	**P2D3000FS32M09**	30	143	60			0.7	31.4		
7803146	**P2D3100FS32M09**	31	145	62			0.6	32.2		
7803196	**P2D3100FS40M09**		155		40	70				
7803147	**P2D3200FS32M09**	32	147	64	32	60	0.5	33.0		
7803197	**P2D3200FS40M09**		157		40	70				
7803148	**P2D3300FS40M09**	33	159	66			0.4	33.8		
7803149	**P2D3350FS40M09**	33.5	160	67			0.2	33.9		
7803150	**P2D3400FS40M10**	34	161	68			1.1	36.2	⑧	
7803151	**P2D3500FS40M10**	35	163	70			0.8	36.6		
7803152	**P2D3600FS40M10**	36	165	72				37.6		
7803153	**P2D3700FS40M10**	37	167	74			0.6	38.2		
7803154	**P2D3800FS40M10**	38	169	76			0.3	38.6		
7803155	**P2D3900FS40M12**	39	178	78			1.0	41.0	⑨	
7803156	**P2D4000FS40M12**	40	180	80			0.9	41.8		
7803157	**P2D4100FS40M12**	41	182	82			0.8	42.6		
7803158	**P2D4200FS40M12**	42	184	84			0.6	43.2		
7803159	**P2D4300FS40M12**	43	186	86			0.5	44.0		
7803160	**P2D4400FS40M12**	44	188	88			0.3	44.6		
7803161	**P2D4500FS40M13**	45	190	90			0.9	46.8	⑩	
7803162	**P2D4600FS40M13**	46	192	92			0.8	47.6		
7803163	**P2D4700FS40M13**	47	194	94	40	70	0.7	48.4		
7803164	**P2D4800FS40M13**	48	196	96			0.5	49.0		
7803165	**P2D4900FS40M13**	49	198	98			0.3	49.6		
7803166	**P2D5000FS40M14**	50	200	100			1.1	52.2	⑪	
7803167	**P2D5100FS40M14**	51	202	102			1.0	53.0		
7803168	**P2D5200FS40M14**	52	204	104			0.8	53.6		
7803169	**P2D5300FS40M14**	53	206	106			0.7	54.4		
7803170	**P2D5400FS40M14**	54	208	108			0.6	55.2		
7803171	**P2D5500FS40M14**	55	210	110			0.4	55.8		
7803172	**P2D5600FS40M14**	56	212	112			0.1	56.2		
7803173	**P2D5700FS40M16**	57	214	114			1.1	59.2	⑫	
7803174	**P2D5800FS40M16**	58	216	116			1.0	60.0		
7803175	**P2D5900FS40M16**	59	218	118			0.9	60.8		
7803176	**P2D6000FS40M16**	60	220	120			0.8	61.6		
7803177	**P2D6100FS40M16**	61	222	122			0.6	62.2		
7803178	**P2D6200FS40M16**	62	224	124			0.4	62.8		
7803179	**P2D6300FS40M16**	63	226	126			0.2	63.4		

1. 扳手请另购。
蓝字= 切削丝锥底孔加工用

1. The wrenches are sold separately from the cutters.
Blue = tap drill hole for cutting taps

适用的刀片及零件请参照 P.237~238 页。See p.237～238 for applicable inserts and accessories.

●=标准库存品 ●=Standard stock item

G-LIST No. | FL1083

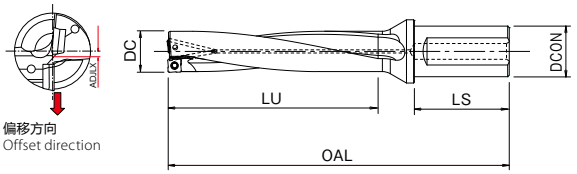
可转位式钻头 3D 型
INDEXABLE DRILL 3D TYPE

P3D

切削条件 Cutting Conditions | P.413

可稳定加工3D 孔的钻头。
It drills 3D holes in a stable manner.

■加工径最大偏移量
Max Offset Amount of Effective Dia.



带内冷油孔 with Coolant Hole

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7803210	P3D1200FS20M03	12	99	36	20	50	0.4	12.8	①	●
7803211	P3D1250FS20M03	12.5	100.5	37.5				13.3		
7803212	P3D1270FS20M03	12.7	101.1	38.1			0.3			
7803213	P3D1300FS20M03	13	102	39				13.6		
7803214	P3D1350FS20M03	13.5	103.5	40.5			0.2	13.9		
7803215	P3D1400FS20M03	14	105	42				14.4		
7803216	P3D1450FS20M03	14.5	106.5	43.5			0.1	14.7		
7803217	P3D1500FS20M04	15	110	45			0.4	15.8	②	
7803218	P3D1550FS20M04	15.5	112	47			0.3	16.1		
7803219	P3D1600FS20M04	16	113	48				16.6		
7803220	P3D1650FS20M04	16.5	115	50				17.1		
7803221	P3D1700FS20M05	17	119	51			0.6	18.2	③	
7803222	P3D1750FS20M05	17.5	121	53			0.5	18.5		
7803290	P3D1750FS25M05		127		25	56				
7803223	P3D1800FS25M05	18	128	54				19.0		
7803224	P3D1850FS25M05	18.5	130	56			0.4	19.3		
7803225	P3D1900FS25M06	19	131	57			0.6	20.2	④	
7803226	P3D1950FS25M06	19.5	133	59			0.5	20.5		
7803227	P3D2000FS25M06	20	134	60			0.4	20.8		
7803228	P3D2050FS25M06	20.5	136	62				21.3		
7803229	P3D2100FS25M07	21	142	63			0.6	22.2	⑤	
7803230	P3D2150FS25M07	21.5	144	65				22.7		
7803231	P3D2200FS25M07	22	145	66			0.5	23.0		
7803232	P3D2250FS25M07	22.5	147	68				23.5		
7803233	P3D2300FS25M07	23	148	69			0.4	23.8		
7803291	P3D2350FS25M07	23.5	150	71			0.3	24.1		
7803234	P3D2350FS32M07		154		32	60				
7803292	P3D2400FS25M07	24	151	72	25	56		24.6		
7803235	P3D2400FS32M07		155		32	60				
7803293	P3D2450FS25M07	24.5	153	74	25	56	0.2	24.9		
7803236	P3D2450FS32M07		157		32	60				
7803294	P3D2500FS25M08	25	154	75	25	56	0.7	26.4	⑥	
7803237	P3D2500FS32M08		158		32	60				
7803295	P3D2550FS25M08	25.5	156	77	25	56	0.6	26.7		
7803238	P3D2550FS32M08		160		32	60				
7803239	P3D2600FS32M08	26	161	78			0.5	27.0		
7803240	P3D2650FS32M08	26.5	163	80				27.5		
7803241	P3D2700FS32M08	27	164	81			0.4	27.8		
7803300	P3D2750FS32M08	27.5	166	83				28.3		
7803242	P3D2800FS32M08	28	167	84			0.3	28.6		
7803243	P3D2850FS32M08	28.5	169	86			0.2	28.9		

1. 扳手请另购。
蓝字 = 切削丝锥底孔加工用

1. The wrenches are sold separately from the cutters.
Blue = tap drill hole for cutting taps

下一页
外径 DC 29～63 NEXT

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
P3D	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	◎	○	○			

上一页
FROM 外径 DC 12～28.5

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7803244	**P3D2900FS32M09**	29	170	87	32	60	0.8	30.6	⑦	
7803301	**P3D2950FS32M09**	29.5	172	89				31.1		
7803245	**P3D3000FS32M09**	30	173	90			0.7	31.4		
7803302	**P3D3050FS32M09**	30.5	175	92				31.9		
7803246	**P3D3100FS32M09**	31	176	93			0.6	32.2		
7803296	**P3D3100FS40M09**		186		40	70				
7803303	**P3D3150FS32M09**	31.5	178	95	32	60	0.5	32.5		
7803247	**P3D3200FS32M09**	32	179	96				33.0		
7803297	**P3D3200FS40M09**		189		40	70				
7803304	**P3D3250FS40M09**	32.5	191	98			0.4	33.3		
7803248	**P3D3300FS40M09**	33	192	99				33.8		
7803249	**P3D3350FS40M09**	33.5	194	101			0.2	33.9		
7803250	**P3D3400FS40M10**	34	195	102			1.1	36.2	⑧	
7803305	**P3D3450FS40M10**	34.5	197	104			0.9	36.3		
7803251	**P3D3500FS40M10**	35	198	105			0.8	36.6		
7803306	**P3D3550FS40M10**	35.5	200	107			0.7	36.9		
7803252	**P3D3600FS40M10**	36	201	108			0.8	37.6		
7803253	**P3D3700FS40M10**	37	204	111			0.6	38.2		
7803307	**P3D3750FS40M10**	37.5	206	113			0.4	38.3		
7803254	**P3D3800FS40M10**	38	207	114			0.3	38.6		
7803255	**P3D3900FS40M12**	39	217	117			1.0	41.0	⑨	●
7803256	**P3D4000FS40M12**	40	220	120			0.9	41.8		
7803308	**P3D4050FS40M12**	40.5	222	122			0.8	42.1		
7803257	**P3D4100FS40M12**	41	223	123				42.6		
7803258	**P3D4200FS40M12**	42	226	126			0.6	43.2		
7803259	**P3D4300FS40M12**	43	229	129			0.5	44.0		
7803260	**P3D4400FS40M12**	44	232	132			0.3	44.6		
7803261	**P3D4500FS40M13**	45	235	135			0.9	46.8	⑩	
7803262	**P3D4600FS40M13**	46	238	138			0.8	47.6		
7803263	**P3D4700FS40M13**	47	241	141			0.7	48.4		
7803264	**P3D4800FS40M13**	48	244	144			0.5	49.0		
7803265	**P3D4900FS40M13**	49	247	147			0.3	49.6		
7803266	**P3D5000FS40M14**	50	250	150			1.1	52.2	⑪	
7803309	**P3D5050FS40M14**	50.5	252	152			1.0	52.5		
7803267	**P3D5100FS40M14**	51	253	153				53.0		
7803268	**P3D5200FS40M14**	52	256	156			0.8	53.6		
7803269	**P3D5300FS40M14**	53	259	159			0.7	54.4		
7803270	**P3D5400FS40M14**	54	262	162			0.6	55.2		
7803271	**P3D5500FS40M14**	55	265	165			0.4	55.8		
7803272	**P3D5600FS40M14**	56	268	168			0.1	56.2		
7803273	**P3D5700FS40M16**	57	271	171			1.1	59.2	⑫	
7803274	**P3D5800FS40M16**	58	274	174			1.0	60.0		
7803275	**P3D5900FS40M16**	59	277	177			0.9	60.8		
7803276	**P3D6000FS40M16**	60	280	180			0.8	61.6		
7803277	**P3D6100FS40M16**	61	283	183			0.6	62.2		
7803278	**P3D6200FS40M16**	62	286	186			0.4	62.8		
7803279	**P3D6300FS40M16**	63	289	189			0.2	63.4		

1. 扳手请另购。
蓝字 = 切削丝锥底孔加工用

1. The wrenches are sold separately from the cutters.
Blue = tap drill hole for cutting taps

适用的刀片及零件请参照 P.237~238 页。See p.237～238 for applicable inserts and accessories.

●=标准库存品 ●=Standard stock item

G-LIST No. | FL1084

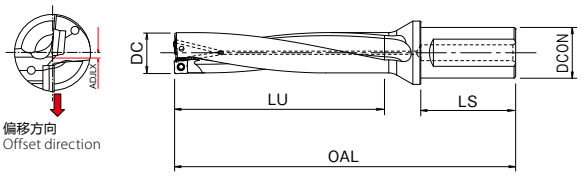
可转位式钻头 4D 型
INDEXABLE DRILL 4D TYPE

P4D

切削条件 Cutting Conditions | P.413

可进行对于可转位式刀具相当困难的4D 深孔的稳定加工。
It drills deep, 4D holes in a stable manner, work that is ordinarity difficult to achieve with a double-flute, single-edge indexable type.

■加工径最大偏移量
Max Offset Amount of Effective Dia.



带内冷油孔 with Coolant Hole

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7803311	**P4D1200FS20M03**	12	111	48	20	50	0.4	12.8	①	●
7803312	**P4D1250FS20M03**	12.5	113	50				13.3		
7803313	**P4D1300FS20M03**	13	115	52			0.3	13.6		
7803314	**P4D1350FS20M03**	13.5	117	54			0.2	13.9		
7803315	**P4D1400FS20M03**	14	119	56				14.4		
7803316	**P4D1450FS20M03**	14.5	121	58			0.1	14.7		
7803317	**P4D1500FS20M04**	15	125	60			0.4	15.8	②	
7803318	**P4D1550FS20M04**	15.5	127	62			0.3	16.1		
7803319	**P4D1600FS20M04**	16	129	64				16.6		
7803320	**P4D1650FS20M04**	16.5	131	66				17.1		
7803321	**P4D1700FS20M05**	17	136	68			0.6	18.2	③	
7803322	**P4D1750FS20M05**	17.5	138	70			0.5	18.5		
7803390	**P4D1750FS25M05**		144		25	56				
7803323	**P4D1800FS25M05**	18	146	72				19.0		
7803324	**P4D1850FS25M05**	18.5	148	74			0.4	19.3		
7803325	**P4D1900FS25M06**	19	150	76			0.6	20.2	④	
7803326	**P4D1950FS25M06**	19.5	152	78			0.5	20.5		
7803327	**P4D2000FS25M06**	20	154	80			0.4	20.8		
7803328	**P4D2050FS25M06**	20.5	156	82				21.3		
7803329	**P4D2100FS25M07**	21	163	84			0.6	22.2	⑤	
7803330	**P4D2150FS25M07**	21.5	165	86				22.7		
7803331	**P4D2200FS25M07**	22	167	88			0.5	23.0		
7803332	**P4D2250FS25M07**	22.5	169	90				23.5		
7803333	**P4D2300FS25M07**	23	171	92			0.4	23.8		
7803391	**P4D2350FS25M07**	23.5	173	94			0.3	24.1		
7803334	**P4D2350FS32M07**		177		32	60				
7803392	**P4D2400FS25M07**	24	175	96	25	56		24.6		
7803335	**P4D2400FS32M07**		179		32	60				
7803393	**P4D2450FS25M07**	24.5	177	98	25	56	0.2	24.9		
7803336	**P4D2450FS32M07**		181		32	60				
7803394	**P4D2500FS25M08**	25	179	100	25	56	0.7	26.4	⑥	
7803337	**P4D2500FS32M08**		183		32	60				
7803395	**P4D2550FS25M08**	25.5	181	102	25	56	0.6	26.7		
7803338	**P4D2550FS32M08**		185		32	60				
7803339	**P4D2600FS32M08**	26	187	104			0.5	27.0		
7803340	**P4D2650FS32M08**	26.5	189	106				27.5		
7803341	**P4D2700FS32M08**	27	191	108			0.4	27.8		
7803342	**P4D2800FS32M08**	28	195	112			0.3	28.6		
7803343	**P4D2850FS32M08**	28.5	197	114			0.2	28.9		

1. 扳手请另购。

1. The wrenches are sold separately from the cutters.

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外径 DC 29～63 NEXT

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
P4D	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	◎	○	○			

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FROM 外径 DC 12～28.5

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7803344	**P4D2900FS32M09**	29	199	116	32	60	0.8	30.6	⑦	●
7803345	**P4D3000FS32M09**	30	203	120			0.7	31.4		
7803346	**P4D3100FS32M09**	31	207	124			0.6	32.2		
7803396	**P4D3100FS40M09**		217		40	70				
7803347	**P4D3200FS32M09**	32	211	128	32	60	0.5	33.0		
7803397	**P4D3200FS40M09**		221		40	70				
7803348	**P4D3300FS40M09**	33	225	132			0.4	33.8		
7803349	**P4D3350FS40M09**	33.5	227	134			0.2	33.9		
7803350	**P4D3400FS40M10**	34	229	136			1.1	36.2	⑧	
7803351	**P4D3500FS40M10**	35	233	140			0.8	36.6		
7803352	**P4D3600FS40M10**	36	237	144				37.6		
7803353	**P4D3700FS40M10**	37	241	148			0.6	38.2		
7803354	**P4D3800FS40M10**	38	245	152			0.3	38.6		
7803355	**P4D3900FS40M12**	39	256	156			1.0	41.0	⑨	
7803356	**P4D4000FS40M12**	40	260	160			0.9	41.8		
7803357	**P4D4100FS40M12**	41	264	164			0.8	42.6		
7803358	**P4D4200FS40M12**	42	268	168			0.6	43.2		
7803359	**P4D4300FS40M12**	43	272	172			0.5	44.0		
7803360	**P4D4400FS40M12**	44	276	176			0.3	44.6		
7803361	**P4D4500FS40M13**	45	280	180			0.9	46.8	⑩	
7803362	**P4D4600FS40M13**	46	284	184			0.8	47.6		
7803363	**P4D4700FS40M13**	47	288	188	40	70	0.7	48.4		
7803364	**P4D4800FS40M13**	48	292	192			0.5	49.0		
7803365	**P4D4900FS40M13**	49	296	196			0.3	49.6		
7803366	**P4D5000FS40M14**	50	300	200			1.1	52.2	⑪	
7803367	**P4D5100FS40M14**	51	304	204			1.0	53.0		
7803368	**P4D5200FS40M14**	52	308	208			0.8	53.6		
7803369	**P4D5300FS40M14**	53	312	212			0.7	54.4		
7803370	**P4D5400FS40M14**	54	316	216			0.6	55.2		
7803371	**P4D5500FS40M14**	55	320	220			0.4	55.8		
7803372	**P4D5600FS40M14**	56	324	224			0.1	56.2		
7803373	**P4D5700FS40M16**	57	328	228			1.1	59.2	⑫	
7803374	**P4D5800FS40M16**	58	332	232			1.0	60.0		
7803375	**P4D5900FS40M16**	59	336	236			0.9	60.8		
7803376	**P4D6000FS40M16**	60	340	240			0.8	61.6		
7803377	**P4D6100FS40M16**	61	344	244			0.6	62.2		
7803378	**P4D6200FS40M16**	62	348	248			0.4	62.8		
7803379	**P4D6300FS40M16**	63	352	252			0.2	63.4		

1. 扳手请另购。

1. The wrenches are sold separately from the cutters.

适用的刀片及零件请参照 P.237~238 页。See p.237～238 for applicable inserts and accessories.

●=标准库存品 ●=Standard stock item

G-LIST No. | FL1076

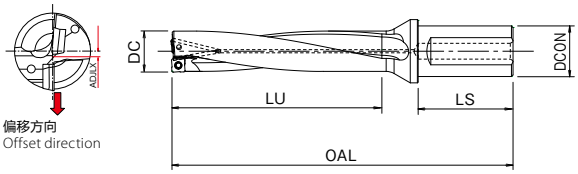
可转位式钻头 5D 型
INDEXABLE DRILL 5D TYPE

P5D

切削条件 Cutting Conditions | P.413

可进行对于可转位式刀具相当困难的5D 深孔的稳定加工。
It drills deep, 5D holes in a stable manner, work that is ordinarity difficult to achieve with a double-flute, single-edge indexable type.

■加工径最大偏移量
Max Offset Amount of Effective Dia.



带内冷油孔 with Coolant Hole

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7802780	**P5D1200FS20M03**	12	123	60	20	50	0.4	12.8	①	●
7802781	**P5D1250FS20M03**	12.5	125.5	62.5				13.3		
7802782	**P5D1300FS20M03**	13	128	65			0.3	13.6		
7802783	**P5D1350FS20M03**	13.5	130.5	67.5			0.2	13.9		
7802784	**P5D1400FS20M03**	14	133	70				14.4		
7802785	**P5D1450FS20M03**	14.5	135.5	72.5			0.1	14.7		
7802717	**P5D1500FS20M04**	15	140	75			0.4	15.8	②	
7802718	**P5D1550FS20M04**	15.5	143	78			0.3	16.1		
7802719	**P5D1600FS20M04**	16	145	80				16.6		
7802720	**P5D1650FS20M04**	16.5	148	83				17.1		
7802721	**P5D1700FS20M05**	17	153	85			0.6	18.2	③	
7802722	**P5D1750FS20M05**	17.5	156	88			0.5	18.5		
7802790	**P5D1750FS25M05**		162		25	56				
7802723	**P5D1800FS25M05**	18	164	90				19.0		
7802724	**P5D1850FS25M05**	18.5	167	93			0.4	19.3		
7802725	**P5D1900FS25M06**	19	169	95			0.6	20.2	④	
7802726	**P5D1950FS25M06**	19.5	172	98			0.5	20.5		
7802727	**P5D2000FS25M06**	20	174	100			0.4	20.8		
7802728	**P5D2050FS25M06**	20.5	177	103				21.3		
7802729	**P5D2100FS25M07**	21	184	105			0.6	22.2	⑤	
7802730	**P5D2150FS25M07**	21.5	187	108				22.7		
7802731	**P5D2200FS25M07**	22	189	110			0.5	23.0		
7802732	**P5D2250FS25M07**	22.5	192	113				23.5		
7802733	**P5D2300FS25M07**	23	194	115			0.4	23.8		
7802791	**P5D2350FS25M07**	23.5	197	118			0.3	24.1		
7802734	**P5D2350FS32M07**		201		32	60				
7802792	**P5D2400FS25M07**	24	199	120	25	56		24.6		
7802735	**P5D2400FS32M07**		203		32	60				
7802793	**P5D2450FS25M07**	24.5	202	123	25	56	0.2	24.9		
7802736	**P5D2450FS32M07**		206		32	60				
7802794	**P5D2500FS25M08**	25	204	125	25	56	0.7	26.4	⑥	
7802737	**P5D2500FS32M08**		208		32	60				
7802795	**P5D2550FS25M08**	25.5	207	128	25	56	0.6	26.7		
7802738	**P5D2550FS32M08**		211		32	60				
7802739	**P5D2600FS32M08**	26	213	130			0.5	27.0		
7802740	**P5D2650FS32M08**	26.5	216	133				27.5		
7802741	**P5D2700FS32M08**	27	218	135			0.4	27.8		
7802742	**P5D2800FS32M08**	28	223	140			0.3	28.6		
7802743	**P5D2850FS32M08**	28.5	226	143			0.2	28.9		

1. 扳手请另购。

1. The wrenches are sold separately from the cutters.

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外径 DC 29～63 NEXT

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
P5D	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	◎	○	○			

上一页
FROM 外径 DC 12～28.5

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	最大偏移量 ADJLX	最大加工径 DCX	适用刀片 Applicable Inserts	库存 Stock
7802744	**P5D2900FS32M09**	29	228	145	32	60	0.8	30.6	⑦	●
7802745	**P5D3000FS32M09**	30	233	150			0.7	31.4		
7802746	**P5D3100FS32M09**	31	238	155			0.6	32.2		
7802796	**P5D3100FS40M09**		248		40	70				
7802747	**P5D3200FS32M09**	32	243	160	32	60	0.5	33.0		
7802797	**P5D3200FS40M09**		253		40	70				
7802748	**P5D3300FS40M09**	33	258	165			0.4	33.8		
7802749	**P5D3350FS40M09**	33.5	261	168			0.2	33.9		
7802750	**P5D3400FS40M10**	34	263	170			1.1	36.2	⑧	
7802751	**P5D3500FS40M10**	35	268	175			0.8	36.6		
7802752	**P5D3600FS40M10**	36	273	180				37.6		
7802753	**P5D3700FS40M10**	37	278	185			0.6	38.2		
7802754	**P5D3800FS40M10**	38	283	190			0.3	38.6		
7802755	**P5D3900FS40M12**	39	295	195			1.0	41.0	⑨	
7802756	**P5D4000FS40M12**	40	300	200			0.9	41.8		
7802757	**P5D4100FS40M12**	41	305	205			0.8	42.6		
7802758	**P5D4200FS40M12**	42	310	210			0.6	43.2		
7802759	**P5D4300FS40M12**	43	315	215			0.5	44.0		
7802760	**P5D4400FS40M12**	44	320	220			0.3	44.6		
7802761	**P5D4500FS40M13**	45	325	225			0.9	46.8	⑩	
7802762	**P5D4600FS40M13**	46	330	230			0.8	47.6		
7802763	**P5D4700FS40M13**	47	335	235			0.7	48.4		
7802764	**P5D4800FS40M13**	48	340	240			0.5	49.0		
7802765	**P5D4900FS40M13**	49	345	245			0.3	49.6		
7802766	**P5D5000FS40M14**	50	350	250			1.1	52.2	⑪	
7802767	**P5D5100FS40M14**	51	355	255			1.0	53.0		
7802768	**P5D5200FS40M14**	52	360	260			0.8	53.6		
7802769	**P5D5300FS40M14**	53	365	265			0.7	54.4		
7802770	**P5D5400FS40M14**	54	370	270			0.6	55.2		
7802771	**P5D5500FS40M14**	55	375	275			0.4	55.8		
7802772	**P5D5600FS40M14**	56	380	280			0.1	56.2		
7802773	**P5D5700FS40M16**	57	385	285			1.1	59.2	⑫	
7802774	**P5D5800FS40M16**	58	390	290			1.0	60.0		
7802775	**P5D5900FS40M16**	59	395	295			0.9	60.8		
7802776	**P5D6000FS40M16**	60	400	300			0.8	61.6		
7802777	**P5D6100FS40M16**	61	405	305			0.6	62.2		
7802778	**P5D6200FS40M16**	62	410	310			0.4	62.8		
7802779	**P5D6300FS40M16**	63	415	315			0.2	63.4		

1. 扳手请另购。

1. The wrenches are sold separately from the cutters.

适用的刀片及零件请参照 P.237~238 页。See p.237～238 for applicable inserts and accessories.

●=标准库存品 ●=Standard stock item

■P2D/P3D/P4D/P5D适用刀片 Available Inserts

式样 Specification		名称 Designation	切削刃数 Number of Cutting Edge	适用刀体 Applicable Body	刀片尺寸 Insert Size				硬质合金 Uncoated	涂层种类 Grade of Coated Materials	
					L(×W1)	厚度 S	后角 AN	RE	CK110	XP9020	XP1010
钢用 不锈钢 for Steel & Stainless Steel	①	XCMT031904ER-DM	2	φ12～14.5	6.1 × 4.5	1.9	8°	0.4		7823098	
	②	XCMT042204ER-DM	4	φ15～16.5	5.0	2.2	8°	0.4		7823064	
	③	XCMT052404ER-DM	4	φ17～18.5	5.83	2.4	8°	0.4		7823065	
	④	XCMT062706ER-DM	4	φ19～20.5	6.46	2.7	8°	0.6		7823066	
	⑤	XCMT073106ER-DM	4	φ21～24.5	7.11	3.1	8°	0.6		7823067	
	⑥	XCMT083508ER-DM	4	φ25～28.5	8.36	3.5	8°	0.8		7823068	
	⑦	XCMT094008ER-DM	4	φ29～33.5	9.62	4.0	8°	0.8		7823069	
	⑧	XCMT104608ER-DM	4	φ34～38	10.89	4.6	8°	0.8		7823097	
	⑨	XCMT125010ER-DM	4	φ39～44	12.57	5.0	8°	1.0		7823071	
	⑩	XCMT135212ER-DM	4	φ45～49	14.05	5.2	8°	1.2		7823072	
	⑪	XCMT145612ER-DM	4	φ50～56	15.58	5.6	8°	1.2		7823073	
	⑫	XCMT165912ER-DM	4	φ57～63	17.28	5.9	8°	1.2		7823075	
铸铁 for Cast Iron	①	XCMT031904ER-DR	2	φ12～14.5	6.1 × 4.5	1.9	8°	0.4			7823163
	②	XCMT042204ER-DR	4	φ15～16.5	5.0	2.2	8°	0.4			7823164
	③	XCMT052404ER-DR	4	φ17～18.5	5.83	2.4	8°	0.4			7823165
	④	XCMT062706ER-DR	4	φ19～20.5	6.46	2.7	8°	0.6			7823166
	⑤	XCMT073106ER-DR	4	φ21～24.5	7.11	3.1	8°	0.6			7823167
	⑥	XCMT083508ER-DR	4	φ25～28.5	8.36	3.5	8°	0.8			7823168
	⑦	XCMT094008ER-DR	4	φ29～33.5	9.62	4.0	8°	0.8			7823169
	⑧	XCMT104608ER-DR	4	φ34～38	10.89	4.6	8°	0.8			7823197
	⑨	XCMT125010ER-DR	4	φ39～44	12.57	5.0	8°	1.0			7823171
	⑩	XCMT135212ER-DR	4	φ45～49	14.05	5.2	8°	1.2			7823172
	⑪	XCMT145612ER-DR	4	φ50～56	15.58	5.6	8°	1.2			7823173
	⑫	XCMT165912ER-DR	4	φ57～63	17.28	5.9	8°	1.2			7823175
铝 非铁金属 for Alluminum(alloy) and Nonferrous Metal	①	XCMT031904ER-DN	2	φ12～14.5	6.1 × 4.5	1.9	8°	0.4	7823263		
	②	XCMT042204ER-DN	4	φ15～16.5	5.0	2.2	8°	0.4	7823264		
	③	XCMT052404ER-DN	4	φ17～18.5	5.83	2.4	8°	0.4	7823265		
	④	XCMT062706ER-DN	4	φ19～20.5	6.46	2.7	8°	0.6	7823266		
	⑤	XCMT073106ER-DN	4	φ21～24.5	7.11	3.1	8°	0.6	7823267		
	⑥	XCMT083508ER-DN	4	φ25～28.5	8.36	3.5	8°	0.8	7823268		
	⑦	XCMT094008ER-DN	4	φ29～33.5	9.62	4.0	8°	0.8	7823269		
	⑧	XCMT104608ER-DN	4	φ34～38	10.89	4.6	8°	0.8	7823297		
	⑨	XCMT125010ER-DN	4	φ39～44	12.57	5.0	8°	1.0	7823271		
	⑩	XCMT135212ER-DN	4	φ45～49	14.05	5.2	8°	1.2	7823272		
	⑪	XCMT145612ER-DN	4	φ50～56	15.58	5.6	8°	1.2	7823273		
	⑫	XCMT165912ER-DN	4	φ57～63	17.28	5.9	8°	1.2	7823275		

库存分类全部为●(标准库存品)。
Stock are categorized in section ● (Standard stock item).

●=标准库存品 ●=Standard stock item

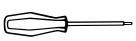
外壳上贴有专用标签。
Indicating label

■P2D/P3D/P4D/P5D外周刃专用刀片 Inserts for Peripheral Cutting Edge

式样 Specification		名称 Designation	切削刃数 Number of Cutting Edge	适用刀体 Applicable Body	刀片尺寸 Insert Size				涂层种类 Grade of Coated Materials
					L(×W1)	厚度 S	后角 AN	RE	XC9015
钢 铸铁 for Steel & Cast Iron	①	XCMT031904ER-DM	2	φ12～14.5	6.1 × 4.5	1.9	8°	0.4	7829098
	②	XCMT042204ER-DM	4	φ15～16.5	5.0	2.2	8°	0.4	7829064
	③	XCMT052404ER-DM	4	φ17～18.5	5.83	2.4	8°	0.4	7829065
	④	XCMT062706ER-DM	4	φ19～20.5	6.46	2.7	8°	0.6	7829066
	⑤	XCMT073106ER-DM	4	φ21～24.5	7.11	3.1	8°	0.6	7829067
	⑥	XCMT083508ER-DM	4	φ25～28.5	8.36	3.5	8°	0.8	7829068
	⑦	XCMT094008ER-DM	4	φ29～33.5	9.62	4.0	8°	0.8	7829069
	⑧	XCMT104608ER-DM	4	φ34～38	10.89	4.6	8°	0.8	7829097
	⑨	XCMT125010ER-DM	4	φ39～44	12.57	5.0	8°	1.0	7829071
	⑩	XCMT135212ER-DM	4	φ45～49	14.05	5.2	8°	1.2	7829072
	⑪	XCMT145612ER-DM	4	φ50～56	15.58	5.6	8°	1.2	7829073
	⑫	XCMT165912ER-DM	4	φ57～63	17.28	5.9	8°	1.2	7829075

库存分类全部为●(标准库存品)。
Stock are categorized in section ● (Standard stock item).

■零件 Accessories

	商品号 EDP No.	库存 Stock	名称 Designation	适用刀片 Applicable Inserts					
固定螺丝 Clamping Screw	7808096	●	FS18536P (Torx 6IP)	①	XCMT0319···	–	–	–	–
	7808139	●	FS20543P (Torx 6IP)	②	XCMT0422···	③	XCMT0524···	–	–
	7808138	●	FS22550P (Torx 7IP)	④	XCMT0627···	–	–	–	–
	7808136	●	FS25560P (Torx 8IP)	⑤	XCMT0731···	–	–	–	–
	7808135	●	FS30570P (Torx 9IP)	⑥	XCMT0835···	⑦	XCMT0940···	–	–
	7808137	●	FS35586P (Torx 15IP)	⑧	XCMT1046···	⑨	XCMT1250···	–	–
	7808114	●	FS45510P (Torx 20IP)	⑩	XCMT1352···	⑪	XCMT1456···	⑫	XCMT1659···
 扳手 Wrench	7808223	●	6IP-D (Torx 6IP)	①	XCMT0319···	②	XCMT0422···	③	XCMT0524···
	7808224	●	7IP-D (Torx 7IP)	④	XCMT0627···	–	–	–	–
	7808225	●	8IP-D (Torx 8IP)	⑤	XCMT0731···	–	–	–	–
	7808226	●	9IP-D (Torx 9IP)	⑥	XCMT0835···	⑦	XCMT0940···	–	–
	7808228	●	15IP-D (Torx 15IP)	⑧	XCMT1046···	⑨	XCMT1250···	–	–
	7808229	●	20IP-D (Torx 20IP)	⑩	XCMT1352···	⑪	XCMT1456···	⑫	XCMT1659···

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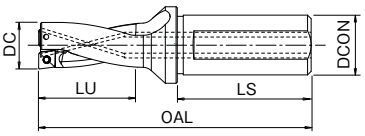
●=标准库存品 ●=Standard stock item

G-LIST No. | FL1097 NEW

可转位平头钻
INDEXABLE FLAT DRILL

PDZ

切削条件 Cutting Conditions | P.415



带内冷油孔 with Coolant Hole

2D型 2D Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	适用刀片 Applicable Inserts	库存 Stock
7803776	**PDZ1600FS20M05-2D**	16	97	32	20	50	①	●
7803777	**PDZ1650FS20M05-2D**	16.5	98	33				
7803778	**PDZ1700FS20M05-2D**	17	102	34				
7803779	**PDZ1750FS25M05-2D**	17.5	109	35	25	56		
7803780	**PDZ1800FS25M05-2D**	18	110	36				
7803781	**PDZ1850FS25M05-2D**	18.5	111	37				
7803782	**PDZ1900FS25M06-2D**	19	112	38			②	
7803783	**PDZ1950FS25M06-2D**	19.5	113	39				
7803784	**PDZ2000FS25M06-2D**	20	114	40				
7803785	**PDZ2100FS25M06-2D**	21	121	42				
7803786	**PDZ2200FS25M06-2D**	22	123	44				
7803787	**PDZ2300FS25M07-2D**	23	125	46			③	
7803788	**PDZ2400FS25M07-2D**	24	127	48				
7803789	**PDZ2500FS25M07-2D**	25	129	50				
7803790	**PDZ2500FS32M07-2D**		133		32	60		
7803791	**PDZ2600FS32M07-2D**	26	135	52				
7803792	**PDZ2700FS32M08-2D**	27	137	54			④	
7803793	**PDZ2800FS32M08-2D**	28	139	56				
7803794	**PDZ2900FS32M08-2D**	29	141	58				
7803795	**PDZ3000FS32M08-2D**	30	143	60				
7803796	**PDZ3100FS32M08-2D**	31	145	62				
7803797	**PDZ3200FS32M09-2D**	32	147	64			⑤	
7803798	**PDZ3300FS40M09-2D**	33	159	66	40	70		
7803799	**PDZ3400FS40M09-2D**	34	161	68				
7803800	**PDZ3500FS40M10-2D**	35	163	70			⑥	
7803801	**PDZ3600FS40M10-2D**	36	165	72				
7803802	**PDZ3700FS40M10-2D**	37	167	74				
7803803	**PDZ3800FS40M10-2D**	38	169	76				
7803804	**PDZ3900FS40M13-2D**	39	178	78			⑦	
7803805	**PDZ4000FS40M13-2D**	40	180	80				
7803806	**PDZ4100FS40M13-2D**	41	182	82				
7803807	**PDZ4200FS40M13-2D**	42	184	84				
7803808	**PDZ4300FS40M13-2D**	43	186	86				

蓝字 = 紧固螺栓沉孔对应尺寸

Items in blue = cap bolt counterbore compatible size

●=标准库存品 ●=Standard stock item

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
PDZ	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	○	○	○	○	○

3D型 3D Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	全长 OAL	有效加工深度 LU	柄径 DCON	柄长 LS	适用刀片 Applicable Inserts	库存 Stock
7803828	**PDZ1600FS20M05-3D**	16	113	48	20	50	①	●
7803829	**PDZ1650FS20M05-3D**	16.5	115	49.5				
7803830	**PDZ1700FS20M05-3D**	17	119	51				
7803831	**PDZ1750FS25M05-3D**	17.5	127	52.5	25	56		
7803832	**PDZ1800FS25M05-3D**	18	128	54				
7803833	**PDZ1850FS25M05-3D**	18.5	130	55.5				
7803834	**PDZ1900FS25M06-3D**	19	131	57			②	
7803835	**PDZ1950FS25M06-3D**	19.5	133	58.5				
7803836	**PDZ2000FS25M06-3D**	20	134	60				
7803837	**PDZ2100FS25M06-3D**	21	142	63				
7803838	**PDZ2200FS25M06-3D**	22	145	66				
7803839	**PDZ2300FS25M07-3D**	23	148	69			③	
7803840	**PDZ2400FS25M07-3D**	24	151	72				
7803841	**PDZ2500FS25M07-3D**	25	154	75				
7803842	**PDZ2500FS32M07-3D**		158		32	60		
7803843	**PDZ2600FS32M07-3D**	26	161	78				
7803844	**PDZ2700FS32M08-3D**	27	164	81			④	
7803845	**PDZ2800FS32M08-3D**	28	167	84				
7803846	**PDZ2900FS32M08-3D**	29	170	87				
7803847	**PDZ3000FS32M08-3D**	30	173	90				
7803848	**PDZ3100FS32M08-3D**	31	176	93				
7803849	**PDZ3200FS32M09-3D**	32	179	96			⑤	
7803850	**PDZ3300FS40M09-3D**	33	192	99	40	70		
7803851	**PDZ3400FS40M09-3D**	34	195	102				
7803852	**PDZ3500FS40M10-3D**	35	198	105			⑥	
7803853	**PDZ3600FS40M10-3D**	36	201	108				
7803854	**PDZ3700FS40M10-3D**	37	204	111				
7803855	**PDZ3800FS40M10-3D**	38	207	114				
7803856	**PDZ3900FS40M13-3D**	39	217	117			⑦	
7803857	**PDZ4000FS40M13-3D**	40	220	120				
7803858	**PDZ4100FS40M13-3D**	41	223	123				
7803859	**PDZ4200FS40M13-3D**	42	226	126				
7803860	**PDZ4300FS40M13-3D**	43	229	129				

蓝字 = 紧固螺栓沉孔对应尺寸

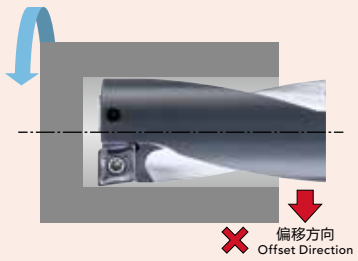
Items in blue = cap bolt counterbore compatible size

⚠从固体开始钻孔的注意事项 Precautions when drilling from solid

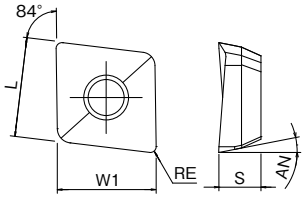
不推荐 off set 刀补程序设定加工。
由于PDZ的刀片排列方式，off set加工会导致中心刃刀片的崩刃。
Offset machining is not recommended.
Due to the insert arrangement of the PDZ, chipping will occur in the center insert when offset machining is performed.

对于需要调整的孔加工，请选择PD钻头*(参考p.229)。
Select the PD drill* for drilling that requires adjustment (refer to p.229).

＊PD钻头不会将孔底变平。
*PD drill does not make the bottom of the hole flat.



●=标准库存品 ●=Standard stock item



■适用刀片 Applicable Inserts

单位:mm Unit:mm

	名称 Designation	刀片尺寸 Insert Size				适用刀体 Applicable Body	涂层种类 Carbide Coated Materials
		L×W1	厚度 S	后角 AN	RE		XP8030
①	**ZPNT050204EN**	5.9 × 5.9	2.25	11°	0.4	φ16～18.5	7814102
②	**ZPNT060204EN**	6.95× 6.95	2.93	11°	0.4	φ19～22	7814103
③	**ZPNT070304EN**	7.84× 7.84	3.87	11°	0.4	φ23～26	7814104
④	**ZPNT080304EN**	8.85× 8.85	3.92	11°	0.4	φ27～31	7814105
⑤	**ZPNT090404EN**	9.94× 9.94	4.65	11°	0.4	φ32～34	7814106
⑥	**ZPNT100408EN**	10.95×10.95	4.65	11°	0.8	φ35～38	7814108
⑦	**ZPNT130508EN**	13.92×13.92	5.46	11°	0.8	φ39～43	7814110

库存分类全部为● (标准库存品)。
Stock are categorized in section ● (Standard stock item).

对于追求更高耐久性的加工，请选择外周刃专用刀片。
For machining that requires greater durability, select a designated insert for the peripheral cutting edge.

■PDZ外周刃专用刀片 Inserts for Peripheral Cutting Edge

※请不要将PDZ外周刃专用刀片安装到中心刃上。
* Do not attach inserts dedicated for the PDZ peripheral cutting edge to the center cutting edge.

单位:mm Unit:mm

	名称 Designation	刀片尺寸 Insert Size				适用刀体 Applicable Body	涂层种类 Carbide Coated Materials
		L×W1	厚度 S	后角 AN	RE		XC8035
①	**ZPNT050204EN**	5.9 × 5.9	2.25	11°	0.4	φ16～18.5	7815102
②	**ZPNT060204EN**	6.95× 6.95	2.93	11°	0.4	φ19～22	7815103
③	**ZPNT070304EN**	7.84× 7.84	3.87	11°	0.4	φ23～26	7815104
④	**ZPNT080304EN**	8.85× 8.85	3.92	11°	0.4	φ27～31	7815105
⑤	**ZPNT090404EN**	9.94× 9.94	4.65	11°	0.4	φ32～34	7815106
⑥	**ZPNT100408EN**	10.95×10.95	4.65	11°	0.8	φ35～38	7815108
⑦	**ZPNT130508EN**	13.92×13.92	5.46	11°	0.8	φ39～43	7815110

库存分类全部为● (标准库存品)。
Stock are categorized in section ● (Standard stock item).

⚠安装刀片时的注意事项 Precautions when installing the insert

・刀片(XP8030) 2个角作为外周刃、2个角作为中心刃，共计可使用4个角。
The insert (XP8030) has a total of 4 working corners – 2 corners for the peripheral cutting edge and 2 corners for the center cutting edge.

・请在外周刃使用外周刃用圆弧角，中心刃使用中心刃用圆弧角。
Use the peripheral cutting edge corner for the peripheral cutting edge and the center cutting edge corner for the center cutting edge.

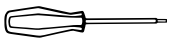
安装外周刃时
Attached with peripheral cutting edge

安装中心刃时
Attached with center cutting edge

●=标准库存品 ●=Standard stock item

■零件 Accessories

	商品号 EDP No.	库存 Stock	名称 Designation		适用刀片 Applicable Inserts	适用刀体 Applicable Body	推荐安装扭矩 Recommended Tightening Torque
固定螺丝 Clamping Screw	7808139	●	**FS20543P (Torx 6IP)**	①	ZPNT05…	PDZ φ16~18.5	0.7 N·m
	7808138	●	**FS22550P (Torx 7IP)**	②	ZPNT06…	PDZ φ19~22	1.0 N·m
	7808136	●	**FS25560P (Torx 8IP)**	③	ZPNT07…	PDZ φ23~26	1.6 N·m
	7808135	●	**FS30570P (Torx 9IP)**	④	ZPNT08…	PDZ φ27~34	2.2 N·m
				⑤	ZPNT09…		
	7808137	●	**FS35586P (Torx 15IP)**	⑥	ZPNT10…	PDZ φ35~38	3.2 N·m
	7808114	●	**FS45510P (Torx 20IP)**	⑦	ZPNT13…	PDZ φ39~43	5.0 N·m

	商品号 EDP No.	库存 Stock	名称 Designation		适用刀片 Applicable Inserts	适用刀体 Applicable Body
 扳手 Wrench	7808223	●	**6IP-D (Torx 6IP)**	①	ZPNT05…	PDZ φ16~18.5
	7808224	●	**7IP-D (Torx 7IP)**	②	ZPNT06…	PDZ φ19~22
	7808225	●	**8IP-D (Torx 8IP)**	③	ZPNT07…	PDZ φ23~26
	7808226	●	**9IP-D (Torx 9IP)**	④	ZPNT08…	PDZ φ27~34
				⑤	ZPNT09…	
	7808228	●	**15IP-D (Torx 15IP)**	⑥	ZPNT10…	PDZ φ35~38
	7808229	●	**20IP-D (Torx 20IP)**	⑦	ZPNT13…	PDZ φ39~43

扳手请另购。
The wrenchs are sold separately from the cutters.

●=标准库存品 ●=Standard stock item

G-LIST No. | **DW1002**

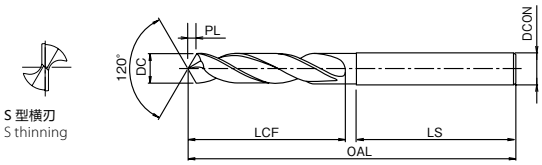
金刚石涂层硬质合金钻头
DIAMOND COATED CARBIDE

D-GDN

切削条件 Cutting Conditions | P.418

从普通铝合金到一般钻头难以取得良好效果的高硅铝合金，都可以发挥巨大威力。

Able to drill aluminum alloy and even with the high silicon aluminum alloy which is previously suffered a short tool life with carbide drills, this drill performs well.



CARBIDE | DIA | 0~-0.020 DC ≦ 6 | h8 6 < DC | 20° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8601020	**2**	18	54	3	32.1	0.6	●	6
8601023	**2.3**	20			30.7	0.7	●	6
8601025	**2.5**	22			29.1	0.7	●	6
8601030	**3**	25	59		32	0.9	●	7
8601033	**3.3**	27		4	28.7	1	●	11
8601035	**3.5**	30	65		32.1	1	●	11

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8601040	**4**	33	65	4	30	1.2	●	12
8601042	**4.2**		73	5	36.5	1.2	●	18
8601045	**4.5**	36			34.1	1.3	●	21
8601050	**5**	39			32	1.4	●	22
8601055	**5.5**	43	83	6	37.1	1.6	●	27
8601060	**6**				38	1.7	●	29

下一页
直径 DC 6.5～12 NEXT

库存记号 Inventory symbols
- ●＝标准库存品 Standard stock item
- ○＝准标准库存品(请确认库存。) Limited standard stock item
- ▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
- △＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
D-GDN														○	◎	◎				◎	○

上一页
FROM 直径 DC 2～6

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8601065	**6.5**	47	87	7	38	1.9	●	40
8601068	**6.8**	50	90		38	2	●	42
8601070	**7**				38	2	●	43
8601075	**7.5**	52	92	8	38	2.2	●	52
8601080	**8**	56	96		38	2.3	●	57
8601085	**8.5**			9	38	2.5	●	70
8601090	**9**	61	101		38	2.6	●	76

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8601095	**9.5**	61	105	10	42	2.7	●	91
8601100	**10**	65	109		42	2.9	●	110
8601103	**10.3**			11	42	3	●	110
8601105	**10.5**				42	3	●	113
8601110	**11**	71	115		42	3.2	●	122
8601115	**11.5**		121	12	48	3.3	●	147
8601120	**12**	76	126		48	3.5	●	155

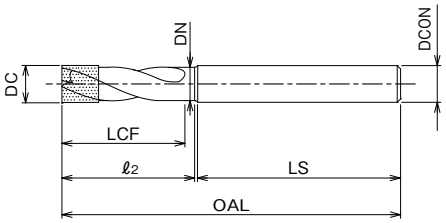
库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | **DP1000**

电镀金刚石钻头 陶瓷用
ELECTROPLATED DIAMOND DRILLS FOR CERAMICS

ED-DS

切削条件 Cutting Conditions | P.417



单位:mm Unit:mm

商品号 EDP No.	直径 DC 英寸 inch	直径 DC 毫米 mm	槽长 LCF	全长 OAL	柄径 DCON 英寸 inch	柄径 DCON 毫米 mm	柄长 LS	ℓ2	颈径 DN	电镀长度 Length of electroplating	粒度 Grit Size	库存 Stock	重量 (g)
8599720	–	**2**	7	39	–	3	27.9	8.5	1.6	8.5	#100	●	–
8599725	–	**2.5**	9	41	–		28.8	10.5	2.1	10.5		●	–
8599730	–	**3**	11	43	–		29.7	12.5	2.6	12.5		●	–
8599735	–	**3.5**	15	47	–	4	28.5	16.5	3.1	10		●	–
8599740	–	**4**	17	49	–		29.7	18.5	3.6			●	–
8599745	–	**4.5**	19	63	–	6	35.8	21	4.1			●	–
8599750	–	**5**	21	65	–		37.2	23	4.6			●	–
8599755	–	**5.5**	23	67	–		38.7	25	5.1			●	–

陶瓷用钻头 ED-DS 的特点请参阅 P.1005。
Please see p.1005 for features of ED-DS.

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直径 DC 6～9.5 NEXT

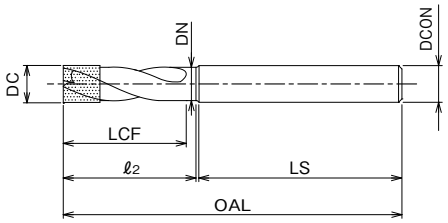
库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

电镀金刚石钻头 陶瓷用
ELECTROPLATED DIAMOND DRILLS FOR CERAMICS

ED-DS

切削条件 Cutting Conditions | P.417



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FROM 直径 DC 2～5.5

商品号 EDP No.	直径 DC 英寸 inch	直径 DC 毫米 mm	槽长 LCF	全长 OAL	柄径 DCON 英寸 inch	柄径 DCON 毫米 mm	柄长 LS	ℓ2	颈径 DN	电镀长度 Length of electroplating	粒度 Grit Size	库存 Stock	重量 (g)
8599760	–	**6**	25	69	–	6	41.6	27.4	5.6	10	#100	●	–
8599765	–	**6.5**	28	72	–	8	35.9	30	6.1			●	–
8599770	–	**7**			–		38		6.6			●	–
8599775	–	**7.5**	31	75	–		38.8	33	7.1			●	–
8599780	–	**8**	34	78	–		41.6	36.4	7.6			●	–
8599785	–	**8.5**		84	–	10	41.6	36	8.1			●	–
8599790	–	**9**	37	87	–		43.3	39	8.6			●	–
8599795	–	**9.5**			–		44.7		9.1			●	–

陶瓷用钻头 ED-DS 的特点请参阅 P.1005。
Please see p.1005 for features of ED-DS.

下一页
直径 DC 10～13 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

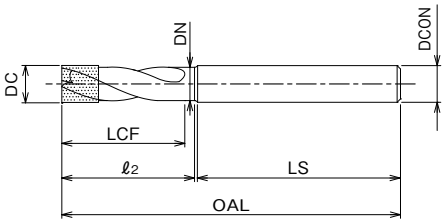
■标识说明请参考 P.1。 See p.1 for explanation of icons.

G-LIST No. | **DP1000**

电镀金刚石钻头 陶瓷用
ELECTROPLATED DIAMOND DRILLS FOR CERAMICS

ED-DS

切削条件 Cutting Conditions | P.417



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FROM 直径 DC 6～9.5

单位:mm Unit:mm

商品号 EDP No.	直径 DC 英寸 inch	直径 DC 毫米 mm	槽长 LCF	全长 OAL	柄径 DCON 英寸 inch	柄径 DCON 毫米 mm	柄长 LS	ℓ2	颈径 DN	电镀长度 Length of electroplating	粒度 Grit Size	库存 Stock	重量 (g)
8599800	–	**10**	40	90	–	10	47.6	42.4	9.6	10	#100	●	–
8599805	–	**10.5**		97	–	12	48.9	42	10.1			●	–
8599810	–	**11**			–		50.3		10.6			●	–
8599815	–	**11.5**	44	101	–		51.7	46	11.1			●	–
8599820	–	**12**			–		54.6	46.4	11.6			●	–
8599825	–	**12.5**	48	105	–		55	51	12.1			●	–
8599830	–	**13**			–		55		12.6			●	–

陶瓷用钻头 ED-DS 的特点请参阅 P.1005。
Please see p.1005 for features of ED-DS.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

CFRP用金刚石涂层硬质合金三角钻头
DIAMOND COATED CARBIDE TRIPLE ANGLE DRILL FOR COMPOSITE MATERIAL

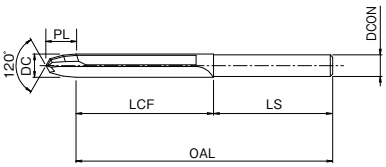
D-STAD

切削条件 Cutting Conditions | P.418

前角由三个角度组成，切削抵抗能够由半径方向进行分散，可以抑制CFRP 材加工时出入口两侧的分层现象。可加工出高品质的孔。

Three point angle spreads cutting resistance to radial direction which controls elimination at CFRP entrance and exit of the hole thus high hole quality.

N 型横刃
N thinning



CARBIDE | DIA | 0~-0.020 | 0° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	尺寸 Designation	直径 DC 英寸 inch	直径 DC 毫米 mm	槽长 LCF	全长 OAL	柄径 DCON 英寸 inch	柄径 DCON 毫米 mm	柄长 LS	先端 PL	库存 Stock	重量 (g)
8809078	#40	.0985	2.502	15	65	.0985	2.502	50	4.2	●	8
8809079	#30	.1290	3.277	20	70	.1290	3.277	50	5.5	●	14
8809080	#20	.1615	4.102	25	75	.1615	4.102	50	6.9	●	19
8809081	.1915	.1915	4.864	39	89	.1915	4.864	50	8.2	●	26
8809082	.2510	.2510	6.375	51	101	.2510	6.375	50	10.7	●	43
8809083	.3760	.3760	9.550	76	126	.3760	9.550	50	16.1	●	107

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
D-STAD																			◎		

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DW1105**

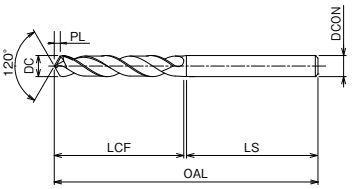
CFRP用金刚石涂层硬质合金双角钻头

DIAMOND COATED CARBIDE DOUBLE ANGLE DRILL FOR COMPOSITE MATERIAL

D-DAD

切削条件 Cutting Conditions | P.418

N 型横刃
N thinning



CARBIDE | DIA | 0~-0.020 | 40° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	尺寸 Designation	直径 DC 英寸 inch	直径 DC 毫米 mm	槽长 LCF	全长 OAL	柄径 DCON 英寸 inch	柄径 DCON 毫米 mm	柄长 LS	先端 PL	库存 Stock	重量 (g)
8809141	**#40**	**.0985**	**2.502**	15	50	.0985	2.502	35	1.7	●	5
8809142	**#30**	**.1290**	**3.277**	20	76	.1290	3.277	56	2.2	●	11
8809143	**#20**	**.1615**	**4.102**	25	80	.1615	4.102	55	2.2	●	16
8809144	**.1915**	**.1915**	**4.864**	29		.1915	4.864	51	2.6	●	20
8809145	**.2510**	**.2510**	**6.375**	38	94	.2510	6.375	56	3.5	●	41
8809146	**.3760**	**.3760**	**9.550**	57	115	.3760	9.550	58	5.2	●	97

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
D-DAD																			◎		

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

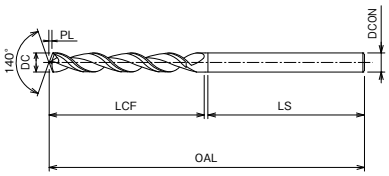
△=停产产品(请确认库存。)
Discontinued item

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

CFRP/金属叠板加工用钻头
HIGH HELIX DRILL FOR CFRP AND STACKS

STCH

R+W型横刃
R+W thinning



CARBIDE | FX | h8 | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	尺寸 Designation	直径 DC 英寸 inch	直径 DC 毫米 mm	槽长 LCF	全长 OAL	柄径 DCON 英寸 inch	柄径 DCON 毫米 mm	柄长 LS	先端 PL	库存 Stock	重量 (g)
8809111	**#11**	**.1915**	**4.864**	32	83	.1915	4.864	50	0.9	●	20
8809112	**1/4**	**.2510**	**6.375**	50	101	.2510	6.375	50	1.2	●	36

库存记号 Inventory symbols
- ●＝标准库存品 Standard stock item
- ○＝准标准库存品(请确认库存。) Limited standard stock item
- ▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
- △＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1106

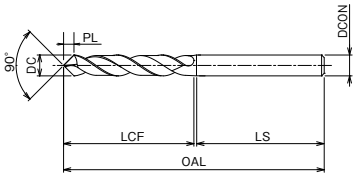
CFRP用金刚石涂层硬质合金中等刃长型 先端角90°

DIAMOND COATED 90 DEGREE POINT ANGLE DRILL FOR COMPOSITES

D-GDN90

切削条件 Cutting Conditions | P.418

N 型横刃
N thinning



CARBIDE | DIA | 0~-0.020 | 40° | SHRINK FIT

单位:mm Unit:mm

商品号 EDP No.	尺寸 Designation	直径 DC 英寸 inch	直径 DC 毫米 mm	槽长 LCF	全长 OAL	柄径 DCON 英寸 inch	柄径 DCON 毫米 mm	柄长 LS	先端 PL	库存 Stock	重量 (g)
8809151	#40	.0985	2.502	15	50	.0985	2.502	35	1.3	●	5
8809152	#30	.1290	3.277	20	76	.1290	3.277	56	1.6	●	11
8809153	#20	.1615	4.102	25	80	.1615	4.102	55	2.1	●	16
8809154	.1915	.1915	4.864	29		.1915	4.864	51	2.4	●	20
8809155	.2510	.2510	6.375	38	94	.2510	6.375	56	3.2	●	40
8809156	.3760	.3760	9.550	57	115	.3760	9.550	58	4.8	●	97

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
D-GDN90																			◎		

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

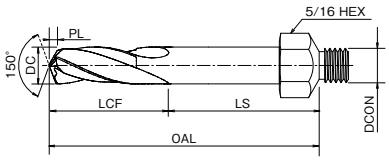
▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

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

耐热合金用手动钻头
STARTING HAND DRILL FOR HRSA

NEPTUNE



CARBIDE | TiAlN | h8

单位:mm Unit:mm

商品号 EDP No.	尺寸 Size	直径 DC		槽长 LCF		全长 OAL		柄径 DCON	柄长 LS	先端 PL	刃数 ZEFP	库存 Stock	重量 (g)
		英寸 inch	毫米 mm	英寸 inch	毫米 mm	英寸 inch	毫米 mm						
8809128	**#40**	**.0980**	**2.489**	.5	12.7	1.5	38.1	1/4-28UNF	25.4	0.3	3	●	12
8809129	**#30**	**.1285**	**3.264**						25.4	0.4		●	13
8809130	**#20**	**.1610**	**4.089**						25.4	0.6		●	15
8809131	**#11**	**.1910**	**4.851**						25.4	0.7		●	17

库存记号 Inventory symbols
- ● = 标准库存品 Standard stock item
- ○ = 准标准库存品(请确认库存。) Limited standard stock item
- ▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
- △ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DH1014

调质钢用粉末高速钢超短刃型钻头

POWDER HSS STUB FOR HARDENED STEEL

VPH-GDS

切削条件 Cutting Conditions | P.419

在40-50HRC 的调质钢加工中，能发挥高性价比。
Effective for high hardened steels (40 ~ 50 HRC).

XPM | V | or | WDI | h8 | SHANK h7 | 30°

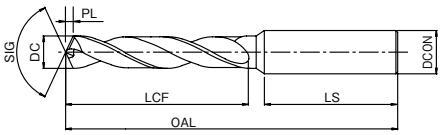
DC＜2 2≦DC＜6 *2 6≦DC≦13 | 2≦DC＜6 *1 13＜DC | 注1)

四棱式横刃 Four Facet point (DC≦1.5)

X 型横刃 X thinning (1.5＜DC＜4)

R 型横刃 R thinning (4≦DC)

DC≦13 : SIG=130°
13＜DC : SIG=120°



*1 适用于0.01mm 递增的尺寸
Applies to sizes in 0.01mm increment

*2 适用于0.1mm 递增的尺寸
Applies to sizes in 0.1mm increment

注1) 刃径公差都在0~-0.009mm。
All drill diameter have limits from 0 ~ -0.009mm.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599005	**0.5**	3	38	3	25.8	0.1	●	4
8608051	**0.51**				25.9	0.1	●	4
8608052	**0.52**				25.9	0.1	●	4
8608053	**0.53**				25.9	0.1	●	4
8608054	**0.54**	3.5			25.9	0.1	●	4
8608055	**0.55**				25.9	0.1	●	4
8608056	**0.56**				25.9	0.1	●	4
8608057	**0.57**				26	0.1	●	4
8608058	**0.58**				26	0.1	●	4
8608059	**0.59**				26	0.1	●	4
8599006	**0.6**				26	0.1	●	4
8608061	**0.61**	4			26	0.1	●	4
8608062	**0.62**				26.1	0.1	●	4
8608063	**0.63**				26.1	0.1	●	4
8608064	**0.64**				26.1	0.1	●	4
8608065	**0.65**				26.1	0.1	●	4
8608066	**0.66**				26.1	0.1	●	4
8608067	**0.67**				26.2	0.1	●	4
8608068	**0.68**	4.5			26.2	0.1	●	4
8608069	**0.69**				26.2	0.1	●	4
8599007	**0.7**				26.2	0.2	●	4
8608071	**0.71**				26.2	0.2	●	4
8608072	**0.72**				26.2	0.2	●	4
8608073	**0.73**				26.3	0.2	●	4
8608074	**0.74**				26.3	0.2	●	4
8608075	**0.75**				26.3	0.2	●	4
8608076	**0.76**	5			26.3	0.2	●	4
8608077	**0.77**				26.3	0.2	●	4
8608078	**0.78**				26.3	0.2	●	4
8608079	**0.79**				26.4	0.2	●	4
8599008	**0.8**				26.4	0.2	●	4
8608081	**0.81**				26.4	0.2	●	4
8608082	**0.82**	5.5	38	3	26.4	0.2	●	4
8608083	**0.83**				26.5	0.2	●	4
8608084	**0.84**				26.5	0.2	●	4
8608085	**0.85**				26.5	0.2	●	4
8608086	**0.86**				26.5	0.2	●	4
8608087	**0.87**				26.5	0.2	●	4
8608088	**0.88**				26.5	0.2	●	4
8608089	**0.89**				26.6	0.2	●	4
8599009	**0.9**				26.6	0.2	●	4
8608091	**0.91**				26.6	0.2	●	4
8608092	**0.92**				26.6	0.2	●	4
8608093	**0.93**				26.6	0.2	●	4
8608094	**0.94**				26.7	0.2	●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8608095	**0.95**	5.5	38	3	26.7	0.2	●	4
8608096	**0.96**	6			26.7	0.2	●	4
8608097	**0.97**				26.7	0.2	●	4
8608098	**0.98**				26.7	0.2	●	4
8608099	**0.99**				26.7	0.2	●	4
8599010	**1**				26.8	0.2	●	4
8608101	**1.01**				26.8	0.2	●	4
8608102	**1.02**				26.8	0.2	●	4
8608103	**1.03**				26.8	0.2	●	4
8608104	**1.04**				26.8	0.2	●	4
8608105	**1.05**				26.9	0.2	●	4
8608106	**1.06**				26.9	0.2	●	4
8608107	**1.07**	7	39		26.9	0.2	●	4
8608108	**1.08**				26.9	0.3	●	4
8608109	**1.09**				26.9	0.3	●	4
8599011	**1.1**				27	0.3	●	4
8608111	**1.11**				27	0.3	●	4
8608112	**1.12**				27	0.3	●	4
8608113	**1.13**				27	0.3	●	4
8608114	**1.14**				27	0.3	●	4
8608115	**1.15**				27	0.3	●	4
8608116	**1.16**				27.1	0.3	●	4
8608117	**1.17**				27.1	0.3	●	4
8608118	**1.18**				27.1	0.3	●	4
8608119	**1.19**	8	40		27.1	0.3	●	4
8599012	**1.2**				27.1	0.3	●	4
8608121	**1.21**				27.2	0.3	●	4
8608122	**1.22**				27.2	0.3	●	4
8608123	**1.23**				27.2	0.3	●	4
8608124	**1.24**				27.2	0.3	●	4
8608125	**1.25**				27.2	0.3	●	4
8608126	**1.26**				27.3	0.3	●	4
8608127	**1.27**				27.3	0.3	●	4
8608128	**1.28**				27.3	0.3	●	4
8608129	**1.29**				27.3	0.3	●	4
8599013	**1.3**				27.3	0.3	●	4
8608131	**1.31**				27.3	0.3	●	4
8608132	**1.32**				27.4	0.3	●	4
8608133	**1.33**	9	41		27.4	0.3	●	4
8608134	**1.34**				27.4	0.3	●	4
8608135	**1.35**				27.4	0.3	●	4
8608136	**1.36**				27.4	0.3	●	4
8608137	**1.37**				27.5	0.3	●	4
8608138	**1.38**				27.5	0.3	●	4
8608139	**1.39**				27.5	0.3	●	4

下一页
直径 DC 1.4～2.29 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VPH-GDS	○	◎	◎	◎	◎	◎	◎				◎	◎	◎				◎	◎			
※	○	◎	◎	◎	◎	○	○				◎	◎	◎				◎	○			

※孔深：3D～4D　Drilling depth：3D～4D

上一页
FROM 直径 DC 0.5～1.39

单位:mm　Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599014	**1.4**	9	41	3	27.5	0.3	●	4
8608141	**1.41**				27.5	0.3	●	4
8608142	**1.42**				27.6	0.3	●	4
8608143	**1.43**				27.6	0.3	●	4
8608144	**1.44**				27.6	0.3	●	4
8608145	**1.45**				27.6	0.3	●	4
8608146	**1.46**				27.6	0.3	●	4
8608147	**1.47**				27.6	0.3	●	4
8608148	**1.48**				27.7	0.3	●	4
8608149	**1.49**				27.7	0.3	●	4
8599015	**1.5**				27.7	0.3	●	4
8608151	**1.51**	10	42		27.7	0.4	●	4
8608152	**1.52**				27.7	0.4	●	4
8608153	**1.53**				27.8	0.4	●	4
8608154	**1.54**				27.8	0.4	●	4
8608155	**1.55**				27.8	0.4	●	4
8608156	**1.56**				27.8	0.4	●	4
8608157	**1.57**				27.8	0.4	●	4
8608158	**1.58**				27.9	0.4	●	4
8608159	**1.59**				27.9	0.4	●	4
8599016	**1.6**				27.9	0.4	●	4
8608161	**1.61**				27.9	0.4	●	4
8608162	**1.62**				27.9	0.4	●	4
8608163	**1.63**				27.9	0.4	●	4
8608164	**1.64**				28	0.4	●	4
8608165	**1.65**				28	0.4	●	4
8608166	**1.66**				28	0.4	●	4
8608167	**1.67**				28	0.4	●	4
8608168	**1.68**				28	0.4	●	4
8608169	**1.69**				28.1	0.4	●	4
8599017	**1.7**				28.1	0.4	●	4
8608171	**1.71**	11	43		28.1	0.4	●	5
8608172	**1.72**				28.1	0.4	●	5
8608173	**1.73**				28.1	0.4	●	5
8608174	**1.74**				28.1	0.4	●	5
8608175	**1.75**				28.2	0.4	●	5
8608176	**1.76**				28.2	0.4	●	5
8608177	**1.77**				28.2	0.4	●	5
8608178	**1.78**				28.2	0.4	●	5
8608179	**1.79**				28.2	0.4	●	5
8599018	**1.8**				28.3	0.4	●	4
8608181	**1.81**				28.3	0.4	●	5
8608182	**1.82**				28.3	0.4	●	5
8608183	**1.83**				28.3	0.4	●	5
8608184	**1.84**				28.4	0.4	●	5

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8608185	**1.85**	11	43	3	28.4	0.4	●	4
8608186	**1.86**				28.4	0.4	●	5
8608187	**1.87**				28.4	0.4	●	5
8608188	**1.88**				28.4	0.4	●	5
8608189	**1.89**				28.4	0.4	●	5
8599019	**1.9**				28.4	0.4	●	4
8608191	**1.91**	12	44		28.5	0.4	●	5
8608192	**1.92**				28.5	0.4	●	5
8608193	**1.93**				28.5	0.4	●	5
8608194	**1.94**				28.5	0.5	●	5
8608195	**1.95**				28.5	0.5	●	5
8608196	**1.96**				28.6	0.5	●	5
8608197	**1.97**				28.6	0.5	●	5
8608198	**1.98**				28.6	0.5	●	5
8608199	**1.99**				28.6	0.5	●	5
8599020	**2**				28.6	0.5	●	4
8608201	**2.01**				28.7	0.5	●	5
8608202	**2.02**				28.7	0.5	●	5
8608203	**2.03**				28.7	0.5	●	5
8608204	**2.04**				28.7	0.5	●	5
8608205	**2.05**				28.7	0.5	●	4
8608206	**2.06**				28.7	0.5	●	5
8608207	**2.07**				28.8	0.5	●	5
8608208	**2.08**				28.8	0.5	●	5
8608209	**2.09**				28.8	0.5	●	5
8599021	**2.1**				28.8	0.5	●	4
8608211	**2.11**				28.8	0.5	●	5
8608212	**2.12**				28.9	0.5	●	5
8608213	**2.13**	13	45		28.9	0.5	●	5
8608214	**2.14**				28.9	0.5	●	5
8608215	**2.15**				28.9	0.5	●	5
8608216	**2.16**				28.9	0.5	●	5
8608217	**2.17**				28.9	0.5	●	5
8608218	**2.18**				29	0.5	●	5
8608219	**2.19**				29	0.5	●	5
8599022	**2.2**				29	0.5	●	4
8608221	**2.21**				29	0.5	●	5
8608222	**2.22**				29	0.5	●	5
8608223	**2.23**				29.1	0.5	●	5
8608224	**2.24**				29.1	0.5	●	5
8608225	**2.25**				29.1	0.5	●	5
8608226	**2.26**				29.1	0.5	●	5
8608227	**2.27**				29.1	0.5	●	5
8608228	**2.28**				29.1	0.5	●	5
8608229	**2.29**				29.2	0.5	●	5

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直径 DC 2.3～3.19 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DH1014

调质钢用粉末高速钢超短刃型钻头

POWDER HSS STUB FOR HARDENED STEEL

VPH-GDS

切削条件 Cutting Conditions | P.419

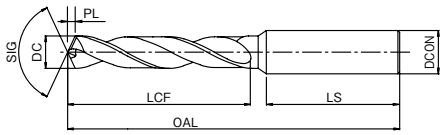
在40-50HRC 的调质钢加工中，能发挥高性价比。
Effective for high hardened steels (40 ~ 50 HRC).

四棱式横刃
Four Facet point
(DC≦1.5)

X 型横刃
X thinning
(1.5< DC<4)

R 型横刃
R thinning
(4≦ DC)

DC≦13 : SIG=130°
13< DC : SIG=120°



*1 适用于0.01mm 递增的尺寸
Applies to sizes in 0.01mm increment

*2 适用于0.1mm 递增的尺寸
Applies to sizes in 0.1mm increment

注1) 刃径公差都在0~-0.009mm。
All drill diameter have limits from 0 ~ -0.009mm.

上一页
FROM 直径 DC 1.4～2.29

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599023	**2.3**				29.2	0.5	●	4
8608231	**2.31**				29.2	0.5	●	5
8608232	**2.32**				29.2	0.5	●	5
8608233	**2.33**	13	45		29.2	0.5	●	5
8608234	**2.34**				29.3	0.5	●	5
8608235	**2.35**				29.3	0.5	●	5
8608236	**2.36**				29.3	0.6	●	5
8608237	**2.37**				29.3	0.6	●	5
8608238	**2.38**				29.3	0.6	●	5
8608239	**2.39**				29.4	0.6	●	5
8599024	**2.4**				29.4	0.6	●	4
8608241	**2.41**				29.4	0.6	●	5
8608242	**2.42**				29.4	0.6	●	5
8608243	**2.43**				29.4	0.6	●	5
8608244	**2.44**				29.5	0.6	●	4
8608245	**2.45**				29.5	0.6	●	4
8608246	**2.46**				29.5	0.6	●	5
8608247	**2.47**				29.5	0.6	●	5
8608248	**2.48**				29.5	0.6	●	5
8608249	**2.49**				29.5	0.6	●	5
8599025	**2.5**				29.6	0.6	●	4
8608251	**2.51**	14	46		29.6	0.6	●	5
8608252	**2.52**			3	29.6	0.6	●	5
8608253	**2.53**				29.6	0.6	●	5
8608254	**2.54**				29.6	0.6	●	5
8608255	**2.55**				29.7	0.6	●	4
8608256	**2.56**				29.7	0.6	●	5
8608257	**2.57**				29.7	0.6	●	5
8608258	**2.58**				29.7	0.6	●	5
8608259	**2.59**				29.7	0.6	●	5
8599026	**2.6**				29.8	0.6	●	4
8608261	**2.61**				29.8	0.6	●	5
8608262	**2.62**				29.8	0.6	●	5
8608263	**2.63**				29.8	0.6	●	5
8608264	**2.64**				29.8	0.6	●	5
8608265	**2.65**				29.8	0.6	●	5
8608266	**2.66**				29.9	0.6	●	5
8608267	**2.67**				29.9	0.6	●	5
8608268	**2.68**				29.9	0.6	●	5
8608269	**2.69**				29.9	0.6	●	5
8599027	**2.7**	16	48		29.9	0.6	●	4
8608271	**2.71**				30	0.6	●	5
8608272	**2.72**				30	0.6	●	5
8608273	**2.73**				30	0.6	●	5
8608274	**2.74**				30	0.6	●	5

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8608275	**2.75**				30	0.6	●	5
8608276	**2.76**				30.1	0.6	●	5
8608277	**2.77**				30.1	0.6	●	5
8608278	**2.78**				30.1	0.6	●	4
8608279	**2.79**				30.1	0.7	●	5
8599028	**2.8**				30.1	0.7	●	4
8608281	**2.81**				30.1	0.7	●	5
8608282	**2.82**				30.2	0.7	●	5
8608283	**2.83**				30.2	0.7	●	5
8608284	**2.84**				30.2	0.7	●	5
8608285	**2.85**				30.2	0.7	●	5
8608286	**2.86**				30.2	0.7	●	5
8608287	**2.87**				30.3	0.7	●	5
8608288	**2.88**	16	48	3	30.3	0.7	●	5
8608289	**2.89**				30.3	0.7	●	5
8599029	**2.9**				30.3	0.7	●	4
8608291	**2.91**				30.3	0.7	●	5
8608292	**2.92**				30.4	0.7	●	5
8608293	**2.93**				30.4	0.7	●	5
8608294	**2.94**				30.4	0.7	●	5
8608295	**2.95**				30.4	0.7	●	4
8608296	**2.96**				30.4	0.7	●	5
8608297	**2.97**				30.4	0.7	●	5
8608298	**2.98**				30.5	0.7	●	5
8608299	**2.99**				30.5	0.7	●	5
8599030	**3**				30.5	0.7	●	4
8608301	**3.01**				28.8	0.7	●	5
8608302	**3.02**				28.7	0.7	●	5
8608303	**3.03**				28.7	0.7	●	5
8608304	**3.04**				28.9	0.7	●	5
8608305	**3.05**				28.7	0.7	●	5
8608306	**3.06**				28.7	0.7	●	5
8608307	**3.07**				28.8	0.7	●	5
8608308	**3.08**				28.8	0.7	●	5
8608309	**3.09**				28.8	0.7	●	5
8599031	**3.1**	18	50	4	29	0.7	●	5
8608311	**3.11**				28.8	0.7	●	5
8608312	**3.12**				28.9	0.7	●	5
8608313	**3.13**				28.9	0.7	●	5
8608314	**3.14**				28.9	0.7	●	5
8608315	**3.15**				28.9	0.7	●	5
8608316	**3.16**				28.9	0.7	●	5
8608317	**3.17**				29.1	0.7	●	6
8608318	**3.18**				29	0.7	●	6
8608319	**3.19**				29	0.7	●	6

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直径 DC 3.2～4.09 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VPH-GDS	○	◎	◎	◎	◎	◎	◎				◎	◎	◎				◎	◎			
※	○	◎	◎	◎	◎	○	○				◎	◎	◎				◎	○			

※孔深：3D～4D　Drilling depth：3D～4D

上一页
FROM 直径 DC 2.3～3.19

单位:mm　Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599032	**3.2**	18	50	4	29.2	0.7	●	5
8608321	**3.21**				29	0.7	●	6
8608322	**3.22**				29	0.8	●	6
8608323	**3.23**				29.1	0.8	●	6
8608324	**3.24**				29.1	0.8	●	6
8608325	**3.25**				29.1	0.8	●	6
8608326	**3.26**				29.3	0.8	●	6
8608327	**3.27**				29.1	0.8	●	6
8608328	**3.28**				29.2	0.8	●	6
8608329	**3.29**				29.2	0.8	●	6
8599033	**3.3**				29.2	0.8	●	5
8608331	**3.31**				29.2	0.8	●	6
8608332	**3.32**				29.2	0.8	●	6
8608333	**3.33**				29.2	0.8	●	6
8608334	**3.34**				29.3	0.8	●	6
8608335	**3.35**				29.3	0.8	●	5
8608336	**3.36**	20	52		29.3	0.8	●	6
8608337	**3.37**				29.3	0.8	●	6
8608338	**3.38**				29.3	0.8	●	6
8608339	**3.39**				29.4	0.8	●	6
8599034	**3.4**				29.3	0.8	●	6
8608341	**3.41**				29.4	0.8	●	6
8608342	**3.42**				29.4	0.8	●	6
8608343	**3.43**				29.4	0.8	●	6
8608344	**3.44**				29.5	0.8	●	6
8608345	**3.45**				29.5	0.8	●	6
8608346	**3.46**				29.5	0.8	●	6
8608347	**3.47**				29.5	0.8	●	6
8608348	**3.48**				29.5	0.8	●	6
8608349	**3.49**				29.5	0.8	●	6
8599035	**3.5**				29.5	0.8	●	6
8608351	**3.51**				29.5	0.8	●	6
8608352	**3.52**				29.5	0.8	●	6
8608353	**3.53**				29.5	0.8	●	6
8608354	**3.54**				29.5	0.8	●	6
8608355	**3.55**				29.7	0.8	●	6
8608356	**3.56**				29.7	0.8	●	6
8608357	**3.57**				29.7	0.8	●	6
8608358	**3.58**				29.7	0.8	●	6
8608359	**3.59**				29.7	0.8	●	6
8599036	**3.6**				29.9	0.8	●	6
8608361	**3.61**				29.8	0.8	●	6
8608362	**3.62**				29.8	0.8	●	6
8608363	**3.63**				29.8	0.8	●	6
8608364	**3.64**				29.8	0.8	●	6

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8608365	**3.65**	20	52	4	29.8	0.9	●	6
8608366	**3.66**				29.9	0.9	●	6
8608367	**3.67**				29.9	0.9	●	6
8608368	**3.68**				29.9	0.9	●	6
8608369	**3.69**				29.9	0.9	●	6
8599037	**3.7**				29.9	0.9	●	6
8608371	**3.71**				30	0.9	●	6
8608372	**3.72**				30	0.9	●	6
8608373	**3.73**				30	0.9	●	6
8608374	**3.74**				30	0.9	●	6
8608375	**3.75**				30	0.9	●	6
8608376	**3.76**	22	54		30.1	0.9	●	6
8608377	**3.77**				30.1	0.9	●	6
8608378	**3.78**				30.1	0.9	●	6
8608379	**3.79**				30.1	0.9	●	6
8599038	**3.8**				30.3	0.9	●	6
8608381	**3.81**				30.1	0.9	●	6
8608382	**3.82**				30.2	0.9	●	6
8608383	**3.83**				30.2	0.9	●	6
8608384	**3.84**				30.2	0.9	●	6
8608385	**3.85**				30.2	0.9	●	6
8608386	**3.86**				30.2	0.9	●	6
8608387	**3.87**				30.3	0.9	●	6
8608388	**3.88**				30.3	0.9	●	6
8608389	**3.89**				30.3	0.9	●	6
8599039	**3.9**				30.3	0.9	●	6
8608391	**3.91**				30.5	0.9	●	6
8608392	**3.92**				30.5	0.9	●	6
8608393	**3.93**				30.5	0.9	●	6
8608394	**3.94**				30.5	0.9	●	6
8608395	**3.95**				30.5	0.9	●	6
8608396	**3.96**				30.5	0.9	●	6
8608397	**3.97**				30.5	0.9	●	6
8608398	**3.98**				30.5	0.9	●	6
8608399	**3.99**				30.5	0.9	●	6
8599040	**4**				30.5	0.9	●	6
8608401	**4.01**	22	66	6	35.9	0.9	●	12
8608402	**4.02**				35.9	0.9	●	12
8608403	**4.03**				35.9	0.9	●	13
8608404	**4.04**				35.9	0.9	●	12
8608405	**4.05**				35.9	0.9	●	13
8608406	**4.06**				36	0.9	●	12
8608407	**4.07**				36	0.9	●	12
8608408	**4.08**				36	1	●	12
8608409	**4.09**				36	1	●	12

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直径 DC 4.1～4.99 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DH1014

调质钢用粉末高速钢超短刃型钻头

POWDER HSS STUB FOR HARDENED STEEL

VPH-GDS

切削条件 Cutting Conditions | P.419

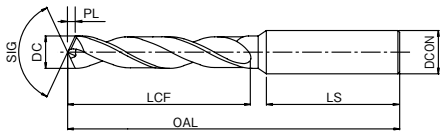
在40-50HRC 的调质钢加工中，能发挥高性价比。
Effective for high hardened steels (40 ~ 50 HRC).

四棱式横刃
Four Facet point
(DC≦1.5)

X 型横刃
X thinning
(1.5< DC<4)

R 型横刃
R thinning
(4≦ DC)

DC≦13 : SIG=130°
13< DC : SIG=120°



*1 适用于0.01mm 递增的尺寸
Applies to sizes in 0.01mm increment

*2 适用于0.1mm 递增的尺寸
Applies to sizes in 0.1mm increment

注1) 刃径公差都在0~-0.009mm。
All drill diameter have limits from 0 ~ -0.009mm.

上一页
FROM 直径 DC 3.2 ～4.09

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599041	4.1	22	66	6	36	1	●	12
8608411	4.11				36.1	1	●	12
8608412	4.12				36.1	1	●	12
8608413	4.13				36.1	1	●	12
8608414	4.14				36.1	1	●	12
8608415	4.15				36.1	1	●	12
8608416	4.16				36.1	1	●	12
8608417	4.17				36.1	1	●	12
8608418	4.18				36.2	1	●	12
8608419	4.19				36.2	1	●	12
8599042	4.2				36	1	●	12
8608421	4.21				36.2	1	●	12
8608422	4.22				36.2	1	●	12
8608423	4.23				36.2	1	●	12
8608424	4.24				36.3	1	●	12
8608425	4.25				36.3	1	●	12
8608426	4.26	24	68		36.3	1	●	12
8608427	4.27				36.3	1	●	13
8608428	4.28				36.3	1	●	13
8608429	4.29				36.3	1	●	13
8599043	4.3				36.8	1	●	13
8608431	4.31				36.4	1	●	13
8608432	4.32				37	1	●	13
8608433	4.33				37	1	●	13
8608434	4.34				37	1	●	13
8608435	4.35				37	1	●	13
8608436	4.36				37.1	1	●	13
8608437	4.37				37.1	1	●	13
8608438	4.38				37.1	1	●	13
8608439	4.39				37.1	1	●	13
8599044	4.4				37.1	1	●	13
8608441	4.41				37.1	1	●	13
8608442	4.42				37.2	1	●	13
8608443	4.43				37.2	1	●	13
8608444	4.44				37.2	1	●	13
8608445	4.45				37.2	1	●	13
8608446	4.46				37.2	1	●	13
8608447	4.47				37.2	1	●	13
8608448	4.48				37.3	1	●	13
8608449	4.49				37.3	1	●	13
8599045	4.5				37.1	1	●	13
8608451	4.51				37.3	1.1	●	13
8608452	4.52				37.3	1.1	●	13
8608453	4.53				37.3	1.1	●	13
8608454	4.54				37.4	1.1	●	13
8608455	4.55	24	68	6	37.4	1.1	●	13
8608456	4.56				37.4	1.1	●	13
8608457	4.57				37.4	1.1	●	13
8608458	4.58				37.4	1.1	●	13
8608459	4.59				37.4	1.1	●	13
8599046	4.6				37.5	1.1	●	14
8608461	4.61				37.5	1.1	●	13
8608462	4.62				37.5	1.1	●	14
8608463	4.63				37.5	1.1	●	13
8608464	4.64				37.5	1.1	●	13
8608465	4.65				37.5	1.1	●	14
8608466	4.66				37.6	1.1	●	16
8608467	4.67				37.6	1.1	●	16
8608468	4.68				37.6	1.1	●	16
8608469	4.69				37.6	1.1	●	16
8599047	4.7				37.6	1.1	●	14
8608471	4.71				37.6	1.1	●	16
8608472	4.72				37.7	1.1	●	16
8608473	4.73				37.7	1.1	●	16
8608474	4.74				37.7	1.1	●	16
8608475	4.75				37.7	1.1	●	16
8608476	4.76	26	70		37.7	1.1	●	14
8608477	4.77				37.7	1.1	●	16
8608478	4.78				37.8	1.1	●	16
8608479	4.79				37.8	1.1	●	16
8599048	4.8				37.8	1.1	●	14
8608481	4.81				37.8	1.1	●	16
8608482	4.82				37.8	1.1	●	16
8608483	4.83				37.9	1.1	●	16
8608484	4.84				37.9	1.1	●	16
8608485	4.85				37.9	1.1	●	14
8608486	4.86				37.9	1.1	●	16
8608487	4.87				37.9	1.1	●	16
8608488	4.88				38	1.1	●	16
8608489	4.89				38	1.1	●	16
8599049	4.9				38.6	1.1	●	14
8608491	4.91				38	1.1	●	16
8608492	4.92				38.6	1.1	●	16
8608493	4.93				38.6	1.1	●	16
8608494	4.94				38.6	1.2	●	17
8608495	4.95				38.6	1.2	●	17
8608496	4.96				38.6	1.2	●	17
8608497	4.97				38.7	1.2	●	17
8608498	4.98				38.6	1.2	●	17
8608499	4.99				38.7	1.2	●	17

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直径 DC 5 ～5.89 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VPH-GDS	○	◎	◎	◎	◎	◎	◎				◎	◎	◎				◎	◎			
※	○	◎	◎	◎	◎	○	○				◎	◎	◎				◎	○			

※孔深：3D～4D　Drilling depth：3D～4D

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FROM 直径 DC 4.1～4.99

单位:mm　Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599050	**5**	26	70	6	38.6	1.2	●	14
8608501	**5.01**				38.7	1.2	●	17
8608502	**5.02**				38.7	1.2	●	17
8608503	**5.03**				38.8	1.2	●	17
8608504	**5.04**				38.8	1.2	●	17
8608505	**5.05**				38.8	1.2	●	14
8608506	**5.06**				38.8	1.2	●	17
8608507	**5.07**				38.8	1.2	●	17
8608508	**5.08**				38.9	1.2	●	17
8608509	**5.09**				38.9	1.2	●	17
8599051	**5.1**				39	1.2	●	14
8608511	**5.11**				38.9	1.2	●	17
8608512	**5.12**				38.9	1.2	●	17
8608513	**5.13**				38.9	1.2	●	17
8608514	**5.14**				39	1.2	●	17
8608515	**5.15**				39	1.2	●	14
8608516	**5.16**				39	1.2	●	17
8608517	**5.17**				39	1.2	●	17
8608518	**5.18**				39	1.2	●	17
8608519	**5.19**				39.1	1.2	●	17
8599052	**5.2**				39.2	1.2	●	14
8608521	**5.21**				39.1	1.2	●	17
8608522	**5.22**				39.1	1.2	●	17
8608523	**5.23**				39.1	1.2	●	17
8608524	**5.24**				39.2	1.2	●	17
8608525	**5.25**				39.2	1.2	●	17
8608526	**5.26**				39.2	1.2	●	17
8608527	**5.27**				39.2	1.2	●	17
8608528	**5.28**				39.2	1.2	●	17
8608529	**5.29**				39.5	1.2	●	14
8599053	**5.3**				39.5	1.2	●	15
8608531	**5.31**	28	72		39.7	1.2	●	17
8608532	**5.32**				39.7	1.2	●	17
8608533	**5.33**				39.7	1.2	●	17
8608534	**5.34**				39.7	1.2	●	17
8608535	**5.35**				39.7	1.2	●	17
8608536	**5.36**				39.8	1.2	●	17
8608537	**5.37**				39.8	1.3	●	17
8608538	**5.38**				39.8	1.3	●	17
8608539	**5.39**				39.8	1.3	●	17
8599054	**5.4**				39.8	1.3	●	15
8608541	**5.41**				39.9	1.3	●	17
8608542	**5.42**				39.9	1.3	●	18
8608543	**5.43**				39.9	1.3	●	18
8608544	**5.44**				39.9	1.3	●	18

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8608545	**5.45**	28	72	6	39.9	1.3	●	18
8608546	**5.46**				39.9	1.3	●	18
8608547	**5.47**				39.8	1.3	●	18
8608548	**5.48**				40	1.3	●	18
8608549	**5.49**				40.1	1.3	●	18
8599055	**5.5**				39.9	1.3	●	15
8608551	**5.51**				40.1	1.3	●	18
8608552	**5.52**				40.1	1.3	●	18
8608553	**5.53**				40.2	1.3	●	18
8608554	**5.54**				40.2	1.3	●	18
8608555	**5.55**				40.2	1.3	●	18
8608556	**5.56**				40.2	1.3	●	18
8608557	**5.57**				40.3	1.3	●	18
8608558	**5.58**				40.3	1.3	●	18
8608559	**5.59**				40.3	1.3	●	18
8599056	**5.6**				41.6	1.3	●	15
8608561	**5.61**				41.6	1.3	●	18
8608562	**5.62**				41.6	1.3	●	18
8608563	**5.63**				41.6	1.3	●	18
8608564	**5.64**				41.6	1.3	●	18
8608565	**5.65**				41.6	1.3	●	18
8608566	**5.66**				41.6	1.3	●	18
8608567	**5.67**				41.6	1.3	●	18
8608568	**5.68**				41.6	1.3	●	18
8608569	**5.69**				41.5	1.3	●	18
8599057	**5.7**				41.7	1.3	●	15
8608571	**5.71**				41.7	1.3	●	18
8608572	**5.72**				41.7	1.3	●	18
8608573	**5.73**				41.7	1.3	●	18
8608574	**5.74**				41.7	1.3	●	18
8608575	**5.75**				41.7	1.3	●	18
8608576	**5.76**				41.7	1.3	●	18
8608577	**5.77**				41.7	1.3	●	18
8608578	**5.78**				41.8	1.3	●	18
8608579	**5.79**				41.8	1.3	●	18
8599058	**5.8**				41.6	1.4	●	15
8608581	**5.81**				41.8	1.4	●	18
8608582	**5.82**				41.8	1.4	●	18
8608583	**5.83**				41.8	1.4	●	18
8608584	**5.84**				41.9	1.4	●	18
8608585	**5.85**				41.9	1.4	●	18
8608586	**5.86**				41.9	1.4	●	18
8608587	**5.87**				42	1.4	●	18
8608588	**5.88**				42	1.4	●	18
8608589	**5.89**				42	1.4	●	18

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直径 DC 5.9～13.9 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | DH1014

调质钢用粉末高速钢超短刃型钻头

POWDER HSS STUB FOR HARDENED STEEL

VPH-GDS

切削条件 Cutting Conditions | P.419

在40-50HRC 的调质钢加工中，能发挥高性价比。
Effective for high hardened steels (40 ~ 50 HRC).

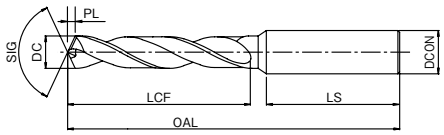
XPM | V (DC<2, 2≦DC<6 *1, 13<DC) or WDI (2≦DC<6 *2, 6≦DC≦13) | h8 注1) | SHANK h7 | 30°

四棱式横刃 Four Facet point (DC≦1.5)

X 型横刃 X thinning (1.5< DC<4)

R 型横刃 R thinning (4≦ DC)

DC≦13 : SIG=130°
13< DC : SIG=120°



*1 适用于0.01mm 递增的尺寸
Applies to sizes in 0.01mm increment

*2 适用于0.1mm 递增的尺寸
Applies to sizes in 0.1mm increment

注1) 刃径公差都在0~-0.009mm。
All drill diameter have limits from 0 ~ -0.009mm.

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FROM 直径 DC 5～5.89

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599059	**5.9**	28	72	6	41.7	1.4	●	15
8608591	**5.91**				42	1.4	●	18
8608592	**5.92**				42	1.4	●	18
8608593	**5.93**				42	1.4	●	18
8608594	**5.94**				42	1.4	●	18
8608595	**5.95**				42	1.4	●	18
8608596	**5.96**				42	1.4	●	18
8608597	**5.97**				42	1.4	●	18
8608598	**5.98**				42	1.4	●	18
8608599	**5.99**				42	1.4	●	18
8599060	**6**				42	1.4	●	16
8599061	**6.1**	31	75	8	36.1	1.4	●	23
8599062	**6.2**				36.2	1.4	●	23
8599063	**6.3**				36.3	1.5	●	24
8599064	**6.4**				37.2	1.5	●	24
8599065	**6.5**				37.2	1.5	●	24
8599066	**6.6**				37.4	1.5	●	24
8599067	**6.7**				37.7	1.6	●	25
8599068	**6.8**	34	78		37.7	1.6	●	25
8599069	**6.9**				38.6	1.6	●	25
8599070	**7**				38.6	1.6	●	25
8599071	**7.1**				38.9	1.7	●	26
8599072	**7.2**				39.1	1.7	●	26
8599073	**7.3**				39.6	1.7	●	27
8599074	**7.4**				39.8	1.7	●	27
8599075	**7.5**				41.5	1.7	●	27
8599076	**7.6**	37	81		41.6	1.8	●	27
8599077	**7.7**				41.6	1.8	●	27
8599078	**7.8**				41.6	1.8	●	28
8599079	**7.9**				41.7	1.8	●	29
8599080	**8**				42	1.9	●	29
8599081	**8.1**		87	10	42.1	1.9	●	46
8599082	**8.2**				42.2	1.9	●	47
8599083	**8.3**				43	1.9	●	48
8599084	**8.4**				43.2	2	●	49
8599085	**8.5**				43.1	2	●	50
8599086	**8.6**	40	90		43.5	2	●	50
8599087	**8.7**				43.7	2	●	50
8599088	**8.8**				43.8	2.1	●	51
8599089	**8.9**				44.6	2.1	●	51
8599090	**9**				44.6	2.1	●	51
8599091	**9.1**				44.9	2.1	●	52
8599092	**9.2**				45.1	2.1	●	52
8599093	**9.3**				45.6	2.2	●	53
8599094	**9.4**				45.8	2.2	●	53

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599095	**9.5**	40	90	10	47.5	2.2	●	53
8599096	**9.6**	43	93		48	2.2	●	53
8599097	**9.7**				48	2.3	●	55
8599098	**9.8**				47.6	2.3	●	55
8599099	**9.9**				47.7	2.3	●	56
8599100	**10**				48	2.3	●	54
8599101	**10.1**		100	12	49.1	2.4	●	75
8599102	**10.2**				49.3	2.4	●	76
8599103	**10.3**				49.2	2.4	●	76
8599104	**10.4**				50.2	2.4	●	77
8599105	**10.5**				50.2	2.4	●	77
8599106	**10.6**				50.5	2.5	●	78
8599107	**10.7**	47	104		50.7	2.5	●	80
8599108	**10.8**				50.9	2.5	●	80
8599109	**10.9**				51	2.5	●	80
8599110	**11**				51.6	2.6	●	81
8599111	**11.1**				52	2.6	●	81
8599112	**11.2**				52.2	2.6	●	82
8599113	**11.3**				52.4	2.6	●	82
8599114	**11.4**				52.8	2.7	●	83
8599115	**11.5**				55	2.7	●	83
8599116	**11.6**				54.6	2.7	●	84
8599117	**11.7**				54.7	2.7	●	84
8599118	**11.8**				54.6	2.8	●	85
8599119	**11.9**	51	108		54.7	2.8	●	87
8599120	**12**				55	2.8	●	87
8599121	**12.1**				55	2.8	●	88
8599122	**12.2**				55	2.8	●	88
8599123	**12.3**				55	2.9	●	89
8599124	**12.4**				55	2.9	●	90
8599125	**12.5**				55	2.9	●	90
8599126	**12.6**				55	2.9	●	90
8599127	**12.7**				55	3	●	91
8599128	**12.8**				55	3	●	89
8599129	**12.9**				55	3	●	92
8599130	**13**				55	3	●	93
8599131	**13.1**		111	16	48	3.8	●	138
8599132	**13.2**				48	3.8	●	144
8599133	**13.3**	54	114		48	3.8	●	145
8599134	**13.4**				48	3.9	●	146
8599135	**13.5**				48	3.9	●	143
8599136	**13.6**				48	3.9	●	147
8599137	**13.7**				48	4	●	144
8599138	**13.8**				48	4	●	148
8599139	**13.9**				48	4	●	145

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直径 DC 14～20 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VPH-GDS	○	◎	◎	◎	◎	◎	◎				◎	◎	◎				◎	◎			
※	○	◎	◎	◎	◎	○	○				◎	◎	◎				◎	○			

※孔深：3D～4D　Drilling depth：3D～4D

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FROM 直径 **DC** 5.9～13.9

单位:mm　Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599140	**14**	54	114		48	4	●	146
8599141	**14.1**				48	4.1	●	148
8599142	**14.2**				48	4.1	●	149
8599143	**14.3**				48	4.1	●	148
8599144	**14.4**				48	4.2	●	150
8599145	**14.5**	56	116		48	4.2	●	151
8599146	**14.6**				48	4.2	●	156
8599147	**14.7**				48	4.2	●	156
8599148	**14.8**				48	4.3	●	153
8599149	**14.9**				48	4.3	●	154
8599150	**15**			16	48	4.3	●	158
8599151	**15.1**				48	4.4	●	158
8599152	**15.2**				48	4.4	●	155
8599153	**15.3**				48	4.4	●	157
8599154	**15.4**				48	4.4	●	162
8599155	**15.5**	58	118		48	4.5	●	158
8599156	**15.6**				48	4.5	●	159
8599157	**15.7**				48	4.5	●	160
8599158	**15.8**				48	4.6	●	161
8599159	**15.9**				48	4.6	●	162
8599160	**16**				48	4.6	●	167
8599161	**16.1**				50	4.6	●	234
8599162	**16.2**				50	4.7	●	229
8599163	**16.3**				50	4.7	●	235
8599164	**16.4**				50	4.7	●	237
8599165	**16.5**	60	126	20	50	4.8	●	240
8599166	**16.6**				50	4.8	●	239
8599167	**16.7**				50	4.8	●	239
8599168	**16.8**				50	4.8	●	239
8599169	**16.9**				50	4.9	●	239
8599170	**17**				50	4.9	●	235

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8599171	**17.1**				50	4.9	●	238
8599172	**17.2**				50	5	●	240
8599173	**17.3**				50	5	●	247
8599174	**17.4**				50	5	●	249
8599175	**17.5**	62	128		50	5.1	●	249
8599176	**17.6**				50	5.1	●	250
8599177	**17.7**				50	5.1	●	252
8599178	**17.8**				50	5.1	●	252
8599179	**17.9**				50	5.2	●	254
8599180	**18**				50	5.2	●	256
8599181	**18.1**				50	5.2	●	256
8599182	**18.2**				50	5.3	●	259
8599183	**18.3**				50	5.3	●	259
8599184	**18.4**				50	5.3	●	262
8599185	**18.5**	64	130	20	50	5.3	●	262
8599186	**18.6**				50	5.4	●	257
8599187	**18.7**				50	5.4	●	257
8599188	**18.8**				50	5.4	●	266
8599189	**18.9**				50	5.5	●	259
8599190	**19**				50	5.5	●	269
8599191	**19.1**				50	5.5	●	262
8599192	**19.2**				50	5.5	●	264
8599193	**19.3**				50	5.6	●	272
8599194	**19.4**				50	5.6	●	272
8599195	**19.5**	66	132		50	5.6	●	274
8599196	**19.6**				50	5.7	●	268
8599197	**19.7**				50	5.7	●	268
8599198	**19.8**				50	5.7	●	271
8599199	**19.9**				50	5.7	●	280
8599200	**20**				50	5.8	●	280

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

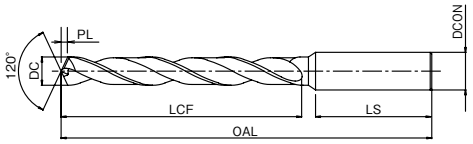
G-LIST No. | DH1009

超级含钴高速钢钻头标准刃长型
SUPER PREMIUM HSS REGULAR

VP-GDR

切削条件 Cutting Conditions | P.420

超级含钴高速钢+V 涂层，加工速度可接近于硬质合金钻头。
The super premium HSS regular and V coating allows for higher speed processing (Closed to carbide drills).



X 型横刃
X thinning
(DC<4)

R 型横刃
R thinning
(4≦DC)

SPH | V | h8 | SHANK h7 | 40°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593018	**1.8**	22	54	3	28.3	0.5	●	4
8616182	**1.82**				28.4	0.5	●	4
8593020	**2**	24	56		28.6	0.6	●	4
8593021	**2.1**				28.8	0.6	●	4
8593022	**2.2**	27	59		29	0.6	●	4
8593023	**2.3**				29.2	0.7	●	4
8593024	**2.4**	30	62		29.4	0.7	●	4
8593025	**2.5**				29.6	0.7	●	4
8593026	**2.6**				29.7	0.8	●	4
8593027	**2.7**	33	65		29.9	0.8	●	4
8616276	**2.76**				30.1	0.8	●	4
8616278	**2.78**				30.1	0.8	●	4
8593028	**2.8**				30.1	0.8	●	4
8593029	**2.9**				30.3	0.8	●	4
8593030	**3**				30.5	0.9	●	4
8593031	**3.1**	36	68	4	28.8	0.9	●	7
8593032	**3.2**				29.1	0.9	●	7
8593033	**3.3**				29.3	1	●	7
8593034	**3.4**	39	71		29.4	1	●	7
8593035	**3.5**				29.6	1	●	7
8593036	**3.6**				29.7	1	●	7
8616366	**3.66**				30.1	1.1	●	7
8616368	**3.68**				30.1	1.1	●	7
8593037	**3.7**				29.9	1.1	●	7
8593038	**3.8**	43	75		30.1	1.1	●	7
8593039	**3.9**				30.3	1.1	●	8
8593040	**4**				30.5	1.2	●	8
8593041	**4.1**		87	6	36.1	1.2	●	14
8593042	**4.2**				36.3	1.2	●	15
8593043	**4.3**	47	91		36.5	1.2	●	15
8593044	**4.4**				37.2	1.3	●	15
8593045	**4.5**				37.3	1.3	●	15
8593046	**4.6**				37.6	1.3	●	15
8616462	**4.62**				37.6	1.3	●	15
8593047	**4.7**				37.7	1.4	●	15
8593048	**4.8**	52	96		37.9	1.4	●	16
8593049	**4.9**				38.7	1.4	●	16
8593050	**5**				38.8	1.4	●	17
8593051	**5.1**				39	1.5	●	17

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593052	**5.2**	52	96	6	39.2	1.5	●	17
8593053	**5.3**				39.7	1.5	●	17
8593054	**5.4**	57	101		39.9	1.6	●	17
8593055	**5.5**				39.8	1.6	●	18
8616552	**5.52**				40.2	1.6	●	18
8616554	**5.54**				40.2	1.6	●	18
8593056	**5.6**				41.6	1.6	●	18
8593057	**5.7**				41.7	1.6	●	19
8593058	**5.8**				41.7	1.7	●	19
8593059	**5.9**				41.9	1.7	●	19
8593060	**6**				42	1.7	●	19
8593061	**6.1**	63	107	8	39.5	1.8	●	29
8593062	**6.2**				39.6	1.8	●	29
8593063	**6.3**				39.7	1.8	●	30
8593064	**6.4**				39.9	1.8	●	30
8593065	**6.5**				40.1	1.9	●	30
8593066	**6.6**				40.2	1.9	●	30
8593067	**6.7**				40.3	1.9	●	30
8593068	**6.8**	69	113		40.5	2	●	31
8593069	**6.9**				40.6	2	●	32
8593070	**7**				40.8	2	●	33
8593071	**7.1**				40.8	2	●	33
8593072	**7.2**				41	2.1	●	34
8593073	**7.3**				41.1	2.1	●	34
8616736	**7.36**				41.3	2.1	●	36
8616738	**7.38**				41.3	2.1	●	34
8593074	**7.4**				41.3	2.1	●	34
8593075	**7.5**				41.5	2.2	●	34
8616752	**7.52**	75	119		41.5	2.2	●	37
8616754	**7.54**				41.5	2.2	●	37
8593076	**7.6**				41.5	2.2	●	36
8593077	**7.7**				41.7	2.2	●	36
8593078	**7.8**				41.7	2.3	●	37
8593079	**7.9**				41.9	2.3	●	37
8593080	**8**				42	2.3	●	37
8593081	**8.1**		125	10	45.6	2.3	●	55
8593082	**8.2**				45.7	2.4	●	56
8593083	**8.3**				45.8	2.4	●	56
8593084	**8.4**				46	2.4	●	56

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直径 DC 8.5～24 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VP-GDR	○	◎	◎	◎	◎						◎	◎	○		○	◎	○			○	
※	○	◎	◎	◎	◎						◎	◎	○		○	○	○			○	

※5D＜：孔深　5D＜：Drilling depth

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FROM 直径 DC 1.8～8.4

单位:mm　Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593085	**8.5**	75	125		46.1	2.5	●	57
8593086	**8.6**				46.2	2.5	●	59
8593087	**8.7**				46.4	2.5	●	60
8593088	**8.8**				46.5	2.5	●	60
8593089	**8.9**				46.7	2.6	●	60
8593090	**9**				46.8	2.6	●	61
8593091	**9.1**				46.9	2.6	●	62
8593092	**9.2**	81	131		47.1	2.7	●	62
8616924	**9.24**				47.1	2.7	●	63
8616926	**9.26**				47.2	2.7	●	66
8593093	**9.3**				47.2	2.7	●	62
8616936	**9.36**			10	47.3	2.7	●	63
8616938	**9.38**				47.3	2.7	●	63
8593094	**9.4**				47.3	2.7	●	62
8593095	**9.5**				47.5	2.7	●	64
8616952	**9.52**				47.6	2.8	●	68
8616954	**9.54**				47.6	2.8	●	69
8593096	**9.6**				47.6	2.8	●	66
8593097	**9.7**		137		47.6	2.8	●	66
8593098	**9.8**				47.6	2.8	●	67
8593099	**9.9**				47.7	2.9	●	68
8593100	**10**	87			48	2.9	●	68
8593101	**10.1**				52.6	2.9	●	87
8593102	**10.2**				52.6	2.9	●	88
8593103	**10.3**		144		52.8	3	●	88
8593104	**10.4**				52.9	3	●	89
8593105	**10.5**				53.1	3	●	89
8593106	**10.6**				53.1	3.1	●	90
8593107	**10.7**				53.3	3.1	●	93
8593108	**10.8**				53.4	3.1	●	94
8593109	**10.9**			12	53.6	3.1	●	94
8593110	**11**				53.8	3.2	●	96
8593111	**11.1**				53.8	3.2	●	97
8593112	**11.2**	94	151		54.1	3.2	●	97
8617122	**11.22**				54.2	3.2	●	108
8617124	**11.24**				54.2	3.2	●	108
8593113	**11.3**				54.2	3.3	●	108
8617136	**11.36**				54.4	3.3	●	108
8617138	**11.38**				54.4	3.3	●	109

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593114	**11.4**				54.4	3.3	●	98
8593115	**11.5**	94	151		54.5	3.3	●	99
8593116	**11.6**				54.6	3.3	●	99
8593117	**11.7**				54.6	3.4	●	100
8593118	**11.8**				54.6	3.4	●	101
8593119	**11.9**				54.7	3.4	●	105
8593120	**12**				55	3.5	●	105
8593121	**12.1**				55	3.5	●	107
8593122	**12.2**			12	55	3.5	●	107
8593123	**12.3**				55	3.6	●	108
8593124	**12.4**	101	158		55	3.6	●	110
8593125	**12.5**				55	3.6	●	110
8593126	**12.6**				55	3.6	●	111
8593127	**12.7**				55	3.7	●	111
8593128	**12.8**				55	3.7	●	114
8593129	**12.9**				55	3.7	●	114
8593130	**13**				55	3.8	●	116
8593135	**13.5**	106	166		48	3.9	●	165
8593140	**14**				48	4	●	172
8593145	**14.5**	109	169	16	48	4.2	●	185
8593150	**15**				48	4.3	●	190
8593155	**15.5**	112	172		48	4.5	●	194
8593160	**16**				48	4.6	●	200
8593165	**16.5**	115	181		50	4.8	●	291
8593170	**17**				50	4.9	●	289
8593175	**17.5**	118	184		50	5.1	●	310
8593180	**18**			20	50	5.2	●	317
8593185	**18.5**	122	188		50	5.3	●	331
8593190	**19**				50	5.5	●	340
8593195	**19.5**	125	191		50	5.6	●	350
8593200	**20**				50	5.8	●	354
8593205	**20.5**	128	204		56	5.9	●	488
8593210	**21**				56	6.1	●	495
8593215	**21.5**	132	208		56	6.2	●	499
8593220	**22**			25	56	6.4	●	525
8593225	**22.5**				56	6.5	●	537
8593230	**23**	136	212		56	6.6	●	540
8593235	**23.5**				56	6.8	●	553
8593240	**24**	140	216		56	6.9	●	565

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直径 DC 24.5～32 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

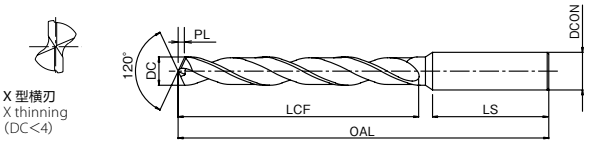
G-LIST No. | DH1009

超级含钴高速钢钻头标准刃长型
SUPER PREMIUM HSS REGULAR

VP-GDR

切削条件 Cutting Conditions | P.420

超级含钴高速钢+V涂层，加工速度可接近于硬质合金钻头。
The super premium HSS regular and V coating allows for higher speed processing (Closed to carbide drills).



X 型横刃
X thinning
(DC<4)

R 型横刃
R thinning
(4≦DC)

SPH | V | h8 | SHANK h7 | 40°

上一页

FROM 直径 DC 8.5～24

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593245	**24.5**	140	216	25	56	7.1	●	584
8593250	**25**				56	7.2	●	618
8593255	**25.5**	145	225	32	60	7.4	●	810
8593260	**26**				60	7.5	●	838
8593265	**26.5**				60	7.6	●	854
8593270	**27**	150	230		60	7.8	●	875

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593280	**28**	150	230	32	60	8.1	●	909
8593290	**29**	155	235		60	8.4	●	958
8593300	**30**				60	8.7	●	997
8593310	**31**	160	240		60	8.9	●	1,042
8593320	**32**	165	245		60	9.2	●	1,099

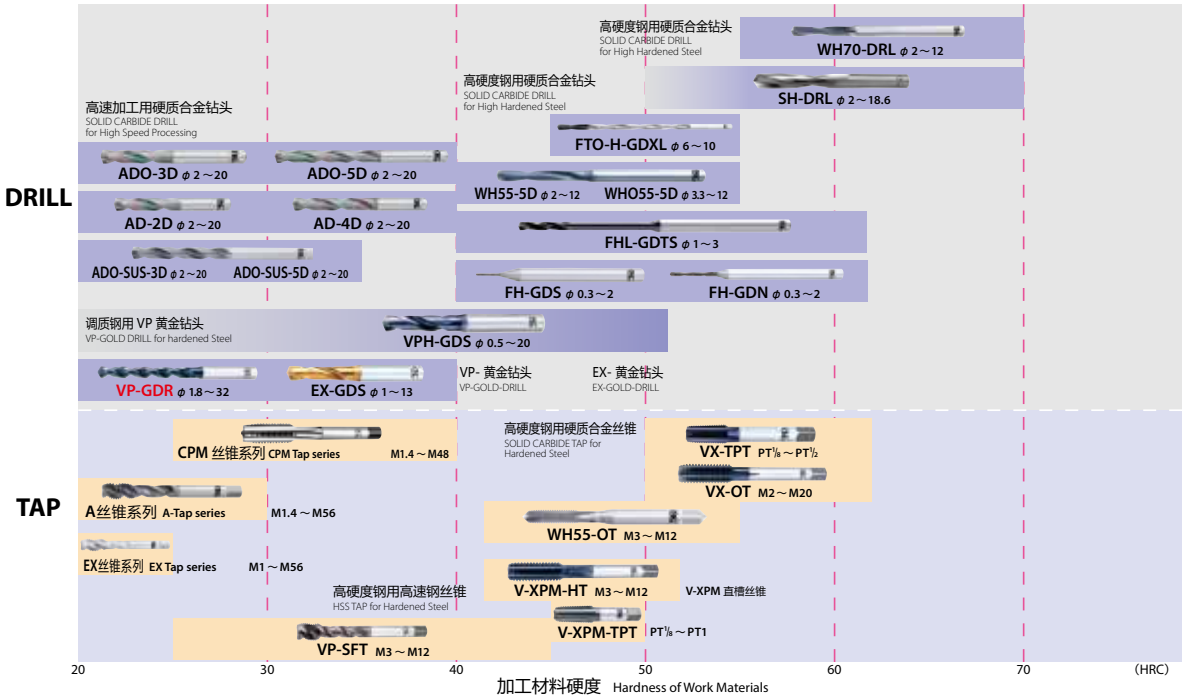
库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VP-GDR	○	◎	◎	◎	◎						◎	◎	○		○	◎	○			○	
※	○	◎	◎	◎	◎						◎	◎	○		○	○	○			○	

※5D＜：孔深　5D＜：Drilling depth

■孔加工工具选择指南　Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | DH1018

高速加工用粉末高速钢内冷油孔超短刃型钻头

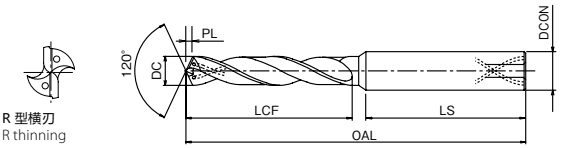
POWDER METALLURGY STUB FOR HIGH SPEED PROCESSING WITH INTERNAL COOLANT SUPPLY

VP-HO-GDS

切削条件 Cutting Conditions | P.422

内冷油孔 + 粉末高速钢 +V 涂层，使得加工速度高于硬质合金钻头。

Similar to the VP-GDR, but includes an internal coolant supply system. This drill's high-speed processing capability exceeds that of carbide drills.



CPM | V | h8 | SHANK h7 | 30°

※φ12以下为普通直柄。
※Drill dia. ≦ 12 : with plain straight shank
※φ12以上为带凹槽直柄。
※12 < Drill dia. : straight and flat shank

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594560	**6**	28	72	6	42	1.7	●	16
8594561	**6.1**	31	75		42	1.8	●	16
8594562	**6.2**				42	1.8	●	16
8594563	**6.3**				42	1.8	●	16
8594564	**6.4**				42	1.8	●	16
8594565	**6.5**				42	1.9	●	16
8594566	**6.6**			7	42	1.9	●	19
8594567	**6.7**				42	1.9	●	19
8594568	**6.8**	34	78		42	2	●	20
8594569	**6.9**				42	2	●	20
8594570	**7**				42	2	●	20
8594571	**7.1**			8	40.2	2	●	27
8594572	**7.2**				40.4	2.1	●	27
8594573	**7.3**				40.6	2.1	●	27
8594574	**7.4**				40.8	2.1	●	27
8594575	**7.5**				40.9	2.2	●	27
8594576	**7.6**	37	81		41.2	2.2	●	28
8594577	**7.7**				41.4	2.2	●	28
8594578	**7.8**				41.6	2.3	●	28
8594579	**7.9**				41.7	2.3	●	28
8594580	**8**				42	2.3	●	25
8594581	**8.1**		87	9	46.2	2.3	●	38
8594582	**8.2**				46.4	2.4	●	38
8594583	**8.3**				46.6	2.4	●	38
8594584	**8.4**				46.8	2.4	●	38
8594585	**8.5**				47	2.5	●	39
8594586	**8.6**	40	90		47.2	2.5	●	39
8594587	**8.7**				47.5	2.5	●	40
8594588	**8.8**				47.6	2.5	●	40
8594589	**8.9**				47.7	2.6	●	41

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594590	**9**	40	90	9	48	2.6	●	42
8594591	**9.1**			10	46.2	2.6	●	46
8594592	**9.2**				46.4	2.7	●	46
8594593	**9.3**				46.6	2.7	●	46
8594594	**9.4**				46.8	2.7	●	46
8594595	**9.5**				47	2.7	●	47
8594596	**9.6**	43	93		47.2	2.8	●	47
8594597	**9.7**				47.5	2.8	●	47
8594598	**9.8**				47.6	2.8	●	48
8594599	**9.9**				47.7	2.9	●	48
8594600	**10**				48	2.9	●	48
8594601	**10.1**		100	11	53.3	2.9	●	60
8594602	**10.2**				53.5	2.9	●	60
8594603	**10.3**				53.7	3	●	60
8594604	**10.4**				53.8	3	●	61
8594605	**10.5**				54	3	●	61
8594606	**10.6**				54.2	3.1	●	61
8594607	**10.7**	47	104		54.6	3.1	●	62
8594608	**10.8**				54.6	3.1	●	62
8594609	**10.9**				54.7	3.1	●	62
8594610	**11**				55	3.2	●	63
8594611	**11.1**			12	53.3	3.2	●	71
8594612	**11.2**				53.5	3.2	●	71
8594613	**11.3**				53.7	3.3	●	72
8594614	**11.4**				53.8	3.3	●	72
8594615	**11.5**				54	3.3	●	72
8594616	**11.6**				54.2	3.3	●	73
8594617	**11.7**				54.6	3.4	●	74
8594618	**11.8**				54.6	3.4	●	74
8594619	**11.9**	51	108		54.7	3.4	●	75

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直径 DC 12～17.9 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VP-HO-GDS	◎	◎	◎	◎	◎	○				◎	◎	◎	◎	○	○	◎	◎	○		○	

上一页
FROM 直径 DC 6～11.9

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594620	**12**	51	108	12	55	3.5	●	75
8594621	**12.1**		111	16	48	3.5	●	113
8594622	**12.2**				48	3.5	●	114
8594623	**12.3**				48	3.6	●	114
8594624	**12.4**				48	3.6	●	114
8594625	**12.5**				48	3.6	●	115
8594626	**12.6**				48	3.6	●	116
8594627	**12.7**				48	3.7	●	116
8594628	**12.8**				48	3.7	●	116
8594629	**12.9**				48	3.7	●	117
8594630	**13**				48	3.8	●	117
8594631	**13.1**				48	3.8	●	117
8594632	**13.2**				48	3.8	●	118
8594633	**13.3**	54	114		48	3.8	●	120
8594634	**13.4**				48	3.9	●	120
8594635	**13.5**				48	3.9	●	120
8594636	**13.6**				48	3.9	●	121
8594637	**13.7**				48	4	●	122
8594638	**13.8**				48	4	●	123
8594639	**13.9**				48	4	●	123
8594640	**14**				48	4	●	124
8594641	**14.1**	56	116		48	4.1	●	124
8594642	**14.2**				48	4.1	●	126
8594643	**14.3**				48	4.1	●	126
8594644	**14.4**				48	4.2	●	127
8594645	**14.5**				48	4.2	●	128
8594646	**14.6**				48	4.2	●	129
8594647	**14.7**				48	4.2	●	129
8594648	**14.8**				48	4.3	●	130
8594649	**14.9**				48	4.3	●	131

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594650	**15**	58	118	16	48	4.3	●	131
8594651	**15.1**				48	4.4	●	131
8594652	**15.2**				48	4.4	●	132
8594653	**15.3**				48	4.4	●	131
8594654	**15.4**				48	4.4	●	133
8594655	**15.5**				48	4.5	●	133
8594656	**15.6**				48	4.5	●	136
8594657	**15.7**				48	4.5	●	135
8594658	**15.8**				48	4.6	●	134
8594659	**15.9**				48	4.6	●	137
8594660	**16**				48	4.6	●	136
8594661	**16.1**	60	126	20	50	4.6	●	191
8594662	**16.2**				50	4.7	●	191
8594663	**16.3**				50	4.7	●	193
8594664	**16.4**				50	4.7	●	193
8594665	**16.5**				50	4.8	●	194
8594666	**16.6**				50	4.8	●	195
8594667	**16.7**				50	4.8	●	196
8594668	**16.8**				50	4.8	●	197
8594669	**16.9**				50	4.9	●	199
8594670	**17**				50	4.9	●	198
8594671	**17.1**	62	128		50	4.9	●	199
8594672	**17.2**				50	5	●	199
8594673	**17.3**				50	5	●	200
8594674	**17.4**				50	5	●	201
8594675	**17.5**				50	5.1	●	202
8594676	**17.6**				50	5.1	●	204
8594677	**17.7**				50	5.1	●	204
8594678	**17.8**				50	5.1	●	206
8594679	**17.9**				50	5.2	●	206

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直径 DC 18～26 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DH1018

高速加工用粉末高速钢内冷油孔超短刃型钻头

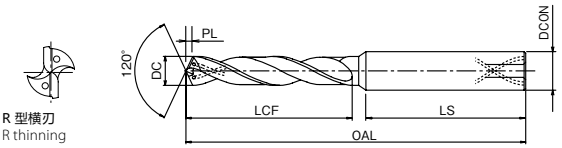
POWDER METALLURGY STUB FOR HIGH SPEED PROCESSING WITH INTERNAL COOLANT SUPPLY

VP-HO-GDS

切削条件 Cutting Conditions | P.422

内冷油孔 + 粉末高速钢 +V 涂层，使得加工速度高于硬质合金钻头。

Similar to the VP-GDR, but includes an internal coolant supply system. This drill's high-speed processing capability exceeds that of carbide drills.



CPM | V | h8 | SHANK h7 | 30°

※φ12以下为普通直柄。
※Drill dia. ≦ 12 : with plain straight shank
※φ12以上为带凹槽直柄。
※12 < Drill dia. : straight and flat shank

上一页

FROM 直径 DC 12～17.9

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594680	**18**	62	128	20	50	5.2	●	207
8594681	**18.1**	64	130		50	5.2	●	210
8594682	**18.2**				50	5.3	●	210
8594683	**18.3**				50	5.3	●	211
8594684	**18.4**				50	5.3	●	213
8594685	**18.5**				50	5.3	●	213
8594686	**18.6**				50	5.4	●	216
8594687	**18.7**				50	5.4	●	215
8594688	**18.8**				50	5.4	●	220
8594689	**18.9**				50	5.5	●	220
8594690	**19**				50	5.5	●	218
8594691	**19.1**	66	132		50	5.5	●	213
8594692	**19.2**				50	5.5	●	214
8594693	**19.3**				50	5.6	●	214
8594694	**19.4**				50	5.6	●	220
8594695	**19.5**				50	5.6	●	217
8594696	**19.6**				50	5.7	●	220

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594697	**19.7**	66	132	20	50	5.7	●	221
8594698	**19.8**				50	5.7	●	222
8594699	**19.9**				50	5.7	●	223
8594700	**20**				50	5.8	●	225
8594705	**20.5**	68	144	25	56	5.9	●	329
8594710	**21**				56	6.1	●	334
8594715	**21.5**	70	146		56	6.2	●	352
8594720	**22**				56	6.4	●	361
8594725	**22.5**	72	148		56	6.5	●	368
8594730	**23**				56	6.6	●	376
8594735	**23.5**				56	6.8	●	378
8594740	**24**	75	151		56	6.9	●	390
8594745	**24.5**				56	7.1	●	395
8594750	**25**				56	7.2	●	404
8594755	**25.5**	78	158	32	60	7.4	●	584
8594760	**26**				60	7.5	●	597

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VP-HO-GDS	◎	◎	◎	◎	◎	○				◎	◎	◎	◎	○	○	◎	◎	○		○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

高速加工用粉末高速钢内冷油孔标准刃长型钻头

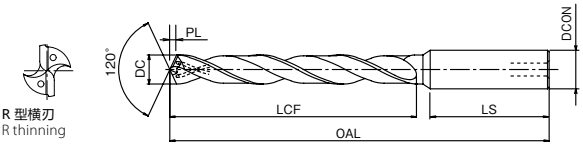
POWDER HSS REGULAR WITH INTERNAL COOLANT SUPPLY FOR HIGH SPEED PROCESSING

VP-HO-GDR

切削条件 Cutting Conditions | P.423

内冷油孔 + 粉末高速钢 +V 涂层，使得加工速度高于硬质合金钻头。

Similar to the VP-GDR, but includes an internal coolant supply system. This drill's high-speed processing capability exceeds that of carbide drills.



CPM | V | h8 | SHANK h6 (12<DC) | SHANK h7 (DC≦12) | 30°

※φ12以下为普通直柄。
※Drill dia. ≦ 12 : with plain straight shank
※φ12以上为带凹槽直柄。
※12 < Drill dia. : straight and flat shank

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593560	**6**	57	101	6	42	1.7	●	17
8593565	**6.5**	63	107		42	1.9	●	20
8593568	**6.8**	69	113	7	42	2	●	26
8593570	**7**				42	2	●	26
8593575	**7.5**			8	41.1	2.2	●	31
8593580	**8**	75	119		42	2.3	●	34
8593585	**8.5**		125	9	47.1	2.5	●	47
8593586	**8.6**	81	131		47.3	2.5	●	48
8593590	**9**				48	2.6	●	50
8593595	**9.5**			10	47.1	2.7	●	58
8593600	**10**	87	137		48	2.9	●	61
8593603	**10.3**		144	11	53.6	3	●	77
8593605	**10.5**				54.1	3	●	78

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593610	**11**	94	151	11	55	3.2	●	83
8593615	**11.5**			12	54.2	3.3	●	94
8593620	**12**	101	158		55	3.5	●	101
8593625	**12.5**		161	16	48	3.6	●	141
8593630	**13**				48	3.8	●	144
8593635	**13.5**	106	166		48	3.9	●	149
8593640	**14**				48	4	●	153
8593641	**14.1**	109	169		48	4.1	●	157
8593645	**14.5**				48	4.2	●	162
8593650	**15**				48	4.3	●	167
8593655	**15.5**	112	172		48	4.5	●	170
8593656	**15.6**				48	4.5	●	170
8593660	**16**				48	4.6	●	177

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直径 DC 16.5～32 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VP-HO-GDR	◎	◎	◎	◎	◎					◎	◎	◎	◎	○	○	◎	◎	○		○	
※	◎	◎	◎	◎	◎					◎	○	◎	◎	○	○	◎	◎			○	

※5D < : 孔深 5D < : Drilling depth

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DH1010

高速加工用粉末高速钢内冷油孔标准刃长型钻头

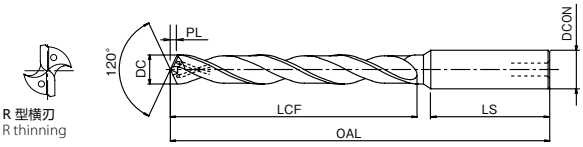
POWDER HSS REGULAR WITH INTERNAL COOLANT SUPPLY FOR HIGH SPEED PROCESSING

VP-HO-GDR

切削条件 Cutting Conditions | P.423

内冷油孔 + 粉末高速钢 +V 涂层，使得加工速度高于硬质合金钻头。

Similar to the VP-GDR, but includes an internal coolant supply system. This drill's high-speed processing capability exceeds that of carbide drills.



※φ12以下为普通直柄。
※Drill dia. ≦ 12 : with plain straight shank
※φ12以上为带凹槽直柄。
※12 < Drill dia. : straight and flat shank

CPM | V | h8 | SHANK h6 (12<DC) | SHANK h7 (DC≦12) | 30°

上一页

FROM 直径 DC 6～16

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593665	**16.5**	115	181	20	50	4.8	●	251
8593670	**17**				50	4.9	●	256
8593675	**17.5**	118	184		50	5.1	●	266
8593676	**17.6**				50	5.1	●	270
8593680	**18**				50	5.2	●	275
8593685	**18.5**	122	188		50	5.3	●	287
8593690	**19**				50	5.5	●	293
8593695	**19.5**	125	191		50	5.6	●	298
8593696	**19.6**				50	5.7	●	298
8593700	**20**				50	5.8	●	300
8593705	**20.5**	128	204	25	56	5.9	●	410
8593710	**21**				56	6.1	●	420
8593711	**21.1**				56	6.1	●	420
8593715	**21.5**	132	208		56	6.2	●	430
8593720	**22**				56	6.4	●	444

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8593725	**22.5**	136	212	25	56	6.5	●	457
8593730	**23**				56	6.6	●	472
8593735	**23.5**				56	6.8	●	473
8593740	**24**	140	216		56	6.9	●	493
8593745	**24.5**				56	7.1	●	505
8593750	**25**				56	7.2	●	515
8593755	**25.5**	145	225	32	60	7.4	●	685
8593760	**26**				60	7.5	●	710
8593765	**26.5**				60	7.6	●	725
8593770	**27**	150	230		60	7.8	●	747
8593780	**28**				60	8.1	●	780
8593790	**29**	155	235		60	8.4	●	817
8593800	**30**				60	8.7	●	834
8593810	**31**	160	240		60	8.9	●	885
8593820	**32**	165	245		60	9.2	●	930

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VP-HO-GDR	◎	◎	◎	◎	◎					◎	◎	◎	◎	○	○	◎	◎	○		○	
※	◎	◎	◎	◎	◎					◎	○	◎	◎	○	○	◎	◎			○	

※5D＜：孔深　5D＜：Drilling depth

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

粉末高速钢长刃型
POWDER METALLURGY LONG

VP-GDXL

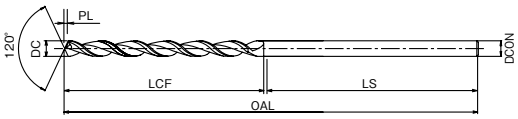
切削条件 Cutting Conditions | P.421

高刚性排屑槽与高级粉末高速钢和V涂层相辅相成，7~10倍的深孔也可以轻松自如地加工，而且刀具寿命长。

Rigid parabolic flutes, the powdered metallurgy HSS and V coating can increase hole-processing depth to 7-10 times the hole diameter.

X 型横刃
X thinning
(DC<4)

R 型横刃
R thinning
(4≦DC)



CPM | V | h8 | SHANK h7 | 38°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8621030	**3**	55	100	3	35	0.9	●	7
8621033	**3.3**			3.3	35	1	●	8
8621035	**3.5**			3.5	35	1	●	8
8621040	**4**	60		4	30	1.2	●	10
8621540		80	150		60	1.2	●	14
8621042	**4.2**	60	100	4.2	30	1.2	●	10
8621542		80	150		60	1.2	●	15
8621045	**4.5**	60	100	4.5	30	1.3	●	11
8621545		80	150		60	1.3	●	17
8621550	**5**	85		5	55	1.4	●	20
8622050		105	200		85	1.4	●	29
8621551	**5.1**	85	150	5.1	55	1.5	●	21
8621552	**5.2**			5.2	55	1.5	●	22
8622052		105	200		85	1.5	●	31
8621555	**5.5**	85	150	5.5	55	1.6	●	24
8622055		105	200		85	1.6	●	34

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8621560	**6**	90	150	6	50	1.7	●	27
8622060		110	200		80	1.7	●	39
8621565	**6.5**	90	150	6.5	50	1.9	●	33
8622065		110	200		80	1.9	●	48
8621568	**6.8**	90	150	6.8	50	2	●	37
8622068		110	200		80	2	●	52
8621569	**6.9**	90	150	6.9	50	2	●	42
8621570	**7**			7	50	2	●	39
8622070		110	200		80	2	●	55
8621575	**7.5**	90	150	7.5	50	2.2	●	44
8622075		110			80	2.2	●	59
8622080	**8**	115	200	8	75	2.3	●	67
8622085	**8.5**			8.5	75	2.5	●	76
8622090	**9**			9	75	2.6	●	83
8622095	**9.5**			9.5	75	2.7	●	90
8622100	**10**	120		10	70	2.9	●	96

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
VP-GDXL	○	◎	◎	◎	○							◎	◎			○				○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DH1023

高速钢NEXUS钻头 超短刃型

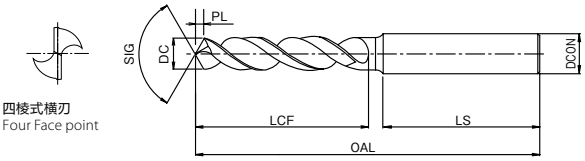
NEXUS DRILL STUB

NEXUS-GDS

切削条件 Cutting Conditions | P.424

采用WDI涂层抑制外周刃带的磨损、实现高速领域加工中寿命更长、最适合于加工不锈钢、软钢、铝合金、铜合金等等。

The WDI Coating inhibits wear on the margin to achieve long tool life in high-speed machining. Providing outstanding peifnmanie in stainless steels,aluminum alloys and copper alloys.



四棱式横刃
Four Face point

HSSE | WDI | h8 | SHANK h7 | 35~40°

注1)

注1) 尺寸为0.01间隔的尺寸公差是0~0.015mm
The drill diameter tolerance is 0 ～ -0.015 is for sizes of 0.01mm increments.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8650100	1	6	38	3	26.8	0.2	140°	●	4
8650110	1.1	7	39		27	0.2		●	4
8650120	1.2	8	40		27.1	0.2		●	4
8650130	1.3				27.3	0.2		●	4
8650140	1.4	9	41		27.5	0.3		●	4
8650150	1.5				27.7	0.3		●	4
8650160	1.6	10	42		27.9	0.3		●	4
8650170	1.7				28.1	0.3		●	4
8650180	1.8	11	43		28.3	0.3		●	4
8650181	1.81				28.3	0.3		●	4
8650183	1.83				28.3	0.3		●	4
8650190	1.9				28.4	0.3		●	4
8650200	2	12	44		28.6	0.5	130°	●	4
8650210	2.1				28.8	0.5		●	4
8650211	2.11				28.8	0.5		●	4
8650213	2.13	13	45		28.9	0.5		●	4
8650220	2.2				29	0.5		●	4
8650228	2.28				29.2	0.5		●	4
8650230	2.3				29.2	0.5		●	4
8650238	2.38	14	46		29.3	0.6		●	4
8650240	2.4				29.4	0.6		●	4
8650250	2.5				29.6	0.6		●	4
8650260	2.6				29.8	0.6		●	4
8650270	2.7	16	48		29.9	0.6		●	4
8650276	2.76				30.1	0.6		●	4
8650278	2.78				30.1	0.6		●	4
8650280	2.8				30.1	0.7		●	4
8650290	2.9				30.3	0.7		●	4
8650300	3				30.5	0.7		●	4
8650310	3.1	18	50	4	28.8	0.7		●	5
8650320	3.2				29	0.7		●	5
8650325	3.25				29.1	0.8		●	6
8650330	3.3				29.2	0.8		●	5
8650340	3.4	20	52		29.4	0.8		●	6
8650350	3.5				29.6	0.8		●	6
8650360	3.6				29.8	0.8		●	6
8650365	3.65				29.8	0.9		●	6
8650367	3.67				29.9	0.9		●	6
8650370	3.7				29.9	0.9		●	6
8650380	3.8	22	54		30.1	0.9		●	6
8650390	3.9				30.3	0.9		●	6
8650400	4				30.5	0.9		●	6
8650410	4.1		66	6	35.9	1.2	120°	●	12
8650420	4.2				36.1	1.2		●	12
8650430	4.3	24	68		36.2	1.2		●	13
8650440	4.4				36.4	1.3		●	15
8650450	4.5				37.1	1.3		●	15
8650459	4.59				37.3	1.3		●	15
8650460	4.6				37.3	1.3		●	13
8650463	4.63				37.3	1.3		●	13
8650470	4.7				37.5	1.4		●	13
8650480	4.8	26	70		37.6	1.4		●	13
8650490	4.9				37.8	1.4		●	15

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8650500	5	26	70	6	38	1.4	120°	●	14
8650510	5.1				38.7	1.5		●	14
8650520	5.2				38.9	1.5		●	14
8650530	5.3				39.1	1.5		●	14
8650540	5.4	28	72		39.5	1.6		●	16
8650548	5.48				39.8	1.6		●	16
8650550	5.5				39.8	1.6		●	14
8650560	5.6				41.5	1.6		●	14
8650570	5.7				41.5	1.6		●	16
8650580	5.8				41.5	1.7		●	15
8650590	5.9				41.5	1.7		●	15
8650600	6				42	1.7		●	15
8650610	6.1	31	75	8	36	1.8		●	22
8650620	6.2				36.1	1.8		●	22
8650630	6.3				36.3	1.8		●	22
8650640	6.4				37.1	1.8		●	24
8650650	6.5				37.3	1.9		●	24
8650660	6.6				37.4	1.9		●	23
8650680	6.8	34	78		37.7	2		●	23
8650690	6.9				37.9	2		●	23
8650700	7				38.6	2		●	23
8650734	7.34				39.6	2.1		●	25
8650738	7.38				39.5	2.1		●	25
8650740	7.4				39.7	2.1		●	25
8650750	7.5				39.9	2.2		●	26
8650780	7.8	37	81		41.7	2.3	120°	●	26
8650790	7.9				41.6	2.3		●	26
8650800	8				42	2.3		●	26
8650810	8.1		87	10	42	2.3		●	45
8650820	8.2				42.1	2.4		●	45
8650830	8.3				42.2	2.4		●	45
8650840	8.4				43.1	2.4		●	46
8650850	8.5				43.2	2.5		●	46
8650860	8.6	40	90		43.4	2.5		●	46
8650870	8.7				43.6	2.5		●	47
8650880	8.8				43.7	2.5		●	47
8650900	9				44.6	2.6		●	48
8650918	9.18				45	2.7		●	48
8650920	9.2				45	2.7		●	49
8650924	9.24				45.1	2.7		●	49
8650934	9.34				45.5	2.7		●	49
8650936	9.36				45.1	2.7		●	49
8650950	9.5				45.9	2.7		●	49
8650980	9.8	43	93		47.7	2.8		●	50
8651000	10				48	2.9		●	51
8651020	10.2		100	12	49.1	2.9		●	70
8651030	10.3				49.2	3		●	71
8651040	10.4				50	3		●	71
8651050	10.5				50.2	3		●	72
8651100	11	47	104		51.6	3.2		●	74
8651120	11.2				51.9	3.2		●	75
8651150	11.5				52.8	3.3		●	76
8651200	12	51	108		55	3.5		●	80

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

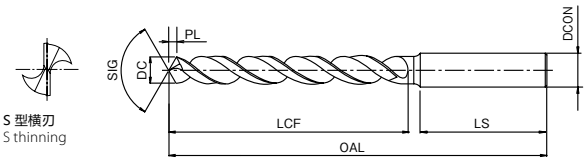
高速钢NEXUS钻头 标准刃长型
NEXUS DRILL REGULAR

NEXUS-GDR

切削条件 Cutting Conditions | P.425

采用WDI涂层抑制外周刃带的磨损、实现高速领域加工中寿命更长、最适合于加工不锈钢、软钢、铝合金、铜合金等等。

The WDI Coating inhibits wear on the margin to achieve long tool life in high-speed machining. Providing outstanding peifnmanie in stainless steels,aluminum alloys and copper alloys.



HSSE | WDI | h8 | SHANK h7 | 35~40°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8655200	**2**	24	56	3	28.7	0.5	130°	●	4
8655230	**2.3**	27	59		29.2	0.5		●	5
8655250	**2.5**	30	62		29.6	0.6		●	5
8655260	**2.6**				29.8	0.6		●	5
8655280	**2.8**	33	65		30.2	0.7		●	5
8655300	**3**				30.5	0.7		●	6
8655330	**3.3**	36	68	4	29.2	0.8		●	7
8655340	**3.4**	39	71		29.5	0.8		●	7
8655350	**3.5**				29.7	0.8		●	7
8655400	**4**	43	75		30.5	0.9		●	8
8655420	**4.2**		87	6	36.2	1.2	120°	●	8
8655430	**4.3**	47	91		36.4	1.2		●	15
8655450	**4.5**				37.3	1.3		●	20
8655500	**5**	52	96		38.8	1.4		●	20
8655510	**5.1**				38.9	1.5		●	17
8655520	**5.2**				39.1	1.5		●	17

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8655550	**5.5**	57	101	6	39.7	1.6	120°	●	17
8655600	**6**				42	1.7		●	17
8655680	**6.8**	69	113	8	37.9	2		●	31
8655690	**6.9**				38.6	2		●	31
8655700	**7**				38.8	2		●	31
8655800	**8**	75	119		42	2.3		●	31
8655850	**8.5**		125	10	43.4	2.5		●	54
8655860	**8.6**	81	131		43.5	2.5		●	56
8655880	**8.8**				43.9	2.5		●	56
8655900	**9**				44.8	2.6		●	58
8656000	**10**	87	137	12	48	2.9		●	66
8656030	**10.3**		144		49.2	3		●	82
8656040	**10.4**				50	3		●	84
8656050	**10.5**				50.2	3		●	84
8656100	**11**	94	151		51.7	3.2		●	89
8656200	**12**	101	158		55	3.5		●	97

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
NEXUS-GDS	◎	○								◎				◎	◎	◎				○	
NEXUS-GDR	◎	○								◎				◎	◎	◎				○	

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **DH1005**

不锈钢·软钢用超短刃型钻头

STUB FOR STAINLESS STEELS

EX-SUS-GDS

切削条件 Cutting Conditions | P.426

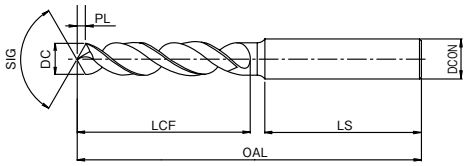
最适合用于不锈钢、软钢、铜合金等。

This drill is most suitable for stainless steels, mild steels, and copper alloys.

HSSE | TiN | h8 注1) | SHANK h7 | 约30° ABOUT30° DC<1 | 35~40° 1≦DC

四棱式横刃
Four Facet point
(DC≦13)

N 型横刃
N thinning
(13< DC)



注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。

All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61505	**0.5**	3	38	3	26	0.1	150°	●	4
8595051	**0.51**				26	0.1		●	4
8595052	**0.52**				26	0.1		●	4
8595053	**0.53**				26	0.1		●	3
8595054	**0.54**	3.5			26	0.1		●	3
8595055	**0.55**				26	0.1		●	4
8595056	**0.56**				26	0.1		●	3
8595057	**0.57**				26	0.1		●	4
8595058	**0.58**				26	0.1		●	3
8595059	**0.59**				26	0.1		●	3
61506	**0.6**				26	0.1		●	4
8595061	**0.61**	4			26.5	0.1		●	4
8595062	**0.62**				26.5	0.1		●	4
8595063	**0.63**				26.5	0.1		●	4
8595064	**0.64**				26.5	0.1		●	3
8595065	**0.65**				26.5	0.1		●	4
8595066	**0.66**				26.5	0.1		●	4
8595067	**0.67**	4.5			26.5	0.1		●	4
8595068	**0.68**				26.5	0.1		●	4
8595069	**0.69**				26.5	0.1		●	3
61507	**0.7**				26.5	0.1		●	4
8595071	**0.71**				26.5	0.1		●	3
8595072	**0.72**				26.5	0.1		●	4
8595073	**0.73**				26.5	0.1		●	3
8595074	**0.74**				26.5	0.1		●	3
8595075	**0.75**				26.5	0.1		●	4
8595076	**0.76**	5			26.5	0.1		●	4
8595077	**0.77**				26.5	0.1		●	4
8595078	**0.78**				26.5	0.1		●	4
8595079	**0.79**				26.5	0.1		●	4
61508	**0.8**				26.5	0.1		●	4
8595081	**0.81**				26.5	0.1		●	4
8595082	**0.82**				26.5	0.1		●	4
8595083	**0.83**				26.5	0.1		●	4
8595084	**0.84**				26.5	0.1		●	3
8595085	**0.85**				26.5	0.1		●	4
8595086	**0.86**	5.5			26.7	0.1		●	3
8595087	**0.87**				26.7	0.1		●	4
8595088	**0.88**				26.7	0.1		●	3
8595089	**0.89**				26.7	0.1		●	4
61509	**0.9**				26.7	0.1		●	4
8595091	**0.91**				26.7	0.1		●	4
8595092	**0.92**				26.7	0.1		●	4
8595093	**0.93**				26.7	0.1		●	4
8595094	**0.94**				26.7	0.1		●	4
8595095	**0.95**				26.7	0.1		●	4
8595096	**0.96**	6			26.7	0.1		●	3
8595097	**0.97**				26.7	0.1		●	4
8595098	**0.98**				26.7	0.1		●	4
8595099	**0.99**				26.7	0.1		●	4
61510	**1**				26.8	0.2	140°	●	4
8595101	**1.01**				26.8	0.2		●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595102	**1.02**	6	38	3	26.8	0.2	140°	●	4
8595103	**1.03**				26.8	0.2		●	4
8595104	**1.04**				26.8	0.2		●	4
8595105	**1.05**				26.9	0.2		●	4
8595106	**1.06**				26.9	0.2		●	4
8595107	**1.07**	7	39		26.9	0.2		●	4
8595108	**1.08**				26.9	0.2		●	4
8595109	**1.09**				26.9	0.2		●	4
61511	**1.1**				27	0.2		●	4
8595111	**1.11**				27	0.2		●	4
8595112	**1.12**				27	0.2		●	4
8595113	**1.13**				27	0.2		●	4
8595114	**1.14**				27	0.2		●	4
8595115	**1.15**				27	0.2		●	4
8595116	**1.16**				27.1	0.2		●	3
8595117	**1.17**				27.1	0.2		●	4
8595118	**1.18**				27.1	0.2		●	4
8595119	**1.19**	8	40		27.1	0.2		●	4
61512	**1.2**				27.1	0.2		●	4
8595121	**1.21**				27.2	0.2		●	4
8595122	**1.22**				27.2	0.2		●	4
8595123	**1.23**				27.2	0.2		●	4
8595124	**1.24**				27.2	0.2		●	4
8595125	**1.25**				27.2	0.2		●	4
8595126	**1.26**				27.3	0.2		●	4
8595127	**1.27**				27.3	0.2		●	4
8595128	**1.28**				27.3	0.2		●	4
8595129	**1.29**				27.3	0.2		●	4
61513	**1.3**				27.3	0.2		●	4
8595131	**1.31**				27.3	0.2		●	3
8595132	**1.32**				27.4	0.2		●	4
8595133	**1.33**	9	41		27.4	0.2		●	4
8595134	**1.34**				27.4	0.2		●	3
8595135	**1.35**				27.4	0.2		●	4
8595136	**1.36**				27.4	0.2		●	4
8595137	**1.37**				27.5	0.2		●	4
8595138	**1.38**				27.5	0.3		●	4
8595139	**1.39**				27.5	0.3		●	3
61514	**1.4**				27.5	0.3		●	4
8595141	**1.41**				27.5	0.3		●	4
8595142	**1.42**				27.6	0.3		●	4
8595143	**1.43**				27.6	0.3		●	4
8595144	**1.44**				27.6	0.3		●	4
8595145	**1.45**				27.6	0.3		●	4
8595146	**1.46**				27.6	0.3		●	4
8595147	**1.47**				27.6	0.3		●	4
8595148	**1.48**				27.7	0.3		●	4
8595149	**1.49**				27.7	0.3		●	4
61515	**1.5**				27.7	0.3		●	4
8595151	**1.51**	10	42		27.7	0.3		●	4
8595152	**1.52**				27.7	0.3		●	4
8595153	**1.53**				27.8	0.3		●	4

下一页
直径 DC 1.54 ~ 2.57 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDS	◎	○								◎				◎	◎	◎				○	

上一页
FROM 直径 DC 0.5～1.53

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595154	**1.54**	10	42	3	27.8	0.3	140°	●	4
8595155	**1.55**				27.8	0.3		●	4
8595156	**1.56**				27.8	0.3		●	4
8595157	**1.57**				27.8	0.3		●	4
8595158	**1.58**				27.9	0.3		●	4
8595159	**1.59**				27.9	0.3		●	4
61516	**1.6**				27.9	0.3		●	4
8595161	**1.61**				27.9	0.3		●	4
8595162	**1.62**				27.9	0.3		●	4
8595163	**1.63**				27.9	0.3		●	4
8595164	**1.64**				28	0.3		●	4
8595165	**1.65**				28	0.3		●	4
8595166	**1.66**				28	0.3		●	4
8595167	**1.67**				28	0.3		●	4
8595168	**1.68**				28	0.3		●	4
8595169	**1.69**				28.1	0.3		●	3
61517	**1.7**				28.1	0.3		●	4
8595171	**1.71**	11	43		28.1	0.3		●	4
8595172	**1.72**				28.1	0.3		●	4
8595173	**1.73**				28.1	0.3		●	4
8595174	**1.74**				28.1	0.3		●	3
8595175	**1.75**				28.2	0.3		●	4
8595176	**1.76**				28.2	0.3		●	3
8595177	**1.77**				28.2	0.3		●	4
8595178	**1.78**				28.2	0.3		●	4
8595179	**1.79**				28.2	0.3		●	3
61518	**1.8**				28.3	0.3		●	4
8595181	**1.81**				28.3	0.3		●	4
8595182	**1.82**				28.3	0.3		●	4
8595183	**1.83**				28.3	0.3		●	4
8595184	**1.84**				28.3	0.3		●	4
8595185	**1.85**				28.4	0.3		●	4
8595186	**1.86**				28.4	0.3		●	4
8595187	**1.87**				28.4	0.3		●	4
8595188	**1.88**				28.4	0.3		●	4
8595189	**1.89**				28.4	0.3		●	4
61519	**1.9**				28.4	0.3		●	4
8595191	**1.91**	12	44		28.5	0.3		●	3
8595192	**1.92**				28.5	0.3		●	4
8595193	**1.93**				28.5	0.4		●	4
8595194	**1.94**				28.5	0.4		●	3
8595195	**1.95**				28.5	0.4		●	4
8595196	**1.96**				28.6	0.4		●	4
8595197	**1.97**				28.6	0.4		●	4
8595198	**1.98**				28.6	0.4		●	4
8595199	**1.99**				28.6	0.4		●	4
61520	**2**				28.6	0.4	130°	●	4
8595201	**2.01**				28.7	0.5		●	4
8595202	**2.02**				28.7	0.5		●	4
8595203	**2.03**				28.7	0.5		●	4
8595204	**2.04**				28.7	0.5		●	4
8595205	**2.05**				28.7	0.5		●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595206	**2.06**	12	44	3	28.8	0.5	130°	●	4
8595207	**2.07**				28.8	0.5		●	4
8595208	**2.08**				28.8	0.5		●	4
8595209	**2.09**				28.8	0.5		●	4
61521	**2.1**				28.8	0.5		●	4
8595211	**2.11**				28.8	0.5		●	4
8595212	**2.12**				28.9	0.5		●	4
8595213	**2.13**	13	45		28.9	0.5		●	4
8595214	**2.14**				28.9	0.5		●	4
8595215	**2.15**				28.9	0.5		●	4
8595216	**2.16**				28.9	0.5		●	4
8595217	**2.17**				29	0.5		●	4
8595218	**2.18**				29	0.5		●	4
8595219	**2.19**				29	0.5		●	4
61522	**2.2**				29	0.5		●	4
8595221	**2.21**				29	0.5		●	4
8595222	**2.22**				29	0.5		●	4
8595223	**2.23**				29.1	0.5		●	4
8595224	**2.24**				29.1	0.5		●	4
8595225	**2.25**				29.1	0.5		●	4
8595226	**2.26**				29.1	0.5		●	4
8595227	**2.27**				29.1	0.5		●	4
8595228	**2.28**				29.2	0.5		●	4
8595229	**2.29**				29.2	0.5		●	4
61523	**2.3**				29.2	0.5		●	4
8595231	**2.31**				29.2	0.5		●	4
8595232	**2.32**				29.2	0.5		●	4
8595233	**2.33**				29.2	0.5		●	4
8595234	**2.34**				29.3	0.5		●	4
8595235	**2.35**				29.3	0.5		●	4
8595236	**2.36**				29.3	0.6		●	4
8595237	**2.37**	14	46		29.3	0.6		●	4
8595238	**2.38**				29.3	0.6		●	4
8595239	**2.39**				29.4	0.6		●	4
61524	**2.4**				29.4	0.6		●	4
8595241	**2.41**				29.4	0.6		●	4
8595242	**2.42**				29.4	0.6		●	4
8595243	**2.43**				29.4	0.6		●	4
8595244	**2.44**				29.5	0.6		●	4
8595245	**2.45**				29.5	0.6		●	4
8595246	**2.46**				29.5	0.6		●	4
8595247	**2.47**				29.5	0.6		●	4
8595248	**2.48**				29.5	0.6		●	4
8595249	**2.49**				29.5	0.6		●	4
61525	**2.5**				29.6	0.6		●	4
8595251	**2.51**				29.6	0.6		●	4
8595252	**2.52**				29.6	0.6		●	4
8595253	**2.53**				29.6	0.6		●	4
8595254	**2.54**				29.6	0.6		●	4
8595255	**2.55**				29.7	0.6		●	4
8595256	**2.56**				29.7	0.6		●	4
8595257	**2.57**				29.7	0.6		●	4

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直径 DC 2.58～3.61 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DH1005**

不锈钢·软钢用超短刃型钻头

STUB FOR STAINLESS STEELS

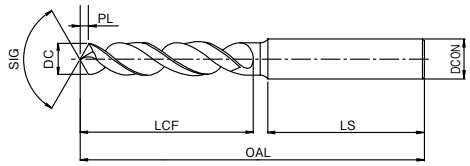
EX-SUS-GDS

切削条件 Cutting Conditions | P.426

最适合用于不锈钢、软钢、铜合金等。

This drill is most suitable for stainless steels, mild steels, and copper alloys.

四棱式横刃
Four Facet point
(DC≦13)



N 型横刃
N thinning
(13< DC)

注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。

All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

HSSE | TiN | h8 注1) | SHANK h7 | 约30° ABOUT30° DC<1 | 35~40° 1≦DC

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FROM 直径 DC 1.54～2.57

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595258	**2.58**	14	46	3	29.7	0.6	130°	●	4
8595259	**2.59**				29.7	0.6		●	4
61526	**2.6**				29.8	0.6		●	4
8595261	**2.61**				29.8	0.6		●	4
8595262	**2.62**				29.8	0.6		●	4
8595263	**2.63**				29.8	0.6		●	4
8595264	**2.64**				29.8	0.6		●	4
8595265	**2.65**				29.8	0.6		●	4
8595266	**2.66**	16	48		29.9	0.6		●	4
8595267	**2.67**				29.9	0.6		●	4
8595268	**2.68**				29.9	0.6		●	4
8595269	**2.69**				29.9	0.6		●	4
61527	**2.7**				29.9	0.6		●	4
8595271	**2.71**				30	0.6		●	4
8595272	**2.72**				30	0.6		●	4
8595273	**2.73**				30	0.6		●	4
8595274	**2.74**				30	0.6		●	4
8595275	**2.75**				30	0.6		●	4
8595276	**2.76**				30.1	0.6		●	4
8595277	**2.77**				30.1	0.6		●	4
8595278	**2.78**				30.1	0.6		●	4
8595279	**2.79**				30.1	0.7		●	4
61528	**2.8**				30.1	0.7		●	4
8595281	**2.81**				30.1	0.7		●	4
8595282	**2.82**				30.2	0.7		●	4
8595283	**2.83**				30.2	0.7		●	4
8595284	**2.84**				30.2	0.7		●	4
8595285	**2.85**				30.2	0.7		●	4
8595286	**2.86**				30.2	0.7		●	4
8595287	**2.87**				30.3	0.7		●	4
8595288	**2.88**				30.3	0.7		●	4
8595289	**2.89**				30.3	0.7		●	4
61529	**2.9**				30.3	0.7		●	4
8595291	**2.91**				30.3	0.7		●	4
8595292	**2.92**				30.4	0.7		●	4
8595293	**2.93**				30.4	0.7		●	4
8595294	**2.94**				30.4	0.7		●	4
8595295	**2.95**				30.4	0.7		●	4
8595296	**2.96**				30.5	0.7		●	4
8595297	**2.97**				30.5	0.7		●	4
8595298	**2.98**				30.5	0.7		●	4
8595299	**2.99**				30.5	0.7		●	4
61530	**3**				30.5	0.7		●	4
8595301	**3.01**	18	50	4	28.7	0.7		●	5
8595302	**3.02**				28.7	0.7		●	5
8595303	**3.03**				28.7	0.7		●	5
8595304	**3.04**				28.7	0.7		●	5
8595305	**3.05**				28.7	0.7		●	5
8595306	**3.06**				28.7	0.7		●	5
8595307	**3.07**				28.8	0.7		●	5
8595308	**3.08**				28.8	0.7		●	5
8595309	**3.09**				28.8	0.7		●	5

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61531	**3.1**	18	50	4	28.8	0.7	130°	●	5
8595311	**3.11**				28.8	0.7		●	5
8595312	**3.12**				28.9	0.7		●	5
8595313	**3.13**				28.9	0.7		●	5
8595314	**3.14**				28.9	0.7		●	5
8595315	**3.15**				28.9	0.7		●	5
8595316	**3.16**				28.9	0.7		●	5
8595317	**3.17**				29	0.7		●	5
8595318	**3.18**				29	0.7		●	5
8595319	**3.19**				29	0.7		●	5
61532	**3.2**				29	0.7		●	5
8595321	**3.21**				29	0.7		●	5
8595322	**3.22**				29	0.8		●	5
8595323	**3.23**				29	0.8		●	5
8595324	**3.24**				29.1	0.8		●	5
8595325	**3.25**				29.1	0.8		●	5
8595326	**3.26**				29.1	0.8		●	5
8595327	**3.27**				29.1	0.8		●	5
8595328	**3.28**				29.2	0.8		●	5
8595329	**3.29**				29.2	0.8		●	5
61533	**3.3**				29.2	0.8		●	5
8595331	**3.31**				29.2	0.8		●	5
8595332	**3.32**				29.2	0.8		●	5
8595333	**3.33**				29.2	0.8		●	5
8595334	**3.34**				29.3	0.8		●	5
8595335	**3.35**				29.3	0.8		●	5
8595336	**3.36**	20	52	4	29.3	0.8	130°	●	6
8595337	**3.37**				29.3	0.8		●	5
8595338	**3.38**				29.3	0.8		●	6
8595339	**3.39**				29.4	0.8		●	5
61534	**3.4**				29.4	0.8		●	6
8595341	**3.41**				29.4	0.8		●	5
8595342	**3.42**				29.4	0.8		●	6
8595343	**3.43**				29.4	0.8		●	5
8595344	**3.44**				29.5	0.8		●	5
8595345	**3.45**				29.5	0.8		●	5
8595346	**3.46**				29.5	0.8		●	6
8595347	**3.47**				29.5	0.8		●	6
8595348	**3.48**				29.5	0.8		●	5
8595349	**3.49**				29.5	0.8		●	5
61535	**3.5**				29.6	0.8		●	6
8595351	**3.51**				29.6	0.8		●	5
8595352	**3.52**				29.6	0.8		●	6
8595353	**3.53**				29.6	0.8		●	6
8595354	**3.54**				29.6	0.8		●	5
8595355	**3.55**				29.7	0.8		●	6
8595356	**3.56**				29.7	0.8		●	5
8595357	**3.57**				29.7	0.8		●	6
8595358	**3.58**				29.7	0.8		●	5
8595359	**3.59**				29.7	0.8		●	5
61536	**3.6**				29.8	0.8		●	6
8595361	**3.61**				29.8	0.8		●	5

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直径 DC 3.62～4.65 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDS	◎	○								◎				◎	◎	◎				○	

上一页
FROM 直径 DC 2.58～3.61

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595362	**3.62**	20	52	4	29.8	0.8	130°	●	5
8595363	**3.63**				29.8	0.8		●	6
8595364	**3.64**				29.8	0.8		●	6
8595365	**3.65**				29.8	0.9		●	6
8595366	**3.66**				29.9	0.9		●	6
8595367	**3.67**				29.9	0.9		●	6
8595368	**3.68**				29.9	0.9		●	6
8595369	**3.69**				29.9	0.9		●	6
61537	**3.7**				29.9	0.9		●	6
8595371	**3.71**				30	0.9		●	5
8595372	**3.72**				30	0.9		●	6
8595373	**3.73**				30	0.9		●	6
8595374	**3.74**				30	0.9		●	5
8595375	**3.75**				30	0.9		●	6
8595376	**3.76**	22	54		30.1	0.9		●	5
8595377	**3.77**				30.1	0.9		●	5
8595378	**3.78**				30.1	0.9		●	5
8595379	**3.79**				30.1	0.9		●	5
61538	**3.8**				30.1	0.9		●	6
8595381	**3.81**				30.1	0.9		●	6
8595382	**3.82**				30.2	0.9		●	6
8595383	**3.83**				30.2	0.9		●	5
8595384	**3.84**				30.2	0.9		●	5
8595385	**3.85**				30.2	0.9		●	6
8595386	**3.86**				30.2	0.9		●	6
8595387	**3.87**				30.3	0.9		●	5
8595388	**3.88**				30.3	0.9		●	5
8595389	**3.89**				30.3	0.9		●	5
61539	**3.9**				30.3	0.9		●	6
8595391	**3.91**				30.3	0.9		●	6
8595392	**3.92**				30.4	0.9		●	6
8595393	**3.93**				30.4	0.9		●	6
8595394	**3.94**				30.4	0.9		●	6
8595395	**3.95**				30.4	0.9		●	6
8595396	**3.96**				30.4	0.9		●	6
8595397	**3.97**				30.4	0.9		●	6
8595398	**3.98**				30.5	0.9		●	6
8595399	**3.99**				30.5	0.9		●	6
61540	**4**				30.5	0.9		●	6
8595401	**4.01**		66	6	35.8	1.2	120°	●	12
8595402	**4.02**				35.8	1.2		●	12
8595403	**4.03**				35.8	1.2		●	12
8595404	**4.04**				35.8	1.2		●	12
8595405	**4.05**				35.8	1.2		●	12
8595406	**4.06**				35.9	1.2		●	12
8595407	**4.07**				35.9	1.2		●	12
8595408	**4.08**				35.9	1.2		●	12
8595409	**4.09**				35.9	1.2		●	12
61541	**4.1**				35.9	1.2		●	12
8595411	**4.11**				35.9	1.2		●	12
8595412	**4.12**				35.9	1.2		●	12
8595413	**4.13**				35.9	1.2		●	12

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595414	**4.14**	22	66	6	35.9	1.2	120°	●	12
8595415	**4.15**				35.9	1.2		●	12
8595416	**4.16**				36.1	1.2		●	12
8595417	**4.17**				36.1	1.2		●	12
8595418	**4.18**				36.1	1.2		●	12
8595419	**4.19**				36.1	1.2		●	12
61542	**4.2**				36.1	1.2		●	12
8595421	**4.21**				36.1	1.2		●	12
8595422	**4.22**				36.1	1.2		●	12
8595423	**4.23**				36.1	1.2		●	12
8595424	**4.24**				36.1	1.2		●	12
8595425	**4.25**				36.1	1.2		●	12
8595426	**4.26**	24	68		36.2	1.2		●	12
8595427	**4.27**				36.2	1.2		●	12
8595428	**4.28**				36.2	1.2		●	13
8595429	**4.29**				36.2	1.2		●	12
61543	**4.3**				36.2	1.2		●	13
8595431	**4.31**				36.2	1.2		●	12
8595432	**4.32**				36.2	1.2		●	12
8595433	**4.33**				36.2	1.2		●	12
8595434	**4.34**				36.2	1.3		●	12
8595435	**4.35**				36.2	1.3		●	13
8595436	**4.36**				36.4	1.3		●	12
8595437	**4.37**				36.4	1.3		●	13
8595438	**4.38**				36.4	1.3		●	13
8595439	**4.39**				36.4	1.3		●	13
61544	**4.4**				36.4	1.3		●	13
8595441	**4.41**				37	1.3		●	13
8595442	**4.42**				37	1.3		●	13
8595443	**4.43**				37	1.3		●	13
8595444	**4.44**				37	1.3		●	13
8595445	**4.45**				37	1.3		●	13
8595446	**4.46**				37.1	1.3		●	13
8595447	**4.47**				37.1	1.3		●	13
8595448	**4.48**				37.1	1.3		●	13
8595449	**4.49**				37.1	1.3		●	13
61545	**4.5**				37.1	1.3		●	13
8595451	**4.51**				37.2	1.3		●	13
8595452	**4.52**				37.2	1.3		●	13
8595453	**4.53**				37.2	1.3		●	13
8595454	**4.54**				37.2	1.3		●	13
8595455	**4.55**				37.2	1.3		●	13
8595456	**4.56**				37.3	1.3		●	13
8595457	**4.57**				37.3	1.3		●	13
8595458	**4.58**				37.3	1.3		●	13
8595459	**4.59**				37.3	1.3		●	13
61546	**4.6**				37.3	1.3		●	13
8595461	**4.61**				37.3	1.3		●	13
8595462	**4.62**				37.3	1.3		●	13
8595463	**4.63**				37.3	1.3		●	13
8595464	**4.64**				37.3	1.3		●	13
8595465	**4.65**				37.3	1.3		●	13

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直径 DC 4.66～5.69 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DH1005

不锈钢·软钢用超短刃型钻头

STUB FOR STAINLESS STEELS

EX-SUS-GDS

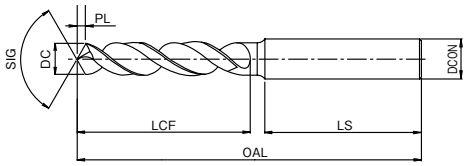
切削条件 Cutting Conditions | P.426

最适合用于不锈钢、软钢、铜合金等。

This drill is most suitable for stainless steels, mild steels, and copper alloys.

四棱式横刃
Four Facet point
(DC≦13)

N 型横刃
N thinning
(13< DC)



注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。
All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

HSSE | TiN | h8 注1) | SHANK h7 | 约30° ABOUT30° DC<1 | 35~40° 1≦DC

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FROM 直径 DC 3.62 ~ 4.65

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595466	**4.66**	24	68	6	37.5	1.3	120°	●	13
8595467	**4.67**				37.5	1.3		●	13
8595468	**4.68**				37.5	1.4		●	13
8595469	**4.69**				37.5	1.4		●	13
61547	**4.7**				37.5	1.4		●	13
8595471	**4.71**				37.5	1.4		●	13
8595472	**4.72**				37.5	1.4		●	13
8595473	**4.73**				37.5	1.4		●	13
8595474	**4.74**				37.5	1.4		●	13
8595475	**4.75**				37.5	1.4		●	13
8595476	**4.76**	26	70		37.6	1.4		●	13
8595477	**4.77**				37.6	1.4		●	13
8595478	**4.78**				37.6	1.4		●	13
8595479	**4.79**				37.6	1.4		●	13
61548	**4.8**				37.6	1.4		●	14
8595481	**4.81**				37.7	1.4		●	13
8595482	**4.82**				37.7	1.4		●	13
8595483	**4.83**				37.7	1.4		●	14
8595484	**4.84**				37.7	1.4		●	13
8595485	**4.85**				37.7	1.4		●	14
8595486	**4.86**				37.8	1.4		●	13
8595487	**4.87**				37.8	1.4		●	13
8595488	**4.88**				37.8	1.4		●	13
8595489	**4.89**				37.8	1.4		●	13
61549	**4.9**				37.8	1.4		●	14
8595491	**4.91**				37.8	1.4		●	13
8595492	**4.92**				37.8	1.4		●	13
8595493	**4.93**				37.8	1.4		●	13
8595494	**4.94**				37.8	1.4		●	13
8595495	**4.95**				37.8	1.4		●	14
8595496	**4.96**				38	1.4		●	13
8595497	**4.97**				38	1.4		●	14
8595498	**4.98**				38	1.4		●	14
8595499	**4.99**				38	1.4		●	14
61550	**5**				38	1.4		●	14
8595501	**5.01**				38.6	1.4		●	14
8595502	**5.02**				38.6	1.4		●	14
8595503	**5.03**				38.6	1.5		●	14
8595504	**5.04**				38.6	1.5		●	14
8595505	**5.05**				38.6	1.5		●	14
8595506	**5.06**				38.6	1.5		●	13
8595507	**5.07**				38.7	1.5		●	14
8595508	**5.08**				38.7	1.5		●	14
8595509	**5.09**				38.7	1.5		●	13
61551	**5.1**				38.7	1.5		●	14
8595511	**5.11**				38.7	1.5		●	14
8595512	**5.12**				38.7	1.5		●	14
8595513	**5.13**				38.7	1.5		●	14
8595514	**5.14**				38.7	1.5		●	13
8595515	**5.15**				38.7	1.5		●	14
8595516	**5.16**				38.9	1.5		●	13
8595517	**5.17**				38.9	1.5		●	14

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8595518	**5.18**	26	70	6	38.9	1.5	120°	●	14
8595519	**5.19**				38.9	1.5		●	14
61552	**5.2**				38.9	1.5		●	14
8595521	**5.21**				38.9	1.5		●	14
8595522	**5.22**				38.9	1.5		●	14
8595523	**5.23**				38.9	1.5		●	14
8595524	**5.24**				38.9	1.5		●	14
8595525	**5.25**				38.9	1.5		●	14
8595526	**5.26**				39.1	1.5		●	14
8595527	**5.27**				39.1	1.5		●	14
8595528	**5.28**				39.1	1.5		●	14
8595529	**5.29**				39.1	1.5		●	14
61553	**5.3**				39.1	1.5		●	14
8595531	**5.31**	28	72		39.2	1.5		●	14
8595532	**5.32**				39.2	1.5		●	14
8595533	**5.33**				39.2	1.5		●	14
8595534	**5.34**				39.2	1.5		●	14
8595535	**5.35**				39.2	1.5		●	14
8595536	**5.36**				39.5	1.5		●	14
8595537	**5.37**				39.5	1.6		●	14
8595538	**5.38**				39.5	1.6		●	14
8595539	**5.39**				39.5	1.6		●	14
61554	**5.4**				39.5	1.6		●	14
8595541	**5.41**				39.7	1.6		●	14
8595542	**5.42**				39.7	1.6		●	14
8595543	**5.43**				39.7	1.6		●	14
8595544	**5.44**				39.7	1.6		●	14
8595545	**5.45**				39.7	1.6		●	14
8595546	**5.46**				39.8	1.6		●	14
8595547	**5.47**				39.8	1.6		●	14
8595548	**5.48**				39.8	1.6		●	14
8595549	**5.49**				39.8	1.6		●	14
61555	**5.5**				39.8	1.6		●	14
8595551	**5.51**				39.9	1.6		●	14
8595552	**5.52**				39.9	1.6		●	14
8595553	**5.53**				39.9	1.6		●	14
8595554	**5.54**				39.9	1.6		●	14
8595555	**5.55**				39.9	1.6		●	15
8595556	**5.56**				40	1.6		●	15
8595557	**5.57**				40	1.6		●	15
8595558	**5.58**				40	1.6		●	14
8595559	**5.59**				40	1.6		●	14
61556	**5.6**				41.5	1.6		●	15
8595561	**5.61**				41.5	1.6		●	14
8595562	**5.62**				41.5	1.6		●	14
8595563	**5.63**				41.5	1.6		●	14
8595564	**5.64**				41.5	1.6		●	14
8595565	**5.65**				41.5	1.6		●	15
8595566	**5.66**				41.5	1.6		●	14
8595567	**5.67**				41.5	1.6		●	14
8595568	**5.68**				41.5	1.6		●	14
8595569	**5.69**				41.5	1.6		●	14

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直径 DC 5.7 ~ 9.65 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDS	◎	○								◎				◎	◎	◎				○	

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FROM 直径 DC 4.66～5.69

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61557	**5.7**	28	72	6	41.5	1.6	120°	●	15
8595571	**5.71**				41.5	1.6		●	14
8595572	**5.72**				41.5	1.7		●	14
8595573	**5.73**				41.5	1.7		●	14
8595574	**5.74**				41.5	1.7		●	14
8595575	**5.75**				41.5	1.7		●	15
8595576	**5.76**				41.5	1.7		●	14
8595577	**5.77**				41.5	1.7		●	14
8595578	**5.78**				41.5	1.7		●	14
8595579	**5.79**				41.5	1.7		●	14
61558	**5.8**				41.5	1.7		●	15
8595581	**5.81**				41.5	1.7		●	14
8595582	**5.82**				41.5	1.7		●	14
8595583	**5.83**				41.5	1.7		●	14
8595584	**5.84**				41.5	1.7		●	14
8595585	**5.85**				41.5	1.7		●	15
8595586	**5.86**				41.5	1.7		●	14
8595587	**5.87**				41.5	1.7		●	14
8595588	**5.88**				41.5	1.7		●	14
8595589	**5.89**				41.5	1.7		●	14
61559	**5.9**				41.5	1.7		●	15
8595591	**5.91**				41.5	1.7		●	14
8595592	**5.92**				41.5	1.7		●	14
8595593	**5.93**				41.5	1.7		●	15
8595594	**5.94**				41.5	1.7		●	14
8595595	**5.95**				41.5	1.7		●	15
8595596	**5.96**				41.5	1.7		●	14
8595597	**5.97**				41.5	1.7		●	14
8595598	**5.98**				41.5	1.7		●	14
8595599	**5.99**				41.5	1.7		●	14
61560	**6**				42	1.7		●	15
8595605	**6.05**	31	75	8	35.9	1.7	120°	●	22
61561	**6.1**				36	1.8		●	22
8595615	**6.15**				36	1.8		●	22
61562	**6.2**				36.1	1.8		●	22
8595625	**6.25**				36.2	1.8		●	22
61563	**6.3**				36.3	1.8		●	22
8595635	**6.35**				36.3	1.8		●	23
61564	**6.4**				37.1	1.8		●	23
8595645	**6.45**				37.1	1.9		●	23
61565	**6.5**				37.3	1.9		●	23
8595655	**6.55**				37.3	1.9		●	23
61566	**6.6**				37.4	1.9		●	23
8595665	**6.65**				37.4	1.9		●	23
61567	**6.7**				37.6	1.9		●	23
8595675	**6.75**	34	78		37.6	1.9		●	24
61568	**6.8**				37.7	2		●	24
8595685	**6.85**				37.8	2		●	24
61569	**6.9**				37.9	2		●	24
8595695	**6.95**				38	2		●	24
61570	**7**				38.6	2		●	24
8595705	**7.05**				38.7	2		●	24

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61571	**7.1**	34	78	8	38.8	2	120°	●	24
8595715	**7.15**				38.9	2.1		●	24
61572	**7.2**				39	2.1		●	25
8595725	**7.25**				39.1	2.1		●	25
61573	**7.3**				39.2	2.1		●	25
8595735	**7.35**				39.3	2.1		●	25
61574	**7.4**				39.7	2.1		●	25
8595745	**7.45**				39.7	2.2		●	25
61575	**7.5**				39.9	2.2		●	25
8595755	**7.55**	37	81		39.9	2.2		●	25
61576	**7.6**				41.5	2.2		●	25
8595765	**7.65**				41.5	2.2		●	26
61577	**7.7**				41.6	2.2		●	26
8595775	**7.75**				41.6	2.2		●	26
61578	**7.8**				41.7	2.3		●	26
8595785	**7.85**				41.7	2.3		●	26
61579	**7.9**				41.6	2.3		●	26
8595795	**7.95**				41.6	2.3		●	26
61580	**8**				42	2.3		●	27
8595805	**8.05**		87		41.9	2.3		●	45
61581	**8.1**				42	2.3		●	45
8595815	**8.15**				42	2.4		●	45
61582	**8.2**				42.1	2.4		●	45
8595825	**8.25**				42.2	2.4		●	46
61583	**8.3**				42.2	2.4		●	46
8595835	**8.35**				42.3	2.4		●	46
61584	**8.4**				43.1	2.4		●	46
8595845	**8.45**				43.1	2.4		●	46
61585	**8.5**				43.2	2.5		●	46
8595855	**8.55**	40	90	10	43.3	2.5		●	47
61586	**8.6**				43.4	2.5		●	47
8595865	**8.65**				43.3	2.5		●	47
61587	**8.7**				43.6	2.5		●	47
8595875	**8.75**				43.6	2.5		●	47
61588	**8.8**				43.7	2.5		●	48
8595885	**8.85**				43.8	2.6		●	47
61589	**8.9**				43.9	2.6		●	48
8595895	**8.95**				44	2.6		●	47
61590	**9**				44.6	2.6		●	48
8595905	**9.05**				44.7	2.6		●	48
61591	**9.1**				44.8	2.6		●	49
8595915	**9.15**				44.9	2.6		●	48
61592	**9.2**				45	2.7		●	49
8595925	**9.25**				45.1	2.7		●	48
61593	**9.3**				45.2	2.7		●	49
8595935	**9.35**				45.3	2.7		●	48
61594	**9.4**				45.8	2.7		●	49
8595945	**9.45**				45.7	2.7		●	49
61595	**9.5**				45.9	2.7		●	49
8595955	**9.55**	43	93		45.9	2.8		●	49
61596	**9.6**				47.5	2.8		●	50
8595965	**9.65**				47.5	2.8		●	50

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直径 DC 9.7～17.7 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | **DH1005**

不锈钢·软钢用超短刃型钻头
STUB FOR STAINLESS STEELS

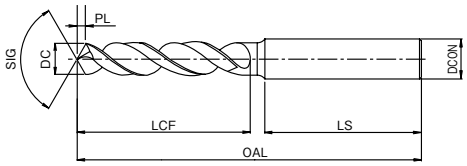
EX-SUS-GDS

切削条件 Cutting Conditions | P.426

最适合用于不锈钢、软钢、铜合金等。
This drill is most suitable for stainless steels, mild steels, and copper alloys.

四棱式横刃
Four Facet point
(DC≦13)

N 型横刃
N thinning
(13< DC)



注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。
All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

HSSE | TiN | h8 注1) | SHANK h7 | 约30° ABOUT30° DC<1 | 35~40° 1≦DC

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FROM 直径 DC 5.7～9.65

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61597	**9.7**				47.6	2.8		●	50
8595975	**9.75**				47.6	2.8		●	50
61598	**9.8**				47.7	2.8		●	51
8595985	**9.85**		93	10	47.7	2.8		●	50
61599	**9.9**				47.7	2.9		●	51
8595995	**9.95**				47.7	2.9		●	50
61600	**10**				48	2.9		●	51
8596005	**10.05**				48.9	2.9		●	69
61601	**10.1**				49	2.9		●	70
8596015	**10.15**	43			49.1	2.9		●	70
61602	**10.2**				49.1	2.9		●	71
8596025	**10.25**				49.2	3		●	70
61603	**10.3**		100		49.2	3		●	71
8596035	**10.35**				49.4	3		●	70
61604	**10.4**				50	3		●	71
8596045	**10.45**				50.1	3		●	71
61605	**10.5**				50.2	3		●	72
8596055	**10.55**				50.3	3		●	72
61606	**10.6**				50.3	3.1		●	72
8596065	**10.65**				50.5	3.1		●	73
61607	**10.7**				50.5	3.1		●	73
8596075	**10.75**				50.6	3.1		●	73
61608	**10.8**				50.7	3.1		●	74
8596085	**10.85**				50.8	3.1		●	74
61609	**10.9**				50.9	3.1		●	74
8596095	**10.95**				51	3.2	120°	●	75
61610	**11**				51.6	3.2		●	74
8596105	**11.05**				51.7	3.2		●	74
61611	**11.1**				51.7	3.2		●	74
8596115	**11.15**			12	51.9	3.2		●	74
61612	**11.2**	47	104		51.9	3.2		●	75
8596125	**11.25**				52.1	3.2		●	75
61613	**11.3**				52.1	3.3		●	75
8596135	**11.35**				52.5	3.3		●	75
61614	**11.4**				52.6	3.3		●	76
8596145	**11.45**				52.8	3.3		●	76
61615	**11.5**				52.8	3.3		●	77
8596155	**11.55**				53	3.3		●	76
61616	**11.6**				55	3.3		●	77
8596165	**11.65**				55	3.4		●	77
61617	**11.7**				55	3.4		●	77
8596175	**11.75**				55	3.4		●	77
61618	**11.8**				55	3.4		●	77
8596185	**11.85**				55	3.4		●	78
61619	**11.9**				55	3.4		●	79
8596195	**11.95**				55	3.4		●	79
61620	**12**				55	3.5		●	80
61621	**12.1**	51	108		55	3.5		●	81
61622	**12.2**				55	3.5		●	81
61623	**12.3**				55	3.6		●	81
61624	**12.4**				55	3.6		●	82
61625	**12.5**				55	3.6		●	82

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61626	**12.6**				55	3.6		●	82
61627	**12.7**				55	3.7		●	84
61628	**12.8**		108	12	55	3.7		●	84
61629	**12.9**	51			55	3.7		●	84
61630	**13**				55	3.8		●	84
61631	**13.1**		111		48	3.8		●	136
61632	**13.2**				48	3.8		●	136
61633	**13.3**				48	3.8		●	139
61634	**13.4**				48	3.9		●	139
61635	**13.5**				48	3.9		●	140
61636	**13.6**	54	114		48	3.9		●	140
61637	**13.7**				48	4		●	140
61638	**13.8**				48	4		●	141
61639	**13.9**				48	4		●	143
61640	**14**				48	4		●	143
61641	**14.1**				48	4.1		●	144
61642	**14.2**				48	4.1		●	145
61643	**14.3**				48	4.1		●	145
61644	**14.4**				48	4.2		●	147
61645	**14.5**				48	4.2		●	147
61646	**14.6**	56	116	16	48	4.2		●	147
61647	**14.7**				48	4.2		●	150
61648	**14.8**				48	4.3		●	149
61649	**14.9**				48	4.3		●	150
61650	**15**				48	4.3		●	150
61651	**15.1**				48	4.4	120°	●	151
61652	**15.2**				48	4.4		●	153
61653	**15.3**				48	4.4		●	153
61654	**15.4**				48	4.4		●	153
61655	**15.5**	58	118		48	4.5		●	155
61656	**15.6**				48	4.5		●	155
61657	**15.7**				48	4.5		●	155
61658	**15.8**				48	4.6		●	157
61659	**15.9**				48	4.6		●	157
61660	**16**				48	4.6		●	158
61661	**16.1**				50	4.6		●	228
61662	**16.2**				50	4.7		●	229
61663	**16.3**				50	4.7		●	229
61664	**16.4**				50	4.7		●	229
61665	**16.5**	60	126		50	4.8		●	231
61666	**16.6**				50	4.8		●	231
61667	**16.7**				50	4.8		●	232
61668	**16.8**				50	4.8		●	233
61669	**16.9**			20	50	4.9		●	233
61670	**17**				50	4.9		●	235
61671	**17.1**				50	4.9		●	235
61672	**17.2**				50	5		●	235
61673	**17.3**				50	5		●	239
61674	**17.4**	62	128		50	5		●	239
61675	**17.5**				50	5.1		●	241
61676	**17.6**				50	5.1		●	241
61677	**17.7**				50	5.1		●	241

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直径 DC 17.8～32 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDS	◎	○								◎				◎	◎	◎				○	

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FROM 直径 **DC** 9.7～17.7

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61678	**17.8**	62	128	20	50	5.1	120°	●	243
61679	**17.9**				50	5.2		●	245
61680	**18**				50	5.2		●	245
61681	**18.1**	64	130		50	5.2		●	248
61682	**18.2**				50	5.3		●	250
61683	**18.3**				50	5.3		●	250
61684	**18.4**				50	5.3		●	250
61685	**18.5**				50	5.3		●	251
61686	**18.6**				50	5.4		●	249
61687	**18.7**				50	5.4		●	251
61688	**18.8**				50	5.4		●	253
61689	**18.9**				50	5.5		●	253
61690	**19**				50	5.5		●	258
61691	**19.1**	66	132		50	5.5		●	261
61692	**19.2**				50	5.5		●	259
61693	**19.3**				50	5.6		●	257
61694	**19.4**				50	5.6		●	263
61695	**19.5**				50	5.6		●	263
61696	**19.6**				50	5.7		●	262
61697	**19.7**				50	5.7		●	267
61698	**19.8**				50	5.7		●	268
61699	**19.9**				50	5.7		●	268
61700	**20**				50	5.8		●	271
61705	**20.5**	68	144	25	56	5.9		●	386

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
61710	**21**	68	144	25	56	6.1	120°	●	393
61715	**21.5**	70	146		56	6.2		●	412
61720	**22**				56	6.4		●	421
61725	**22.5**	72	148		56	6.5		●	430
61730	**23**				56	6.6		●	438
61735	**23.5**				56	6.8		●	445
61740	**24**	75	151		56	6.9		●	459
61745	**24.5**				56	7.1		●	470
61750	**25**				56	7.2		●	480
61755	**25.5**	78	158	32	60	7.4		●	684
61760	**26**				60	7.5		●	696
61765	**26.5**				60	7.6		●	699
61770	**27**	81	161		60	7.8		●	717
61775	**27.5**				60	7.9		●	736
61780	**28**				60	8.1		●	743
61785	**28.5**	84	164		60	8.2		●	753
61790	**29**				60	8.4		●	760
61795	**29.5**				60	8.5		●	770
61800	**30**				60	8.7		●	784
61805	**30.5**	87	167		60	8.8		●	807
61810	**31**				60	8.9		●	815
61815	**31.5**				60	9.1		●	820
61820	**32**	90	170		60	9.2		●	838

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | **DH1006**

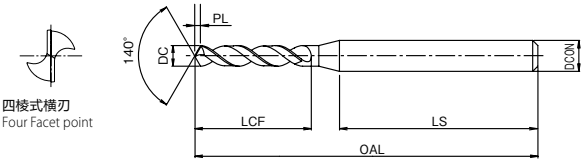
不锈钢·软钢用中等刃长型钻头
MEDIUM FOR STAINLESS AND MILD STEELS

EX-SUS-GDN

切削条件 Cutting Conditions | P.426

最适合用于不锈钢、软钢、铜合金等。
This drill is most suitable for stainless steels, mild steels, and copper alloys.

HSSE | TiN | h8 | SHANK h7 | 35~40°



注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。
All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8610100	**1**	9	41	3	26.9	0.2	●	4
8610101	**1.01**				26.9	0.2	●	3
8610102	**1.02**				26.9	0.2	●	3
8610103	**1.03**				26.9	0.2	●	3
8610104	**1.04**				26.9	0.2	●	3
8610105	**1.05**				26.9	0.2	●	3
8610106	**1.06**				26.9	0.2	●	4
8610107	**1.07**	11	43		27	0.2	●	3
8610108	**1.08**				27	0.2	●	3
8610109	**1.09**				27	0.2	●	3
8610110	**1.1**				27	0.2	●	4
8610111	**1.11**				27	0.2	●	3
8610112	**1.12**				27	0.2	●	3
8610113	**1.13**				27.1	0.2	●	3
8610114	**1.14**				27.1	0.2	●	3
8610115	**1.15**				27.1	0.2	●	3
8610116	**1.16**				27.1	0.2	●	3
8610117	**1.17**				27.1	0.2	●	3
8610118	**1.18**				27.1	0.2	●	3
8610119	**1.19**	12	44		27.2	0.2	●	3
8610120	**1.2**				27.2	0.2	●	4
8610121	**1.21**				27.2	0.2	●	3
8610122	**1.22**				27.2	0.2	●	3
8610123	**1.23**				27.2	0.2	●	3
8610124	**1.24**				27.2	0.2	●	3
8610125	**1.25**				27.2	0.2	●	4
8610126	**1.26**				27.4	0.2	●	3
8610127	**1.27**				27.4	0.2	●	3
8610128	**1.28**				27.4	0.2	●	3
8610129	**1.29**				27.4	0.2	●	3
8610130	**1.3**				27.4	0.2	●	4
8610131	**1.31**				27.4	0.2	●	3
8610132	**1.32**				27.4	0.2	●	3
8610133	**1.33**	14	46		27.5	0.2	●	3
8610134	**1.34**				27.5	0.2	●	3
8610135	**1.35**				27.5	0.2	●	3
8610136	**1.36**				27.5	0.2	●	3
8610137	**1.37**				27.5	0.2	●	3
8610138	**1.38**				27.5	0.3	●	3
8610139	**1.39**				27.5	0.3	●	3
8610140	**1.4**				27.5	0.3	●	4
8610141	**1.41**				27.7	0.3	●	3
8610142	**1.42**				27.7	0.3	●	3
8610143	**1.43**				27.7	0.3	●	3

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8610144	**1.44**	14	46	3	27.7	0.3	●	3
8610145	**1.45**				27.7	0.3	●	4
8610146	**1.46**				27.7	0.3	●	3
8610147	**1.47**				27.7	0.3	●	3
8610148	**1.48**				27.7	0.3	●	3
8610149	**1.49**				27.7	0.3	●	3
8610150	**1.5**				27.7	0.3	●	4
8610151	**1.51**	15	47		27.9	0.3	●	3
8610152	**1.52**				27.9	0.3	●	3
8610153	**1.53**				27.9	0.3	●	3
8610154	**1.54**				27.9	0.3	●	3
8610155	**1.55**				27.9	0.3	●	4
8610156	**1.56**				27.9	0.3	●	3
8610157	**1.57**				27.9	0.3	●	3
8610158	**1.58**				27.9	0.3	●	3
8610159	**1.59**				27.9	0.3	●	3
8610160	**1.6**				27.9	0.3	●	4
8610161	**1.61**				28.1	0.3	●	3
8610162	**1.62**				28.1	0.3	●	3
8610163	**1.63**				28.1	0.3	●	3
8610164	**1.64**				28.1	0.3	●	3
8610165	**1.65**				28.1	0.3	●	4
8610166	**1.66**				28.1	0.3	●	3
8610167	**1.67**				28.1	0.3	●	4
8610168	**1.68**				28.1	0.3	●	3
8610169	**1.69**				28.1	0.3	●	3
8610170	**1.7**				28.1	0.3	●	4
8610171	**1.71**	17	49		28.4	0.3	●	3
8610172	**1.72**				28.4	0.3	●	3
8610173	**1.73**				28.4	0.3	●	3
8610174	**1.74**				28.4	0.3	●	3
8610175	**1.75**				28.4	0.3	●	4
8610176	**1.76**				28.4	0.3	●	3
8610177	**1.77**				28.4	0.3	●	3
8610178	**1.78**				28.4	0.3	●	3
8610179	**1.79**				28.4	0.3	●	3
8610180	**1.8**				28.4	0.3	●	4
8610181	**1.81**				28.4	0.3	●	3
8610182	**1.82**				28.4	0.3	●	3
8610183	**1.83**				28.4	0.3	●	3
8610184	**1.84**				28.4	0.3	●	3
8610185	**1.85**				28.4	0.3	●	4
8610186	**1.86**				28.4	0.3	●	4
8610187	**1.87**				28.4	0.3	●	4

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直径 DC 1.88～1.99 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDN	◎	○								◎				◎	◎	◎				○	

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FROM 直径 DC 1～1.87

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8610188	**1.88**	17	49	3	28.4	0.3	●	4
8610189	**1.89**				28.4	0.3	●	4
8610190	**1.9**				28.4	0.3	●	4
8610191	**1.91**	18	50		28.7	0.3	●	4
8610192	**1.92**				28.7	0.3	●	4
8610193	**1.93**				28.7	0.4	●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8610194	**1.94**	18	50	3	28.7	0.4	●	4
8610195	**1.95**				28.7	0.4	●	4
8610196	**1.96**				28.7	0.4	●	4
8610197	**1.97**				28.7	0.4	●	4
8610198	**1.98**				28.7	0.4	●	4
8610199	**1.99**				28.7	0.4	●	4

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | **DH1007**

不锈钢·软钢用标准刃长型钻头

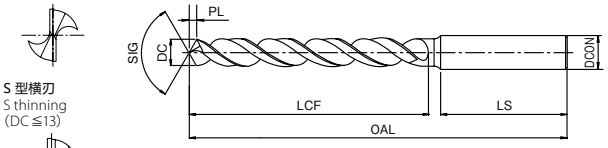
REGULAR FOR STAINLESS STEELS

EX-SUS-GDR

切削条件 Cutting Conditions | P.426

最适用于不锈钢、软钢、铝合金、铜合金等的标准槽长系列。

The regular flute length series is ideal for stainless steels, mild steels, and aluminum alloys.



S 型横刃
S thinning
(DC≦13)

N 型横刃
N thinning
(13<DC)

HSSE | TiN | h8 | SHANK h7 | 35~40°

注1)

注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。

All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
62520	**2**	24	56	3	28.7	0.5	130°	●	4
8597201	**2.01**				28.8	0.5		●	4
8597202	**2.02**				28.8	0.5		●	4
8597203	**2.03**				28.8	0.5		●	4
8597204	**2.04**				28.8	0.5		●	4
8597205	**2.05**				28.8	0.5		●	4
8597206	**2.06**				29	0.5		●	4
8597207	**2.07**				29	0.5		●	4
8597208	**2.08**				29	0.5		●	4
8597209	**2.09**				29	0.5		●	4
62521	**2.1**				28.9	0.5		●	4
8597211	**2.11**				29	0.5		●	4
8597212	**2.12**				29	0.5		●	4
8597213	**2.13**	27	59		29.1	0.5		●	4
8597214	**2.14**				29.1	0.5		●	4
8597215	**2.15**				29	0.5		●	4
8597216	**2.16**				29.1	0.5		●	4
8597217	**2.17**				29.1	0.5		●	4
8597218	**2.18**				29.3	0.5		●	4
8597219	**2.19**				29.3	0.5		●	4
62522	**2.2**				29	0.5		●	4
8597221	**2.21**				29.3	0.5		●	4
8597222	**2.22**				29.3	0.5		●	4
8597223	**2.23**				29.3	0.5		●	4
8597224	**2.24**				29.3	0.5		●	4
8597225	**2.25**				29.1	0.5		●	4
8597226	**2.26**				29.3	0.5		●	4
8597227	**2.27**				29.3	0.5		●	4
8597228	**2.28**				29.3	0.5		●	4
8597229	**2.29**				29.3	0.5		●	4
62523	**2.3**				29.2	0.5		●	4
8597231	**2.31**				29.4	0.5		●	4
8597232	**2.32**				29.4	0.5		●	4
8597233	**2.33**				29.4	0.5		●	4
8597234	**2.34**				29.4	0.5		●	4
8597235	**2.35**				29.3	0.5		●	4
8597236	**2.36**				29.4	0.6		●	4
8597237	**2.37**	30	62		29.5	0.6		●	4
8597238	**2.38**				29.5	0.6		●	4
8597239	**2.39**				29.5	0.6		●	4
62524	**2.4**				29.5	0.6		●	4
8597241	**2.41**				29.5	0.6		●	4
8597242	**2.42**				29.5	0.6		●	4
8597243	**2.43**				29.5	0.6		●	4
8597244	**2.44**				29.5	0.6		●	4
8597245	**2.45**				29.5	0.6		●	4
8597246	**2.46**				29.7	0.6		●	4
8597247	**2.47**				29.7	0.6		●	4
8597248	**2.48**				29.7	0.6		●	4
8597249	**2.49**				29.7	0.6		●	4
62525	**2.5**				29.6	0.6		●	4
8597251	**2.51**				29.7	0.6		●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8597252	**2.52**	30	62	3	29.7	0.6	130°	●	4
8597253	**2.53**				29.7	0.6		●	4
8597254	**2.54**				29.7	0.6		●	4
8597255	**2.55**				29.7	0.6		●	4
8597256	**2.56**				29.8	0.6		●	4
8597257	**2.57**				29.8	0.6		●	4
8597258	**2.58**				29.8	0.6		●	4
8597259	**2.59**				29.8	0.6		●	4
62526	**2.6**				29.8	0.6		●	4
8597261	**2.61**				29.8	0.6		●	4
8597262	**2.62**				29.8	0.6		●	4
8597263	**2.63**				29.8	0.6		●	4
8597264	**2.64**				29.8	0.6		●	4
8597265	**2.65**				29.9	0.6		●	4
8597266	**2.66**	33	65		30	0.6		●	4
8597267	**2.67**				30	0.6		●	4
8597268	**2.68**				30	0.6		●	6
8597269	**2.69**				30	0.6		●	6
62527	**2.7**				30	0.6		●	4
8597271	**2.71**				30	0.6		●	6
8597272	**2.72**				30	0.6		●	6
8597273	**2.73**				30	0.6		●	6
8597274	**2.74**				30	0.6		●	6
8597275	**2.75**				30.1	0.6		●	4
8597276	**2.76**				30.1	0.6		●	4
8597277	**2.77**				30.1	0.6		●	4
8597278	**2.78**				30.1	0.6		●	4
8597279	**2.79**				30.1	0.7		●	6
62528	**2.8**				30.2	0.7		●	5
8597281	**2.81**				30.2	0.7		●	4
8597282	**2.82**				30.2	0.7		●	6
8597283	**2.83**				30.2	0.7		●	4
8597284	**2.84**				30.2	0.7		●	6
8597285	**2.85**				30.2	0.7		●	4
8597286	**2.86**				30.2	0.7		●	6
8597287	**2.87**				30.2	0.7		●	6
8597288	**2.88**				30.3	0.7		●	6
8597289	**2.89**				30.3	0.7		●	6
62529	**2.9**				30.3	0.7		●	5
8597291	**2.91**				30.3	0.7		●	6
8597292	**2.92**				30.4	0.7		●	6
8597293	**2.93**				30.4	0.7		●	6
8597294	**2.94**				30.4	0.7		●	6
8597295	**2.95**				30.4	0.7		●	5
8597296	**2.96**				30.5	0.7		●	6
8597297	**2.97**				30.5	0.7		●	6
8597298	**2.98**				30.5	0.7		●	5
8597299	**2.99**				30.5	0.7		●	6
62530	**3**				30.5	0.7		●	5
8597301	**3.01**	36	68	4	28.8	0.7	130°	●	7
8597302	**3.02**				28.8	0.7		●	7
8597303	**3.03**				28.8	0.7		●	7

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直径 DC 3.04 ~ 4.07 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDR	◎	○								◎				◎	◎	◎				○	

上一页
FROM 直径 DC 2～3.03

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8597304	**3.04**	36	68	4	28.8	0.7	130°	●	6
8597305	**3.05**				28.7	0.7		●	6
8597306	**3.06**				28.8	0.7		●	6
8597307	**3.07**				28.8	0.7		●	6
8597308	**3.08**				28.8	0.7		●	6
8597309	**3.09**				28.8	0.7		●	6
62531	**3.1**				28.8	0.7		●	7
8597311	**3.11**				29	0.7		●	8
8597312	**3.12**				29	0.7		●	8
8597313	**3.13**				29	0.7		●	8
8597314	**3.14**				29	0.7		●	8
8597315	**3.15**				28.9	0.7		●	7
8597316	**3.16**				29	0.7		●	7
8597317	**3.17**				29	0.7		●	8
8597318	**3.18**				29	0.7		●	7
8597319	**3.19**				29	0.7		●	8
62532	**3.2**				29	0.7		●	7
8597321	**3.21**				29.2	0.7		●	7
8597322	**3.22**				29.2	0.8		●	7
8597323	**3.23**				29.2	0.8		●	8
8597324	**3.24**				29.2	0.8		●	8
8597325	**3.25**				29.1	0.8		●	7
8597326	**3.26**				29.2	0.8		●	8
8597327	**3.27**				29.2	0.8		●	8
8597328	**3.28**				29.2	0.8		●	8
8597329	**3.29**				29.2	0.8		●	8
62533	**3.3**				29.2	0.8		●	7
8597331	**3.31**				29.3	0.8		●	8
8597332	**3.32**				29.3	0.8		●	8
8597333	**3.33**				29.3	0.8		●	7
8597334	**3.34**				29.3	0.8		●	8
8597335	**3.35**				29.3	0.8		●	7
8597336	**3.36**	39	71		29.5	0.8		●	8
8597337	**3.37**				29.5	0.8		●	8
8597338	**3.38**				29.5	0.8		●	8
8597339	**3.39**				29.5	0.8		●	8
62534	**3.4**				29.5	0.8		●	7
8597341	**3.41**				29.5	0.8		●	8
8597342	**3.42**				29.5	0.8		●	8
8597343	**3.43**				29.7	0.8		●	8
8597344	**3.44**				29.7	0.8		●	8
8597345	**3.45**				29.6	0.8		●	7
8597346	**3.46**				29.7	0.8		●	8
8597347	**3.47**				29.7	0.8		●	8
8597348	**3.48**				29.7	0.8		●	8
8597349	**3.49**				29.8	0.8		●	8
62535	**3.5**				29.7	0.8		●	7
8597351	**3.51**				29.8	0.8		●	8
8597352	**3.52**				29.8	0.8		●	8
8597353	**3.53**				29.8	0.8		●	8
8597354	**3.54**				29.8	0.8		●	8
8597355	**3.55**				29.8	0.8		●	7

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8597356	**3.56**	39	71	4	30	0.8	130°	●	8
8597357	**3.57**				30	0.8		●	8
8597358	**3.58**				30	0.8		●	8
8597359	**3.59**				30	0.8		●	8
62536	**3.6**				29.8	0.8		●	7
8597361	**3.61**				30	0.8		●	8
8597362	**3.62**				30	0.8		●	8
8597363	**3.63**				30.1	0.8		●	8
8597364	**3.64**				30.1	0.8		●	8
8597365	**3.65**				29.9	0.9		●	7
8597366	**3.66**				30.1	0.9		●	7
8597367	**3.67**				30.1	0.9		●	7
8597368	**3.68**				30.1	0.9		●	7
8597369	**3.69**				30.2	0.9		●	8
62537	**3.7**				30	0.9		●	7
8597371	**3.71**				30.2	0.9		●	8
8597372	**3.72**				30.2	0.9		●	8
8597373	**3.73**				30.2	0.9		●	8
8597374	**3.74**				30.2	0.9		●	8
8597375	**3.75**				30.1	0.9		●	7
8597376	**3.76**	43	75		30.4	0.9		●	8
8597377	**3.77**				30.4	0.9		●	8
8597378	**3.78**				30.4	0.9		●	8
8597379	**3.79**				30.4	0.9		●	8
62538	**3.8**				30.2	0.9		●	8
8597381	**3.81**				30.4	0.9		●	8
8597382	**3.82**				30.4	0.9		●	8
8597383	**3.83**				30.4	0.9		●	8
8597384	**3.84**				30.4	0.9		●	8
8597385	**3.85**				30.3	0.9		●	8
8597386	**3.86**				30.4	0.9		●	8
8597387	**3.87**				30.4	0.9		●	8
8597388	**3.88**				30.4	0.9		●	8
8597389	**3.89**				30.4	0.9		●	8
62539	**3.9**				30.3	0.9		●	8
8597391	**3.91**				30.4	0.9		●	8
8597392	**3.92**				30.5	0.9		●	8
8597393	**3.93**				30.5	0.9		●	8
8597394	**3.94**				30.5	0.9		●	8
8597395	**3.95**				30.4	0.9		●	8
8597396	**3.96**				30.5	0.9		●	8
8597397	**3.97**				30.5	0.9		●	8
8597398	**3.98**				30.5	0.9		●	8
8597399	**3.99**				30.5	0.9		●	8
62540	**4**				30.5	0.9		●	8
8597401	**4.01**	87		6	35.8	1.2	120°	●	14
8597402	**4.02**				35.8	1.2		●	14
8597403	**4.03**				35.8	1.2		●	14
8597404	**4.04**				35.8	1.2		●	14
8597405	**4.05**				35.8	1.2		●	14
8597406	**4.06**				36	1.2		●	14
8597407	**4.07**				36	1.2		●	14

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直径 DC 4.08～5.11 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DH1007**

不锈钢·软钢用标准刃长型钻头

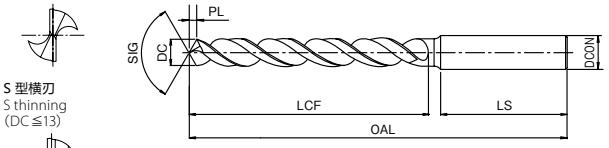
REGULAR FOR STAINLESS STEELS

EX-SUS-GDR

切削条件 Cutting Conditions | P.426

最适用于不锈钢、软钢、铝合金、铜合金等的标准槽长系列。

The regular flute length series is ideal for stainless steels, mild steels, and aluminum alloys.



S 型横刃
S thinning
(DC≦13)

N 型横刃
N thinning
(13<DC)

注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。

All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

HSSE | TiN | h8 | SHANK h7 | 35~40°

注1)

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FROM 直径 DC 3.04 ~ 4.07

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8597408	**4.08**	43	87	6	36	1.2	120°	●	14
8597409	**4.09**				36	1.2		●	14
62541	**4.1**				36	1.2		●	14
8597411	**4.11**				36	1.2		●	19
8597412	**4.12**				36	1.2		●	19
8597413	**4.13**				36	1.2		●	19
8597414	**4.14**				36	1.2		●	19
8597415	**4.15**				36	1.2		●	14
8597416	**4.16**				36.2	1.2		●	19
8597417	**4.17**				36.2	1.2		●	19
8597418	**4.18**				36.2	1.2		●	19
8597419	**4.19**				36.2	1.2		●	19
62542	**4.2**				36.2	1.2		●	14
8597421	**4.21**				36.2	1.2		●	19
8597422	**4.22**				36.2	1.2		●	15
8597423	**4.23**				36.2	1.2		●	19
8597424	**4.24**				36.2	1.2		●	19
8597425	**4.25**				36.2	1.2		●	14
8597426	**4.26**				36.4	1.2		●	19
8597427	**4.27**				36.4	1.2		●	19
8597428	**4.28**				36.4	1.2		●	19
8597429	**4.29**				36.4	1.2		●	19
62543	**4.3**				36.4	1.2		●	14
8597431	**4.31**				36.3	1.2		●	19
8597432	**4.32**				36.3	1.2		●	19
8597433	**4.33**				36.3	1.2		●	19
8597434	**4.34**				36.3	1.3		●	19
8597435	**4.35**				36.3	1.3		●	14
8597436	**4.36**				37.1	1.3		●	19
8597437	**4.37**				37.1	1.3		●	19
8597438	**4.38**				37.1	1.3		●	19
8597439	**4.39**				37.1	1.3		●	19
62544	**4.4**				37.1	1.3		●	14
8597441	**4.41**	47	91		37.1	1.3		●	19
8597442	**4.42**				37.1	1.3		●	19
8597443	**4.43**				37.1	1.3		●	19
8597444	**4.44**				37.1	1.3		●	19
8597445	**4.45**				37.1	1.3		●	15
8597446	**4.46**				37.3	1.3		●	19
8597447	**4.47**				37.3	1.3		●	19
8597448	**4.48**				37.3	1.3		●	19
8597449	**4.49**				37.3	1.3		●	19
62545	**4.5**				37.3	1.3		●	15
8597451	**4.51**				37.3	1.3		●	19
8597452	**4.52**				37.3	1.3		●	19
8597453	**4.53**				37.3	1.3		●	19
8597454	**4.54**				37.3	1.3		●	19
8597455	**4.55**				37.3	1.3		●	15
8597456	**4.56**				37.5	1.3		●	19
8597457	**4.57**				37.5	1.3		●	19
8597458	**4.58**				37.5	1.3		●	19
8597459	**4.59**				37.5	1.3		●	19

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
62546	**4.6**	47	91	6	37.5	1.3	120°	●	15
8597461	**4.61**				37.4	1.3		●	19
8597462	**4.62**				37.4	1.3		●	19
8597463	**4.63**				37.4	1.3		●	19
8597464	**4.64**				37.4	1.3		●	19
8597465	**4.65**				37.4	1.3		●	15
8597466	**4.66**				37.6	1.3		●	19
8597467	**4.67**				37.6	1.3		●	19
8597468	**4.68**				37.6	1.4		●	19
8597469	**4.69**				37.6	1.4		●	19
62547	**4.7**				37.6	1.4		●	15
8597471	**4.71**				37.6	1.4		●	19
8597472	**4.72**				37.6	1.4		●	19
8597473	**4.73**				37.6	1.4		●	19
8597474	**4.74**				37.6	1.4		●	19
8597475	**4.75**				37.6	1.4		●	15
8597476	**4.76**	52	96		37.9	1.4		●	16
8597477	**4.77**				37.9	1.4		●	19
8597478	**4.78**				37.9	1.4		●	19
8597479	**4.79**				37.9	1.4		●	19
62548	**4.8**				37.9	1.4		●	16
8597481	**4.81**				37.8	1.4		●	21
8597482	**4.82**				37.8	1.4		●	15
8597483	**4.83**				37.8	1.4		●	15
8597484	**4.84**				37.8	1.4		●	15
8597485	**4.85**				37.8	1.4		●	15
8597486	**4.86**				38.6	1.4		●	16
8597487	**4.87**				38.6	1.4		●	20
8597488	**4.88**				38.6	1.4		●	21
8597489	**4.89**				38.6	1.4		●	16
62549	**4.9**				38.6	1.4		●	16
8597491	**4.91**				38	1.4		●	16
8597492	**4.92**				38	1.4		●	16
8597493	**4.93**				38	1.4		●	16
8597494	**4.94**				38	1.4		●	16
8597495	**4.95**				38	1.4		●	16
8597496	**4.96**				38.8	1.4		●	20
8597497	**4.97**				38.8	1.4		●	20
8597498	**4.98**				38.8	1.4		●	20
8597499	**4.99**				38.8	1.4		●	20
62550	**5**				38.8	1.4		●	16
8597501	**5.01**				38.7	1.4		●	17
8597502	**5.02**				38.7	1.4		●	20
8597503	**5.03**				38.7	1.5		●	20
8597504	**5.04**				38.7	1.5		●	17
8597505	**5.05**				38.7	1.5		●	16
8597506	**5.06**				38.9	1.5		●	20
8597507	**5.07**				38.9	1.5		●	20
8597508	**5.08**				38.9	1.5		●	20
8597509	**5.09**				38.9	1.5		●	20
62551	**5.1**				38.9	1.5		●	16
8597511	**5.11**				38.9	1.5		●	20

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直径 DC 5.12 ~ 6.75 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDR	◎	○								◎				◎	◎	◎				○	

上一页
FROM 直径 DC 4.08～5.11

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8597512	**5.12**	52	96	6	38.9	1.5	120°	●	20
8597513	**5.13**				38.9	1.5		●	20
8597514	**5.14**				38.9	1.5		●	20
8597515	**5.15**				38.9	1.5		●	16
8597516	**5.16**				39.1	1.5		●	20
8597517	**5.17**				39.1	1.5		●	20
8597518	**5.18**				39.1	1.5		●	20
8597519	**5.19**				39.1	1.5		●	20
62552	**5.2**				39.1	1.5		●	17
8597521	**5.21**				39	1.5		●	20
8597522	**5.22**				39	1.5		●	20
8597523	**5.23**				39	1.5		●	20
8597524	**5.24**				39	1.5		●	20
8597525	**5.25**				39	1.5		●	17
8597526	**5.26**				39.6	1.5		●	20
8597527	**5.27**				39.6	1.5		●	20
8597528	**5.28**				39.6	1.5		●	20
8597529	**5.29**				39.6	1.5		●	20
62553	**5.3**				39.6	1.5		●	17
8597531	**5.31**	57	101		39.2	1.5		●	20
8597532	**5.32**				39.2	1.5		●	20
8597533	**5.33**				39.2	1.5		●	20
8597534	**5.34**				39.2	1.5		●	20
8597535	**5.35**				39.2	1.5		●	17
8597536	**5.36**				39.8	1.5		●	20
8597537	**5.37**				39.8	1.6		●	20
8597538	**5.38**				39.8	1.6		●	20
8597539	**5.39**				39.8	1.6		●	21
62554	**5.4**				39.8	1.6		●	17
8597541	**5.41**				39.7	1.6		●	21
8597542	**5.42**				39.7	1.6		●	21
8597543	**5.43**				39.7	1.6		●	21
8597544	**5.44**				39.7	1.6		●	21
8597545	**5.45**				39.7	1.6		●	17
8597546	**5.46**				39.7	1.6		●	21
8597547	**5.47**				39.7	1.6		●	21
8597548	**5.48**				39.7	1.6		●	21
8597549	**5.49**				39.7	1.6		●	21
62555	**5.5**				39.7	1.6		●	18
8597551	**5.51**				39.9	1.6		●	21
8597552	**5.52**				39.9	1.6		●	21
8597553	**5.53**				39.9	1.6		●	21
8597554	**5.54**				39.9	1.6		●	21
8597555	**5.55**				39.9	1.6		●	18
8597556	**5.56**				40.1	1.6		●	21
8597557	**5.57**				39.9	1.6		●	21
8597558	**5.58**				39.9	1.6		●	21
8597559	**5.59**				39.9	1.6		●	21
62556	**5.6**				41.6	1.6		●	18
8597561	**5.61**				41.6	1.6		●	21
8597562	**5.62**				41.6	1.6		●	21
8597563	**5.63**				41.6	1.6		●	21

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8597564	**5.64**	57	101	6	41.6	1.6	120°	●	21
8597565	**5.65**				41.6	1.6		●	18
8597566	**5.66**				41.6	1.6		●	21
8597567	**5.67**				41.6	1.6		●	21
8597568	**5.68**				41.6	1.6		●	21
8597569	**5.69**				41.6	1.6		●	21
62557	**5.7**				41.6	1.6		●	18
8597571	**5.71**				41.7	1.6		●	21
8597572	**5.72**				41.7	1.7		●	21
8597573	**5.73**				41.7	1.7		●	21
8597574	**5.74**				41.7	1.7		●	21
8597575	**5.75**				41.7	1.7		●	18
8597576	**5.76**				41.6	1.7		●	21
8597577	**5.77**				41.6	1.7		●	21
8597578	**5.78**				41.6	1.7		●	21
8597579	**5.79**				41.6	1.7		●	21
62558	**5.8**				41.6	1.7		●	18
8597581	**5.81**				41.7	1.7		●	21
8597582	**5.82**				41.7	1.7		●	22
8597583	**5.83**				41.7	1.7		●	22
8597584	**5.84**				41.7	1.7		●	22
8597585	**5.85**				41.7	1.7		●	19
8597586	**5.86**				41.6	1.7		●	22
8597587	**5.87**				41.6	1.7		●	22
8597588	**5.88**				41.6	1.7		●	22
8597589	**5.89**				41.6	1.7		●	22
62559	**5.9**				41.6	1.7		●	19
8597591	**5.91**				41.8	1.7		●	22
8597592	**5.92**				41.8	1.7		●	22
8597593	**5.93**				41.8	1.7		●	22
8597594	**5.94**				41.8	1.7		●	22
8597595	**5.95**				41.8	1.7		●	19
8597596	**5.96**				42	1.7		●	22
8597597	**5.97**				42	1.7		●	22
8597598	**5.98**				42	1.7		●	22
8597599	**5.99**				42	1.7		●	22
62560	**6**				42	1.7		●	19
8597605	**6.05**	63	107	8	35.9	1.7	120°	●	27
62561	**6.1**				36.1	1.8		●	28
8597615	**6.15**				36.1	1.8		●	27
62562	**6.2**				36.3	1.8		●	28
8597625	**6.25**				36.2	1.8		●	28
62563	**6.3**				37	1.8		●	28
8597635	**6.35**				36.4	1.8		●	28
62564	**6.4**				37.2	1.8		●	28
8597645	**6.45**				37.1	1.9		●	29
62565	**6.5**				37.2	1.9		●	29
8597655	**6.55**				37.3	1.9		●	29
62566	**6.6**				37.5	1.9		●	29
8597665	**6.65**				37.5	1.9		●	30
62567	**6.7**				37.7	1.9		●	30
8597675	**6.75**	69	113		37.6	1.9		●	30

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直径 DC 6.8～11.36 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DH1007**

不锈钢·软钢用标准刃长型钻头

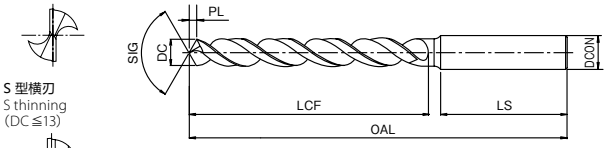
REGULAR FOR STAINLESS STEELS

EX-SUS-GDR

切削条件 Cutting Conditions | P.426

最适用于不锈钢、软钢、铝合金、铜合金等的标准槽长系列。

The regular flute length series is ideal for stainless steels, mild steels, and aluminum alloys.



S 型横刃
S thinning
(DC≦13)

N 型横刃
N thinning
(13<DC)

注1) 除去刃径为0.05mm 整数倍数的型号以外，其它刃径公差都在0~-0.009mm。

All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

HSSE | TiN | h8 | SHANK h7 | 35~40°

注1)

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FROM 直径 DC 5.12～6.75

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
62568	**6.8**	69	113	8	37.9	2	120°	●	30
8597685	**6.85**				37.8	2		●	31
62569	**6.9**				38.6	2		●	31
8597695	**6.95**				38	2		●	31
62570	**7**				38.8	2		●	31
8597705	**7.05**				39	2		●	32
62571	**7.1**				39	2		●	32
8597715	**7.15**				39.2	2.1		●	32
62572	**7.2**				39.2	2.1		●	32
8597725	**7.25**				39.6	2.1		●	32
62573	**7.3**				39.6	2.1		●	32
8597734	**7.34**				39.7	2.1		●	32
8597735	**7.35**				39.8	2.1		●	32
8597736	**7.36**				39.7	2.1		●	33
62574	**7.4**				39.8	2.1		●	33
8597745	**7.45**				41.5	2.2		●	33
62575	**7.5**				41.5	2.2		●	33
8597752	**7.52**	75	119		41.6	2.2		●	36
8597755	**7.55**				41.6	2.2		●	34
62576	**7.6**				41.6	2.2		●	34
8597765	**7.65**				41.7	2.2		●	34
62577	**7.7**				41.7	2.2		●	35
8597775	**7.75**				41.6	2.2		●	33
62578	**7.8**				41.8	2.3		●	35
8597785	**7.85**				41.7	2.3		●	35
62579	**7.9**				41.7	2.3		●	35
8597795	**7.95**				41.8	2.3		●	35
62580	**8**				42	2.3		●	36
8597805	**8.05**		125	10	42.1	2.3		●	53
62581	**8.1**				42.1	2.3		●	53
8597815	**8.15**				42.3	2.4		●	53
62582	**8.2**				42.3	2.4		●	53
8597825	**8.25**				43	2.4		●	54
62583	**8.3**				43	2.4		●	54
8597835	**8.35**				43.2	2.4		●	55
62584	**8.4**				43.2	2.4		●	54
8597845	**8.45**				43.4	2.4		●	55
62585	**8.5**				43.4	2.5		●	55
8597855	**8.55**	81	131		43.5	2.5		●	56
62586	**8.6**				43.5	2.5		●	57
8597865	**8.65**				43.7	2.5		●	57
62587	**8.7**				43.7	2.5		●	57
8597875	**8.75**				43.9	2.5		●	57
62588	**8.8**				43.9	2.5		●	58
8597885	**8.85**				44.6	2.6		●	58
62589	**8.9**				44.6	2.6		●	58
8597895	**8.95**				44.8	2.6		●	58
62590	**9**				44.8	2.6		●	59
8597905	**9.05**				44.8	2.6		●	59
62591	**9.1**				45	2.6		●	60
8597915	**9.15**				44.9	2.6		●	59
62592	**9.2**				45.2	2.7		●	60

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
8597924	**9.24**	81	131	10	45.2	2.7	120°	●	60
8597925	**9.25**				45.4	2.7		●	60
8597926	**9.26**				45.5	2.7		●	60
62593	**9.3**				45.6	2.7		●	60
8597934	**9.34**				45.7	2.7		●	60
8597935	**9.35**				45.8	2.7		●	61
8597936	**9.36**				45.7	2.7		●	60
62594	**9.4**				45.8	2.7		●	60
8597945	**9.45**				48	2.7		●	61
62595	**9.5**				47.5	2.7		●	61
8597952	**9.52**	87	137		48	2.7		●	63
8597955	**9.55**				48	2.8		●	63
62596	**9.6**				47.6	2.8		●	63
8597965	**9.65**				48	2.8		●	64
62597	**9.7**				47.7	2.8		●	64
8597975	**9.75**				48	2.8		●	64
62598	**9.8**				47.8	2.8		●	64
8597985	**9.85**				48	2.8		●	65
62599	**9.9**				47.7	2.9		●	65
8597995	**9.95**				48	2.9		●	66
62600	**10**				48	2.9		●	65
8598005	**10.05**	87	144	12	48.9	2.9	120°	●	82
62601	**10.1**				48.9	2.9		●	81
8598015	**10.15**				49	2.9		●	81
62602	**10.2**				49.1	2.9		●	81
8598025	**10.25**				49.2	3		●	81
62603	**10.3**				49.2	3		●	82
8598035	**10.35**				50	3		●	82
62604	**10.4**				50	3		●	84
8598045	**10.45**				50.1	3		●	83
62605	**10.5**				50.2	3		●	84
8598055	**10.55**				50.3	3		●	85
62606	**10.6**				50.3	3.1		●	84
8598065	**10.65**	94	151		50.5	3.1		●	86
62607	**10.7**				50.5	3.1		●	87
8598075	**10.75**				50.7	3.1		●	87
62608	**10.8**				50.8	3.1		●	88
8598085	**10.85**				51.6	3.1		●	87
62609	**10.9**				51.7	3.1		●	88
8598095	**10.95**				51.8	3.2		●	88
62610	**11**				51.7	3.2		●	89
8598105	**11.05**				51.8	3.2		●	89
62611	**11.1**				51.9	3.2		●	90
8598115	**11.15**				52	3.2		●	90
62612	**11.2**				52.5	3.2		●	90
8598122	**11.22**				52.6	3.2		●	91
8598124	**11.24**				52.6	3.2		●	92
8598125	**11.25**				52.6	3.2		●	91
62613	**11.3**				52.7	3.3		●	91
8598134	**11.34**				52.8	3.3		●	91
8598135	**11.35**				52.7	3.3		●	91
8598136	**11.36**				52.7	3.3		●	91

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直径 DC 11.4～32 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-SUS-GDR	◎	○								◎				◎	◎	◎				○	

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FROM 直径 **DC** **6.8～11.36**

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
62614	**11.4**	94	151	12	52.8	3.3	120°	●	91
8598145	**11.45**				54.5	3.3		●	91
62615	**11.5**				54.5	3.3		●	92
8598155	**11.55**				55	3.3		●	92
62616	**11.6**				54.5	3.3		●	93
8598165	**11.65**				55	3.4		●	93
62617	**11.7**				54.6	3.4		●	94
8598175	**11.75**				55	3.4		●	95
62618	**11.8**				54.6	3.4		●	94
8598185	**11.85**	101	158		55	3.4		●	96
62619	**11.9**				54.7	3.4		●	97
8598195	**11.95**				55	3.4		●	99
62620	**12**				55	3.5		●	98
62621	**12.1**				55	3.5		●	100
62622	**12.2**				55	3.5		●	100
62623	**12.3**				55	3.6		●	101
62624	**12.4**				55	3.6		●	103
62625	**12.5**				55	3.6		●	103
62626	**12.6**				55	3.6		●	104
62627	**12.7**				55	3.7		●	105
62628	**12.8**				55	3.7		●	106
62629	**12.9**				55	3.7		●	107
62630	**13**				55	3.8		●	107
62635	**13.5**	106	166	16	48	3.9		●	166
62640	**14**				48	4		●	171
62641	**14.1**	109	169		48	4.1		●	171
62645	**14.5**				48	4.2		●	178
62650	**15**				48	4.3		●	182
62655	**15.5**	112	172		48	4.5		●	187
62656	**15.6**				48	4.5		●	189

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	库存 Stock	重量 (g)
62660	**16**	112	172	16	58	4.6	120°	●	196
62665	**16.5**	115	181	20	50	4.8		●	285
62670	**17**				50	4.9		●	293
62675	**17.5**	118	184		50	5.1		●	302
62676	**17.6**				50	5.1		●	299
62680	**18**				50	5.2		●	311
62685	**18.5**	122	188		50	5.3		●	323
62690	**19**				50	5.5		●	330
62695	**19.5**	125	191		50	5.6		●	336
62696	**19.6**				50	5.7		●	342
62700	**20**				50	5.8		●	355
62705	**20.5**	128	204	25	56	5.9		●	467
62710	**21**				56	6.1		●	476
62715	**21.5**	132	208		56	6.2		●	490
62720	**22**				56	6.4		●	501
62725	**22.5**	136	212		56	6.5		●	510
62730	**23**				56	6.6		●	522
62735	**23.5**				56	6.8		●	544
62740	**24**	140	216		56	6.9		●	560
62745	**24.5**				56	7.1		●	571
62750	**25**				56	7.2		●	584
62755	**25.5**	145	225	32	60	7.4		●	798
62760	**26**				60	7.5		●	800
62765	**26.5**				60	7.6		●	806
62770	**27**	150	230		60	7.8		●	828
62780	**28**				60	8.1		●	868
62790	**29**	155	235		60	8.4		●	911
62800	**30**				60	8.7		●	945
62810	**31**	160	240		60	8.9		●	990
62820	**32**	165	245		60	9.2		●	1,055

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DH1013**

不锈钢·软钢用MT柄钻头

REGULAR WITH MORSE TAPER SHANK FOR STAINLESS STEELS

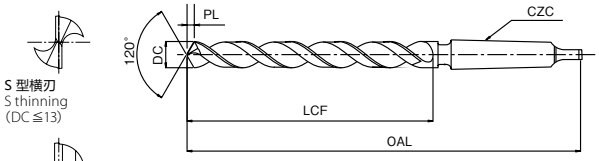
MT-SUS-GDR

切削条件 Cutting Conditions | P.426

莫氏锥柄系列，广泛适用于普通设备。

MT shank series is added. EX-SUS drill is get easier to be used in a conventional machine.

HSSE | TiN | h8 | 35~40°



单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
65060	**6**	57	137	MT1	1.7	●	66
65065	**6.5**	63	143		1.9	●	68
65068	**6.8**	69	149		2	●	70
65070	**7**				2	●	71
65075	**7.5**				2.2	●	73
65080	**8**	75	155		2.3	●	76
65085	**8.5**		158		2.5	●	81
65090	**9**	81	164		2.6	●	81
65095	**9.5**				2.7	●	83
65100	**10**	87	170		2.9	●	90
65103	**10.3**				3	●	88
65105	**10.5**				3	●	91
65110	**11**	94	177		3.2	●	96
65115	**11.5**				3.3	●	100
65120	**12**	101	184		3.5	●	111
65125	**12.5**				3.6	●	116
65130	**13**				3.8	●	118
65135	**13.5**	106	189		3.9	●	121
65140	**14**				4	●	130
65145	**14.5**	109	209	MT2	4.2	●	231
65150	**15**				4.3	●	235
65155	**15.5**	112	212		4.5	●	248
65160	**16**				4.6	●	252
65165	**16.5**	115	215		4.8	●	262
65170	**17**				4.9	●	267
65175	**17.5**	118	218		5.1	●	275
65180	**18**				5.2	●	283
65185	**18.5**	122	222		5.3	●	295
65190	**19**				5.5	●	304
65195	**19.5**	125	225		5.6	●	314
65200	**20**				5.8	●	335
65205	**20.5**	128	228		5.9	●	353
65210	**21**				6.1	●	361
65215	**21.5**	132	232		6.2	●	376
65220	**22**				6.4	●	391
65225	**22.5**	136	236		6.5	●	398
65230	**23**				6.6	●	413

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
65235	**23.5**	136	256	MT3	6.8	●	568
65240	**24**	140	260		6.9	●	583
65245	**24.5**				7.1	●	603
65250	**25**				7.2	●	615
65255	**25.5**	145	265		7.4	●	636
65260	**26**				7.5	●	639
65265	**26.5**				7.6	●	667
65270	**27**	150	270		7.8	●	697
65275	**27.5**				7.9	●	713
65280	**28**				8.1	●	747
65285	**28.5**	155	275		8.2	●	759
65290	**29**				8.4	●	778
65295	**29.5**				8.5	●	782
65300	**30**				8.7	●	806
65305	**30.5**	160	280		8.8	●	838
65310	**31**				8.9	●	847
65315	**31.5**				9.1	●	858
65320	**32**	165	285		9.2	●	893
65330	**33**		310	MT4	9.5	●	1,333
65340	**34**	170	315		9.8	●	1,373
65350	**35**				10.1	●	1,417
65360	**36**	175	320		10.4	●	1,471
65370	**37**				10.7	●	1,544
65380	**38**	180	325		11	●	1,600
65390	**39**				11.3	●	1,633
65400	**40**				11.5	●	1,679
65410	**41**	185	330		11.8	●	1,841
65420	**42**				12.1	●	1,874
65430	**43**	190	335		12.4	●	1,964
65440	**44**				12.7	●	2,031
65450	**45**				13	●	2,100
65460	**46**	195	340		13.3	●	2,187
65470	**47**				13.6	●	2,242
65480	**48**	200	345		13.9	●	2,260
65490	**49**				14.1	●	2,345
65500	**50**				14.4	●	2,384

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
MT-SUS-GDR	◎	○								◎				◎	◎	◎				○	

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

一般加工用超短刃型钻头
STUB FOR GENERAL APPLICATION

EX-GDS

切削条件 Cutting Conditions | P.427

高刚性槽形和超短刃，能够实现高效率·高精度加工。最适于攻丝前底孔用和车床用。

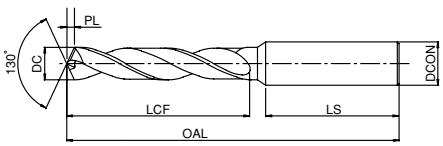
Rigid flute form and stub length enhances efficiency and precision. Most suitable for tapping or Lathe processing.

HSS-Co | TiN | h8 | SHANK h7 | 25°

四棱式横刃
Four Facet point
(DC ≦1.9)

X 型横刃
X thinning
(1.9＜DC＜4)

R 型横刃
R thinning
(4≦DC)



单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60010	1	6	38	3	26.8	0.2	●	3
60410	1.05				26.9	0.2	●	4
60011	1.1	7	39		27	0.3	●	3
60411	1.15				27.1	0.3	●	4
60012	1.2	8	40		27.2	0.3	●	3
60412	1.25				27.3	0.3	●	4
60013	1.3				27.4	0.3	●	4
60413	1.35	9	41		27.5	0.3	●	4
60014	1.4				27.6	0.3	●	4
60414	1.45				27.7	0.3	●	4
60015	1.5				27.8	0.3	●	4
60415	1.55	10	42		27.9	0.4	●	4
60016	1.6				27.9	0.4	●	4
60416	1.65				28	0.4	●	4
60017	1.7				28.1	0.4	●	4
60417	1.75	11	43		28.2	0.4	●	4
60018	1.8				28.3	0.4	●	4
60418	1.85				28.4	0.4	●	4
60019	1.9				28.5	0.4	●	4
60419	1.95	12	44		28.6	0.5	●	4
60020	2				28.7	0.5	●	4
60420	2.05				28.8	0.5	●	4
60021	2.1				28.9	0.5	●	4
60421	2.15	13	45		29	0.5	●	4
60022	2.2				29.1	0.5	●	4
60422	2.25				29.2	0.5	●	4
60023	2.3				29.2	0.5	●	4
60423	2.35				29.3	0.5	●	4
60024	2.4	14	46		29.4	0.6	●	4
60424	2.45				29.5	0.6	●	4
60025	2.5				29.6	0.6	●	4
60425	2.55				29.7	0.6	●	4
60026	2.6				29.8	0.6	●	4
60426	2.65				29.9	0.6	●	4
60027	2.7	16	48		30	0.6	●	4
60427	2.75				30.1	0.6	●	4
60028	2.8				30.2	0.7	●	4
60428	2.85				30.3	0.7	●	4
60029	2.9				30.3	0.7	●	4
60429	2.95				30.4	0.7	●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60030	3	16	48	3	30.5	0.7	●	4
60430	3.05	18	50	4	28.8	0.7	●	5
60031	3.1				28.9	0.7	●	5
60431	3.15				29	0.7	●	5
60032	3.2				29.1	0.7	●	5
60432	3.25				29.2	0.8	●	5
60033	3.3				29.2	0.8	●	5
60433	3.35				29.3	0.8	●	5
60034	3.4	20	52		29.4	0.8	●	6
60434	3.45				29.5	0.8	●	6
60035	3.5				29.6	0.8	●	6
60435	3.55				29.7	0.8	●	6
60036	3.6				29.8	0.8	●	6
60436	3.65				29.9	0.9	●	6
60037	3.7				30	0.9	●	6
60437	3.75				30.1	0.9	●	6
60038	3.8	22	54		30.2	0.9	●	6
60438	3.85				30.3	0.9	●	6
60039	3.9				30.3	0.9	●	6
60439	3.95				30.4	0.9	●	6
60040	4				30.5	0.9	●	6
60440	4.05		66	6	35.7	0.9	●	12
60041	4.1				35.8	1	●	12
60441	4.15				35.9	1	●	13
60042	4.2				36	1	●	13
60442	4.25				36.1	1	●	13
60043	4.3	24	68		36.8	1	●	13
60443	4.35				36.9	1	●	13
60044	4.4				36.9	1	●	13
60444	4.45				37	1	●	14
60045	4.5				37.1	1	●	13
60445	4.55				37.2	1.1	●	14
60046	4.6				37.4	1.1	●	13
60446	4.65				37.4	1.1	●	14
60047	4.7				37.7	1.1	●	14
60447	4.75				37.6	1.1	●	14
60048	4.8	26	70		37.8	1.1	●	14
60448	4.85				37.7	1.1	●	14
60049	4.9				37.8	1.1	●	14
60449	4.95				37.9	1.2	●	14

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直径 DC 5～12.1 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDS	○	◎	◎	◎	◎	○					◎	◎	○			○		○		○	
EX-GDS ※	○	◎	◎	◎	○						○	◎	○			○		○		○	

※孔深：3D～4D　　Drilling depth：3D～4D

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DH1000**

一般加工用超短刃型钻头
STUB FOR GENERAL APPLICATION

EX-GDS

切削条件 Cutting Conditions | P.427

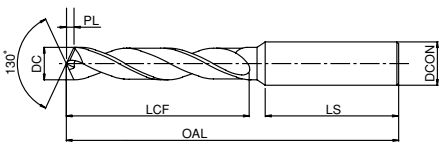
高刚性槽形和超短刃，能够实现高效率·高精度加工。最适于攻丝前底孔用和车床用。

Rigid flute form and stub length enhances efficiency and precision. Most suitable for tapping or Lathe processing.

四棱式横刃
Four Facet point
(DC≦1.9)

X 型横刃
X thinning
(1.9＜DC＜4)

R 型横刃
R thinning
(4≦DC)



HSS-Co | TiN | h8 | SHANK h7 | 25°

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FROM 直径 DC 1～4.95

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60050	**5**	26	70	6	38.8	1.2	●	14
60450	**5.05**				38.6	1.2	●	14
60051	**5.1**				38.7	1.2	●	14
60451	**5.15**				38.8	1.2	●	14
60052	**5.2**				38.9	1.2	●	15
60452	**5.25**				39	1.2	●	15
60053	**5.3**				39.3	1.2	●	15
60453	**5.35**	28	72		39.4	1.2	●	15
60054	**5.4**				39.5	1.3	●	15
60454	**5.45**				39.6	1.3	●	15
60055	**5.5**				39.7	1.3	●	15
60455	**5.55**				39.8	1.3	●	15
60056	**5.6**				41.6	1.3	●	15
60456	**5.65**				41.6	1.3	●	15
60057	**5.7**				41.6	1.3	●	16
60457	**5.75**				41.6	1.3	●	15
60058	**5.8**				41.7	1.4	●	16
60458	**5.85**				41.7	1.4	●	15
60059	**5.9**				41.8	1.4	●	16
60459	**5.95**				41.8	1.4	●	16
60060	**6**				42	1.4	●	16
60061	**6.1**	31	75	8	35.9	1.4	●	23
60062	**6.2**				36.1	1.4	●	24
60063	**6.3**				36.8	1.5	●	24
60064	**6.4**				37	1.5	●	24
60065	**6.5**				37.1	1.5	●	25
60465	**6.55**				37.2	1.5	●	24
60066	**6.6**				37.3	1.5	●	25
60466	**6.65**				37.4	1.6	●	25
60067	**6.7**				37.5	1.6	●	25
60068	**6.8**	34	78		37.6	1.6	●	25
60069	**6.9**				38.4	1.6	●	26
60070	**7**				38.6	1.6	●	26
60071	**7.1**				38.7	1.7	●	26
60072	**7.2**				38.9	1.7	●	26
60073	**7.3**				39.4	1.7	●	27
60473	**7.35**				39.5	1.7	●	27
60074	**7.4**				39.5	1.7	●	27
60075	**7.5**				41.5	1.7	●	27
60475	**7.55**	37	81		41.5	1.8	●	28
60076	**7.6**				41.6	1.8	●	28
60476	**7.65**				41.6	1.8	●	28
60077	**7.7**				41.7	1.8	●	28
60078	**7.8**				41.6	1.8	●	28
60079	**7.9**				41.8	1.8	●	29
60080	**8**				42	1.9	●	29
60081	**8.1**		87	10	41.9	1.9	●	47
60082	**8.2**				42	1.9	●	48
60083	**8.3**				42.8	1.9	●	48
60483	**8.35**				42.9	1.9	●	48
60084	**8.4**				43	2	●	49
60085	**8.5**				43.2	2	●	49

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60485	**8.55**	40	90	10	43.2	2	●	50
60086	**8.6**				43.2	2	●	50
60486	**8.65**				43.4	2	●	50
60087	**8.7**				43.5	2	●	50
60088	**8.8**				43.8	2.1	●	51
60089	**8.9**				43.8	2.1	●	51
60090	**9**				44.5	2.1	●	51
60091	**9.1**				44.7	2.1	●	52
60092	**9.2**				44.9	2.1	●	52
60492	**9.25**				45.3	2.2	●	52
60093	**9.3**				45.3	2.2	●	52
60493	**9.35**				45.5	2.2	●	53
60094	**9.4**				45.8	2.2	●	52
60494	**9.45**				45.7	2.2	●	53
60095	**9.5**				47.5	2.2	●	53
60495	**9.55**	43	93		47.5	2.2	●	54
60096	**9.6**				47.6	2.2	●	54
60496	**9.65**				47.5	2.2	●	54
60097	**9.7**				47.6	2.3	●	55
60098	**9.8**				47.7	2.3	●	55
60099	**9.9**				47.8	2.3	●	55
60499	**9.95**				47.8	2.3	●	56
60100	**10**				48	2.3	●	56
60101	**10.1**		100	12	48.9	2.4	●	75
60102	**10.2**				49	2.4	●	75
62002	**10.25**				49.2	2.4	●	76
60103	**10.3**				49.8	2.4	●	76
62003	**10.35**				49.7	2.4	●	76
60104	**10.4**				50	2.4	●	77
60105	**10.5**				50.1	2.4	●	77
62005	**10.55**				50.3	2.5	●	77
60106	**10.6**				50.3	2.5	●	77
62006	**10.65**	47	104		50.4	2.5	●	79
60107	**10.7**				50.5	2.5	●	79
60108	**10.8**				50.6	2.5	●	80
60109	**10.9**				50.7	2.5	●	80
62009	**10.95**				51.4	2.6	●	81
60110	**11**				51.5	2.6	●	81
60111	**11.1**				51.7	2.6	●	82
60112	**11.2**				51.9	2.6	●	82
62012	**11.25**				52	2.6	●	82
60113	**11.3**				52.3	2.6	●	82
62013	**11.35**				52.5	2.6	●	82
60114	**11.4**				52.5	2.7	●	83
60115	**11.5**				54.5	2.7	●	83
62015	**11.55**				54.5	2.7	●	83
60116	**11.6**				54.6	2.7	●	84
60117	**11.7**				54.6	2.7	●	84
60118	**11.8**				54.6	2.8	●	85
60119	**11.9**	51	108		54.8	2.8	●	87
60120	**12**				55	2.8	●	88
60121	**12.1**				55	2.8	●	88

下一页
直径 DC 12.2～13 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDS	○	◎	◎	◎	◎	○					◎	◎	○			○		○		○	
※	○	◎	◎	◎	○						○	◎	○			○		○		○	

※孔深：3D～4D　　Drilling depth：3D～4D

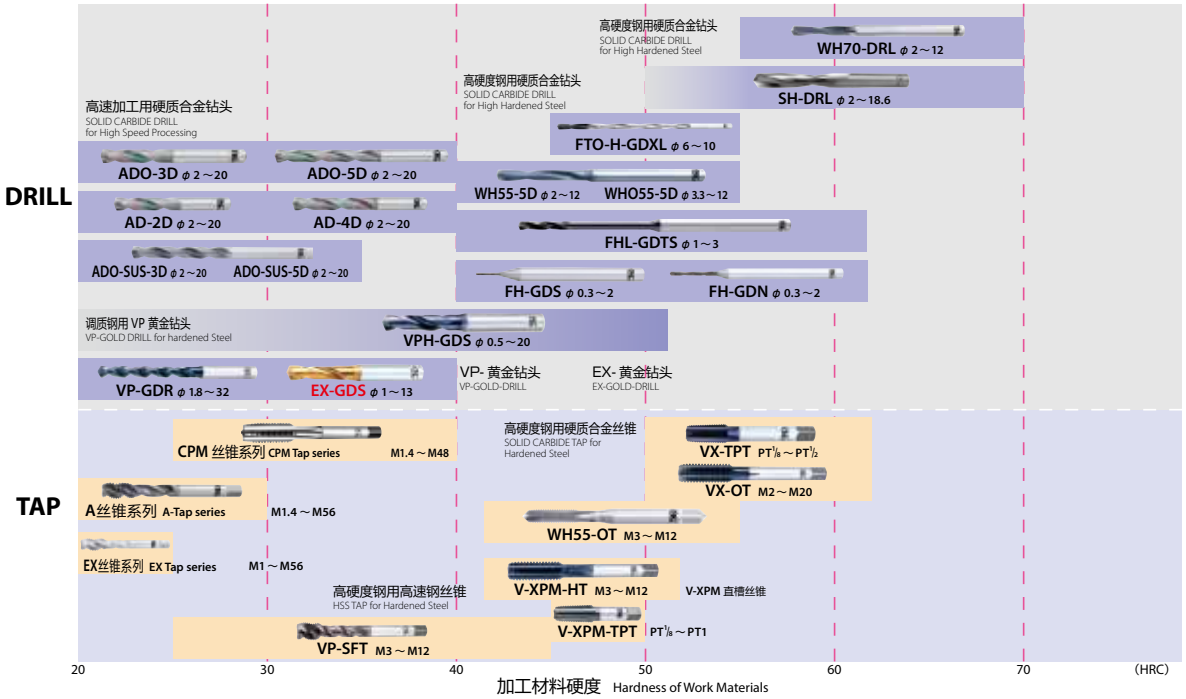
上一页
FROM 直径 DC 5～12.1

单位:mm　Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60122	**12.2**	51	108	12	55	2.8	●	88
60123	**12.3**				55	2.9	●	89
60124	**12.4**				55	2.9	●	89
60125	**12.5**				55	2.9	●	90
60126	**12.6**				55	2.9	●	91

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60127	**12.7**	51	108	12	55	3	●	91
60128	**12.8**				55	3	●	91
60129	**12.9**				55	3	●	92
60130	**13**				55	3	●	92

■孔加工工具选择指南　Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | **DH1017**

一般加工用长柄超短刃型钻头

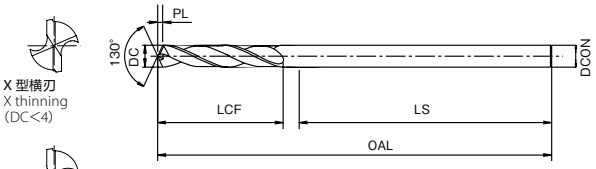
STUB WITH LONG SHANK FOR GENERAL APPLICATION

EX-LS-GDS

切削条件 Cutting Conditions | P.428

适用于卧式设备和较深部位的加工

EX-LS-GDS is best used with a horizontal machine which requires long overhang length. It performs well for drilling besides deep walls and with bush or clamping system.



X 型横刃
X thinning
(DC<4)

R 型横刃
R thinning
(4 ≦ DC)

HSS-Co | TiN | h8 | SHANK h7 | 30°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8601525	2.5	14	100	2.5	65	0.6	●	6
8602025			120		80	0.6	●	9
8602525			150		100	0.6	●	10
8601533	3.3	18	100	3.3	65	0.8	●	9
8602033			120		80	0.8	●	12
8602533			150		100	0.8	●	13
8601542	4.2	22	100	4.2	65	1	●	13
8602042			120		80	1	●	17
8602542			150		100	1	●	18
8601550	5	26	100	5	65	1.2	●	17
8602050			120		80	1.2	●	22
8602550			150		100	1.2	●	25
8603050			200		130	1.2	●	35
8601568	6.8	34	100	6.8	65	1.6	●	29
8602068			120		80	1.6	●	36
8602568			150		100	1.6	●	43
8603068			200		130	1.6	●	62
8603568			250		170	1.6	●	85
8602070	7		120	7	80	1.6	●	37
8602570			150		100	1.6	●	47
8603070			200		130	1.6	●	64
8603570			250		170	1.6	●	81

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8602085	8.5	37	120	8.5	80	2	●	52
8602585			150		100	2	●	67
8603085			200		130	2	●	91
8603585			250		170	2	●	116
8602088	8.8	41	120	8.8	70	2.1	●	59
8602588			150		100	2.1	●	72
8603088			200		130	2.1	●	97
8603588			250		170	2.1	●	122
8602103	10.3	43	120	10.3	70	2.4	●	78
8602603			150		100	2.4	●	96
8603103			200		130	2.4	●	139
8603603			250		170	2.4	●	174
8602105	10.5		120	10.5	70	2.4	●	81
8602605			150		100	2.4	●	100
8603105			200		130	2.4	●	135
8603605			250		170	2.4	●	179
8602108	10.8	47	120	10.8	70	2.5	●	84
8602608			150		100	2.5	●	104
8603108			200		130	2.5	●	150
8603608			250		170	2.5	●	186

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-LS-GDS	○	◎	◎	◎	◎						○	◎	○			○				○	

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

一般加工用中等刃长型钻头
MEDIUM FOR GENERAL APPLICATION

EX-GDN

切削条件 Cutting Conditions | P.429

槽长度在超短刃与标准刃之间，即使是小径也能实现4 倍的无停顿的高速加工。

The middle-flute length allows for high speed, non-step processing; to depths up to 4 times the drill diameter.

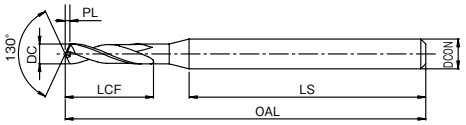
HSS-Co | TiN | h8 | SHANK h7 | 30°

注1)

四棱式横刃
Four Facet point
(DC≦1.5)

X 型横刃
X thinning
(1.5<DC<4)

R 型横刃
R thinning
(4≦DC)



注1) 除去刃径为0.05mm 整数倍数的型号以外,其它刃径公差都在0~-0.009mm。

All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
61005	**0.5**	6	38	3	25.8	0.1	●	4
8607051	**0.51**				25.9	0.1	●	4
8607052	**0.52**				25.9	0.1	●	4
8607053	**0.53**				25.9	0.1	●	4
8607054	**0.54**	7	39		25.9	0.1	●	4
8607055	**0.55**				25.9	0.1	●	4
8607056	**0.56**				25.9	0.1	●	4
8607057	**0.57**				26	0.1	●	4
8607058	**0.58**				26	0.1	●	4
8607059	**0.59**				26	0.1	●	4
61006	**0.6**				26	0.1	●	4
8607061	**0.61**				26	0.1	●	4
8607062	**0.62**				26.1	0.1	●	4
8607063	**0.63**				26.1	0.2	●	4
8607064	**0.64**				26.1	0.2	●	4
8607065	**0.65**				26.1	0.2	●	4
8607066	**0.66**				26.1	0.2	●	4
8607067	**0.67**				26.2	0.2	●	4
8607068	**0.68**	8	40		26.2	0.2	●	4
8607069	**0.69**				26.2	0.2	●	4
61007	**0.7**				26.2	0.2	●	4
8607071	**0.71**				26.2	0.2	●	4
8607072	**0.72**				26.2	0.2	●	4
8607073	**0.73**				26.3	0.2	●	4
8607074	**0.74**				26.3	0.2	●	4
8607075	**0.75**				26.3	0.2	●	4
8607076	**0.76**				26.3	0.2	●	4
8607077	**0.77**				26.3	0.2	●	4
8607078	**0.78**				26.4	0.2	●	4
8607079	**0.79**				26.4	0.2	●	4
61008	**0.8**				26.4	0.2	●	4
8607081	**0.81**				26.4	0.2	●	4
8607082	**0.82**				26.4	0.2	●	4
8607083	**0.83**				26.5	0.2	●	4
8607084	**0.84**				26.5	0.2	●	4
8607085	**0.85**				26.5	0.2	●	4
8607086	**0.86**	9	41		26.5	0.2	●	4
8607087	**0.87**				26.5	0.2	●	4
8607088	**0.88**				26.5	0.2	●	4
8607089	**0.89**				26.6	0.2	●	4
61009	**0.9**				26.6	0.2	●	4
8607091	**0.91**				26.6	0.2	●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8607092	**0.92**	9	41	3	26.6	0.2	●	4
8607093	**0.93**				26.6	0.2	●	4
8607094	**0.94**				26.7	0.2	●	4
8607095	**0.95**				26.7	0.2	●	4
8607096	**0.96**				26.7	0.2	●	4
8607097	**0.97**				26.7	0.2	●	4
8607098	**0.98**				26.7	0.2	●	4
8607099	**0.99**				26.7	0.2	●	4
61010	**1**				26.8	0.2	●	4
8607101	**1.01**				26.8	0.2	●	4
8607102	**1.02**				26.8	0.2	●	4
8607103	**1.03**				26.8	0.2	●	4
8607104	**1.04**				26.8	0.2	●	4
8607105	**1.05**				26.9	0.2	●	4
8607106	**1.06**				26.9	0.3	●	4
8607107	**1.07**	11	43		26.9	0.3	●	4
8607108	**1.08**				26.9	0.3	●	4
8607109	**1.09**				26.9	0.3	●	4
61011	**1.1**				27	0.3	●	4
8607111	**1.11**				27	0.3	●	4
8607112	**1.12**				27	0.3	●	4
8607113	**1.13**				27	0.3	●	4
8607114	**1.14**				27	0.3	●	4
8607115	**1.15**				27	0.3	●	4
8607116	**1.16**				27.1	0.3	●	4
8607117	**1.17**				27.1	0.3	●	4
8607118	**1.18**				27.1	0.3	●	4
8607119	**1.19**	12	44		27.1	0.3	●	4
61012	**1.2**				27.1	0.3	●	4
8607121	**1.21**				27.2	0.3	●	4
8607122	**1.22**				27.2	0.3	●	4
8607123	**1.23**				27.2	0.3	●	4
8607124	**1.24**				27.2	0.3	●	4
8607125	**1.25**				27.2	0.3	●	4
8607126	**1.26**				27.3	0.3	●	4
8607127	**1.27**				27.3	0.3	●	4
8607128	**1.28**				27.3	0.3	●	4
8607129	**1.29**				27.3	0.3	●	4
61013	**1.3**				27.3	0.3	●	4
8607131	**1.31**				27.3	0.3	●	4
8607132	**1.32**				27.4	0.3	●	4
8607133	**1.33**	14	46		27.4	0.3	●	4

下一页
直径 DC 1.34～3.85 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDN	○	◎	◎	◎	○						◎	◎	○		○	○				○	

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **DH1001**

一般加工用中等刃长型钻头
MEDIUM FOR GENERAL APPLICATION

EX-GDN

切削条件 Cutting Conditions | P.429

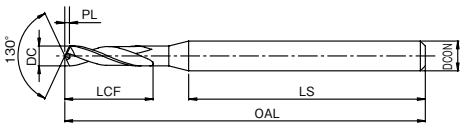
槽长度在超短刃与中等刃之间，即使是小径也能实现4 倍的无停顿的高速加工。

The middle-flute length allows for high speed, non-step processing; to depths up to 4 times the drill diameter.

四棱式横刃
Four Facet point
(DC≦1.5)

X 型横刃
X thinning
(1.5<DC<4)

R 型横刃
R thinning
(4≦DC)



注1) 除去刃径为0.05mm 整数倍数的型号以外,其它刃径公差都在0~-0.009mm。

All drill diameters have limits from 0 ~ -0.009mm, except those with intervals of 0.05mm.

HSS-Co | TiN | h8 | SHANK h7 | 30°

注1)

上一页
FROM 直径 DC 0.5～1.33

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8607134	**1.34**	14	46	3	27.4	0.3	●	4
8607135	**1.35**				27.4	0.3	●	4
8607136	**1.36**				27.4	0.3	●	4
8607137	**1.37**				27.5	0.3	●	4
8607138	**1.38**				27.5	0.3	●	4
8607139	**1.39**				27.5	0.3	●	4
61014	**1.4**				27.5	0.3	●	4
8607141	**1.41**				27.5	0.3	●	4
8607142	**1.42**				27.6	0.3	●	4
8607143	**1.43**				27.6	0.3	●	4
8607144	**1.44**				27.6	0.3	●	4
8607145	**1.45**				27.6	0.3	●	4
8607146	**1.46**				27.6	0.3	●	4
8607147	**1.47**				27.6	0.3	●	4
8607148	**1.48**				27.7	0.4	●	4
8607149	**1.49**				27.7	0.4	●	4
61015	**1.5**				27.7	0.4	●	4
8607151	**1.51**	15	47		27.7	0.4	●	4
8607152	**1.52**				27.7	0.4	●	4
8607153	**1.53**				27.8	0.4	●	4
8607154	**1.54**				27.8	0.4	●	4
8607155	**1.55**				27.8	0.4	●	4
8607156	**1.56**				27.8	0.4	●	4
8607157	**1.57**				27.8	0.4	●	4
8607158	**1.58**				27.9	0.4	●	4
8607159	**1.59**				27.9	0.4	●	4
61016	**1.6**				27.9	0.4	●	4
8607161	**1.61**				27.9	0.4	●	4
8607162	**1.62**				27.9	0.4	●	4
8607163	**1.63**				27.9	0.4	●	4
8607164	**1.64**				28	0.4	●	4
8607165	**1.65**				28	0.4	●	4
8607166	**1.66**				28	0.4	●	4
8607167	**1.67**				28	0.4	●	4
8607168	**1.68**				28	0.4	●	4
8607169	**1.69**				28.1	0.4	●	4
61017	**1.7**				28.1	0.4	●	4
8607171	**1.71**	17	49		28.1	0.4	●	4
8607172	**1.72**				28.1	0.4	●	4
8607173	**1.73**				28.1	0.4	●	4
8607174	**1.74**				28.1	0.4	●	4
8607175	**1.75**				28.2	0.4	●	4
8607176	**1.76**				28.2	0.4	●	4
8607177	**1.77**				28.2	0.4	●	4
8607178	**1.78**				28.2	0.4	●	4
8607179	**1.79**				28.2	0.4	●	4
61018	**1.8**				28.3	0.4	●	4
8607181	**1.81**				28.3	0.4	●	4
8607182	**1.82**				28.3	0.4	●	4
8607183	**1.83**				28.3	0.4	●	4
8607184	**1.84**				28.3	0.4	●	4
8607185	**1.85**				28.4	0.4	●	4

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8607186	**1.86**	17	49	3	28.4	0.4	●	4
8607187	**1.87**				28.4	0.4	●	4
8607188	**1.88**				28.4	0.4	●	4
8607189	**1.89**				28.4	0.4	●	4
61019	**1.9**				28.4	0.4	●	4
8607191	**1.91**	18	50		28.5	0.5	●	4
8607192	**1.92**				28.5	0.5	●	4
8607193	**1.93**				28.5	0.5	●	4
8607194	**1.94**				28.5	0.5	●	4
8607195	**1.95**				28.5	0.5	●	4
8607196	**1.96**				28.6	0.5	●	4
8607197	**1.97**				28.6	0.5	●	4
8607198	**1.98**				28.6	0.5	●	4
8607199	**1.99**				28.6	0.5	●	4
61020	**2**				28.7	0.5	●	4
8607205	**2.05**				28.8	0.5	●	4
61021	**2.1**				28.9	0.5	●	4
8607215	**2.15**	20	52		29	0.5	●	4
61022	**2.2**				29.1	0.5	●	4
8607225	**2.25**				29.2	0.5	●	4
61023	**2.3**				29.3	0.5	●	4
8607235	**2.35**				29.4	0.6	●	4
61024	**2.4**	22	54		29.5	0.6	●	4
8607245	**2.45**				29.6	0.6	●	4
61025	**2.5**				29.7	0.6	●	4
8607255	**2.55**				29.8	0.6	●	4
61026	**2.6**				29.8	0.6	●	4
8607265	**2.65**				29.9	0.6	●	4
61027	**2.7**	25	57		30	0.6	●	5
8607275	**2.75**				30.1	0.6	●	4
61028	**2.8**				30.2	0.7	●	4
8607285	**2.85**				30.3	0.7	●	4
61029	**2.9**				30.3	0.7	●	4
8607295	**2.95**				30.4	0.7	●	5
61030	**3**				30.5	0.7	●	4
8607305	**3.05**	27	59	4	28.8	0.7	●	6
61031	**3.1**				28.9	0.7	●	6
8607315	**3.15**				29	0.7	●	6
61032	**3.2**				29.1	0.8	●	6
8607325	**3.25**				29.2	0.8	●	6
61033	**3.3**				29.2	0.8	●	6
8607335	**3.35**				29.3	0.8	●	6
61034	**3.4**	30	62		29.4	0.8	●	6
8607345	**3.45**				29.5	0.8	●	6
61035	**3.5**				29.6	0.8	●	6
8607355	**3.55**				29.7	0.8	●	6
61036	**3.6**				29.8	0.8	●	6
8607365	**3.65**				29.9	0.9	●	6
61037	**3.7**				30	0.9	●	7
8607375	**3.75**				30.1	0.9	●	7
61038	**3.8**	33	65		30.2	0.9	●	7
8607385	**3.85**				30.3	0.9	●	7

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直径 DC 3.9～6 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDN	○	◎	◎	◎	○						◎	◎	○		○	○				○	

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FROM 直径 **DC** **1.34～3.85**

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
61039	**3.9**	33	65	4	30.3	0.9	●	7
8607395	**3.95**				30.4	0.9	●	7
61040	**4**				30.5	0.9	●	7
8607405	**4.05**		77	6	36	0.9	●	14
61041	**4.1**				36	1	●	14
8607415	**4.15**				36.1	1	●	14
61042	**4.2**				36.2	1	●	14
8607425	**4.25**				36.3	1	●	14
61043	**4.3**	36	80		36.4	1	●	15
8607435	**4.35**				37	1	●	18
61044	**4.4**				37.1	1	●	14
8607445	**4.45**				37.2	1	●	14
61045	**4.5**				37.3	1.1	●	14
8607455	**4.55**				37.4	1.1	●	18
61046	**4.6**				37.5	1.1	●	14
8607465	**4.65**				37.5	1.1	●	15
61047	**4.7**				37.6	1.1	●	15
8607475	**4.75**				37.7	1.1	●	18
61048	**4.8**	39	83		37.8	1.1	●	18
8607485	**4.85**				37.9	1.1	●	16
61049	**4.9**				38	1.1	●	18
8607495	**4.95**				38	1.2	●	19

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
61050	**5**	39	83	6	38.7	1.2	●	16
8607505	**5.05**				38.8	1.2	●	16
61051	**5.1**				38.9	1.2	●	18
8607515	**5.15**				39	1.2	●	16
61052	**5.2**				39.1	1.2	●	16
8607525	**5.25**				39.2	1.2	●	19
61053	**5.3**				39.5	1.2	●	16
8607535	**5.35**	43	87		39.6	1.3	●	17
61054	**5.4**				39.7	1.3	●	17
8607545	**5.45**				39.8	1.3	●	17
61055	**5.5**				40	1.3	●	17
8607555	**5.55**				40.1	1.3	●	17
61056	**5.6**				41.6	1.3	●	17
8607565	**5.65**				41.6	1.3	●	20
61057	**5.7**				41.6	1.3	●	17
8607575	**5.75**				41.7	1.3	●	21
61058	**5.8**				41.7	1.4	●	18
8607585	**5.85**				41.8	1.4	●	18
61059	**5.9**				41.8	1.4	●	18
8607595	**5.95**				41.9	1.4	●	21
61060	**6**				42	1.4	●	19

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | **DH1002**

一般加工用标准刃长型钻头

REGULAR FOR GENERAL APPLICATION

EX-GDR

切削条件 Cutting Conditions | P.429

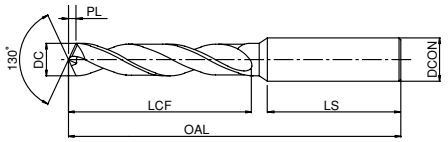
用途广泛，能实现直径4~5 倍无停顿式高速加工。

Non-stop processing to depth 4~5 times the hole diameter allows this drill to be used for numerous high speed applications.

HSS-Co | TiN | h8 | SHANK h7 | 30°

X 型横刃
X thinning
(DC<4)

R 型横刃
R thinning
(4≦DC)



※超过φ13 的尺寸为带凹槽直柄，但库存消耗完后将改为普通直柄。

※ For shank size over 13mm, shank geometry "with flat on shank" is changed to "without flat on shank" accordingly.

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60520	**2**	24	56	3	28.7	0.5	●	4
62120	**2.05**				28.8	0.5	●	4
60521	**2.1**				28.9	0.5	●	4
62121	**2.15**	27	59		29	0.5	●	4
60522	**2.2**				29.1	0.5	●	4
62122	**2.25**				29.2	0.5	●	4
60523	**2.3**				29.3	0.5	●	4
62123	**2.35**				29.4	0.5	●	4
60524	**2.4**	30	62		29.5	0.6	●	4
62124	**2.45**				29.6	0.6	●	4
60525	**2.5**				29.7	0.6	●	4
62125	**2.55**				29.8	0.6	●	4
60526	**2.6**				29.8	0.6	●	4
62126	**2.65**				29.9	0.6	●	4
60527	**2.7**	33	65		30	0.6	●	4
62127	**2.75**				30.1	0.6	●	4
60528	**2.8**				30.2	0.7	●	4
62128	**2.85**				30.3	0.7	●	4
60529	**2.9**				30.3	0.7	●	4
62129	**2.95**				30.4	0.7	●	5
60530	**3**				30.5	0.7	●	5
62130	**3.05**	36	68	4	28.8	0.7	●	6
60531	**3.1**				28.9	0.7	●	7
62131	**3.15**				29	0.7	●	7
60532	**3.2**				29.1	0.7	●	7
62132	**3.25**				29.2	0.8	●	7
60533	**3.3**				29.2	0.8	●	7
62133	**3.35**				29.3	0.8	●	7
60534	**3.4**	39	71		29.5	0.8	●	7
62134	**3.45**				29.6	0.8	●	7
60535	**3.5**				29.7	0.8	●	7
62135	**3.55**				29.8	0.8	●	7
60536	**3.6**				29.9	0.8	●	7
62136	**3.65**				30	0.9	●	7
60537	**3.7**				30.1	0.9	●	7
62137	**3.75**				30.2	0.9	●	7

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60538	**3.8**	43	75	4	30.3	0.9	●	7
62138	**3.85**				30.3	0.9	●	8
60539	**3.9**				30.3	0.9	●	8
62139	**3.95**				30.4	0.9	●	8
60540	**4**				30.5	0.9	●	8
62140	**4.05**		87	6	36	0.9	●	15
60541	**4.1**				36	1	●	15
62141	**4.15**				36.2	1	●	15
60542	**4.2**				36.3	1	●	15
62142	**4.25**				36.3	1	●	15
60543	**4.3**	47	91		36.5	1	●	15
62143	**4.35**				37.1	1	●	15
60544	**4.4**				37.2	1	●	15
62144	**4.45**				37.3	1	●	15
60545	**4.5**				37.3	1	●	15
62145	**4.55**				37.4	1.1	●	16
60546	**4.6**				37.6	1.1	●	16
62146	**4.65**				37.6	1.1	●	17
60547	**4.7**				37.7	1.1	●	16
62147	**4.75**				37.8	1.1	●	16
60548	**4.8**	52	96		37.9	1.1	●	16
62148	**4.85**				38	1.1	●	17
60549	**4.9**				38.7	1.1	●	17
62149	**4.95**				38.7	1.2	●	17
60550	**5**				38.8	1.2	●	17
62150	**5.05**				38.9	1.2	●	17
60551	**5.1**				39	1.2	●	17
62151	**5.15**				39.1	1.2	●	17
60552	**5.2**				39.2	1.2	●	17
62152	**5.25**				39.5	1.2	●	18
60553	**5.3**				39.7	1.2	●	17
62153	**5.35**	57	101		39.8	1.2	●	17
60554	**5.4**				39.9	1.3	●	18
62154	**5.45**				40	1.3	●	18
60555	**5.5**				39.8	1.3	●	19
62155	**5.55**				40	1.3	●	18

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直径 DC 5.6～9.15 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDR	○	◎	◎	◎	○						◎	◎	○		○	○				○	

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FROM 直径 DC 2～5.55

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60556	**5.6**	57	101	6	41.6	1.3	●	19
62156	**5.65**				41.6	1.3	●	19
60557	**5.7**				41.7	1.3	●	19
62157	**5.75**				41.7	1.3	●	19
60558	**5.8**				41.6	1.4	●	19
62158	**5.85**				41.7	1.4	●	20
60559	**5.9**				41.8	1.4	●	20
62159	**5.95**				41.8	1.4	●	20
60560	**6**				42	1.4	●	20
62160	**6.05**	63	107	8	36	1.4	●	29
60561	**6.1**				36	1.4	●	29
62161	**6.15**				36.1	1.4	●	30
60562	**6.2**				36.3	1.4	●	29
62162	**6.25**				36.3	1.5	●	29
60563	**6.3**				37.1	1.5	●	29
62163	**6.35**				37.1	1.5	●	30
60564	**6.4**				37.9	1.5	●	30
62164	**6.45**				37.2	1.5	●	30
60565	**6.5**				37.4	1.5	●	30
62165	**6.55**				37.4	1.5	●	30
60566	**6.6**				37.6	1.5	●	31
62166	**6.65**				37.6	1.6	●	31
60567	**6.7**				37.7	1.6	●	31
62167	**6.75**	69	113		37.7	1.6	●	32
60568	**6.8**				37.9	1.6	●	32
62168	**6.85**				37.9	1.6	●	33
60569	**6.9**				38.7	1.6	●	33
62169	**6.95**				38.7	1.6	●	33
60570	**7**				38.8	1.6	●	33
62170	**7.05**				38.8	1.6	●	34
60571	**7.1**				38.9	1.7	●	34
62171	**7.15**				39	1.7	●	34
60572	**7.2**				39.2	1.7	●	34
62172	**7.25**				39.2	1.7	●	34
60573	**7.3**				39.6	1.7	●	34
62173	**7.35**				39.7	1.7	●	34

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60574	**7.4**	69	113	8	39.8	1.7	●	35
62174	**7.45**				39.9	1.7	●	35
60575	**7.5**				41.5	1.7	●	35
62175	**7.55**	75	119		41.5	1.8	●	36
60576	**7.6**				41.6	1.8	●	36
62176	**7.65**				41.6	1.8	●	37
60577	**7.7**				41.7	1.8	●	37
62177	**7.75**				41.7	1.8	●	37
60578	**7.8**				41.6	1.8	●	38
62178	**7.85**				41.7	1.8	●	38
60579	**7.9**				41.8	1.8	●	38
62179	**7.95**				41.8	1.9	●	38
60580	**8**				42	1.9	●	38
62180	**8.05**		125	10	42	1.9	●	56
60581	**8.1**				42.1	1.9	●	56
62181	**8.15**				42.1	1.9	●	56
60582	**8.2**				42.3	1.9	●	56
62182	**8.25**				42.3	1.9	●	57
60583	**8.3**				43	1.9	●	57
62183	**8.35**				43.1	1.9	●	57
60584	**8.4**				43.2	2	●	57
62184	**8.45**				43.2	2	●	58
60585	**8.5**				43.3	2	●	58
62185	**8.55**	81	131		43.4	2	●	59
60586	**8.6**				43.5	2	●	60
62186	**8.65**				43.6	2	●	61
60587	**8.7**				43.7	2	●	61
62187	**8.75**				43.7	2	●	61
60588	**8.8**				43.8	2.1	●	61
62188	**8.85**				43.9	2.1	●	61
60589	**8.9**				43.9	2.1	●	61
62189	**8.95**				44	2.1	●	62
60590	**9**				44.8	2.1	●	62
62190	**9.05**				44.8	2.1	●	63
60591	**9.1**				45	2.1	●	63
62191	**9.15**				45	2.1	●	64

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直径 DC 9.2～15 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DH1002**

一般加工用标准刃长型钻头

REGULAR FOR GENERAL APPLICATION

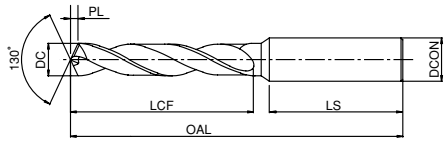
EX-GDR

切削条件 Cutting Conditions | P.429

用途广泛，能实现直径4~5 倍无停顿式高速加工。

Non-step processing to depth 4~5 times the hole diameter allows this drill to be used for numerous high speed applications.

X 型横刃
X thinning
(DC<4)



R 型横刃
R thinning
(4≦DC)

※超过φ13 的尺寸为带凹槽直柄，但库存消耗完后将改为普通直柄。

※ For shank size over 13mm, shank geometry "with flat on shank" is changed to "without flat on shank" accordingly.

HSS-Co | TiN | h8 | SHANK h7 | 30°

上一页
FROM 直径 DC 5.6～9.15

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60592	**9.2**	81	131	10	45.2	2.1	●	64
62192	**9.25**				45.2	2.2	●	64
60593	**9.3**				45.2	2.2	●	64
62193	**9.35**				45.7	2.2	●	64
60594	**9.4**				45.8	2.2	●	64
62194	**9.45**				45.9	2.2	●	65
60595	**9.5**				47.5	2.2	●	65
62195	**9.55**	87	137		47.5	2.2	●	68
60596	**9.6**				47.6	2.2	●	68
62196	**9.65**				47.6	2.2	●	68
60597	**9.7**				47.7	2.3	●	68
62197	**9.75**				47.7	2.3	●	69
60598	**9.8**				47.6	2.3	●	69
62198	**9.85**				47.8	2.3	●	69
60599	**9.9**				47.8	2.3	●	69
62199	**9.95**				47.8	2.3	●	69
60600	**10**				48	2.3	●	70
62200	**10.05**		144	12	49	2.3	●	89
60601	**10.1**				49.1	2.4	●	89
62201	**10.15**				49.1	2.4	●	90
60602	**10.2**				49.2	2.4	●	90
62202	**10.25**				49.3	2.4	●	90
60603	**10.3**				50	2.4	●	90
62203	**10.35**				50.1	2.4	●	90
60604	**10.4**				50.2	2.4	●	90
62204	**10.45**				50.2	2.4	●	91
60605	**10.5**				50.4	2.4	●	91
62205	**10.55**				50.4	2.5	●	93
60606	**10.6**				50.5	2.5	●	93
62206	**10.65**	94	151		50.7	2.5	●	95
60607	**10.7**				50.7	2.5	●	96
62207	**10.75**				50.9	2.5	●	96
60608	**10.8**				50.8	2.5	●	98
62208	**10.85**				51.5	2.5	●	98
60609	**10.9**				51.6	2.5	●	98
62209	**10.95**				51.7	2.6	●	100

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60610	**11**	94	151	12	51.7	2.6	●	99
62210	**11.05**				51.9	2.6	●	100
60611	**11.1**				51.9	2.6	●	100
62211	**11.15**				52.1	2.6	●	100
60612	**11.2**				52.1	2.6	●	100
62212	**11.25**				52.5	2.6	●	102
60613	**11.3**				52.6	2.6	●	102
62213	**11.35**				52.8	2.6	●	102
60614	**11.4**				52.8	2.7	●	102
62214	**11.45**				52.9	2.7	●	103
60615	**11.5**				54.5	2.7	●	103
62215	**11.55**				54.6	2.7	●	104
60616	**11.6**				54.6	2.7	●	104
62216	**11.65**				54.6	2.7	●	105
60617	**11.7**				54.7	2.7	●	105
62217	**11.75**				54.7	2.7	●	106
60618	**11.8**				54.6	2.8	●	106
62218	**11.85**	101	158		54.7	2.8	●	109
60619	**11.9**				54.8	2.8	●	109
62219	**11.95**				54.8	2.8	●	110
60620	**12**				55	2.8	●	110
60621	**12.1**				55	2.8	●	110
60622	**12.2**				55	2.8	●	111
60623	**12.3**				55	2.9	●	112
60624	**12.4**				55	2.9	●	114
60625	**12.5**				55	2.9	●	114
60626	**12.6**				55	2.9	●	115
60627	**12.7**				55	3	●	116
60628	**12.8**				55	3	●	117
60629	**12.9**				55	3	●	118
60630	**13**				55	3	●	119
60635	**13.5**	90	150	16	48	3.1	●	162
60640	**14**				48	3.3	●	165
60641	**14.1**	95	155		48	3.3	●	171
60645	**14.5**				48	3.4	●	176
60650	**15**		161	20	50	3.5	●	244

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直径 DC 15.5～32 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDR	○	◎	◎	◎	○						◎	◎	○		○	○				○	

上一页
FROM 直径 DC 9.2～15

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60655	**15.5**	100	166	20	50	3.6	●	252
60656	**15.6**				50	3.6	●	254
60660	**16**				50	3.7	●	261
60665	**16.5**	106	172		50	3.8	●	270
60670	**17**				50	4	●	279
60675	**17.5**	112	178		50	4.1	●	294
60676	**17.6**				50	4.1	●	294
60680	**18**				50	4.2	●	305
60685	**18.5**	118	184		50	4.3	●	350
60690	**19**		194	25	56	4.4	●	443
60695	**19.5**	125	201		56	4.5	●	461
60696	**19.6**				56	4.6	●	465
60700	**20**				56	4.7	●	474
60705	**20.5**	128	204		56	4.8	●	489
60710	**21**				56	4.9	●	497
60711	**21.1**				56	4.9	●	511
60715	**21.5**	132	208		56	5	●	515

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
60720	**22**	132	208	25	56	5.1	●	529
60725	**22.5**	136	212		56	5.2	●	546
60730	**23**				56	5.4	●	567
60735	**23.5**				56	5.5	●	567
60740	**24**	140	220	32	60	5.6	●	780
60745	**24.5**				60	5.7	●	792
60750	**25**				60	5.8	●	801
60755	**25.5**	145	225		60	5.9	●	832
60760	**26**				60	6.1	●	846
60765	**26.5**				60	6.2	●	859
60770	**27**	150	230		60	6.3	●	908
60780	**28**				60	6.5	●	917
60790	**29**	155	235		60	6.8	●	972
60800	**30**				60	7	●	1,028
60810	**31**	160	240		60	7.2	●	1,060
60820	**32**	165	245		60	7.5	●	1,125

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

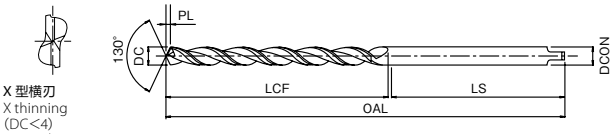
G-LIST No. | **DH1020**

一般加工用长刃型钻头
LONG FOR GENERAL APPLICATION

EX-GDXL

切削条件 Cutting Conditions | P.430

刚性抛物线槽形使得 7~10 倍的深孔加工成为可能。
Rigid parabolic flutes can increase hole-processing depth to 7~10 times the hole diameter.



X 型横刃
X thinning
(DC<4)

R 型横刃
R thinning
(4≦DC)

HSS-Co | TiN | h8 | 38°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8590520	2	40	100	2	50	0.5	●	5
8591020		50			50	0.5	●	5
8590521	2.1	40		2.1	50	0.5	●	5
8591021		50			50	0.5	●	6
8590522	2.2	40		2.2	50	0.5	●	5
8591022		50			50	0.5	●	6
8590523	2.3	40		2.3	50	0.5	●	6
8591023		50			50	0.5	●	6
8590524	2.4	40		2.4	50	0.6	●	6
8591024		50			50	0.6	●	6
8591025	2.5			2.5	50	0.6	●	6
8591026	2.6			2.6	50	0.6	●	6
8591027	2.7			2.7	50	0.6	●	6
8591028	2.8			2.8	50	0.7	●	6
8591029	2.9			2.9	50	0.7	●	7
8591030	3	55		3	35	0.7	●	7
8591530		75	150		65	0.7	●	9
8592030		100	200		90	0.7	●	13
8591031	3.1	55	100	3.1	35	0.7	●	7
8591531		75	150		65	0.7	●	12
8592031		100	200		90	0.7	●	14
8591032	3.2	55	100	3.2	35	0.7	●	7
8591532		75	150		65	0.7	●	10
8592032		100	200		90	0.7	●	15
8591033	3.3	55	100	3.3	35	0.8	●	7
8591533		75	150		65	0.8	●	11
8592033		100	200		90	0.8	●	15
8591034	3.4	55	100	3.4	35	0.8	●	8
8591534		75	150		65	0.8	●	12
8592034		100	200		90	0.8	●	16
8591035	3.5	55	100	3.5	35	0.8	●	9
8591535		75	150		65	0.8	●	11
8592035		100	200		90	0.8	●	16
8591036	3.6	55	100	3.6	35	0.8	●	8
8591536		75	150		65	0.8	●	12
8592036		100	200		90	0.8	●	17
8591037	3.7	55	100	3.7	35	0.9	●	9
8591537		75	150		65	0.9	●	12
8592037		100	200		90	0.9	●	18
8591038	3.8	55	100	3.8	35	0.9	●	9
8591538		75	150		65	0.9	●	13
8592038		100	200		90	0.9	●	18
8591039	3.9	55	100	3.9	35	0.9	●	10
8591539		75	150		65	0.9	●	13
8592039		100	200		90	0.9	●	19
8591040	4	60	100	4	30	0.9	●	10
8591540		80	150		60	0.9	●	14
8592040		100	200		90	0.9	●	20
8591041	4.1	60	100	4.1	30	1	●	10
8591541		80	150		60	1	●	14
8592041		100	200		90	1	●	20
8591042	4.2	60	100	4.2	30	1	●	10
8591542		80	150		60	1	●	15

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8592042	4.2	100	200	4.2	90	1	●	22
8591043	4.3	60	100	4.3	30	1	●	11
8591543		80	150		60	1	●	15
8592043		100	200		90	1	●	22
8591044	4.4	60	100	4.4	30	1	●	11
8591544		80	150		60	1	●	16
8592044		100	200		90	1	●	23
8591045	4.5	60	100	4.5	30	1	●	11
8591545		80	150		60	1	●	17
8592045		100	200		90	1	●	23
8591046	4.6	60	100	4.6	30	1.1	●	12
8591546		80	150		60	1.1	●	17
8592046		100	200		90	1.1	●	24
8591547	4.7	80	150	4.7	60	1.1	●	18
8592047		100	200		90	1.1	●	25
8591548	4.8	80	150	4.8	60	1.1	●	19
8592048		100	200		90	1.1	●	26
8591549	4.9	80	150	4.9	60	1.1	●	19
8592049		100	200		90	1.1	●	27
8591550	5	85	150	5	55	1.2	●	20
8592050		105	200		85	1.2	●	28
8592550		130	250		110	1.2	●	34
8604050		160			80	1.2	●	35
8591551	5.1	85	150	5.1	55	1.2	●	20
8592051		105	200		85	1.2	●	29
8604051		160	250		80	1.2	●	33
8591552	5.2	85	150	5.2	55	1.2	●	21
8592052		105	200		85	1.2	●	30
8604052		160	250		80	1.2	●	34
8591553	5.3	85	150	5.3	55	1.2	●	21
8592053		105	200		85	1.2	●	32
8604053		160	250		80	1.2	●	35
8591554	5.4	85	150	5.4	55	1.3	●	22
8592054		105	200		85	1.3	●	32
8604054		160	250		80	1.3	●	37
8591555	5.5	85	150	5.5	55	1.3	●	23
8592055		105	200		85	1.3	●	33
8604055		160	250		80	1.3	●	37
8591556	5.6	85	150	5.6	55	1.3	●	23
8592056		105	200		85	1.3	●	34
8604056		160	250		80	1.3	●	39
8591557	5.7	85	150	5.7	55	1.3	●	24
8592057		105	200		85	1.3	●	35
8604057		160	250		80	1.3	●	40
8591558	5.8	85	150	5.8	55	1.4	●	25
8592058		105	200		85	1.4	●	36
8604058		160	250		80	1.4	●	41
8591559	5.9	85	150	5.9	55	1.4	●	26
8592059		105	200		85	1.4	●	36
8604059		160	250		80	1.4	●	42
8591560	6	90	150	6	50	1.4	●	26
8592060		110	200		80	1.4	●	37
8604060		160	250		80	1.4	●	43

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直径 DC 6～9 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDXL	○	◎	◎	◎	○						○	◎	◎			○				○	

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FROM 直径 DC 2～6

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8604260	**6**	200	300	6	90	1.4	●	55
8591561	**6.1**	90	150	6.1	50	1.4	●	29
8592061		110	200		80	1.4	●	42
8604061		160	250		80	1.4	●	47
8604261		200	300		90	1.4	●	56
8591562	**6.2**	90	150	6.2	50	1.4	●	30
8592062		110	200		80	1.4	●	42
8604062		160	250		80	1.4	●	48
8604262		200	300		90	1.4	●	57
8591563	**6.3**	90	150	6.3	50	1.5	●	31
8592063		110	200		80	1.5	●	44
8604063		160	250		80	1.5	●	49
8604263		200	300		90	1.5	●	58
8591564	**6.4**	90	150	6.4	50	1.5	●	32
8592064		110	200		80	1.5	●	44
8604064		160	250		80	1.5	●	51
8604264		200	300		90	1.5	●	60
8591565	**6.5**	90	150	6.5	50	1.5	●	33
8592065		110	200		80	1.5	●	46
8604065		160	250		80	1.5	●	53
8604265		200	300		90	1.5	●	62
8591566	**6.6**	90	150	6.6	50	1.5	●	34
8592066		110	200		80	1.5	●	48
8604066		160	250		80	1.5	●	54
8604266		200	300		90	1.5	●	64
8591567	**6.7**	90	150	6.7	50	1.6	●	35
8592067		110	200		80	1.6	●	48
8604067		160	250		80	1.6	●	55
8604267		200	300		90	1.6	●	66
8591568	**6.8**	90	150	6.8	50	1.6	●	35
8592068		110	200		80	1.6	●	50
8604068		160	250		80	1.6	●	57
8604268		200	300		90	1.6	●	67
8591569	**6.9**	90	150	6.9	50	1.6	●	36
8592069		110	200		80	1.6	●	50
8604069		160	250		80	1.6	●	58
8604269		200	300		90	1.6	●	70
8591570	**7**	90	150	7	50	1.6	●	37
8592070		110	200		80	1.6	●	52
8604070		160	250		80	1.6	●	59
8604270		200	300		90	1.6	●	40
8591571	**7.1**	90	150	7.1	50	1.7	●	38
8592071		110	200		80	1.7	●	53
8604071		160	250		80	1.7	●	62
8604271		200	300		90	1.7	●	73
8591572	**7.2**	90	150	7.2	50	1.7	●	38
8592072		110	200		80	1.7	●	53
8604072		160	250		80	1.7	●	62
8604272		200	300		90	1.7	●	74
8591573	**7.3**	90	150	7.3	50	1.7	●	39
8592073		110	200		80	1.7	●	55
8604073		160	250		80	1.7	●	65
8604273		200	300		90	1.7	●	76

注1) 柄部形状请参考 P.1011。

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8591574	**7.4**	90	150	7.4	50	1.7	●	39
8592074		110	200		80	1.7	●	57
8604074		160	250		80	1.7	●	65
8604274		200	300		90	1.7	●	78
8591575	**7.5**	90	150	7.5	50	1.7	●	42
8592075		110	200		80	1.7	●	58
8604075		160	250		80	1.7	●	67
8604275		200	300		90	1.7	●	80
8592076	**7.6**	110	200	7.6	80	1.8	●	59
8604076		160	250		80	1.8	●	70
8604276		200	300		90	1.8	●	82
8592077	**7.7**	110	200	7.7	80	1.8	●	61
8604077		160	250		80	1.8	●	70
8604277		200	300		90	1.8	●	83
8592078	**7.8**	110	200	7.8	80	1.8	●	62
8604078		160	250		80	1.8	●	72
8604278		200	300		90	1.8	●	84
8592079	**7.9**	110	200	7.9	80	1.8	●	64
8604079		160	250		80	1.8	●	74
8604279		200	300		90	1.8	●	88
8592080	**8**	115	200	8	75	1.9	●	65
8604080		160	250		80	1.9	●	76
8604280		200	300		90	1.9	●	90
8592081	**8.1**	115	200	8.1	75	1.9	●	66
8604081		160	250		80	1.9	●	75
8604281		200	300		90	1.9	●	91
8592082	**8.2**	115	200	8.2	75	1.9	●	68
8604082		160	250		80	1.9	●	79
8604282		200	300		90	1.9	●	93
8592083	**8.3**	115	200	8.3	75	1.9	●	69
8604083		160	250		80	1.9	●	81
8604283		200	300		90	1.9	●	97
8592084	**8.4**	115	200	8.4	75	2	●	70
8604084		160	250		80	2	●	83
8604284		200	300		90	2	●	99
8592085	**8.5**	115	200	8.5	75	2	●	72
8604085		160	250		80	2	●	84
8604285		200	300		90	2	●	100
8592086	**8.6**	115	200	8.6	75	2	●	73
8604086		160	250		80	2	●	86
8604286		200	300		90	2	●	101
8592087	**8.7**	115	200	8.7	75	2	●	75
8604087		160	250		80	2	●	89
8604287		200	300		90	2	●	104
8592088	**8.8**	115	200	8.8	75	2.1	●	76
8604088		160	250		80	2.1	●	90
8604288		200	300		90	2.1	●	107
8592089	**8.9**	115	200	8.9	75	2.1	●	78
8604089		160	250		80	2.1	●	93
8604289		200	300		90	2.1	●	110
8592090	**9**	115	200	9	75	2.1	●	79
8604090		160	250		80	2.1	●	94
8604290		200	300		90	2.1	●	110

NOTE. Dimension of shank : refer to Appendix p.1011

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直径 DC 9.1～12.6 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

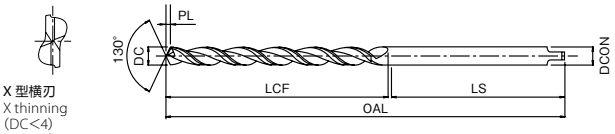
G-LIST No. | DH1020

一般加工用长刃型钻头
LONG FOR GENERAL APPLICATION

EX-GDXL

切削条件 Cutting Conditions | P.430

刚性抛物线槽形使得 7~10 倍的深孔加工成为可能。
Rigid parabolic flutes can increase hole-processing depth to 7~10 times the hole diameter.



HSS-Co | TiN | h8 | 38°

上一页
FROM 直径 DC 6～9

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8592091	9.1	115	200	9.1	75	2.1	●	81
8604091		160	250		80	2.1	●	97
8604291		200	300		90	2.1	●	114
8592092	9.2	115	200	9.2	75	2.1	●	82
8604092		160	250		80	2.1	●	98
8604292		200	300		90	2.1	●	116
8592093	9.3	115	200	9.3	75	2.2	●	85
8604093		160	250		80	2.2	●	101
8604293		200	300		90	2.2	●	119
8592094	9.4	115	200	9.4	75	2.2	●	85
8604094		160	250		80	2.2	●	103
8604294		200	300		90	2.2	●	121
8592095	9.5	115	200	9.5	75	2.2	●	88
8604095		160	250		80	2.2	●	103
8604295		200	300		90	2.2	●	122
8592096	9.6	115	200	9.6	75	2.2	●	88
8604096		160	250		80	2.2	●	105
8604296		200	300		90	2.2	●	123
8592097	9.7	115	200	9.7	75	2.3	●	90
8604097		160	250		80	2.3	●	106
8604297		200	300		90	2.3	●	127
8592098	9.8	115	200	9.8	75	2.3	●	91
8604098		160	250		80	2.3	●	108
8604298		200	300		90	2.3	●	128
8592099	9.9	115	200	9.9	75	2.3	●	92
8604099		160	250		80	2.3	●	111
8604299		200	300		90	2.3	●	131
8592100	10	120	200	10	70	2.3	●	94
8604100		160	250		80	2.3	●	112
8604300		200	300		90	2.3	●	133
8592101	10.1	120	200	10.1	70	2.4	●	96
8604101		160	250		80	2.4	●	113
8604301		200	300		90	2.4	●	152
8592102	10.2	120	200	10.2	70	2.4	●	98
8604102		160	250		80	2.4	●	116
8604302		200	300		90	2.4	●	150
8592103	10.3	120	200	10.3	70	2.4	●	98
8604103		160	250		80	2.4	●	119
8604303		200	300		90	2.4	●	151
8592104	10.4	120	200	10.4	70	2.4	●	100
8604104		160	250		80	2.4	●	120
8604304		200	300		90	2.4	●	153
8592105	10.5	120	200	10.5	70	2.4	●	101
8604105		160	250		80	2.4	●	123
8604305		200	300		90	2.4	●	157
8592106	10.6	120	200	10.6	70	2.5	●	104
8604106		160	250		80	2.5	●	126
8604306		200	300		90	2.5	●	163
8592107	10.7	120	200	10.7	70	2.5	●	107
8604107		160	250		80	2.5	●	127
8604307		200	300		90	2.5	●	166
8592108	10.8	120	200	10.8	70	2.5	●	108
8604108		160	250		80	2.5	●	131
8604308		200	300		90	2.5	●	167
8592109	10.9	120	200	10.9	70	2.5	●	109
8604109		160	250		80	2.5	●	132
8604309		200	300		90	2.5	●	172
8592110	11	120	200	11	70	2.6	●	111
8604110		160	250		80	2.6	●	133
8604310		200	300		90	2.6	●	170
8592111	11.1	120	200	11.1	70	2.6	●	115
8604111		160	250		80	2.6	●	139
8604311		200	300		90	2.6	●	175
8592112	11.2	120	200	11.2	70	2.6	●	117
8604112		160	250		80	2.6	●	141
8604312		200	300		90	2.6	●	179
8592113	11.3	120	200	11.3	70	2.6	●	117
8604113		160	250		80	2.6	●	145
8604313		200	300		90	2.6	●	180
8592114	11.4	120	200	11.4	70	2.7	●	121
8604114		160	250		80	2.7	●	147
8604314		200	300		90	2.7	●	183
8592115	11.5	120	200	11.5	70	2.7	●	123
8604115		160	250		80	2.7	●	148
8604315		200	300		90	2.7	●	182
8592116	11.6	120	200	11.6	70	2.7	●	125
8604116		160	250		80	2.7	●	153
8604316		200	300		90	2.7	●	191
8592117	11.7	120	200	11.7	70	2.7	●	126
8604117		160	250		80	2.7	●	155
8604317		200	300		90	2.7	●	194
8592118	11.8	120	200	11.8	70	2.8	●	129
8604118		160	250		80	2.8	●	155
8604318		200	300		90	2.8	●	198
8592119	11.9	120	200	11.9	70	2.8	●	132
8604119		160	250		80	2.8	●	160
8604319		200	300		90	2.8	●	200
8592120	12	120	200	12	70	2.8	●	134
8604120		160	250		80	2.8	●	162
8604320		200	300		90	2.8	●	201
8592121	12.1	120	200	12.1	70	2.8	●	135
8604121		160	250		80	2.8	●	163
8604321		200	300		90	2.8	●	207
8592122	12.2	120	200	12.2	70	2.8	●	139
8604122		160	250		80	2.8	●	167
8604322		200	300		90	2.8	●	210
8592123	12.3	120	200	12.3	70	2.9	●	140
8604123		160	250		80	2.9	●	167
8604323		200	300		90	2.9	●	212
8592124	12.4	120	200	12.4	70	2.9	●	143
8604124		160	250		80	2.9	●	173
8604324		200	300		90	2.9	●	214
8592125	12.5	120	200	12.5	70	2.9	●	146
8604125		160	250		80	2.9	●	174
8604325		200	300		90	2.9	●	215
8592126	12.6	120	200	12.6	70	2.9	●	145

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直径 DC 12.6～13 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-GDXL	○	◎	◎	◎	○						○	◎	◎			○				○	

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FROM 直径 **DC** **9.1～12.6**

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8604126	**12.6**	160	250	12.6	80	2.9	●	176
8604326		200	300		90	2.9	●	223
8592127	**12.7**	120	200	12.7	70	3	●	148
8604127		160	250		80	3	●	179
8604327		200	300		90	3	●	226
8592128	**12.8**	120	200	12.8	70	3	●	150
8604128		160	250		80	3	●	181

注1) 柄部形状请参考 P.1011。

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8604328	**12.8**	200	300	12.8	90	3	●	225
8592129	**12.9**	120	200	12.9	70	3	●	154
8604129		160	250		80	3	●	185
8604329		200	300		90	3	●	231
8592130	**13**	120	200	13	70	3	●	156
8604130		160	250		80	3	●	186
8604330		200	300		90	3	●	233

NOTE. Dimension of shank : refer to Appendix p.1011

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DH1003

一般加工用内冷油孔标准刃长型钻头

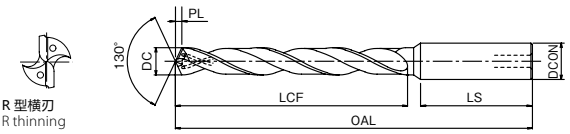
REGULAR WITH INTERNAL COOLANT SUPPLY FOR GENERAL APPLICATION

EX-HO-GDR

切削条件 Cutting Conditions | P.431

由于带有内冷油孔，能够实现高效率、长寿命加工。特别是对不锈钢等难加工材料有较好效果。

This drill is highly efficient with difficult to machine materials (such as stainless steels) and has long tool life due to the internal coolant supply.



HSS-Co | TiN | h8 | SHANK h6 (12<DC) | SHANK h7 (DC≦12) | 30°

※φ12以下为普通直柄。
※Drill dia. ≦ 12 : with plain straight shank
※φ12以上为带凹槽直柄。
※ 12< Drill dia. : straight and flat shank

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
64060	**6**	57	101	6	42	1.4	●	18
64061	**6.1**	63	107	6	42	1.4	●	20
64062	**6.2**	63	107	6	42	1.4	●	20
64063	**6.3**	63	107	6	42	1.5	●	21
64064	**6.4**	63	107	6	42	1.5	●	23
64065	**6.5**	63	107	6	42	1.5	●	22
64066	**6.6**	63	107	7	41.3	1.5	●	26
64067	**6.7**	63	107	7	41.4	1.6	●	25
64068	**6.8**	69	113	7	41.6	1.6	●	26
64069	**6.9**	69	113	7	41.8	1.6	●	26
64070	**7**	69	113	7	42	1.6	●	27
64071	**7.1**	69	113	8	40.3	1.7	●	31
64072	**7.2**	69	113	8	40.5	1.7	●	31
64073	**7.3**	69	113	8	40.7	1.7	●	33
64074	**7.4**	69	113	8	40.9	1.7	●	33
64075	**7.5**	69	113	8	41.1	1.7	●	32
64076	**7.6**	75	119	8	41.3	1.8	●	35
64077	**7.7**	75	119	8	41.4	1.8	●	35
64078	**7.8**	75	119	8	41.6	1.8	●	35
64079	**7.9**	75	119	8	41.8	1.8	●	35
64080	**8**	75	119	8	42	1.9	●	35
64081	**8.1**	75	125	9	46.3	1.9	●	45
64082	**8.2**	75	125	9	46.5	1.9	●	46
64083	**8.3**	75	125	9	46.7	1.9	●	46
64084	**8.4**	75	125	9	46.9	2	●	48
64085	**8.5**	75	125	9	47.1	2	●	48
64086	**8.6**	81	131	9	47.3	2	●	51
64087	**8.7**	81	131	9	47.4	2	●	50
64088	**8.8**	81	131	9	47.6	2.1	●	51
64089	**8.9**	81	131	9	47.8	2.1	●	51
64090	**9**	81	131	9	48	2.1	●	52
64091	**9.1**	81	131	10	46.3	2.1	●	57
64092	**9.2**	81	131	10	46.5	2.1	●	58
64093	**9.3**	81	131	10	46.7	2.2	●	59
64094	**9.4**	81	131	10	46.9	2.2	●	59
64095	**9.5**	81	131	10	47.1	2.2	●	60
64096	**9.6**	87	137	10	47.3	2.2	●	61
64097	**9.7**	87	137	10	47.4	2.3	●	62
64098	**9.8**	87	137	10	47.6	2.3	●	63
64099	**9.9**	87	137	10	47.8	2.3	●	63
64100	**10**	87	137	10	48	2.3	●	64
64101	**10.1**	87	144	11	53.3	2.4	●	74
64102	**10.2**	87	144	11	53.5	2.4	●	75
64103	**10.3**	87	144	11	53.7	2.4	●	75
64104	**10.4**	87	144	11	53.9	2.4	●	76
64105	**10.5**	87	144	11	54.1	2.4	●	77
64106	**10.6**	87	144	11	54.3	2.5	●	77
64107	**10.7**	94	151	11	54.4	2.5	●	81
64108	**10.8**	94	151	11	54.6	2.5	●	81
64109	**10.9**	94	151	11	54.8	2.5	●	82
64110	**11**	94	151	11	55	2.6	●	83
64111	**11.1**	94	151	12	53.3	2.6	●	91
64112	**11.2**	94	151	12	53.5	2.6	●	92
64113	**11.3**	94	151	12	53.7	2.6	●	92

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
64114	**11.4**	94	151	12	53.9	2.7	●	92
64115	**11.5**	94	151	12	54.1	2.7	●	93
64116	**11.6**	94	151	12	54.3	2.7	●	94
64117	**11.7**	94	151	12	54.4	2.7	●	95
64118	**11.8**	94	151	12	54.6	2.8	●	96
64119	**11.9**	101	158	12	54.8	2.8	●	99
64120	**12**	101	158	12	55	2.8	●	100
64121	**12.1**	80	140	16	48	2.8	●	128
64122	**12.2**	80	140	16	48	2.8	●	130
64123	**12.3**	80	140	16	48	2.9	●	130
64124	**12.4**	80	140	16	48	2.9	●	130
64125	**12.5**	80	140	16	48	2.9	●	133
64126	**12.6**	85	145	16	48	2.9	●	134
64127	**12.7**	85	145	16	48	3	●	135
64128	**12.8**	85	145	16	48	3	●	136
64129	**12.9**	85	145	16	48	3	●	137
64130	**13**	85	145	16	48	3	●	138
64131	**13.1**	85	145	16	48	3.1	●	138
64132	**13.2**	85	145	16	48	3.1	●	138
64133	**13.3**	90	150	16	48	3.1	●	141
64134	**13.4**	90	150	16	48	3.1	●	143
64135	**13.5**	90	150	16	48	3.1	●	144
64136	**13.6**	90	150	16	48	3.2	●	144
64137	**13.7**	90	150	16	48	3.2	●	145
64138	**13.8**	90	150	16	48	3.2	●	146
64139	**13.9**	90	150	16	48	3.2	●	146
64140	**14**	90	150	16	48	3.3	●	148
64141	**14.1**	90	150	16	48	3.3	●	151
64142	**14.2**	95	155	16	48	3.3	●	151
64143	**14.3**	95	155	16	48	3.3	●	153
64144	**14.4**	95	155	16	48	3.4	●	154
64145	**14.5**	95	155	16	48	3.4	●	156
64146	**14.6**	95	161	20	50	3.4	●	210
64147	**14.7**	95	161	20	50	3.4	●	210
64148	**14.8**	95	161	20	50	3.5	●	210
64149	**14.9**	95	161	20	50	3.5	●	213
64150	**15**	95	161	20	50	3.5	●	214
64151	**15.1**	100	166	20	50	3.5	●	234
64152	**15.2**	100	166	20	50	3.5	●	233
64153	**15.3**	100	166	20	50	3.6	●	233
64154	**15.4**	100	166	20	50	3.6	●	233
64155	**15.5**	100	166	20	50	3.6	●	235
64156	**15.6**	100	166	20	50	3.6	●	235
64157	**15.7**	100	166	20	50	3.7	●	239
64158	**15.8**	100	166	20	50	3.7	●	240
64159	**15.9**	100	166	20	50	3.7	●	241
64160	**16**	100	166	20	50	3.7	●	243
64161	**16.1**	106	172	20	50	3.8	●	246
64162	**16.2**	106	172	20	50	3.8	●	248
64163	**16.3**	106	172	20	50	3.8	●	249
64164	**16.4**	106	172	20	50	3.8	●	252
64165	**16.5**	106	172	20	50	3.8	●	252
64166	**16.6**	106	172	20	50	3.9	●	253
64167	**16.7**	106	172	20	50	3.9	●	254

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直径 DC 16.8～40 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-HO-GDR	◎	◎	◎	◎	○					◎	○	○	◎	○	○	○	○			○	

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FROM 直径 **DC** 6～16.7

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
64168	**16.8**	106	172	20	50	3.9	●	257
64169	**16.9**				50	3.9	●	253
64170	**17**				50	4	●	259
64171	**17.1**	112	178		50	4	●	254
64172	**17.2**				50	4	●	264
64173	**17.3**				50	4	●	252
64174	**17.4**				50	4.1	●	254
64175	**17.5**				50	4.1	●	273
64176	**17.6**				50	4.1	●	273
64177	**17.7**				50	4.1	●	273
64178	**17.8**				50	4.2	●	274
64179	**17.9**				50	4.2	●	275
64180	**18**				50	4.2	●	279
64181	**18.1**	118	184		50	4.2	●	283
64182	**18.2**				50	4.2	●	287
64183	**18.3**				50	4.3	●	289
64184	**18.4**				50	4.3	●	289
64185	**18.5**				50	4.3	●	289
64186	**18.6**		194	25	56	4.3	●	393
64187	**18.7**				56	4.4	●	389
64188	**18.8**				56	4.4	●	394
64189	**18.9**				56	4.4	●	392
64190	**19**				56	4.4	●	396
64191	**19.1**	125	201		56	4.5	●	402
64192	**19.2**				56	4.5	●	405
64193	**19.3**				56	4.5	●	404
64194	**19.4**				56	4.5	●	409
64195	**19.5**				56	4.5	●	410
64196	**19.6**				56	4.6	●	412
64197	**19.7**				56	4.6	●	416
64198	**19.8**				56	4.6	●	415
64199	**19.9**				56	4.6	●	419
64200	**20**				56	4.7	●	421

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
64205	**20.5**	128	204	25	56	4.8	●	438
64210	**21**				56	4.9	●	440
64211	**21.1**	132	208		56	4.9	●	439
64215	**21.5**				56	5	●	457
64220	**22**				56	5.1	●	468
64225	**22.5**	136	212		56	5.2	●	481
64230	**23**				56	5.4	●	496
64235	**23.5**				56	5.5	●	507
64240	**24**	140	220	32	60	5.6	●	690
64245	**24.5**				60	5.7	●	705
64250	**25**				60	5.8	●	716
64255	**25.5**	145	225		60	5.9	●	728
64260	**26**				60	6.1	●	740
64265	**26.5**				60	6.2	●	758
64270	**27**	150	230		60	6.3	●	798
64275	**27.5**				60	6.4	●	803
64280	**28**				60	6.5	●	809
64285	**28.5**	155	235		60	6.6	●	838
64290	**29**				60	6.8	●	861
64295	**29.5**				60	6.9	●	877
64300	**30**				60	7	●	903
64305	**30.5**	160	240		60	7.1	●	925
64310	**31**				60	7.2	●	946
64315	**31.5**				60	7.3	●	939
64320	**32**	165	245		60	7.5	●	1,008
64330	**33**				60	7.7	●	1,030
64340	**34**	170	260	40	70	7.9	●	1,430
64350	**35**				70	8.2	●	1,450
64360	**36**	175	265		70	8.4	●	1,521
64370	**37**				70	8.6	●	1,537
64380	**38**	180	270		70	8.9	●	1,591
64390	**39**				70	9.1	●	1,650
64400	**40**				70	9.3	●	1,702

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | **DH1004**

一般加工用MT柄标准刃长型钻头

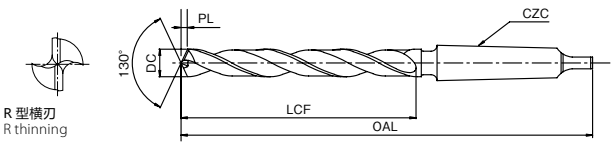
REGULAR WITH MORSE TAPER SHANK FOR GENERAL APPLICATION

EX-MT-GDR

切削条件 Cutting Conditions | P.429

适用于车床、多轴专机。

This drill is suitable for lathe and multi-spindle specialized machines.



HSS-Co | TiN | h8 | 30°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
64560	**6**	57	137	MT1	1.4	●	67
64565	**6.5**	63	143		1.5	●	70
64568	**6.8**	69	149		1.6	●	72
64570	**7**				1.6	●	73
64575	**7.5**				1.7	●	75
64580	**8**	75	155		1.9	●	79
64585	**8.5**		158		2	●	84
64588	**8.8**	81	164		2.1	●	84
64590	**9**				2.1	●	84
64595	**9.5**				2.2	●	88
64600	**10**	87	170		2.3	●	94
64603	**10.3**				2.4	●	95
64605	**10.5**				2.4	●	98
64610	**11**	94	177		2.6	●	106
64615	**11.5**				2.7	●	110
64620	**12**	101	184		2.8	●	118
64625	**12.5**				2.9	●	122
64630	**13**				3	●	128
64635	**13.5**	106	189		3.1	●	133
64640	**14**				3.3	●	140
64641	**14.1**	109	209	MT2	3.3	●	235
64642	**14.2**				3.3	●	238
64643	**14.3**				3.3	●	245
64644	**14.4**				3.4	●	245
64645	**14.5**				3.4	●	240
64646	**14.6**				3.4	●	241
64647	**14.7**				3.4	●	249
64648	**14.8**				3.5	●	254
64649	**14.9**				3.5	●	246
64650	**15**				3.5	●	249
64651	**15.1**	112	212		3.5	●	259
64652	**15.2**				3.5	●	261
64653	**15.3**				3.6	●	260
64654	**15.4**				3.6	●	260
64655	**15.5**				3.6	●	259
64656	**15.6**				3.6	●	265
64657	**15.7**				3.7	●	260
64658	**15.8**				3.7	●	270
64659	**15.9**				3.7	●	263
64660	**16**				3.7	●	269
64661	**16.1**	115	215		3.8	●	276
64662	**16.2**				3.8	●	278
64663	**16.3**				3.8	●	281
64664	**16.4**				3.8	●	276
64665	**16.5**				3.8	●	276

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
64666	**16.6**	115	215	MT2	3.9	●	280
64667	**16.7**				3.9	●	281
64668	**16.8**				3.9	●	285
64669	**16.9**				3.9	●	288
64670	**17**				4	●	285
64671	**17.1**	118	218		4	●	289
64672	**17.2**				4	●	299
64673	**17.3**				4	●	296
64674	**17.4**				4.1	●	301
64675	**17.5**				4.1	●	296
64676	**17.6**				4.1	●	303
64677	**17.7**				4.1	●	304
64678	**17.8**				4.2	●	304
64679	**17.9**				4.2	●	306
64680	**18**				4.2	●	313
64681	**18.1**	122	222		4.2	●	316
64682	**18.2**				4.2	●	320
64683	**18.3**				4.3	●	320
64684	**18.4**				4.3	●	318
64685	**18.5**				4.3	●	320
64686	**18.6**				4.3	●	322
64687	**18.7**				4.4	●	328
64688	**18.8**				4.4	●	325
64689	**18.9**				4.4	●	328
64690	**19**				4.4	●	327
64691	**19.1**	125	225		4.5	●	336
64692	**19.2**				4.5	●	339
64693	**19.3**				4.5	●	335
64694	**19.4**				4.5	●	341
64695	**19.5**				4.5	●	339
64696	**19.6**				4.6	●	345
64697	**19.7**				4.6	●	346
64698	**19.8**				4.6	●	348
64699	**19.9**				4.6	●	351
64700	**20**				4.7	●	355
64701	**20.1**	128	228		4.7	●	374
64702	**20.2**				4.7	●	380
64703	**20.3**				4.7	●	378
64704	**20.4**				4.8	●	378
64705	**20.5**				4.8	●	378
64706	**20.6**				4.8	●	380
64707	**20.7**				4.8	●	388
64708	**20.8**				4.8	●	386
64709	**20.9**				4.9	●	390
64710	**21**				4.9	●	387

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直径 DC 21.1～29.7 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-MT-GDR	○	◎	◎	◎	○						◎	◎	○		○	○				○	

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FROM 直径 DC 6～21

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
64711	**21.1**	128	228	MT2	4.9	●	395
64712	**21.2**				4.9	●	400
64713	**21.3**	132	232		5	●	406
64714	**21.4**				5	●	409
64715	**21.5**				5	●	412
64716	**21.6**				5	●	413
64717	**21.7**				5.1	●	416
64718	**21.8**				5.1	●	421
64719	**21.9**				5.1	●	419
64720	**22**				5.1	●	421
64721	**22.1**				5.2	●	427
64722	**22.2**				5.2	●	429
64723	**22.3**				5.2	●	429
64724	**22.4**				5.2	●	433
64725	**22.5**	136	236		5.2	●	438
64726	**22.6**				5.3	●	440
64727	**22.7**				5.3	●	449
64728	**22.8**				5.3	●	447
64729	**22.9**				5.3	●	469
64730	**23**				5.4	●	448
64731	**23.1**		256		5.4	●	606
64732	**23.2**				5.4	●	607
64733	**23.3**				5.4	●	612
64734	**23.4**				5.5	●	627
64735	**23.5**				5.5	●	623
64736	**23.6**				5.5	●	614
64737	**23.7**	140	260	MT3	5.5	●	636
64738	**23.8**				5.5	●	635
64739	**23.9**				5.6	●	635
64740	**24**				5.6	●	629
64741	**24.1**				5.6	●	640
64742	**24.2**				5.6	●	645
64743	**24.3**				5.7	●	645
64744	**24.4**				5.7	●	645
64745	**24.5**				5.7	●	643
64746	**24.6**				5.7	●	657
64747	**24.7**				5.8	●	660
64748	**24.8**				5.8	●	664
64749	**24.9**				5.8	●	675
64750	**25**				5.8	●	680
64751	**25.1**	145	265		5.9	●	680
64752	**25.2**				5.9	●	686
64753	**25.3**				5.9	●	691
64754	**25.4**				5.9	●	690

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
64755	**25.5**	145	265	MT3	5.9	●	688
64756	**25.6**				6	●	686
64757	**25.7**				6	●	686
64758	**25.8**				6	●	688
64759	**25.9**				6	●	690
64760	**26**				6.1	●	688
64761	**26.1**				6.1	●	734
64762	**26.2**				6.1	●	734
64763	**26.3**				6.1	●	735
64764	**26.4**				6.2	●	735
64765	**26.5**				6.2	●	744
64766	**26.6**	150	270		6.2	●	757
64767	**26.7**				6.2	●	757
64768	**26.8**				6.2	●	762
64769	**26.9**				6.3	●	765
64770	**27**				6.3	●	768
64771	**27.1**				6.3	●	763
64772	**27.2**				6.3	●	766
64773	**27.3**				6.4	●	766
64774	**27.4**				6.4	●	781
64775	**27.5**				6.4	●	783
64776	**27.6**				6.4	●	777
64777	**27.7**				6.5	●	796
64778	**27.8**				6.5	●	801
64779	**27.9**				6.5	●	801
64780	**28**				6.5	●	798
64781	**28.1**	155	275		6.6	●	816
64782	**28.2**				6.6	●	816
64783	**28.3**				6.6	●	822
64784	**28.4**				6.6	●	843
64785	**28.5**				6.6	●	852
64786	**28.6**				6.7	●	843
64787	**28.7**				6.7	●	843
64788	**28.8**				6.7	●	843
64789	**28.9**				6.7	●	846
64790	**29**				6.8	●	849
64791	**29.1**				6.8	●	846
64792	**29.2**				6.8	●	866
64793	**29.3**				6.8	●	867
64794	**29.4**				6.9	●	867
64795	**29.5**				6.9	●	864
64796	**29.6**				6.9	●	868
64797	**29.7**				6.9	●	887

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直径 DC 29.8～50 NEXT

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | DH1004

一般加工用MT柄标准刃长型钻头

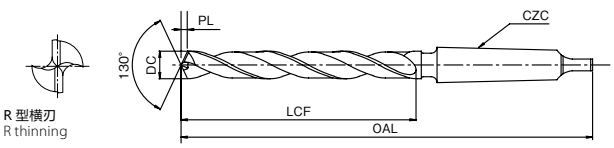
REGULAR WITH MORSE TAPER SHANK FOR GENERAL APPLICATION

EX-MT-GDR

切削条件 Cutting Conditions | P.429

适用于车床、多轴专机。

This drill is suitable for lathe and multi-spindle specialized machines.



HSS-Co | TiN | h8 | 30°

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FROM 直径 DC 21.1～29.7

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
64798	**29.8**	155	275	MT3	6.9	●	882
64799	**29.9**				7	●	891
64800	**30**				7	●	882
64805	**30.5**	160	280		7.1	●	920
64810	**31**				7.2	●	929
64815	**31.5**				7.3	●	950
64820	**32**	165	285		7.5	●	985
64825	**32.5**		310	MT4	7.6	●	1,409
64830	**33**				7.7	●	1,435
64835	**33.5**				7.8	●	1,461
64840	**34**	170	315		7.9	●	1,470
64845	**34.5**				8	●	1,518
64850	**35**				8.2	●	1,519
64855	**35.5**				8.3	●	1,558
64860	**36**	175	320		8.4	●	1,586
64865	**36.5**				8.5	●	1,596
64870	**37**				8.6	●	1,655
64875	**37.5**				8.7	●	1,671
64880	**38**	180	325		8.9	●	1,716
64885	**38.5**				9	●	1,742
64890	**39**				9.1	●	1,764
64895	**39.5**				9.2	●	1,773

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
64900	**40**	180	325	MT4	9.3	●	1,802
64905	**40.5**	185	330		9.4	●	1,964
64910	**41**				9.6	●	1,902
64915	**41.5**				9.7	●	1,978
64920	**42**				9.8	●	2,010
64925	**42.5**				9.9	●	2,000
64930	**43**	190	335		10	●	2,060
64935	**43.5**				10.1	●	2,104
64940	**44**				10.3	●	2,122
64945	**44.5**				10.4	●	2,133
64950	**45**				10.5	●	2,176
64955	**45.5**	195	340		10.6	●	2,200
64960	**46**				10.7	●	2,292
64965	**46.5**				10.8	●	2,350
64970	**47**				11	●	2,381
64975	**47.5**				11.1	●	2,380
64980	**48**	200	345		11.2	●	2,386
64985	**48.5**				11.3	●	2,414
64990	**49**				11.4	●	2,500
64995	**49.5**				11.5	●	2,490
65000	**50**				11.7	●	2,546

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

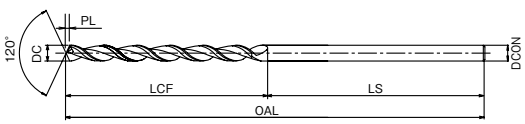
■标识说明请参考P.1。 See p.1 for explanation of icons.

高速钢超长刃型钻头 10D 型
TDXL DRILL 10D TYPE

TDXL

切削条件 Cutting Conditions | P.432

使用高速钢钻头加工深度达10D 的深孔加工。
HSS drills can achieve 10 × D



注1) 2012年6月后将逐渐以WXL 涂层替代生产。
Start manufacturing with WXL Coating of tip from June 2012.

HSS-Co | WXL | h8 | SHANK h7 (2≦DC) | SHANK h8 (DC<2) | 40°

10D用 For 10D operation

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8622816	1.6 × 10D	26	70	1.57	44	0.5	●	4
8622818	1.8 × 10D			1.77	49	0.5	●	4
8622820	2 × 10D		75	2	49	0.6	●	4
8622821	2.1 × 10D	33		2.1	42	0.6	●	4
8622822	2.2 × 10D			2.2	42	0.6	●	4
8622823	2.3 × 10D			2.3	42	0.7	●	5
8622824	2.4 × 10D			2.4	42	0.7	●	5
8622825	2.5 × 10D			2.5	42	0.7	●	5
8622826	2.6 × 10D	40	90	2.6	50	0.8	●	6
8622827	2.7 × 10D			2.7	50	0.8	●	6
8622828	2.8 × 10D			2.8	50	0.8	●	6
8622829	2.9 × 10D			2.9	50	0.8	●	7
8622830	3 × 10D			3	50	0.9	●	7
8622831	3.1 × 10D	45	100	3.1	55	0.9	●	7
8622832	3.2 × 10D			3.2	55	0.9	●	7
8622833	3.3 × 10D			3.3	55	1	●	8
8622834	3.4 × 10D	50		3.4	50	1	●	8
8622835	3.5 × 10D			3.5	50	1	●	9
8622836	3.6 × 10D			3.6	50	1	●	9
8622837	3.7 × 10D			3.7	50	1.1	●	9
8622838	3.8 × 10D			3.8	50	1.1	●	10
8622839	3.9 × 10D			3.9	50	1.1	●	10
8622840	4 × 10D			4	50	1.2	●	10
8622841	4.1 × 10D	55	115	4.1	60	1.2	●	14
8622842	4.2 × 10D			4.2	60	1.2	●	14
8622843	4.3 × 10D	60		4.3	55	1.2	●	14
8622844	4.4 × 10D			4.4	55	1.3	●	14
8622845	4.5 × 10D			4.5	55	1.3	●	15
8622846	4.6 × 10D			4.6	55	1.3	●	15
8622847	4.7 × 10D			4.7	55	1.4	●	15
8622848	4.8 × 10D	65		4.8	50	1.4	●	17
8622849	4.9 × 10D			4.9	50	1.4	●	17
8622850	5 × 10D			5	50	1.4	●	17
8622851	5.1 × 10D	70	128	5.1	58	1.5	●	21

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8622852	5.2 × 10D	70	128	5.2	58	1.5	●	22
8622853	5.3 × 10D			5.3	58	1.5	●	23
8622854	5.4 × 10D	78		5.4	50	1.6	●	22
8622855	5.5 × 10D			5.5	50	1.6	●	23
8622856	5.6 × 10D			5.6	50	1.6	●	24
8622857	5.7 × 10D			5.7	50	1.6	●	24
8622858	5.8 × 10D			5.8	50	1.7	●	25
8622859	5.9 × 10D			5.9	50	1.7	●	25
8622860	6 × 10D			6	50	1.7	●	26
8622861	6.1 × 10D	87	140	6.1	53	1.8	●	31
8622862	6.2 × 10D			6.2	53	1.8	●	31
8622863	6.3 × 10D			6.3	53	1.8	●	32
8622864	6.4 × 10D			6.4	53	1.8	●	33
8622865	6.5 × 10D			6.5	53	1.9	●	34
8622866	6.6 × 10D			6.6	53	1.9	●	34
8622867	6.7 × 10D			6.7	53	1.9	●	36
8622868	6.8 × 10D	90		6.8	50	2	●	36
8622869	6.9 × 10D			6.9	50	2	●	37
8622870	7 × 10D			7	50	2	●	38
8622871	7.1 × 10D	100	155	7.1	55	2	●	38
8622872	7.2 × 10D			7.2	55	2.1	●	39
8622873	7.3 × 10D			7.3	55	2.1	●	41
8622874	7.4 × 10D			7.4	55	2.1	●	42
8622875	7.5 × 10D			7.5	55	2.2	●	43
8622876	7.6 × 10D	105		7.6	50	2.2	●	43
8622877	7.7 × 10D			7.7	50	2.2	●	44
8622878	7.8 × 10D			7.8	50	2.3	●	45
8622879	7.9 × 10D			7.9	50	2.3	●	45
8622880	8 × 10D			8	50	2.3	●	47
8622881	8.1 × 10D	110	165	8.1	55	2.3	●	51
8622882	8.2 × 10D			8.2	55	2.4	●	51
8622883	8.3 × 10D			8.3	55	2.4	●	53
8622884	8.4 × 10D			8.4	55	2.4	●	54
8622885	8.5 × 10D			8.5	55	2.5	●	56

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直径 DC 8.6 ～ 12 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
TDXL	○	◎	◎	◎							○	◎	◎			◎				◎	

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DH1022**

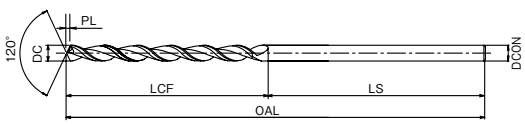
高速钢超长刃型钻头 10D 型

TDXL DRILL 10D TYPE

TDXL

切削条件 Cutting Conditions | P.432

使用高速钢钻头加工深度达10D 的深孔加工。
HSS drills can achieve 10 × D



注1) 2012年6月后将逐渐以WXL 涂层替代生产。
Start manufacturing with WXL Coating of tip from June 2012.

HSS-Co | WXL | h8 | SHANK h7 (2≦DC) | SHANK h8 (DC<2) | 40°

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FROM 直径 DC 1.6～8.5

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8622886	8.6 × 10D	115	165	8.6	50	2.5	●	55
8622887	8.7 × 10D			8.7	50	2.5	●	57
8622888	8.8 × 10D			8.8	50	2.5	●	58
8622889	8.9 × 10D			8.9	50	2.6	●	59
8622890	9 × 10D			9	50	2.6	●	60
8622891	9.1 × 10D	125	190	9.1	65	2.6	●	74
8622892	9.2 × 10D			9.2	65	2.7	●	76
8622893	9.3 × 10D			9.3	65	2.7	●	77
8622894	9.4 × 10D			9.4	65	2.7	●	77
8622895	9.5 × 10D			9.5	65	2.7	●	77
8622896	9.6 × 10D	130		9.6	60	2.8	●	80
8622897	9.7 × 10D			9.7	60	2.8	●	81
8622898	9.8 × 10D			9.8	60	2.8	●	83
8622899	9.9 × 10D			9.9	60	2.9	●	83
8622900	10 × 10D			10	60	2.9	●	85
8622901	10.1 × 10D	140	205	10.1	65	2.9	●	94
8622902	10.2 × 10D			10.2	65	2.9	●	96
8622903	10.3 × 10D			10.3	65	3	●	97

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8622904	10.4 × 10D	140	205	10.4	65	3	●	100
8622905	10.5 × 10D			10.5	65	3	●	101
8622906	10.6 × 10D	145		10.6	60	3.1	●	100
8622907	10.7 × 10D			10.7	60	3.1	●	103
8622908	10.8 × 10D			10.8	60	3.1	●	104
8622909	10.9 × 10D			10.9	60	3.1	●	106
8622910	11 × 10D			11	60	3.2	●	108
8622911	11.1 × 10D	155	215	11.1	60	3.2	●	116
8622912	11.2 × 10D			11.2	60	3.2	●	119
8622913	11.3 × 10D			11.3	60	3.3	●	120
8622914	11.4 × 10D			11.4	60	3.3	●	122
8622915	11.5 × 10D			11.5	60	3.3	●	123
8622916	11.6 × 10D			11.6	60	3.3	●	127
8622917	11.7 × 10D			11.7	60	3.4	●	127
8622918	11.8 × 10D			11.8	60	3.4	●	129
8622919	11.9 × 10D			11.9	60	3.4	●	132
8622920	12 × 10D			12	60	3.5	●	134

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
TDXL	○	◎	◎	◎							○	◎	◎			◎				◎	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

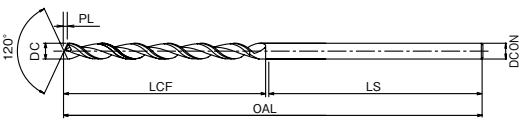
■标识说明请参考P.1。 See p.1 for explanation of icons.

高速钢超长刃型钻头 15D 型
TDXL DRILL 15D TYPE

TDXL

切削条件 Cutting Conditions | P.432

使用高速钢钻头加工深度达15D 的深孔加工。
HSS drills can achieve 15 × D



注1) 2012年6月后将逐渐以WXL 涂层替代生产。
Start manufacturing with WXL Coating of tip from June 2012.

HSS-Co | WXL | h8 | SHANK h7 (2≦DC) | SHANK h8 (DC<2) | 40°

15D用 For 15D operation

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623016	1.6 × 15D	30	70	1.57	40	0.5	●	3
8623018	1.8 × 15D	34	75	1.77	41	0.5	●	4
8623020	2 × 15D	36	80	2	44	0.6	●	4
8623021	2.1 × 15D	38		2.1	42	0.6	●	4
8623022	2.2 × 15D	40		2.2	40	0.6	●	4
8623023	2.3 × 15D	42	85	2.3	43	0.7	●	5
8623024	2.4 × 15D	44		2.4	41	0.7	●	5
8623025	2.5 × 15D	46		2.5	39	0.7	●	5
8623026	2.6 × 15D	48	100	2.6	52	0.8	●	5
8623027	2.7 × 15D	50		2.7	50	0.8	●	6
8623028	2.8 × 15D			2.8	50	0.8	●	6
8623029	2.9 × 15D	54	105	2.9	51	0.8	●	9
8623030	3 × 15D			3	51	0.9	●	9
8623031	3.1 × 15D	56	110	3.1	54	0.9	●	9
8623032	3.2 × 15D	58		3.2	52	0.9	●	10
8623033	3.3 × 15D	60		3.3	50	1	●	10
8623034	3.4 × 15D	62	115	3.4	53	1	●	10
8623035	3.5 × 15D	64		3.5	51	1	●	11
8623036	3.6 × 15D	66		3.6	49	1	●	11
8623037	3.7 × 15D	68	120	3.7	52	1.1	●	13
8623038	3.8 × 15D	70		3.8	50	1.1	●	12
8623039	3.9 × 15D			3.9	50	1.1	●	13
8623040	4 × 15D	72		4	48	1.2	●	13
8623041	4.1 × 15D	74	135	4.1	61	1.2	●	13
8623042	4.2 × 15D	76		4.2	59	1.2	●	14
8623043	4.3 × 15D	78	140	4.3	62	1.2	●	15
8623044	4.4 × 15D	80		4.4	60	1.3	●	15
8623045	4.5 × 15D	82		4.5	58	1.3	●	15

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623046	4.6 × 15D	84	145	4.6	61	1.3	●	17
8623047	4.7 × 15D	86		4.7	59	1.4	●	17
8623048	4.8 × 15D			4.8	59	1.4	●	18
8623049	4.9 × 15D	88	150	4.9	62	1.4	●	19
8623050	5 × 15D	90		5	60	1.4	●	19
8623051	5.1 × 15D	92		5.1	58	1.5	●	20
8623052	5.2 × 15D	94	155	5.2	61	1.5	●	21
8623053	5.3 × 15D	96		5.3	59	1.5	●	22
8623054	5.4 × 15D	98		5.4	57	1.6	●	23
8623055	5.5 × 15D	100		5.5	55	1.6	●	23
8623056	5.6 × 15D	102	160	5.6	58	1.6	●	24
8623057	5.7 × 15D	104	165	5.7	61	1.6	●	26
8623058	5.8 × 15D	106		5.8	59	1.7	●	27
8623060	6 × 15D	108	170	6	62	1.7	●	29
8623062	6.2 × 15D	112		6.2	58	1.8	●	33
8623063	6.3 × 15D	114	175	6.3	61	1.8	●	34
8623065	6.5 × 15D	118	200	6.5	82	1.9	●	45
8623066	6.6 × 15D	120		6.6	80	1.9	●	45
8623068	6.8 × 15D	124		6.8	76	2	●	48
8623069	6.9 × 15D	126		6.9	74	2	●	49
8623070	7 × 15D			7	74	2	●	50
8623071	7.1 × 15D	128		7.1	72	2	●	50
8623075	7.5 × 15D	136	205	7.5	69	2.2	●	56
8623080	8 × 15D	144	215	8	71	2.3	●	65
8623081	8.1 × 15D	146		8.1	69	2.3	●	66
8623082	8.2 × 15D	148	220	8.2	72	2.4	●	69
8623085	8.5 × 15D	154	225	8.5	71	2.5	●	74
8623086	8.6 × 15D	156		8.6	69	2.5	●	76

下一页
直径 DC 8.8～12 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
TDXL	○	◎	◎	◎							○	◎	◎			◎				◎	

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | DH1022

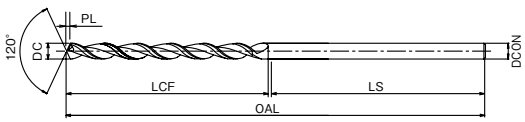
高速钢超长刃型钻头 15D 型

TDXL DRILL 15D TYPE

TDXL

切削条件 Cutting Conditions | P.432

使用高速钢钻头加工深度达15D 的深孔加工。
HSS drills can achieve 15 × D



HSS-Co | WXL | h8 | SHANK h7 (2≦DC) | SHANK h8 (DC<2) | 40°

注1) 2012年6月后将逐渐以WXL 涂层替代生产。
Start manufacturing with WXL Coating of tip from June 2012.

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FROM 直径 DC 1.6～8.6

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623088	**8.8 ×15D**	160	230	8.8	70	2.5	●	81
8623090	**9 ×15D**	162		9	68	2.6	●	83
8623093	**9.3 ×15D**	168	240	9.3	72	2.7	●	92
8623095	**9.5 ×15D**	172		9.5	68	2.7	●	93
8623097	**9.7 ×15D**	176	245	9.7	69	2.8	●	99
8623098	**9.8 ×15D**	178		9.8	67	2.8	●	101
8623100	**10 ×15D**	180	250	10	70	2.9	●	107

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623105	**10.5 × 15D**	190	270	10.5	80	3	●	128
8623110	**11 × 15D**	200	280	11	80	3.2	●	147
8623115	**11.5 × 15D**	208	290	11.5	82	3.3	●	165
8623118	**11.8 × 15D**	214	295	11.8	81	3.4	●	175
8623120	**12 × 15D**	216	300	12	84	3.5	●	185

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
TDXL	○	◎	◎	◎							○	◎	◎			◎				◎	

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

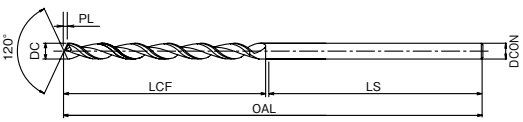
■标识说明请参考P.1。 See p.1 for explanation of icons.

高速钢超长刃型钻头 20D 型
TDXL DRILL 20D TYPE

TDXL

切削条件 Cutting Conditions | P.432

使用高速钢钻头加工深度达20D 的深孔加工。
HSS drills can achieve 20 × D



注1) 2012年6月后将逐渐以WXL 涂层替代生产。
Start manufacturing with WXL Coating of tip from June 2012.

HSS-Co | WXL | h8 | SHANK h7 (2≦DC) | SHANK h8 (DC<2) | 40°

20D用 For 20D operation

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623216	1.6 × 20D	38	85	1.57	47	0.5	●	4
8623218	1.8 × 20D	42		1.77	43	0.5	●	4
8623220	2 × 20D	46		2	39	0.6	●	4
8623221	2.1 × 20D	50	90	2.1	40	0.6	●	5
8623222	2.2 × 20D	52		2.2	38	0.6	●	5
8623223	2.3 × 20D	54	95	2.3	41	0.7	●	5
8623224	2.4 × 20D	56		2.4	39	0.7	●	5
8623225	2.5 × 20D	58	100	2.5	42	0.7	●	5
8623226	2.6 × 20D	60	110	2.6	50	0.8	●	6
8623227	2.7 × 20D	64	115	2.7	51	0.8	●	8
8623228	2.8 × 20D	66		2.8	49	0.8	●	8
8623229	2.9 × 20D	68	120	2.9	52	0.8	●	9
8623230	3 × 20D	70		3	50	0.9	●	9
8623231	3.1 × 20D	72	125	3.1	53	0.9	●	10
8623232	3.2 × 20D	74		3.2	51	0.9	●	10
8623233	3.3 × 20D	76		3.3	49	1	●	10
8623234	3.4 × 20D	80	130	3.4	50	1	●	12
8623235	3.5 × 20D	82		3.5	48	1	●	13
8623237	3.7 × 20D	86	135	3.7	49	1.1	●	11
8623238	3.8 × 20D	88	140	3.8	52	1.1	●	12
8623240	4 × 20D	92		4	48	1.2	●	12

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623241	4.1 × 20D	96	155	4.1	59	1.2	●	14
8623242	4.2 × 20D	98		4.2	57	1.2	●	14
8623243	4.3 × 20D	100	160	4.3	60	1.2	●	15
8623245	4.5 × 20D	104	165	4.5	61	1.3	●	17
8623246	4.6 × 20D	106		4.6	59	1.3	●	18
8623248	4.8 × 20D	112	170	4.8	58	1.4	●	19
8623250	5 × 20D	116	175	5	59	1.4	●	24
8623251	5.1 × 20D	118	180	5.1	62	1.5	●	25
8623252	5.2 × 20D	120		5.2	60	1.5	●	25
8623255	5.5 × 20D	128	185	5.5	57	1.6	●	28
8623257	5.7 × 20D	132	190	5.7	58	1.6	●	30
8623258	5.8 × 20D	134	200	5.8	66	1.7	●	32
8623260	6 × 20D	138		6	62	1.7	●	34
8623263	6.3 × 20D	146		6.3	54	1.8	●	39
8623265	6.5 × 20D	150	225	6.5	75	1.9	●	47
8623268	6.8 × 20D	158		6.8	67	2	●	50
8623269	6.9 × 20D	160	230	6.9	70	2	●	52
8623270	7 × 20D	162		7	68	2	●	53
8623275	7.5 × 20D	174	245	7.5	71	2.2	●	63
8623280	8 × 20D	184	255	8	71	2.3	●	74
8623281	8.1 × 20D	188		8.1	67	2.3	●	75

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直径 DC 8.2～12 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
TDXL	○	◎	◎	◎							○	◎	◎			◎				◎	

库存记号 Inventory symbols
● = 标准库存品
Standard stock item
○ = 准标准库存品(请确认库存。)
Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **DH1022**

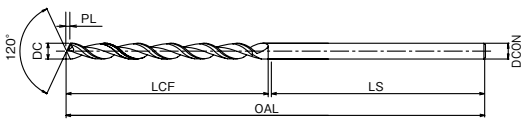
高速钢超长刃型钻头 20D 型

TDXL DRILL 20D TYPE

使用高速钢钻头加工深度达20D 的深孔加工。
HSS drills can achieve 20 × D

TDXL

切削条件 Cutting Conditions | P.432



HSS-Co | WXL | h8 | SHANK h7 (2≦DC) | SHANK h8 (DC<2) | 40°

注1) 2012年6月后将逐渐以WXL 涂层替代生产。
Start manufacturing with WXL Coating of tip from June 2012.

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FROM 直径 DC 1.6～8.1

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623282	**8.2 × 20D**	190	260	8.2	70	2.4	●	79
8623285	**8.5 × 20D**	196	265	8.5	69	2.5	●	84
8623290	**9 × 20D**	208	275	9	67	2.6	●	95

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8623300	**10 × 20D**	230	300	10	70	2.9	●	122
8623310	**11 × 20D**	254	350	11	96	3.2	●	178
8623320	**12 × 20D**	276		12	74	3.5	●	200

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
TDXL	○	◎	◎	◎							○	◎	◎			◎				◎	

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

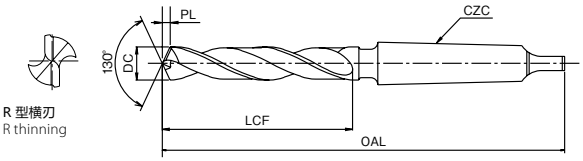
车床用钻头
FOR LATHE MACHINE

V-MT-GDN

切削条件 Cutting Conditions | P.434

考虑到低阻力化，易操作的 V 涂层与锥柄配上中等刃长最适合用于车床。

This drill has V coated and a tapered shank. Suitable for drilling on lathe machines.



HSSE | V | h8 | 40°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
66060	**6**	43	123	MT1	1.4	●	64
66065	**6.5**	47	127		1.5	●	65
66068	**6.8**	52	132		1.6	●	68
66070	**7**				1.6	●	68
66075	**7.5**				1.8	●	68
66080	**8**	56	136		1.9	●	73
66085	**8.5**		139		2	●	75
66088	**8.8**	61	144		2.1	●	76
66090	**9**				2.1	●	76
66095	**9.5**				2.2	●	82
66100	**10**	65	148		2.3	●	86
66103	**10.3**				2.4	●	85
66105	**10.5**				2.5	●	90
66110	**11**	71	154		2.6	●	95
66115	**11.5**				2.7	●	98
66120	**12**				2.8	●	99
66125	**12.5**	76	159		2.9	●	106
66130	**13**				3	●	111
66135	**13.5**	80	163		3.2	●	122

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
66140	**14**	80	163	MT1	3.3	●	128
66145	**14.5**	83	183	MT2	3.4	●	219
66150	**15**				3.5	●	221
66155	**15.5**	85	185		3.6	●	231
66160	**16**				3.7	●	233
66165	**16.5**	88	188		3.9	●	240
66170	**17**				4	●	248
66175	**17.5**	90	190		4.1	●	253
66180	**18**				4.2	●	263
66185	**18.5**	93	193		4.3	●	270
66190	**19**				4.4	●	275
66195	**19.5**	96	196		4.6	●	287
66200	**20**				4.7	●	298
66205	**20.5**	98	198		4.8	●	319
66210	**21**				4.9	●	330
66215	**21.5**	101	201		5	●	338
66220	**22**				5.1	●	347
66225	**22.5**				5.3	●	369
66230	**23**				5.4	●	380

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直径 DC 23.5～32 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
V-MT-GDN	◎	◎	◎	◎	◎						○	○	○	○	○	○	○			○	
※	◎	◎	◎	◎	○						○	○	○	○	○	○	○			○	

※孔深：4D～5D　　Drilling depth：4D～5D

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

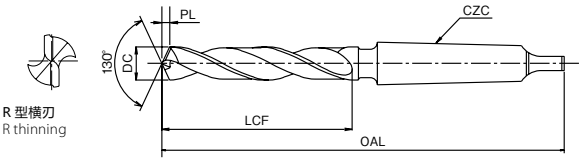
G-LIST No. | **DH1012**

车床用钻头
FOR LATHE MACHINE

V-MT-GDN

切削条件 Cutting Conditions | P.434

考虑到低阻力化，易操作的 V 涂层与锥柄配上中等刃长最适合用于车床。
This drill has V coated and a tapered shank. Suitable for drilling on lathe machines.



HSSE | V | h8 | 40°

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FROM 直径 DC 6～23

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
66235	**23.5**	104	224	MT3	5.5	●	538
66240	**24**	108	228		5.6	●	560
66245	**24.5**				5.7	●	567
66250	**25**				5.8	●	570
66255	**25.5**	112	232		6	●	577
66260	**26**				6.1	●	600
66265	**26.5**				6.2	●	630
66270	**27**	116	236		6.3	●	640
66275	**27.5**				6.4	●	646
66280	**28**				6.5	●	684

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
66285	**28.5**	120	240	MT3	6.6	●	703
66290	**29**				6.8	●	701
66295	**29.5**				6.9	●	702
66300	**30**				7	●	734
66305	**30.5**	124	244		7.1	●	742
66310	**31**				7.2	●	746
66315	**31.5**				7.3	●	763
66320	**32**	128	248		7.5	●	787

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
V-MT-GDN	◎	◎	◎	◎	◎						○	○	○	○	○	○	○			○	
※	◎	◎	◎	◎	○						○	○	○	○	○	○	○			○	

※孔深：4D～5D　　Drilling depth : 4D～5D

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

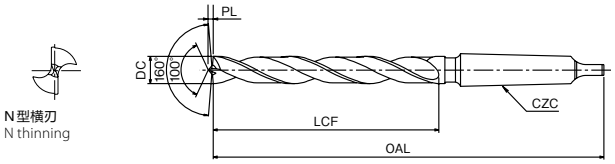
■标识说明请参考 P.1。 See p.1 for explanation of icons.

钢筋用钻头
FOR STEEL FRAME (SELECTIONS AND SHEET PLATES)

EX-MT-TDR

切削条件 Cutting Conditions | P.435

适用于型钢及薄板的高效率加工。
Suitable for high efficiency drilling of thin plates, such as sections and splice plates.



N型横刃
N thinning

HSSE | TiN | 30°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
65675	**17.5**	140	260	MT3	4.1	●	469
65680	**18**				4.2	●	457
65690	**19**	145	265		4.4	●	502
65700	**20**	150	270		4.7	●	523
65715	**21.5**	160	280		5	●	573

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄 CZC	先端 PL	库存 Stock	重量 (g)
65720	**22**	160	280	MT3	5.1	●	582
65735	**23.5**	165	285		5.5	●	624
65740	**24**				5.6	●	655
65750	**25**				5.8	●	679
65760	**26**				6.1	●	720

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
EX-MT-TDR	◎																				

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1000

清除折损丝锥用
EX HARD DRILLS FOR REMOVING TAPS

EX-H-DRL

用于折损丝锥的清除、淬火钢 (58~69HRC) 等加工、合金的补孔加工。
This drill is used for: removing broken taps, drilling after heat treatment, drilling stellite or drilling quenched and tempered steels (58~68HRC).

CARBIDE | SHANK h7

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	适应破损丝锥 直槽丝锥		适应破损丝锥 刃倾角丝锥		适应破损丝锥 螺旋槽丝锥		库存 Stock	重量 (g)
87700	2-6 打包 (每组5支)													●	57
87702	**2**	10	30	2	19.3	0.6		M 3	No.4,No.5,No.6	M 3	No.4,No.5	M 3	No.4,No.5,No.6	●	3
87703	**3**	15	40	3	24.1	0.9		M 4,M 5	No.8,No.10	M 4	No.8,No.10	M 4,M 5	No.8,No.10	●	5
87704	**4**	20	45	4	24	1.2		M 6	¼, 5⁄16	M 5,M 6	¼	M 6	¼, 5⁄16	●	8
87705	**5**	25	50	5	23.9	1.5		M 8,M10	⅜	—	5⁄16	M 8,M10	⅜	●	12
87706	**6**	30	60	6	28.8	1.8		M 12	7⁄16, ½	M 8	⅜	M 12	7⁄16, ½	●	21
87707	**7**	35	80	8	43.6	2.1	118°	M 14	9⁄16	M10	7⁄16	M 14	9⁄16	●	46
87708	**8**	40			38.7	2.4		M 16	⅝	M12	½	M 16	⅝	●	48
87709	**9**	45	100	10	53.6	2.7		M 18	¾	M14	9⁄16	M 18	¾	●	89
87710	**10**	50			48.3	3		M 20	—	M16	⅝	M 20	—	●	93
87781	**11**	55	110	12	53.5	3.3		M 22	⅞	M18	—	M 22	⅞	●	137
87782	**12**	60			48.4	3.6		M 24	1	M20	¾	M 24	1	●	141

1. 钻头直径的选定请按下列公式(D= 丝锥大径, d= 钻头直径)
直槽丝锥，螺旋槽丝锥0.46D<d<0.75D，刃倾角丝锥0.6D<d<0.75D
2. 亦可按φ2、3、4、5、6 各一支为5件套来订购(商品号：87700)

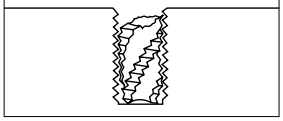
1. For drill diameter selection, use the method outlined below.
(D=tap dia. d=drill dia.)
Straight Fluted taps, Spiral Fluted taps : 0.46D < d < 0.75D
Spiral Pointed taps : 0.6D < d < 0.75D
2. Drills are available as a 5pcs. set (EDP No. 87700) for φ2 through φ6.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

清除破损丝锥的步骤　Work Procedure for Removing Damaged Tap in Hole

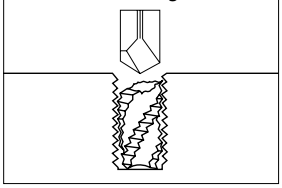
1



将工件固定紧，使钻头置于破损丝锥的中心位置。如果丝锥是于孔外折断的，那么将断处削平，则易于找到丝锥的中心点。

Position the drill at the center of the damaged tap, securing both the workpiece and the drill firmly. When the head of the damaged tap is protruding, grind the damaged surface flat to make the center of the damaged tap easier to drill.

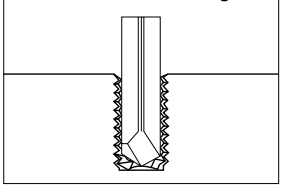
2 找中心 Centering



进行找中心加工时，无需供油，请使用微速谨慎进行。如果使用的钻头尺寸比步骤**3**中所使用的更大，则加工可以更加容易。

Make an initial, centered approach by drilling lightly, then quickly withdrawing the drill. For this step, do not use lubrication.

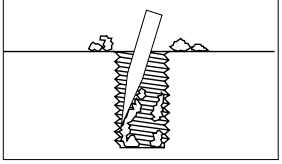
3 孔加工 Hole Processing



参照上表选择合适的钻头。注意速度要保持一定，要经常停下钻头，将碎屑取出，要用优质的切屑液。

Select an appropriate drill by consulting the table. Drill the hole at a fixed feed speed, stopping the operation occasion-ally to remove chip waste. In addition, use plenty of high quality cutting fluid.

4 除去丝锥残留部分和切屑
Tap remains, chips removal



在破损丝锥上钻孔完毕后，可用尖锐之物将丝锥的碎屑取出。

Once the hole has been cleared, the peripheral remnants of the tap can be removed with ease. Once the hole is cleaned, tapping can be resumed.

※亦可用于淬火钢上的补孔加工。

＊ For drilling after heat treatment, follow the instructions above.

切削条件以及注意点　Cutting Conditions and Procedures to Note.

1. 请将切削速度定为 20~25m/min。
2. 手动进给量为 0.01~0.05m/rev。
3. 请使用对应直径的有刚性的刀柄。
4. 请选择优质的切削液，强制注油。
5. 不适用于软钢，铝，铜等较柔软的加工材料。
6. 请定期进行修磨，保持刀尖锋利。
7. 在淬火钢等的通孔加工过程中，为了防止在钻穿时扭矩突然增大，若能在底下垫些东西，能防止切损。

1. Use a drilling speed of 20-25 m/min.
2. Hand feed of 0.01mm - 0.05mm/rev. is the norm.
3. Use a rigid holder.
4. Select a high quality cutting oil and apply sufficient amounts.
5. This tool should not be used to drill soft steel, aluminium alloy equivalents, or other soft materials.
6. Resharpening should be done periodically.
7. For through hole processing of heat treated steel etc., using a cut off - positioned under the work material - to prevent breakage caused by sudden torque.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

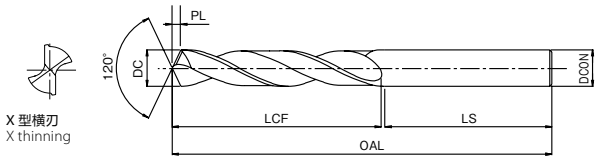
G-LIST No. | **DH1008**

一般用途钻头
REGULAR

V-SDR

切削条件 Cutting Conditions | P.436

适用范围广泛，从低速至中速加工。
This multi-purpose drill is best used at low to medium speeds.



HSSE | V | 28~38°

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594020	**2**	24	49	2	25	0.6	●	2
8594021	**2.1**			2.1	25	0.6	●	3
8594022	**2.2**	27	53	2.2	26	0.6	●	3
8594023	**2.3**			2.3	26	0.7	●	3
8594024	**2.4**	30	57	2.4	27	0.7	●	3
8594025	**2.5**			2.5	27	0.7	●	4
8594026	**2.6**			2.6	27	0.8	●	4
8594027	**2.7**	33	61	2.7	28	0.8	●	4
8594028	**2.8**			2.8	28	0.8	●	4
8594029	**2.9**			2.9	28	0.8	●	4
8594030	**3**			3	28	0.9	●	4
8594031	**3.1**	36	65	3.1	29	0.9	●	5
8594032	**3.2**			3.2	29	0.9	●	5
8594033	**3.3**			3.3	29	1	●	5
8594034	**3.4**	39	70	3.4	31	1	●	6
8594035	**3.5**			3.5	31	1	●	6
8594036	**3.6**			3.6	31	1	●	6
8594037	**3.7**			3.7	31	1.1	●	7
8594038	**3.8**	43	75	3.8	32	1.1	●	8
8594039	**3.9**			3.9	32	1.1	●	8
8594040	**4**			4	32	1.2	●	8
8594041	**4.1**			4.1	32	1.2	●	8
8594042	**4.2**			4.2	32	1.2	●	8
8594043	**4.3**	47	80	4.3	33	1.2	●	9
8594044	**4.4**			4.4	33	1.3	●	9
8594045	**4.5**			4.5	33	1.3	●	10
8594046	**4.6**			4.6	33	1.3	●	10
8594047	**4.7**			4.7	33	1.4	●	10
8594048	**4.8**	52	86	4.8	34	1.4	●	11
8594049	**4.9**			4.9	34	1.4	●	12
8594050	**5**			5	34	1.4	●	12
8594051	**5.1**			5.1	34	1.5	●	12
8594052	**5.2**			5.2	34	1.5	●	13
8594053	**5.3**			5.3	34	1.5	●	13
8594054	**5.4**	57	93	5.4	36	1.6	●	14
8594055	**5.5**			5.5	36	1.6	●	15
8594056	**5.6**			5.6	36	1.6	●	15
8594057	**5.7**			5.7	36	1.6	●	16
8594058	**5.8**			5.8	36	1.7	●	16
8594059	**5.9**			5.9	36	1.7	●	17
8594060	**6**			6	36	1.7	●	17
8594061	**6.1**	63	101	6.1	38	1.8	●	20

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594062	**6.2**	63	101	6.2	38	1.8	●	20
8594063	**6.3**			6.3	38	1.8	●	21
8594064	**6.4**			6.4	38	1.8	●	21
8594065	**6.5**			6.5	38	1.9	●	22
8594066	**6.6**			6.6	38	1.9	●	22
8594067	**6.7**			6.7	38	1.9	●	23
8594068	**6.8**	69	109	6.8	40	2	●	26
8594069	**6.9**			6.9	40	2	●	27
8594070	**7**			7	40	2	●	27
8594071	**7.1**			7.1	40	2	●	27
8594072	**7.2**			7.2	40	2.1	●	28
8594073	**7.3**			7.3	40	2.1	●	28
8594074	**7.4**			7.4	40	2.1	●	30
8594075	**7.5**			7.5	40	2.2	●	30
8594076	**7.6**	75	117	7.6	42	2.2	●	33
8594077	**7.7**			7.7	42	2.2	●	34
8594078	**7.8**			7.8	42	2.3	●	34
8594079	**7.9**			7.9	42	2.3	●	35
8594080	**8**			8	42	2.3	●	36
8594081	**8.1**			8.1	42	2.3	●	38
8594082	**8.2**			8.2	42	2.4	●	39
8594083	**8.3**			8.3	42	2.4	●	39
8594084	**8.4**			8.4	42	2.4	●	41
8594085	**8.5**			8.5	42	2.5	●	41
8594086	**8.6**	81	125	8.6	44	2.5	●	47
8594087	**8.7**			8.7	44	2.5	●	48
8594088	**8.8**			8.8	44	2.5	●	49
8594089	**8.9**			8.9	44	2.6	●	50
8594090	**9**			9	44	2.6	●	51
8594091	**9.1**			9.1	44	2.6	●	53
8594092	**9.2**			9.2	44	2.7	●	54
8594093	**9.3**			9.3	44	2.7	●	54
8594094	**9.4**			9.4	44	2.7	●	56
8594095	**9.5**			9.5	44	2.7	●	56
8594096	**9.6**	87	133	9.6	46	2.8	●	60
8594097	**9.7**			9.7	46	2.8	●	60
8594098	**9.8**			9.8	46	2.8	●	62
8594099	**9.9**			9.9	46	2.9	●	63
8594100	**10**			10	46	2.9	●	64
8594101	**10.1**			10.1	46	2.9	●	64
8594102	**10.2**			10.2	46	2.9	●	65
8594103	**10.3**			10.3	46	3	●	66

下一页
直径 DC 10.4～13 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC			CFRP	AZ91D	
V-SDR	◎	◎	○	◎							○	○	○		○	○				○	

上一页
FROM 直径 DC 2～10.3

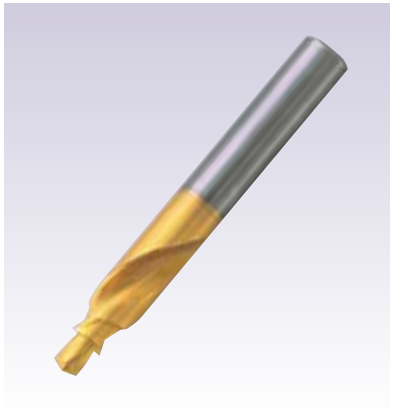
单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594104	**10.4**	87	133	10.4	46	3	●	68
8594105	**10.5**			10.5	46	3	●	69
8594106	**10.6**			10.6	46	3.1	●	71
8594107	**10.7**	94	142	10.7	48	3.1	●	73
8594108	**10.8**			10.8	48	3.1	●	73
8594109	**10.9**			10.9	48	3.1	●	75
8594110	**11**			11	48	3.2	●	76
8594111	**11.1**			11.1	48	3.2	●	78
8594112	**11.2**			11.2	48	3.2	●	79
8594113	**11.3**			11.3	48	3.3	●	81
8594114	**11.4**			11.4	48	3.3	●	83
8594115	**11.5**			11.5	48	3.3	●	83
8594116	**11.6**			11.6	48	3.3	●	87
8594117	**11.7**			11.7	48	3.4	●	87

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock	重量 (g)
8594118	**11.8**	94	142	11.8	48	3.4	●	88
8594119	**11.9**	101	151	11.9	50	3.4	●	97
8594120	**12**			12	50	3.5	●	97
8594121	**12.1**			12.1	50	3.5	●	99
8594122	**12.2**			12.2	50	3.5	●	99
8594123	**12.3**			12.3	50	3.6	●	102
8594124	**12.4**			12.4	50	3.6	●	104
8594125	**12.5**			12.5	50	3.6	●	104
8594126	**12.6**			12.6	50	3.6	●	105
8594127	**12.7**			12.7	50	3.7	●	108
8594128	**12.8**			12.8	50	3.7	●	110
8594129	**12.9**			12.9	50	3.7	●	110
8594130	**13**			13	50	3.8	●	112

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

特殊钻头制造事例
DRILLS SPECIALLY MADE UPON REQUEST

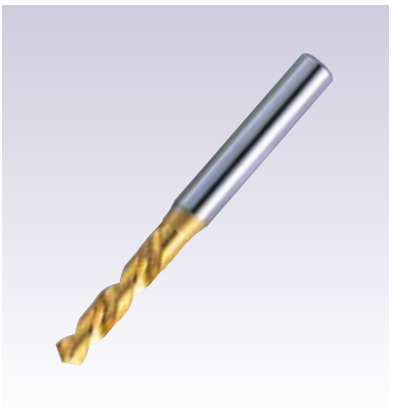


阶梯钻头
STEP DRILL

双刃背钻头
SUBLAND DRILL

双刃带钻头
DOUBLE MARGIN DRILL

阶梯抛光钻头
STEP BURNISHING DRILL

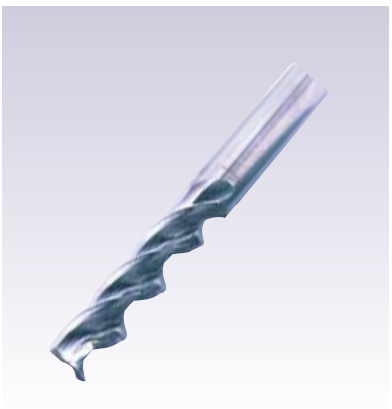


左螺旋钻头
LEFT HAND HELIX DRILL

R 角钻头
CORNER ROUNDED DRILL

整体硬质合金钻头
SOLID CARBIDE-END DRILL

空心钻头
CORE DRILL



3 刃钻头
3-FLUTED DRILL

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

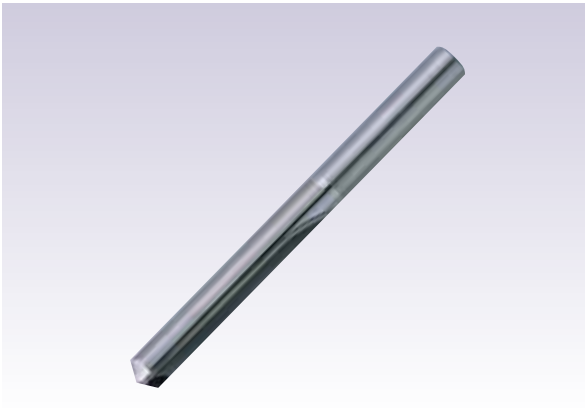
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

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

PCD 特殊钻头制造事例
PCD TOOLS SPECIALLY MADE UPON REQUEST

PCD 带内冷麻花钻
PCD TWIST DRILL WITH INTERNAL COOLANT SUPPLY



PCD 抛光钻头
PCD BURNISHING DRILL

PCD 阶梯钻
PCD STEP DRILL

PCD 铰刀
PCD REAMER

PCD 阶梯铰刀
PCD STEP REAMER

PCD 沉孔用铣刀
PCD COUNTERBORING END MILL

库存记号 Inventory symbols
● = 标准库存品
Standard stock item
○ = 准标准库存品(请确认库存。)
Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | CW1027

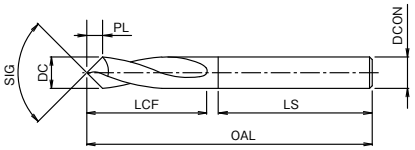
硬质合金中心钻
CARBIDE STARTER DRILL

The A Brand

AD-LDS

切削条件 Cutting Conditions | P.437

先端角的公差为60° ±3°、90° ±1°、
120° ±2°、140° $^{+4°}_{0°}$。
Tolerance of the point angle is 60°± 3°, 90°± 1°,
120°± 2°, 140° $^{+4°}_{0°}$



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration,
but it does not cause any performance problems.

CARBIDE | EgiAs | WXL | SHANK h6 | 12° | 约25°

2≦DC　DC<2　3≦DC　DC<3

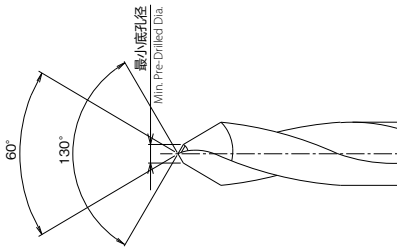
单位:mm　Unit:mm

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8688951	3 × 60°	9	48	3	39	1.8	1.5	●	6
8688952	4 × 60°	12	54	4	42	2.7	1.7	●	10
8688953	6 × 60°	15	72	6	57	4.2	2	●	28
8688954	8 × 60°	20	81	8	61	5.9	2.1	●	54
8688955	10 × 60°	24	93	10	69	7.4	2.5	●	95
8688956	12 × 60°	28	108	12	80	9.1	2.5	●	156
8688930	0.5 × 90°	1	38	3	32.2	0.3	0.25	●	5
8688931	1 × 90°	1.8			32	0.5	0.4	●	5
8688932	2 × 90°	2.5			33	1	1	●	5
8688933	3 × 90°	9	48		39	1.5	1.2	●	6
8688934	4 × 90°	12	54	4	42	2	1.5	●	10
8688935	6 × 90°	15	72	6	57	3	1.9	●	28
8688936	8 × 90°	20	81	8	61	4	2.1	●	54
8688937	10 × 90°	24	93	10	69	5	2.5	●	96
8688938	12 × 90°	28	108	12	80	6		●	157

注1) 表示进行倒角情况下的底孔最小值。

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8688957	3 × 120°	9	48	3	39	0.9	–	●	6
8688958	4 × 120°	12	54	4	42	1.2		●	10
8688959	6 × 120°	15	72	6	57	1.7		●	28
8688960	8 × 120°	20	81	8	61	2.3		●	54
8688961	10 × 120°	24	93	10	69	2.9		●	95
8688962	12 × 120°	28	108	12	80	3.5		●	157
8688963	0.5 × 140°	1	38	3	32.2	0.1		●	7
8688964	1 × 140°	1.8			32	0.2		●	7
8688965	2 × 140°	2.5			33.1	0.4		●	7
8688966	3 × 140°	9	48		39	0.5		●	6
8688967	4 × 140°	12	54	4	42	0.7		●	10
8688968	6 × 140°	15	72	6	57	1.1		●	28
8688969	8 × 140°	20	81	8	61	1.5		●	54
8688970	10 × 140°	24	93	10	69	1.8		●	95
8688971	12 × 140°	28	108	12	80	2.2		●	157

These minimum pre-drilled hole sizes are required before chamfering operations.



先端角60°，直径φ3~φ12 的产品用于中心定位加工时易产生钻尖崩损，为解决此问题，钻尖中心小于最小底孔径的部分为130°
Items with a point angle of 60° in outer diameter sizes of φ3 to φ12 have a 130° point angle within the minimum drill diameter to prevent the chisel edge from crushing during centering.

加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	60~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
AD-LDS	中心定位用 Centering	◎	◎	◎	◎	◎	○					◎	◎	◎	○		○	○	○
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	◎	◎			◎	○	○

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | CW1028

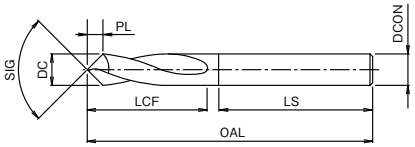
硬质合金中心钻 长柄型
CARBIDE LONG SHANK STARTER DRILL

The A Brand

AD-LS-LDS

切削条件 Cutting Conditions | P.443

先端角的公差为90° ±1°。
Tolerance of the point angle is 90°±1°



涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | SHANK h6 | 12°

单位:mm Unit:mm

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8688942	**3 × 90°**	9	75	3	66	1.5	1.2	●	9
8688943	**4 × 90°**	12	100	4	88	2	1.5	●	18
8688944	**6 × 90°**	15	150	6	135	3	1.9	●	62

注1) 表示进行倒角情况下的底孔最小值。

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8688945	**8 × 90°**	20	150	8	130	4	2.1	●	105
8688946	**10 × 90°**	24	200	10	176	5	2.5	●	210
8688947	**12 × 90°**	28		12	172	6		●	365

These minimum pre-drilled hole sizes are required before chamfering operations.

加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
AD-LS-LDS	中心定位用 Centering	◎	◎	◎	◎	◎	○					◎	◎	◎	○		○	○	○
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	◎			○	○	◎	◎			◎	○	○

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

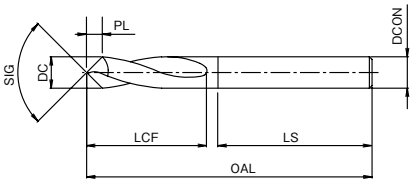
G-LIST No. | CW1000

硬质合金FX 涂层
FX COATED CARBIDE

FX-LDS

切削条件 Cutting Conditions | P.445

即可用于倒角也可用于高速中心定位加工，实现长寿命加工。
This drill increases processing speed for both centering and countersinking.



CARBIDE | FX | SHANK h7 | 12° | 约25°

3≦DC　DC<3

先端角的公差为60° ±3°、90° ±1°、130° ±2°。
Tolerance of the point angle is 60°±3°, 90°±1°, 130°±2°

单位:mm　Unit:mm

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8561500	0.5 × 90°	1	38	3	32.2	0.25	0.25	▲	9
8561516	16 × 90°	41	118	16	75	8	5	●	291

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8561520	20 × 90°	46	132	20	84	10	5	●	502
8561525	25 × 90°	53	151	25	96	12.5		●	894

注1) 表示进行倒角情况下的底孔最小值。
These minimum pre-drilled hole sizes are required before chamfering operations.

▲=此产品已停止生产，由 AD-LDS (P.325) 替代。
▲= The products have been stopped producing and replaced by AD-LDS (p.325).

先端角 60°，直径φ 3~ φ 12 的产品用于中心定位加工时易产生钻尖崩损，为解决此问题，钻尖中心小于最小底孔径的部分为 130°。
Items with a point angle of 60° in outer diameter sizes of φ3 to φ12 have a 130° point angle within the minimum drill diameter to prevent the chisel edge from crushing during centering.

加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	60~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
FX-LDS	中心定位用 Centering	◎	◎	◎	◎	◎	○					◎	◎	◎	○		○	○	○
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	◎	◎			◎	○	○

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

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

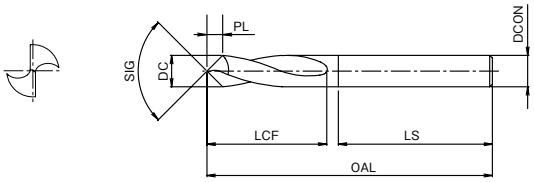
标准型
HSS GENERAL TYPE

NC-LDS

切削条件 Cutting Conditions | P.440

有90（° 45° 倒角）、120° 、130° （、EX-黄金钻头斜面曲面加工时的中心定位）的先端角。

The drill with a 90°point angle, is for counter sinking, and a 120°and 130°point angle for positioning process on curved and inclined surfaces.



HSS | SHANK h7 | 20°

先端角的公差为90° ±1°、120° ±2°、130° ±2°。

Tolerance of the point angle is 90°±1°, 120°±2°, 130°±2°

单位:mm Unit:mm

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
62903	3 × 90°	11	48	3	37	1.5	1.1	●	4
62904	4 × 90°	15	54	4	39	2	1.3	●	7
62906	6 × 90°	20	72	6	52	3	1.5	●	16
62908	8 × 90°	26	81	8	55	4	1.6	●	30
62910	10 × 90°	30	93	10	63	5	2.1	●	57
62912	12 × 90°	36	108	12	72	6		●	90
62916	16 × 90°	41	118	16	75	8		●	179
62918	20 × 90°	53	132	20	77	10	3	●	299
62920	25 × 90°	60	151	25	89	12.5		●	512
62923	3 × 120°	11	48	3	37	0.9		●	4
62924	4 × 120°	15	54	4	39	1.2		●	7
62926	6 × 120°	20	72	6	52	1.7	–	●	17
62928	8 × 120°	26	81	8	55	2.3		●	30
62930	10 × 120°	30	93	10	63	2.9		●	58

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
62932	12 × 120°	36	108	12	72	3.5		●	91
62936	16 × 120°	41	118	16	75	4.6		●	182
62938	20 × 120°	53	132	20	77	5.8		●	302
62940	25 × 120°	60	151	25	89	7.2		●	526
62943	3 × 130°	11	48	3	37	0.7		●	4
62944	4 × 130°	15	54	4	39	0.9		●	8
62946	6 × 130°	20	72	6	52	1.4	–	●	17
62948	8 × 130°	26	81	8	55	1.9		●	30
62950	10 × 130°	30	93	10	63	2.3		●	58
62952	12 × 130°	36	108	12	72	2.8		●	92
62956	16 × 130°	41	118	16	75	3.7		●	180
62958	20 × 130°	53	132	20	77	4.7		●	296
62960	25 × 130°	60	151	25	89	5.8		●	516

注 1）表示进行倒角情况下的底孔最小值。

These minimum pre-drilled hole sizes are required before chamfering operations.

商品记号 Abbreviation / 加工材料 Work Material		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
NC-LDS	中心定位用 Centering	◎	◎	◎	○							○	○	○	○	○	○		
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎				○	○	○	◎	○	○	○		

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

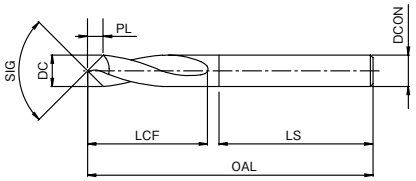
G-LIST No. | CH1002

TIN涂层
TIN COATED HSS

TIN-NC-LDS

切削条件 Cutting Conditions | P.448

TIN 涂层与NC-LDS 相比更高速，使用寿命更长。
This is the same drill as the NC-LDS, but the TiN coating increases tool life and allows for higher speed.



HSS | TiN | SHANK h7 | 20°

先端角的公差为60°±2°、90°±1°、120°±2°。
Tolerance of the point angle is 60°±2°,90°±1°,120°±2°

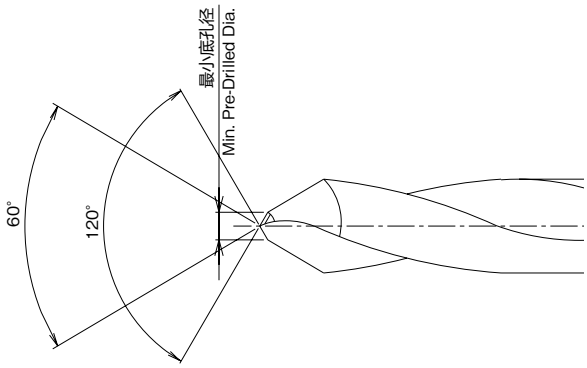
单位:mm Unit:mm

商品号 EDP No.	直径×先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63703	3 × 60°	11	48	3	37	1.9	1.5	●	4
63704	4 × 60°	15	54	4	39	2.8	1.7	●	6
63706	6 × 60°	20	72	6	52	4.3	1.9	●	16
63708	8 × 60°	26	81	8	55	6.1		●	29
63710	10 × 60°	30	93	10	63	7.7	2.1	●	57
63712	12 × 60°	36	108	12	72	9.4		●	88
63603	3 × 90°	11	48	3	37	1.5	1.1	●	6
63604	4 × 90°	15	54	4	39	2	1.3	●	6
63606	6 × 90°	20	72	6	52	3	1.5	●	16
63608	8 × 90°	26	81	8	55	4	1.6	●	30
63610	10 × 90°	30	93	10	63	5	2.1	●	57
63612	12 × 90°	36	108	12	72	6		●	90

商品号 EDP No.	直径×先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63616	16 × 90°	41	118	16	75	8	3	●	178
63618	20 × 90°	53	132	20	77	10		●	298
63620	25 × 90°	60	151	25	89	12.5		●	510
63653	3 ×120°	11	48	3	37	0.9	–	●	4
63654	4 ×120°	15	54	4	39	1.2		●	6
63656	6 ×120°	20	72	6	52	1.7		●	18
63658	8 ×120°	26	81	8	55	2.3		●	30
63660	10 ×120°	30	93	10	63	2.9		●	58
63662	12 ×120°	36	108	12	72	3.5		●	91

注 1）表示进行倒角情况下的底孔最小值。

These minimum pre-drilled hole sizes are required before chamfering operations.



先端角 60°的产品用于中心定位加工时易产生钻尖崩损，为解决此问题，钻尖中心小于最小底孔径的部分为 120°
The TIN-NC-LDS with point angle 60°has a 120°point angle within the minimum drill hole diameter in order to prevent the chisel edges from crashing.

商品记号 Abbreviation	加工材料 Work Material	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
TIN-NC-LDS	中心定位用 Counter Sinking	◎	◎	◎	◎	○					◎	◎	◎	◎	◎		◎	◎	
	60° 倒角用 Countersinking	◎	◎	◎	◎	◎	○	○			◎	◎	◎	◎	◎	◎	◎	◎	◎
	90° 倒角用 Countersinking	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	◎	◎	◎	◎	◎

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

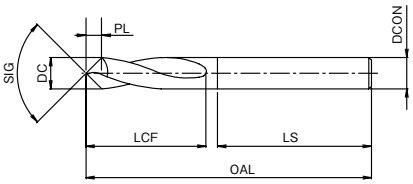
■标识说明请参考P.1。 See p.1 for explanation of icons.

V 涂层粉末高速钢
V COATED XPM

VP-LDS

切削条件 Cutting Conditions | P.440

V 涂层型比TIN-NC-LDS 的寿命更长。
This is the same drill as the TIN-NC-LDS, but the powdered metallurgy HSS and V coating increases tool life.



XPM | V | SHANK h7 | 20°

先端角的公差为90° ±1°。
Tolerance of the point angle is 90°±1°

单位:mm Unit:mm

商品号 EDP No.	直径 x 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63803	**3 × 90°**	11	48	3	37	1.5	1.1	●	4
63804	**4 × 90°**	15	54	4	39	2	1.3	●	7
63806	**6 × 90°**	20	72	6	52	3	1.5	●	16
63808	**8 × 90°**	26	81	8	55	4	1.6	●	30
63810	**10 × 90°**	30	93	10	63	5	2.1	●	57

注 1）表示进行倒角情况下的底孔最小值。

商品号 EDP No.	直径 x 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63812	**12 × 90°**	36	108	12	72	6	2.1	●	91
63816	**16 × 90°**	41	118	16	75	8		●	177
63818	**20 × 90°**	53	132	20	77	10	3	●	297
63820	**25 × 90°**	60	151	25	89	12.5		●	521

These minimum pre-drilled hole sizes are required before chamfering operations.

加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	60~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
VP-LDS	中心定位用 Centering	◎	◎	◎	◎	◎	◎	○			○	◎	◎	○	◎	◎	◎	◎	◎
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	◎	◎	◎	◎	◎

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

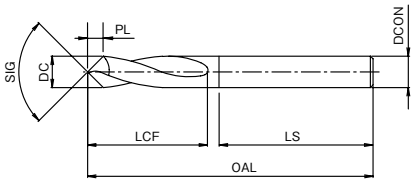
G-LIST No. | CH1001

长柄型
HSS GENERAL TYPE WITH LONG SHANK

LS-NC-LDS

切削条件 Cutting Conditions | P.447

先端角是90°，最适合用于深槽部分的倒角加工。
This drill is most suitable for processing countersinks in deep/recessed holes (point angle, 90°).



HSS | SHANK h7 | 20°

先端角的公差为90°±1°。
Tolerance of the point angle is 90°±1°

单位:mm Unit:mm

商品号 EDP No.	直径×先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63503	**3 × 90°**	11	75	3	50	1.5	1.1	●	6
63504	**4 × 90°**	15	100	4	60	2	1.3	●	12
63506	**6 × 90°**	20	150	6	60	3	1.5	●	34
63508	**8 × 90°**	26		8	60	4	1.6	●	60
63510	**10 × 90°**	30	200	10	80	5	2.1	●	124

注 1）表示进行倒角情况下的底孔最小值。

商品号 EDP No.	直径×先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63512	**12 × 90°**	36	200	12	80	6	2.1	●	174
63516	**16 × 90°**	41		16	175	8		●	384
63518	**20 × 90°**	53	250	20	175	10	3	●	589
63520	**25 × 90°**	60		25	175	12.5		●	884

These minimum pre-drilled hole sizes are required before chamfering operations.

商品记号 Abbreviation / 加工材料 Work Material		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
LS-NC-LDS	中心定位用 Centering	◎	◎	◎	○							○	○	○		○	○		
	倒角用 Countersinking	◎	◎	◎	◎	◎	○				○	○	○	○	○	○	○		

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

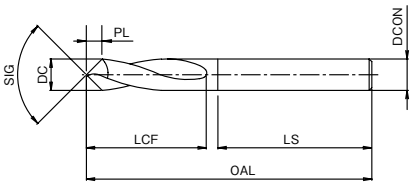
G-LIST No. | CH1006

V涂层粉末高速钢长柄型
V COATED XPM WITH LONG SHANK

VP-LS-LDS

切削条件 Cutting Conditions | P.440

先端角是90°，最适合用于深槽部分的倒角加工。
This drill is most suitable for processing countersinks in deep/recessed holes (point angle, 90°).



XPM | V | SHANK h7 | 20°

先端角的公差为90°±1°。
Tolerance of the point angle is 90°±1°

单位:mm Unit:mm

商品号 EDP No.	直径×先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63903	3× 90°	11	75	3	50	1.5	1.1	●	6
63904	4× 90°	15	100	4	60	2	1.3	●	12
63906	6× 90°	20	150	6	60	3	1.5	●	35
63908	8× 90°	26		8	60	4	1.6	●	60
63910	10× 90°	30	200	10	80	5	2.1	●	126

注 1）表示进行倒角情况下的底孔最小值。

商品号 EDP No.	直径×先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
63912	12× 90°	36	200	12	80	6	2.1	●	177
63916	16× 90°	41	250	16	140	8	3	●	382
63918	20× 90°	53		20	160	10		●	571
63920	25× 90°	60		25	180	12.5		●	870

These minimum pre-drilled hole sizes are required before chamfering operations.

商品记号 Abbreviation	加工材料 Work Material	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	60~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
VP-LS-LDS	中心定位用 Centering	◎	◎	◎	◎	◎	○				○	○	○	○	○	○	○	○	
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎				○	○	○	○	○	○	○	○	

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

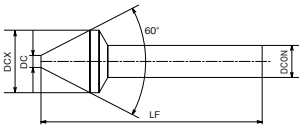
G-LIST No. | **CW1015**

硬质合金FX 涂层三刃孔口倒角刀
FX COATED CARBIDE

FX-MG-CS×60°

切削条件 Cutting Conditions | P.442

60° 系列



CARBIDE | FX

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	先端径 DC	大端径 DCX	全长 LF	柄径 DCON	锥部长 Lt	库存 Stock	重量 (g)
9139063	6.3× 6×2.0×55	1	6.3	55	6	(4.59)	●	27
9139083	8.3× 6×3.0×55	2.5	8.3			(5.02)	●	29
9139104	10.4× 8×3.0×65	2.6	10.4	65	8	(6.75)	●	51
9139124	12.4×10×4.0×65	2.5	12.4		10	(8.57)	●	73

商品号 EDP No.	名称 Designation	先端径 DC	大端径 DCX	全长 LF	柄径 DCON	锥部长 Lt	库存 Stock	重量 (g)
9139165	16.5×10×4.0×70	3.1	16.5	70	10	(11.6)	●	95
9139205	20.5×12×5.0×80	3.5	20.5	80	12	(14.72)	●	153
9139250	25 ×12×5.0×80	3.8	25			(18.36)	●	181

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

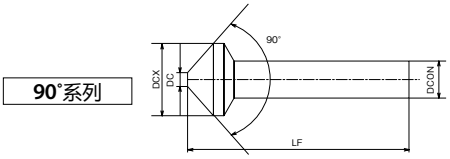
△＝停产产品(请确认库存。)
Discontinued item

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

硬质合金FX 涂层三刃孔口倒角刀
FX COATED CARBIDE

FX-MG-CS×90°

切削条件 Cutting Conditions | P.442



CARBIDE FX

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	先端径 DC	大端径 DCX	全长 LF	柄径 DCON	锥部长 Lt	库存 Stock	重量 (g)
9149063	6.3× 6×2.0×55	1	6.3	55	6	(2.65)	●	27
9149083	8.3× 6×2.5×55	2.5	8.3			(2.9)	●	28
9149104	10.4× 8×3.0×65	2.6	10.4	65	8	(3.9)	●	52
9149124	12.4×10×4.0×65	2.5	12.4		10	(4.95)	●	76

商品号 EDP No.	名称 Designation	先端径 DC	大端径 DCX	全长 LF	柄径 DCON	锥部长 Lt	库存 Stock	重量 (g)
9149165	16.5×10×4.0×70	3.1	16.5	70	10	(6.7)	●	94
9149205	20.5×12×5.0×70	3.8	20.5		12	(8.35)	●	138
9149250	25 ×12×5.0×70	3.8	25			(10.6)	●	159

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | CH1012

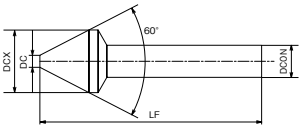
V 涂层高速钢倒角刀
V COATED HSS

V-UCS

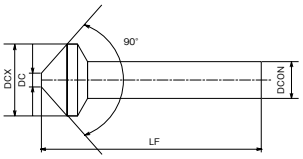
切削条件 Cutting Conditions | P.449

HSS | V

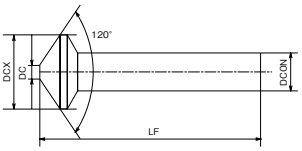
60°系列



90°系列



120°系列



单位:mm Unit:mm

商品号 EDP No.	外径 x 先端角 DCX × SIG	先端径 DC	大端径 DCX	全长 LF	柄径 DCON	锥部长 Lt	库存 Stock	重量 (g)
9106063	6.3 X 60°	1.3	6.3	47	5	(4.16)	●	9
9106083	8.3 X 60°	1.8	8.3	52	6	(5.46)	●	14
9106104	10.4 X 60°	2.3	10.4	53		(6.84)	●	16
9106124	12.4 X 60°	2.5	12.4	60	8	(8.14)	●	30
9106165	16.5 X 60°	2.8	16.5	65	10	(10.83)	●	46
9106205	20.5 X 60°	3	20.5	69		(14.29)	●	52
9106250	25 X 60°	3.2	25	75		(17.32)	●	71
9109043	4.3 X 90°	1.3	4.3	40	4	(1.5)	●	5
9109053	5.3 X 90°		5.3			(1.9)	●	5
9109063	6.3 X 90°		6.3	45	5	(2.4)	●	9
9109073	7.3 X 90°	1.6	7.3	50	6	(2.75)	●	13
9109083	8.3 X 90°	1.8	8.3			(3.15)	●	14
9109094	9.4 X 90°	2	9.4			(3.6)	●	15
9109104	10.4 X 90°	2.2	10.4			(3.95)	●	15
9109115	11.5 X 90°	2.5	11.5	56	8	(4.5)	●	28
9109124	12.4 X 90°		12.4			(4.8)	●	28
9109134	13.4 X 90°		13.4			(5.3)	●	26
9109144	14.4 X 90°		14.4			(5.75)	●	27
9109150	15 X 90°	2.8	15	60	10	(5.9)	●	41

商品号 EDP No.	外径 x 先端角 DCX × SIG	先端径 DC	大端径 DCX	全长 LF	柄径 DCON	锥部长 Lt	库存 Stock	重量 (g)
9109165	16.5 X 90°	2.8	16.5	60	10	(6.65)	●	43
9109190	19 X 90°	3	19	63		(7.75)	●	50
9109205	20.5 X 90°		20.5			(8.5)	●	51
9109230	23 X 90°	3.2	23	67		(9.6)	●	61
9109250	25 X 90°		25			(10.6)	●	66
9109260	26 X 90°		26			(11.1)	●	66
9109280	28 X 90°	3.5	28	71	12	(12)	●	92
9109300	30 X 90°		30			(12.9)	●	96
9109310	31 X 90°		31			(13.4)	●	108
9109340	34 X 90°	4.5	34	107	16	(14.75)	●	245
9109370	37 X 90°		37	111		(16.25)	●	304
9112063	6.3 X120°	1.3	6.3	44	5	(1.39)	●	9
9112083	8.3 X120°	1.8	8.3	48	6	(1.82)	●	14
9112104	10.4 X120°	2.2	10.4			(2.28)	●	15
9112124	12.4 X120°	2.5	12.4	54	8	(2.86)	●	28
9112165	16.5 X120°	2.8	16.5	57	10	(3.95)	●	42
9112205	20.5 X120°	3	20.5	59		(4.91)	●	47
9112250	25 X120°	3.2	25	62		(6.12)	●	63

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

硬质合金FX 涂层长柄型
FX COATED CARBIDE WITH LONG SHANK

FX-LS-LDS

切削条件 Cutting Conditions | P.439

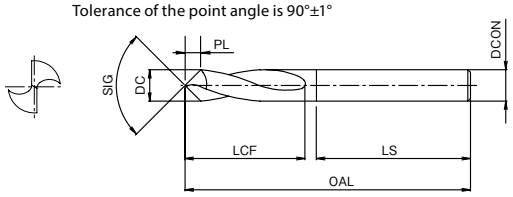
CARBIDE | FX | SHANK h7 | 12°

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8561616	**16 × 90°**	41	250	16	207	8	5	●	668
8561620	**20 × 90°**	46		20	202	10		●	1,033

注1) 表示进行倒角情况下的底孔最小值。

先端角是90°，最适合用于深槽部分的倒角。
This drill is most suitable for processing counter sinks in deep/recessed holes (point angle, 90°).

先端角的公差为90° ±1°。
Tolerance of the point angle is 90°±1°



单位:mm Unit:mm

商品号 EDP No.	直径 × 先端角 DC × SIG	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	最小底孔径 Min.Pre-Drilled Dia. 注1)	库存 Stock	重量 (g)
8561625	**25 × 90°**	53	250	25	195	12.5	5	●	1,581

These minimum pre-drilled hole sizes are required before chamfering operations.

加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel C~0.25%	中碳素钢 Medium Carbon Steel C0.25~0.45%	高碳素钢 High Carbon Steel C0.45%~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel ~35 HRC	调质钢 Hardened Steel 35~45 HRC	淬火钢 Quenched and Tempered Steel 45~50 HRC	淬火钢 Quenched and Tempered Steel 50~60 HRC	淬火钢 Quenched and Tempered Steel 60~70 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD SKS	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜合金 Copper Alloy Cu	变形铝 Aluminum AL	铸造铝合金 Aluminum Alloy Casting AC	钛合金 Titanium Alloy	镍基合金 Inconel
FX-LS-LDS	中心定位用 Centering	◎	◎	◎	◎	◎	○					◎	◎	◎	○		○	○	○
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	◎			○	○	◎	◎			◎	○	○

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

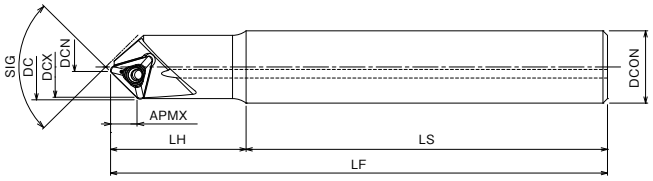
■标识说明请参考 P.1。 See p.1 for explanation of icons.

G-LIST No. | **FL1091** NEW

可转位中心钻
CENTERING AND CHAMFERING CUTTER

PLDS

切削条件 Cutting Conditions | P.441



带内冷油孔
with Coolant Hole

直柄型 Straight Shank Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	先端角 SIG	加工径 最小 DCN	加工径 最大 DCX	外径 DC	刃数 ZEFP	柄径 DCON	柄长 LS	全长 OAL	颈长 LH	APMX	重量 (kg)
7803401	**PLDS11R002SS16-90**	90°	2.5	13.5	14.4	1	16	80	110	30	5.8	0.15
7803402	**PLDS11R002SS16-L90**							170	200			0.28
7803403	**PLDS11R002SS16-120**	120°	2.4	16	17.3			80	110		4	0.15
7803404	**PLDS11R002SS16-L120**							170	200			0.28

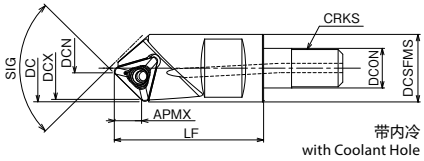
加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
PLDS	中心定位用 Centering	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎

●=标准库存品 ●=Standard stock item.

可转位中心钻
CENTERING AND CHAMFERING CUTTER

PLDS

切削条件 Cutting Conditions | P.441



螺纹安装型 Screw Fit Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	先端角 SIG	加工径 最小 DCN	加工径 最大 DCX	外径 DC	刃数 ZEFP	装夹直径 DCON	螺纹尺寸 CRKS	扳手尺寸 Spanner Size	全长 OAL	端面直径 DCSFMS	APMX	重量 (kg)
7803405	**PLDS11R002SF8-90**	90°	2.5	13.5	14.4	1	8.5	M8	10	32	14.5	5.8	0.05
7803406	**PLDS11R002SF8-120**	120°	2.4	16	17.3							4	0.05

加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
PLDS	中心定位用 Centering	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎

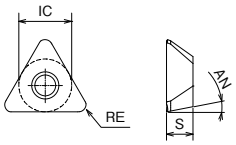
●=标准库存品 ●=Standard stock item.

G-LIST No. | **FL1091** NEW

可转位中心钻
CENTERING AND CHAMFERING CUTTER

PLDS

切削条件 Cutting Conditions | P.441



■适用刀片 Inserts

单位:mm Unit:mm

名称 Designation	切削刃数 No. of Cutting Edges	刀片尺寸 Insert Size				涂层种类 Grade of Coated Materials	
		内接圆径 IC	厚度 S	后角 AN	RE	XP9020	XP2040
TPKT110308ER-DM	3	6.35	3.18	11°	0.8	7814205	7813205

加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
PLDS	中心定位用 Centering	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎

●=标准库存品 ●=Standard stock item.

G-LIST No. | FL1091 NEW

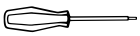
可转位中心钻
CENTERING AND CHAMFERING CUTTER

PLDS

切削条件 Cutting Conditions | P.441

■零件 Accessories

	商品号 EDP No.	名称 Designation	推荐安装扭矩 Recommended Tightening Torque
固定螺丝 Clamping Screw	7808138	FS22550P (Torx 7IP)	1.0 N·m

	商品号 EDP No.	名称 Designation
 扳手 Wrench	7808224	7IP-D (Torx 7IP)

扳手需另购。
The wrenchs are sold separately from the cutters.

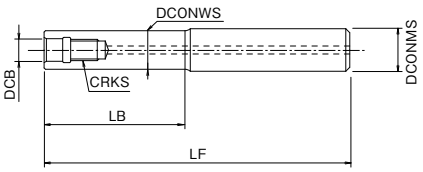
加工材料 Work Material / 商品记号 Abbreviation		低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
		C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
PLDS	中心定位用 Centering	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎
	倒角用 Countersinking	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	◎	◎

●=标准库存品 ●=Standard stock item.

G-LIST No. | FL1072

螺纹安装型专用刀杆
SHANK HOLDER FOR SCREW FIT TYPE

OP-SFA



螺纹安装型专用直柄刀杆：钢制刀杆 Straight Shank Holder for Screw Fit Type : Steel Shank

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	柄径 DCONMS	颈径 DCONWS	螺纹尺寸 CRKS	装夹直径 DCB	全长 LF	颈长 LB	库存 Stock
7801900	**SF-M08SS16-15**	16	14.5	M8	8.5	95	13	●

螺纹安装型专用直柄刀杆：硬质合金刀杆 Straight Shank Holder for Screw Fit Type : Carbide Shank

单位:mm Unit:mm

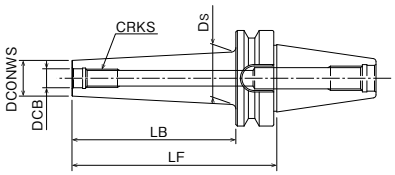
商品号 EDP No.	名称 Designation	柄径 DCONMS	颈径 DCONWS	螺纹尺寸 CRKS	装夹直径 DCB	全长 LF	颈长 LB	库存 Stock
7801910	**SF-M08SS16-55CS**	16	14.5	M8	8.5	115	53	●
7801911	**SF-M08SS16-85CS**					145	83	

●=标准库存品 ●=Standard stock item.

G-LIST No. | FL1072

螺纹安装型专用刀杆
SHANK HOLDER FOR SCREW FIT TYPE

OP-SFA



螺纹安装型专用BT刀柄 BT Shank Holder for Screw Fit Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	颈径 DCONWS	螺纹尺寸 CRKS	装夹直径 DCB	悬长 LF	颈长 LB	颈口径 Ds	库存 Stock
7802500	**BT30-SFA8-45**	14.5	M8	8.5	45	23	16	※
7802501	**BT30-SFA8-85**				85	63	21.1	
7802508	**BT40-SFA8-45**				45	18	16	
7802509	**BT40-SFA8-85**				85	58	20.5	
7802518	**BT50-SFA8-85**					47	19.4	
7802519	**BT50-SFA8-135**				135	97	24.6	

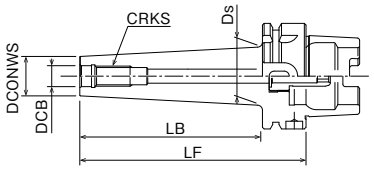
※＝交货期请咨询我司营业人员。※=Please contact our sales department for lead time

●=标准库存品 ●=Standard stock item.

G-LIST No. | FL1072

螺纹安装型专用刀杆
SHANK HOLDER FOR SCREW FIT TYPE

OP-SFA



螺纹安装型专用HSK刀柄 HSK Shank Holder for Screw Fit Type

单位:mm Unit:mm

商品号 EDP No.	名称 Designation	颈径 DCONWS	螺纹尺寸 CRKS	装夹直径 DCB	悬长 LF	颈长 LB	颈口径 Ds	库存 Stock
7802550	**A63-SFA8-45**	14.5	M8	8.5	85	19	16	※
7802551	**A63-SFA8-85**					59	20.6	
7802560	**A100-SFA8-85**					50	19.7	
7802561	**A100-SFA8-135**				135	100	24.9	

※＝交货期请咨询我司营业人员。※=Please contact our sales department for lead time

●=标准库存品 ●=Standard stock item.

G-LIST No. | DW1071 NEW SIZES

硬质合金平头钻 2D型
CARBIDE FLAT DRILL 2D TYPE

The A Brand

ADF-2D

切削条件 Cutting Conditions | P.450

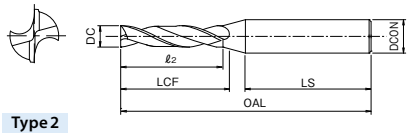
采用"EgiAs"涂层可以提高耐磨损性·韧性。
一把平头钻可以对应如倾斜面，曲面的沉孔加工等多样化用途。

With the addition of OSG's EgiAs coating, tool life can be prolonged with excellent heat and wear resistance.
The ADF enables one-step drilling in a wide variety of applications, such as inclined and curved surfaces.

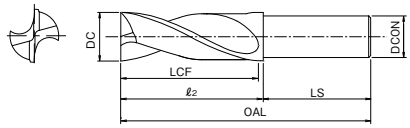
涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration,
but it does not cause any performance problems.

CARBIDE | EgiAs 2≦DC | IchAda DC<2 | h8 2≦DC | 0~-0.009 DC<2 | SHRINK FIT | 约20° ABOUT20°

Type 1



Type 2



单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330020	**0.2**	0.6	40	3	34.1	0.7	1	●	7
3330025	**0.25**	0.8			34	0.9		●	7
3330030	**0.3**	0.9			34	1		●	7
3330035	**0.35**	1.1			33.9	1.2		●	7
3330040	**0.4**	1.2			33.9	1.3		●	7
3330045	**0.45**	1.4			33.7	1.5		●	7
3330050	**0.5**	1.7			33.4	1.9		●	7
3330055	**0.55**	1.9			33.3	2.1		●	7
3330060	**0.6**	2			33.3	2.2		●	7
3330065	**0.65**	2.2			33.2	2.4		●	7

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330070	**0.7**	2.4	40	3	33.1	2.6	1	●	7
3330071	**0.71**				33.1			●	7
3330072	**0.72**				33.2			●	7
3330074	**0.74**	2.5			33.1	2.7		●	7
3330075	**0.75**	2.6			33	2.8		●	7
3330080	**0.8**	2.7			33	2.9		●	7
3330081	**0.81**	2.8			32.9	3		●	7
3330085	**0.85**	2.9			32.9	3.1		●	7
3330089	**0.89**	3			32.9	3.2		●	7
3330090	**0.9**	3.1			32.8	3.3		●	7

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直径 DC 0.91～1.46 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C～0.25%	中碳素钢 Medium Carbon Steel C0.25～0.45%	高碳素钢 High Carbon Steel C0.45%～	合金钢 Alloy Steel SCM	调质钢 Hardened Steel ～35 HRC	35～45 HRC	淬火钢 Quenched and Tempered Steel 45～50 HRC	50～62 HRC	62～70 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD SKS	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜合金 Copper Alloy Cu	变形铝 Aluminum AL	铸造铝合金 Aluminum Alloy Casting AC	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy AZ91D	金属基复合材料 (MMC) Metal Matrix Composites
ADF-2D	◎	◎	◎	◎	◎	○				○ 注1)		◎	◎		○	○					

注1) DC<2
Note

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1071 NEW SIZES

硬质合金平头钻 2D型
CARBIDE FLAT DRILL 2D TYPE

The A Brand

ADF-2D

切削条件 Cutting Conditions | P.450

采用"EgiAs"涂层可以提高耐磨损性·韧性。
一把平头钻可以对应如倾斜面，曲面的沉孔加工等多样化用途。

With the addition of OSG's EgiAs coating, tool life can be prolonged with excellent heat and wear resistance.
The ADF enables one-step drilling in a wide variety of applications, such as inclined and curved surfaces.

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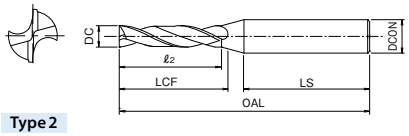
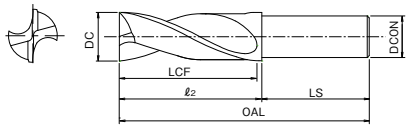
Drills may have some discoloration,
but it does not cause any performance problems.

Type 1



Type 2



CARBIDE	EgiAs	IchAda	h8	0~-0.009	SHRINK FIT	約20°
	2≦DC	DC<2	2≦DC	DC<2		ABOUT20°

上一页
FROM 直径 DC 0.2～0.9

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330091	**0.91**	3.1	40	3	32.8	3.3	1	●	7
3330092	**0.92**				32.8			●	7
3330095	**0.95**	3.2			32.8	3.4		●	7
3330100	**1**	4	45		37	4.3		●	7
3330109	**1.09**	4.4			36.7	4.7		●	7
3330110	**1.1**				36.8			●	7
3330111	**1.11**				36.8			●	7
3330112	**1.12**	4.5			36.7	4.8		●	7
3330120	**1.2**	4.8			36.5	5.1		●	7
3330125	**1.25**	5			36.4	5.3		●	7

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330126	**1.26**	5	45	3	36.5	5.3	1	●	7
3330127	**1.27**	5.1			36.4	5.4		●	7
3330128	**1.28**				36.4			●	7
3330129	**1.29**	5.2			36.3	5.5		●	7
3330130	**1.3**							●	7
3330135	**1.35**	5.4			36.2	5.7		●	7
3330140	**1.4**	5.6			36.1	5.9		●	7
3330144	**1.44**	5.8			36	6.1		●	7
3330145	**1.45**				36			●	7
3330146	**1.46**				36			●	7

下一页
直径 DC 1.47～1.95 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADF-2D	◎	◎	◎	◎	◎	○				○ 注1)		◎	◎		○	○					

注1) DC<2
Note

上一页
FROM 直径 DC 0.91～1.46

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3330147	**1.47**	5.9	45	3	35.9	6.2	1	●	7
3330148	**1.48**				36			●	7
3330150	**1.5**	6			35.9	6.3		●	7
3330153	**1.53**	6.1				6.4		●	7
3330154	**1.54**	6.2			35.8	6.5		●	7
3330155	**1.55**				35.8			●	7
3330156	**1.56**				35.8			●	7
3330157	**1.57**	6.3			35.7	6.6		●	7
3330158	**1.58**				35.8			●	7
3330160	**1.6**	6.4			35.7	6.7		●	7

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3330170	**1.7**	6.8	45	3	35.5	7.1	1	●	7
3330175	**1.75**	7			35.4	7.3		●	7
3330180	**1.8**	7.2			35.3	7.5		●	7
3330182	**1.82**	7.3			35.2	7.6		●	7
3330183	**1.83**				35.2			●	7
3330184	**1.84**				35.1			●	7
3330185	**1.85**	7.4			35.2	7.7		●	7
3330186	**1.86**				35.2			●	7
3330190	**1.9**	7.6			35.1	7.9		●	7
3330195	**1.95**	7.8			34.9	8.1		●	7

下一页
直径 DC 2～3.15 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1071 NEW SIZES

硬质合金平头钻 2D型
CARBIDE FLAT DRILL 2D TYPE

The A Brand

ADF-2D

切削条件 Cutting Conditions | P.450

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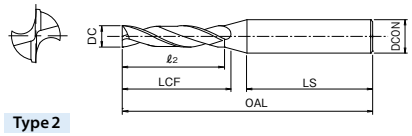
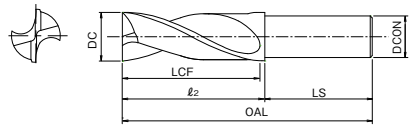
CARBIDE	EgiAs	IchAda	h8	0~-0.009	FIT	约20°
	2≦DC	DC<2	2≦DC	DC<2		ABOUT20°

Type 1



Type 2



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FROM 直径 DC 1.47～1.95

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330200	**2**	10	50	4	36	10.3	1	●	9
3330210	**2.1**				36	10.5		●	9
3330220	**2.2**	11			36	10.6		●	9
3330230	**2.3**				36	10.8		●	9
3330232	**2.32**				36	10.9		●	9
3330240	**2.4**	12			36	11		●	9
3330242	**2.42**				36	11.1		●	9
3330250	**2.5**				36	11.2		●	9
3330254	**2.54**				36	11.3		●	9
3330258	**2.58**	13			36	11.4		●	9

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330260	**2.6**	13	50	4	36	11.4	1	●	9
3330270	**2.7**				36	11.6		●	9
3330276	**2.76**	14			36	11.7		●	9
3330278	**2.78**				36			●	9
3330280	**2.8**				36	11.8		●	9
3330290	**2.9**				36	11.9		●	9
3330300	**3**	15	55	6	38	11.4		●	19
3330303	**3.03**				38	11.5		●	19
3330310	**3.1**				38	11.6		●	19
3330315	**3.15**				38	11.7		●	19

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直径 DC 3.2～4.6 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADF-2D	◎	◎	◎	◎	◎	○				○ 注1)		◎	◎		○	○					

注1) DC<2
Note

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FROM 直径 DC 2～3.15

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3330320	**3.2**	15	55	6	38	11.8	1	●	19
3330330	**3.3**				38	12		●	19
3330340	**3.4**	16			38	12.1		●	19
3330350	**3.5**				38	12.3		●	19
3330353	**3.53**				38	12.4		●	19
3330360	**3.6**				38	12.5		●	19
3330366	**3.66**				38	12.6		●	19
3330368	**3.68**				38	12.7		●	19
3330370	**3.7**				38			●	19
3330380	**3.8**	19	60		38	17.9		●	20

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3330390	**3.9**	19	60	6	38	18.1	1	●	20
3330400	**4**				38	18.3		●	20
3330403	**4.03**				38			●	20
3330410	**4.1**				38	18.5		●	20
3330420	**4.2**	21			38	18.6		●	20
3330430	**4.3**				38	18.8		●	20
3330440	**4.4**				38	19		●	20
3330450	**4.5**				38	19.2		●	20
3330453	**4.53**				38	19.3		●	21
3330460	**4.6**				38	19.4		●	20

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直径 DC 4.62~6.03 NEXT

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1071 NEW SIZES

硬质合金平头钻 2D型
CARBIDE FLAT DRILL 2D TYPE

The A Brand

ADF-2D

切削条件 Cutting Conditions | P.450

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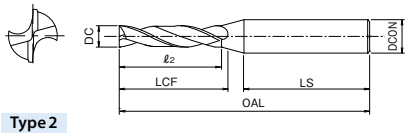
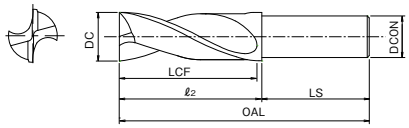
but it does not cause any performance problems.

CARBIDE	EgiAs	IchAda	h8	0~-0.009	SHRINK FIT	约20°
	2≦DC	DC<2	2≦DC	DC<2		ABOUT20°

Type 1



Type 2



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FROM 直径 DC 3.2～4.6

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330462	**4.62**				38	19.4		●	21
3330464	**4.64**	21	60		38	19.5		●	20
3330470	**4.7**				38	19.6		●	21
3330480	**4.8**				38	24.8		●	21
3330490	**4.9**				38	24.9		●	21
3330500	**5**			6	38	25.1	1	●	22
3330503	**5.03**	24	65		38	25.2		●	22
3330510	**5.1**				38	25.3		●	22
3330520	**5.2**				38	25.5		●	22
3330530	**5.3**				38	25.7		●	22

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330540	**5.4**				38	25.9		●	22
3330550	**5.5**				38			●	22
3330552	**5.52**				38	26.1		●	22
3330554	**5.54**				38			●	22
3330560	**5.6**	27	65	6	38	26.3	1	●	22
3330570	**5.7**				38	26.4		●	23
3330580	**5.8**				38	26.6		●	23
3330590	**5.9**				38	26.8		●	23
3330600	**6**				38	27	2	●	23
3330603	**6.03**	30	70		38	32		●	28

下一页
直径 DC 6.1～7.8 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADF-2D	◎	◎	◎	◎	◎	○				○ 注1)		◎	◎		○	○					

注1) DC<2
Note

上一页
FROM 直径 DC 4.62~6.03

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3330610	**6.1**	30	70	6	38	32	2	●	28
3330620	**6.2**				38			●	28
3330630	**6.3**				38			●	28
3330640	**6.4**				38			●	29
3330650	**6.5**				38			●	29
3330653	**6.53**				38			●	29
3330660	**6.6**				38			●	29
3330670	**6.7**				38			●	29
3330680	**6.8**				38			●	30
3330690	**6.9**				38			●	30
3330700	**7**	30	70	6	38	32	2	●	30
3330703	**7.03**	34	75		39	36		●	32
3330710	**7.1**				39			●	33
3330720	**7.2**				39			●	33
3330730	**7.3**				39			●	33
3330740	**7.4**				39			●	34
3330750	**7.5**				39			●	34
3330760	**7.6**				39			●	34
3330770	**7.7**				39			●	35
3330780	**7.8**				39			●	34

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直径 DC 7.9~9.5 NEXT

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1071 NEW SIZES

硬质合金平头钻 2D型
CARBIDE FLAT DRILL 2D TYPE

The A Brand

ADF-2D

切削条件 Cutting Conditions | P.450

采用"EgiAs"涂层可以提高耐磨损性·韧性。
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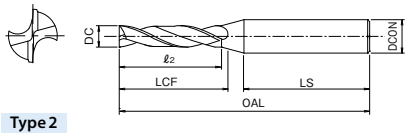
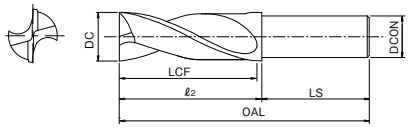
涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration,
but it does not cause any performance problems.

Type 1



Type 2



CARBIDE	EgiAs	IchAda	h8	0~-0.009	SHRINK FIT	约20°
	2≦DC	DC<2	2≦DC	DC<2		ABOUT20°

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FROM 直径 DC 6.1～7.8

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3330790	**7.9**	34	75	6	39	36	2	●	35
3330800	**8**				39			●	49
3330803	**8.03**	38	80	8	40	40		●	50
3330810	**8.1**				40			●	50
3330820	**8.2**				40			●	51
3330830	**8.3**				40			●	51
3330840	**8.4**				40			●	52
3330850	**8.5**				40			●	52
3330853	**8.53**				40			●	53
3330860	**8.6**				40			●	53
3330870	**8.7**	38	80	8	40	40	2	●	53
3330880	**8.8**				40			●	54
3330890	**8.9**				40			●	54
3330900	**9**				40			●	55
3330903	**9.03**	42	85		41	44		●	58
3330910	**9.1**				41			●	59
3330920	**9.2**				41			●	60
3330930	**9.3**				41			●	60
3330940	**9.4**				41			●	61
3330950	**9.5**				41			●	62

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直径 DC 9.6～11.3 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADF-2D	◎	◎	◎	◎	◎	○				○ 注1)		◎	◎		○	○					

注1) DC<2
Note

上一页
FROM 直径 DC 7.9~9.5

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3330960	**9.6**	42	85	8	41	44	2	●	62
3330970	**9.7**				41			●	63
3330980	**9.8**				41			●	64
3330990	**9.9**				41			●	63
3331000	**10**			10	41			●	81
3331003	**10.03**	46	90		42	48		●	85
3331010	**10.1**				42			●	85
3331020	**10.2**				42			●	86
3331030	**10.3**				42			●	86
3331040	**10.4**				42			●	86

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3331050	**10.5**	46	90	10	42	48	2	●	88
3331060	**10.6**				42			●	88
3331070	**10.7**				42			●	89
3331080	**10.8**				42			●	89
3331090	**10.9**				42			●	90
3331100	**11**				42			●	90
3331103	**11.03**	50	95		43	52		●	93
3331110	**11.1**				43			●	95
3331120	**11.2**				43			●	96
3331130	**11.3**				43			●	97

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直径 DC 11.4~13.2 NEXT

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1071 NEW SIZES

硬质合金平头钻 2D型
CARBIDE FLAT DRILL 2D TYPE

The A Brand

ADF-2D

切削条件 Cutting Conditions | P.450

采用"EgiAs"涂层可以提高耐磨损性·韧性。
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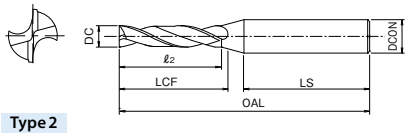
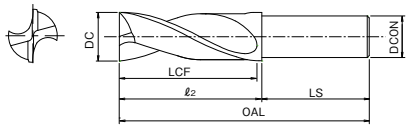
Type 1



Type 2



CARBIDE	EgiAs	IchAda	h8	0~-0.009	SHRINK FIT	约20°
	2≦DC	DC<2	2≦DC	DC<2		ABOUT20°

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FROM 直径 DC 9.6～11.3

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3331140	**11.4**	50	95	10	43	52	2	●	97
3331150	**11.5**				43			●	99
3331160	**11.6**				43			●	99
3331170	**11.7**				43			●	100
3331180	**11.8**				43			●	100
3331190	**11.9**				43			●	101
3331200	**12**			12	43			●	123
3331203	**12.03**	56	100		42	58		●	131
3331210	**12.1**				42			●	130
3331220	**12.2**				42			●	131

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3331230	**12.3**	56	100	12	42	58	2	●	132
3331240	**12.4**				42			●	135
3331250	**12.5**				42			●	133
3331260	**12.6**				42			●	134
3331270	**12.7**				42			●	135
3331280	**12.8**				42			●	136
3331290	**12.9**				42			●	138
3331300	**13**				42			●	138
3331310	**13.1**	60	105		43	62		●	147
3331320	**13.2**				43			●	148

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直径 DC 13.3～15.2 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
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加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADF-2D	◎	◎	◎	◎	◎	○				○ 注1)		◎	◎		○	○					

注1) DC<2
Note

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FROM 直径 DC 11.4～13.2

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3331330	**13.3**	60	105	12	43	62	2	●	151
3331340	**13.4**				43			●	152
3331350	**13.5**				43			●	153
3331360	**13.6**				43			●	152
3331370	**13.7**				43			●	153
3331380	**13.8**				43			●	155
3331390	**13.9**				43			●	157
3331400	**14**				43			●	157
3331410	**14.1**	64	110		44	66		●	165
3331420	**14.2**				44			●	165

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3331430	**14.3**	64	110	12	44	66	2	●	166
3331440	**14.4**				44			●	168
3331450	**14.5**				44			●	169
3331460	**14.6**				44			●	168
3331470	**14.7**				44			●	169
3331480	**14.8**				44			●	172
3331490	**14.9**				44			●	176
3331500	**15**				44			●	174
3331510	**15.1**	68	115		45	70		●	181
3331520	**15.2**				45			●	184

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直径 DC 15.3～20 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1071 NEW SIZES

硬质合金平头钻 2D型
CARBIDE FLAT DRILL 2D TYPE

The A Brand

ADF-2D

切削条件 Cutting Conditions | P.450

采用"EgiAs"涂层可以提高耐磨损性·韧性。
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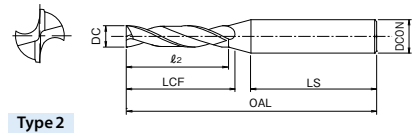
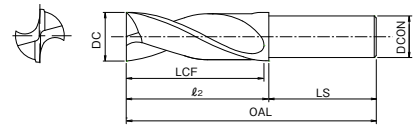
CARBIDE	EgiAs	IchAda	h8	0~-0.009	SHRINK FIT	约20°
	2≦DC	DC<2	2≦DC	DC<2		ABOUT20°

Type 1



Type 2



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FROM 直径 DC 13.3～15.2

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3331530	**15.3**	68	115	12	45	70	2	●	185
3331540	**15.4**				45			●	188
3331550	**15.5**				45			●	188
3331560	**15.6**				45			●	189
3331570	**15.7**				45			●	189
3331580	**15.8**				45			●	191
3331590	**15.9**				45			●	192
3331600	**16**			16	45			●	252

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3331650	**16.5**	74	125	16	49	76	2	●	284
3331700	**17**				49			●	293
3331750	**17.5**	78	130		50	80		●	309
3331800	**18**				50			●	320
3331850	**18.5**	84	135		49	86		●	336
3331900	**19**				49			●	346
3331950	**19.5**	88	140		50	90		●	367
3332000	**20**			20	50			●	458

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C~0.25%	C0.25~0.45%	C0.45%~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~62 HRC	62~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADF-2D	◎	◎	◎	◎	◎	○				○ 注1)		◎	◎		○	○					

注1) DC<2
Note

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | DW1072 NEW SIZES

硬质合金平头钻长柄 2D型

CARBIDE FLAT DRILL · LONG SHANK 2D TYPE

The A Brand

ADFLS-2D

切削条件 Cutting Conditions | P.451

采用"EgiAs"涂层可以提高耐磨损性·韧性。
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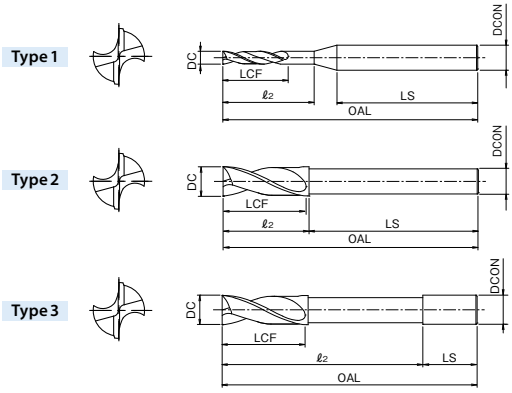
CARBIDE | EgiAs | h8 | SHRINK FIT | 约20° ABOUT20°



单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3332300	**3**	15	100	6	64.4	30	1	●	32
3332310	**3.1**				63.6	31		●	32
3332320	**3.2**				62.8	32		●	32
3332330	**3.3**				62	33		●	32
3332340	**3.4**	16			61.1	34		●	32
3332350	**3.5**				60.3	35		●	32
3332360	**3.6**				59.5	36		●	32
3332370	**3.7**				58.7	37		●	32
3332380	**3.8**	19			57.9	38		●	32
3332390	**3.9**				57.1	39		●	32
3332400	**4**				56.3	40		●	32
3332410	**4.1**				55.5	41		●	32
3332420	**4.2**	21			54.6	42		●	32
3332430	**4.3**				53.8	43		●	32

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3332440	**4.4**	21	100	6	53	44	1	●	32
3332450	**4.5**				52.2	45		●	32
3332460	**4.6**				51.4	46		●	33
3332470	**4.7**				50.6	47		●	33
3332480	**4.8**	24			49.8	48		●	33
3332490	**4.9**				48.9	49		●	33
3332500	**5**		110		58.1	50		●	37
3332510	**5.1**				57.3	51		●	38
3332520	**5.2**				56.5	52		●	38
3332530	**5.3**				55.7	53		●	38
3332540	**5.4**	27			54.9	54		●	39
3332550	**5.5**				54.1	55		●	39
3332560	**5.6**				53.3	56		●	39
3332570	**5.7**				52.4	57		●	40

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直径 DC 5.8～15 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C～0.25%	中碳素钢 Medium Carbon Steel C0.25～0.45%	高碳素钢 High Carbon Steel C0.45%～	合金钢 Alloy Steel SCM	调质钢 Hardened Steel ～35 HRC	35～45 HRC	淬火钢 Quenched and Tempered Steel 45～50 HRC	50～62 HRC	62～70 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD SKS	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜合金 Copper Alloy Cu	变形铝 Aluminum AL	铸造铝合金 Aluminum Alloy Casting AC	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy AZ91D	金属基复合材料 (MMC) Metal Matrix Composites
ADFLS-2D	○	○	○	○	○	○						○	○		○	○					

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **DW1072** NEW SIZES

硬质合金平头钻长柄 2D型
CARBIDE FLAT DRILL· LONG SHANK 2D TYPE

The A Brand

ADFLS-2D

切削条件 Cutting Conditions | P.451

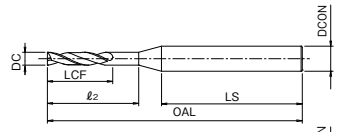
涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | SHRINK FIT | 约20° ABOUT20°

采用"EgiAs"涂层可以提高耐磨损性· 韧性。
一把平头钻可以对应如倾斜面，曲面的沉孔加工等多样化用途。

With the addition of OSG's EgiAs coating, tool life can be prolonged with excellent heat and wear resistance.
The ADF enables one-step drilling in a wide variety of applications, such as inclined and curved surfaces.

Type 1



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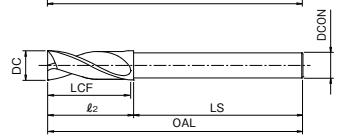
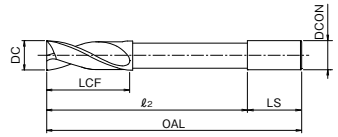


Type 3



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FROM 直径 DC 3～5.7

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3332580	5.8	27	110	6	51.6	58	1	●	40
3332590	5.9				50.8	59		●	41
3332600	6				81	29	2	●	43
3334060					50	60	3	●	40
3332650	6.5	30	120		88	32	2	●	51
3332680	6.8				88			●	53
※ 3332690	6.9				88			●	53
3332700	7				88			●	53
※ 3332740	7.4	34	130		94	36		●	59
3332750	7.5				94			●	58
3332780	7.8				94			●	59
3332800	8			8	94	40		●	90
3334080					50	80	3	●	90
3332850	8.5	38	140		100		2	●	98
※ 3332860	8.6				100			●	98
3332880	8.8				100			●	99
3332900	9				100			●	99
※ 3332920	9.2	42	150		106	44		●	111
3332950	9.5				106			●	110

※=NEW SIZES

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3332980	9.8	42	150	8	106	44	2	●	113
3333000	10			10	106			●	157
3334100					50	100	3	●	160
※ 3333030	10.3	46	160		112	48	2	●	168
※ 3333040	10.4				112			●	171
3333050	10.5				112			●	169
3333080	10.8				112			●	172
3333100	11				112			●	173
3333110	11.1	50	170		118	52		●	185
※ 3333150	11.5				118			●	189
3333180	11.8				118			●	188
3333200	12			12	118			●	248
3334120					50	120	3	●	240
3333250	12.5	56	180		122	58	2	●	269
3333300	13				122			●	271
3333350	13.5	60	190		128	62		●	303
3333400	14				128			●	305
※ 3333450	14.5	64	200		134	66		●	330
3333500	15				134			●	333

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直径 DC 15.5～20 NEXT

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADFLS-2D	○	○	○	○	○	○						○	○		○	○					

上一页

FROM 直径 **DC** 5.8～15

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
※ 3333550	**15.5**	68	210	12	140	70	2	●	358
3333600	**16**			16	140			●	535
3334160					50	160	3	●	530
※ 3333650	**16.5**	74	220		144	76	2	●	579
3333700	**17**				144			●	578
3333750	**17.5**	78	230		150	80		●	615

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3333800	**18**	78	230	16	150	80	2	●	620
※ 3333850	**18.5**	84	240		154	86		●	661
※ 3333900	**19**				154			●	673
※ 3333950	**19.5**	88	250		160	90		●	713
3334000	**20**			20	160			●	963
3334200					50	200	3	●	950

※＝NEW SIZES

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | **DW1110**

硬质合金内冷油孔平头钻 3D型

CARBIDE FLAT DRILL WITH INTERNAL COOLANT SUPPLY (3D TYPE)

The A Brand

ADFO-3D

切削条件 Cutting Conditions | P.452

采用"EgiAs"涂层可以提高耐磨损性·韧性。
一把平头钻可以对应如倾斜面，曲面的沉孔加工等多样化用途。通过内部供油可稳定加工不锈钢。

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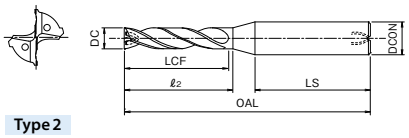
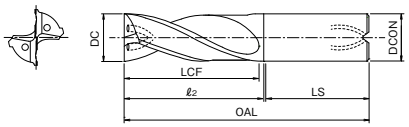
CARBIDE | EgiAs | h8 | SHRINK FIT | 约20° ABOUT20°

Type 1



Type 2



単位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3334300	**3**	15	55	4	37.1	16	1	●	9
3334301	**3.03**				37.2			●	10
3334302	**3.1**				37.3			●	10
3334303	**3.15**				37.4			●	10
3334304	**3.2**				37.5			●	10
3334305	**3.3**				37.7			●	10
3334306	**3.4**	16			36.9	17		●	10
3334307	**3.5**				37.1			●	10
3334308	**3.53**				37.1			●	10
3334309	**3.6**				37.3			●	10
3334310	**3.66**				37.4			●	10
3334311	**3.68**				37.4			●	10
3334312	**3.7**				37.4			●	10
3334313	**3.8**	19	60		39.6	20		●	11
3334314	**3.9**				39.8			●	11
3334315	**4**				40		2	●	11
3334316	**4.03**	21		6	34.3	22	1	●	19

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3334317	**4.1**	21	60	6	34.5	22	1	●	19
3334318	**4.2**				34.6			●	19
3334319	**4.3**				34.8			●	19
3334320	**4.4**				35			●	19
3334321	**4.5**				35.2			●	19
3334322	**4.53**				35.3			●	19
3334323	**4.6**				35.4			●	20
3334324	**4.62**				35.4			●	20
3334325	**4.64**				35.5			●	20
3334326	**4.7**				35.6			●	20
3334327	**4.8**	24	65		37.8	25		●	21
3334328	**4.9**				37.9			●	21
3334329	**5**				38.1			●	21
3334330	**5.03**				38.2			●	21
3334331	**5.1**				38.3			●	22
3334332	**5.2**				38.5			●	22
3334333	**5.3**				38.7			●	22

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直径 DC 5.4～8.1 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADFO-3D	◎	◎	◎	◎	◎	○				◎		◎	◎		○	○				○	

上一页
FROM 直径 DC 3～5.3

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3334334	**5.4**	27	65	6	35.9	28	1	●	22
3334335	**5.5**				36.1			●	22
3334336	**5.52**				36.1			●	22
3334337	**5.54**				36.1			●	22
3334338	**5.6**				36.3			●	22
3334339	**5.7**				36.4			●	23
3334340	**5.8**				36.6			●	23
3334341	**5.9**				36.8			●	23
3334342	**6**				37		2	●	23
3334343	**6.03**	30	70	8	35.3	31	1	●	38
3334344	**6.1**				35.5			●	38
3334345	**6.2**				35.6			●	38
3334346	**6.3**				35.8			●	39
3334347	**6.4**				36			●	40
3334348	**6.5**				36.2			●	40
3334349	**6.53**				36.3			●	40
3334350	**6.6**				36.4			●	40

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3334351	**6.7**	30	70	8	36.6	31	1	●	40
3334352	**6.8**				36.8			●	41
3334353	**6.9**				36.9			●	41
3334354	**7**				37.1			●	41
3334355	**7.03**				37.2			●	42
3334356	**7.1**	34	75		38.3	35		●	43
3334357	**7.2**				38.5			●	44
3334358	**7.3**				38.7			●	44
3334359	**7.4**				38.9			●	45
3334360	**7.5**				39.1			●	45
3334361	**7.6**				39.3			●	45
3334362	**7.7**				39.4			●	46
3334363	**7.8**				39.6			●	46
3334364	**7.9**				39.8			●	47
3334365	**8**				40		2	●	47
3334366	**8.03**	38	80	10	37.3	39	1	●	65
3334367	**8.1**				37.5			●	65

下一页
直径 DC 8.2～11.1 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | DW1110

硬质合金内冷油孔平头钻 3D型

CARBIDE FLAT DRILL WITH INTERNAL COOLANT SUPPLY (3D TYPE)

The A Brand

ADFO-3D

切削条件 Cutting Conditions | P.452

采用"EgiAs"涂层可以提高耐磨损性·韧性。
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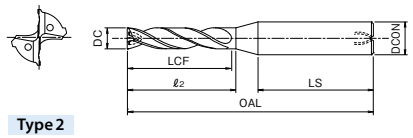
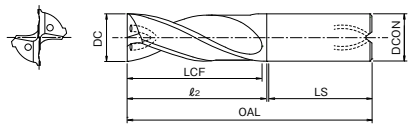
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | SHRINK FIT | 约20° ABOUT20°

Type 1



Type 2



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FROM 直径 DC 5.4～8.1

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3334368	**8.2**	38	80	10	37.6	39	1	●	65
3334369	**8.3**				37.8			●	66
3334370	**8.4**				38			●	67
3334371	**8.5**				38.2			●	67
3334372	**8.53**				38.3			●	68
3334373	**8.6**				38.4			●	68
3334374	**8.7**				38.6			●	68
3334375	**8.8**				38.8			●	68
3334376	**8.9**				38.9			●	70
3334377	**9**				39.1			●	70
3334378	**9.03**				39.2			●	70
3334379	**9.1**	42	85		40.3	43		●	72
3334380	**9.2**				40.5			●	73
3334381	**9.3**				40.7			●	75
3334382	**9.4**				40.9			●	75
3334383	**9.5**				41.1			●	75
3334384	**9.6**				41.3			●	76

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3334385	**9.7**	42	85	10	41.4	43	1	●	76
3334386	**9.8**				41.6			●	77
3334387	**9.9**				41.8			●	78
3334388	**10**				42		2	●	78
3334389	**10.03**	46	90	12	39.3	47	1	●	102
3334390	**10.1**				39.5			●	102
3334391	**10.2**				39.8			●	103
3334392	**10.3**				39.8			●	104
3334393	**10.4**				40			●	104
3334394	**10.5**				40.2			●	105
3334395	**10.6**				40.4			●	105
3334396	**10.7**				40.8			●	107
3334397	**10.8**				40.8			●	107
3334398	**10.9**				40.9			●	107
3334399	**11**				41.1			●	108
3334400	**11.03**				41.2			●	108
3334401	**11.1**	50	95		42.3	51		●	113

下一页
直径 DC 11.2～14.4 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel	复合材料 CFRP Composite Material	镁合金 Magnesium Alloy	金属基复合材料 (MMC) Metal Matrix Composites
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～62 HRC	62～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC				AZ91D	
ADFO-3D	◎	◎	◎	◎	◎	○				◎		◎	◎		○	○				○	

上一页
FROM 直径 DC 8.2～11.1

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3334402	**11.2**	50	95	12	42.5	51	1	●	114
3334403	**11.3**				42.7			●	116
3334404	**11.4**				42.9			●	116
3334405	**11.5**				43.1			●	117
3334406	**11.6**				43.3			●	118
3334407	**11.7**				43.4			●	119
3334408	**11.8**				43.6			●	119
3334409	**11.9**				43.8			●	120
3334410	**12**				44		2	●	122
3334411	**12.03**	56	100	14	39.3	57	1	●	148
3334412	**12.1**				39.5			●	149
3334413	**12.2**				39.6			●	150
3334414	**12.3**				39.8			●	151
3334415	**12.4**				40			●	151
3334416	**12.5**				40.2			●	153
3334417	**12.6**				40.4			●	153
3334418	**12.7**				40.6			●	154

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ_2	形状 Type	库存 Stock	重量 (g)
3334419	**12.8**	56	100	14	40.8	57	1	●	156
3334420	**12.9**				40.9			●	157
3334421	**13**				41.1			●	159
3334422	**13.1**	60	105		42.3	61		●	164
3334423	**13.2**				42.5			●	166
3334424	**13.3**				42.7			●	166
3334425	**13.4**				42.9			●	168
3334426	**13.5**				43.1			●	169
3334427	**13.6**				43.3			●	171
3334428	**13.7**				43.4			●	171
3334429	**13.8**				43.8			●	173
3334430	**13.9**				43.8			●	174
3334431	**14**				44		2	●	176
3334432	**14.1**	64	110	16	41.5	65	1	●	214
3334433	**14.2**				41.6			●	216
3334434	**14.3**				41.8			●	217
3334435	**14.4**				42			●	219

下一页
直径 DC 14.5～20 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | DW1110

硬质合金内冷油孔平头钻 3D型

CARBIDE FLAT DRILL WITH INTERNAL COOLANT SUPPLY (3D TYPE)

The A Brand

ADFO-3D

切削条件 Cutting Conditions | P.452

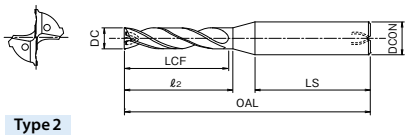
采用"EgiAs"涂层可以提高耐磨损性·韧性。
一把平头钻可以对应如倾斜面，曲面的沉孔加工等多样化用途。通过内部供油可稳定加工不锈钢。

With the addition of OSG's EgiAs coating, tool life can be prolonged with excellent heat and wear resistance. The ADF enables one-step drilling in a wide variety of applications, such as inclined and curved surfaces. Stable processing of stainless steel is made possible by internal lubrication.

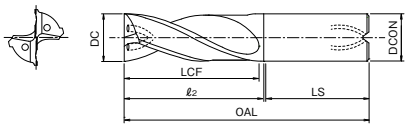
涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
Drills may have some discoloration, but it does not cause any performance problems.

CARBIDE | EgiAs | h8 | SHRINK FIT | 约20° ABOUT20°

Type 1



Type 2



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FROM 直径 DC 11.2～14.4

单位:mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3334436	**14.5**	64	110	16	42.2	65	1	●	221
3334437	**14.6**				42.4			●	221
3334438	**14.7**				42.6			●	223
3334439	**14.8**				42.8			●	224
3334440	**14.9**				42.9			●	226
3334441	**15**				43.1			●	227
3334442	**15.1**	68	115		44.3	69		●	235
3334443	**15.2**				44.5			●	239
3334444	**15.3**				44.7			●	240
3334445	**15.4**				44.9			●	241
3334446	**15.5**				45.1			●	242
3334447	**15.6**				45.3			●	244

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	形状 Type	库存 Stock	重量 (g)
3334448	**15.7**	68	115	16	45.4	69	1	●	246
3334449	**15.8**				45.6			●	246
3334450	**15.9**				45.8			●	248
3334451	**16**				46		2	●	249
3334452	**16.5**	74	125	18	47.2	75	1	●	320
3334453	**17**				48.1			●	329
3334454	**17.5**	78	130		50.1	79		●	348
3334455	**18**				51		2	●	359
3334456	**18.5**	84	135	20	47.2	85	1	●	416
3334457	**19**				48.1			●	430
3334458	**19.5**	88	140		50.1	89		●	455
3334459	**20**				51		2	●	465

库存记号 Inventory symbols

●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

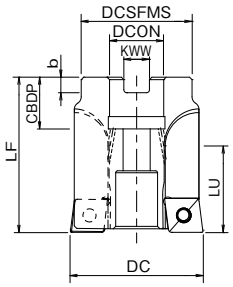
■标识说明请参考P.1。 See p.1 for explanation of icons.

G-LIST No. | FL1089

沉孔钻头 刀盘型
COUNTERBORING CUTTER BORE TYPE

PZAG BORE

切削条件 Cutting Conditions | P.455



带内冷油孔 with Coolant Hole

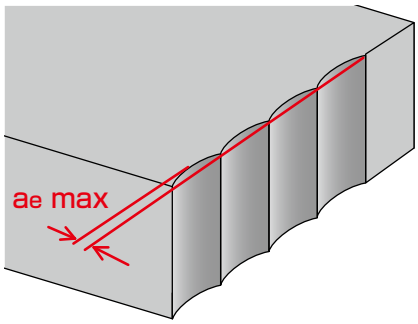
单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	刃数 ZEFP	刀具高度 LF	有效槽长 LU	刀盘径 DCSFMS	孔径 DCON	孔径深度 CBDP	端面键槽 Key Slot 宽度 KWW	端面键槽 Key Slot 深度 b	最小底孔径 Min.Pre-Drilled Dia. 注1)	ae 注2) (max)	适用刀片 Applicable Inserts
7832111	**PZAG13R054M22-4**	54	4	63	35	45	22	21	10.4	6.3	29	12.5	④
7832112	**PZAG13R058M22-4**	58			38						33		
7832113	**PZAG13R062M22-4**	62			41						37		
7832114	**PZAG13R067M22-4**	67			44						42		
7832115	**PZAG13R072M22-4**	72			47						47		
7832116	**PZAG17R076M22-4**	76			50						44	16	⑤
7832117	**PZAG17R082M22-4**	82			54						50		

注1) 表示进行沉孔加工时底孔的最小值。
※ 不可横拉。

These minimum pre-drilled hole sizes are required before counterboring operations.
※ Specialized for plunging.

注2) : 轴向加工时的最大切深量(ae)
Maximum depth of cut in plunge milling



可根据加工孔径定制非标品。详情请咨询我司营业人员 (对应φ14以上)。
Special orders made according to the machined hole diameter are also accepted. Please contact OSG's sales division for details (for items over dia. 14).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
	C~0.25%	C0.25~0.45%	C0.45% ~	SCM	~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	60~70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
PZAG	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	○	○

库存分类全部为● (标准库存品) 。Stock are categorized as ● (Standard stock item) .

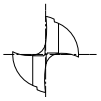
G-LIST No. | CW1007

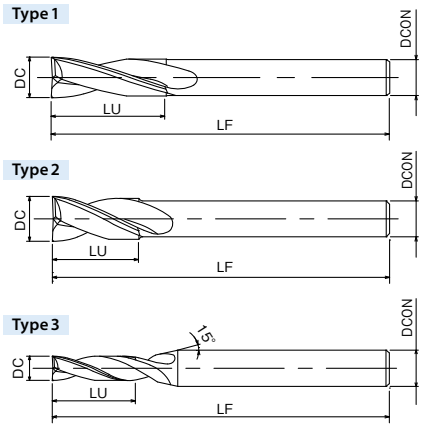
FX 涂层沉孔加工用2刃短刃型

FX COATED·2FLUTES· SHORT· FOR COUNTERBORING

FX-ZDS

切削条件 Cutting Conditions | P.453





CARBIDE | FX | 0～−0.02 | SHRINK FIT | 约20° ABOUT 20°

单位:mm Unit:mm

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8530630	**3**	50	8	6	3	●	18
8530633	**3.3**		10			●	18
8530635	**3.5**					●	18
8530640	**4**		11			●	18
8530642	**4.2**					●	18
8530645	**4.5**					●	19
8530650	**5**	60	13			●	23
8530655	**5.5**					●	23
8530660	**6**				1	●	23
8530665	**6.5**	70	16		2	●	29

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8530668	**6.8**	70	16	6	2	●	29
8530670	**7**					●	29
8530675	**7.5**					●	30
8530680	**8**		19	8	1	●	45
8530685	**8.5**	80			2	●	55
8530690	**9**					●	55
8530695	**9.5**					●	55
8530700	**10**		22	10	1	●	77
8530703	**10.3**	90			2	●	93
8530705	**10.5**					●	94

下一页
外径 DC 11～20 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
FX-ZDS	◎	◎	◎	◎	◎	○	○			◎	◎	◎	◎		○	○		

上一页

FROM 外径 **DC** 3～10.5

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8530710	**11**	90	22	10	2	●	94
8530715	**11.5**					●	96
8530720	**12**		26	12	1	●	125
8530725	**12.5**	100			2	●	142
8530730	**13**					●	145
8530735	**13.5**					●	156
8530740	**14**					●	158
8530745	**14.5**	105				●	170
8530750	**15**					●	170
8530755	**15.5**	115	32			●	188

※不可横拉。

单位:mm Unit:mm

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8530760	**16**	115	32	16	1	●	287
8530765	**16.5**				2	●	289
8530770	**17**					●	292
8530775	**17.5**					●	295
8530780	**18**					●	304
8530785	**18.5**					●	307
8530790	**19**					●	307
8530795	**19.5**	125	38			●	330
8530800	**20**			20	1	●	467

※ Specialized for plunging.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

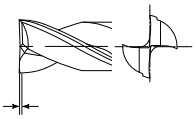
G-LIST No. | **CH1008**

V 涂层 CPM 沉孔加工用 2刃短刃型

V COATED・CPM・2FLUTES・SHORT・FOR COUNTERBORING

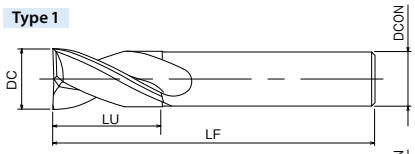
VP-ZDS

切削条件 Cutting Conditions | P.454

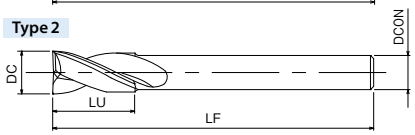


平整度0.05mm以下
Flatness ≦ 0.05mm

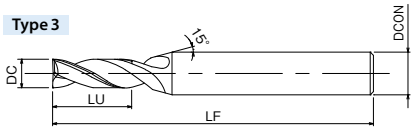
Type 1



Type 2



Type 3



CPM | V | 0～−0.03 | 約25° ABOUT 25°

単位:mm Unit:mm

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8463030	**3**	50	8	6	3	●	13
8463031	**3.1**		10			●	13
8463032	**3.2**					●	13
8463033	**3.3**					●	13
8463034	**3.4**					●	13
8463035	**3.5**					●	13
8463036	**3.6**					●	13
8463037	**3.7**					●	13
8463038	**3.8**		11			●	13
8463039	**3.9**					●	13
8463040	**4**					●	13
8463041	**4.1**					●	13
8463042	**4.2**					●	13
8463043	**4.3**					●	13
8463044	**4.4**					●	13
8463045	**4.5**					●	13
8463046	**4.6**					●	13
8463047	**4.7**					●	13
8463048	**4.8**	60	13			●	15
8463049	**4.9**					●	15
8463050	**5**					●	15
8463051	**5.1**					●	15

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8463052	**5.2**	60	13	6	3	●	16
8463053	**5.3**					●	15
8463054	**5.4**					●	15
8463055	**5.5**					●	16
8463056	**5.6**					●	16
8463057	**5.7**					●	15
8463058	**5.8**					●	16
8463059	**5.9**					●	16
8463060	**6**				1	●	16
8463061	**6.1**	70	16		2	●	18
8463062	**6.2**					●	18
8463063	**6.3**					●	18
8463064	**6.4**					●	18
8463065	**6.5**					●	19
8463066	**6.6**					●	19
8463067	**6.7**					●	19
8463068	**6.8**					●	19
8463069	**6.9**					●	19
8463070	**7**					●	19
8463071	**7.1**					●	19
8463072	**7.2**					●	19
8463073	**7.3**					●	19

下一页
外径 DC 7.4～11.7 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
商品记号 Abbreviation	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
VP-ZDS	◎	◎	◎	◎						◎	◎	◎	◎	○	○	○		

上一页
FROM 外径 DC 3～7.3

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8463074	**7.4**	70	16	6	2	●	19
8463075	**7.5**		19			●	19
8463076	**7.6**					●	19
8463077	**7.7**					●	19
8463078	**7.8**					●	19
8463079	**7.9**					●	19
8463080	**8**			8	1	●	28
8463081	**8.1**	80			2	●	34
8463082	**8.2**					●	34
8463083	**8.3**					●	34
8463084	**8.4**					●	34
8463085	**8.5**					●	34
8463086	**8.6**					●	34
8463087	**8.7**					●	34
8463088	**8.8**					●	35
8463089	**8.9**					●	34
8463090	**9**					●	35
8463091	**9.1**					●	34
8463092	**9.2**					●	35
8463093	**9.3**					●	34
8463094	**9.4**					●	36
8463095	**9.5**					●	36

※不可横拉。

单位:mm Unit:mm

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8463096	**9.6**	80	22	8	2	●	36
8463097	**9.7**					●	36
8463098	**9.8**					●	36
8463099	**9.9**					●	38
8463100	**10**			10	1	●	57
8463101	**10.1**	90			2	●	57
8463102	**10.2**					●	57
8463103	**10.3**					●	58
8463104	**10.4**					●	58
8463105	**10.5**					●	58
8463106	**10.6**					●	59
8463107	**10.7**					●	59
8463108	**10.8**					●	59
8463109	**10.9**					●	62
8463110	**11**					●	60
8463111	**11.1**					●	60
8463112	**11.2**					●	61
8463113	**11.3**					●	61
8463114	**11.4**					●	61
8463115	**11.5**					●	61
8463116	**11.6**					●	61
8463117	**11.7**					●	61

※ Specialized for plunging.

下一页
外径 DC 11.8～20 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

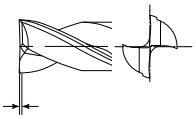
G-LIST No. | CH1008

V 涂层 CPM 沉孔加工用 2刃短刃型

V COATED・CPM・2FLUTES・SHORT・FOR COUNTERBORING

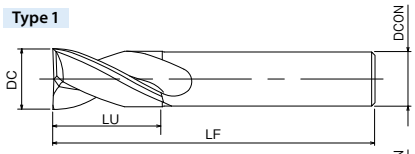
VP-ZDS

切削条件 Cutting Conditions | P.454

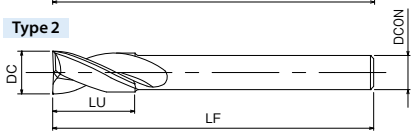


平整度0.05mm以下
Flatness ≦ 0.05mm

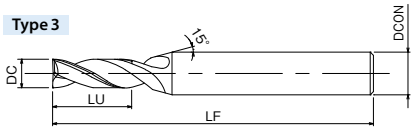
Type 1



Type 2



Type 3



CPM | V | 0～−0.03 | 約25° ABOUT 25°

上一页

FROM 外径 DC 7.4～11.7

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8463118	**11.8**	90	22	10	2	●	61
8463119	**11.9**		26			●	61
8463120	**12**			12	1	●	78
8463125	**12.5**	100			2	●	89
8463130	**13**					●	94
8463135	**13.5**					●	97
8463140	**14**					●	99
8463145	**14.5**	105				●	103
8463150	**15**					●	105
8463155	**15.5**	115	32			●	121

单位:mm Unit:mm

商品号 EDP No.	外径 DC	全长 LF	有效槽长 LU	柄径 DCON	形状 Type	库存 Stock	重量 (g)
8463160	**16**	115	32	16	1	●	181
8463165	**16.5**				2	●	182
8463170	**17**					●	183
8463175	**17.5**					●	184
8463180	**18**					●	187
8463185	**18.5**					●	189
8463190	**19**					●	191
8463195	**19.5**	125	38			●	250
8463200	**20**			20	1	●	288

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
VP-ZDS	◎	◎	◎	◎						◎	◎	◎	◎	○	○	○		

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

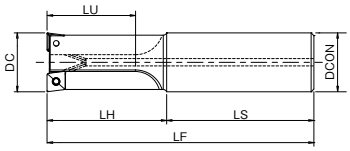
■标识说明请参考P.1。 See p.1 for explanation of icons.

沉孔钻头 直柄型
COUNTERBORING CUTTER WITH STRAIGHT SHANK TYPE

PZAG SS

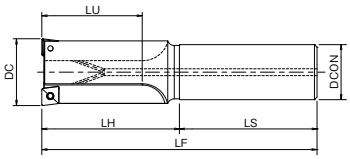
切削条件 Cutting Conditions | P.455

Type 1



带内冷油孔 with Coolant Hole

Type 2



带内冷油孔 with Coolant Hole

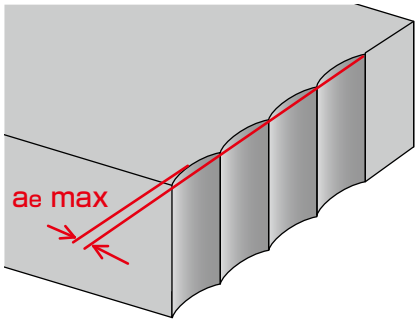
单位:mm Unit:mm

商品号 EDP No.	名称 Designation	外径 DC	刃数 ZEFP	全长 LF	颈长 LH	有效槽长 LU	柄径 DCON	柄长 LS	最小底孔径 Min.Pre-Drilled Dia. 注1)	ae 注2) (max)	适用刀片 Applicable Inserts	形状 Type
7832100	**PZAG04R014SS20-2**	14	2	100	30	21	20	70	6	4	①	1
7832101	**PZAG06R0175SS20-2**	17.5		105	35	26			5.5	6	②	
7832102	**PZAG06R020SS20-2**	20		110	40	30			8			
7832103	**PZAG06R023SS25-2**	23		125	50	34.5	25	75	11			
7832104	**PZAG09R026SS25-2**	26		130	55	39			8	9	③	
7832105	**PZAG09R029SS32-2**	29		140	60	43.5	32	80	11			
7832106	**PZAG09R032SS32-2**	32		145	65	48			14			
7832107	**PZAG09R035SS32-2**	35		150	70	52.5			17			2
7832108	**PZAG09R039SS32-2**	39		160	80	58.5			21			
7832109	**PZAG09R043SS32-2**	43		170	90	64.5			25			
7832110	**PZAG09R048SS32-2**	48		180	100	72			30			

注1) 表示进行沉孔加工时底孔的最小值。
※ 不可横拉。

These minimum pre-drilled hole sizes are required before counterboring operations.
※ Specialized for plunging.

注2)：轴向加工时的最大切深量(ae)
Maximum depth of cut in plunge milling



可根据加工孔径定制非标品。详情请咨询我司营业人员（对应φ14以上）。
Special orders made according to the machined hole diameter are also accepted. Please contact OSG's sales division for details (for items over dia. 14).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel		淬火钢 Quenched and Tempered Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜合金 Copper Alloy	变形铝 Aluminum	铸造铝合金 Aluminum Alloy Casting	钛合金 Titanium Alloy	镍基合金 Inconel
	C～0.25%	C0.25～0.45%	C0.45%～	SCM	～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	60～70 HRC	SUS	SKD SKS	FC	FCD	Cu	AL	AC		
PZAG	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	○	○	○	○	○

库存分类全部为● (标准库存品)。Stock are categorized as ● (Standard stock item) .

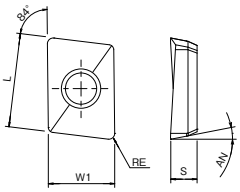
G-LIST No. | FW1006

沉孔钻头
COUNTERBORING CUTTER

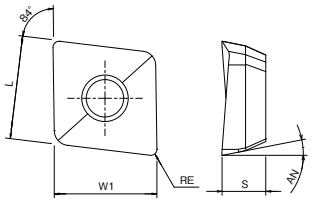
PZAG 适用刀片

切削条件 Cutting Conditions | P.455

Type 1



Type 2



■适用刀片 Inserts

单位:mm Unit:mm

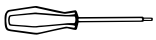
	名称 Designation	切削刃数 No. of Cutting Edges	刀片尺寸 Insert Size L × W1	厚度 S	后角 AN	RE	形状 Type	适用刀体 Applicable Body	涂层种类 Carbide Coated Material XP8030	XC8035
①	ZPNT040104ER	2	6.35× 4.45	1.76	11°	0.4	1	φ 14	7814101	7815101
–	ZPNT050204EN		5.9 × 5.9	2.25		0.4	2	※	7814102	7815102
②	ZPNT060204EN		6.95× 6.95	2.93		0.4	2	φ 17.5 ～ 23	7814103	7815103
–	ZPNT070304EN		7.84× 7.84	3.87		0.4	2	※	7814104	7815104
–	ZPNT080304EN		8.85× 8.85	3.92		0.4	2	※	7814105	7815105
③	ZPNT090404EN		9.94× 9.94	4.65		0.4	2	φ 26 ～ 48	7814106	7815106
–	ZPNT100404EN		10.95 × 10.95	4.65		0.4	2	※	7814107	7815107
	ZPNT100408EN					0.8			7814108	7815108
④	ZPNT130504EN		13.92 × 13.92	5.46		0.4	2	φ 54 ～ 72	7814109	7815109
	ZPNT130508EN					0.8			7814110	7815110
⑤	ZPNT170608EN		17.85 × 17.85	6.31		0.8	2	φ 76, φ 82	7814111	7815111

※=适用刀体为非标品。详情请咨询我司营业人员。
※= applicable body is a special item. Please contact OSG' s sales division for details.

库存分类全部为● (标准库存品)。Stock are categorized as ● (Standard stock item) .

■零件 Accessories

	商品号 EDP No.	名 称 Designation	适用刀片 Applicable Inserts		适用刀体 Applicable Body	推荐安装扭矩 Recommended Tightening Torque
固定螺丝 Clamping Screw	7808096	FS18536P (Torx 6IP)	①	ZPNT04···	PZAG SSϕ14	0.7 N·m
	7808138	FS22550P (Torx 7IP)	②	ZPNT06···	PZAG SS ϕ17.5～23	1.0 N·m
	7808135	FS30570P (Torx 9IP)	③	ZPNT09···	PZAG SS ϕ26～48	2.2 N·m
	7808114	FS45510P (Torx 20IP)	④	ZPNT13···	PZAG BORE ϕ54～82	5.0 N·m
			⑤	ZPNT17···		

	商品号 EDP No.	名 称 Designation	适用刀片 Applicable Inserts		适用刀体 Applicable Body
 扳手 Wrench	7808223	6IP-D (Torx 6IP)	①	ZPNT04···	PZAG SSϕ14
	7808224	7IP-D (Torx 7IP)	②	ZPNT06···	PZAG SS ϕ17.5～23
	7808226	9IP-D (Torx 9IP)	③	ZPNT09···	PZAG SS ϕ26～48
	7808229	20IP-D (Torx 20IP)	④	ZPNT13···	PZAG BORE ϕ54～82
			⑤	ZPNT17···	

扳手需另购。TThe wrenches are sold separately from the cutters.

库存分类全部为● (标准库存品)。Stock are categorized as ● (Standard stock item) .

G-LIST No. | **MW1000**

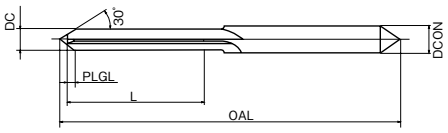
硬质合金直刃铰刀
CARBIDE STRAIGHT REAMER

CRM

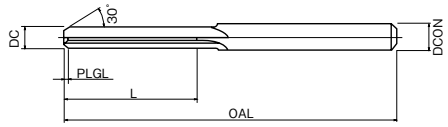
切削条件 Cutting Conditions | **P.456**

CARBIDE | SHANK h6 | 0 ~ + 0.005

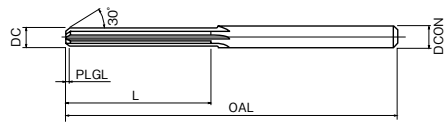
ϕ 0.3 ~ ϕ 3



ϕ 3.01 ~ ϕ 4



ϕ 4.01 ~ ϕ 13.05



单位:mm Unit:mm

商品号 EDP No.	直径 DC	全长 OAL	刃长 L	切削锥长 PLGL	柄径 DCON	刃数 ZEFP	库存 Stock	重量 (g)
8900030	**0.3**	50	4	0.1	2	4	●	5
8900031 ~ 8900039	**0.31 ~ 0.39**						●	5
8900040	**0.4**						●	5
8900041 ~ 8900047	**0.41 ~ 0.47**						●	5
8900048 ~ 8900049	**0.48 ~ 0.49**		5				●	5
8900050	**0.5**						●	5
8900051 ~ 8900053	**0.51 ~ 0.53**						●	5
8900054 ~ 8900059	**0.54 ~ 0.59**		6				●	5
8900060	**0.6**						●	5
8900061 ~ 8900067	**0.61 ~ 0.67**		8				●	5
8900068 ~ 8900069	**0.68 ~ 0.69**		10				●	5
8900070	**0.7**						●	5
8900071 ~ 8900075	**0.71 ~ 0.75**						●	5
8900076 ~ 8900079	**0.76 ~ 0.79**		12				●	5
8900080	**0.8**						●	5
8900081 ~ 8900089	**0.81 ~ 0.89**			0.2			●	5
8900090	**0.9**						●	5
8900091 ~ 8900095	**0.91 ~ 0.95**						●	5
8900096 ~ 8900099	**0.96 ~ 0.99**		14				●	5
8900100	**1**						●	5
8900101 ~ 8900109	**1.01 ~ 1.09**						●	5
8900110	**1.1**						●	5
8900111 ~ 8900118	**1.11 ~ 1.18**						●	5
8900119	**1.19**						●	5
8900120	**1.2**						●	5
8900121 ~ 8900125	**1.21 ~ 1.25**		16				●	5
8900126 ~ 8900129	**1.26 ~ 1.29**						●	5
8900130	**1.3**			0.3			●	5
8900131 ~ 8900139	**1.31 ~ 1.39**						●	5
8900140	**1.4**						●	5
8900141 ~ 8900149	**1.41 ~ 1.49**						●	5
8900150	**1.5**						●	5
8900151 ~ 8900159	**1.51 ~ 1.59**		18				●	5
8900160	**1.6**						●	5
8900161 ~ 8900169	**1.61 ~ 1.69**			0.4			●	5
8900170	**1.7**						●	5
8900171 ~ 8900179	**1.71 ~ 1.79**						●	5
8900180	**1.8**						●	5
8900181 ~ 8900189	**1.81 ~ 1.89**						●	5
8900190	**1.9**						●	5
8900191 ~ 8900199	**1.91 ~ 1.99**		20				●	5
8900200	**2**						●	5
8900201 ~ 8900209	**2.01 ~ 2.09**			0.5	2.5		●	5
8900210	**2.1**						●	5
8900211 ~ 8900219	**2.11 ~ 2.19**						●	5
8900220	**2.2**						●	5
8900221 ~ 8900229	**2.21 ~ 2.29**						●	5
8900230	**2.3**						●	5

下一页
直径 DC 2.31 ~ 5.39 NEXT

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

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

单位:mm Unit:mm

商品号 EDP No.	直径 DC	全长 OAL	刃长 L	切削锥长 PLGL	柄径 DCON	刃数 ZEFP	库存 Stock	重量 (g)
8900231～8900236	**2.31～2.36**	50	20	0.5	2.5	4	●	5
8900237～8900239	**2.37～2.39**		22				●	5
8900240	**2.4**						●	5
8900241～8900249	**2.41～2.49**						●	5
8900250	**2.5**						●	5
8900251～8900259	**2.51～2.59**	60		0.6	3		●	8
8900260	**2.6**						●	8
8900261～8900269	**2.61～2.69**						●	8
8900270	**2.7**						●	8
8900271～8900279	**2.71～2.79**						●	8
8900280	**2.8**						●	8
8900281～8900289	**2.81～2.89**		25				●	8
8900290	**2.9**						●	8
8900291～8900299	**2.91～2.99**						●	8
8900300	**3**						●	8
8900301～8900309	**3.01～3.09**		28		3.5		●	9
8900310	**3.1**						●	9
8900311～8900315	**3.11～3.15**						●	9
8900316～8900319	**3.16～3.19**			0.8			●	9
8900320	**3.2**						●	9
8900321～8900329	**3.21～3.29**						●	9
8900330	**3.3**						●	9
8900331～8900339	**3.31～3.39**						●	9
8900340	**3.4**						●	10
8900341～8900349	**3.41～3.49**						●	10
8900350	**3.5**						●	10
8900351～8900359	**3.51～3.59**	70			4		●	10
8900360	**3.6**						●	13
8900361～8900369	**3.61～3.69**						●	13
8900370	**3.7**						●	13
8900371～8900379	**3.71～3.79**						●	13
8900380	**3.8**						●	13
8900381～8900389	**3.81～3.89**						●	13
8900390	**3.9**						●	13
8900391～8900399	**3.91～3.99**						●	14
8900400	**4**						●	14
8900401～8900409	**4.01～4.09**				4.5	6	●	14
8900410	**4.1**						●	16
8900411～8900419	**4.11～4.19**						●	16
8900420	**4.2**						●	16
8900421～8900429	**4.21～4.29**						●	16
8900430	**4.3**						●	16
8900431～8900439	**4.31～4.39**						●	16
8900440	**4.4**						●	17
8900441～8900449	**4.41～4.49**						●	17
8900450	**4.5**						●	17
8900451～8900459	**4.51～4.59**	80			5		●	25
8900460	**4.6**						●	25
8900461～8900469	**4.61～4.69**						●	25
8900470	**4.7**						●	25
8900471～8900475	**4.71～4.75**						●	25
8900476～8900479	**4.76～4.79**		32				●	25
8900480	**4.8**						●	25
8900481～8900489	**4.81～4.89**						●	25
8900490	**4.9**						●	25
8900491～8900499	**4.91～4.99**						●	25
8900500	**5**						●	25
8900501～8900509	**5.01～5.09**				5.5		●	28
8900510	**5.1**						●	28
8900511～8900519	**5.11～5.19**						●	28
8900520	**5.2**						●	28
8900521～8900529	**5.21～5.29**						●	29
8900530	**5.3**						●	29
8900531～8900539	**5.31～5.39**						●	29

商品号为 8900000 + （直径 ×100）。

Tool No.:8900000 + Mill Dia.×100

下一页
直径 DC 5.4～7.79 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

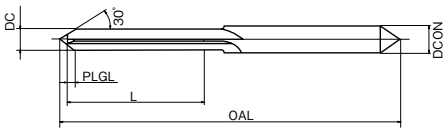
G-LIST No. | MW1000

硬质合金直刃铰刀
CARBIDE STRAIGHT REAMER

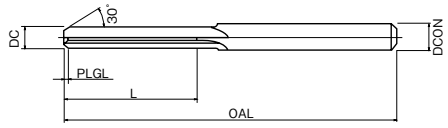
CRM

切削条件 Cutting Conditions | P.456

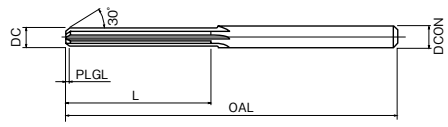
ϕ 0.3 ～ ϕ 3



ϕ 3.01 ～ ϕ 4



ϕ 4.01 ～ ϕ 13.05



CARBIDE | SHANK h6 | 0～+0.005

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FROM 直径 DC 2.31～5.39

单位:mm Unit:mm

商品号 EDP No.	直径 DC	全长 OAL	刃长 L	切削锥长 PLGL	柄径 DCON	刃数 ZEFP	库存 Stock	重量 (g)
8900540	5.4	80	32	0.8	5.5	6	●	29
8900541～8900549	5.41～5.49						●	29
8900550	5.5						●	29
8900551～8900559	5.51～5.59				6		●	33
8900560	5.6						●	33
8900561～8900569	5.61～5.69						●	33
8900570	5.7						●	33
8900571～8900579	5.71～5.79						●	33
8900580	5.8						●	33
8900581～8900589	5.81～5.89						●	33
8900590	5.9						●	33
8900591～8900599	5.91～5.99						●	33
8900600	6						●	34
8900601～8900609	6.01～6.09		35		7		●	40
8900610	6.1						●	40
8900611～8900619	6.11～6.19						●	40
8900620	6.2						●	40
8900621～8900629	6.21～6.29						●	40
8900630	6.3						●	40
8900631～8900639	6.31～6.39						●	41
8900640	6.4						●	41
8900641～8900649	6.41～6.49						●	41
8900650	6.5						●	41
8900651～8900659	6.51～6.59						●	41
8900660	6.6						●	41
8900661～8900669	6.61～6.69						●	42
8900670	6.7						●	42
8900671～8900679	6.71～6.79						●	43
8900680	6.8						●	43
8900681～8900689	6.81～6.89						●	43
8900690	6.9						●	43
8900691～8900699	6.91～6.99						●	43
8900700	7						●	43
8900701～8900709	7.01～7.09	90			8		●	58
8900710	7.1						●	58
8900711～8900719	7.11～7.19						●	58
8900720	7.2						●	58
8900721～8900729	7.21～7.29						●	58
8900730	7.3						●	58
8900731～8900739	7.31～7.39						●	59
8900740	7.4						●	59
8900741～8900749	7.41～7.49						●	59
8900750	7.5						●	59
8900751～8900759	7.51～7.59		40				●	59
8900760	7.6						●	59
8900761～8900769	7.61～7.69						●	59
8900770	7.7						●	59
8900771～8900779	7.71～7.79						●	60

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直径 DC 7.8～10.99 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

单位:mm Unit:mm

商品号 EDP No.	直径 DC	全长 OAL	刃长 L	切削锥长 PLGL	柄径 DCON	刃数 ZEFP	库存 Stock	重量 (g)
8900780	**7.8**	90	40	0.8	8	6	●	60
8900781～8900789	**7.81～7.89**						●	60
8900790	**7.9**						●	60
8900791～8900799	**7.91～7.99**						●	60
8900800	**8**						●	61
8900801～8900809	**8.01～8.09**			1	9		●	73
8900810	**8.1**						●	73
8900811～8900819	**8.11～8.19**						●	73
8900820	**8.2**						●	73
8900821～8900829	**8.21～8.29**						●	73
8900830	**8.3**						●	73
8900831～8900839	**8.31～8.39**						●	74
8900840	**8.4**						●	74
8900841～8900849	**8.41～8.49**						●	74
8900850	**8.5**						●	74
8900851～8900859	**8.51～8.59**						●	75
8900860	**8.6**						●	75
8900861～8900869	**8.61～8.69**						●	75
8900870	**8.7**						●	76
8900871～8900879	**8.71～8.79**						●	76
8900880	**8.8**						●	76
8900881～8900889	**8.81～8.89**						●	76
8900890	**8.9**						●	77
8900891～8900899	**8.91～8.99**						●	78
8900900	**9**						●	78
8900901～8900909	**9.01～9.09**	100			10		●	100
8900910	**9.1**						●	100
8900911～8900919	**9.11～9.19**						●	100
8900920	**9.2**						●	100
8900921～8900929	**9.21～9.29**						●	100
8900930	**9.3**						●	100
8900931～8900939	**9.31～9.39**						●	101
8900940	**9.4**						●	101
8900941～8900949	**9.41～9.49**						●	102
8900950	**9.5**						●	102
8900951～8900959	**9.51～9.59**		45				●	102
8900960	**9.6**						●	102
8900961～8900969	**9.61～9.69**						●	102
8900970	**9.7**						●	102
8900971～8900979	**9.71～9.79**						●	102
8900980	**9.8**						●	102
8900981～8900989	**9.81～9.89**						●	104
8900990	**9.9**						●	104
8900991～8900999	**9.91～9.99**						●	104
8901000	**10**						●	104
8901001～8901009	**10.01～10.09**				11		●	106
8901010	**10.1**						●	106
8901011～8901019	**10.11～10.19**						●	117
8901020	**10.2**						●	117
8901021～8901029	**10.21～10.29**						●	120
8901030	**10.3**						●	120
8901031～8901039	**10.31～10.39**						●	120
8901040	**10.4**						●	120
8901041～8901049	**10.41～10.49**						●	120
8901050	**10.5**						●	120
8901051～8901059	**10.51～10.59**						●	120
8901060	**10.6**						●	120
8901061～8901069	**10.61～10.69**						●	120
8901070	**10.7**						●	120
8901071～8901079	**10.71～10.79**						●	123
8901080	**10.8**						●	123
8901081～8901089	**10.81～10.89**						●	123
8901090	**10.9**						●	123
8901091～8901099	**10.91～10.99**						●	123

商品号为 8900000 + （直径 ×100）。

Tool No.:8900000 + Mill Dia.×100

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直径 DC 11～13.05 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | MW1000

硬质合金直刃铰刀
CARBIDE STRAIGHT REAMER

CRM

切削条件 Cutting Conditions | P.456

CARBIDE | 0～+0.005 | SHANK h6

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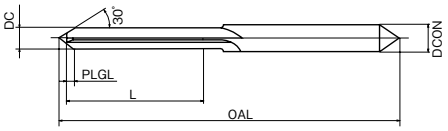
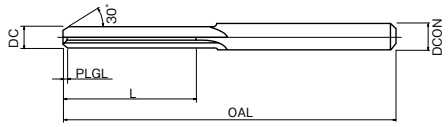
FROM 直径 DC 7.8～10.99

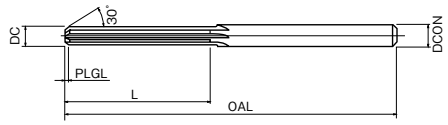
ϕ 0.3～ϕ 3



ϕ 3.01～ϕ 4



ϕ 4.01～ϕ 13.05



单位:mm Unit:mm

商品号 EDP No.	直径 DC	全长 OAL	刃长 L	切削锥长 PLGL	柄径 DCON	刃数 ZEFP	库存 Stock	重量 (g)
8901100	**11**	100	45	1	11	6	●	123
8901101～8901109	**11.01～11.09**	110			12		●	154
8901110	**11.1**						●	154
8901111～8901119	**11.11～11.19**						●	154
8901120	**11.2**						●	154
8901121～8901129	**11.21～11.29**						●	155
8901130	**11.3**						●	155
8901131～8901139	**11.31～11.39**						●	155
8901140	**11.4**						●	155
8901141～8901149	**11.41～11.49**						●	155
8901150	**11.5**						●	155
8901151～8901159	**11.51～11.59**						●	155
8901160	**11.6**						●	155
8901161～8901169	**11.61～11.69**						●	155
8901170	**11.7**						●	155
8901171～8901179	**11.71～11.79**						●	161
8901180	**11.8**						●	161
8901181～8901189	**11.81～11.89**		50				●	161
8901190	**11.9**						●	161
8901191～8901199	**11.91～11.99**						●	161
8901200	**12**						●	161
8901201～8901300	**12.01～13**				13		●	185
8901301～8901305	**13.01～13.05**				14		●	210

商品号为 8900000 + （直径 ×100）。

Tool No.:8900000 + Mill Dia.×100

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

铰刀的特殊品制作事例
REAMER SPECIALLY MADE UPON REQEST

硬质合金螺旋槽铰刀（锥柄）
CARBIDE HELICAL REAMER（TAPER SHANK TYPE）

硬质合金螺旋槽铰刀（直柄）
CARBIDE HELICAL REAMER（STRAIGHT SHANK TYPE）

钻头的加工条件 CUTTING CONDITIONS

基本切削条件 Cutting Conditions

$$n = \frac{1{,}000 \cdot Vc}{\pi \cdot DC}$$

$$Vc = \frac{\pi \cdot DC \cdot n}{1{,}000}$$

$$Vf = f \cdot n$$

Vc : 切削速度 Cutting Speed (m/min)
Vf : 进给速度 Feed (mm/min)
DC : 钻头直径 Drill Dia. (mm)
n : 转速 Speed (min^{-1})
π : 圆周率 Circumference Ratio
f : 每转进给量 Feed per Revolution (mm/rev)

若想得到良好的加工结果，工具寿命和加工效率的判定极为重要，在这里，对于如何提高加工效率进行简单说明。
钻头的加工效率用进给量 F(mm/min) 来表示，一般来说，对于高速钢钻头的寿命，与每转进给量相比，主轴转速的影响更大，因此提高进给量是提高加工效率的有效手段。
但是若过分提高进给量，切屑则会变得很厚，因此通过试切削找出最佳进给量是很重要的。

硬质合金钻头由于在切削刃上有负倒角，较高速钢钻头其进给量的选择范围狭窄，但是，由于它的耐热性能较好，可以提高切削速度，即主轴转速的方式来提高加工效率。

For excellent results, it is best to follow established criterion for maximizing tool efficiency. Feed per table, expressed as F (mm/min), shows the drills' cutting efficiency. Although the spindle speed significantly influences the life of HSS drills, feed rate does not. Therefore, increasing feed rate will help improve cutting efficiency. However, if feed rate is too high, chips may end up being too thick. Users should be careful to find the appropriate feed rate for their particular operation.

The range of appropriate feed rates for carbide alloy drills is smaller than that of HSS drills because carbide alloy drills have negative chamfered cutting edge. If a feed rate outside the recommended range is used, tool life declines considerably. Carbide alloy drills, however, have higher heat resistance than HSS tools. Also, cutting efficiency can be improved by using a higher cutting speed (i.e. increasing the number of revolutions per minute).

槽长的设定 Flute Length

钻头的槽长、切削速度、进给量和切削油剂的选择会直接影响工具的寿命。在考虑到加工孔深、导向套长、再研磨长度的前提下，请尽量将钻头槽长设定在最短。这是因为槽长越长刚性越差，从而影响到螺旋，晃动度及装夹精度，产生不稳定的切削情况，适中的槽长，请参考以下数字。

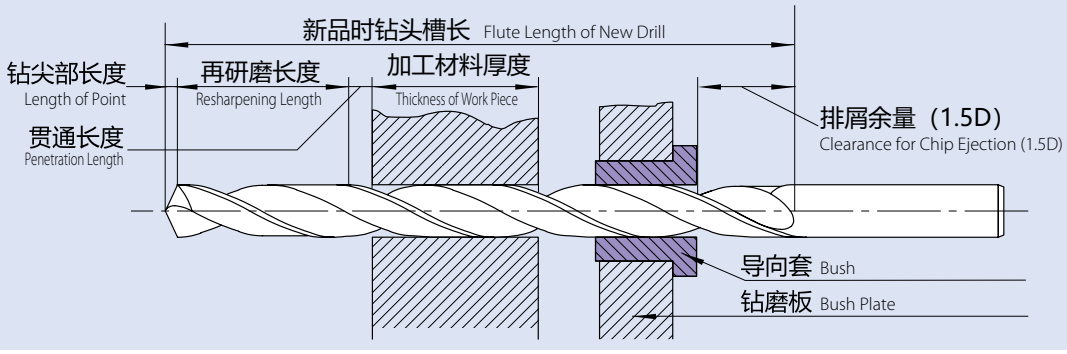
Similar to cutting speed, feed and cutting fluid, flute length is a critical determinant of tool life. Considering drilling depth, bush and resharpening requirements, flute length should usually be as short as possible. Unnecessarily long flute length can cause instability because of lower rigidity and possible twisting or/and deflection (depending on the holder). For most operations, suitable flute length can be calculated by using the following formula.

孔深（导向套间隔，含导向套）+1.5xD（钻头直径）+ 再研磨长度 + 贯通长度

Depth of Hole* + 1.5× DC** + Resharpening Length + Penetration Length

*[Includes bush length and distance between bush and work piece.]

**[D = Drill Diameter]



钻头的加工条件 CUTTING CONDITIONS

根据加工材料的不同推荐不同的切削油剂 Recommended Cutting Fluid Selection Table-Based on Work Material

工具 Tool	涂层高速钢钻头 Coated HSS Drill						涂层硬质合金钻头 Coated Carbide Drill			
冷却方式 Type of Supply	湿 式 Wet				干 式 Dry		湿 式 Wet			
冷却剂 Type of Cutting Fluid	油性 Non Water Soluble	水溶性 Water Soluble			干 式 Dry	半 干 式 Semi Dry	油性 Non Water Soluble	水溶性 Water Soluble		
加工材料 Work Material	JIS N种 (JIS N)	JIS A1 乳化液 Emulsion (JIS A-1)	JIS A2 可溶型 Soluble (JIS A-2)	JIS A3 可溶型 Solution(JIS A-3)	气冷式 Air Blow	油雾式 Mist	JIS N种 (JIS N)	JIS A1 乳化液 Emulsion (JIS A-1)	JIS A2 可溶型 Soluble (JIS A-2)	
碳素钢 Carbon Steels		○			○	○		○		
铸铁 Cast Iron		○	○		○	○		○	○	
高硬度钢 High Hardened Steels		○				○		○		
不锈钢 Stainless Steels		○			×	○		○		
钛合金 Titanium Alloy		○			×			○		
超耐热合金 (Inconel 等) Heat Resistant Alloy (ex. Inconel)		○			×			○		
铝合金 Aluminum Alloy		○	○					○	○	
铜 Copper	○						○			

钻头的加工条件 CUTTING CONDITIONS

	涂层硬质合金钻头 Coated Carbide Drill			金刚石涂层硬质合金钻头 Diamond Coated Carbide Drill					
	湿 式 Wet	干 式 Dry		湿 式 Wet				干 式 Dry	
	水溶性 Water Soluble	干 式 Dry	半 干 式 Semi Dry	油性 Non Water Soluble	水溶性 Water Soluble			干 式 Dry	半 干 式 Semi Dry
	JIS A3 可溶型 Solution(JIS A-3)	气冷式 Air Blow	油雾式 Mist	JIS N种 (JIS N)	JIS A1 乳化液 Emulsion (JIS A-1)	JIS A2 可溶型 Soluble (JIS A-2)	JIS A3 可溶型 Solution(JIS A-3)	气冷式 Air Blow	油雾式 Mist
		○	○		×	×	×	×	×
		○	○					×	×
			○		×	×	×	×	×
					×	×	×	×	×
		×			×	×	×	×	×
					×	×	×	×	×
					○	○		×	○
		×		○				×	○

难切削材料的孔加工 DRILLING DIFFICULT TO MACHINE MATERIALS

所谓难切削材料就如下所示具有不同种材料特性所组合，为此加工难度非常高，切削材料上钻孔，不仅要把握其特性，选择适当的工具，还需参考下面的注意事项，寻找出合适的切削条件。

Certain materials have special characteristics (listed below), that make drilling difficult. In order to successfully drill these materials, it is critical to use proper cutting conditions based on information about the material and the tool, and to understand how variations of these characteristics can influence the final outcome.

■难切削材料的特性 Characteristics of Difficult to Machine Materials

材料特性 Characteristics	对加工时的影响 Effect(s)
①高硬度 High hardness	切削刃的崩损 Chipping of the cutting edge
②高强度 High tensile strength	刀具的磨损 Tool wear
③热传导率小 Low heat conductivity	刀具切削热集中 High temperature at cutting edge
④加工硬化性大 High work hardening	扭矩、阻力大 High thrust force and torque
⑤含有高硬度粒子 Contains hardened grain	易引起切屑问题 Chip trouble (discharging, shape)
⑥延伸性大 High ductility	加工表面质量差 Bad surface finish
⑦亲和性大 High affinity	

难切削材料的孔加工 DRILLING DIFFICULT TO MACHINE MATERIALS

■具有代表性的难切削材料的加工注意事项 Machining Recommendations for Difficult to Machine Materials

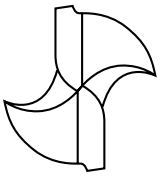
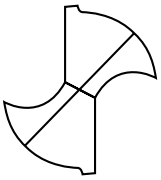
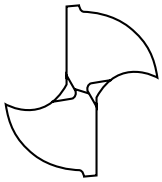
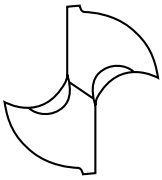
加工材料 Work Material	材料特性 Characteristics	加工建议 Machining Recommendations	推荐钻头 Recommended drills
奥氏体系不锈钢 Austenitic Stainless Steel SUS304、SUS316	●加工硬质大 ●高温强度大 ●热传导率小 ●易延展，易生成刀瘤 ●High work hardening ●High tensile strength at high temperatures ●Low heat conductivity ●High ductility. Easy to get build up at the edge. => chipping	●应选用高韧性的工具及切削刀刃锋利的涂层工具。 ●加快进给速度 ●充分供给切削油剂 ●Use tough drill material with sharp cutting edge and coating ●High feed rate ●High coolant supply	ADO-3D ADO-5D FTO-GDS EX-SUS-GDS EX-SUS-GDR VP-HO-GDS EX-HO-GDR FTO-GDN NEXUS-GDS NEXUS-GDR EX-SUS-GDN MT-SUS-GDR VP-HO-GDR
模具钢 Die Steel SKD11	●含有大而硬的碳化物 ●Made of hard carbide grain (under 0.4%C =>carbide grain is melted)	●应选用高刚性高速工具 ●降低传速，加快进给速度 ●Use high rigid HSS coated tools ●Use lower cutting speed and higher feed rate	FTO-GDS AD-2D AD-4D EX-GDS EX-GDN FTO-GDN ADO-3D ADO-5D VPH-GDS EX-GDR
高锰钢 High Manganese Steel SCMnH	●强度高，强韧性 ●加工硬化性大 ●High tensile strength and high toughness High work hardening	●提高工具和机械的刚性，固定夹具 ●Use rigid tools, machine and work clamping device	AD-2D AD-4D VP-HO-GDS EX-GDS VPH-GDS FTO-GDS
钛合金 Titanium Alloy Ti-6Al-4V	●强度高 ●热传导率小 ●与工具的化学亲和力高 ●High tensile strength per Lower case ●Low heat conductivity ●Chemically active High affinity with tools	●充分冷却，低速控制发热 ●Use sufficient coolant and low cutting speed to maintain low cutting temperature.	FTO-GDS VP-HO-GDS EX-SUS-GDS EX-GDR ADO-3D ADO-5D FTO-GDN VP-HO-GDR EX-HO-GDR
耐热合金 Heat Resistant Alloy Inconel、Hastelloy	●高硬度 ●韧性大，加工硬化大 ●High hardness ●High work hardening Tough Diifficult to machine	●提高工具和机械的刚性 ●使用有刚性的超短刃涂层工具 ●Improve rigidity of tools and machines ●Use an Stub Drill with coating and rigidity	FTO-GDS FT-GDS VPH-GDS ADO-3D ADO-5D FTO-GDN FT-GDN EX-GDS
高硬度淬火钢 High Hardened Quenched and Tempered Steels	●高硬度剪断应力高，抗切削性大 ●High hardness High shearing stress High cutting resistance	●请选用高硬度的工具和高刚性的工具 ●Use a drill made from high hardened and rigid materialif the work material is over 45 HRC, use a carbide drill.	FH-GDS FHL-GDTS SH-DRL AD-2D AD-4D FH-GDN VPH-GDS FTO-M-GDXL FTO-H-GDXL
高硅铝合金 High Silicon Aluminum Alloy AC9A、A390	●含有高硬度粒子，易引起强烈工具磨损 ●High hardened grain causes large wear on tools	●请选用高硬度的工具 ●充分供给切削油剂 ●Use a drill made from high hardened material ●Provide sufficient coolant supply	D-GDN PCD-GDN NF-GDN
铁镍钴合金 Kovar Fe-Ni-Co合金	●低热膨胀材料 ●凝着力高易加工 ●Low thermal Expansion material ●Tend to Build-up, but easy to machine	●请选用大螺旋角切削刃锋利的钻头 ●Use high helix and sharp edge drill	WX-MS-GDS EX-SUS-GDS EX-SUS-GDR EX-SUS-GDN NEXUS-GDS NEXUS-GDR
钴铬合金 Co-Cr Alloy	●耐蚀好，韧性好 ●和谐性好 ●Better anti-rust, Better rigidity ●Harmonize with organism	●使用切屑分断性好，耐磨损的钻头 ●Easy to break chips, but recommended to use better drill on wear resistance	FTO-GDN FTO-GDS FT-GDN ADO-3D ADO-5D
复合材料 Composite CFRP GFRP	●内部的硬纤维物质导致强烈磨损 ●易产生细毛和剥离 ●Tough fiber causes extrame wear ●Tend to have naps and peel off	●请使用锋利且耐磨损的工具 ●防止产生毛刺及毛刺剥离的设计要求 ●Use sharp and wear resistant tools ●Design the tool to prevent naps and peeling	D-STAD PCD-CF-GDN

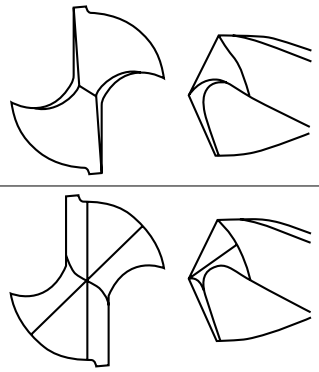
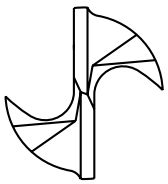
横刃 THINNING

OSG的钻头所使用的横刃及其各自的特点，用途如表1所示。

Table 1 Displays the characteristics and applications for each of OSG's thinning types and drills.

表1: 横刃的种类和功能 Table 1 Characteristics and Effects of Thinning

类型 Type	外观 Design	用途・特征 Characteristics and Applications
R型 R Thinning		●重切削 ●吃入性能好 ●切屑分断 ●减少轴向负荷 ●For heavy drilling ●Good chamfering ●Creates small chips ●Reduces thrust force
X型 X Thinning		●吃入性能好 ●适用于钻芯厚的钻头 ●减少轴向负荷 ●Good chamfering ●For drills with large web diameter ●Reduces thrust force
N型 N Thinning		●适用于钻芯厚和锋角小的钻头 ●容屑槽大 ●钻头尖部强度大 ●For drills with small web diameter and/or with small point angle ●Large chip pocket ●High strength at the point
S型 S Thinning		●适用于钻芯厚和锋角小的钻头 ●钻头尖部强度大 ●再研磨简单 ●For drills with small web diameter and/or with small point angle ●High strength at the point ●Easy to regrind

类型 Type	外观 Design	用途・特征 Characteristics and Applications
W、W+R型 W Thinning, W + R Thinning		●重切削及高硬度材料用 ●切削刃的抗崩对策 ●抑制高硬度材料加工中容易发生的崩刃现象 ●切削刃强度高 ●减少轴向负荷 ●For heavy drilling ●Prevents chipping on cutting edge ●For high hardened materials Prevents chipping that can occus when drilling in high hardened steel materials ●High strength on the cutting edge ●Reduces thrust force
三面倾斜式横刃型 Three-rake Thinning		●刃尖精度好，孔精度高，但不适用于钻芯厚的钻头及高进给速度。 ●Accurate at cutting edge tolerance Better hole size control not good for high feed rate

形状尺寸表 SPECIFICATION CHARTS AD-2D ▶ P.137
形状尺寸表 SPECIFICATION CHARTS AD-4D ▶ P.141

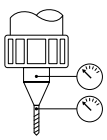
硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

AD-2D·AD-4D

2D·4D用
For 2D, 4D

加工材料 Work Material	软钢·低碳素钢·合金钢 Mild steel Low Carbon Steel Alloy Steel (C<0.3%) SS400·SCM ～710N/㎟		碳素钢 Carbon Steel S35C·S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM·SCr·SNCM 16～28HRC 710～900N/㎟		合金钢 Alloy Steel SCM·SCr·SNCM 28～35HRC 900～1,100N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400～600N/㎟	
切削速度 Cutting Speed	70～120m/min		60～120m/min		60～120m/min		50～90m/min		60～120m/min		50～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	12,000	0.06～0.08	10,400	0.06～0.08	10,400	0.06～0.08	8,800	0.06～0.08	10,400	0.06～0.08	9,600	0.06～0.08
4	8,000	0.08～0.16	7,200	0.08～0.16	7,200	0.08～0.16	5,600	0.08～0.16	7,200	0.08～0.16	6,000	0.08～0.16
6	5,300	0.12～0.24	4,800	0.12～0.24	4,800	0.12～0.24	3,700	0.12～0.24	4,800	0.12～0.24	4,000	0.12～0.24
8	4,000	0.16～0.28	3,600	0.16～0.28	3,600	0.16～0.28	2,800	0.16～0.28	3,600	0.16～0.28	3,000	0.16～0.28
10	3,200	0.2 ～0.3	2,900	0.2 ～0.3	2,900	0.2 ～0.3	2,200	0.2 ～0.3	2,900	0.2 ～0.3	2,400	0.2 ～0.3
12	2,700	0.21～0.3	2,400	0.21～0.3	2,400	0.21～0.3	1,900	0.21～0.3	2,400	0.21～0.3	2,000	0.21～0.3
14	2,300	0.22～0.35	2,050	0.22～0.35	2,050	0.22～0.35	1,400	0.22～0.35	2,050	0.22～0.35	1,700	0.22～0.35
16	2,000	0.25～0.36	1,800	0.25～0.36	1,800	0.25～0.36	1,200	0.25～0.36	1,800	0.25～0.36	1,500	0.25～0.36
18	1,800	0.28～0.38	1,600	0.28～0.38	1,600	0.28～0.38	1,050	0.28～0.38	1,600	0.28～0.38	1,350	0.28～0.38
20	1,600	0.3 ～0.4	1,450	0.3 ～0.4	1,450	0.3 ～0.4	950	0.3 ～0.4	1,450	0.3 ～0.4	1,200	0.3 ～0.4

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，切削速度请下调30%。
4. 此切削条件基准表适用于孔深在3D 以下的情况。
5. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
6. 请保持加工材料在不变形、不弯曲、不振动的状态下。
7. 机器转数无法达到上述切削速度时，请尽可能使用高转速。另外，此情况可能会导致寿命降低。



1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. Water-soluble high density coolant (less than 20 times dilution) is recommended.
3. When using non-water-soluble or water-soluble (over 20 times dilution), reduce cutting speed by 30%.
4. These conditions are for drilling depth under 3 times the drill diameter.
5. Equip the drill with a scratch- and dust-free collet and minimize drill deflection to less than 0.02mm.
6. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
7. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible. Tool life may be decreased.

形状尺寸表 SPECIFICATION CHARTS ADO-MICRO 2D ▶ P.144
形状尺寸表 SPECIFICATION CHARTS ADO-MICRO 5D ▶ P.145

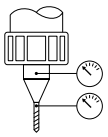
硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

ADO-MICRO 2D・5D

加工材料 Work Material	软钢・低碳素钢 Mild Steel Low Carbon Steel SS400・S10C ～150HB ～500N/㎟		碳素钢 Carbon Steel S35C・S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM・SCr・SNCM 16～28HRC 710～900N/㎟		合金钢 Alloy Steel SCM・SCr・SNCM 28～35HRC 900～1,100N/㎟		奥氏体不锈钢 Austenitic Stainless Steel SUS303・SUS304 SUS316・SUS316L		特殊钢 Special Alloy Steel SUJ2・SUS440	
切削速度 Cutting Speed	20～40～60m/min		20～40～60m/min		20～40～60m/min		20～30～40m/min		20～30～70m/min		25～35～45m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
0.7	18,200	0.007～0.021	18,200	0.007～0.021	18,200	0.014～0.028	13,600	0.014～0.028	13,600	0.007～0.021	15,900	0.007～0.021
1	12,700	0.01 ～0.03	12,700	0.01 ～0.03	12,700	0.02 ～0.04	9,500	0.02 ～0.04	9,500	0.01 ～0.03	11,100	0.01 ～0.03
1.5	8,500	0.015～0.045	8,500	0.015～0.045	8,500	0.03 ～0.06	6,400	0.03 ～0.06	6,400	0.015～0.045	7,400	0.015～0.045
2	6,400	0.02 ～0.06	6,400	0.02 ～0.06	6,400	0.04 ～0.08	4,800	0.04 ～0.08	4,800	0.02 ～0.06	5,600	0.02 ～0.06

加工材料 Work Material	铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD450・FCD600 400～600N/㎟		铸造铝合金 Aluminum Alloy AC4C・ADC		变形铝 Aluminum A5052・A7075		钛合金 Titanium Alloy		耐热合金 Heat Resistant Alloy Inconel 718	
切削速度 Cutting Speed	40～50～60m/min		30～40～50m/min		30～50～70m/min		20～40～60m/min		40～50～60m/min		5～10～15m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
0.7	22,700	0.014～0.028	18,200	0.014～0.028	22,700	0.014～0.042	18,200	0.007～0.021	22,700	0.011～0.018	4,500	0.004～0.014
1	15,900	0.02 ～0.04	12,700	0.02 ～0.04	15,900	0.02 ～0.06	12,700	0.01 ～0.03	15,900	0.015～0.025	3,200	0.005～0.02
1.5	10,600	0.03 ～0.06	8,500	0.03 ～0.06	10,600	0.03 ～0.09	8,500	0.015～0.045	10,600	0.023～0.038	2,100	0.008～0.03
2	8,000	0.04 ～0.08	6,400	0.04 ～0.08	8,000	0.04 ～0.12	6,400	0.02 ～0.06	8,000	0.03 ～0.05	1,600	0.01 ～0.04

1. 此切削条件基准表是水溶性切削油剂及内部供油的情况下使用的。
2. 请使用稀释倍率20倍的优质水溶性切削油剂。
3. 为了防止油孔堵塞，请使用精密过滤器。(参考值3μm ～5μm)
4. 推荐内冷压力为3MPa，但根据所使用的切削油剂种类・浓度，喷油不充分的情况下请调整压力。
5. 安装时的振动精度如右图所示，刀体圆筒部分或刀柄端请以0.002mm 以下为标准。
6. 排屑难的加工材料，请适当进行阶梯式加工。
7. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。另外，请注意切屑的处理。可能会引起火灾。



1. This cutting condition chart is based on the usage of water-soluble coolant and internal oil supply.
2. Please use quality water-soluble coolant with a dilution factor of approximately 20 times.
3. Please use a precision filter (approximation of 3μm to 5μm) to prevent the oil holes from clogging.
4. Although the recommended coolant pressure is 3 MPa or more, please adjust accordingly if the level of flow volume is unsatisfactory due to the type and concentration of cutting oil used.
5. For accurate mounting, acceptable deflection of the body cylindrical part at the shank end should be less than 0.002mm, as shown in the illustrated figure.
6. For work material with poor chip evacuation characteristic, please perform step drilling as required.
7. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.

形状尺寸表 SPECIFICATION CHARTS ADO-MICRO 12D ▶ P.146
形状尺寸表 SPECIFICATION CHARTS ADO-MICRO 20D ▶ P.147
形状尺寸表 SPECIFICATION CHARTS ADO-MICRO 30D ▶ P.148

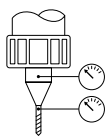
硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

ADO-MICRO 12D・20D・30D

加工材料 Work Material	软钢・低碳素钢 Mild Steel Low Carbon Steel SS400・S10C ～150HB ～500N/mm²		碳素钢 Carbon Steel S35C・S50C ～210HB ～710N/mm²		合金钢 Alloy Steel SCM・SCr・SNCM 16～28HRC 710～900N/mm²		合金钢 Alloy Steel SCM・SCr・SNCM 28～35HRC 900～1,100N/mm²		奥氏体不锈钢 Austenitic Stainless Steel SUS303・SUS304 SUS316・SUS316L		特殊钢 Special Alloy Steel SUJ2・SUS440	
切削速度 Cutting Speed	20～40～60m/min		20～40～60m/min		20～40～60m/min		20～30～40m/min		20～30～70m/min		25～35～45m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
1	12,700	0.01 ～0.03	12,700	0.01 ～0.03	12,700	0.02 ～0.04	9,500	0.02 ～0.04	9,500	0.01 ～0.03	11,100	0.01 ～0.03
1.5	8,500	0.015～0.045	8,500	0.015～0.045	8,500	0.03 ～0.06	6,400	0.03 ～0.06	6,400	0.015～0.045	7,400	0.015～0.045
2	6,400	0.02 ～0.06	6,400	0.02 ～0.06	6,400	0.04 ～0.08	4,800	0.04 ～0.08	4,800	0.02 ～0.06	5,600	0.02 ～0.06

加工材料 Work Material	铸铁 Cast Iron FC250 ～350N/mm²		球墨铸铁 Ductile Cast Iron FCD450・FCD600 400～600N/mm²		铸造铝合金 Aluminum Alloy AC4C・ADC		变形铝 Aluminum A5052・A7075		钛合金 Titanium Alloy		耐热合金 Heat Resistant Alloy Inconel 718	
切削速度 Cutting Speed	40～50～60m/min		30～40～50m/min		30～50～70m/min		20～40～60m/min		40～50～60m/min		5～10～15m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
1	15,900	0.02 ～0.04	12,700	0.02 ～0.04	15,900	0.02 ～0.06	12,700	0.01 ～0.03	15,900	0.015～0.025	3,200	0.005～0.02
1.5	10,600	0.03 ～0.06	8,500	0.03 ～0.06	10,600	0.03 ～0.09	8,500	0.015～0.045	10,600	0.023～0.038	2,100	0.008～0.03
2	8,000	0.04 ～0.08	6,400	0.04 ～0.08	8,000	0.04 ～0.12	6,400	0.02 ～0.06	8,000	0.03 ～0.05	1,600	0.01 ～0.04

1. 此切削条件基准表是水溶性切削油剂及内部供油的情况下使用的。
2. 请使用稀释倍率20倍的优质水溶性切削油剂。
3. 为了防止油孔堵塞，请使用精密过滤器。(参考值3μ m～5μm)
4. 推荐内冷压力为3MPa，但根据所使用的切削油剂种类・浓度，喷油不充分的情况下请调整压力。
5. 安装时的振动精度如右图所示，刀体圆筒部分或刀柄端请以0.002mm 以下为标准。
6. 排屑难的加工材料，请适当进行阶梯式加工。
7. 使用12D 型以上的钻头进行加工前，请先用2D 型钻头进行底孔加工。
8. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。另外，请注意切屑的处理。可能会引起火灾。

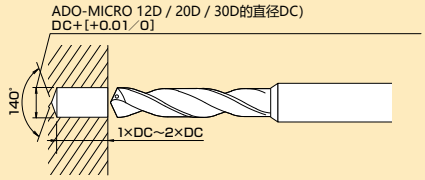


1. This cutting condition chart is based on the usage of water-soluble coolant and internal oil supply.
2. Please use quality water-soluble coolant with a dilution factor of approximately 20 times.
3. Please use a precision filter (approximation of 3μm to 5μm) to prevent the oil holes from clogging.
4. Although the recommended coolant pressure is 3 MPa or more, please adjust accordingly if the level of flow volume is unsatisfactory due to the type and concentration of cutting oil used.
5. For accurate mounting, acceptable deflection of the body cylindrical part at the shank end should be less than 0.002mm, as shown in the illustrated figure.
6. For work material with poor chip evacuation characteristic, please perform step drilling as required.
7. For holes from 12D and above, please use a 2D type drill to prepare a pilot hole prior to processing.
8. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.

■ ADO-MICRO 12D/20D/30D的推荐加工方法
Recommended operation for using ADO-MICRO 12D/20D/30D

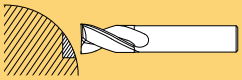
①使用ADO-MICRO 2D 进行导向孔加工
Make a pilot hole with the ADO-MICRO 2D.

推荐使用ADO-MICRO 2D（先端角140°）
作为ADO-MICRO 12D / 20D / 30D 的导向孔加工用刀具
The ADO-MICRO 2D (140°point angle) is the recommended pilot hole drills of the ADO-MICRO 12D/20D/30D.



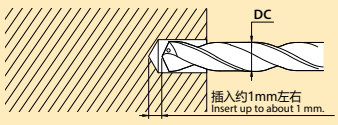
★弯曲部加工时，在导向孔加工前请先用FX-ZDS沉孔加工铣刀或ADF硬质合金平头钻进行沉孔加工。

When working on a curved surface, use the FX-ZDS (end mill for counterboring) or the ADF (carbide flat drill) to counterbore a flat surface before drilling a pilot hole.



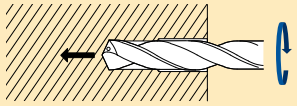
②长刃型钻头以转速（n）=300~500min⁻¹左右，进给速度（Vf）=300~500mm/min插入

Insert the long drill at a speed of (n) = 300 to 500 min⁻¹ and a feed rate of (Vf) = 300 to 500 mm/min.



③加速至规定转速后开始加工

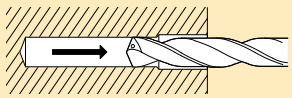
Increase the revolution to the designated speed and start drilling.



加工通孔时，请在拔出时降低进给量至（f）=0.05～0.1mm/rev.
When drilling through holes, reduce the feed rate to (f) 0.05 to 0.1 mm/rev.

④加工后，拔出钻头时，请降低转速至(n)=300～500min⁻¹・进给速度(Vf)=1,000 ～3,000mm/min左右拔出

After drilling, reduce the speed to (n) = 300 to 500 min⁻¹ and a feed rate of (Vf) = 1,000 to 3,000 mm/min and pull the drill out of the hole.



※请务必使用内冷方式进行加工
Make sure to use internal coolant supply when drilling.

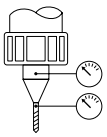
形状尺寸表 SPECIFICATION CHARTS ADO-3D ▶ P.149
形状尺寸表 SPECIFICATION CHARTS ADO-5D ▶ P.153
形状尺寸表 SPECIFICATION CHARTS ADO-8D ▶ P.157

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

ADO-3D・5D・8D

加工材料 Work Material	软钢・低碳素钢 Mild Steel Low Carbon Steel SS400・S10C ～150HB ～500N/mm²		碳素钢 Carbon Steel S35C・S50C ～210HB ～710N/mm²		合金钢 Alloy Steel SCM・SCr・SNCM 16～28HRC 710～900N/mm²		合金钢 Alloy Steel SCM・SCr・SNCM 28～35HRC 900～1,100N/mm²		铸铁 Cast Iron FC250 ～350N/mm²		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400～600N/mm²		不锈钢 Stainless Steel SUS300系 SUS400系 480～800N/mm²		特殊钢・调质钢・预硬钢 Special Alloy Steel・Hardened Steel・Prehardened Steel SKD61 (非调质) (Unquenched) 34～40HRC 1,060～1,250N/mm²	
切削速度 Cutting Speed	80～120m/min		80～160m/min		80～120m/min		60～90m/min		80～120m/min		60～100m/min		40～80m/min		30～60m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	12,700	0.04～0.08	12,700	0.04～0.08	12,700	0.04～0.08	11,100	0.04～0.08	12,700	0.04～0.08	12,700	0.04～0.08	9,500	0.04～0.08	7,200	0.04～0.06
3	10,600	0.06～0.12	10,600	0.06～0.12	10,600	0.06～0.12	7,400	0.06～0.12	10,600	0.06～0.12	8,500	0.06～0.12	6,400	0.06～0.12	4,800	0.06～0.09
4	8,000	0.08～0.16	8,000	0.08～0.16	8,000	0.08～0.16	5,600	0.08～0.16	8,000	0.08～0.16	6,400	0.08～0.16	4,800	0.08～0.16	3,600	0.08～0.12
5	6,400	0.1 ～0.2	6,400	0.1 ～0.2	6,400	0.1 ～0.2	4,500	0.1 ～0.2	6,400	0.1 ～0.2	5,100	0.1 ～0.2	3,800	0.1 ～0.2	2,900	0.1 ～0.15
6	5,300	0.12～0.24	5,300	0.12～0.24	5,300	0.12～0.24	3,700	0.12～0.24	5,300	0.12～0.24	4,200	0.12～0.24	3,200	0.12～0.24	2,400	0.12～0.18
7	4,500	0.14～0.26	4,500	0.14～0.26	4,500	0.14～0.26	3,200	0.14～0.26	4,500	0.14～0.26	3,600	0.14～0.26	2,700	0.14～0.26	2,000	0.14～0.21
8	4,000	0.16～0.28	4,000	0.16～0.28	4,000	0.16～0.28	2,800	0.16～0.28	4,000	0.16～0.28	3,200	0.16～0.28	2,400	0.16～0.28	1,800	0.16～0.24
9	3,500	0.18～0.3	3,500	0.18～0.3	3,500	0.18～0.3	2,500	0.18～0.3	3,500	0.18～0.3	2,800	0.18～0.3	2,100	0.18～0.3	1,600	0.18～0.27
10	3,200	0.2 ～0.3	3,200	0.2 ～0.3	3,200	0.2 ～0.3	2,200	0.2 ～0.3	3,200	0.2 ～0.3	2,500	0.2 ～0.3	1,900	0.2 ～0.3	1,400	0.2 ～0.3
11	2,900	0.2 ～0.3	2,900	0.2 ～0.3	2,900	0.2 ～0.3	2,000	0.2 ～0.3	2,900	0.2 ～0.3	2,300	0.2 ～0.3	1,700	0.2 ～0.3	1,300	0.2 ～0.3
12	2,700	0.21～0.3	2,700	0.21～0.3	2,700	0.21～0.3	1,900	0.21～0.3	2,700	0.21～0.3	2,100	0.21～0.3	1,600	0.21～0.3	1,200	0.21～0.3
14	2,300	0.22～0.35	2,300	0.22～0.35	2,300	0.22～0.35	1,600	0.22～0.35	2,300	0.22～0.35	1,800	0.22～0.35	1,400	0.22～0.35	1,000	0.22～0.35
16	2,000	0.25～0.36	2,000	0.25～0.36	2,000	0.25～0.36	1,400	0.25～0.36	2,000	0.25～0.36	1,600	0.25～0.36	1,200	0.25～0.36	900	0.25～0.36
18	1,800	0.28～0.38	1,800	0.28～0.38	1,800	0.28～0.38	1,200	0.28～0.38	1,800	0.28～0.38	1,400	0.28～0.38	1,100	0.28～0.38	800	0.28～0.38
20	1,600	0.3 ～0.4	1,600	0.3 ～0.4	1,600	0.3 ～0.4	1,100	0.3 ～0.4	1,600	0.3 ～0.4	1,300	0.3 ～0.4	1,000	0.3 ～0.4	700	0.3 ～0.4

1. 此切削条件基准表适用于水溶性切削油剂或油雾式冷却加工。
2. 请使用稀释20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，切削速度请下调30%。
4. 此切削条件基准表适用于孔深在8D 以下的加工。
5. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
6. 请保持加工材料在不变形、不弯曲、不振动的状态下。
7. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。
8. 加工高硬度材料或8D用时，请根据情况进行1D~2D 的阶梯式加工。
9. 根据使用环境，也有可能无法达到高速条件。
10. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。



1. The indicated speeds and feeds are for drilling with water-soluble coolant or MQL.
2. Water-soluble high density coolant (less than 20 times dilution) is recommended.
3. When using non-water-soluble or water-soluble (over 20times dilution), reduce cutting speed by 30%.
4. These conditions are for drilling depth less than 8 times the drill diameter.
5. Equip the drill with a scratch- and dust-free collet and minimize drill deflection to less than 0.02mm.
6. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
7. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.
8. 1D-2D step feeding may be required for drilling high hardened steels and mid-range (8D) work.
9. Depending on actual operation environment, high speed cutting parameters listed above may not be applicable.
10. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.

形状尺寸表 SPECIFICATION CHARTS ADO-10D ▶ P.160
形状尺寸表 SPECIFICATION CHARTS ADO-15D ▶ P.162
形状尺寸表 SPECIFICATION CHARTS ADO-20D ▶ P.164
形状尺寸表 SPECIFICATION CHARTS ADO-25D ▶ P.166
形状尺寸表 SPECIFICATION CHARTS ADO-30D ▶ P.168

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

ADO-10D•15D•20D•25D•30D

加工材料 Work Material	软钢·低碳素钢 Mild Steel Low Carbon Steel SS400·S10C ～150HB ～500N/mm²		碳素钢 Carbon Steel S35C·S50C ～210HB ～710N/mm²		合金钢 Alloy Steel SCM·SCr·SNCM 16～28HRC 710～900N/mm²		合金钢·预硬钢 Alloy Steel·Prehardened Steel (C≧0.3%) SCM440 28～34HRC 900～1,060N/mm²		铸铁 Cast Iron FC250 ～350N/mm²		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400～600N/mm²		不锈钢 Stainless Steel SUS400系 480～800N/mm²		特殊钢·调质钢·预硬钢 Special Alloy Steel·Hardened Steel·Prehardened Steel SKD61 (非调质) (Unquenched) 34～40HRC 1,060～1,250N/mm²	
切削速度 Cutting Speed	60～125m/min		60～125m/min		60～125m/min		50～70m/min		60～125m/min		50～80m/min		40～80m/min		30～50m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed (mm/rev)
3	7,500	0.06～0.12	7,500	0.06～0.12	7,500	0.06～0.12	6,300	0.08～0.11	7,500	0.06～0.12	7,500	0.06～0.12	5,300	0.06～0.12	4,200	0.08～0.11
4	6,400	0.08～0.16	6,400	0.08～0.16	6,400	0.08～0.16	4,700	0.1～0.15	6,400	0.08～0.16	5,600	0.08～0.16	4,400	0.08～0.16	3,100	0.1～0.15
5	5,800	0.1～0.2	5,800	0.1～0.2	5,800	0.1～0.2	3,800	0.12～0.18	5,800	0.1～0.2	4,500	0.1～0.2	3,800	0.1～0.2	2,500	0.12～0.18
6	4,800	0.12～0.24	4,800	0.12～0.24	4,800	0.12～0.24	3,100	0.14～0.2	4,800	0.12～0.24	3,800	0.12～0.24	3,200	0.12～0.24	2,100	0.14～0.2
8	3,600	0.16～0.28	3,600	0.16～0.28	3,600	0.16～0.28	2,300	0.16～0.24	3,600	0.16～0.28	2,800	0.16～0.28	2,400	0.16～0.28	1,500	0.16～0.24
10	2,900	0.2～0.35	2,900	0.2～0.35	2,900	0.2～0.35	1,900	0.18～0.27	2,900	0.2～0.35	2,300	0.2～0.35	1,900	0.2～0.35	1,200	0.18～0.27
12	2,400	0.24～0.42	2,400	0.24～0.42	2,400	0.24～0.42	1,500	0.24～0.3	2,400	0.24～0.42	1,900	0.24～0.42	1,600	0.24～0.42	1,000	0.24～0.3

1. 此切削条件基准表适用于水溶性切削油剂或油雾式冷却加工。(不锈钢加工不推荐MQL)。
2. 请使用稀释倍率在20倍～30倍左右的优质水溶性切削油剂。
3. 使用油性切削油剂时，将切削速度设定在最低值的70% 左右。。
4. 请按照下面的资料"ADO-10D/15D/20D/30D/TRS-HO-10D的推荐加工方法"进行导向孔加工
5. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。
6. 加工高硬度材料时，请进行1D～2D 的阶梯式加工。

1. The indicated speeds and feeds are for drilling with water-soluble coolant or MQL (mist drilling in stainless steels is not recommended).
2. Water-soluble high density coolant (20-30 times dilution) is recommended.
3. When using non-water-soluble coolant, set the cutting speed between 70-100% of the lowest limit.
4. Make a pilot hole before using in accordance with recommended operation.
5. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.
6. Peck drilling of 1D-2D is strongly recommended.

■ ADO-10D/15D/20D/25D/30D/40D/50D/TRS-HO-10D的推荐加工方法

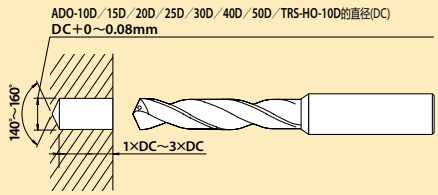
Recommended operation for using ADO-10D/15D/20D/25D/30D/40D/50D/TRS-HO-10D

①使用ADO-3D/5D, ADO-PLT进行导向孔加工

Make a pilot hole with ADO-3D/5D, ADO-PLT.

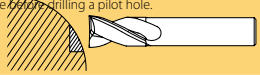
●导向孔加工用工具请选择比ADO-10D/15D/20D/25D/30D/40D/50D/TRS-HO-10D的直径(DC) +0～0.08mm的钻头，推荐在加工时将导向孔尽量加深。

For a pilot hole, select 0～0.08mm larger size drill than ADO-10D／15D／20D／25D／30D／40D／50D／TRS-HO-10D.



★弯曲部加工时，在导向孔加工前请先用FX-ZDS沉孔加工铣刀或ADF 硬质合金平头钻进行如图所示的沉孔加工。

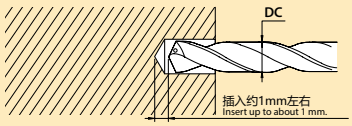
When working on a curved surface, use the FX-ZDS (end mill for counterboring) or the ADF (carbide flat drill) to counterbore a flat surface before drilling a pilot hole.



②长刃钻以转速(n) = 300～500min⁻¹左右，进给速度(Vf) = 300～500mm/min 插入

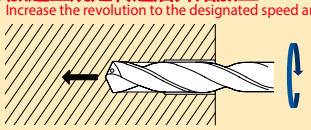
※ADO-40D/50D 为逆转插入

Insert the long drill at a speed of (n) = 300 to 500 min⁻¹ and a feed rate of (Vf) = 300 to 500 mm/min. *Insert the ADO-40D/50D in reverse.



③加速至规定转速后开始加工

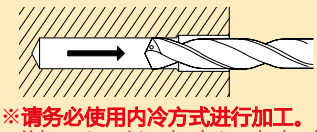
Increase the revolution to the designated speed and start drilling.



加工通孔时，请在拔出时降低进给量至 (f) = 0.05～0.1mm/rev.
When drilling through holes, reduce the feed rate to (f) 0.05 to 0.1 mm/rev.

④加工后，拔出钻头时，请降低转速至(n)=300～500min⁻¹・进给速度(Vf) = 1,000 ～3,000mm/min左右拔出。

After drilling, reduce the speed to (n) = 300 to 500 min⁻¹ and a feed rate of (Vf) = 1,000 to 3,000 mm/min and pull the drill out of the hole.



※请务必使用内冷方式进行加工。

Make sure to use internal coolant supply when drilling.

形状尺寸表 SPECIFICATION CHARTS ADO-40D ▶ P.170
形状尺寸表 SPECIFICATION CHARTS ADO-50D ▶ P.171

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

ADO-40D•50D

加工材料 Work Material	软钢·低碳素钢 Mild Steel Low Carbon Steel SS400・S10C ～150HB ～500N/㎟		碳素钢 Carbon Steel S35C・S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM・SCr・SNCM 16～28HRC 710～900N/㎟		合金钢 Alloy Steel (C≧0.3%) SCM440 28～35HRC 900～1,060N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400～600N/㎟		不锈钢 Stainless Steel SUS300/400系 480～800N/㎟	
切削速度 Cutting Speed	60～90m/min		60～90m/min		50～80m/min		40～70m/min		60～90m/min		50～80m/min		40～60m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3	7,500	0.06～0.12	7,500	0.06～0.12	6,400	0.06～0.12	5,300	0.06～0.11	7,500	0.06～0.12	6,400	0.06～0.12	5,300	0.06～0.12
4	5,600	0.08～0.16	5,600	0.08～0.16	4,800	0.08～0.16	4,000	0.08～0.14	5,600	0.08～0.16	4,800	0.08～0.16	4,000	0.08～0.16
5	4,500	0.1 ～0.2	4,500	0.1 ～0.2	3,800	0.1 ～0.2	3,200	0.1 ～0.17	4,500	0.1 ～0.2	3,800	0.1 ～0.2	3,200	0.1 ～0.2
6	3,700	0.12～0.24	3,700	0.12～0.24	3,200	0.12～0.24	2,700	0.12～0.21	3,700	0.12～0.24	3,200	0.12～0.24	2,700	0.12～0.24
8	2,800	0.16～0.28	2,800	0.16～0.28	2,400	0.16～0.28	2,000	0.16～0.24	2,800	0.16～0.28	2,400	0.16～0.28	2,000	0.16～0.28
10	2,300	0.2 ～0.35	2,300	0.2 ～0.35	1,900	0.2 ～0.35	1,600	0.2 ～0.3	2,300	0.2 ～0.35	1,900	0.2 ～0.35	1,600	0.2 ～0.35

1. 此切削条件基准表适用于水溶性切削油剂或油雾式冷却加工。（不锈钢加工不推荐 MQL）
2. 请使用稀释倍率在20倍～30倍左右的优质水溶性切削油剂。
3. 使用油性切削油剂时，请将切削速度设定在最低值的70% 左右。
4. 请按照下面的资料"ADO-40D/50D 的推荐加工方法"进行导向孔加工。
5. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。
6. 加工高硬度材料时，请进行1D～2D 的阶梯式加工。
7. 请按照资料"ADO-10D/15D/20D/25D/30D/40D/50D/TRS-HO-10D的推荐加工方法" 进行导向孔加工。（请参考 P.391）

★ 加工困难或需改善孔的垂直度的情况下，请在导向孔加工后，使用内冷油孔硬质合金钻头 ADO-20D/30D 进行加工，之后再使用 ADO-40D/50D 进行加工。使用三种工具加工的情况下，ADO-40D/50D 可使用比上述切削条件表更高的切削条件进行加工。

1. The indicated speeds and feeds are for drilling with water-soluble coolant or MQL (mist drilling in stainless steels is not recommended).
2. Water-soluble high density coolant (20-30 times dilution) is recommended.
3. When using non-water-soluble coolant, set the cutting speed between 70-100% of the lowest limit.
4. Make a pilot hole before using in accordance with the recommended operation.
5. A clogged oil hole can lead to breakage. Make sure that a filter is attached to the oil feeder.
6. Peck drilling of 1D-2D is strongly recommended.
7. Make a guide hole before using in accordance with recommended operation. (See p.391)

★ If it is difficult to process or if the straightness of the hole needed to be improved, use the coolant-through carbide drill ADO-20/30D after drilling a pilot hole, then process with the ADO-40/50D. When processing with 3 tools, the ADO-40/50D may be used at a more aggressive cutting condition than those listed above.

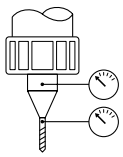
形状尺寸表 SPECIFICATION CHARTS
ADO-PLT ▶ P.172

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

ADO-PLT

加工材料 Work Material	软钢·低碳素钢 Mild Steel Low Carbon Steel SS400·S10C ～150HB ～500N/㎟		碳素钢 Carbon Steel S35C·S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM·SCr·SNCM 16～28HRC 710～900N/㎟		合金钢·预硬钢 Alloy Steel·Prehardened Steel (C≧0.3%) SCM440 28～34HRC 900～1,060N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400～600N/㎟		不锈钢 Stainless Steel SUS400系 480～800N/㎟		特殊钢·调质钢·预硬钢 Special Alloy Steel·Hardened Steel·Prehardened Steel SKD61 (非调质) (Unquenched) 34～40HRC 1,060～1,250N/㎟	
切削速度 Cutting Speed	60～125m/min		60～80m/min		60～80m/min		40～60m/min		60～80m/min		60～80m/min		40～60m/min		30～50m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3.03	7,400	0.06～0.09	7,400	0.06～0.09	7,400	0.06～0.09	5,200	0.06～0.09	7,400	0.06～0.09	7,400	0.06～0.09	5,200	0.06～0.09	4,200	0.06～0.09
4.03	5,600	0.08～0.12	5,600	0.08～0.12	5,600	0.08～0.12	3,900	0.08～0.12	5,600	0.08～0.12	5,600	0.08～0.12	3,900	0.08～0.12	3,100	0.08～0.12
5.03	4,500	0.1 ～0.15	4,500	0.1 ～0.15	4,500	0.1 ～0.15	3,100	0.1 ～0.15	4,500	0.1 ～0.15	4,500	0.1 ～0.15	3,100	0.1 ～0.15	2,500	0.1 ～0.15
6.03	3,700	0.12～0.18	3,700	0.12～0.18	3,700	0.12～0.18	2,600	0.12～0.18	3,700	0.12～0.18	3,700	0.12～0.18	2,600	0.12～0.18	2,100	0.12～0.18
7.03	3,200	0.14～0.2	3,200	0.14～0.2	3,200	0.14～0.2	2,300	0.14～0.2	3,200	0.14～0.2	3,200	0.14～0.2	2,300	0.14～0.2	1,800	0.14～0.2
8.03	2,800	0.14～0.2	2,800	0.14～0.2	2,800	0.14～0.2	2,000	0.14～0.2	2,800	0.14～0.2	2,800	0.14～0.2	2,000	0.14～0.2	1,600	0.14～0.2
9.03	2,500	0.14～0.22	2,500	0.14～0.22	2,500	0.14～0.22	1,800	0.14～0.22	2,500	0.14～0.22	2,500	0.14～0.22	1,800	0.14～0.22	1,400	0.14～0.22
10.03	2,200	0.15～0.24	2,200	0.15～0.24	2,200	0.15～0.24	1,600	0.15～0.24	2,200	0.15～0.24	2,200	0.15～0.24	1,600	0.15～0.24	1,300	0.15～0.24
11.03	2,000	0.16～0.26	2,000	0.16～0.26	2,000	0.16～0.26	1,500	0.17～0.24	2,000	0.16～0.26	2,000	0.16～0.26	1,400	0.16～0.26	1,150	0.17～0.24
12.03	1,800	0.18～0.28	1,800	0.18～0.28	1,800	0.18～0.28	1,350	0.18～0.24	1,800	0.18～0.28	1,800	0.18～0.28	1,300	0.18～0.28	1,100	0.18～0.24

1. 此切削条件基准表适用于水溶性切削油剂或油雾式冷却加工。(不锈钢加工不推荐MQL)。
2. 请使用稀释20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，标准条件下切削速度请下调30%，不适用于高速加工。。
4. 使用油性切削油剂时，请选择标准条件的切削速度以下的数值，不适用于高速加工。
5. 此切削条件基准表适用于孔深3D 以下的加工。
6. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
7. 请保持加工材料在不变形、不弯曲、不振动的状态下。
8. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。



1. The indicated speeds and feeds are for drilling with water-soluble coolant or MQL (mist drilling in stainless steels is not recommended).
2. Water-soluble high density coolant (less than 20 times dilution) is recommended.
3. When using water-soluble coolant with over 20 times dilution, reduce cutting speed by 30% below the standard conditions. Do not use the high speed cutting conditions in this case.
4. When using non-water-soluble coolant, the lower cutting speed in the table should be selected. Do not use the high speed drilling conditions in this case.
5. These conditions are for drilling depth less than 3 times the drill diameter.
6. Equip the drill with a scratch- and dust-free collet and minimize drill deflection to less than 0.02mm.
7. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
8. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

形状尺寸表 SPECIFICATION CHARTS ADO-SUS-3D ▶ P.173
形状尺寸表 SPECIFICATION CHARTS ADO-SUS-5D ▶ P.176
形状尺寸表 SPECIFICATION CHARTS ADO-SUS-8D ▶ P.180

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

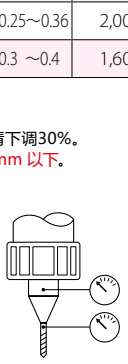
ADO-SUS-3D•5D•8D

加工材料 Work Material	铁素体·马氏体不锈钢 Ferritic Stainless Steel · Martensitic Stainless Steel				奥氏体不锈钢 Austenitic Stainless Steel				二相体不锈钢 Duplex Stainless Steel			
硬度 Hardness	≦200HB		>200HB		≦200HB		>200HB		≦290HB		>290HB	
钢种 No. Steel Type	1		2		3		4		5		6	
切削速度 Cutting Speed	60～80～100m/min		40～60～80m/min		60～80～100m/min		40～60～80m/min		40～60～80m/min		30～40～50m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	12,700	0.04～0.08	9,500	0.04～0.08	12,700	0.04～0.08	9,500	0.04～0.08	9,500	0.04～0.08	6,400	0.04～0.08
3	8,500	0.06～0.12	6,400	0.06～0.12	8,500	0.06～0.12	6,400	0.06～0.12	6,400	0.06～0.12	4,200	0.06～0.12
4	6,400	0.08～0.16	4,800	0.08～0.16	6,400	0.08～0.16	4,800	0.08～0.16	4,800	0.08～0.16	3,200	0.08～0.16
6	4,200	0.12～0.21	3,200	0.12～0.21	4,200	0.12～0.21	3,200	0.12～0.21	3,200	0.12～0.21	2,100	0.12～0.21
8	3,200	0.16～0.24	2,400	0.16～0.24	3,200	0.16～0.24	2,400	0.16～0.24	2,400	0.16～0.24	1,600	0.16～0.24
10	2,500	0.17～0.27	1,900	0.17～0.27	2,500	0.2 ～0.3	1,900	0.17～0.27	1,900	0.2 ～0.3	1,300	0.17～0.27
12	2,100	0.19～0.3	1,600	0.19～0.3	2,100	0.21～0.31	1,600	0.19～0.3	1,600	0.21～0.31	1,100	0.19～0.3
16	1,600	0.22～0.32	1,200	0.22～0.32	1,600	0.22～0.32	1,200	0.22～0.32	1,200	0.22～0.32	800	0.22～0.32
20	1,300	0.28～0.4	1,000	0.28～0.4	1,300	0.28～0.4	1,000	0.28～0.4	1,000	0.28～0.4	600	0.28～0.4

加工材料 Work Material	析出硬化体不锈钢 Precipitation Stainless Steel		钛合金 Titanium Alloy		软钢·低碳素钢 Mild Steel · Low Carbon Steel SS400 · S10C		碳素钢 Carbon Steel S35C · S50C		合金钢 Alloy Steel SCM · SCr · SNCM		镍基合金※ Nickel Alloy Inconel 718		铜合金 Copper Alloy C1020·2600	
硬度 Hardness	≦340HB		280HB～340HB		～150HB ～500N/mm²		～210HB ～710N/mm²		16～28HRC 710～900N/mm²		38～45HRC		—	
钢种 No. Steel Type	7		—		—		—		—		—		—	
切削速度 Cutting Speed	40～50～60 m/min		30～40～50 m/min		80～100～120 m/min		80～100～120 m/min		60～75～90 m/min		10～20～30 m/min		140～170～200 m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	8,000	0.04～0.08	6,400	0.04～0.08	12,700	0.04～0.08	12,700	0.04～0.08	11,900	0.04～0.08	3,200	0.03～0.05	22,300	0.03～0.05
3	5,300	0.06～0.12	4,200	0.06～0.12	10,600	0.06～0.12	10,600	0.06～0.12	8,000	0.06～0.12	2,100	0.05～0.08	18,000	0.05～0.08
4	4,000	0.08～0.16	3,200	0.08～0.16	8,000	0.08～0.16	8,000	0.08～0.16	6,000	0.08～0.16	1,600	0.06～0.1	13,500	0.06～0.1
6	2,700	0.12～0.21	2,100	0.12～0.21	5,300	0.12～0.24	5,300	0.12～0.24	4,000	0.12～0.24	1,100	0.09～0.15	9,000	0.09～0.15
8	2,000	0.16～0.24	1,600	0.16～0.24	4,000	0.16～0.28	4,000	0.16～0.28	3,000	0.16～0.28	800	0.12～0.2	6,800	0.12～0.2
10	1,600	0.2 ～0.3	1,300	0.17～0.27	3,200	0.2 ～0.3	3,200	0.2 ～0.3	2,400	0.2 ～0.3	640	0.15～0.2	5,500	0.15～0.25
12	1,300	0.21～0.31	1,100	0.19～0.3	2,700	0.21～0.3	2,700	0.21～0.3	2,000	0.21～0.3	530	0.15～0.2	4,500	0.18～0.3
16	1,000	0.22～0.32	800	0.22～0.32	2,000	0.25～0.36	2,000	0.25～0.36	1,500	0.25～0.36	400	0.15～0.24	3,400	0.24～0.32
20	800	0.28～0.4	600	0.28～0.4	1,600	0.3 ～0.4	1,600	0.3 ～0.4	1,200	0.3 ～0.4	320	0.15～0.3	2,700	0.3 ～0.4

1. 此切削条件基准表适用于水溶性切削油剂及内部供油的方式。
2. 请使用稀释20倍～30倍的优质水溶性切削油剂。
3. 使用油性切削油剂或是超过20倍的水溶性切削油剂时，切削速度请下调30%。
4. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
5. 请保持加工材料在不变形、不弯曲、不振动的状态下。
6. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。
7. 铜合金加工时，根据切屑形状，调整切削速度及进给量。

※ Inconel 718为首的耐热合金，孔深3D以下的情况，可以使用上表参数。如果超过3D时，根据情况采用阶梯式加工。



1. The above speeds and feeds are for water-soluble coolant and internal coolant supply.
2. Suitable cutting fluid is water-soluble high density coolant (20~30 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 30times dilution), reduce cutting speed by 30%.
4. Equip the drill with a scratch- and dust-free collet and minimize drill deflection to less than 0.02mm.
5. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
6. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.
7. Adjust the speed and feed accordingly based on chip shape when machining copper alloy.

※ The above cutting conditions are applicable to hole depth under 3D for heat-resistant alloys such as Inconel 718. When necessary please consider step drilling.

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

■不锈钢记号对照表 Stainless Steel Symbol Chart by Standard

加工材料 Work Material	钢种 No. Steel Type	日本工业规格 Japan JIS	国际规格 International Standard ISO 15510	欧洲规格 Europe	美国规格 U.S.A.		中国规格 China
				EN	UNS	(AISI)	GB
铁素体·马氏体不锈钢 Ferritic Stainless Steel· Martensitic Stainless Steel	1	SUS405	X6CrAl13	1.4002	S40500	405	S11348
		SUS430	X6Cr17	1.4016	S43000	430	S11710
		SUS410	X12Cr13	1.4006	S41000	410	S41010
		SUS410S	X6Cr13	1.4	S41008		S41008
	2	SUS420J1	X20Cr13	1.4021	S42000	420	S42020
		SUS420J2	X30Cr13	1.4028	S42000	420	S42030
奥氏体不锈钢 Austenitic Stainless Steel	3	SUS303	X10CrNiS18-9	1.4305	S30300	303	S30317
		SUS304	X5CrNi18-10	1.4301	S30400	304	S30408
		SUS304L	X2CrNi18-9	1.4307	S30403	304L	S30403
		SUS305	X6CrNi18-12	1.4303	S30500	305	S30510
		SUS309S	X6CrNi23-13	1.495	S30908	309S	S30908
		SUS310S	X6CrNi25-20	1.4951	S31008	310S	S31008
		SUS316	X5CrNiMo17-12-2	1.4401	S31600	316	S31608
		SUS316L	X2CrNiMo17-12-2	1.4404	S31603	316L	S31603
		SUS316Ti	X6CrNiMoTi17-12-2	1.4571	S31635		S31668
		SUS317L	X2CrNiMo19-14-4	1.4438	S31703	317L	S31703
		SUS347	X6CrNiNb18-10	1.455	S34700	347	S34778
	4	SUS301	X5CrNi17-7	1.4319	S30100	301	S30110
		SUS301L	X2CrNiN18-7	1.4318	S30153		S30153
		SUS304N1	X5CrNiN19-9	1.4315	S30451	304N	S30458
		SUS304N2			S30452		
二相体不锈钢 Duplex Stainless Steel	5	SUS329J1	X6CrNiMo26-4-2		S32900	329	
	6	SUS329J3L	X2CrNiMoN22-5-3	1.4462	S32205		S22053
		SUS329J4L	X2CrNiMoN25-7-3		S31260		S22583
					S32750		
析出硬化体不锈钢 Precipitation Stainless Steel	7	SUS630	X5CrNiCuNb16-4	1.4542	S17400	17-4PH (S17400)	S51740
						15-5PH (S15500)	
		SUS631	X7CrNiAl17-7	1.4568	S17700	17-7PH (S17700)	S51700

形状尺寸表 SPECIFICATION CHARTS ADO-TRS-3D ▶ P.182
形状尺寸表 SPECIFICATION CHARTS ADO-TRS-5D ▶ P.184

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

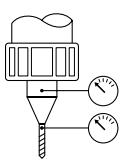
ADO-TRS-3D•5D

加工材料 Work Material	软钢·低碳素钢 Mild Steel·Low Carbon Steel SS400、S10C ~150HB ~500N/mm²		碳素钢 Carbon Steel S35C、S50C ~210HB ~710N/mm²		合金钢 Alloy Steel SCM、SCr、SNCM 16~28HRC 710 ~900N/mm²	
切削速度 Cutting Speed	80~120m/min		80~120m/min		60~100m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
3	10,000	0.11 ~ 0.15	10,000	0.11 ~ 0.15	8,500	0.11 ~ 0.15
4	8,000	0.14 ~ 0.2	8,000	0.14 ~ 0.2	6,400	0.14 ~ 0.2
5	6,400	0.18 ~ 0.25	6,400	0.18 ~ 0.25	5,100	0.18 ~ 0.25
6	5,300	0.21 ~ 0.3	5,300	0.21 ~ 0.3	4,200	0.21 ~ 0.3
7	4,500	0.25 ~ 0.35	4,500	0.25 ~ 0.35	3,600	0.25 ~ 0.35
8	4,000	0.28 ~ 0.4	4,000	0.28 ~ 0.4	3,200	0.28 ~ 0.4
9	3,500	0.32 ~ 0.45	3,500	0.32 ~ 0.45	2,800	0.32 ~ 0.45
10	3,200	0.35 ~ 0.5	3,200	0.35 ~ 0.5	2,500	0.35 ~ 0.5
11	2,900	0.39 ~ 0.55	2,900	0.39 ~ 0.55	2,300	0.39 ~ 0.55
12	2,700	0.42 ~ 0.6	2,700	0.42 ~ 0.6	2,100	0.42 ~ 0.6
13	2,400	0.46 ~ 0.65	2,400	0.46 ~ 0.65	2,000	0.46 ~ 0.65
14	2,300	0.49 ~ 0.7	2,300	0.49 ~ 0.7	1,800	0.49 ~ 0.7
15	2,100	0.53 ~ 0.75	2,100	0.53 ~ 0.7	1,700	0.53 ~ 0.7
16	2,000	0.56 ~ 0.8	2,000	0.56 ~ 0.72	1,600	0.56 ~ 0.72
17	1,900	0.6 ~ 0.85	1,900	0.6 ~ 0.77	1,500	0.6 ~ 0.77
18	1,800	0.63 ~ 0.9	1,800	0.63 ~ 0.81	1,400	0.63 ~ 0.81
19	1,700	0.67 ~ 0.9	1,700	0.67 ~ 0.86	1,300	0.67 ~ 0.86
20	1,600	0.7 ~ 0.9	1,600	0.7 ~ 0.9	1,300	0.7 ~ 0.9

加工材料 Work Material	合金钢 Alloy Steel SCM、SCr、SNCM 28~35HRC 900 ~1,100N/mm²		铸铁 Cast Iron FC250 ~350N/mm²		球墨铸铁 Ductile Cast Iron FCD450、FCD600 400 ~600N/mm²	
切削速度 Cutting Speed	60~90m/min		80~120m/min		60~100m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
3	8,000	0.11 ~ 0.15	10,000	0.11 ~ 0.18	8,500	0.11 ~ 0.15
4	6,000	0.14 ~ 0.2	8,000	0.14 ~ 0.24	6,400	0.14 ~ 0.2
5	4,800	0.18 ~ 0.25	6,400	0.18 ~ 0.3	5,100	0.18 ~ 0.25
6	4,000	0.21 ~ 0.3	5,300	0.21 ~ 0.36	4,200	0.21 ~ 0.3
7	3,400	0.25 ~ 0.35	4,500	0.25 ~ 0.42	3,600	0.25 ~ 0.35
8	3,000	0.28 ~ 0.4	4,000	0.28 ~ 0.48	3,200	0.28 ~ 0.4
9	2,700	0.32 ~ 0.45	3,500	0.32 ~ 0.54	2,800	0.32 ~ 0.45
10	2,400	0.35 ~ 0.5	3,200	0.35 ~ 0.6	2,500	0.35 ~ 0.5
11	2,200	0.39 ~ 0.55	2,900	0.39 ~ 0.66	2,300	0.39 ~ 0.55
12	2,000	0.42 ~ 0.6	2,700	0.42 ~ 0.72	2,100	0.42 ~ 0.6
13	1,800	0.46 ~ 0.65	2,400	0.46 ~ 0.78	2,000	0.46 ~ 0.65
14	1,700	0.49 ~ 0.7	2,300	0.49 ~ 0.84	1,800	0.49 ~ 0.7
15	1,600	0.53 ~ 0.7	2,100	0.53 ~ 0.75	1,700	0.53 ~ 0.7
16	1,500	0.56 ~ 0.72	2,000	0.56 ~ 0.8	1,600	0.56 ~ 0.72
17	1,400	0.6 ~ 0.77	1,900	0.6 ~ 0.85	1,500	0.6 ~ 0.77
18	1,300	0.63 ~ 0.81	1,800	0.63 ~ 0.9	1,400	0.63 ~ 0.81
19	1,300	0.67 ~ 0.86	1,700	0.67 ~ 0.95	1,300	0.67 ~ 0.86
20	1,200	0.7 ~ 0.9	1,600	0.7 ~ 1	1,300	0.7 ~ 0.9

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释20倍的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，切削速度请下调30%。
4. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
5. 请保持加工材料在不变形、不弯曲、不振动的状态下。
6. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. Water-soluble high density coolant (less than 20 times dilution) is recommended.
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce cutting speed by 30%.
4. Equip the drill with a scratch- and dust-free collet and minimize drill deflection to less than 0.02mm.
5. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
6. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.



形状尺寸表 SPECIFICATION CHARTS TRS-HO-3D ▶ P.186
形状尺寸表 SPECIFICATION CHARTS TRS-HO-5D ▶ P.188

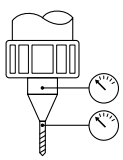
硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

TRS-HO-3D・5D

加工材料 Work Material	软钢・低碳素钢 Mild Steel・Low Carbon Steel SS400、S10C ～150HB ～500N/㎟		碳素钢 Carbon Steel S35C、S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM、SCr、SNCM 16～28HRC 710～900N/㎟	
切削速度 Cutting Speed	80～120m/min		80～120m/min		60～90m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
5	6,400	0.18 ～ 0.25	6,400	0.18 ～ 0.25	4,800	0.18 ～ 0.25
6	5,300	0.21 ～ 0.3	5,300	0.21 ～ 0.3	4,000	0.21 ～ 0.3
7	4,500	0.25 ～ 0.35	4,500	0.25 ～ 0.35	3,400	0.25 ～ 0.35
8	4,000	0.28 ～ 0.4	4,000	0.28 ～ 0.4	3,000	0.28 ～ 0.4
9	3,500	0.32 ～ 0.45	3,500	0.32 ～ 0.45	2,700	0.32 ～ 0.45
10	3,200	0.35 ～ 0.5	3,200	0.35 ～ 0.5	2,400	0.35 ～ 0.5
11	2,900	0.39 ～ 0.55	2,900	0.39 ～ 0.55	2,200	0.39 ～ 0.5
12	2,700	0.42 ～ 0.6	2,700	0.42 ～ 0.6	2,000	0.42 ～ 0.54
13	2,400	0.46 ～ 0.65	2,400	0.46 ～ 0.65	1,800	0.46 ～ 0.59
14	2,300	0.49 ～ 0.7	2,300	0.49 ～ 0.7	1,700	0.49 ～ 0.63
15	2,100	0.45 ～ 0.68	2,100	0.45 ～ 0.68	1,600	0.45 ～ 0.6
16	2,000	0.48 ～ 0.72	2,000	0.48 ～ 0.72	1,500	0.48 ～ 0.64
17	1,900	0.51 ～ 0.77	1,900	0.51 ～ 0.77	1,400	0.51 ～ 0.68
18	1,800	0.54 ～ 0.81	1,800	0.54 ～ 0.81	1,300	0.54 ～ 0.72
19	1,700	0.57 ～ 0.86	1,700	0.57 ～ 0.86	1,300	0.57 ～ 0.76
20	1,600	0.6 ～ 0.9	1,600	0.6 ～ 0.9	1,200	0.6 ～ 0.8

加工材料 Work Material	合金钢 Alloy Steel SCM、SCr、SNCM 28～35HRC 900～1,100N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD450、FCD600 400～600N/㎟	
切削速度 Cutting Speed	60～90m/min		80～120m/min		60～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
5	4,800	0.18 ～ 0.25	6,400	0.18 ～ 0.3	5,100	0.18 ～ 0.25
6	4,000	0.21 ～ 0.3	5,300	0.21 ～ 0.36	4,200	0.21 ～ 0.3
7	3,400	0.25 ～ 0.35	4,500	0.25 ～ 0.42	3,600	0.25 ～ 0.35
8	3,000	0.28 ～ 0.4	4,000	0.28 ～ 0.48	3,200	0.28 ～ 0.4
9	2,700	0.32 ～ 0.45	3,500	0.32 ～ 0.54	2,800	0.32 ～ 0.45
10	2,400	0.35 ～ 0.5	3,200	0.35 ～ 0.6	2,500	0.35 ～ 0.5
11	2,200	0.39 ～ 0.5	2,900	0.39 ～ 0.66	2,300	0.39 ～ 0.55
12	2,000	0.42 ～ 0.54	2,700	0.42 ～ 0.72	2,100	0.42 ～ 0.6
13	1,800	0.46 ～ 0.59	2,400	0.46 ～ 0.78	2,000	0.46 ～ 0.65
14	1,700	0.49 ～ 0.63	2,300	0.49 ～ 0.84	1,800	0.49 ～ 0.7
15	1,600	0.45 ～ 0.6	2,100	0.53 ～ 0.75	1,700	0.45 ～ 0.68
16	1,500	0.48 ～ 0.64	2,000	0.56 ～ 0.8	1,600	0.48 ～ 0.72
17	1,400	0.51 ～ 0.68	1,900	0.6 ～ 0.85	1,500	0.51 ～ 0.77
18	1,300	0.54 ～ 0.72	1,800	0.63 ～ 0.9	1,400	0.54 ～ 0.81
19	1,300	0.57 ～ 0.76	1,700	0.67 ～ 0.95	1,300	0.57 ～ 0.86
20	1,200	0.6 ～ 0.8	1,600	0.7 ～ 1	1,300	0.6 ～ 0.9

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释20倍的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，切削速度请下调30%。
4. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
5. 请保持加工材料在不变形、不弯曲、不振动的状态下。
6. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。



1. The indicated speeds and feeds are for water-soluble coolant.
2. Suitable cutting fluid is water-soluble high density coolant (20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20times dilution), reduce drilling speed by 30%.
4. When inserting a drill into the machine, use a collet that does not have any scratches or dust located within internal bore. Also, reduce deflection of drill to less than 0.02mm.
5. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
6. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

TRS-HO-10D

加工材料 Work Material	软钢·低碳素钢 Mild Steel Low Carbon Steel SS400・S10C ～150HB ～500N/mm²		碳素钢 Carbon Steel S35C・S50C ～210HB ～710N/mm²		合金钢 Alloy Steel SCM・SCr・SNCM 16～28HRC 710～900N/mm²		铸铁 Cast Iron FC250 ～350N/mm²		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400～600N/mm²	
切削速度 Cutting Speed	80～120m/min		80～120m/min		60～120m/min		80～120m/min		60～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
5	6,400	0.18～0.25	6,400	0.18～0.25	5,700	0.18～0.25	6,400	0.18～0.30	5,100	0.18～0.25
6	5,300	0.21～0.3	5,300	0.21～0.3	4,800	0.21～0.3	5,300	0.21～0.36	4,200	0.21～0.3
7	4,500	0.25～0.35	4,500	0.25～0.35	4,100	0.25～0.35	4,500	0.25～0.42	3,600	0.25～0.35
8	4,000	0.28～0.4	4,000	0.28～0.4	3,600	0.28～0.4	4,000	0.28～0.48	3,200	0.28～0.4
9	3,500	0.32～0.45	3,500	0.32～0.45	3,200	0.32～0.45	3,500	0.32～0.54	2,800	0.32～0.45
10	3,200	0.35～0.5	3,200	0.35～0.5	2,900	0.35～0.5	3,200	0.35～0.6	2,500	0.35～0.5
11	2,900	0.39～0.55	2,900	0.39～0.55	2,600	0.39～0.55	2,900	0.39～0.66	2,300	0.39～0.55
12	2,700	0.42～0.6	2,700	0.42～0.6	2,400	0.42～0.6	2,700	0.42～0.72	2,100	0.42～0.6

1. 此切削条件基准表适用于水溶性切削油剂或50ml/h左右的油雾冷却。
2. 请使用稀释20倍左右的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，切削速度请下调30%。
4. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
5. 请保持加工材料在不变形、不弯曲、不振动的状态下。
6. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。
7. 请按照资料"ADO-10D/15D/20D/25D/30D/40D/50D/TRS-HO-10D的推荐加工方法"进行加工。(请参考P.391)

1. The indicated speeds and feeds are for drilling with water-soluble coolant or mist (approx.50ml/hour)
2. Suitable cutting fluid is water-soluble high density coolant (20 times dilution)
3. When using non-water-soluble or water-soluble coolant (over 20times dilution), reduce drilling speed by 30%.
4. When inserting a drill into the machine, use a collet that does not have any scratches or dust located within internal bore. Also, reduce deflection of drill to less than 0.02mm.
5. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
6. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.
7. Make a guide hole before using in accordance with recommended operation. (See p.391)

形状尺寸表 SPECIFICATION CHARTS
WX-MS-GDS ▶ P.194

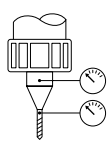
硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

WX-MS-GDS

加工材料 Work Material	碳素钢 Carbon Steel S15C・S50C (～900N/㎟)			合金钢 Alloy Steel SCM440 (～1060N/㎟)			特殊钢 Special Alloy Steel SUS410・SUS440・SUJ2			科伐铁镍钴合金※ Kover (Fe-Ni-Co合金)		
切削速度 Cutting Speed	20～80m/min			20～56m/min			20～36m/min			20～45m/min		
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)
0.2	25,000	0.002	0.04	25,000	0.002	0.04	25,000	0.002	0.04	25,000	0.002	0.04
0.3	20,000	0.003	0.06	20,000	0.003	0.06	20,000	0.003	0.06	20,000	0.003	0.06
0.5	15,000	0.007	0.1	14,000	0.007	0.1	13,000	0.007	0.1	13,000	0.007	0.1
1	12,000	0.02	–	11,000	0.02	–	10,000	0.02	–	6,400	0.01	0.25
1.5	10,000	0.02～0.04	–	8,400	0.02～0.04	–	6,800	0.03～0.05	–	4,800	0.012～0.03	0.45
2	8,000	0.03～0.05	–	6,500	0.03～0.05	–	5,000	0.04～0.06	–	4,000	0.016～0.04	0.5～1
3	5,500	0.04～0.07	–	4,500	0.04～0.07	–	3,400	0.06～0.09	–	3,000	0.024～0.06	0.7～1.5
4	4,000	0.06～0.1	–	3,200	0.06～0.1	–	2,500	0.08～0.12	–	2,500	0.03～0.08	1～2
5	3,200	0.07～0.12	–	2,600	0.07～0.12	–	2,000	0.1～0.15	–	2,000	0.04～0.1	1.2～2.5

加工材料 Work Material	铜・铜合金 Copper・Copper Alloys (C＜0.3%) S1020・S2600			变形铝 Aluminum A5052・A7075			铝合金 Aluminum Alloy AC4C・ADC		
切削速度 Cutting Speed	20～45m/min			32～80m/min			32～63m/min		
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)
0.2	25,000	0.002	0.04	25,000	0.004	–	25,000	0.002	–
0.3	20,000	0.003	0.06	20,000	0.007	–	20,000	0.003	–
0.5	13,000	0.007	0.1	15,000	0.015	–	15,000	0.007	–
1	6,400	0.01	0.25	12,000	0.03	–	12,000	0.01	–
1.5	4,800	0.012～0.03	0.45	10,000	0.03～0.08	–	10,000	0.012～0.03	–
2	4,000	0.016～0.04	0.5～1	8,000	0.04～0.1	–	8,000	0.016～0.04	–
3	3,000	0.024～0.06	0.7～1.5	6,500	0.06～0.15	–	6,500	0.024～0.06	–
4	2,500	0.03～0.08	1～2	5,000	0.08～0.2	–	5,000	0.03～0.08	–
5	2,000	0.04～0.1	1.2～2.5	4,000	0.1～0.25	–	4,000	0.04～0.1	–

1.请使用主轴回转精度好的机械。
2.此切削条件基准表适用于水溶性切削油剂。
3.请使用稀释倍率20倍左右的优质水溶性切削油剂。
4.此切削条件基准表适用于孔深为3D以下。孔深为3D以上时，即使未达到上表中的停顿量，也请以0.25D～0.5D为标准进行适当的阶梯式加工。
5.安装时的振动精度请如右图所示使夹头本体圆筒部或柄部处于0.002mm以下。(特别φ0.5以下)
6.热膨胀刀柄较为有效。



注1: 机械转速未达到上述切削速度时，请尽可能使用高转速。但是，可能会降低刀具寿命。
※加工科伐铁镍钴合金时，尽管比较好加工，但请考虑到毛刺，切屑的处理性，请选择适当的切削参数。

1. Please use a carbide drill in a machine with precise spindle rotation.
2. The indicated speeds and feeds are for drilling with water-soluble coolant.
3. Please use water-soluble high density coolant (20 times dilution).
4. The above shown table is applied for less than 3xD deep drilling operation. When a hole is deeper than 3xD, please add step feeding with every 0.25-0.5xD accordingly.
5. The run out with a drill in a spindle should be less than 0.002mm, as in the picture. (especially, under drill dia.0.5mm)
6. The shrink fit system is effective holder.

Note 1. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible. Tool life may be decreased.
※ On Kover, select speed&feed cosidering burr and chip ejection.

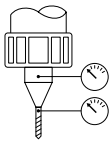
形状尺寸表 SPECIFICATION CHARTS
MRS-GDL ▶ P.201

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

MRS-GDL

加工材料 Work Material	马氏体不锈钢 Martensitic Stainless Steel SUS420J2・SUS440C		奥氏体不锈钢 Austenitic Stainless Steel SUS303・SUS304・SUS316・SUS316L		铁素体不锈钢 Ferritic Stainless Steel SUS430・SUS430F		析出硬化体不锈钢 Precipitation Stainless Steel SUS630	
切削速度 Cutting Speed	20～50m/min		15～40m/min		20～50m/min		15～40m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
0.5	12,700～31,800	0.005～0.015	9,500～25,400	0.005～0.015	12,700～31,800	0.005～0.015	9,500～25,400	0.005～0.015
1	6,300～15,900	0.01～0.03	4,700～12,700	0.01～0.03	6,300～15,900	0.01～0.03	4,700～12,700	0.01～0.03
1.5	4,200～10,600	0.015～0.045	3,100～8,400	0.015～0.045	4,200～10,600	0.015～0.045	3,100～8,400	0.015～0.045
2	3,180～7,900	0.02～0.06	2,300～6,300	0.02～0.06	3,180～7,900	0.02～0.06	2,300～6,300	0.02～0.06
2.5	2,500～6,300	0.025～0.075	1,900～5,000	0.025～0.075	2,500～6,300	0.025～0.075	1,900～5,000	0.025～0.075
3	2,100～5,300	0.03～0.09	1,500～4,200	0.03～0.09	2,100～5,300	0.03～0.09	1,500～4,200	0.03～0.09

1.请使用主轴回转精度好的机械。
2.此切削条件基准表适用于水溶性切削油剂。
3.请使用稀释倍率20倍左右的优质水溶性切削油剂。
4.此切削条件基准表适用于孔深为3D以下。孔深为3D以上时，即使未达到上表中的停顿量，也请以0.25D ~ 0.5D为标准进行适当的阶梯式加工。
5.安装时的振动精度请如右图所示使夹头本体圆筒部或柄部处于0.002mm以下。(特别φ0.5以下)
6.热膨胀刀柄较为有效。



注1: 机械转速未达到上述切削速度时，请尽可能使用高转速。但是，可能 会降低刀具寿命。

1. Please use a carbide drill in a machine with precise spindle rotation.
2. The indicated speeds and feeds are for drilling with water-soluble coolant.
3. Please use water-soluble high density coolant (20 times dilution).
4. The above shown table is applied for less than 3xD deep drilling operation. When a hole is deeper than 3xD, please add step feeding with every 0.25-0.5xD accordingly.
5. The run out with a drill in a spindle should be less than 0.002mm, as in the picture. (especially, under drill dia. 0.5mm)
6. The shrink fit system acts as an effective holder.

Note 1. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible. Tool life may be decreased.

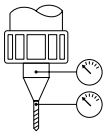
形状尺寸表 SPECIFICATION CHARTS
NF-GDN ▶ P.203

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

NF-GDN

加工材料 Work Material	铸造铝合金 Aluminum Alloy Casting ～13wt%Si・AC1～8・ADC		变形铝 Aluminum A7075・A2024・A5052		铜合金 Copper Alloy C1020・C6140		镁合金 Magnesium Alloy AZ91D・AZ80A		铸铁 Cast Iron FC250 ～350N/㎟	
切削速度 Cutting Speed	80 ～200m/min		80 ～200m/min		40 ～100m/min		63 ～100m/min		63 ～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3	9,600	0.09～0.3	9,600	0.09～0.18	7,400	0.02～0.03	8,500	0.09～0.18	7,400	0.05～0.08
4	7,600	0.12～0.4	7,600	0.12～0.24	5,600	0.02～0.04	6,400	0.12～0.24	5,600	0.06～0.1
5	6,400	0.15～0.5	6,400	0.15～0.3	4,500	0.03～0.05	5,100	0.15～0.3	5,100	0.08～0.13
6	5,600	0.18～0.6	5,600	0.18～0.36	3,700	0.03～0.06	4,200	0.18～0.36	4,200	0.09～0.15
8	4,400	0.24～0.8	4,400	0.24～0.48	2,800	0.04～0.08	3,200	0.24～0.48	3,200	0.12～0.2
10	3,800	0.3～1	3,800	0.30～0.6	2,200	0.05～0.1	2,500	0.30～0.6	2,500	0.15～0.25
12	3,500	0.36～1.2	3,500	0.36～0.72	1,900	0.06～0.12	2,100	0.36～0.72	2,300	0.18～0.3
13	3,300	0.39～1.3	3,300	0.39～0.78	1,700	0.07～0.13	2,000	0.39～0.78	2,100	0.20～0.33

1. 此切削条件基准表适用于使用水溶性切削油剂的场合。
2. 请使用稀释倍率20倍～30倍左右的优质水溶性切削油剂。
3. 上述条件适用于孔深为3D以下的情况。若孔深超过3D时，请按照下表调整切削速度。
4. 当加工材料的切屑不易分断时，请适当采用阶梯式加工。
5. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.01mm 以下。



1. The indicated speeds and feeds are for drilling with water- soluble coolant.
2. The most suitable cutting fuid is water-soluble coolant (20-30 times dilution).
3. These conditions are for drilling depth less than 3 times the drill diameter. For drilling depth > 3D, reduce the drilling speed (using the table below).
4. Operate the drill in steps as necessary when working on a material that disintegrates chips poorly.
5. When inserting a drill into the machine, use a collet that does not have any scratches or dust located within the internal bore. Also, reduce the runout of drill to less than 0.01mm.

D : drill dia

孔深（D为外径） Depth of Cut	4D以下 ≦4D	5D以下 ≦5D
切削速度抑制系数 Coefficient for reducing speed	×0.8	×0.7

加工镁合金时：
1. 请在与切削油剂制造商商谈之后，务必使用镁专用油剂。
2. 请注意切屑的处理和管理。

When a drill is used in Magnesium alloy...
1. Please use cutting fluid for Magnesium and check with a cutting fluid producer.
2. Please be careful of control and disposition of chips.

●半干式（油雾式）加工时的注意事项

1. 喷雾量以50CC/n以上为宜，推荐下表追加涂层。
2. 当加工材料的切屑不易分断时，请适当采用阶梯式加工。

About semi-dry (mist) processing

1. To use a minimum mist dischage rate of 50cc/h, the addition of the coating in the table below is recommended.
2. Operate the drill in steps as necessary when working on a material that disintegrates chips poorly.

D：钻头直径　D : drill dia

加工材料 Work Material	切削速度 Cutting Speed (m/min)	每转进给量 Feed Rate (mm/rev)	推荐涂层 Recommended Coating
铸造铝合金 Aluminum Alloy Casting	40～60	3%×D～4%×D	DLC涂层 DLC coating
变形铝 Aluminum	40～60	3%×D～4%×D	DLC涂层 DLC coating
铸铁 Cast Iron	40～60	3%×D～4%×D	FX(TiALN)涂层 FX(TiALN) coating

形状尺寸表 SPECIFICATION CHARTS
CAO-GDXL ▶ P.205

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

CAO-GDXL

15D・20D用
For 15D, 20D

加工材料 Work Material	压铸铝 铸造铝合金 Aluminum Die Castings Aluminum Alloy Castings ADC・AC		变形铝 Aluminum A20系・A70系		变形铝 Aluminum A50系・A60系		铜合金 Copper Alloys C1020・C1100		铜合金 Copper Alloys CrCu・黄铜 Brass	
切削油剂 Coolant	水溶性切削油使用的场合 Use water-soluble									
切削速度 Cutting Speed	80 ～200m/min		60 ～120m/min		80 ～200m/min		80 ～200m/min		60 ～120m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3	12,800	0.09 ～0.15	10,700	0.09 ～0.15	12,800	0.06 ～0.12	12,800	0.06 ～0.12	10,700	0.05 ～0.09
4	9,600	0.12 ～0.2	8,000	0.12 ～0.2	9,600	0.08 ～0.16	9,600	0.08 ～0.16	8,000	0.06 ～0.1
5	7,700	0.15 ～0.25	6,400	0.15 ～0.25	7,700	0.1 ～0.2	7,700	0.1 ～0.2	6,400	0.06 ～0.1
6	6,400	0.18 ～0.3	5,400	0.18 ～0.3	6,400	0.12 ～0.2	6,400	0.12 ～0.2	5,400	0.06 ～0.1
8	4,800	0.2 ～0.4	4,000	0.2 ～0.4	4,800	0.12 ～0.25	4,800	0.12 ～0.25	4,000	0.08 ～0.15
10	3,900	0.25 ～0.5	3,200	0.25 ～0.5	3,900	0.15 ～0.25	3,900	0.15 ～0.25	3,200	0.08 ～0.15

1. 进行MQL加工时，请参照以下条件。加工A50、A60系的变形铝时，若钻头直径为φ5mm以下，请设定切削速度为60m/min ～100m/min。进给量以(0.02-0.03)xD为基准，最大不可超过0.15mm/rev。加工A20、A70系的变形铝以及铜合金时，请与本公司营业人员联系。
2. 请使用稀释倍率20倍～30倍左右的优质水溶性切削油剂。
3. 使用油性切削油剂时，请将切削速度设定在最低值的70% 左右。
4. 加工高硬度的铍铜时，请使用FTO-GDXL。
5. 若钻头推出时为断续切削，或者加工干涉孔时，请降低进给量。
6. 切削条件的范围设定的较广，这是因为考虑到设备，切削油剂、工作的夹持状况等周边环境对可能加工条件的影响。

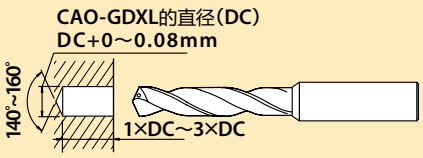
1. When machining with MQL (Minimum Quantity Lubrication), please follow these conditions. When drilling A50 & A60 aluminum, if the drill diameter is less than 5mm, please set the cutting speed to 60m/min~100m/min. With a target feed amount of (0.02~0.03) x D, be sure not to exceed a maximum of 0.15mm/rev. Please contact our sales staff when drilling A20 & A70 aluminum and copper alloys.
2. The most suitable cutting fluid is water-soluble coolant (20-30 times dilution).
3. When using non-water-soluble coolant, set the drilling speed between 70 -100% of the lowest limit.
4. Use FTO-GDXL when drilling high hardness copper-beryllium alloys.
5. When coming through to intermittent drilling and drilling interrupting holes, reduce the feed rate.
6. There is a wide range of cutting conditions, and these should be chosen based on a wide variety of factors including the machine, cutting fluid and workholding.

使用30D用的CAO-GDXL时，请与我公司营业人员联络。To use CAO-GDXL for 30D times the drill diameter, please contact our sales.

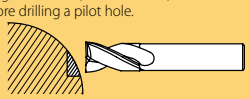
■ CAO-GDXL的推荐加工方法 Recommended operation for using CAO-GDXL

①使用ADO-3D/5D,ADO-PLT进行导向孔加工
Make a pilot hole with the ADO-3D/5D or ADO-PLT.

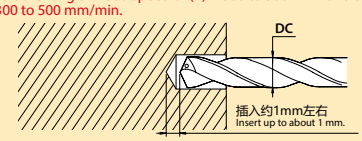
●导向孔加工用工具请选择比CAO-GDXL的直径（DC）+0~0.08mm的钻头。推荐在加工时将导向孔尽量加深。
For a pilot hole, select 0-0.08mm larger size drill than CAO-GDXL.



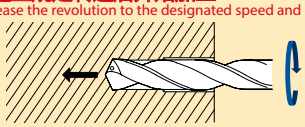
★弯曲部加工时，在导向孔加工前请先用FX-ZDS沉孔加工铣刀或ADF硬质合金平头钻进行沉孔加工。
When working on a curved surface, use the FX-ZDS (end mill for counterboring)or the ADF (carbide flat drill) to counterbore a flat surface before drilling a pilot hole.



②CAO-GDXL以转速(n)＝ 300～500min^{-1}左右，进给速度(Vf)＝300～500mm/min 插入
Insert the long drill at a speed of (n) = 300 to 500 min^{-1} and a feed rate of (Vf) = 300 to 500 mm/min.

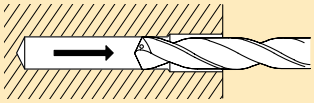


③加速至规定转速后开始加工
Increase the revolution to the designated speed and start drilling.



加工通孔时，请在拔出时降低进给量至（f）＝0.05～0.1mm/rev.
When drilling through holes, reduce the feed rate to (f) 0.05 to 0.1 mm/rev.

④加工后，拔出钻头时，请降低转速至(n)=300～500min^{-1}・进给速度(Vf)＝1,000 ～3,000mm/min左右拔出
After drilling, reduce the speed to (n) = 300 to 500 min^{-1} and a feed rate of (Vf) = 1,000 to 3,000 mm/min and pull the drill out of the hole.



＊请务必使用内冷方式进行加工。
Make sure to use an internal coolant supply when drilling.

形状尺寸表 SPECIFICATION CHARTS FH-GDS ▶ P.208
形状尺寸表 SPECIFICATION CHARTS FH-GDN ▶ P.209

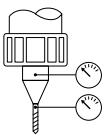
硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

FH-GDS• FH-GDN

加工材料 Work Material	调质钢·预硬钢 Hardened Steel· Prehardened Steel 40 ～50HRC			SKT· SKD61 50 ～55HRC			SKD11· SKT· SUS440 55 ～62HRC		
切削速度 Cutting Speed	50 ～54m/min			50 ～54m/min			50 ～54m/min		
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)
0.3	注1 (Note1)	0.006	0.03	注1 (Note1)	0.006	0.03	注1 (Note1)	0.006	0.03
0.4	注1 (Note1)	0.008	0.04	注1 (Note1)	0.008	0.04	注1 (Note1)	0.008	0.04
0.5	注1 (Note1)	0.015	0.15	注1 (Note1)	0.01	0.1	注1 (Note1)	0.01	0.05
0.6	注1 (Note1)	0.018	0.18	注1 (Note1)	0.012	0.12	注1 (Note1)	0.012	0.06
0.7	24,000	0.021	0.21	24,000	0.014	0.14	24,000	0.014	0.07
0.8	21,000	0.024	0.24	21,000	0.016	0.16	21,000	0.016	0.08
0.9	18,000	0.027	0.27	18,000	0.018	0.18	18,000	0.018	0.09
1	17,000	0.03	0.3	17,000	0.02	0.2	17,000	0.02	0.1
1.1	15,000	0.033	0.33	15,000	0.022	0.22	15,000	0.022	0.11
1.2	14,000	0.036	0.36	14,000	0.024	0.24	14,000	0.024	0.12
1.3	13,000	0.039	0.39	13,000	0.026	0.26	13,000	0.026	0.13
1.4	12,000	0.042	0.42	12,000	0.028	0.28	12,000	0.028	0.14
1.5	11,000	0.045	0.45	11,000	0.03	0.3	11,000	0.03	0.15
1.6	10,000	0.048	0.48	10,000	0.032	0.32	10,000	0.032	0.16
1.7	10,000	0.051	0.51	10,000	0.034	0.34	10,000	0.034	0.17
1.8	9,000	0.054	0.54	9,000	0.036	0.36	9,000	0.036	0.18
1.9	9,000	0.057	0.57	9,000	0.038	0.38	9,000	0.038	0.19
2	8,000	0.06	0.6	8,000	0.04	0.4	8,000	0.04	0.2

1. 请使用主轴回转精度好的机械。
2. 此切削条件基准表适用于水溶性切削油剂。
3. 请使用稀释倍率20倍左右的优质水溶性切削油剂。
4. 此切削条件基准表，FH-GDS适用于孔深3D 以下，FH-GDN 适用于孔深7D 以下。
5. 推荐使用FH-GDS作为FH-GDN的导向孔加工。
6. 安装时的振动精度请如右图所示使夹头本体圆筒部或柄部处于0.002mm 以下。
7. 热膨胀刀柄较为有效。

注1: 机械转速未达到上述切削速度时，请尽可能使用高转速。但是，可能会降低刀具寿命。



1. Please use a carbide drill in a machine with precise spindle rotation.
2. The indicated speeds and feeds are for drilling with water-soluble coolant.
3. Please use water-soluble high density coolant (20 times dilution).
4. This cutting condition chart is made for the following: depth of cut less than 3 x drill dia. for FH-GDS and less than 7 x drill dia. for FH-GDN.
5. We recommend FH-GDS for the pilot hole operation prior to FH-GDN.
6. The run out with a drill in a spindle should be less than 0.002mm as in the picture.
7. The shrink fit system is effective holder.

Note 1. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible. Tool life may be decreased.

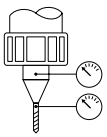
形状尺寸表 SPECIFICATION CHARTS
WH55-5D ▶ P.210

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

WH55-5D

加工材料 Work Material	特殊钢・调质钢・预硬钢 SKD61（非调质） Special Alloy Steel・Hardened Steel・Prehardened Steel (unquenched) 40～45HRC		DAC55、DH31S、SKD61、SKD11、STAVAX等			
			45～50HRC		50～55HRC	
切削速度 Cutting Speed	30～50m/min		20～30m/min		20～30m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	6,400	0.02～0.04	4,000	0.02～0.04	4,000	0.02～0.04
3	4,200	0.03～0.06	2,700	0.03～0.06	2,700	0.03～0.06
4	3,200	0.04～0.08	2,000	0.04～0.08	2,000	0.04～0.08
5	2,500	0.05～0.1	1,600	0.05～0.1	1,600	0.05～0.1
6	2,100	0.06～0.12	1,300	0.06～0.12	1,300	0.06～0.12
7	1,800	0.07～0.14	1,100	0.07～0.14	1,100	0.07～0.14
8	1,600	0.08～0.16	1,000	0.08～0.16	1,000	0.08～0.16
9	1,400	0.09～0.18	900	0.09～0.18	900	0.09～0.18
10	1,300	0.1～0.2	800	0.1～0.2	800	0.1～0.2
11	1,150	0.11～0.22	720	0.11～0.22	720	0.11～0.22
12	1,100	0.12～0.24	700	0.12～0.24	700	0.12～0.24

1. 此切削条件基础表适用于水溶性切削油剂冷却加工。
2. 请使用稀释20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，切削速度请下调30%。
4. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
5. 请保持加工材料在不变形、不弯曲、不振动的状态下。



1. The indicated speeds and feeds are for water-soluble coolant.
2. Suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce drilling speed by 30%.
4. When inserting a drill into the machine, use a collet that does not have any scratches or dust located within internal bore. Also, reduce deflection of drill to less than 0.02mm.
5. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.

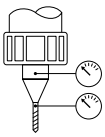
形状尺寸表 SPECIFICATION CHARTS
WHO55-5D ▶ P.211

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

WHO55-5D

加工材料 Work Material	特殊钢・调质钢・预硬钢 SKD61（非调质） Special Alloy Steel・Hardened Steel・Prehardened Steel (unquenched) 40～45HRC		DAC55、DH31S、SKD61、SKD11、STAVAX等 45～50HRC		DAC55、DH31S、SKD61、SKD11、STAVAX等 50～55HRC		Inconel® 38～45HRC	
切削速度 Cutting Speed	30～50m/min		20～30m/min		20～30m/min		10～30m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3.3	3,900	0.03～0.07	2,400	0.03～0.07	2,400	0.03～0.07	1,900	0.03～0.07
4	3,200	0.04～0.08	2,000	0.04～0.08	2,000	0.04～0.08	1,600	0.04～0.08
5	2,500	0.05～0.1	1,600	0.05～0.1	1,600	0.05～0.1	1,300	0.05～0.1
6	2,100	0.06～0.12	1,300	0.06～0.12	1,300	0.06～0.12	1,100	0.06～0.12
7	1,800	0.07～0.14	1,100	0.07～0.14	1,100	0.07～0.14	900	0.07～0.14
8	1,600	0.08～0.16	1,000	0.08～0.16	1,000	0.08～0.16	800	0.08～0.16
9	1,400	0.09～0.18	900	0.09～0.18	900	0.09～0.18	700	0.09～0.18
10	1,300	0.1～0.2	800	0.1～0.2	800	0.1～0.2	600	0.1～0.2
11	1,150	0.11～0.22	720	0.11～0.22	720	0.11～0.22	600	0.11～0.22
12	1,100	0.12～0.24	700	0.12～0.24	700	0.12～0.24	500	0.12～0.24

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或者稀释倍率超过20倍时，切削速度请下调30%。
4. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm 以下。
5. 请保持加工材料在不变形、不弯曲、不振动的状态下。
6. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。
7. 以Inconel 718为首的镍基合金，上述条件表仅适用于孔深3D以下的场合。



1. The indicated speeds and feeds are for water-soluble coolant.
2. Suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20times dilution), reduce drilling speed by 30% .
4. When inserting a drill into the machine, use a collet that does not have any scratches or dust located within internal bore. Also, reduce deflection of drill to less than 0.02mm.
5. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
6. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.
7. For drilling heat resistant alloys as Inconel 718, please used above chart only 3D and less deep holes.

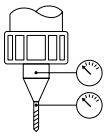
形状尺寸表 SPECIFICATION CHARTS
WH70-DRL ▶ P.212

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

WH70-DRL

加工材料 Work Material	SKD11・SKT・SUS440 55～60HRC		SKH・SKD11・SKS 60～70HRC	
切削速度 Cutting Speed	10～16m/min		8～13m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	2,000	～0.04	1,900	～0.04
3	1,330	～0.04	1,250	～0.04
4	1,000	～0.04	950	～0.04
5	800	～0.04	750	～0.04
6	670	～0.04	630	～0.04
8	500	～0.04	480	～0.04
10	400	～0.04	380	～0.04
12	330	～0.04	320	～0.04

1.请使用稀释倍率为5~10倍的优质水溶性切削油剂。
2.请使用精度高，夹持力好的夹具。
3.孔深超过直径3倍时，请使用阶梯式进给。
4.若加工材料切屑容易缠绕钻头，请使用阶梯式进给。



1. Use a water-soluble coolant with high density (5~10 times dilution).
2. Tight clamping is critical.
3. For drilling depth > 3D, use a step feed.
4. For materials susceptible to chip packing in the flute, apply a step feed.

形状尺寸表 SPECIFICATION CHARTS
SH-DRL ▶ P.214

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

SH-DRL

加工材料 Work Material	SKT・SKD61 50～55HRC		SKD11・SKT・SUS440 55～60HRC		SKH・SKD11・SKS 60～70HRC	
切削速度 Cutting Speed	14～22m/min		10～16m/min		8～13m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	2,860	～0.04	2,000	～0.04	1,900	～0.03
3	1,900	～0.04	1,330	～0.04	1,250	～0.04
4	1,430	～0.04	1,000	～0.04	950	～0.04
5	1,150	～0.04	800	～0.04	750	～0.04
6	960	～0.04	670	～0.04	630	～0.04
8	720	～0.04	500	～0.04	480	～0.04
10	570	～0.04	400	～0.04	380	～0.04
12	480	～0.04	330	～0.04	320	～0.04
14.1	435	～0.04	280	～0.04	270	～0.04
16.1	380	～0.04	250	～0.04	240	～0.04
17.6	325	～0.04	235	～0.04	190	～0.04
18.6	310	～0.04	220	～0.04	180	～0.04

1.请使用稀释倍率为5~10倍的优质水溶性切削油剂。
2.请使用精度高，夹持力好的夹具。
3.孔深超过直径3倍时，请使用阶梯式进给。
4.若加工材料切屑容易缠绕钻头，请使用阶梯式进给。

1. Use a water-soluble coolant with high density (5~10 times dilution).
2. Tight clamping is critical.
3. For drilling depth > 3D, use a step feed.
4. For materials susceptible to chip packing in the flute, apply a step feed.

形状尺寸表 SPECIFICATION CHARTS
FHL-GDTS ▶ P.215

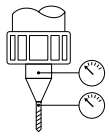
硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

FHL-GDTS

加工材料 Work Material	调质钢·预硬钢 Hardened Steel · Prehardened Steel 40～50HRC			SKT · SKD61 50～55HRC			SKD11 · SKT · SUS440 55～62HRC		
切削速度 Cutting Speed	40～50m/min			35～45m/min			30～40m/min		
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	停顿量 Step Feed (mm)
1	14,000	0.02～0.05	0.02～0.05	13,000	0.02～0.05	0.02～0.05	11,000	0.02～0.05	0.02～0.05
1.1	13,000	0.02～0.05	0.02～0.05	12,000	0.02～0.05	0.02～0.05	10,000	0.02～0.05	0.02～0.05
1.2	12,000	0.02～0.05	0.02～0.05	11,000	0.02～0.05	0.02～0.05	9,000	0.02～0.05	0.02～0.05
1.3	11,000	0.02～0.05	0.02～0.05	10,000	0.02～0.05	0.02～0.05	8,600	0.02～0.05	0.02～0.05
1.4	10,000	0.02～0.05	0.02～0.05	9,000	0.02～0.05	0.02～0.05	8,000	0.02～0.05	0.02～0.05
1.5	9,500	0.02～0.05	0.02～0.05	8,500	0.02～0.05	0.02～0.05	7,400	0.02～0.05	0.02～0.05
1.6	9,000	0.02～0.05	0.02～0.05	8,000	0.02～0.05	0.02～0.05	7,000	0.02～0.05	0.02～0.05
1.7	8,400	0.02～0.05	0.02～0.05	7,500	0.02～0.05	0.02～0.05	6,600	0.02～0.05	0.02～0.05
1.8	8,000	0.02～0.05	0.02～0.05	7,100	0.02～0.05	0.02～0.05	6,200	0.02～0.05	0.02～0.05
1.9	7,500	0.02～0.05	0.02～0.05	6,700	0.02～0.05	0.02～0.05	5,900	0.02～0.05	0.02～0.05
2	7,200	0.02～0.05	0.02～0.05	6,400	0.02～0.05	0.02～0.05	5,600	0.02～0.05	0.02～0.05
2.5	5,700	0.02～0.05	0.02～0.05	5,100	0.02～0.05	0.02～0.05	4,500	0.02～0.05	0.02～0.05
3	4,800	0.02～0.05	0.02～0.05	4,200	0.02～0.05	0.02～0.05	3,700	0.02～0.05	0.02～0.05

1. 请使用主轴回转精度好的机械。
2. 此切削条件基准表适用于水溶性切削油剂。
3. 请使用稀释倍率20倍左右的优质水溶性切削油剂。
4. 推荐使用相同直径的FH-GDS作为FH-GDTS的导向孔加工。
5. 安装时的振动精度请如右图所示使夹头本体圆筒部或柄部处于0.002mm 以下。(特别φ0.5以下)
6. 热膨胀刀柄较为有效。

注1: 机械转速未达到上述切削速度时，请尽可能使用高转速。但是，可能会降低刀具寿命。



1. Please use in a machine with precise spindle rotation.
2. The indicated speeds and feeds are for drilling with water-soluble coolant.
3. Please use water-soluble high density coolant (20 times dilution).
4. We recommend FH-GDS for the pilot hole operation prior to FHL-GDTS.
5. The run out with a drill in a spindle should be less than 0.002mm, as in the picture. (especially, for drills less than 0.5mm)
6. The shrink fit system is effective holder.

Note 1. For machines that cannot achieve the speeds indicated in the above table, please set rotation as high as possible. Tool life may be decreased.

形状尺寸表 SPECIFICATION CHARTS
FTO-M-GDXL ▶ P.217

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

FTO-M-GDXL

加工材料 Work Material	碳素钢 Carbon Steel S50C		合金钢·预硬钢 Alloy Steel · Prehardened Steel (C≧0.3%) SCM440 28～34HRC		特殊钢·调质钢·预硬钢 SKD61（非调质） Special Alloy Steel · Hardened Steel · Prehardened Steel (Unquenched) 34～40HRC		特殊钢·调质钢·预硬钢 SKD61（非调质） Special Alloy Steel · Hardened Steel · Prehardened Steel (Unquenched) 40～45HRC	
切削速度 Cutting Speed	70～90m/min		50～70m/min		40～60m/min		30～40m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
4	6,300	0.1 ～0.15	4,700	0.1 ～0.15	3,900	0.1 ～0.15	2,700	0.08 ～0.13
5	5,000	0.12 ～0.18	3,800	0.12 ～0.18	3,100	0.12 ～0.18	2,200	0.1 ～0.15
6	4,200	0.14 ～0.2	3,100	0.14 ～0.2	2,600	0.14 ～0.2	1,800	0.12 ～0.18
8	3,100	0.16 ～0.24	2,300	0.16 ～0.24	1,900	0.16 ～0.24	1,400	0.14 ～0.22
10	2,500	0.18 ～0.27	1,900	0.18 ～0.27	1,500	0.18 ～0.27	1,100	0.15 ～0.25

1. 此切削条件基准表适用于水溶性切削油剂或50ml/h左右的油雾冷却。
2. 请使用稀释20倍左右的优质水溶性切削油剂。
3. 使用油性切削油剂时，将切削速度设定在最低值的70% 左右。
4. 请按照资料「FTO-GDXL /FTO-M-GDXL / FTO-H-GDXL的推荐加工方法」进行导向孔加工。
5. 对于低碳素钢、碳素钢和合金钢的加工，如果满足以下条件，进给量可以达到（钻头直径×0.08）。
   - 机械刚性高　・无干涉孔
   - 夹持条件好　・冷却液压力高
6. 加工高硬度材料时请进行1D~2D的阶梯式加工。
7. 退刀时为斜面或曲面等的场合，请将贯穿时的进给调整至0.05 ~ 0.1mm/rev。
8. 油污堵塞会造成折损，因此供油装置请务必安装过滤网。

1. The indicated speeds and feeds are for drilling with water-soluble coolant or mist (approx. 50ml/hour).
2. Suitable cutting fluid is water-soluble high density coolant (20 times dilution).
3. When using non-water-soluble coolant, set the drilling speed between 70-100% of the lowest limit.
4. Make a pilot hole before using FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL in accordance with recommended operation.
5. A feed rate of 8% of drill diameter is obtainable in Low Carbon Steels, Carbon Steels and Alloy Steels under the following conditions:
   - A machine with high rigidity　・No interrupting holes
   - Stable, rigid clamping　・High pressure coolant supply
6. 1D~2D step feeding is required for drilling high hardened steels.
7. When coming through to an inclined or curved surface, set to the feed to 0.05~0.1mm/rev at the time of perforation.
8. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

■ FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL的推荐加工方法

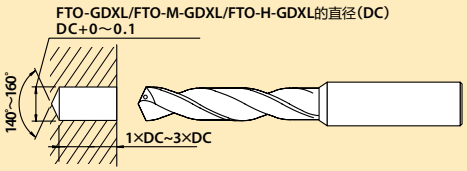
Recommended operation for using FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL

①使用ADO-3D/5D,ADO-PLT进行导向孔加工

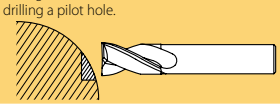
Make a pilot hole with the ADO-3D/5D or ADO-PLT.

●导向孔加工用工具请选择比FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL的直径（DC）+0~+0.1mm的钻头。
推荐在加工时将导向孔尽量加深。

For a pilot hole, select 0 - 0.1mm larger size drill than FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL.

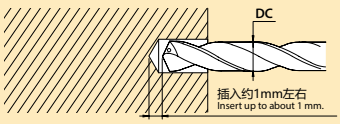


★弯曲部加工时，在导向孔加工前请先用FX-ZDS沉孔加工铣刀或ADF硬质合金平头钻进行沉孔加工。
When working on a curved surface, use the FX-ZDS (end mill for counterboring) or the ADF (carbide flat drill) to counterbore a flat surface before drilling a pilot hole.



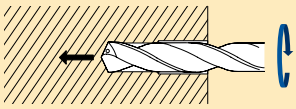
②FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL以转速(n) = 300～500min^{-1}左右，进给速度(Vf) = 300～500mm/min 插入

Insert the long drill at a speed of (n) = 300 to 500 min^{-1} and a feed rate of (Vf) = 300 to 500 mm/min.



③加速至规定转速后开始加工

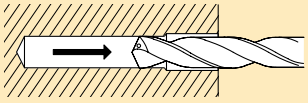
Increase the revolution to the designated speed and start drilling.



加工通孔时，请在拔出时降低进给量至（f）= 0.05～0.1mm/rev.
When drilling through holes, reduce the feed rate to (f) 0.05 to 0.1 mm/rev.

④加工后，拔出钻头时，请降低转速至(n)=300～500min^{-1}・进给速度(Vf) = 1,000 ～3,000mm/min左右拔出

After drilling, reduce the speed to (n) = 300 to 500 min^{-1} and a feed rate of (Vf) = 1,000 to 3,000 mm/min and pull the drill out of the hole.



※请务必使用内冷方式进行加工。

Make sure to use an internal coolant supply when drilling.

硬质合金钻头切削条件基准表 CARBIDE DRILLS CUTTING CONDITIONS

FTO-H-GDXL

加工材料 Work Material	SKD61、SKD11、DAC55、DH31、STAVAX、ORVAR等					
加工材料硬度 Hardness Of Work Material	45～50HRC		50～53HRC		53～56HRC	
切削速度 Cutting Speed	25 ～35m/min		25 ～35m/min		20 ～30m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
6	1,600	0.05～0.07	1,600	0.05～0.07	1,350	0.04～0.06
8	1,200	0.07～0.09	1,200	0.07～0.09	995	0.05～0.07
10	955	0.09～0.11	955	0.09～0.11	795	0.07～0.09

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释20倍左右的优质水溶性切削油剂。
3. 使用油性切削油剂时，将切削速度设定在最低值的70% 左右。
4. 请按照资料「 FTO-GDXL /FTO-M-GDXL / FTO-H-GDXL的推荐加工方法」进行导向孔加工。
5. 请进行1D~3D的阶梯式加工。
6. 使用高压冷却时，也可进行啄钻加工或超过3D 的阶梯式加工。
7. 退刀时为斜面或曲面等的场合，请将贯穿时的进给调整至0.05 ~ 0.1mm/rev。
8. 油污堵塞会造成折损，因此供油装置请务必安装过滤网。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. Suitable cutting fluid is water-soluble high density coolant (20 times dilution).
3. When using non-water-soluble coolant, set the drilling speed between 70-100% of the lowest limit.
4. Make a pilot hole before using FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL in accordance with recommended operation.
5. 1D~3D step feeding is required.
6. When it is used with high-pressure coolant, it can perform peck drilling, or step drilling of holes exceeding 3 times the drill diameter.
7. When coming through to an inclined or curved surface, set to the feed to 0.05~0.1mm/rev at the time of perforation.
8. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

■ FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL的推荐加工方法

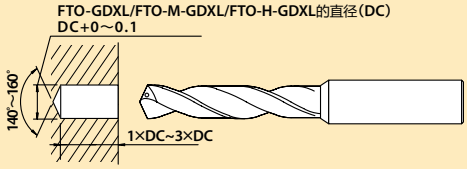
Recommended operation for using FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL

①使用ADO-3D/5D,ADO-PLT进行导向孔加工

Make a pilot hole with the ADO-3D/5D or ADO-PLT.

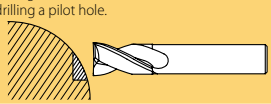
●导向孔加工用工具请选择比FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL的直径（DC）+0~+0.1mm的钻头。推荐在加工时将导向孔尽量加深。

For a pilot hole, select 0 - 0.1mm larger size drill than FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL.



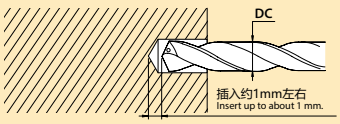
★弯曲部加工时，在导向孔加工前请先用FX-ZDS沉孔加工铣刀或ADF硬质合金平头钻进行沉孔加工。

When working on a curved surface, use the FX-ZDS (end mill for counterboring)or the ADF (carbide flat drill) to counterbore a flat surface before drilling a pilot hole.



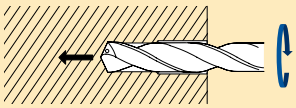
②FTO-GDXL/FTO-M-GDXL/FTO-H-GDXL以转速(n)= 300～500min^{-1}左右，进给速度(Vf)=300～500mm/min 插入

Insert the long drill at a speed of (n) = 300 to 500 min^{-1} and a feed rate of (Vf) = 300 to 500 mm/min.



③加速至规定转速后开始加工

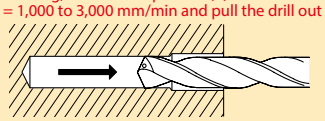
Increase the revolution to the designated speed and start drilling.



加工通孔时，请在拔出时降低进给量至（f）= 0.05～0.1mm/rev.
When drilling through holes, reduce the feed rate to (f) 0.05 to 0.1 mm/rev.

④加工后，拔出钻头时，请降低转速至(n)=300～500min^{-1}・进给速度(Vf)=1,000 ～3,000mm/min左右拔出

After drilling, reduce the speed to (n) = 300 to 500 min^{-1} and a feed rate of (Vf) = 1,000 to 3,000 mm/min and pull the drill out of the hole.



※请务必使用内冷方式进行加工。

Make sure to use an internal coolant supply when drilling.

形状尺寸表 SPECIFICATION CHARTS PXD ▶ P.221
形状尺寸表 SPECIFICATION CHARTS PXDZ ▶ P.219

可转位式钻头切削条件基准表 INDEXABLE DRILLS CUTTING CONDITIONS

PXD/PXDZ

	PC(钢用) For Steel						KC(铸铁用) For Cast Iron				NC(非铁用) For Nonferrous Metal	
加工材料 Work Material	软钢・低碳素钢 Mildsteels・Low Carbon Steel SS400・S10C ～150HB ～500N/㎟		碳素钢 Carbon Steel S35C・S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM・SCr・SNCM 16～30HRC 710～950N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD450・FCD600 400～600N/㎟		铸造铝合金 Aluminum Alloy Casting AC4A・ADC	
切削速度 Cutting Speed	80～120m/min		80～120m/min		60～120m/min		80～120m/min		60～100m/min		80～180m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
14	2,300	0.21～0.35	2,300	0.21～0.35	2,000	0.21～0.35	2,300	0.21～0.35	1,800	0.21～0.35	3,000	0.28～0.42
15	2,100	0.23～0.38	2,100	0.23～0.38	1,900	0.23～0.38	2,100	0.23～0.38	1,700	0.23～0.38	2,800	0.3～0.45
16	2,000	0.24～0.4	2,000	0.24～0.4	1,800	0.24～0.4	2,000	0.24～0.4	1,600	0.24～0.4	2,600	0.32～0.48
17	1,900	0.26～0.43	1,900	0.26～0.43	1,700	0.26～0.43	1,900	0.26～0.43	1,500	0.26～0.43	2,400	0.34～0.51
18	1,800	0.27～0.45	1,800	0.27～0.45	1,600	0.27～0.45	1,800	0.27～0.45	1,400	0.27～0.45	2,300	0.36～0.54
19	1,700	0.29～0.48	1,700	0.29～0.48	1,500	0.29～0.48	1,700	0.29～0.48	1,300	0.29～0.48	2,200	0.38～0.57
20	1,600	0.3～0.5	1,600	0.3～0.5	1,400	0.3～0.5	1,600	0.3～0.5	1,300	0.3～0.5	2,100	0.4～0.6
21	1,500	0.32～0.53	1,500	0.32～0.53	1,400	0.32～0.53	1,500	0.32～0.53	1,200	0.32～0.53	2,000	0.42～0.63
22	1,400	0.33～0.55	1,400	0.33～0.55	1,300	0.33～0.55	1,400	0.33～0.55	1,200	0.33～0.55	1,900	0.44～0.66
23	1,400	0.35～0.58	1,400	0.35～0.58	1,200	0.35～0.58	1,400	0.35～0.58	1,100	0.35～0.58	1,800	0.46～0.69
24	1,300	0.36～0.6	1,300	0.36～0.6	1,200	0.36～0.6	1,300	0.36～0.6	1,100	0.36～0.6	1,700	0.48～0.72
25	1,300	0.38～0.63	1,300	0.38～0.63	1,100	0.38～0.63	1,300	0.38～0.63	1,000	0.38～0.63	1,700	0.5～0.75

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍左右的优质水溶性切削油剂。
3. 请保持加工材料在不变形、不弯曲、不振动的状态下。
4. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器

1. The indicated speeds and feeds are for water-soluble coolant.
2. Suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
4. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

可转位式钻头切削条件基准表 INDEXABLE DRILLS CUTTING CONDITIONS

PHP

	加工材料 Work Material	抗损强度·硬度 Tensile Strength·Hardness	切削速度 Vc (m/min) Cutting Speed	进给量 f (mm/rev) Feed Rate			
				ø14 ～ ø20.5	ø21 ～ ø28	ø29 ～ ø34	ø35 ～ ø40
P	软钢·低碳素钢 Mild Steel·Carbon Steel (SS400·S10C)	～180HB	200 (60 ～250)	0.09 (0.06 ～0.13)	0.13 (0.1 ～0.18)	0.18 (0.13 ～0.21)	0.25 (0.2 ～0.27)
	碳素钢·合金钢 Carbon Steel·Alloy Steel (S50C·SCM440)	～280HB	160 (40 ～220)	0.09 (0.06 ～0.13)	0.13 (0.1 ～0.18)	0.18 (0.13 ～0.21)	0.25 (0.2 ～0.27)
	模具钢 Die Steel (SKD11·SKD61)	～280HB	140 (40 ～180)	0.08 (0.05 ～0.12)	0.12 (0.06 ～0.15)	0.14 (0.09 ～0.18)	0.15 (0.1 ～0.2)
M	不锈钢 Stainless Steel (SUS304·SUS420)	～250HB	150 (60 ～180)	0.08 (0.05 ～0.12)	0.1 (0.06 ～0.12)	0.15 (0.1 ～0.17)	0.18 (0.15 ～0.2)
K	铸铁 Cast Iron (FC250)	～350N/mm²	150 (60 ～180)	0.09 (0.06 ～0.13)	0.13 (0.1 ～0.18)	0.18 (0.13 ～0.21)	0.25 (0.2 ～0.27)
	球墨铸铁 Ductile Cast Iron (FCD400)	～800N/mm²	130 (40 ～150)	0.09 (0.06 ～0.13)	0.12 (0.08 ～0.16)	0.16 (0.1 ～0.2)	0.2 (0.15 ～0.25)
N	铝合金 Aluminum Alloys	～13%Si	220 (100 ～800)	0.09 (0.06 ～0.2)	0.13 (0.1 ～0.25)	0.18 (0.13 ～0.3)	0.25 (0.2 ～0.35)
S	耐热合金(湿式) Heat Resistant Alloys(Wet) (Inconel 718)	–	30 (15 ～50)	0.04 (0.02 ～0.06)	0.06 (0.03 ～0.1)	0.08 (0.04 ～0.12)	0.1 (0.06 ～0.14)
	钛合金(湿式) Titanium Alloy(Wet) (Ti-6Al-4V)	–	60 (30 ～100)	0.06 (0.04 ～0.08)	0.08 (0.06 ～0.12)	0.1 (0.08 ～0.15)	0.12 (0.1 ～0.15)

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释20倍以下的优质水溶性切削油剂。
3. 不推荐使用油性切削油剂。
4. 此切削条件基准表适用于孔深3D 以下的加工。
5. 安装刀片时，请确保在整洁干净的状态下牢固安装。
6. 请保持加工材料在不变形、不弯曲、不振动的状态下。
7. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器

1. The indicated speeds and feeds are for water-soluble coolant.
2. Suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. Using non-water-soluble coolant is not recommended.
4. These conditions are for drilling depth less than 3 times the drill diameter.
5. Inserts should be attached to the holder tightly in a very neat condition.
6. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
7. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

■按加工材料推荐材质 Recommended Materials by Application

◎第一推荐材质 First recommended material
○第二推荐材质 Second recommended material

刀片材质 Inserts Grades	断屑槽 Insert Breaker	切削油剂 Coolant	P	M	K	N	S	H
XP9040	DM	有 Wet	◎	◎		◎	○	
XC9025	DM	有 Wet	○	○	◎	○		

DM: 钻头中切削用
DM:Center Cutting Type Drill

形状尺寸表 SPECIFICATION CHARTS P2D ▶ P.229
形状尺寸表 SPECIFICATION CHARTS P3D ▶ P.231
形状尺寸表 SPECIFICATION CHARTS P4D ▶ P.233
形状尺寸表 SPECIFICATION CHARTS P5D ▶ P.235

可转位式钻头切削条件基准表 INDEXABLE DRILLS CUTTING CONDITIONS

P2D/P3D/P4D/P5D

	加工材料 Work Material	抗损强度·硬度 Tensile Strength·Hardness	切削速度 Vc (m/min) Drilling Speed	进给量 f (mm/rev) Feed Rate 加工深度 2D 3D Depth of Cut 2× Dia, 3× Dia							
				ø12～ø14.5	ø15～ø16.5	ø17～ø18.5	ø19～ø20.5	ø21～ø24.5	ø25～ø28.5	ø29～ø33.5	ø34～ø63
P	软钢、低碳素钢 Mild Steel、Carbon Steel (SS400、S10C)	～180HB	200 (150～250)	0.06 (0.04～0.08)	0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.07 (0.04～0.1)	0.08 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.05～0.15)	0.1 (0.05～0.18)
P	碳素钢、合金钢 Carbon Steel、Alloy Steel (S50C、SCM440)	～280HB	150 (100～220)	0.08 (0.04～0.12)	0.08 (0.04～0.14)	0.09 (0.04～0.16)	0.1 (0.04～0.18)	0.14 (0.04～0.2)	0.18 (0.06～0.25)	0.2 (0.08～0.3)	0.2 (0.08～0.35)
P	模具钢 Die Steel (SKD11、SKD61)	～280HB	120 (80～180)	0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.07 (0.04～0.1)	0.08 (0.04～0.12)	0.12 (0.04～0.15)	0.14 (0.06～0.2)	0.18 (0.08～0.25)	0.18 (0.08～0.25)
M	不锈钢 Stainless Steel (SUS304、SUS420)	～250HB	130 (80～180)	0.07 (0.04～0.1)	0.07 (0.04～0.1)	0.08 (0.04～0.1)	0.09 (0.04～0.12)	0.1 (0.04～0.15)	0.13 (0.06～0.2)	0.15 (0.08～0.25)	0.15 (0.08～0.25)
K	铸铁 Cast Iron (FC250)	～350N/mm²	200 (150～280)	0.08 (0.04～0.14)	0.08 (0.04～0.14)	0.1 (0.04～0.16)	0.12 (0.04～0.2)	0.16 (0.08～0.25)	0.2 (0.06～0.3)	0.2 (0.08～0.3)	0.2 (0.08～0.35)
K	球墨铸铁 Ductile Cast Iron (FCD400)	～800N/mm²	160 (100～220)	0.08 (0.04～0.1)	0.08 (0.04～0.12)	0.09 (0.04～0.14)	0.1 (0.04～0.18)	0.14 (0.04～0.2)	0.18 (0.06～0.25)	0.18 (0.08～0.25)	0.18 (0.08～0.25)
N	铝合金 Aluminum Alloy	～13%Si	200 (100～800)	0.08 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.04～0.16)	0.12 (0.04～0.2)	0.16 (0.04～0.25)	0.2 (0.06～0.3)	0.2 (0.08～0.3)	0.2 (0.08～0.3)
S	超耐热合金 Supperalloy (Inconel718)	—	50 (15～60)	0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.05 (0.03～0.06)	0.05 (0.03～0.06)	0.06 (0.04～0.08)	0.08 (0.06～0.1)	0.1 (0.06～0.12)	0.1 (0.06～0.12)
S	钛合金 Titanium Alloy (Ti－6AL-4V)	—	60 (30～100)	0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.08 (0.04～0.15)	0.1 (0.06～0.2)	0.14 (0.08～0.2)	0.14 (0.08～0.2)
H	预硬钢 Pre-hardened Steel (NAK80)	40～43HRC	100 (60～120)	0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.06 (0.04～0.12)	0.07 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.06～0.15)	0.1 (0.06～0.15)	0.1 (0.06～0.15)
H	调质钢 Hardened Steel (SKD11)	50～55HRC	60 (40～80)	0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.08 (0.04～0.1)	0.08 (0.04～0.1)	0.08 (0.04～0.1)

1. 此切削条件基准表是以水溶性切屑油剂作为内部供油。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 不推荐使用油性切削油剂。
4. 此切削条件基准表的数值是根据实际切削速度的标准数据。
   请根据加工环境适当的调整。
5. 安装刀片时，请确保在整洁干净的状态下牢固安装。
6. 请保持加工材料在不变形、不弯曲、不振动的状态下。
7. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。

1. The indicated speeds and feeds are for using water-soluble coolant with inner supply.
2. Suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. Using non-water-soluble coolant is not recommended.
4. The above cutting conditions are to be used as general guidelines. Adjustments may be necessary depending on actual cutting condition.
5. Inserts should be attached to the holder tightly in a very neat condition.
6. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
7. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

可转位钻头切削条件基准表 INDEXABLE DRILLS CUTTING CONDITIONS

P2D/P3D/P4D/P5D

进给量 f (mm/rev)
Feed Rate

加工深度 4D Depth of Cut 4× Dia							
ø12～ø14.5	ø15～ø16.5	ø17～ø18.5	ø19～ø20.5	ø21～ø24.5	ø25～ø28.5	ø29～ø33.5	ø34～ø63
0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.07 (0.04～0.1)	0.08 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.05～0.15)	0.1 (0.05～0.18)
0.07 (0.04～0.1)	0.08 (0.04～0.14)	0.08 (0.04～0.16)	0.09 (0.04～0.18)	0.12 (0.04～0.15)	0.18 (0.06～0.25)	0.2 (0.08～0.25)	0.2 (0.08～0.3)
0.06 (0.04～0.08)	0.06 (0.04～0.1)	0.07 (0.04～0.1)	0.08 (0.04～0.12)	0.1 (0.04～0.13)	0.14 (0.06～0.2)	0.18 (0.08～0.25)	0.18 (0.08～0.25)
0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.07 (0.04～0.1)	0.08 (0.04～0.1)	0.08 (0.04～0.1)	0.13 (0.06～0.2)	0.15 (0.08～0.2)	0.15 (0.08～0.2)
0.08 (0.04～0.12)	0.08 (0.04～0.14)	0.09 (0.04～0.16)	0.1 (0.04～0.2)	0.12 (0.04～0.15)	0.2 (0.06～0.3)	0.2 (0.08～0.3)	0.2 (0.08～0.3)
0.08 (0.04～0.1)	0.08 (0.04～0.1)	0.08 (0.04～0.12)	0.09 (0.04～0.15)	0.12 (0.04～0.15)	0.15 (0.06～0.25)	0.18 (0.08～0.25)	0.18 (0.08～0.25)
0.07 (0.04～0.12)	0.07 (0.04～0.12)	0.09 (0.04～0.12)	0.12 (0.04～0.2)	0.14 (0.04～0.2)	0.2 (0.06～0.3)	0.2 (0.08～0.3)	0.2 (0.08～0.3)
0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.05 (0.04～0.08)	0.07 (0.06～0.1)	0.08 (0.06～0.12)	0.08 (0.06～0.12)
0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.08 (0.04～0.1)	0.1 (0.06～0.2)	0.14 (0.08～0.2)	0.14 (0.08～0.2)
0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.08 (0.04～0.12)	0.08 (0.06～0.12)	0.1 (0.06～0.13)	0.1 (0.06～0.13)
0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.08 (0.04～0.1)	0.08 (0.04～0.1)	0.08 (0.04～0.1)

加工深度 5D Depth of Cut 5× Dia							
ø12～ø14.5	ø15～ø16.5	ø17～ø18.5	ø19～ø20.5	ø21～ø24.5	ø25～ø28.5	ø29～ø33.5	ø34～ø63
0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.07 (0.04～0.1)	0.08 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.05～0.15)	0.1 (0.05～0.18)
0.06 (0.04～0.09)	0.06 (0.04～0.09)	0.08 (0.04～0.12)	0.08 (0.04～0.14)	0.12 (0.04～0.15)	0.15 (0.06～0.2)	0.18 (0.08～0.2)	0.18 (0.08～0.25)
0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.07 (0.04～0.1)	0.1 (0.04～0.13)	0.12 (0.06～0.15)	0.15 (0.08～0.18)	0.16 (0.08～0.22)
0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.07 (0.04～0.09)	0.08 (0.04～0.1)	0.1 (0.06～0.15)	0.12 (0.06～0.18)	0.12 (0.06～0.2)
0.06 (0.04～0.08)	0.06 (0.04～0.1)	0.08 (0.04～0.12)	0.08 (0.04～0.13)	0.12 (0.04～0.15)	0.15 (0.06～0.2)	0.18 (0.08～0.2)	0.18 (0.08～0.25)
0.06 (0.04～0.09)	0.06 (0.04～0.09)	0.08 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.04～0.13)	0.12 (0.06～0.15)	0.15 (0.08～0.18)	0.18 (0.08～0.25)
0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.09 (0.04～0.12)	0.1 (0.04～0.15)	0.12 (0.04～0.15)	0.15 (0.06～0.25)	0.2 (0.08～0.3)	0.2 (0.08～0.3)
0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.04 (0.02～0.06)	0.07 (0.06～0.08)	0.07 (0.06～0.08)	0.07 (0.06～0.08)
0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.1)	0.08 (0.06～0.15)	0.1 (0.08～0.15)	0.1 (0.08～0.15)
0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.08 (0.04～0.1)	0.08 (0.06～0.12)	0.1 (0.06～0.12)	0.1 (0.06～0.12)
0.05 (0.04～0.07)	0.05 (0.04～0.07)	0.05 (0.04～0.07)	0.06 (0.04～0.07)	0.06 (0.04～0.08)	0.07 (0.04～0.1)	0.08 (0.04～0.1)	0.08 (0.04～0.1)

■按加工材料推荐材质
Recommended Materials by Insert Type

◎第一推荐材质 Best
○第二推荐材质 Good

刀片材质 Insert Grades	断屑槽 Insert Breaker	切削油剂 Coolant	P	M	K	N	S	H
XP9020	DM	有 Wet	◎	◎	○	○	○	○
XP1010	DR	有 Wet	○		◎			
CK110	DN	有 Wet				◎		

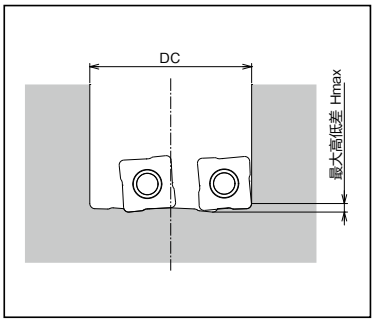
■外周刃专用刀片
Inserts for Peripheral Cutting Edge

◎第一推荐材质 Best
○第二推荐材质 Good

刀片材质 Insert Grades	断屑槽 Insert Breaker	切削油剂 Coolant	P	M	K	N	S	H
XC9015	DM	有 Wet	◎		◎			

■PD 孔底高低差的参考值
Reference value of PD Hmax

钻头径 Drill Dia.	Hmax (mm)
φ12～φ14.5	0.6
φ15～φ16.5	0.8
φ17～φ18.5	0.9
φ19～φ20.5	1.1
φ21～φ24.5	1.2
φ25～φ28.5	1.5
φ29～φ33.5	1.6
φ34～φ38	1.7
φ39～φ44	2
φ45～φ49	2.3
φ50～φ56	2.5
φ57～φ63	2.6



■加工孔径的参考值
Reference Value of Hole Diameter

单位：mm Unit: mm

外径 DC	P2D · P3D	P4D · P5D
φ12～φ20.5	+0.25 0	+0.3 0
φ21～φ49	+0.3 0	+0.4 0
φ50～φ63	+0.35 0	+0.5 0

上述为推荐条件下的标准值。视加工环境会有所不同。
The above values are general recommendation and may differ based on actual machining condition.

形状尺寸表 SPECIFICATION CHARTS
PDZ ▶ P.239

可转位式钻头切削条件基准表 INDEXABLE DRILLS CUTTING CONDITIONS

PDZ

	加工材料 Work Material	抗损强度·硬度 Tensile Strength·Hardness	切削速度 Vc (m/min) Cutting Speed	进给量 f (mm/rev) Feed Rate						
				φ16～φ16.5	φ17～φ18.5	φ19～φ20	φ21～φ24	φ25～φ28	φ29～φ33	φ34～φ43
P	软钢、低碳素钢 Mild Steel、Carbon Steel (SS400、S10C)	～180HB	200 (150～250)	0.06 (0.04～0.1)	0.06 (0.04～0.1)	0.07 (0.04～0.1)	0.08 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.05～0.15)	0.1 (0.05～0.18)
P	碳素钢、合金钢 Carbon Steel、Alloy Steel (S50C、SCM440)	～280HB	150 (100～220)	0.08 (0.04～0.14)	0.09 (0.04～0.16)	0.1 (0.04～0.18)	0.14 (0.04～0.2)	0.18 (0.06～0.25)	0.2 (0.08～0.3)	0.2 (0.08～0.35)
P	模具钢 Die Steel (SKD11、SKD61)	～280HB	120 (80～180)	0.06 (0.04～0.1)	0.07 (0.04～0.1)	0.08 (0.04～0.12)	0.12 (0.04～0.15)	0.14 (0.06～0.2)	0.18 (0.08～0.25)	0.18 (0.08～0.25)
M	不锈钢 Stainless Steel (SUS304、SUS420)	～250HB	130 (80～180)	0.07 (0.04～0.1)	0.08 (0.04～0.1)	0.09 (0.04～0.12)	0.1 (0.04～0.15)	0.13 (0.06～0.2)	0.15 (0.08～0.25)	0.15 (0.08～0.25)
K	铸铁 Cast Iron (FC250)	～350N/mm²	200 (150～280)	0.08 (0.04～0.14)	0.1 (0.04～0.16)	0.12 (0.04～0.2)	0.16 (0.08～0.25)	0.2 (0.06～0.3)	0.2 (0.08～0.3)	0.2 (0.08～0.35)
K	球墨铸铁 Ductile Cast Iron (FCD400)	～800N/mm²	160 (100～220)	0.08 (0.04～0.12)	0.09 (0.04～0.14)	0.1 (0.04～0.18)	0.14 (0.04～0.2)	0.18 (0.06～0.25)	0.18 (0.08～0.25)	0.18 (0.08～0.25)
N	铝合金 Aluminum Alloy	～13%Si	200 (100～800)	0.08 (0.04～0.12)	0.1 (0.04～0.16)	0.12 (0.04～0.2)	0.16 (0.04～0.25)	0.2 (0.06～0.3)	0.2 (0.08～0.3)	0.2 (0.08～0.3)
S	超耐热合金 Supperalloy (Inconel 718)	–	50 (15～60)	0.04 (0.02～0.06)	0.05 (0.03～0.06)	0.05 (0.03～0.06)	0.06 (0.04～0.08)	0.08 (0.06～0.1)	0.1 (0.06～0.12)	0.1 (0.06～0.12)
S	钛合金 Titanium Alloy (Ti－6AL-4V)	–	60 (30～100)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.08 (0.04～0.15)	0.1 (0.06～0.2)	0.14 (0.08～0.2)	0.14 (0.08～0.2)
H	预硬钢 Pre-hardened Steel (NAK80)	40～43HRC	100 (60～120)	0.06 (0.04～0.1)	0.06 (0.04～0.12)	0.07 (0.04～0.12)	0.08 (0.04～0.12)	0.1 (0.06～0.15)	0.1 (0.06～0.15)	0.1 (0.06～0.15)
H	调质钢 Hardened Steel (SKD11)	50～55HRC	60 (40～80)	0.05 (0.04～0.08)	0.05 (0.04～0.08)	0.06 (0.04～0.08)	0.06 (0.04～0.08)	0.08 (0.04～0.1)	0.08 (0.04～0.1)	0.08 (0.04～0.1)

1. 此切削条件基准表是以水溶性切屑油剂作为内部供油。
2. 请使用稀释倍率20倍以下的优质水溶性切屑油剂。
3. 不推荐使用油性切削油剂。
4. 此切削条件表是根据实际切削速度的标准数据。
   请根据加工环境适当调整
5. 安装刀片时，请确保在整洁干净的状态下牢固安装。
6. 请保持加工材料在不变形、不弯曲、不振动的状态下。
7. 油孔堵塞是造成折损问题的原因，请务必安装供油装置的过滤器。

1. The indicated speeds and feeds are for using water-soluble coolant with inner supply.
2. Suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. Using non-water-soluble coolant is not recommended.
4. The above cutting conditions are to be used as general guidelines. Adjustments may be necessary depending on actual cutting condition.
5. Inserts should be attached to the holder tightly in a very neat condition.
6. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
7. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.

■按加工材料推荐材质
Recommended Materials by Insert Type

◎第一推荐材质 Best
○第二推荐材质 Good

刀片材质 Insert Grades	切削油剂 Coolant	P	M	K	N	S	H
XP8030	有 Wet	◎	◎	○	○	○	○

■外周刃专用刀片
Inserts for Peripheral Cutting Edge

◎第一推荐材质 Best
○第二推荐材质 Good

刀片材质 Insert Grades	切削油剂 Coolant	P	M	K	N	S	H
XC8035	无 Dry	○		◎			
	有 Wet		○				

■加工孔径的参考值
Reference Value of Hole Diameter

单位：mm　Unit：mm

外径 DC	PDZ
φ16～φ20	+0.2 −0.15
φ21～φ43	+0.25 −0.15

上述为推荐条件下的标准值。视加工环境会有所不同。
The above values are general recommendation and may differ based on actual machining condition.

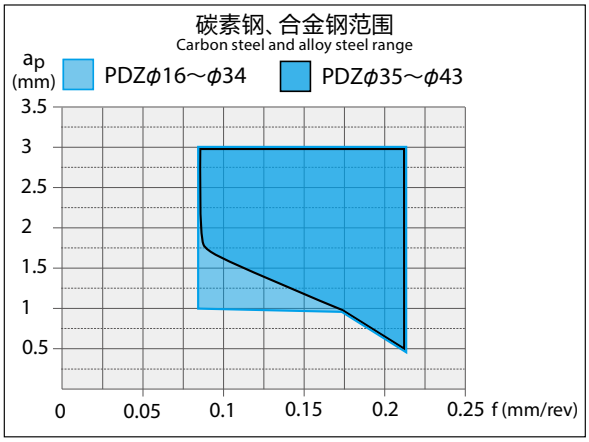
形状尺寸表 SPECIFICATION CHARTS
PDZ ▶ P.239

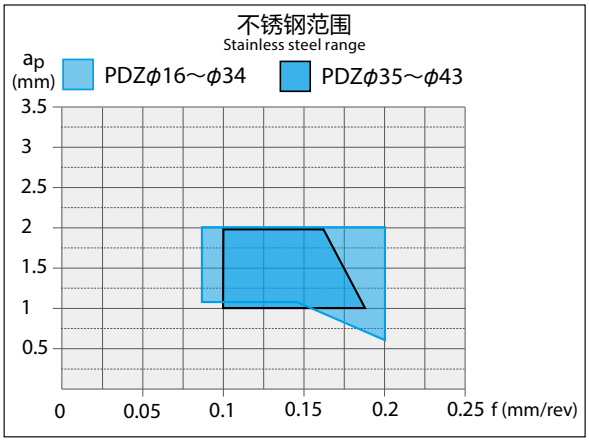
可转位式钻头切削条件基准表 INDEXABLE DRILLS CUTTING CONDITIONS

PDZ

■车削加工 Turning

内径·外径车削的切入量 / 进给条件 Cutting Conditions of Internal / External Turning





形状尺寸表 SPECIFICATION CHARTS
ED-DS ▶ P.245

金刚石钻头切削条件基准表 DIAMOND DRILLS CUTTING CONDITIONS

ED-DS

加工材料 Work Material		氧化物陶瓷 Oxide			非氧化物陶瓷 Non-Oxide			CFRP	
		氧化铝 · 氧化锌 Al_2O_3·ZrO_2			氮化硅 · 碳化硅 Si_3N_4·SiC				
磨削速度 Grinding Speed		85 ～94m/min			47 ～75m/min			50 ～200m/min	
直径 Drill Dia.		转速 Speed (min^{-1})	进给速度 Feed (mm/min)	停顿量 Step Feed (mm/step)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	停顿量 Step Feed (mm/step)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)
英寸 inch	毫米 mm								
–	**2**	13,500	3	0.1	7,500	2.5	0.05	12,000	12 ～ 60
–	**2.5**	10,800	3	0.1	6,000	2.5	0.05	9,500	9.5 ～ 47.5
–	**3**	9,000	3	0.1	5,000	2.5	0.05	8,000	8 ～ 40
–	**3.5**	7,700	3	0.1	4,650	2.5	0.05	6,800	6.8 ～ 34
–	**4**	6,800	3	0.1	4,400	2.5	0.05	6,000	6 ～ 30
–	**4.5**	6,000	3	0.1	4,200	2.5	0.05	5,300	5.3 ～ 26.5
.1910	**4.851**	5,600	3	0.1	4,000	2.5	0.05	4,900	4.9 ～ 24.5
–	**5**	5,400	3	0.1	4,000	2.5	0.05	4,800	4.8 ～ 24
–	**5.5**	5,200	3	0.1	3,900	2.5	0.05	4,300	4.3 ～ 21.5
–	**6**	5,000	5	0.1	3,700	2.5	0.05	4,000	5.6 ～ 28
1/4	**6.35**	4,700	5	0.1	3,500	2.5	0.05	3,800	5.3 ～ 26.6
–	**6.5**	4,600	5	0.1	3,400	2.5	0.05	3,700	5.2 ～ 25.9
–	**7**	4,300	5	0.1	3,200	2.5	0.05	3,400	4.8 ～ 23.8
–	**7.5**	4,000	5	0.1	2,950	2.5	0.05	3,200	4.5 ～ 22.4
–	**8**	3,750	5	0.1	2,800	2.5	0.05	3,000	5.7 ～ 27
–	**8.5**	3,500	5	0.1	2,600	2.5	0.05	2,800	5.3 ～ 25.2
–	**9**	3,300	5	0.1	2,500	2.5	0.05	2,700	5.1 ～ 24.3
–	**9.5**	3,150	5	0.1	2,350	2.5	0.05	2,500	4.8 ～ 22.5
3/8	**9.525**	3,150	5	0.1	2,350	2.5	0.05	2,500	5.3 ～ 25
–	**10**	3,000	5	0.1	2,200	2.5	0.05	2,400	5.5 ～ 28.8
–	**10.5**	2,850	5	0.1	2,100	2.5	0.05	2,300	5.3 ～ 27.6
–	**11**	2,700	5	0.1	2,000	2.5	0.05	2,200	5.1 ～ 26.4
–	**11.5**	2,600	5	0.1	1,900	2.5	0.05	2,100	4.8 ～ 25.2
–	**12**	2,500	5	0.1	1,850	2.5	0.05	2,000	5 ～ 24
–	**12.5**	2,400	5	0.1	1,750	2.5	0.05	1,900	4.8 ～ 22.8
–	**13**	2,300	5	0.1	1,700	2.5	0.05	1,800	4.9 ～ 23.4

1. CF、含 CF 复合材、陶瓷等脆材加工时，请以上表的最小值为基准调整进给速度。当发生崩损情况时，请进一步降低切削深度及进给速度。
2. 陶瓷用钻头，是研磨中心用刀具。即使是在带有螺旋辅助功能的加工中心上也可使用，但要防止切屑跑进滑动面。
3. 为了防止切屑堵塞而导致的短寿命化，请采用高压设备充分喷油。
4. 陶瓷有多种类型，且即使是相同材质也会有由于烧结方法的不同而导致寿命会有大的变化。
5. 陶瓷用钻头虽然是为了针对陶瓷加工用而开发的，也是可以适用于硬质合金。但在硬质合金钻孔加工中，它的寿命要比加工氧化铝陶瓷有着明显的下降

1. When machining brittle material such as CF/CF composite and ceramics, please reduce feed to the minimum amount on the table. If chipping occurs on cutting edge, please reduce the depth of cut and feed further.
2. ED-DS should be used with a grinding center. Even when used in a machining center with helical interpolation, chips need to be kept away from the sleeves to enable removal.
3. High pressure and sufficient coolant is required to prevent short tool life due to chips lodged in flutes.
4. There are several types of ceramic. Though the names of ceramics are same, the performance of tool is different depending on the method of sintering ceramics.
5. ED-DS can be applied to tungsten carbide as well, though its tool life in drilling operation decreases more dramatically than Al_2O_3.

形状尺寸表 SPECIFICATION CHARTS D-GDN ▶ P.243
形状尺寸表 SPECIFICATION CHARTS D-DAD ▶ P.249
形状尺寸表 SPECIFICATION CHARTS D-GDN90 ▶ P.251
形状尺寸表 SPECIFICATION CHARTS D-STAD ▶ P.248

金刚石钻头切削条件基准表 DIAMOND DRILLS CUTTING CONDITIONS

D-GDN WET DRILLING 湿式加工

加工材料 Work Material	铸造铝合金 Aluminum Alloy Casting ~13wt%Si・AC1～8・ADC		铸造铝合金 Aluminum Alloy Casting 13～20wt%Si・AC9B		铸造铝合金 Aluminum Alloy Casting 20～30wt%Si・AC9A		变形铝 Aluminum A7075・A2024		铜合金 Copper Alloy C1020・C6140		镁合金 Magnesium Alloy AZ91D	
切削速度 Cutting Speed	80～200m/min		32～63m/min		20～32m/min		80～200m/min		60～125m/min		60～160m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	20,000	0.02～0.08	5,100	0.02～0.06	4,000	0.02～0.06	20,000	0.02～0.08	10,000	0.02～0.08	16,000	0.02～0.08
3	12,000	0.03～0.1	3,600	0.03～0.09	2,650	0.03～0.09	14,000	0.03～0.1	7,500	0.03～0.1	9,600	0.03～0.1
4	10,000	0.04～0.12	2,900	0.04～0.12	2,000	0.04～0.12	11,000	0.04～0.12	6,000	0.04～0.12	8,000	0.04～0.12
5	9,000	0.05～0.14	2,400	0.05～0.14	1,600	0.05～0.14	9,000	0.05～0.14	5,000	0.05～0.14	7,200	0.05～0.14
6	8,000	0.06～0.15	2,150	0.06～0.15	1,350	0.06～0.15	7,700	0.06～0.15	4,800	0.06～0.15	6,400	0.06～0.15
7	7,000	0.07～0.16	1,800	0.07～0.16	1,150	0.07～0.16	6,800	0.07～0.16	4,600	0.07～0.16	5,600	0.07～0.16
8	6,500	0.08～0.18	1,600	0.08～0.18	1,000	0.08～0.18	6,400	0.08～0.18	4,000	0.08～0.18	5,200	0.08～0.18
9	6,000	0.09～0.19	1,400	0.09～0.19	900	0.09～0.19	5,700	0.09～0.19	3,600	0.09～0.19	4,800	0.09～0.19
10	5,500	0.1～0.2	1,300	0.1～0.2	800	0.1～0.2	5,000	0.1～0.2	3,200	0.1～0.2	4,400	0.1～0.2
11	5,000	0.11～0.22	1,200	0.11～0.22	750	0.11～0.22	4,600	0.11～0.22	2,900	0.11～0.22	4,000	0.11～0.22
12	4,500	0.12～0.24	1,100	0.12～0.24	700	0.12～0.24	4,300	0.12～0.24	2,700	0.12～0.24	3,600	0.12～0.24

1. 此切削条件基准表适用于水溶性切削油剂。
2. 此条件表适用于孔深4D 以下的场合。

1. The indicated speeds and feeds are for water-soluble coolant.
2. These conditions are for drilling depths under 4 times the drill diameter.

加工镁合金时：
1. 请在与切削油剂制造商商谈之后，务必使用镁专用油剂。
2. 使用油性切削油时，请在切削速度60~120m/min 的范围内使用。
3. 请注意切屑的处理和管理。

When a drill is used in Magnesium alloy...
1. Please use cutting fluid for Magnesium and check with a cutting fluid producer.
2. Please use this drill at 60 to 120m/min if water-immiscible cutting fluid is used.
3. Please be careful of control and disposition of chips.

D-DAD/D-GDN90/D-STAD CFRP DRY DRILLING CFRP干式加工

加工材料 Work Material		CFRP		
直径 Drill Dia.		切削速度 Cutting Speed (m/min)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
英寸 inch	毫米 mm			
.0985	**2.502**	60～120	11,000	0.03～0.05
.1290	**3.277**		8,700	0.03～0.05
.1615	**4.102**		7,000	0.03～0.05
.1915	**4.864**		6,000	0.03～0.05
.251	**6.375**		4,500	0.05～0.1
.376	**9.55**		3,000	0.05～0.1

1. 无需切削油剂，请注意充分实施粉尘对策(真空集尘)。
2. 树脂的含油率会影响 CFRP 的切削性，另外薄板会对固定状态有所影响。参考上表，请下调贯穿薄板间隙的进给量。
3. 加工厚板时，请设定低速。
4. 使用得到许可的切削油进行湿式加工，切削速度可上调200m/min 左右。

1. Coolant is not needed, however make sure the through dust collecting settings.
2. Machinability of CFRP depends on resin type and its contents. Please adjust feed rate slowing down at the break through area on thin plate machining, referring above condition chart.
3. Please set slower feed rate at the thick plate drilling.
4. With approved coolant use, feed rate can be up to 200m/min.

形状尺寸表 SPECIFICATION CHARTS
VPH-GDS ▶ P.253

VP-黄金钻头切削条件基准表 VP-GOLD DRILLS CUTTING CONDITIONS

VPH-GDS

加工材料 Work Material	调质钢 Hardened Steel						特殊钢 Special Alloy Steel				合金钢 Alloy Steel	
	34～43HRC 1060～1400N/mm²		43～48HRC 1400～1600N/mm²		48～53HRC 1600～1900N/mm²		SKD11(非调质)～1060N/mm² (Unheated)		SKD61(非调质)～900N/mm² (Unheated)		SCM 710～900N/mm²	
切削速度 Cutting Speed	12～18m/min		6～10m/min		5～8m/min		10～16m/min		12～20m/min		25～32m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	8,000	0.005～0.013	5,000	0.005～0.01	3,800	0.005～0.01	6,400	0.01～0.025	7,600	0.01～0.025	15,000	0.01～0.025
1	4,000	0.01～0.03	2,500	0.01～0.02	1,800	0.01～0.02	3,200	0.03～0.045	5,000	0.03～0.045	8,000	0.03～0.045
2	2,550	0.02～0.04	1,250	0.02～0.04	1,050	0.02～0.04	2,100	0.06～0.09	2,550	0.06～0.09	4,500	0.06～0.09
3	1,700	0.03～0.06	850	0.03～0.06	700	0.03～0.06	1,400	0.1～0.13	1,700	0.1～0.13	3,000	0.1～0.13
4	1,250	0.04～0.08	640	0.04～0.08	520	0.04～0.08	1,030	0.11～0.15	1,270	0.11～0.15	2,250	0.11～0.15
5	1,000	0.05～0.1	510	0.05～0.1	400	0.05～0.1	830	0.12～0.18	1,020	0.12～0.18	1,800	0.12～0.18
6	850	0.06～0.12	430	0.06～0.12	350	0.06～0.12	690	0.13～0.19	850	0.13～0.19	1,500	0.13～0.19
7	730	0.07～0.14	360	0.07～0.14	260	0.07～0.14	600	0.15～0.22	730	0.15～0.22	1,300	0.15～0.22
8	640	0.08～0.16	320	0.08～0.16	230	0.08～0.16	520	0.16～0.24	640	0.16～0.24	1,100	0.16～0.24
9	570	0.09～0.18	280	0.09～0.18	210	0.09～0.18	460	0.18～0.26	570	0.18～0.26	1,000	0.18～0.26
10	510	0.1～0.2	260	0.1～0.2	200	0.1～0.2	410	0.2～0.28	510	0.2～0.28	900	0.2～0.28
11	460	0.11～0.22	230	0.11～0.22	180	0.11～0.22	380	0.22～0.31	460	0.22～0.31	820	0.22～0.31
12	430	0.12～0.24	210	0.12～0.24	170	0.12～0.24	350	0.24～0.34	430	0.24～0.34	760	0.24～0.34
13	400	0.13～0.26	200	0.13～0.26	160	0.13～0.26	320	0.26～0.36	390	0.26～0.36	700	0.26～0.36
14	340	0.14～0.28	180	0.14～0.28	150	0.14～0.26	300	0.21～0.36	360	0.21～0.36	640	0.21～0.36
15	320	0.15～0.3	170	0.15～0.3	140	0.15～0.26	280	0.23～0.38	340	0.23～0.38	590	0.23～0.38
16	300	0.16～0.32	160	0.16～0.32	130	0.16～0.26	260	0.24～0.4	320	0.24～0.4	560	0.24～0.4
17	280	0.17～0.34	150	0.17～0.34	120	0.17～0.26	240	0.26～0.43	300	0.26～0.43	520	0.26～0.43
18	270	0.18～0.36	140	0.18～0.36	115	0.18～0.27	230	0.27～0.45	280	0.27～0.45	500	0.27～0.45
19	250	0.19～0.38	130	0.19～0.38	110	0.19～0.29	220	0.29～0.48	270	0.29～0.48	470	0.29～0.48
20	240	0.2～0.4	130	0.2～0.4	100	0.2～0.3	210	0.3～0.5	260	0.3～0.5	450	0.3～0.5

加工材料 Work Material	钛合金 Ti Alloy Ti-6Al-4V (32～38HRC)		Inconel Inconel 718 (38～45HRC)		碳素钢 Carbon Steel S45C 500～710N/mm²		低碳素钢·软钢 Low Carbon Steel· Mild Steel SS400～500N/mm²		铸铁 Cast Iron FC250～350N/mm²	
切削速度 Cutting Speed	6～10m/min		6～8m/min		25～36m/min		38～50m/min		40～63m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	5,000	0.005～0.01	3,800	0.005～0.01	15,000	0.015～0.025	注1 (Note1)	0.005～0.01	注1 (Note1)	0.005～0.01
1	2,400	0.01～0.02	2,000	0.01～0.02	8,000	0.03～0.045	12,000	0.01～0.02	12,000	0.01～0.02
2	1,200	0.02～0.04	1,100	0.02～0.04	5,000	0.06～0.09	6,350	0.06～0.09	8,400	0.08～0.11
3	800	0.03～0.06	740	0.03～0.06	3,400	0.1～0.13	4,250	0.1～0.13	5,600	0.11～0.16
4	699	0.04～0.08	550	0.04～0.08	2,550	0.11～0.15	3,200	0.11～0.15	4,220	0.13～0.19
5	500	0.05～0.1	445	0.05～0.1	2,050	0.12～0.18	2,550	0.12～0.18	3,370	0.16～0.22
6	440	0.06～0.12	370	0.06～0.12	1,700	0.13～0.19	2,100	0.13～0.19	2,800	0.19～0.26
7	350	0.07～0.14	320	0.07～0.14	1,450	0.15～0.22	1,800	0.15～0.22	2,400	0.2～0.28
8	320	0.08～0.16	280	0.08～0.16	1,270	0.16～0.24	1,600	0.16～0.24	2,100	0.21～0.3
9	280	0.09～0.18	250	0.09～0.18	1,130	0.18～0.26	1,400	0.18～0.26	1,900	0.23～0.33
10	260	0.1～0.2	220	0.1～0.2	1,000	0.2～0.28	1,270	0.2～0.28	1,700	0.25～0.36
11	230	0.11～0.22	200	0.11～0.22	930	0.22～0.31	1,150	0.22～0.31	1,550	0.28～0.39
12	210	0.12～0.24	190	0.12～0.24	850	0.24～0.34	1,060	0.24～0.34	1,400	0.3～0.42
13	200	0.13～0.26	170	0.13～0.26	785	0.26～0.36	980	0.26～0.36	1,300	0.31～0.42
14	–	–	–	–	730	0.28～0.39	900	0.28～0.39	1,200	0.32～0.44
15	–	–	–	–	680	–	–	–	–	–
16	–	–	–	–	640	0.3～0.43	800	0.3～0.43	1,050	0.34～0.46
17	–	–	–	–	600	–	–	–	–	–
18	–	–	–	–	570	0.34～0.49	700	0.34～0.49	950	0.36～0.5
19	–	–	–	–	540	–	–	–	–	–
20	–	–	–	–	510	0.36～0.5	650	0.36～0.5	830	0.4～0.56

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 孔深超过4倍直径时，请进行阶梯式进给，并按照下表设定切削速度。
5. 通过车床、卧式加工中心加工孔深超过3倍直径时，请使用阶梯式进给。

注1: 机械转速未达到上述切削速度时，请尽可能使用高转速。但是，可能会降低刀具寿命。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble, high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. The step process should be used when the drilling depth exceeds 4 times the drill diameter. (Using the table below)
5. Step process should be used when drilling depth of the hole exceeds 3 times drill diameter for lathe / horizontal machine.

Note 1. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible. Tool life may be decreased.

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D	6D以下 ≦6D
切削速度抑制系数 Coefficient for reducing speed	×1	×0.9	×0.7

形状尺寸表 SPECIFICATION CHARTS
VP-GDR ▶ P.261

VP-黄金钻头切削条件基准表 VP-GOLD DRILLS CUTTING CONDITIONS

VP-GDR

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/㎟		碳素钢 Carbon Steel S50C 500～710N/㎟		合金钢 Alloy Steel SCM·SCr 710～900N/㎟		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ～28HRC ～900N/㎟		SKD11 28～34HRC 900～1060N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		铸造铝合金 Aluminum Alloy Castings AC4C·ADC	
切削速度 Cutting Speed	38～50m/min		25～36m/min		25～32m/min		12～20m/min		10～16m/min		40～63m/min		70～120m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
2	6,350	0.06～0.09	5,100	0.06～0.09	4,450	0.06～0.09	2,550	0.06～0.09	2,050	0.06～0.09	8,435	0.08～0.11	15,000	0.12～0.18
3	4,250	0.1～0.13	3,400	0.1～0.13	2,970	0.1～0.13	1,700	0.1～0.13	1,370	0.1～0.13	5,620	0.11～0.16	10,000	0.2～0.28
4	3,200	0.11～0.15	2,550	0.11～0.15	2,230	0.11～0.15	1,270	0.11～0.15	1,035	0.11～0.15	4,220	0.13～0.19	8,000	0.24～0.38
5	2,550	0.12～0.18	2,040	0.12～0.18	1,780	0.12～0.18	1,020	0.12～0.18	825	0.12～0.18	3,375	0.16～0.22	6,350	0.28～0.4
6	2,100	0.13～0.19	1,700	0.13～0.19	1,490	0.13～0.19	850	0.13～0.19	690	0.13～0.19	2,810	0.19～0.26	5,300	0.34～0.48
8	1,600	0.16～0.24	1,270	0.16～0.24	1,110	0.16～0.24	635	0.16～0.24	515	0.16～0.24	2,110	0.21～0.3	4,000	0.38～0.53
10	1,270	0.2～0.28	1,020	0.2～0.28	890	0.2～0.28	510	0.2～0.28	410	0.2～0.28	1,690	0.25～0.36	3,200	0.45～0.63
12	1,060	0.24～0.34	850	0.24～0.34	740	0.24～0.34	425	0.24～0.34	350	0.24～0.34	1,400	0.3～0.42	2,700	0.53～0.75
13	980	0.26～0.36	780	0.26～0.36	690	0.26～0.36	390	0.26～0.36	320	0.26～0.36	1,300	0.31～0.42	2,500	0.56～0.79
14	900	0.28～0.39	720	0.28～0.39	640	0.28～0.39	360	0.28～0.39	300	0.28～0.39	1,200	0.32～0.44	2,300	0.57～0.81
16	800	0.3～0.43	640	0.3～0.43	560	0.3～0.43	320	0.3～0.43	260	0.3～0.43	1,050	0.34～0.46	2,000	0.61～0.85
18	700	0.34～0.49	560	0.34～0.49	500	0.34～0.49	280	0.34～0.49	230	0.34～0.49	950	0.36～0.5	1,800	0.63～0.9
20	650	0.36～0.5	500	0.36～0.5	450	0.36～0.5	260	0.36～0.5	210	0.36～0.5	830	0.4～0.56	1,600	0.68～0.98
22	580	0.4～0.55	460	0.4～0.55	400	0.4～0.55	230	0.4～0.55	190	0.4～0.55	750	0.42～0.59	1,500	0.73～1.06
24	530	0.41～0.6	420	0.41～0.6	370	0.41～0.6	210	0.41～0.6	170	0.41～0.6	700	0.46～0.65	1,350	0.77～1.13
26	500	0.42～0.65	400	0.42～0.65	340	0.42～0.65	200	0.42～0.65	160	0.42～0.65	650	0.47～0.68	1,250	0.81～1.2
28	450	0.45～0.7	360	0.45～0.7	320	0.45～0.7	180	0.45～0.7	150	0.45～0.7	600	0.5～0.73	1,150	0.84～1.26
30	420	0.48～0.75	340	0.48～0.75	300	0.48～0.75	170	0.48～0.75	140	0.48～0.75	550	0.54～0.78	1,100	0.87～1.32
32	400	0.51～0.8	320	0.51～0.8	280	0.51～0.8	160	0.51～0.8	130	0.51～0.8	520	0.58～0.83	1,000	0.9～1.38

1. 此切削条件基准表适用于使用水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用铣刀夹头以外的夹具时，请夹紧，并注意防止振动。
4. 孔深超过4倍直径时，请按照下表设定切削速度。
5. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
6. 通过立式加工中心加工孔深超4倍直径或车床、卧式加工中心加工孔深超过3倍直径时，请使用阶梯式进给。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. Unless you are using milling chucks, pay careful attention to ensure that the drill is tightly clamped in order to minimize deflection.
4. For drilling depth >4D, reduce the drilling speed (using the table below).
5. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce drilling speed by 20%.
6. The step process should be used when the drilling depth exceeds 4 times the drill diameter for vertical machines, and 3 times the drill diameter for horizontal lathe machines.

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D	6D以下 ≦6D
切削速度抑制系数 Coefficient for reducing speed	×1	×0.9	×0.7

形状尺寸表 SPECIFICATION CHARTS
VP-GDXL ▶ P.270

VP-黄金钻头切削条件基准表 VP-GOLD DRILLS CUTTING CONDITIONS

VP-GDXL

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		特殊钢 Special Alloy Steel SKD61 ～900N/mm² ～28HRC		特殊钢 Special Alloy Steel SKD11 ～1060N/mm² 28～34HRC		铸铁 Cast Iron FC250 ～350N/mm²		铸造铝合金 Aluminum Alloy Castings AC4C·ADC	
切削速度 Cutting Speed	16～24m/min		20～25m/min		12～16m/min		10～20m/min		6～10m/min		20～30m/min		20～35m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
3	2,100	0.05～0.1	2,400	0.05～0.1	1,500	0.05～0.1	1,700	0.05～0.1	850	0.04～0.07	2,700	0.04～0.07	3,000	0.05～0.1
4	1,600	0.06～0.12	1,800	0.06～0.12	1,100	0.06～0.12	1,270	0.06～0.12	640	0.05～0.09	2,000	0.05～0.09	2,200	0.06～0.12
5	1,250	0.08～0.13	1,450	0.08～0.13	900	0.08～0.13	1,000	0.08～0.13	510	0.07～0.1	1,600	0.07～0.1	1,800	0.08～0.13
6	1,050	0.1～0.14	1,200	0.1～0.14	750	0.1～0.14	850	0.1～0.14	420	0.09～0.12	1,350	0.09～0.12	1,500	0.1～0.14
7	900	0.12～0.16	1,000	0.12～0.16	640	0.12～0.16	730	0.12～0.16	360	0.1～0.14	1,150	0.1～0.14	1,300	0.12～0.16
8	800	0.14～0.18	900	0.14～0.18	560	0.14～0.18	640	0.14～0.18	320	0.12～0.16	1,000	0.12～0.16	1,100	0.14～0.18
9	700	0.16～0.2	800	0.16～0.2	500	0.16～0.2	570	0.16～0.2	280	0.13～0.18	900	0.13～0.18	1,000	0.16～0.2
10	640	0.18～0.22	720	0.18～0.22	450	0.18～0.22	510	0.18～0.22	260	0.14～0.2	800	0.14～0.2	900	0.18～0.22

1. 此切削条件基准表适用于使用水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或大于20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 在车床、卧式加工中心上进行阶梯式加工时，退刀时一定要退至孔外。
5. 采用阶梯式进给时，每转进给量应设定在0.5 ～3D左右。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. When you perform step process by lathe/horizontal machine, please pull back the drill to the mouth of a hole.
5. When you perform step process, please set the amount of steps about to 0.5D~3D.

形状尺寸表 SPECIFICATION CHARTS
VP-HO-GDS ▶ P.265

VP-黄金钻头切削条件基准表 VP-GOLD DRILLS CUTTING CONDITIONS

VP-HO-GDS

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		不锈钢 Stainless Steel SUS300系·400系 SUS300·400type		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ～28HRC ～900N/mm²		SKD11 ～34HRC 900～1060N/mm²		调质钢 Hardened Steel 34～43HRC 1060～1400N/mm²		铸铁 Cast Iron FC250 ～350N/mm²		铸造铝合金 Aluminum Alloy Castings AC4C·ADC	
切削速度 Cutting Speed	36～80m/min		25～50m/min		25～36m/min		18～25m/min		12～22m/min		10～16m/min		9～13m/min		36～63m/min		70～140m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
6	3,000	0.13～0.19	1,900	0.13～0.19	1,500	0.13～0.19	1,100	0.13～0.19	850	0.13～0.19	660	0.13～0.19	630	0.08～0.15	2,500	0.19～0.26	5,300	0.34～0.48
8	2,300	0.17～0.24	1,400	0.17～0.24	1,100	0.17～0.24	830	0.17～0.24	640	0.17～0.24	450	0.17～0.24	470	0.13～0.2	1,900	0.21～0.3	4,000	0.38～0.53
10	1,800	0.2～0.28	1,100	0.2～0.28	950	0.2～0.28	660	0.2～0.28	500	0.2～0.28	400	0.2～0.28	380	0.16～0.24	1,500	0.25～0.36	3,200	0.45～0.63
12	1,500	0.24～0.34	950	0.24～0.34	800	0.24～0.34	550	0.24～0.34	420	0.24～0.34	330	0.24～0.34	320	0.19～0.28	1,250	0.3～0.42	2,700	0.53～0.75
13	1,400	0.26～0.36	900	0.26～0.36	750	0.26～0.36	510	0.26～0.36	400	0.26～0.36	300	0.26～0.36	290	0.2～0.3	1,200	0.31～0.42	2,500	0.56～0.79
14	1,350	0.28～0.39	820	0.28～0.39	700	0.28～0.39	470	0.28～0.39	360	0.28～0.39	280	0.28～0.39	270	0.2～0.32	1,100	0.32～0.44	2,300	0.57～0.81
16	1,200	0.3～0.43	720	0.3～0.43	600	0.3～0.43	420	0.3～0.43	320	0.3～0.43	250	0.3～0.43	240	0.22～0.32	1,000	0.34～0.46	2,000	0.61～0.85
18	1,100	0.34～0.49	650	0.34～0.49	550	0.34～0.49	370	0.34～0.49	280	0.34～0.49	220	0.34～0.49	210	0.24～0.4	900	0.36～0.5	1,800	0.63～0.9
20	950	0.36～0.5	580	0.36～0.5	480	0.36～0.5	330	0.36～0.5	260	0.36～0.5	200	0.36～0.5	190	0.27～0.45	800	0.4～0.56	1,600	0.68～0.98
22	850	0.4～0.55	520	0.4～0.55	450	0.4～0.55	300	0.4～0.55	230	0.4～0.55	180	0.4～0.55	170	0.28～0.48	700	0.42～0.59	1,500	0.73～1.06
24	800	0.41～0.6	480	0.41～0.6	400	0.41～0.6	280	0.41～0.6	210	0.41～0.6	170	0.41～0.6	160	0.29～0.52	650	0.46～0.65	1,350	0.77～1.13
26	750	0.42～0.65	450	0.42～0.65	370	0.42～0.65	250	0.42～0.65	200	0.42～0.65	150	0.42～0.65	150	0.3～0.56	600	0.47～0.68	1,250	0.81～1.2

1. 此切削条件基准表适用于使用水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.

形状尺寸表 SPECIFICATION CHARTS
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VP-黄金钻头切削条件基准表 VP-GOLD DRILLS CUTTING CONDITIONS

VP-HO-GDR

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		不锈钢 Stainless Steel SUS300系·400系 SUS300·400type		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ～28HRC ～900N/mm²		SKD11 ～34HRC 900～1060N/mm²		调质钢 Hardened Steel 34～43HRC 1060～1400N/mm²		铸铁 Cast Iron FC250 ～350N/mm²		铸造铝合金 Aluminum Alloy Castings AC4C·ADC	
切削速度 Cutting Speed	36～80m/min		25～50m/min		25～36m/min		18～25m/min		12～22m/min		10～16m/min		9～13m/min		36～63m/min		70～140m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
6	3,000	0.13～0.19	1,900	0.13～0.19	1,500	0.13～0.19	1,100	0.13～0.19	850	0.13～0.19	660	0.13～0.19	630	0.08～0.15	2,500	0.19～0.26	5,300	0.34～0.48
8	2,300	0.17～0.24	1,400	0.17～0.24	1,100	0.17～0.24	830	0.17～0.24	640	0.17～0.24	450	0.17～0.24	470	0.13～0.2	1,900	0.21～0.3	4,000	0.38～0.53
10	1,800	0.2～0.28	1,100	0.2～0.28	950	0.2～0.28	660	0.2～0.28	500	0.2～0.28	400	0.2～0.28	380	0.16～0.24	1,500	0.25～0.36	3,200	0.45～0.63
12	1,500	0.24～0.34	950	0.24～0.34	800	0.24～0.34	550	0.24～0.34	420	0.24～0.34	330	0.24～0.34	320	0.19～0.28	1,250	0.3～0.42	2,700	0.53～0.75
13	1,400	0.26～0.36	900	0.26～0.36	750	0.26～0.36	510	0.26～0.36	400	0.26～0.36	300	0.26～0.36	290	0.2～0.3	1,200	0.31～0.42	2,500	0.56～0.79
14	1,350	0.28～0.39	820	0.28～0.39	700	0.28～0.39	470	0.28～0.39	360	0.28～0.39	280	0.28～0.39	270	0.2～0.32	1,100	0.32～0.44	2,300	0.57～0.81
16	1,200	0.3～0.43	720	0.3～0.43	600	0.3～0.43	420	0.3～0.43	320	0.3～0.43	250	0.3～0.43	240	0.22～0.32	1,000	0.34～0.46	2,000	0.61～0.85
18	1,100	0.34～0.49	650	0.34～0.49	550	0.34～0.49	370	0.34～0.49	280	0.34～0.49	220	0.34～0.49	210	0.24～0.4	900	0.36～0.5	1,800	0.63～0.9
20	950	0.36～0.5	580	0.36～0.5	480	0.36～0.5	330	0.36～0.5	260	0.36～0.5	200	0.36～0.5	190	0.27～0.45	800	0.4～0.56	1,600	0.68～0.98
22	850	0.4～0.55	520	0.4～0.55	450	0.4～0.55	300	0.4～0.55	230	0.4～0.55	180	0.4～0.55	170	0.28～0.48	700	0.42～0.59	1,500	0.73～1.06
24	800	0.41～0.6	480	0.41～0.6	400	0.41～0.6	280	0.41～0.6	210	0.41～0.6	170	0.41～0.6	160	0.29～0.52	650	0.46～0.65	1,350	0.77～1.13
26	750	0.42～0.65	450	0.42～0.65	370	0.42～0.65	250	0.42～0.65	200	0.42～0.65	150	0.42～0.65	150	0.3～0.56	600	0.47～0.68	1,250	0.81～1.2
28	700	0.45～0.7	410	0.45～0.7	350	0.45～0.7	240	0.45～0.7	180	0.45～0.7	140	0.45～0.7	140	0.31～0.59	550	0.5～0.73	1,150	0.84～1.26
30	650	0.48～0.75	400	0.48～0.75	320	0.48～0.75	220	0.48～0.75	170	0.48～0.75	130	0.48～0.75	130	0.32～0.63	500	0.54～0.78	1,100	0.87～1.32
32	600	0.51～0.8	360	0.51～0.8	300	0.51～0.8	200	0.51～0.8	160	0.51～0.8	120	0.51～0.8	120	0.32～0.67	480	0.58～0.83	1,000	0.9～1.38

1. 此切削条件基准表适用于使用水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 孔深超过4倍直径时，请进行阶梯式进给，并按照下表设定切削速度。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. The step process should be used when the drilling depth exceeds 4 times the drill diameter. (Using the table below)

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D	6D以下 ≦6D
切削速度抑制系数 Coefficient for reducing speed	×1	×0.9	×0.8

EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

NEXUS-GDS

加工材料 Work Material	不锈钢 Stainless Steel									
	奥氏体系 Austenitic SUS304 (S:0.02%小于) SUS304N		奥氏体系列 Austenitic SUS304 (S:0.02%以上) SUS303		马氏体系 Martensitic SUS420·440		铁素体系 Ferritic SUS430·405		析出硬化体系 Precipitation SUS630·631	
切削速度 Cutting Speed	12～15m/min※		15～25m/min		15～25m/min		15～30m/min		10～20m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
1	4,460	0.01 ～ 0.018	6,370	0.02 ～ 0.04	6,370	0.01 ～ 0.02	7,000	0.01 ～ 0.03	4,770	0.01 ～ 0.03
2	2,230	0.02 ～ 0.036	3,180	0.05 ～ 0.07	3,180	0.02 ～ 0.04	3,500	0.03 ～ 0.05	2,390	0.03 ～ 0.05
3	1,490	0.03 ～ 0.054	2,120	0.06 ～ 0.09	2,120	0.03 ～ 0.06	2,330	0.04 ～ 0.06	1,590	0.04 ～ 0.06
4	1,030	0.04 ～ 0.08	1,590	0.08 ～ 0.12	1,590	0.04 ～ 0.08	1,750	0.06 ～ 0.08	1,190	0.06 ～ 0.08
5	830	0.05 ～ 0.1	1,270	0.1 ～ 0.15	1,270	0.05 ～ 0.1	1,400	0.08 ～ 0.1	950	0.08 ～ 0.1
6	690	0.06 ～ 0.12	1,060	0.12 ～ 0.18	1,060	0.06 ～ 0.12	1,170	0.09 ～ 0.12	800	0.09 ～ 0.12
8	480	0.08 ～ 0.16	800	0.16 ～ 0.24	800	0.08 ～ 0.16	880	0.12 ～ 0.16	600	0.12 ～ 0.16
10	380	0.10 ～ 0.2	640	0.2 ～ 0.28	640	0.1 ～ 0.2	700	0.15 ～ 0.2	480	0.15 ～ 0.2
12	320	0.12 ～ 0.24	530	0.24 ～ 0.34	530	0.12 ～ 0.24	580	0.18 ～ 0.24	400	0.18 ～ 0.24

加工材料 Work Material	变形铝 Aluminum A5052·7075		铸造铝合金 Alminum Alloy Casting AC4C·ADC		铜·铜合金 Copper Copper Alloy C1020·2600		低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²	
切削速度 Cutting Speed	32～63m/min		63～100m/min		40～60m/min		40～60m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
1	15,000	0.02 ～ 0.06	25,000	0.02 ～ 0.06	15,920	0.01 ～ 0.03	15,920	0.02 ～ 0.05
2	8,000	0.04 ～ 0.12	10,000	0.04 ～ 0.12	7,960	0.04 ～ 0.06	7,960	0.06 ～ 0.09
3	5,300	0.06 ～ 0.18	6,700	0.06 ～ 0.18	5,310	0.06 ～ 0.09	5,310	0.1 ～ 0.13
4	4,000	0.08 ～ 0.24	6,400	0.08 ～ 0.24	3,980	0.08 ～ 0.11	3,980	0.11 ～ 0.15
5	3,200	0.1 ～ 0.3	5,000	0.1 ～ 0.3	3,180	0.1 ～ 0.13	3,180	0.12 ～ 0.18
6	2,700	0.12 ～ 0.36	4,200	0.12 ～ 0.36	2,650	0.12 ～ 0.15	2,650	0.13 ～ 0.19
8	2,000	0.16 ～ 0.45	3,200	0.16 ～ 0.45	1,990	0.16 ～ 0.2	1,990	0.17 ～ 0.24
10	1,600	0.2 ～ 0.55	2,500	0.2 ～ 0.55	1,590	0.2 ～ 0.25	1,590	0.2 ～ 0.28
12	1,350	0.24 ～ 0.66	2,100	0.24 ～ 0.66	1,330	0.24 ～ 0.3	1,330	0.24 ～ 0.34

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 切削铸件表面或黑皮时，请将切削速度降低20%。
4. 孔深超过直径的3倍时，请按照下表设定切削速度。
5. 孔深超过直径的4倍时，请采用阶梯进给。
6. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
7. 不锈钢的种类与硬度不同，其切削性也会发生变化，请根据实际状况适当调节切削速度和进给量。(在使用前务必确认Mill sheet。)

※ 钻头直径越大加工时产生的切削热越大，会导致溶着现象的产生，以及切屑形状恶化，请使用推荐切削速度的低值进行加工。

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D	6D以下 ≦6D
切削速度抑制系数 Coefficient for reducing speed	×0.9	×0.8	×0.8

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. When drilling cast surface and black (ie.not ground surface), reduce drilling speed by 20%.
4. For drilling depth>3D.reduce drilling speed (using the table below).
5. Step feeding is required for drilling depth>4D.
6. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
7. The machineability of stainless steels may vary depending on the type and hardness. Therefore, adjust the cutting speed and the feed rate to suit the conditions. (Be sure to check the Mill Sheet before use.)

※ The larger the drill diameter, the higher the milling temperature generated during machining, which can lead to fusing and deterioration of the shape of the cutting chips. Therefore, use a setting that is lower than the recommended cutting speed.

形状尺寸表 SPECIFICATION CHARTS
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EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

NEXUS-GDR

加工材料 Work Material	不锈钢 Stainless Steel									
	奥氏体系 Austenitic SUS304 (S:0.02%小于) SUS304N		奥氏体系 Austenitic SUS304 (S:0.02%以上) SUS303		马氏体系 Martensitic SUS420·440		铁素体系 Ferritic SUS430·405		析出硬化体系 Precipitation SUS630·631	
切削速度 Cutting Speed	12～15m/min※		15～25m/min		15～25m/min		15～30m/min		10～20m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
1	4,460	0.01 ～ 0.018	6,370	0.02 ～ 0.04	6,370	0.01 ～ 0.02	7,000	0.01 ～ 0.03	4,770	0.01 ～ 0.03
2	2,230	0.02 ～ 0.036	3,180	0.05 ～ 0.07	3,180	0.02 ～ 0.04	3,500	0.03 ～ 0.05	2,390	0.03 ～ 0.05
3	1,490	0.03 ～ 0.054	2,120	0.06 ～ 0.09	2,120	0.03 ～ 0.06	2,330	0.04 ～ 0.06	1,590	0.04 ～ 0.06
4	1,030	0.04 ～ 0.08	1,590	0.08 ～ 0.12	1,590	0.04 ～ 0.08	1,750	0.06 ～ 0.08	1,190	0.06 ～ 0.08
5	830	0.05 ～ 0.1	1,270	0.1 ～ 0.15	1,270	0.05 ～ 0.1	1,400	0.08 ～ 0.1	950	0.08 ～ 0.1
6	690	0.06 ～ 0.12	1,060	0.12 ～ 0.18	1,060	0.06 ～ 0.12	1,170	0.09 ～ 0.12	800	0.09 ～ 0.12
8	480	0.08 ～ 0.16	800	0.16 ～ 0.24	800	0.08 ～ 0.16	880	0.12 ～ 0.16	600	0.12 ～ 0.16
10	380	0.10 ～ 0.2	640	0.2 ～ 0.28	640	0.1 ～ 0.2	700	0.15 ～ 0.2	480	0.15 ～ 0.2
12	320	0.12 ～ 0.24	530	0.24 ～ 0.34	530	0.12 ～ 0.24	580	0.18 ～ 0.24	400	0.18 ～ 0.24

加工材料 Work Material	变形铝 Aluminum A5052·7075		铸造铝合金 Alminum Alloy Casting AC4C·ADC		铜·铜合金 Copper Copper Alloy C1020·2600		低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²	
切削速度 Cutting Speed	32～63m/min		63～100m/min		40～60m/min		40～60m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
1	15,000	0.02 ～ 0.06	25,000	0.02 ～ 0.06	15,920	0.01 ～ 0.03	15,920	0.02 ～ 0.05
2	8,000	0.04 ～ 0.12	10,000	0.04 ～ 0.12	7,960	0.04 ～ 0.06	7,960	0.06 ～ 0.09
3	5,300	0.06 ～ 0.18	6,700	0.06 ～ 0.18	5,310	0.06 ～ 0.09	5,310	0.1 ～ 0.13
4	4,000	0.08 ～ 0.24	6,400	0.08 ～ 0.24	3,980	0.08 ～ 0.11	3,980	0.11 ～ 0.15
5	3,200	0.1 ～ 0.3	5,000	0.1 ～ 0.3	3,180	0.1 ～ 0.13	3,180	0.12 ～ 0.18
6	2,700	0.12 ～ 0.36	4,200	0.12 ～ 0.36	2,650	0.12 ～ 0.15	2,650	0.13 ～ 0.19
8	2,000	0.16 ～ 0.45	3,200	0.16 ～ 0.45	1,990	0.16 ～ 0.2	1,990	0.17 ～ 0.24
10	1,600	0.2 ～ 0.55	2,500	0.2 ～ 0.55	1,590	0.2 ～ 0.25	1,590	0.2 ～ 0.28
12	1,350	0.24 ～ 0.66	2,100	0.24 ～ 0.66	1,330	0.24 ～ 0.3	1,330	0.24 ～ 0.34

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 切削铸件表面或黑皮时，请将切削速度降低20%。
4. 孔深超过直径的3倍时，请按照下表设定切削速度。
5. 孔深超过直径的4倍时，请采用阶梯进给。
6. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
7. 不锈钢的种类与硬度不同，其切削性也会发生变化，请根据实际状况适当调节切削速度和进给量。(在使用前务必确认Mill sheet。)

※ 钻头直径越大加工时产生的切削热越大，会导致溶着现象的产生，以及切屑形状恶化，请使用推荐切削速度的低值进行加工。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. When drilling cast surface and black (ie.not ground surface), reduce drilling speed by 20%.
4. For drilling depth>3D.reduce drilling speed (using the table below).
5. Step feeding is required for drilling depth>4D.
6. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
7. The machineability of stainless steels may vary depending on the type and hardness. Therefore, adjust the cutting speed and the feed rate to suit the conditions. (Be sure to check the Mill Sheet before use.)

※ The larger the drill diameter, the higher the milling temperature generated during machining, which can lead to fusing and deterioration of the shape of the cutting chips. Therefore, use a setting that is lower than the recommended cutting speed.

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D	6D以下 ≦6D
切削速度抑制系数 Coefficient for reducing speed	×0.9	×0.8	×0.8

形状尺寸表 SPECIFICATION CHARTS EX-SUS-GDS ▶ P.273
形状尺寸表 SPECIFICATION CHARTS EX-SUS-GDN ▶ P.281
形状尺寸表 SPECIFICATION CHARTS EX-SUS-GDR ▶ P.283
形状尺寸表 SPECIFICATION CHARTS MT-SUS-GDR ▶ P.289

EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

EX-SUS-GDS·EX-SUS-GDN·EX-SUS-GDR·MT-SUS-GDR

加工材料 Work Material	不锈钢 Stainless Steel								变形铝 Aluminum A5052·7075		铸造铝合金 Alminum Alloy Castings AC4C·ADC		铜·铜合金 Copper Copper Alloy C1020·2600		低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500n/㎟	
	奥氏体系 Austenitic SUS304·200		马氏体系 Martensitic SUS420·440		铁素体系 Ferritic SUS430·405		析出硬化体系 Precipitation SUS630·631									
切削速度 Cutting Speed	12～15m/min		15～20m/min		15～20m/min		8～12m/min		32～63m/min		63～100m/min		25～50m/min		32～40m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
1	4,460	0.01～0.018	5,550	0.02～0.04	5,550	0.01～0.03	3,200	0.01～0.03	15,000	0.02～0.06	25,000	0.02～0.06	12,000	0.01～0.03	10,000	0.02～0.05
2	2,230	0.02～0.036	2,850	0.05～0.07	2,850	0.03～0.05	1,600	0.03～0.05	8,000	0.04～0.12	10,000	0.04～0.12	5,100	0.04～0.06	5,700	0.06～0.09
3	1,490	0.03～0.054	1,900	0.06～0.09	1,900	0.04～0.06	1,100	0.04～0.06	5,300	0.06～0.18	6,700	0.06～0.18	3,400	0.06～0.09	3,850	0.1～0.13
4	1,030	0.04～0.08	1,450	0.08～0.12	1,450	0.06～0.08	800	0.06～0.08	4,000	0.08～0.24	6,400	0.08～0.24	2,550	0.08～0.11	2,900	0.11～0.15
5	830	0.05～0.1	1,150	0.12～0.15	1,150	0.08～0.1	650	0.08～0.1	3,200	0.1～0.3	5,000	0.1～0.3	2,050	0.1～0.13	2,260	0.12～0.18
6	690	0.06～0.12	950	0.15～0.18	950	0.09～0.12	550	0.09～0.12	2,700	0.12～0.36	4,200	0.12～0.36	1,700	0.12～0.15	1,900	0.13～0.19
8	480	0.08～0.16	720	0.2～0.24	720	0.12～0.16	400	0.12～0.16	2,000	0.16～0.45	3,200	0.16～0.45	1,250	0.16～0.2	1,400	0.17～0.24
10	380	0.10～0.2	570	0.25～0.3	570	0.15～0.2	320	0.15～0.2	1,600	0.2～0.55	2,500	0.2～0.55	1,000	0.2～0.25	1,120	0.2～0.28
12	320	0.12～0.24	480	0.3～0.36	480	0.18～0.24	280	0.18～0.24	1,350	0.24～0.66	2,100	0.24～0.66	850	0.24～0.3	950	0.24～0.34
13	370	0.26～0.36	440	0.32～0.4	440	0.2～0.26	250	0.2～0.26	1,250	0.25～0.72	2,000	0.25～0.72	780	0.26～0.32	880	0.26～0.36
14	340	0.28～0.39	410	0.35～0.45	410	0.21～0.3	225	0.21～0.3	1,140	0.27～0.74	1,850	0.27～0.74	730	0.26～0.34	820	0.27～0.39
15	320	0.29～0.4	380	0.36～0.48	380	0.22～0.31	210	0.22～0.31	1,060	0.29～0.8	1,700	0.29～0.8	680	0.26～0.36	760	0.28～0.42
16	300	0.3～0.43	355	0.37～0.5	355	0.23～0.32	200	0.23～0.32	1,000	0.3～0.83	1,600	0.3～0.83	640	0.27～0.37	720	0.29～0.43
17	280	0.31～0.45	335	0.38～0.52	335	0.24～0.34	185	0.24～0.34	940	0.31～0.88	1,500	0.31～0.88	600	0.28～0.39	675	0.3～0.46
18	265	0.32～0.47	320	0.39～0.54	320	0.25～0.36	175	0.25～0.36	885	0.32～0.94	1,450	0.32～0.94	570	0.29～0.41	640	0.32～0.49
19	250	0.33～0.48	300	0.4～0.55	300	0.25～0.38	170	0.25～0.38	840	0.34～0.97	1,350	0.34～0.97	540	0.3～0.43	600	0.33～0.51
20	240	0.34～0.5	285	0.4～0.56	285	0.26～0.4	160	0.26～0.4	800	0.36～1	1,300	0.36～1	510	0.3～0.44	570	0.34～0.52
22	215	0.36～0.54	260	0.42～0.61	260	0.28～0.44	145	0.28～0.44	730	0.39～1.08	1,200	0.39～1.08	460	0.32～0.48	520	0.37～0.57
24	200	0.38～0.57	240	0.43～0.65	240	0.3～0.48	135	0.3～0.48	670	0.41～1.15	1,100	0.41～1.15	420	0.33～0.52	480	0.39～0.61
26	185	0.4～0.6	220	0.44～0.7	220	0.32～0.52	120	0.32～0.52	620	0.44～1.22	1,000	0.44～1.22	390	0.34～0.56	450	0.41～0.66
28	170	0.41～0.63	200	0.45～0.74	200	0.34～0.56	115	0.34～0.56	570	0.46～1.29	930	0.46～1.29	360	0.35～0.59	410	0.43～0.71
30	160	0.42～0.66	190	0.45～0.78	190	0.36～0.6	105	0.36～0.6	530	0.48～1.35	870	0.48～1.35	340	0.36～0.63	380	0.45～0.75
32	150	0.43～0.7	180	0.45～0.82	180	0.37～0.64	100	0.37～0.64	500	0.5～1.42	820	0.5～1.42	320	0.38～0.67	360	0.47～0.8
40	120	0.44～0.76	140	0.48～0.88	140	0.4～0.7	80	0.4～0.7	400	0.6～1.4	650	0.6～1.4	250	0.4～0.8	280	0.48～1
50	95	0.45～0.8	115	0.5～0.9	115	0.45～0.75	60	0.45～0.75	320	0.7～1.6	500	0.7～1.6	200	0.45～1	230	0.5～1.2

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 切削铸件表面或黑皮时，请将切削速度降低20%。
4. 孔深超过直径的3倍时，请按照下表设定切削速度。
5. 孔深超过直径的4倍时，请采用阶梯进给。
6. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D	6D以下 ≦6D
切削速度抑制系数 Coefficient for reducing speed	×0.9	×0.8	×0.8

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. When drilling cast surface and black (ie.not ground surface), reduce drilling speed by 20%.
4. For drilling depth>3D.reduce drilling speed (using the table below).
5. Step feeding is required for drilling depth>4D.
6. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.

形状尺寸表 SPECIFICATION CHARTS
EX-GDS ▶ P.290

EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

EX-GDS

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ~500N/mm²		碳素钢 Carbon Steel S50C 500~710N/mm²		合金钢 Alloy Steel SCM·SCr 710~900N/mm²		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ~900N/mm²		SKD11 900~1060N/mm²		调质钢 Hardened Steel 34~43HRC 1060~1400N/mm²		43~48HRC 1400~1600N/mm²		超耐热钢 Inconel 718 (38~43HRC)		铸铁 Cast Iron FC250 ~350N/mm²		铸造铝合金 Aluminum Alloy Castings ADC·AC	
切削速度 Cutting Speed	32~40m/min		22~30m/min		20~25m/min		10~16m/min		8~12m/min		10~15m/min		6~10m/min		6~8m/min		32~40m/min		63~100m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
1	11,500	0.03 ~ 0.05	8,000	0.03 ~ 0.05	7,000	0.03 ~ 0.05	4,000	0.03 ~ 0.05	3,200	0.03 ~ 0.05	3,800	0.01 ~ 0.03	2,500	0.01 ~ 0.02	2,500	0.01 ~ 0.02	10,000	0.04 ~ 0.06	20,000	0.06 ~ 0.09
2	5,700	0.06 ~ 0.09	4,000	0.06 ~ 0.09	3,500	0.06 ~ 0.09	2,000	0.06 ~ 0.09	1,600	0.06 ~ 0.09	1,900	0.02 ~ 0.05	1,250	0.02 ~ 0.04	1,250	0.02 ~ 0.04	5,700	0.08 ~ 0.11	10,000	0.12 ~ 0.18
3	3,800	0.1 ~ 0.13	2,800	0.1 ~ 0.13	2,400	0.1 ~ 0.13	1,350	0.1 ~ 0.13	1,060	0.1 ~ 0.13	1,250	0.03 ~ 0.08	850	0.03 ~ 0.06	850	0.03 ~ 0.06	3,800	0.11 ~ 0.16	10,000	0.18 ~ 0.26
4	2,900	0.11 ~ 0.15	2,100	0.11 ~ 0.15	1,800	0.11 ~ 0.15	1,000	0.11 ~ 0.15	800	0.11 ~ 0.15	960	0.04 ~ 0.1	640	0.04 ~ 0.08	630	0.04 ~ 0.08	2,900	0.13 ~ 0.19	7,500	0.24 ~ 0.34
5	2,300	0.12 ~ 0.18	1,650	0.12 ~ 0.18	1,400	0.12 ~ 0.18	800	0.12 ~ 0.18	640	0.12 ~ 0.18	760	0.05 ~ 0.13	510	0.05 ~ 0.1	500	0.05 ~ 0.1	2,300	0.16 ~ 0.22	6,300	0.28 ~ 0.4
6	1,900	0.13 ~ 0.19	1,400	0.13 ~ 0.19	1,200	0.13 ~ 0.19	660	0.13 ~ 0.19	530	0.13 ~ 0.19	640	0.06 ~ 0.15	430	0.06 ~ 0.12	430	0.06 ~ 0.12	1,900	0.19 ~ 0.26	5,000	0.34 ~ 0.48
7	1,650	0.15 ~ 0.22	1,200	0.15 ~ 0.22	1,050	0.15 ~ 0.22	570	0.15 ~ 0.22	450	0.15 ~ 0.22	550	0.07 ~ 0.18	360	0.07 ~ 0.14	360	0.07 ~ 0.14	1,650	0.2 ~ 0.28	4,450	0.36 ~ 0.5
8	1,400	0.17 ~ 0.24	1,050	0.17 ~ 0.24	920	0.17 ~ 0.24	500	0.16 ~ 0.24	400	0.17 ~ 0.24	480	0.08 ~ 0.2	320	0.08 ~ 0.16	320	0.08 ~ 0.16	1,450	0.21 ~ 0.31	4,000	0.38 ~ 0.53
9	1,250	0.18 ~ 0.26	920	0.18 ~ 0.26	810	0.18 ~ 0.26	440	0.18 ~ 0.26	350	0.18 ~ 0.26	430	0.09 ~ 0.23	280	0.09 ~ 0.18	280	0.09 ~ 0.18	1,270	0.23 ~ 0.33	3,450	0.41 ~ 0.58
10	1,150	0.2 ~ 0.28	830	0.2 ~ 0.28	730	0.2 ~ 0.28	400	0.2 ~ 0.28	320	0.2 ~ 0.28	380	0.1 ~ 0.25	260	0.1 ~ 0.2	260	0.10 ~ 0.2	1,150	0.25 ~ 0.35	3,150	0.45 ~ 0.63
11	1,050	0.22 ~ 0.32	750	0.22 ~ 0.32	670	0.22 ~ 0.32	360	0.22 ~ 0.31	300	0.22 ~ 0.32	350	0.11 ~ 0.28	230	0.11 ~ 0.22	230	0.11 ~ 0.22	1,050	0.27 ~ 0.38	2,850	0.48 ~ 0.69
12	950	0.24 ~ 0.34	690	0.24 ~ 0.34	610	0.24 ~ 0.34	330	0.24 ~ 0.34	270	0.24 ~ 0.34	320	0.12 ~ 0.3	210	0.12 ~ 0.24	210	0.12 ~ 0.24	960	0.3 ~ 0.42	2,650	0.53 ~ 0.75
13	880	0.26 ~ 0.36	640	0.26 ~ 0.36	560	0.26 ~ 0.36	300	0.26 ~ 0.36	250	0.26 ~ 0.36	300	0.13 ~ 0.32	200	0.13 ~ 0.26	200	0.13 ~ 0.26	880	0.31 ~ 0.42	2,400	0.56 ~ 0.79

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 通过车床、卧式加工中心进行3D以上加工时，请使用阶梯式进给。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. Step process should be used when drilling depth of the hole exceeds 3 times drill diameter for lathe / horizontal machine.

形状尺寸表 SPECIFICATION CHARTS
EX-LS-GDS ▶ P.293

EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

EX-LS-GDS

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/㎟		碳素钢 Carbon Steel S50C 500～710N/㎟		合金钢 Alloy Steel SCM·SCr 710～900N/㎟		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ～900N/㎟		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD11 900～1060N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		铸造铝合金 Aluminum Alloy Castings ADC·AC	
切削速度 Cutting Speed	32～40m/min		22～30m/min		20～25m/min		10～16m/min		8～12m/min		32～40m/min		63～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2.5	4,600	0.04～0.08	3,300	0.04～0.08	2,870	0.04～0.08	1,660	0.04～0.08	1,270	0.03～0.07	4,600	0.04～0.08	10,400	0.04～0.08
3.3	3,470	0.05～0.1	2,500	0.05～0.1	2,170	0.05～0.1	1,260	0.05～0.1	970	0.04～0.08	3,470	0.05～0.1	7,870	0.05～0.1
4.2	2,730	0.06～0.12	1,970	0.06～0.12	1,700	0.06～0.12	990	0.06～0.12	760	0.05～0.1	2,730	0.06～0.12	6,180	0.06～0.12
5	2,300	0.08～0.13	1,660	0.08～0.13	1,430	0.08～0.13	830	0.08～0.13	640	0.07～0.12	2,300	0.08～0.13	5,190	0.08～0.13
6.8	1,690	0.11～0.15	1,220	0.11～0.15	1,050	0.11～0.15	610	0.11～0.15	470	0.09～0.13	1,690	0.11～0.15	3,820	0.11～0.15
7	1,640	0.12～0.16	1,180	0.12～0.16	1,020	0.12～0.16	590	0.12～0.16	450	0.1～0.14	1,640	0.12～0.16	3,710	0.12～0.16
8.5	1,350	0.15～0.19	970	0.15～0.19	840	0.15～0.19	490	0.15～0.19	380	0.13～0.17	1,350	0.15～0.19	3,050	0.15～0.19
8.8	1,300	0.16～0.2	940	0.16～0.2	810	0.16～0.2	470	0.16～0.2	360	0.14～0.18	1,300	0.16～0.2	2,950	0.16～0.2
10.3	1,110	0.18～0.22	800	0.18～0.22	700	0.18～0.22	400	0.18～0.22	310	0.16～0.2	1,110	0.18～0.22	2,520	0.18～0.22
10.5	1,090	0.19～0.23	790	0.19～0.23	690	0.19～0.23	390	0.19～0.23	300	0.17～0.21	1,090	0.19～0.23	2,470	0.19～0.23
10.8	1,060	0.2～0.24	770	0.2～0.24	670	0.2～0.24	380	0.2～0.24	290	0.18～0.22	1,060	0.2～0.24	2,400	0.2～0.24

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 通过车床、卧式加工中心进行3D以上加工时，请使用阶梯式进给。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. Step process should be used when drilling depth of the hole exceeds 3 times drill diameter for lathe / horizontal machine.

形状尺寸表 SPECIFICATION CHARTS EX-GDN ▶ P.294
形状尺寸表 SPECIFICATION CHARTS EX-GDR ▶ P.297
形状尺寸表 SPECIFICATION CHARTS EX-MT-GDR ▶ P.307

EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

EX-GDN·EX-GDR·EX-MT-GDR

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM·SCr 710～900N/mm²		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ～900N/mm²		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD11 900～1060N/mm²		铸铁 Cast Iron FC250 ～350N/mm²		铸造铝合金 Aluminum Alloy Castings ADC·AC	
切削速度 Cutting Speed	32～40m/min		22～30m/min		20～25m/min		10～16m/min		8～12m/min		32～40m/min		63～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	17,800	0.01～0.015	12,700	0.01～0.015	11,100	0.01～0.015	6,600	0.01～0.015	5,100	0.01～0.015	17,800	0.01～0.015	37,600	0.01～0.015
1	11,500	0.03～0.05	8,000	0.03～0.05	7,000	0.03～0.05	3,800	0.03～0.05	3,200	0.03～0.05	11,500	0.04～0.06	20,000	0.06～0.09
2	5,700	0.06～0.09	4,000	0.06～0.09	3,500	0.06～0.09	1,900	0.06～0.09	1,600	0.06～0.09	5,700	0.08～0.11	10,000	0.12～0.18
3	3,850	0.1～0.13	2,800	0.1～0.13	2,400	0.1～0.13	1,320	0.1～0.13	1,060	0.1～0.13	3,850	0.11～0.16	10,000	0.2～0.28
4	2,900	0.11～0.15	2,100	0.11～0.15	1,800	0.11～0.15	950	0.11～0.15	800	0.11～0.15	2,900	0.13～0.19	7,500	0.24～0.34
5	2,260	0.12～0.18	1,600	0.12～0.18	1,400	0.12～0.18	750	0.12～0.18	630	0.12～0.18	2,260	0.16～0.22	6,300	0.28～0.4
6	1,900	0.13～0.19	1,320	0.13～0.19	1,180	0.13～0.19	630	0.13～0.19	530	0.13～0.19	1,900	0.19～0.26	5,000	0.34～0.48
8	1,400	0.17～0.24	1,000	0.17～0.24	900	0.17～0.24	480	0.17～0.24	400	0.17～0.24	1,400	0.21～0.3	4,000	0.38～0.53
10	1,120	0.2～0.28	800	0.2～0.28	710	0.2～0.28	380	0.2～0.28	320	0.2～0.28	1,120	0.25～0.35	3,150	0.45～0.63
12	950	0.24～0.34	670	0.24～0.34	600	0.24～0.34	320	0.24～0.34	270	0.24～0.34	950	0.3～0.42	2,650	0.53～0.75
13	880	0.26～0.36	610	0.26～0.36	540	0.26～0.36	290	0.26～0.36	240	0.26～0.36	880	0.31～0.42	2,400	0.56～0.79
14	820	0.28～0.39	570	0.28～0.39	500	0.28～0.39	270	0.28～0.39	230	0.28～0.39	820	0.32～0.44	2,250	0.57～0.81
16	720	0.3～0.43	500	0.3～0.43	440	0.3～0.43	240	0.3～0.43	200	0.3～0.43	720	0.34～0.46	1,950	0.61～0.85
18	640	0.34～0.49	440	0.34～0.49	390	0.34～0.49	210	0.34～0.49	180	0.34～0.49	640	0.36～0.5	1,750	0.63～0.9
20	570	0.36～0.5	400	0.36～0.5	350	0.36～0.5	190	0.36～0.5	160	0.36～0.5	570	0.4～0.56	1,550	0.68～0.98
22	520	0.4～0.55	360	0.4～0.55	320	0.4～0.55	170	0.4～0.55	150	0.4～0.55	520	0.42～0.59	1,400	0.73～1.06
24	480	0.41～0.6	330	0.41～0.6	290	0.41～0.6	160	0.41～0.6	135	0.41～0.6	480	0.46～0.65	1,300	0.77～1.13
26	440	0.42～0.65	310	0.42～0.65	270	0.42～0.65	150	0.42～0.65	120	0.42～0.65	440	0.47～0.68	1,200	0.81～1.2
28	410	0.45～0.7	290	0.45～0.7	250	0.45～0.7	140	0.45～0.7	110	0.45～0.7	410	0.5～0.73	1,100	0.84～1.26
30	380	0.48～0.75	270	0.48～0.75	230	0.48～0.75	130	0.48～0.75	105	0.48～0.75	380	0.54～0.78	1,000	0.87～1.32
32	360	0.51～0.8	250	0.51～0.8	220	0.51～0.8	120	0.51～0.8	100	0.51～0.8	360	0.58～0.83	950	0.9～1.38
40	285	0.6～0.95	200	0.6～0.95	175	0.6～0.95	95	0.6～0.95	80	0.6～0.9	290	0.7～1	750	1～1.6
50	230	0.75～1.2	160	0.75～1.2	140	0.75～1.2	75	0.75～1.2	65	0.75～1.1	230	0.85～1.3	600	1～2

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 使用铣刀夹头以外的夹具时，请夹紧，并注意防止振动。
5. 孔深超过直径的4倍时，请使用比上述切削条件更低的值进行加工。
6. 使用直径未满1mm 的钻头时，请将切削速度(转速) 降低20%。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. Unless you are using milling chucks, pay careful attention to ensure that the drill is tightly clamped in order to minimize deflection.
5. For drilling depth > 4D, reduce the drilling speed and feed rate appropriately.
6. For drill dia. < 1.0mm, reduce the drilling speed by 20%.

形状尺寸表 SPECIFICATION CHARTS
EX-GDXL ▶ P.301

EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

EX-GDXL

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²		碳素钢 Carbon Steel S45C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ～900N/mm² ～28HRC		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD11 ～1060N/mm² 28～34HRC		铸铁 Cast Iron FC250 ～350N/mm²		铸造铝合金 Aluminum Alloy Castings AC4C·ADC	
切削速度 Cutting Speed	16～24m/min		20～25m/min		12～16m/min		10～20m/min		6～10m/min		20～30m/min		20～35m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
2	3,200	0.03～0.07	3,600	0.03～0.07	2,200	0.03～0.07	2,400	0.03～0.07	1,270	0.02～0.05	4,000	0.02～0.05	4,400	0.03～0.07
3	2,100	0.05～0.1	2,400	0.05～0.1	1,500	0.05～0.1	1,700	0.05～0.1	850	0.04～0.07	2,700	0.04～0.07	3,000	0.05～0.1
4	1,600	0.06～0.12	1,800	0.06～0.12	1,100	0.06～0.12	1,270	0.06～0.12	640	0.05～0.09	2,000	0.05～0.09	2,200	0.06～0.12
5	1,250	0.08～0.13	1,450	0.08～0.13	900	0.08～0.13	1,000	0.08～0.13	510	0.07～0.1	1,600	0.07～0.1	1,800	0.08～0.13
6	1,050	0.1～0.14	1,200	0.1～0.14	750	0.1～0.14	850	0.1～0.14	420	0.09～0.12	1,350	0.09～0.12	1,500	0.1～0.14
7	900	0.12～0.16	1,000	0.12～0.16	640	0.12～0.16	730	0.12～0.16	360	0.1～0.14	1,150	0.1～0.14	1,300	0.12～0.16
8	800	0.14～0.18	900	0.14～0.18	560	0.14～0.18	640	0.14～0.18	320	0.12～0.16	1,000	0.12～0.16	1,100	0.14～0.18
9	700	0.16～0.2	800	0.16～0.2	500	0.16～0.2	570	0.16～0.2	280	0.13～0.18	900	0.13～0.18	1,000	0.16～0.2
10	640	0.18～0.22	720	0.18～0.22	450	0.18～0.22	510	0.18～0.22	260	0.14～0.2	800	0.14～0.2	900	0.18～0.22
11	580	0.2～0.24	650	0.2～0.24	400	0.2～0.24	460	0.2～0.24	230	0.15～0.22	750	0.15～0.22	800	0.2～0.24
12	530	0.22～0.26	600	0.22～0.26	370	0.22～0.26	430	0.22～0.26	210	0.17～0.24	660	0.17～0.24	750	0.22～0.26
13	490	0.24～0.28	550	0.24～0.28	340	0.24～0.28	390	0.24～0.28	200	0.2～0.26	610	0.2～0.26	700	0.24～0.28

1. 此切削条件基准表适用于使用水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 在车床、卧式加工中心上进行阶梯式加工时，退刀时一定要退至孔外。
5. 采用阶梯式进给时，每转进给量应设定在0.5 ~ 3D左右。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution)
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. When you perform step process by lathe/horizontal machine, please pull back the drill to the month of a hole.
5. When you perform step process, please set the amount of steps about to 0.5D~3D.

形状尺寸表 SPECIFICATION CHARTS
EX-HO-GDR ▶ P.305

EX-黄金钻头切削条件基准表 EX-GOLD DRILLS CUTTING CONDITIONS

EX-HO-GDR

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/mm²		碳素钢 Carbon Steel (C≧0.3%) S50C 500 ～710N/mm²		合金钢 Alloy Steel SCM 710 ～900N/mm²		不锈钢 Stainless Steel SUS300系·400系 SUS300·400type		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ～900N/mm²		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD11 900～1060N/mm²		铸铁 Cast Iron FC250 ～350N/mm²		铸造铝合金 Aluminum Alloy Castings AC4C·ADC	
切削速度 Cutting Speed	32 ～40m/min		22 ～30m/min		20 ～25m/min		16 ～22m/min		10 ～16m/min		8 ～12m/min		32 ～40m/min		63 ～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
6	1,900	0.13 ～ 0.19	1,320	0.13 ～ 0.19	1,180	0.13 ～ 0.19	1,100	0.13 ～ 0.19	630	0.13 ～ 0.19	530	0.13 ～ 0.19	1,900	0.19 ～ 0.26	5,000	0.34 ～ 0.48
8	1,400	0.17 ～ 0.24	1,000	0.17 ～ 0.24	900	0.17 ～ 0.24	800	0.17 ～ 0.24	480	0.17 ～ 0.24	400	0.17 ～ 0.24	1,400	0.21 ～ 0.3	4,000	0.38 ～ 0.53
10	1,120	0.2 ～ 0.28	800	0.2 ～ 0.28	710	0.2 ～ 0.28	650	0.2 ～ 0.28	380	0.2 ～ 0.28	320	0.2 ～ 0.28	1,120	0.25 ～ 0.36	3,150	0.45 ～ 0.63
12	950	0.24 ～ 0.34	670	0.24 ～ 0.34	600	0.24 ～ 0.34	550	0.24 ～ 0.34	320	0.24 ～ 0.34	270	0.24 ～ 0.34	950	0.3 ～ 0.42	2,650	0.53 ～ 0.75
13	880	0.26 ～ 0.36	610	0.26 ～ 0.36	540	0.26 ～ 0.36	490	0.26 ～ 0.36	290	0.26 ～ 0.36	240	0.26 ～ 0.36	880	0.31 ～ 0.42	2,400	0.56 ～ 0.79
14	820	0.28 ～ 0.39	570	0.28 ～ 0.39	500	0.28 ～ 0.39	455	0.28 ～ 0.39	270	0.28 ～ 0.39	230	0.28 ～ 0.39	820	0.32 ～ 0.44	2,250	0.57 ～ 0.81
16	720	0.3 ～ 0.43	500	0.3 ～ 0.43	440	0.3 ～ 0.43	400	0.3 ～ 0.43	240	0.3 ～ 0.43	200	0.3 ～ 0.43	720	0.34 ～ 0.46	1,950	0.61 ～ 0.85
18	640	0.34 ～ 0.49	440	0.34 ～ 0.49	390	0.34 ～ 0.49	355	0.34 ～ 0.49	210	0.34 ～ 0.49	180	0.34 ～ 0.49	640	0.36 ～ 0.5	1,750	0.63 ～ 0.9
20	570	0.36 ～ 0.5	400	0.36 ～ 0.5	350	0.36 ～ 0.5	320	0.36 ～ 0.5	190	0.36 ～ 0.5	160	0.36 ～ 0.5	570	0.4 ～ 0.56	1,550	0.68 ～ 0.98
22	520	0.4 ～ 0.55	360	0.4 ～ 0.55	320	0.4 ～ 0.55	300	0.4 ～ 0.55	170	0.4 ～ 0.55	150	0.4 ～ 0.55	520	0.42 ～ 0.59	1,400	0.73 ～ 1.06
24	480	0.41 ～ 0.6	330	0.41 ～ 0.6	290	0.41 ～ 0.6	270	0.41 ～ 0.6	160	0.41 ～ 0.6	135	0.41 ～ 0.6	480	0.46 ～ 0.65	1,300	0.77 ～ 1.13
26	440	0.42 ～ 0.65	310	0.42 ～ 0.65	270	0.42 ～ 0.65	250	0.42 ～ 0.65	150	0.42 ～ 0.65	120	0.42 ～ 0.65	440	0.47 ～ 0.68	1,200	0.81 ～ 1.2
28	410	0.45 ～ 0.7	290	0.45 ～ 0.7	250	0.45 ～ 0.7	230	0.45 ～ 0.7	140	0.45 ～ 0.7	110	0.45 ～ 0.7	410	0.5 ～ 0.73	1,100	0.84 ～ 1.26
30	380	0.48 ～ 0.75	270	0.48 ～ 0.75	230	0.48 ～ 0.75	210	0.48 ～ 0.75	130	0.48 ～ 0.75	105	0.48 ～ 0.75	380	0.54 ～ 0.78	1,000	0.87 ～ 1.32
32	360	0.51 ～ 0.8	250	0.51 ～ 0.8	220	0.51 ～ 0.8	200	0.51 ～ 0.8	120	0.51 ～ 0.8	100	0.51 ～ 0.8	360	0.58 ～ 0.83	950	0.9 ～ 1.38
34	340	0.53 ～ 0.84	235	0.53 ～ 0.84	210	0.53 ～ 0.84	185	0.53 ～ 0.84	110	0.53 ～ 0.84	95	0.53 ～ 0.84	340	0.61 ～ 0.87	900	0.93 ～ 1.45
36	320	0.56 ～ 0.88	220	0.56 ～ 0.88	200	0.56 ～ 0.88	175	0.56 ～ 0.88	105	0.56 ～ 0.88	90	0.56 ～ 0.88	320	0.64 ～ 0.91	850	0.95 ～ 1.5
38	300	0.58 ～ 0.92	210	0.58 ～ 0.92	195	0.58 ～ 0.92	170	0.58 ～ 0.92	100	0.58 ～ 0.92	85	0.58 ～ 0.92	300	0.67 ～ 0.95	805	0.97 ～ 1.55
40	290	0.6 ～ 0.95	200	0.6 ～ 0.95	185	0.6 ～ 0.95	160	0.6 ～ 0.95	95	0.6 ～ 0.95	80	0.6 ～ 0.95	290	0.7 ～ 1	770	1 ～ 1.6

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 孔深超过4倍直径时，请进行阶梯式进给，并按照下表设定切削速度。

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D
切削速度抑制系数 Coefficient for reducing speed	×1	×0.9

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce drilling speed by 20%.
4. The step process should be used when the drilling depth exceeds 4 times the drill diameter. (Using the table below)

形状尺寸表 SPECIFICATION CHARTS TDXL 10D ▶ P.310
形状尺寸表 SPECIFICATION CHARTS TDXL 15D ▶ P.312
形状尺寸表 SPECIFICATION CHARTS TDXL 20D ▶ P.314

TDXL钻头切削条件基准表 TDXL DRILLS CUTTING CONDITIONS

TDXL 10D•15D•20D

加工材料 Work Material	碳素钢 Carbon Steel S35C、S50C ～210HB 500～710N/㎟		合金钢 Alloy Steel SCM、SCr、SNCM 16～28HRC 710～900N/㎟		工具钢·模具钢(非调质) Tool Steels· Die Steel(unquenched) SKD、SK、DH31、DAC 710～900N/㎟		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD450、FCD600 400～600N/㎟	
切削速度 Cutting Speed	20～24 m/min		18～22m/min		12～16m/min		18～24m/min		16～20m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
1.6	4,400	0.016～0.03	4,000	0.016～0.03	2,800	0.016～0.03	4,200	0.03～0.05	3,600	0.01～0.03
2	3,500	0.02～0.05	3,200	0.02～0.04	2,200	0.02～0.04	3,300	0.04～0.06	2,900	0.01～0.04
3	2,300	0.03～0.08	2,100	0.03～0.08	1,500	0.03～0.07	2,200	0.06～0.1	1,900	0.02～0.08
4	1,800	0.04～0.1	1,600	0.04～0.1	1,100	0.04～0.09	1,700	0.08～0.13	1,400	0.02～0.1
5	1,400	0.05～0.13	1,300	0.05～0.13	900	0.05～0.12	1,300	0.1～0.16	1,100	0.03～0.13
6	1,200	0.06～0.15	1,100	0.06～0.15	750	0.06～0.14	1,100	0.12～0.19	950	0.04～0.15
8	900	0.08～0.2	800	0.08～0.2	550	0.08～0.18	850	0.16～0.26	700	0.05～0.2
10	700	0.1～0.25	650	0.1～0.25	450	0.1～0.23	650	0.2～0.32	550	0.06～0.25
12	600	0.12～0.3	550	0.12～0.3	350	0.12～0.28	550	0.24～0.38	500	0.07～0.3

1. 此切削条件基准表适用于水溶性切削油剂。
   使用油性切削油剂时，请将切削速度(转速)下调20% ~30%。
2. 请使用稀释倍率10~30倍的优质水溶性切削油剂。
3. 切削油剂的供油方式请参照P.433的 “切削油剂应用要点 ”。
4. 无阶梯加工排屑困难时，请使用阶梯式加工。
5. 卧式加工中心，由于喷嘴少，切削油剂喷油量不足时，请采用阶梯式进给。这种情况下，推荐采用退回孔口的阶梯式进给。
6. 加工前请进行导向孔加工或者中心定位加工。
   1)导向孔加工用工具请选择比TDXL直径大0. 05mm~0.1mm 的钻头径。深孔加工时，推荐孔越深，导向孔开孔越深。
   2)中心定位加工用工具推荐使用LDS先端角130度系列。

1. The indicated speeds and feeds are for drilling with water-soluble coolant. When using non-water-soluble coolant, set the drilling speed, reduce the drilling speed by 20-30%.
2. The most suitable cutting fluid is water-soluble coolant (10-30 times dilution).
3. Refer to the "p.433, Coolant Application Key Points" for instructions on how to apply the coolant.
4. If chips evacuation is difficult while non-step drilling, we recommend to add steps.
5. If the number of nozzles on a horizontal machine center is too few or the discharge flow rate is insufficient, perform step-feed drilling. In this case, we recommend a step-feed method in which the drill is retracted to the entrance of the hole.
6. Pilot or centering is necessary.
   1) For a pilot hole, select 0.05mm to 0.1mm larger size drill than TDXL. For deep hole, we recommend drilling a deeper pilot hole, 3 to 5D in depth.
   2) When centering it is recommended leading drill has a 130 degree point angle.

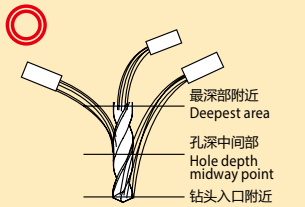
想要获得更稳定的加工请参考 P.433。
In order to have a more stable process please check p.433.

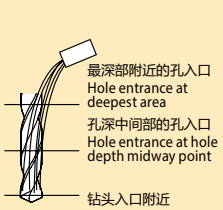
形状尺寸表 SPECIFICATION CHARTS TDXL 10D ▶ P.310
形状尺寸表 SPECIFICATION CHARTS TDXL 15D ▶ P.312
形状尺寸表 SPECIFICATION CHARTS TDXL 20D ▶ P.314

TDXL钻头切削条件基准表 TDXL DRILLS CUTTING CONDITIONS

■切削油剂的应用要点 Coolant Application Key Points

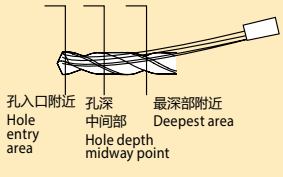
立式加工中心 Vertical Machine



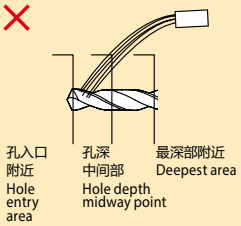


喷油量或喷头数量较少时尽量传达至钻头
Allow the coolant to move along the drill if the discharge flow rate is low or the number of nozzles is too few

卧式加工中心 Horizontal Machine



喷头较少时请提高切削油量和喷射压力使其沿着钻头流出并保证一直喷到孔入口。
If there are too few coolant nozzles is small, increase the amount of coolant and its discharge pressure and allow the coolant to move along the drill so that it is applied constantly to the entrance.



喷头较少时，即使切削油剂喷到孔入口处，也有可能加工途中会偏离孔
If there are too few coolant nozzles is small, the coolant that is applied to the hole entrance will stray from the hole along the way

■TDXL钻头推荐加工方法 Recommended operation for using TDXL

10D的场合 For 10D Type

使用OSG中心钻进行中心定位加工
Centering by OSG' s starting drills

●使用先端角为120°或130°的中心钻。
推荐钻头: NC-LDS, TIN-NC-LDS
Use 120 or 130 degree point angle starting drills. Recommended drills: NC-LDS, TIN-NC-LDS

15D、20D的场合 For 15D, 20DType

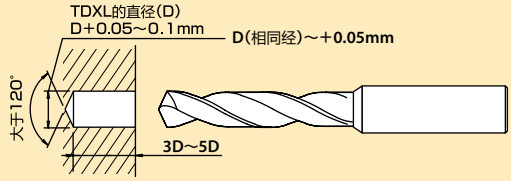
①导向孔加工
Make a pilot hole.

推荐钻头 EX-GDS
Recommended drill : EX-GDS

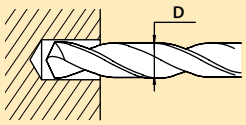
●导向孔加工用工具请选择比TDXL直径大0. 05mm~0.1mm 的钻头径。深孔加工时，推荐孔越深，导向孔开孔越深。
For a pilot hole, select 0.05mm to 0.1mm larger size drill than TDXL.
For deep hole, we recommend to drill deeper pilot hole.

●使用立式加工中心在工件上加工比较密集的孔时，推荐使用LDS130°进行中心定位加工，以避免钻头加工时产生切屑缠绕，导致钻头崩损。在这种情况下，TDXL钻头在加工初始，入口到3D孔深的进给量需控制在钻头直径的1%，之后再提高到切削条件基准表中推荐的进给量范围。
※但是在这种情况下，孔的真直度可能会变差。
For a vertical machining center. When drilling many holes in a small area with vertical machining center. We recommend only centering by 130 degree point angle LDS to avoid chips building up in pilot holes, which can cause drill chipping or breakage. When drilling the pilot hole it is recommended to make the hole 3xD in depth, at a feed rate equal to (Drill ϕx 0.01) per revolution. Straightness will be less accurate than a comparable operation in a horizontal machining center.

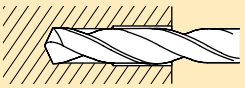
●导向孔加工用工具推荐使用先端角大于120°的钻头。
We recommended to use point angle from 120 degree and over.



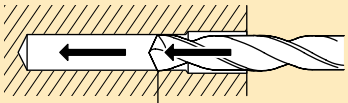
②以低转速插入TDXL（500min⁻¹以下）
Insert the TDXL into a pilot hole with low revolution. (~500min⁻¹)



③开始供应切削油剂
Start supplying the coolant.

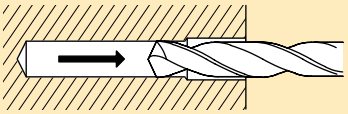


④加速至规定转速后开始加工。但是在TDXL钻头加工开始时，进给量需控制在钻头直径的1%、直到加工至3–5D深度时再提高进给量。
Increase the revolution to the designated speed and start drilling.
At the start of drilling, set the feed rate to 1% of the drill diameter and increase the feed rate when the depth reaches between 3xD and 5xD.



增加进给量至1-2%D 3-5D孔深时进给量为1%D
Increase feed rate to between 1 and 2% Set it to 1%D between 3xD and 5xD

⑤加工后，拔出钻头时，在钻头离开孔底后，请降低转速拔出。
After drilling, move the drill away from the bottom of the hole; then reduce its speed while pulling it out of the hole.



车床用钻头切削条件基准表 LATHE DRILLS CUTTING CONDITIONS

V-MT-GDN

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ~500N/mm²		碳素钢 Carbon Steel S45C 500~710N/mm²		合金钢 Alloy Steel SCM 710~900N/mm²		特殊钢·调质钢 Special Alloy Steel·Hardened Steel SKD61 ~900N/mm²		SKD11 900~1060N/mm²		铸铁 Cast Iron FC250 ~350N/mm²		铸造铝合金 Aluminum Alloy Castings AC·ADC	
切削速度 Cutting Speed	32~45m/min		25~32m/min		22~28m/min		10~18m/min		8~12m/min		32~40m/min		70~120m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
6	2,000	0.13 ~ 0.19	1,600	0.13 ~ 0.19	1,300	0.13 ~ 0.19	800	0.13 ~ 0.19	530	0.13 ~ 0.19	1,900	0.19 ~ 0.26	5,300	0.34 ~ 0.48
8	1,500	0.17 ~ 0.24	1,200	0.17 ~ 0.24	1,000	0.17 ~ 0.24	600	0.17 ~ 0.24	400	0.17 ~ 0.24	1,450	0.21 ~ 0.3	4,000	0.38 ~ 0.53
10	1,200	0.2 ~ 0.28	950	0.2 ~ 0.28	800	0.2 ~ 0.28	480	0.2 ~ 0.28	320	0.2 ~ 0.28	1,150	0.25 ~ 0.36	3,200	0.45 ~ 0.63
12	1,000	0.24 ~ 0.34	800	0.24 ~ 0.34	660	0.24 ~ 0.34	400	0.24 ~ 0.34	270	0.24 ~ 0.34	960	0.3 ~ 0.42	2,650	0.53 ~ 0.75
13	950	0.26 ~ 0.36	740	0.26 ~ 0.36	610	0.26 ~ 0.36	370	0.26 ~ 0.36	250	0.26 ~ 0.36	880	0.31 ~ 0.42	2,450	0.56 ~ 0.79
14	880	0.28 ~ 0.39	680	0.28 ~ 0.39	570	0.28 ~ 0.39	340	0.28 ~ 0.39	230	0.28 ~ 0.39	820	0.32 ~ 0.44	2,280	0.57 ~ 0.81
16	770	0.3 ~ 0.43	600	0.3 ~ 0.43	500	0.3 ~ 0.43	300	0.3 ~ 0.43	200	0.3 ~ 0.43	720	0.34 ~ 0.46	2,000	0.61 ~ 0.85
18	680	0.34 ~ 0.49	530	0.34 ~ 0.49	440	0.34 ~ 0.49	270	0.34 ~ 0.49	180	0.34 ~ 0.49	640	0.36 ~ 0.5	1,800	0.63 ~ 0.9
20	610	0.36 ~ 0.5	480	0.36 ~ 0.5	400	0.36 ~ 0.5	240	0.36 ~ 0.5	160	0.36 ~ 0.5	570	0.4 ~ 0.56	1,600	0.68 ~ 0.98
22	560	0.4 ~ 0.55	430	0.4 ~ 0.55	360	0.4 ~ 0.55	220	0.4 ~ 0.55	150	0.4 ~ 0.55	520	0.42 ~ 0.59	1,500	0.73 ~ 1.06
24	510	0.41 ~ 0.6	400	0.41 ~ 0.6	330	0.41 ~ 0.6	200	0.41 ~ 0.6	130	0.41 ~ 0.6	480	0.46 ~ 0.65	1,350	0.77 ~ 1.13
26	470	0.42 ~ 0.65	370	0.42 ~ 0.65	310	0.42 ~ 0.65	180	0.42 ~ 0.65	120	0.42 ~ 0.65	440	0.47 ~ 0.68	1,200	0.81 ~ 1.2
28	440	0.45 ~ 0.7	340	0.45 ~ 0.7	280	0.45 ~ 0.7	170	0.45 ~ 0.7	110	0.45 ~ 0.7	410	0.5 ~ 0.73	1,150	0.84 ~ 1.26
30	410	0.48 ~ 0.75	320	0.48 ~ 0.75	270	0.48 ~ 0.75	160	0.48 ~ 0.75	105	0.48 ~ 0.75	380	0.54 ~ 0.78	1,050	0.87 ~ 1.32
32	380	0.51 ~ 0.8	300	0.51 ~ 0.8	250	0.51 ~ 0.8	150	0.51 ~ 0.8	100	0.51 ~ 0.8	360	0.58 ~ 0.83	1,000	0.9 ~ 1.38

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 孔深超过直径的4倍时，请按照下表设定切削速度。
5. 车床、卧式加工中心加工孔深超过3倍直径、立式加工中心加工孔深超过4倍直径时，请使用阶梯式进给。

D : drill dia

孔深 (D为外径) Depth of Hole	4D以下 ≦4D	5D以下 ≦5D
切削速度抑制系数 Coefficient for reducing speed	×1	×0.9

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. For drilling depth > 4D, reduce the drilling speed (using the table below).
5. The step process should be used when the drilling depth exceeds 3 times the drill diameter for lathe / horizontal machines and 4 times the drill diameter for vertical machines.

形状尺寸表 SPECIFICATION CHARTS
EX-MT-TDR ▶ P.318

钢筋用钻头切削条件基准表 STEEL FRAME DRILLS CUTTING CONDITIONS

EX-MT-TDR

加工材料 Work Material	一般构造用钢SS400（旧JIS SS41） Steels For General Structure		高张力溶接结构用钢 High Tensile Strength Steel For Welded Structure SM490（前JIS SM50）·SN490		高张力钢 High Tensile Strength Steel SM570·High Tensile 60 SM570（前JIS SM58）·高张力钢60	
切削速度 Cutting Speed	25～32m/min		18～25m/min		14～20m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
18	550	0.27～0.36	350	0.27～0.36	320	0.27～0.32
20	500	0.3～0.4	320	0.3～0.4	280	0.3～0.36
22	450	0.33～0.44	280	0.33～0.44	260	0.33～0.4
24	400	0.35～0.48	260	0.35～0.48	240	0.35～0.43
26	380	0.36～0.52	240	0.36～0.52	220	0.36～0.46

1. 对H型钢薄板加工，请降低进给速度。
2. 请将切削油剂供给在钻头刃尖。
3. 多层板加工时，请尽可能的保持板与板之间的最小间隙。

1. For drilling thin portions(e.g..the web of H steels), reduce the feed rate appropriately.
2. Supply sufficient cutting fluid to the drill point.
3. For drilling applications on piled plates, minimize the space between each plate.

泛用型钻头切削条件基准表 GENERAL-PURPOSE DRILLS CUTTING CONDITIONS

V-SDR

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400		碳素钢 Carbon Steel S45C·S50C		合金钢 Alloy Steel SCM·SNC·SNCM		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61 35HRC		特殊钢 Special Alloy Steel SKD11		铸铁 Cast Iron FC250		铸造铝合金 Aluminum Alloy Castings AC4A·ADC	
切削速度 Cutting Speed	22～40m/min		16～30m/min		12～25m/min		8～16m/min		6～12m/min		22～40m/min		50～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
2	5,700	0.02 ～ 0.08	4,000	0.02 ～ 0.08	3,500	0.02 ～ 0.08	1,900	0.02 ～ 0.08	1,600	0.02 ～ 0.08	5,700	0.07 ～ 0.1	10,000	0.07 ～ 0.1
3	3,850	0.03 ～ 0.1	2,800	0.03 ～ 0.1	2,400	0.03 ～ 0.1	1,320	0.03 ～ 0.1	1,060	0.03 ～ 0.1	3,850	0.11 ～ 0.14	10,000	0.11 ～ 0.14
4	2,900	0.04 ～ 0.13	2,100	0.04 ～ 0.13	1,800	0.04 ～ 0.13	950	0.04 ～ 0.13	800	0.04 ～ 0.13	2,900	0.12 ～ 0.17	7,500	0.12 ～ 0.17
5	2,260	0.05 ～ 0.15	1,600	0.05 ～ 0.15	1,400	0.05 ～ 0.15	750	0.05 ～ 0.15	630	0.05 ～ 0.15	2,260	0.14 ～ 0.2	6,300	0.14 ～ 0.2
6	1,900	0.06 ～ 0.17	1,320	0.06 ～ 0.17	1,180	0.06 ～ 0.17	630	0.06 ～ 0.17	530	0.06 ～ 0.17	1,900	0.17 ～ 0.24	5,000	0.17 ～ 0.24
8	1,400	0.08 ～ 0.21	1,000	0.08 ～ 0.21	900	0.08 ～ 0.21	480	0.08 ～ 0.21	400	0.08 ～ 0.21	1,400	0.19 ～ 0.28	4,000	0.19 ～ 0.28
10	1,120	0.1 ～ 0.22	800	0.1 ～ 0.22	710	0.1 ～ 0.22	380	0.1 ～ 0.22	320	0.1 ～ 0.22	1,120	0.22 ～ 0.33	3,150	0.22 ～ 0.33
12	950	0.12 ～ 0.27	670	0.12 ～ 0.27	600	0.12 ～ 0.27	320	0.12 ～ 0.27	270	0.12 ～ 0.27	950	0.26 ～ 0.38	2,650	0.26 ～ 0.38
13	880	0.13 ～ 0.29	620	0.13 ～ 0.29	550	0.13 ～ 0.29	300	0.13 ～ 0.29	250	0.13 ～ 0.29	880	0.27 ～ 0.39	2,450	0.27 ～ 0.39

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释倍率20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或稀释倍率超过20倍的水溶性切削油剂时，请把切削速度降低20%。
4. 孔深超过直径的3倍时，请降低上表切削条件使用。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. The most suitable cutting fluid is water-soluble high density coolant (less than 20 times dilution).
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce the drilling speed by 20%.
4. For drilling depth > 3D, reduce the drilling speed and feed rate appropriately.

形状尺寸表 SPECIFICATION CHARTS
AD-LDS ▶ P.325

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

AD-LDS 中心定位 CENTERING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61·～900N/mm² 28HRC		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD11·～1060N/mm² 34HRC		工具钢 Tool Steel		球墨铸铁 Cast Iron·Ductile Cast Iron FCD250·FC400 ～500N/mm²		铸造铝合金 Aluminum Alloy Casting ADC·AC4D	
切削速度 Cutting Speed	63～80m/min		40～63m/min		32～50m/min		20～30m/min		16～22m/min		16～22m/min		63～100m/min		80～160m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	20,000	0.005～0.02	25,000	0.005～0.02	20,000	0.005～0.02	16,000	0.005～0.02	12,000	0.005～0.02	12,000	0.005～0.02	注1) Note	0.005～0.015	注1) Note	0.02～0.04
1	10,000	0.01～0.03	16,000	0.01～0.03	10,000	0.01～0.03	8,000	0.01～0.03	6,000	0.01～0.03	6,000	0.01～0.03	20,000	0.01～0.03	注1) Note	0.04～0.07
2	5,000	0.03～0.06	8,000	0.03～0.06	5,000	0.03～0.06	4,000	0.03～0.06	3,000	0.03～0.06	3,000	0.03～0.06	12,000	0.03～0.06	15,000	0.06～0.14
3	7,500	0.04～0.08	5,500	0.04～0.08	4,500	0.04～0.08	2,700	0.04～0.08	2,000	0.04～0.08	2,000	0.04～0.08	8,000	0.05～0.09	12,000	0.1～0.22
4	5,700	0.05～0.1	4,100	0.05～0.1	3,300	0.05～0.1	2,000	0.05～0.1	1,500	0.05～0.1	1,500	0.05～0.1	6,500	0.07～0.12	9,500	0.12～0.25
6	3,800	0.06～0.12	2,700	0.06～0.12	2,300	0.06～0.12	1,300	0.06～0.12	1,000	0.06～0.12	1,000	0.06～0.12	4,300	0.12～0.18	6,400	0.14～0.28
8	2,800	0.08～0.15	2,000	0.08～0.15	1,700	0.08～0.15	1,000	0.08～0.15	750	0.08～0.15	750	0.08～0.15	3,200	0.13～0.2	4,800	0.18～0.32
10	2,300	0.1～0.18	1,700	0.1～0.18	1,400	0.1～0.18	800	0.1～0.18	600	0.1～0.18	600	0.1～0.18	2,600	0.17～0.25	3,800	0.22～0.36
12	1,900	0.12～0.21	1,400	0.12～0.21	1,200	0.12～0.21	650	0.12～0.21	500	0.12～0.21	500	0.12～0.21	2,200	0.21～0.3	3,200	0.25～0.4

1. 如果不能达到表中所示转速，请尽量设置高转速。
2. 此切削条件基准表适用于水溶性切削油剂。
3. 使用油性切削油剂时，请将切削速度降低20%。
4. 当以曲面或倾斜面为中心定位时，请降低进给量。
5. 不推荐在不锈钢上进行中心定位。请使用 TIN-NC-LDS 或NC-LDS。

1. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.
2. The indicated speeds and feeds are for drilling with water-soluble coolant.
3. When using non-water-soluble coolant, reduce the drilling speed by 20%.
4. When centering on a curved or inclined surface, reduce the feed rate accordingly.
5. Centering on Stainless Steels is not recommended. For these procedures, use the TIN-NC-LDS or the NC-LDS.

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

AD-LDS 倒角 COUNTERSINKING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61·～900N/mm² 28HRC		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD11·～1060N/mm² 34HRC		淬火钢 Quenched and Tempered Steel 45～50HRC		铸铁·球墨铸铁 Cast Iron · Ductile Cast Iron FCD250 · FC400 ～500N/mm²		铸造铝合金 Aluminum Alloy Casting ADC · AC4D	
切削速度 Cutting Speed	63～80m/min		40～63m/min		32～50m/min		20～30m/min		20～30m/min		20～30m/min		63～100m/min		80～160m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	20,000	0.005～0.05	25,000	0.005～0.05	20,000	0.005～0.05	16,000	0.005～0.05	16,000	0.005～0.05	16,000	0.005～0.02	注1) Note	0.005～0.05	注1) Note	0.005～0.05
1	10,000	0.01～0.1	16,000	0.01～0.1	10,000	0.01～0.1	8,000	0.01～0.1	8,000	0.01～0.1	8,000	0.01～0.03	20,000	0.01～0.1	注1) Note	0.01～0.1
2	5,000	0.02～0.18	8,000	0.02～0.18	5,000	0.02～0.18	4,000	0.02～0.18	4,000	0.02～0.18	4,000	0.03～0.06	12,000	0.02～0.18	15,000	0.02～0.18
3	7,500	0.04～0.24	5,500	0.04～0.24	4,500	0.04～0.24	2,700	0.04～0.24	2,700	0.04～0.24	2,700	0.04～0.08	8,000	0.04～0.24	12,000	0.04～0.24
4	5,700	0.04～0.24	4,100	0.04～0.24	3,300	0.04～0.24	2,000	0.04～0.24	2,000	0.04～0.24	2,000	0.05～0.1	6,500	0.04～0.24	9,500	0.04～0.24
6	3,800	0.06～0.36	2,700	0.06～0.36	2,300	0.06～0.36	1,300	0.06～0.36	1,300	0.06～0.36	1,300	0.06～0.12	4,300	0.06～0.36	6,400	0.06～0.36
8	2,800	0.08～0.38	2,000	0.08～0.38	1,700	0.08～0.38	1,000	0.08～0.38	1,000	0.08～0.38	1,000	0.08～0.15	3,200	0.08～0.38	4,800	0.08～0.38
10	2,300	0.1～0.4	1,700	0.1～0.4	1,400	0.1～0.4	800	0.1～0.4	800	0.1～0.4	800	0.1～0.18	2,600	0.1～0.4	3,800	0.1～0.4
12	1,900	0.12～0.42	1,400	0.12～0.42	1,200	0.12～0.42	650	0.12～0.42	650	0.12～0.42	650	0.12～0.21	2,200	0.12～0.42	3,200	0.12～0.42

1. 如果不能达到表中所示转速，请尽量设置高转速。
2. 此切削条件基准表适用于水溶性切削油剂。
3. 使用油性切削油剂时，请将切削速度降低20%。
4. 当以曲面或倾斜面为中心定位时，请降低进给量。
5. 高速加工的情况下，请将上表切削速度中央值的2倍作为上限。
6. 加工不锈钢倒角时，请参考低碳素钢的数值。

1. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.
2. The indicated speeds and feeds are for drilling with water-soluble coolant.
3. When using non-water-soluble coolant, reduce the drilling speed by 20%.
4. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
5. For high-speed machining, double the median value of the above cutting condition to use as upper limit.
6. When countersinking on Stainless Steels, use a condition of Low Carbon Steel.

形状尺寸表 SPECIFICATION CHARTS
FX-LS-LDS ▶ P.336

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

FX-LS-LDS 倒角(钢用) COUNTERSINKING FOR STEELS

直径 Drill Dia. (mm)	0.5	1	2	3	4	6	8	10	12	16	20	25
切削速度 Cutting Speed (m/min)	切削速度请以中心定位中推荐速度的2倍左右为上限。 Cutting speed can be up to 2 times the limit shown above for centering.											
进给量 Feed Rate (mm/rev)	0.005～0.02	0.01～0.04	0.02～0.08	0.04～0.12	0.05～0.16	0.06～0.24	0.08～0.28	0.1～0.3	0.12～0.32	0.16～0.36	0.2～0.4	0.25～0.5

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 加工淬火钢倒角时，请设定切削速度20～40/min，使用低进给量。
5. 加工不锈钢倒角时，请设定切削速度63～100/min。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
4. When counter sinking on hardened steels, use a drilling speed of 20-40m/min and lower the feed rate accordingly.
5. When counter sinking on Stainless Steels, use a drilling speed of 63-100m/min.

形状尺寸表 SPECIFICATION CHARTS NC-LDS ▶ P.328
形状尺寸表 SPECIFICATION CHARTS VP-LDS ▶ P.330
形状尺寸表 SPECIFICATION CHARTS VP-LS-LDS ▶ P.332

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

NC-LDS·VP-LDS·VP-LS-LDS 中心定位 CENTERING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/㎟		碳素钢 Carbon Steel S45C		合金钢 Alloy Steel SCM440		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61 35HRC		特殊钢 Special Alloy Steel SKD11		铸铁·球墨铸铁 Cast Iron·Ductile Cast Iron FCD250·FC400 ～500N/㎟		不锈钢 Stainless Steel SUS304		铸造铝合金 Aluminium Alloy Casting ADC·AC4D	
切削速度 Cutting Speed	32～40m/min		22～30m/min		20～25m/min		10～13m/min		8～12m/min		25～32m/min		8～12m/min		51～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3	3,850	0.04～0.08	2,800	0.04～0.08	2,400	0.04～0.08	1,220	0.04～0.08	1,060	0.04～0.08	3,100	0.04～0.09	1,060	0.04～0.08	8,000	0.1～0.22
4	2,900	0.05～0.1	2,100	0.05～0.1	1,800	0.05～0.1	910	0.05～0.1	800	0.05～0.1	2,400	0.05～1.12	800	0.05～0.1	6,000	0.12～0.25
6	1,900	0.06～0.12	1,320	0.06～0.12	1,180	0.06～0.12	610	0.06～0.12	530	0.06～0.12	1,600	0.06～0.18	530	0.06～0.12	4,000	0.14～0.28
8	1,400	0.08～0.15	1,000	0.08～0.15	900	0.08～0.15	450	0.08～0.15	400	0.08～0.15	1,200	0.08～0.2	400	0.08～0.15	3,000	0.18～0.32
10	1,120	0.1～0.18	800	0.1～0.18	710	0.1～0.18	360	0.1～0.18	320	0.1～0.18	950	0.1～0.25	320	0.1～0.18	2,400	0.22～0.36
12	950	0.12～0.21	670	0.12～0.21	600	0.12～0.21	300	0.12～0.21	270	0.12～0.21	800	0.12～0.3	270	0.12～0.21	2,000	0.25～0.4
16	720	0.16～0.28	520	0.16～0.28	450	0.16～0.28	220	0.16～0.28	200	0.16～0.28	600	0.16～0.32	200	0.16～0.28	1,500	0.32～0.48
20	560	0.2～0.34	400	0.2～0.34	360	0.2～0.34	180	0.2～0.34	160	0.2～0.34	480	0.2～0.4	160	0.2～0.34	1,200	0.4～0.6
25	450	0.25～0.45	320	0.25～0.45	290	0.25～0.45	150	0.25～0.45	130	0.25～0.45	380	0.25～0.5	130	0.25～0.45	960	0.5～0.75

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 使用长柄型VP-LS-LDS时，请降低进给量。
5. 使用VP-LDS时，即使将切削速度提升20%左右，也能充分发挥性能。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When centering on a curved or inclined surface, reduce the feed rate accordingly.
4. When using the long shank version, reduce the feed rate accordingly.
5. When using VP-LDS, the drilling speed can be increased 1.2 times the speed listed above.

NC-LDS·VP-LDS 倒角 COUNTERSINKING

直径 Drill Dia. (mm)	3	4	6	8	10	12	16	20	25
切削速度 Cutting Speed (m/min)	切削速度请以中心定位中推荐速度的2倍左右为上限。 Drilling speed can be up to 2 times the limit shown above for centering.								
进给量 Feed (mm/rev)	0.04～0.1	0.05～0.12	0.06～0.18	0.08～0.24	0.1～0.3	0.12～0.36	0.16～0.48	0.2～0.55	0.25～0.6

VP-LS-LDS 倒角 COUNTERSINKING

直径 Drill Dia. (mm)	3	4	6	8	10	12	16	20	25
切削速度 Cutting Speed (m/min)	切削速度请以中心定位中推荐速度的2倍左右为上限。 Drilling speed can be up to 2 times the limit shown above for centering.								
进给量 Feed (mm/rev)	0.04～0.08	0.05～0.1	0.06～0.12	0.08～0.15	0.1～0.18	0.12～0.21	0.16～0.28	0.2～0.34	0.25～0.45

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 加工淬火钢倒角时，请使用硬质合金中心钻。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
4. When counter sinking on hardened steels, use the Carbide starter drill.

形状尺寸表 SPECIFICATION CHARTS
PLDS ▶ P.337

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

PLDS

	加工材料 Work Material	抗损强度・硬度 Tensile Strengh・Hardness	切削速度 Vc Cutting Speed (m/min)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	
					中心定位加工 Centering	倒角加工 (横向进给) Countersinking (Side Feed)
P	软钢、低碳素钢 Mild Steel, Carbon Steel **(SS400, S10C)**	～180HB	80（ 60 ～ 120）	1,500 ～ 3,000	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
P	碳素钢、合金钢 Carbon Steel, Alloy Steel **(S50C, SCM440)**	～280HB	80（ 60 ～ 120）	1,500 ～ 3,000	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
P	模具钢 Die Steel **(SKD11, SKD61)**	～280HB	80（ 60 ～ 120）	1,500 ～ 3,000	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
M	不锈钢 Stainless Steel **(SUS304, SUS420)**	～250HB	80（ 60 ～ 100）	1,500 ～ 2,500	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
K	铸铁 Cast Iron **(FC250)**	～350N/mm^2	100（ 60 ～ 140）	1,500 ～ 3,500	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
K	球墨铸铁 Ductile Cast Iron **(FCD400)**	～800N/mm^2	100（ 60 ～ 140）	1,500 ～ 3,500	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
N	铝合金 Aluminum Alloy	～13%Si	150 (100 ～ 200)	2,500 ～ 5,000	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
S	耐热合金（湿式） Superalloy (Wet) **(Inconel 718)**	—	35（ 25 ～ 60）	600 ～ 1,500	0.04 (0.03 ～0.06)	0.08 (0.05 ～0.12)
S	钛合金（湿式） Titanium Alloy (Wet) **(Ti-6Al-4V)**	—	40（ 30 ～ 100）	700 ～ 2,500	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
H	预硬钢 Pre-hardened Steel **(NAK80)**	40～43HRC	80（ 60 ～ 100）	1,500 ～ 3,000	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)
H	铸件用钢 Steel for Die Casting **(DAC-MAGIC, DH31)**	43～48HRC	60（ 50 ～ 80）	1,200 ～ 2,000	0.06 (0.03 ～0.08)	0.08 (0.05 ～0.12)

1. 此切削条件基准表的数值是根据实际切削速度的标准数据。请根据加工环境适当调整。
2. 安装刀片时，请确保在整洁干净的状态下牢固安装。
3. 请保持加工材料在不变形、不弯曲、不振动的状态下。
4. V形槽加工的进给量请使用上表中倒角加工(横向进给)的80%。

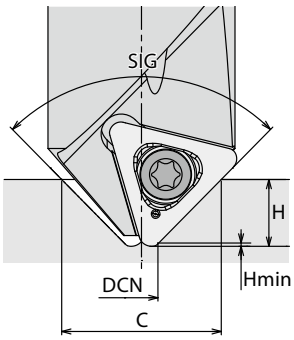
1. The above cutting conditions are to be used as general guidelines. Adjustments may be necessary depending on actual cutting condition.
2. Inserts should be attached to the holder tightly in a very neat condition.
3. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
4. For the feed of V slotting, use 80% of the countersinking (side feed) shown in the above table.

■按加工材料推荐材质
Recommended Materials by Insert Type

◎第一推荐材质 Best
○第二推荐材质 Good

刀片材质 Insert Grades	切削油剂 Coolant	P	M	K	N	S	H
XP9020	有 Wet	◎	○	◎	○	○	○
XP2040	无 Dry	○	○				
	有 Wet	○	◎		○	◎	◎

■中心定位加工深度的标准(H) Standard centering depth (H)



SIG=90° 时 When SIG=90°
Hmin=0.25
DCN =φ2.5(最小加工径)
(Minimum machined hole diameter)

$$H=(C-DCN)\div 2+Hmin$$

H：中心定位加工深度 C：沉孔直径

例) SIG=90° C=φ10(沉孔直径)时，
H的值不是5mm，而是4mm。

SIG=120° 时 When SIG=120°
Hmin=0.1
DCN =φ2.4(最小加工径)
(Minimum machined hole diameter)

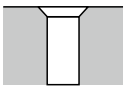
$$H=(C-DCN)\div 3.46+Hmin$$

H: Centering depth C: Countersink diameter

Example: When SIG=90° C=φ10 (Countersink diameter)
The value of H will be 4 mm instead of 5 mm.

倒角刀切削条件基准表 CUTTING CONDITIONS

FX-MG-CS(60°·90°) 硬质合金倒角刀 CARBIDE COUNTERSINC

加工材料 Work Material	铸铁 Cast Iron FC250 FCD400 (~750N/㎟)		一般构造用钢·碳素钢 Mild Steel·Carbon Steel SS400、S45C (~750N/㎟)		合金钢 Alloy Steel SCM435 (~30HRC)		预硬钢 Prehardened Steel NAK55 (30~38HRC)		铝合金 Aluminum Alloy AC4D		不锈钢 Stainless Steel SUS304	
切削速度 Cutting Speed	30~60m/min		60~100m/min		30~40m/min		25~40m/min		100~180m/min		24~36m/min	
直径 Mill Dia. (mm)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)
6.3	3,035	0.17	4,550	0.17	1,820	0.11	1,820	0.11	7,580	0.17	1,515	0.11
8.3	2,300	0.22	3,455	0.22	1,380	0.14	1,380	0.14	5,755	0.22	1,150	0.14
10.4	1,835	0.27	2,755	0.27	1,100	0.18	1,100	0.18	4,595	0.27	920	0.18
12.4	1,540	0.32	2,380	0.32	925	0.22	925	0.22	3,850	0.32	770	0.22
16.5	1,160	0.38	1,735	0.4	695	0.25	695	0.25	2,895	0.4	580	0.25
20.5	930	0.45	1,400	0.45	560	0.28	560	0.28	2,330	0.45	465	0.28
25	765	0.5	1,145	0.5	460	0.32	460	0.32	1,910	0.5	380	0.32
切削深度 Depth Of Cut												

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请把切削速度降低20%。

1. The "Recommended Milling Conditions" above are applicable when using a water-soluble cutting fluid.
2. When using a non-water-soluble cutting fluid, the cutting speed must be reduced 20%.

形状尺寸表 SPECIFICATION CHARTS
AD-LS-LDS ▶ P.326

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

AD-LS-LDS

注1) Note
中心定位 CENTERING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61·～900N/mm² 28HRC		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD11·～1060N/mm² 34HRC		工具钢 Tool Steel		球墨铸铁 Cast Iron·Ductile Cast Iron FCD250·FC400 ～500N/mm²		铸造铝合金 Aluminum Alloy Casting ADC·AC4D	
切削速度 Cutting Speed	63～80m/min		40～63m/min		32～50m/min		20～30m/min		16～22m/min		16～22m/min		63～100m/min		80～160m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	20,000	0.005～0.02	25,000	0.005～0.02	20,000	0.005～0.02	16,000	0.005～0.02	12,000	0.005～0.02	12,000	0.005～0.02	注2) Note	0.005～0.015	注2) Note	0.02～0.04
1	10,000	0.01～0.03	16,000	0.01～0.03	10,000	0.01～0.03	8,000	0.01～0.03	6,000	0.01～0.03	6,000	0.01～0.03	20,000	0.01～0.03	注2) Note	0.04～0.07
2	5,000	0.03～0.06	8,000	0.03～0.06	5,000	0.03～0.06	4,000	0.03～0.06	3,000	0.03～0.06	3,000	0.03～0.06	12,000	0.03～0.06	15,000	0.06～0.14
3	7,500	0.04～0.08	5,500	0.04～0.08	4,500	0.04～0.08	2,700	0.04～0.08	2,000	0.04～0.08	2,000	0.04～0.08	8,000	0.05～0.09	12,000	0.1～0.22
4	5,700	0.05～0.1	4,100	0.05～0.1	3,300	0.05～0.1	2,000	0.05～0.1	1,500	0.05～0.1	1,500	0.05～0.1	6,500	0.07～0.12	9,500	0.12～0.25
6	3,800	0.06～0.12	2,700	0.06～0.12	2,300	0.06～0.12	1,300	0.06～0.12	1,000	0.06～0.12	1,000	0.06～0.12	4,300	0.12～0.18	6,400	0.14～0.28
8	2,800	0.08～0.15	2,000	0.08～0.15	1,700	0.08～0.15	1,000	0.08～0.15	750	0.08～0.15	750	0.08～0.15	3,200	0.13～0.2	4,800	0.18～0.32
10	2,300	0.1～0.18	1,700	0.1～0.18	1,400	0.1～0.18	800	0.1～0.18	600	0.1～0.18	600	0.1～0.18	2,600	0.17～0.25	3,800	0.22～0.36
12	1,900	0.12～0.21	1,400	0.12～0.21	1,200	0.12～0.21	650	0.12～0.21	500	0.12～0.21	500	0.12～0.21	2,200	0.21～0.3	3,200	0.25～0.4

1. 当使用AD-LS-LDS(长柄型)时，请降低进给量。
2. 如果不能达到表中所示转速，请尽量设置高转速。
3. 此切削条件基准表适用于水溶性切削油剂。
4. 使用油性切削油剂时，请将切削速度降低20%。
5. 当以曲面或倾斜面为中心定位时，请降低进给量。
6. 不推荐在不锈钢上进行中心定位。请使用 TIN-NC-LDS 或NC-LDS。

1. When using AD-LS-LDS, reduce the feed rate accordingly.
2. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.
3. The indicated speeds and feeds are for drilling with water-soluble coolant.
4. When using non-water-soluble coolant, reduce the drilling speed by 20%.
5. When centering on a curved or inclined surface, reduce the feed rate accordingly.
6. Centering on Stainless Steels is not recommended. For these procedures, use the TIN-NC-LDS or the NC-LDS.

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

AD-LS-LDS

注1) Note
倒角 COUNTERSINKING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61·～900N/mm² 28HRC		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD11·～1060N/mm² 34HRC		淬火钢 Quenched and Tempered Steel 45～50HRC		铸铁·球墨铸铁 Cast Iron · Ductile Cast Iron FCD250 · FC400 ～500N/mm²		铸造铝合金 Aluminum Alloy Casting ADC · AC4D	
切削速度 Cutting Speed	63～80m/min		40～63m/min		32～50m/min		20～30m/min		20～30m/min		20～30m/min		63～100m/min		80～160m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	20,000	0.005～0.05	25,000	0.005～0.05	20,000	0.005～0.05	16,000	0.005～0.05	16,000	0.005～0.05	16,000	0.005～0.02	注2) Note	0.005～0.05	注2) Note	0.005～0.05
1	10,000	0.01～0.1	16,000	0.01～0.1	10,000	0.01～0.1	8,000	0.01～0.1	8,000	0.01～0.1	8,000	0.01～0.03	20,000	0.01～0.1	注2) Note	0.01～0.1
2	5,000	0.02～0.18	8,000	0.02～0.18	5,000	0.02～0.18	4,000	0.02～0.18	4,000	0.02～0.18	4,000	0.03～0.06	12,000	0.02～0.18	15,000	0.02～0.18
3	7,500	0.04～0.24	5,500	0.04～0.24	4,500	0.04～0.24	2,700	0.04～0.24	2,700	0.04～0.24	2,700	0.04～0.08	8,000	0.04～0.24	12,000	0.04～0.24
4	5,700	0.04～0.24	4,100	0.04～0.24	3,300	0.04～0.24	2,000	0.04～0.24	2,000	0.04～0.24	2,000	0.05～0.1	6,500	0.04～0.24	9,500	0.04～0.24
6	3,800	0.06～0.36	2,700	0.06～0.36	2,300	0.06～0.36	1,300	0.06～0.36	1,300	0.06～0.36	1,300	0.06～0.12	4,300	0.06～0.36	6,400	0.06～0.36
8	2,800	0.08～0.38	2,000	0.08～0.38	1,700	0.08～0.38	1,000	0.08～0.38	1,000	0.08～0.38	1,000	0.08～0.15	3,200	0.08～0.38	4,800	0.08～0.38
10	2,300	0.1～0.4	1,700	0.1～0.4	1,400	0.1～0.4	800	0.1～0.4	800	0.1～0.4	800	0.1～0.18	2,600	0.1～0.4	3,800	0.1～0.4
12	1,900	0.12～0.42	1,400	0.12～0.42	1,200	0.12～0.42	650	0.12～0.42	650	0.12～0.42	650	0.12～0.21	2,200	0.12～0.42	3,200	0.12～0.42

1. 当使用AD-LS-LDS(长柄型)时，请降低进给量。
2. 如果不能达到表中所示转速，请尽量设置高转速。
3. 此切削条件基准表适用于水溶性切削油剂。
4. 使用油性切削油剂时，请将切削速度降低20%。
5. 当以曲面或倾斜面为中心定位时，请降低进给量。
6. 高速加工的情况下，请将上表切削速度中央值的2倍作为上限。
7. 加工不锈钢倒角时，请参考低碳素钢的数值。

1. When using AD-LS-LDS, reduce the feed rate accordingly.
2. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.
3. The indicated speeds and feeds are for drilling with water-soluble coolant.
4. When using non-water-soluble coolant, reduce the drilling speed by 20%.
5. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
6. For high-speed machining, double the median value of the above cutting condition to use as upper limit.
7. When countersinking on Stainless Steels, use a condition of Low Carbon Steel.

形状尺寸表 SPECIFICATION CHARTS
FX-LDS ▶ P.327

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

FX-LDS 中心定位 CENTERING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel SS400 ～500N/mm²		碳素钢 Carbon Steel S50C 500～710N/mm²		合金钢 Alloy Steel SCM 710～900N/mm²		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61·～900N/mm² 28HRC		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD11·～1060N/mm² 34HRC		铸铁·球墨铸铁 Cast Iron·Ductile Cast Iron FCD250·FC400 ～500N/mm²		铸造铝合金 Aluminum Alloy Casting ADC·AC4D	
切削速度 Cutting Speed	63～80m/min		40～63m/min		32～50m/min		20～28m/min		16～22m/min		63～100m/min		80～160m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.5	20,000	0.005～0.02	25,000	0.005～0.02	20,000	0.005～0.02	15,000	0.005～0.02	9,000	0.005～0.02	注6) Note	0.005～0.015	注6) Note	0.02～0.05
1	10,000	0.01～0.03	16,000	0.01～0.03	10,000	0.01～0.03	7,500	0.01～0.03	4,500	0.01～0.03	20,000	0.01～0.03	注6) Note	0.04～0.1
2	5,000	0.03～0.06	8,000	0.03～0.06	5,000	0.03～0.06	3,800	0.03～0.06	2,200	0.03～0.06	12,000	0.03～0.06	15,000	0.06～0.2
3	7,500	0.04～0.08	5,500	0.04～0.08	4,500	0.04～0.08	2,500	0.04～0.08	1,500	0.04～0.08	8,000	0.05～0.09	12,000	0.1～0.22
4	5,700	0.05～0.1	4,100	0.05～0.1	3,300	0.05～0.1	1,900	0.05～0.1	1,100	0.05～0.1	6,500	0.07～0.12	9,500	0.12～0.25
6	3,800	0.06～0.12	2,700	0.06～0.12	2,300	0.06～0.12	1,300	0.06～0.12	750	0.06～0.12	4,300	0.12～0.18	6,400	0.14～0.28
8	2,800	0.08～0.15	2,000	0.08～0.15	1,700	0.08～0.15	1,000	0.08～0.15	550	0.08～0.15	3,200	0.13～0.2	4,800	0.18～0.32
10	2,300	0.1～0.18	1,700	0.1～0.18	1,400	0.1～0.18	750	0.1～0.18	450	0.1～0.18	2,600	0.17～0.25	3,800	0.22～0.36
12	1,900	0.12～0.21	1,400	0.12～0.21	1,200	0.12～0.21	650	0.12～0.21	370	0.12～0.21	2,200	0.21～0.3	3,200	0.25～0.4
16	1,400	0.16～0.28	1,000	0.16～0.28	900	0.16～0.28	480	0.16～0.28	280	0.16～0.28	1,600	0.24～0.32	2,400	0.32～0.48
20	1,150	0.2～0.34	820	0.2～0.34	700	0.2～0.34	380	0.2～0.34	220	0.2～0.34	1,300	0.26～0.4	1,900	0.4～0.6
25	900	0.25～0.45	650	0.25～0.45	560	0.25～0.45	300	0.25～0.45	180	0.25～0.45	1,000	0.3～0.5	1,500	0.5～0.75

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 使用长柄型FX-LS-LDS时，请降低进给量。
5. 不推荐在奥氏体不锈钢上进行中心定位。请使用TIN-NC-LDS或NC-LDS。
6. 如果不能达到表中所示转速，请尽量设置高转速。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When centering on a curved or inclined surface, reduce the feed rate accordingly.
4. "When using FX-LS-LDS, reduce the feed rate accordingly."
5. Centering on Austenitic Stainless Steels is not recommended. For these procedures, use the TIN-NC-LDS or the NC-LDS.
6. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible.

形状尺寸表 SPECIFICATION CHARTS
FX-LDS ▶ P.327

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

FX-LDS 倒角(钢用) COUNTERSINKING FOR STEELS

直径 Drill Dia. (mm)	0.5	1	2	3	4	6	8	10	12	16	20	25
切削速度 Cutting Speed (m/min)	切削速度请以中心定位中推荐速度的2倍左右为上限。 Cutting speed can be up to 2 times the limit shown above for centering.											
进给量 Feed Rate (mm/rev)	0.005～0.05	0.01～0.1	0.02～0.18	0.04～0.24	0.04～0.24	0.06～0.36	0.08～0.38	0.1～0.4	0.12～0.42	0.16～0.48	0.2～0.55	0.25～0.63

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 加工淬火钢倒角时，请设定切削速度20～40/min，使用低进给量。
5. 加工不锈钢倒角时，请设定切削速度63～100/min。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
4. When counter sinking on hardened steels, use a drilling speed of 20-40m/min and lower the feed rate accordingly.
5. When counter sinking on Stainless Steels, use a drilling speed of 63-100m/min.

形状尺寸表 SPECIFICATION CHARTS
LS-NC-LDS ▶ P.331

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

LS-NC-LDS 中心定位 CENTERING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/㎟		碳素钢 Carbon Steel S45C		合金钢 Alloy Steel SCM440		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61 35HRC		特殊钢 Special Alloy Steel SKD11		铸铁·球墨铸铁 Cast Iron · Ductile Cast Iron FCD250 · FC400 ～500N/㎟		不锈钢 Stainless Steel SUS304		铸造铝合金 Aluminium Alloy Casting ADC · AC4D	
切削速度 Cutting Speed	32～40m/min		22～30m/min		20～25m/min		10～13m/min		8～12m/min		25～32m/min		8～12m/min		51～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3	3,850	0.04～0.08	2,800	0.04～0.08	2,400	0.04～0.08	1,220	0.04～0.08	1,060	0.04～0.08	3,100	0.04～0.09	1,060	0.04～0.08	8,000	0.1～0.22
4	2,900	0.05～0.1	2,100	0.05～0.1	1,800	0.05～0.1	910	0.05～0.1	800	0.05～0.1	2,400	0.05～1.12	800	0.05～0.1	6,000	0.12～0.25
6	1,900	0.06～0.12	1,320	0.06～0.12	1,180	0.06～0.12	610	0.06～0.12	530	0.06～0.12	1,600	0.06～0.18	530	0.06～0.12	4,000	0.14～0.28
8	1,400	0.08～0.15	1,000	0.08～0.15	900	0.08～0.15	450	0.08～0.15	400	0.08～0.15	1,200	0.08～0.2	400	0.08～0.15	3,000	0.18～0.32
10	1,120	0.1～0.18	800	0.1～0.18	710	0.1～0.18	360	0.1～0.18	320	0.1～0.18	950	0.1～0.25	320	0.1～0.18	2,400	0.22～0.36
12	950	0.12～0.21	670	0.12～0.21	600	0.12～0.21	300	0.12～0.21	270	0.12～0.21	800	0.12～0.3	270	0.12～0.21	2,000	0.25～0.4
16	720	0.16～0.28	520	0.16～0.28	450	0.16～0.28	220	0.16～0.28	200	0.16～0.28	600	0.16～0.32	200	0.16～0.28	1,500	0.32～0.48
20	560	0.2～0.34	400	0.2～0.34	360	0.2～0.34	180	0.2～0.34	160	0.2～0.34	480	0.2～0.4	160	0.2～0.34	1,200	0.4～0.6
25	450	0.25～0.45	320	0.25～0.45	290	0.25～0.45	150	0.25～0.45	130	0.25～0.45	380	0.25～0.5	130	0.25～0.45	960	0.5～0.75

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 使用长柄型LS-NC-LDS时，请降低进给量。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When centering on a curved or inclined surface, reduce the feed rate accordingly.
4. When using the long shank version, reduce the feed rate accordingly.

LS-NC-LDS 倒角 COUNTERSINKING

直径 Drill Dia. (mm)	3	4	6	8	10	12	16	20	25
切削速度 Cutting Speed (m/min)	切削速度请以中心定位中推荐速度的2倍左右为上限。 Drilling speed can be up to 2 times the limit shown above for centering.								
进给量 Feed (mm/rev)	0.04～0.08	0.05～0.1	0.06～0.12	0.08～0.15	0.1～0.18	0.12～0.21	0.16～0.28	0.2～0.34	0.25～0.45

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 加工淬火钢倒角时，请使用硬质合金中心钻。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
4. When counter sinking on hardened steels, use the Carbide starter drill.

中心钻切削条件基准表 CUTTING CONDITIONS FOR STARTING DRILLS

TIN-NC-LDS 中心定位 CENTERING

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 ～500N/㎟		碳素钢 Carbon Steel S45C		合金钢 Alloy Steel SCM440		特殊钢·调质钢 Special Alloy Steel Hardened Steel SKD61 35HRC		特殊钢 Special Alloy Steel SKD11		铸铁·球墨铸铁 Cast Iron·Ductile Cast Iron FCD250·FC400 ～500N/㎟		不锈钢 Stainless Steel SUS304		铸造铝合金 Aluminium Alloy Casting ADC·AC4D	
切削速度 Cutting Speed	32～40m/min		22～30m/min		20～25m/min		10～13m/min		8～12m/min		25～32m/min		8～12m/min		51～100m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3	3,850	0.04～0.08	2,800	0.04～0.08	2,400	0.04～0.08	1,220	0.04～0.08	1,060	0.04～0.08	3,100	0.04～0.09	1,060	0.04～0.08	8,000	0.1～0.22
4	2,900	0.05～0.1	2,100	0.05～0.1	1,800	0.05～0.1	910	0.05～0.1	800	0.05～0.1	2,400	0.05～1.12	800	0.05～0.1	6,000	0.12～0.25
6	1,900	0.06～0.12	1,320	0.06～0.12	1,180	0.06～0.12	610	0.06～0.12	530	0.06～0.12	1,600	0.06～0.18	530	0.06～0.12	4,000	0.14～0.28
8	1,400	0.08～0.15	1,000	0.08～0.15	900	0.08～0.15	450	0.08～0.15	400	0.08～0.15	1,200	0.08～0.2	400	0.08～0.15	3,000	0.18～0.32
10	1,120	0.1～0.18	800	0.1～0.18	710	0.1～0.18	360	0.1～0.18	320	0.1～0.18	950	0.1～0.25	320	0.1～0.18	2,400	0.22～0.36
12	950	0.12～0.21	670	0.12～0.21	600	0.12～0.21	300	0.12～0.21	270	0.12～0.21	800	0.12～0.3	270	0.12～0.21	2,000	0.25～0.4
16	720	0.16～0.28	520	0.16～0.28	450	0.16～0.28	220	0.16～0.28	200	0.16～0.28	600	0.16～0.32	200	0.16～0.28	1,500	0.32～0.48
20	560	0.2～0.34	400	0.2～0.34	360	0.2～0.34	180	0.2～0.34	160	0.2～0.34	480	0.2～0.4	160	0.2～0.34	1,200	0.4～0.6
25	450	0.25～0.45	320	0.25～0.45	290	0.25～0.45	150	0.25～0.45	130	0.25～0.45	380	0.25～0.5	130	0.25～0.45	960	0.5～0.75

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 使用TIN-NC-LDS时，即使将切削速度提升20%左右，也能充分发挥性能。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When centering on a curved or inclined surface, reduce the feed rate accordingly.
4. When using TIN-NC-LDS, the drilling speed can be increased 1.2 times the speed listed above.

TIN-NC-LDS 倒角 COUNTERSINKING

直径 Drill Dia. (mm)	3	4	6	8	10	12	16	20	25
切削速度 Cutting Speed (m/min)	切削速度请以中心定位中推荐速度的2倍左右为上限。 Drilling speed can be up to 2 times the limit shown above for centering.								
进给量 Feed (mm/rev)	0.04～0.1	0.05～0.12	0.06～0.18	0.08～0.24	0.1～0.3	0.12～0.36	0.16～0.48	0.2～0.55	0.25～0.6

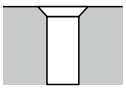
1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请将切削速度降低20%。
3. 当以曲面或倾斜面为中心定位时，请降低进给量。
4. 加工淬火钢倒角时，请使用硬质合金中心钻。

1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. When using non-water-soluble coolant, reduce the drilling speed by 20%.
3. When counter sinking on a curved or inclined surface, reduce the feed rate accordingly.
4. When counter sinking on hardened steels, use the Carbide starter drill.

形状尺寸表 SPECIFICATION CHARTS
V-UCS ▶ P.335

倒角刀切削条件基准表 CUTTING CONDITIONS

V-UCS(60°•90°•120°) 高速钢倒角刀 HSS COUNTERSINC

加工材料 Work Material	铸铁 Cast Iron FC250 FCD400 (~750N/mm²)		一般构造用钢·碳素钢 Mild Steel·Carbon Steel SS400、S45C (~750N/mm²)		合金钢 Alloy Steel SCM435 (~30HRC)		预硬钢 Prehardened Steel NAK55 (30～38HRC)		铝合金 Aluminum Alloy AC4D		不锈钢 Stainless Steel SUS304	
切削速度 Cutting Speed	10～30m/min		20～40m/min		10～14m/min		8～14m/min		30～60m/min		8～12m/min	
直径 Mill Dia. (mm)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed Rate (mm/rev)
4.3	1,480	0.11	2,220	0.11	890	0.08	890	0.08	3,705	0.11	740	0.07
5.3	1,200	0.14	1,800	0.14	720	0.1	720	0.1	3,005	0.14	600	0.09
6.3	1,010	0.17	1,515	0.17	605	0.12	605	0.12	2,525	0.17	505	0.11
7.3	870	0.2	1,310	0.2	525	0.13	525	0.13	2,180	0.2	435	0.12
8.3	765	0.22	1,150	0.22	460	0.14	460	0.14	1,920	0.22	385	0.14
9.4	675	0.25	1,015	0.25	405	0.16	405	0.16	1,695	0.25	340	0.16
10.4	610	0.27	920	0.28	365	0.19	365	0.19	1,530	0.28	305	0.18
12.4	515	0.32	770	0.32	310	0.22	310	0.22	1,285	0.32	255	0.22
14.4	440	0.34	665	0.35	265	0.23	265	0.23	1,105	0.35	220	0.23
15	425	0.35	635	0.37	255	0.24	255	0.24	1,060	0.36	210	0.24
16	385	0.38	580	0.4	230	0.25	230	0.25	965	0.4	195	0.25
20.5	310	0.45	465	0.45	185	0.28	185	0.28	775	0.45	155	0.28
25	255	0.5	380	0.5	150	0.32	150	0.32	635	0.5	125	0.32
切削深度 Depth Of Cut												

1. 此切削条件基准表适用于水溶性切削油剂。
2. 使用油性切削油剂时，请把切削速度降低20%。

1. The "Recommended Milling Conditions" above are applicable when using a water-soluble cutting fluid.
2. When using a non-water-soluble cutting fluid, the cutting speed must be reduced 20%.

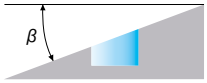
形状尺寸表 SPECIFICATION CHARTS
ADF-2D ▶ P.344

平头钻/沉孔切削条件基准表 CUTTING CONDITIONS FOR FLAT DRILLS / COUNTERBORING

ADF-2D

加工材料 Work Material	低碳素钢·软钢·合金钢 Low Carbon Steel·Mild Steel·Alloy Steel (C<0.3%) SS400·SCM ～710N/mm²		碳素钢 Carbon Steel S35C·S50C ～210HB ～710N/mm²		合金钢 Alloy Steel SCM·SCr·SNCM 28～35HRC 900～1,100N/mm²		塑料模具用钢 Plastic Mold Steel NAK80 ～40HRC		不锈钢 Stainless Steel SUS304 480～800N/mm²		特殊钢·调质钢·预硬钢 Special Alloy Steel·Hardened Steel·Prehardened Steel ～45HRC		铸铁 Cast Iron FC250 ～350N/mm²		球墨铸铁 Ductile Cast Iron FCD600 400～600N/mm²		变形铝 Aluminum A5052·A7075		铸造铝合金 Aluminum Alloy AC4C·ADC	
切削速度 Cutting Speed	30～100m/min		30～100m/min		30～90m/min		20～40m/min		10～30m/min		20～30m/min		30～120m/min		30～80m/min		30～200m/min		30～200m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
0.2	40,000	0.001～0.006	40,000	0.001～0.006	40,000	0.001～0.006	40,000	0.001～0.004	40,000	0.001～0.004	40,000	0.001～0.004	40,000	0.001～0.006	40,000	0.001～0.006	40,000	0.001～0.006	40,000	0.001～0.006
0.5	28,700	0.003～0.015	28,700	0.003～0.015	25,500	0.003～0.015	19,000	0.003～0.01	15,900	0.003～0.01	15,900	0.003～0.01	32,000	0.003～0.015	25,500	0.003～0.015	35,000	0.003～0.015	35,000	0.003～0.015
1	17,500	0.005～0.03	17,500	0.005～0.03	15,900	0.005～0.03	9,550	0.005～0.02	8,000	0.005～0.02	7,950	0.005～0.02	22,500	0.005～0.03	15,900	0.005～0.03	30,000	0.005～0.03	30,000	0.005～0.03
1.5	13,800	0.008～0.045	13,800	0.008～0.045	12,700	0.008～0.045	6,350	0.008～0.03	5,300	0.008～0.03	5,300	0.008～0.03	17,000	0.008～0.045	11,500	0.008～0.045	25,000	0.008～0.045	25,000	0.008～0.045
2	12,700	0.01～0.06	12,700	0.01～0.06	9,550	0.01～0.06	4,750	0.01～0.04	–	–	4,000	0.01～0.03	14,300	0.01～0.06	10,350	0.01～0.06	22,300	0.01～0.06	22,300	0.01～0.06
3	8,500	0.015～0.09	8,500	0.015～0.09	6,350	0.015～0.09	3,200	0.015～0.06	–	–	2,650	0.015～0.045	9,550	0.015～0.09	6,900	0.015～0.09	14,850	0.015～0.09	14,850	0.015～0.09
4	6,350	0.02～0.12	6,350	0.02～0.12	4,750	0.02～0.12	2,400	0.02～0.08	–	–	2,000	0.02～0.06	7,150	0.02～0.12	5,150	0.02～0.12	11,150	0.02～0.12	11,150	0.02～0.12
6	4,250	0.03～0.18	4,250	0.03～0.18	3,200	0.03～0.18	1,600	0.03～0.12	–	–	1,350	0.03～0.09	4,750	0.03～0.18	3,450	0.03～0.18	7,450	0.03～0.18	7,450	0.03～0.18
8	3,200	0.04～0.24	3,200	0.04～0.24	2,400	0.04～0.24	1,200	0.04～0.16	–	–	1,000	0.04～0.12	3,600	0.04～0.24	2,600	0.04～0.24	5,550	0.04～0.24	5,550	0.04～0.24
10	2,550	0.05～0.3	2,550	0.05～0.3	1,900	0.05～0.3	950	0.05～0.2	–	–	800	0.05～0.15	2,850	0.05～0.3	2,050	0.05～0.3	4,450	0.05～0.3	4,450	0.05～0.3
12	2,100	0.06～0.3	2,100	0.06～0.3	1,600	0.06～0.3	800	0.06～0.24	–	–	650	0.06～0.18	2,400	0.06～0.3	1,700	0.06～0.3	3,700	0.06～0.36	3,700	0.06～0.36
14	1,800	0.07～0.35	1,800	0.07～0.35	1,350	0.07～0.35	700	0.07～0.28	–	–	550	0.07～0.21	2,050	0.07～0.35	1,500	0.07～0.35	3,200	0.07～0.42	3,200	0.07～0.42
16	1,600	0.08～0.36	1,600	0.08～0.36	1,200	0.08～0.36	600	0.08～0.32	–	–	500	0.08～0.24	1,800	0.08～0.36	1,300	0.08～0.36	2,800	0.08～0.48	2,800	0.08～0.48
18	1,400	0.09～0.38	1,400	0.09～0.38	1,050	0.09～0.38	550	0.09～0.36	–	–	450	0.09～0.27	1,600	0.09～0.38	1,150	0.09～0.38	2,500	0.09～0.54	2,500	0.09～0.54
20	1,250	0.1～0.4	1,250	0.1～0.4	950	0.1～0.4	500	0.1～0.4	–	–	400	0.1～0.3	1,450	0.1～0.4	1,050	0.1～0.4	2,250	0.1～0.6	2,250	0.1～0.6

1. 上表参数是以工件表面平整，有用铣刀进行面铣的前置工序，以及使用水溶性切削油剂为前提。
2. 当使用油性切削油剂或稀释20倍以上的水溶性切削油剂时，请将切削速度下调30%。
3. 请使用高精度高刚性的机械以及夹具。
4. 在使用期间，请将刀具悬伸量保持在最小限度。
5. 请根据工件的形状以及固定方式来调整切削条件。
6. 安装钻头时，将刀尖振动控制在0.01mm 以下。
7. 在进行斜面加工时，请根据加工面倾斜度(β)调节转速和进给量
   - 当加工面倾斜角度(β)小于30°时，请将上表的进给量下调40～60%
   - 当加工面倾斜角度(β)大于30时，请将上表的转速下调60～80%，进给量下调20～40%。
8. 有底孔时，由于切屑不分断，请进行阶梯式加工。
9. 如果必须确保孔定位的精度，请结合加工精度调节上述转速和进给量。
10. φ5以下的尺寸请使用主轴回转精度良好的机械。
11. 机械转速不满足上述切削速度时，请尽可能使用高转速。此外，这种情况下可能会降低刀具寿命。



1. Water-soluble coolant may be applied as noted in the above table only under the premise that the work surface has been flattened by milling.
2. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce cutting speed by 30%.
3. Use a rigid and precise machine and holder.
4. Please minimize tool hang over as much as possible during machining.
5. Adjust the rotational speed and the feed rate in accordance with conditions such as the machining shape, machine rigidity, or work holding.
6. Please set up the drill so that the runout of the cutting edge is under 0.01 mm.
7. When machining an inclined plane, adjust the rotational speed and the feed in accordance with the angle of the incline (β).
   - When the machining incline angle (β) is less than 30°, please reduce the feed to 40~60%.
   - When the machining incline angle (β) is over 30°, please reduce the speed to 60~80%, the feed to 40~60%.
8. Please use step drilling in pre-drilled holes to improve cutting chip separation.
9. If it is necessary to ensure the locating precision of the hole to be machined, adjust the rotational speed and the feed as indicated above (in accordance with the machining precision requirement).
10. For sizes under φ5, please use a machine with good spindle rotation accuracy.
11. If the machine in use cannot meet the specified values above, please set the rotation speed as high as possible. In this case, please note that durability may decrease.

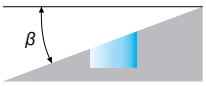
形状尺寸表 SPECIFICATION CHARTS
ADFLS-2D ▶ P.356

平头钻/沉孔切削条件基准表 CUTTING CONDITIONS FOR FLAT DRILLS / COUNTERBORING

ADFLS-2D

加工材料 Work Material	低碳素钢·软钢·合金钢 Low Carbon Steel·Mild Steel·Alloy Steel (C<0.3%) SS400·SCM ～710N/㎟		碳素钢 Carbon Steel S35C·S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM·SCr·SNCM 28～35HRC 900～1,100N/㎟		塑料模具用钢 Plastic Mold Steel NAK80 ～40HRC		特殊钢·调质钢·预硬钢 Special Alloy Steel·Hardened Steel·Prehardened Steel ～45HRC		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD600 400～600N/㎟		变形铝 Aluminum A5052·A7075		铸造铝合金 Aluminum Alloy AC4C·ADC	
切削速度 Cutting Speed	60～100m/min		60～100m/min		30～90m/min		20～40m/min		20～30m/min		60～120m/min		50～80m/min		80～200m/min		80～200m/min	
直径 Drill Dia. (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/rev)
3	8,500	0.045～0.075	8,500	0.045～0.075	6,350	0.045～0.075	3,200	0.045～0.06	2,650	0.03～0.06	9,550	0.06～0.09	6,900	0.06～0.09	14,850	0.015～0.09	14,850	0.015～0.09
4	6,350	0.06～0.1	6,350	0.06～0.1	4,750	0.06～0.1	2,400	0.06～0.08	2,000	0.04～0.08	7,150	0.08～0.12	5,150	0.08～0.12	11,150	0.02～0.12	11,150	0.02～0.12
6	4,250	0.09～0.15	4,250	0.09～0.15	3,200	0.09～0.15	1,600	0.09～0.12	1,350	0.06～0.12	4,750	0.12～0.18	3,450	0.12～0.18	7,450	0.03～0.18	7,450	0.03～0.18
8	3,200	0.12～0.2	3,200	0.12～0.2	2,400	0.12～0.2	1,200	0.12～0.16	1,000	0.08～0.16	3,600	0.16～0.24	2,600	0.16～0.24	5,550	0.04～0.24	5,550	0.04～0.24
10	2,550	0.15～0.25	2,550	0.15～0.25	1,900	0.15～0.25	950	0.15～0.2	800	0.1～0.2	2,850	0.2～0.3	2,050	0.2～0.3	4,450	0.05～0.3	4,450	0.05～0.3
12	2,100	0.18～0.3	2,100	0.18～0.3	1,600	0.18～0.3	800	0.18～0.24	650	0.12～0.24	2,400	0.24～0.36	1,700	0.24～0.36	3,700	0.06～0.36	3,700	0.06～0.36
14	1,800	0.21～0.35	1,800	0.21～0.35	900	0.21～0.35	700	0.21～0.28	550	0.14～0.28	2,050	0.28～0.42	1,500	0.28～0.42	3,200	0.07～0.42	3,200	0.07～0.42
16	1,600	0.24～0.4	1,600	0.24～0.4	800	0.24～0.4	600	0.24～0.32	500	0.16～0.32	1,800	0.32～0.48	1,300	0.32～0.48	2,800	0.08～0.48	2,800	0.08～0.48
18	1,400	0.27～0.45	1,400	0.27～0.45	700	0.27～0.45	550	0.27～0.36	450	0.18～0.36	1,600	0.36～0.54	1,150	0.36～0.54	2,500	0.09～0.54	2,500	0.09～0.54
20	1,250	0.3～0.5	1,250	0.3～0.5	650	0.3～0.5	500	0.3～0.4	400	0.2～0.4	1,450	0.4～0.6	1,050	0.4～0.6	2,250	0.1～0.6	2,250	0.1～0.6

1. 平面加工时，需要比直径大点的中心定位孔。
2. 上表参数是以工件表面平整，有用铣刀进行面铣的前置工序，以及使用水溶性切削油剂为前提。
3. 当使用油性切削油剂或稀释20倍以上的水溶性切削油剂时，请将切削速度下调30%。
4. 请使用高精度高钢性的机械以及夹具。
5. 在使用期间，请将刀具悬伸量保持在最小限度。
6. 请根据工件的形状以及固定方式来调整切削条件。
7. 安装钻头时，将刃尖振动控制在0.01mm 以下。
8. 在进行斜面加工时，请根据加工面倾斜度 (β) 调节转速和进给量。
   - 当加工面倾斜角度 (β) 小于30时，请将上表的进给量下调40～60%。
   - 当加工面倾斜角度 (β) 大于30°时，请将上表的转速下调60～80%，进给量下调20～40%。
9. 有底孔时，由于切屑不分断，请进行阶梯式加工。
10. 如果必须确保孔定位的精度，请结合加工精度调节上述转速和进给量。



1. To process flat surfaces, prior center-drilling with a larger diameter is required.
2. Water-soluble coolant may be applied as noted in the above table only under the premise that the work surface has been flattened by milling.
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce cutting speed by 30%.
4. Use a rigid and precise machine and holder.
5. Please minimize tool hang over as much as possible during machining.
6. Adjust the rotational speed and the feed rate in accordance with conditions such as the machining shape, machine rigidity, or work holding.
7. Please set up the drill so that the runout of the cutting edge is under 0.01 mm.
8. When machining an inclined plane, adjust the rotational speed and the feed in accordance with the angle of the incline (β).
   - When the machining incline angle (β) is less than 30°, please reduce the feed to 40~60%.
   - When the machining incline angle (β) is over 30°, please reduce the speed to 60~80%, the feed to 40~60%.
9. Please use step drilling in pre-drilled holes to improve cutting chip separation.
10. If it is necessary to ensure the locating precision of the hole to be machined, adjust the rotational speed and the feed as indicated above (in accordance with the machining precision requirement).

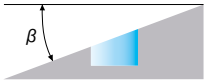
形状尺寸表 SPECIFICATION CHARTS
ADFO-3D ▶ P.359

平头钻/沉孔切削条件基准表 CUTTING CONDITIONS FOR FLAT DRILLS / COUNTERBORING

ADFO-3D

加工材料 Work Material	低碳素钢·软钢·合金钢 Low Carbon Steel· Mild Steel· Alloy Steel (C<0.3%) SS400· SCM ～710N/㎟		碳素钢 Carbon Steel S35C· S50C ～210HB ～710N/㎟		合金钢 Alloy Steel SCM· SCr· SNCM 28～35HRC 900～1,100N/㎟		塑料模具用钢 Plastic Mold Steel NAK80 ～40HRC		不锈钢 Stainless Steel SUS304 480～800N/㎟		特殊钢·调质钢·预硬钢 Special Alloy Steel· Hardened Steel· Prehardened Steel ～45HRC		铸铁 Cast Iron FC250 ～350N/㎟		球墨铸铁 Ductile Cast Iron FCD600 400～600N/㎟		变形铝 Aluminum A5052· A7075		铸造铝合金 Aluminum Alloy AC4C· ADC	
切削速度 Cutting Speed	80～120m/min		80～120m/min		50～90m/min		20～40m/min		40～60m/min		20～30m/min		80～120m/min		60～100m/min		120～200m/min		120～200m/min	
直径 Drill Dia. (mm)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min⁻¹)	进给量 Feed Rate (mm/rev)
3	10,600	0.045～0.09	10,600	0.045～0.09	7,450	0.045～0.09	3,200	0.045～0.06	5,300	0.045～0.09	2,650	0.045～0.06	10,600	0.045～0.09	8,500	0.045～0.09	17,000	0.045～0.09	17,000	0.045～0.09
4	8,000	0.045～0.12	8,000	0.045～0.12	5,550	0.045～0.12	2,400	0.045～0.08	4,000	0.045～0.12	2,000	0.045～0.08	8,000	0.045～0.12	6,350	0.045～0.12	12,750	0.045～0.12	12,750	0.045～0.12
6	5,300	0.06～0.18	5,300	0.06～0.18	3,700	0.06～0.18	1,600	0.06～0.12	2,650	0.06～0.18	1,350	0.06～0.12	5,300	0.06～0.18	4,250	0.06～0.18	8,500	0.06～0.18	8,500	0.06～0.18
8	4,000	0.08～0.24	4,000	0.08～0.24	2,800	0.08～0.24	1,200	0.08～0.16	2,000	0.08～0.24	1,000	0.08～0.16	4,000	0.08～0.24	3,200	0.08～0.24	6,350	0.08～0.24	6,350	0.08～0.24
10	3,200	0.1～0.3	3,200	0.1～0.3	2,250	0.1～0.3	950	0.1～0.2	1,600	0.1～0.3	800	0.1～0.2	3,200	0.1～0.3	2,550	0.1～0.3	5,100	0.1～0.3	5,100	0.1～0.3
12	2,650	0.12～0.36	2,650	0.12～0.36	1,850	0.12～0.36	800	0.12～0.24	1,350	0.12～0.36	650	0.12～0.24	2,650	0.12～0.36	2,100	0.12～0.36	4,250	0.12～0.36	4,250	0.12～0.36
14	2,250	0.14～0.42	2,250	0.14～0.42	1,600	0.14～0.42	700	0.14～0.28	1,150	0.14～0.42	550	0.14～0.28	2,250	0.14～0.42	1,800	0.14～0.42	3,650	0.14～0.42	3,650	0.14～0.42
16	2,000	0.16～0.48	2,000	0.16～0.48	1,400	0.16～0.48	600	0.16～0.32	1,000	0.16～0.48	500	0.16～0.32	2,000	0.16～0.48	1,600	0.16～0.48	3,200	0.16～0.48	3,200	0.16～0.48
18	1,750	0.18～0.54	1,750	0.18～0.54	1,250	0.18～0.54	550	0.18～0.36	900	0.18～0.54	450	0.18～0.36	1,750	0.18～0.54	1,400	0.18～0.54	2,850	0.18～0.54	2,850	0.18～0.54
20	1,600	0.2～0.6	1,600	0.2～0.6	1,100	0.2～0.6	500	0.2～0.4	800	0.2～0.6	400	0.2～0.4	1,600	0.2～0.6	1,250	0.2～0.6	2,550	0.2～0.6	2,550	0.2～0.6

1. 上表参数是以工件表面平整，有用铣刀进行面铣的前置工序，以及使用水溶性切削油剂为前提。
2. 请使用高精度高刚性的机械以及夹具。
3. 在使用期间，请将刀具悬伸量保持在最小限度。
4. 请根据工件的形状以及固定方式来调整切削条件。
5. 安装钻头时，将刀尖振动控制在0.02mm 以下。
6. 请使用适合加工材料，发烟量较少的切削油剂。
7. 在进行斜面加工时，请根据加工面倾斜度 (β) 调节转速和进给量。
   - 当加工面倾斜角度 (β) 小于30°时，请将上表的进给量下调40～60%
   - 当加工面倾斜角度 (β) 大于30°时，请将上表的转速下调60～80%，进给量下调20～40%。



8. 有底孔时，由于切屑不分断，请进行阶梯式加工。
9. 如果必须确保孔定位的精度，请结合加工精度调节上述转速和进给量。
10. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。另外，请注意切屑的处理与管理，以免造成火灾。

1. Water-soluble coolant may be applied as noted in the above table only under the premise that the work surface has been flattened by milling.
2. Use a rigid and precise machine and holder.
3. Please minimize overhang length as much as possible during machining.
4. Adjust the rotational speed and the feed in accordance with conditions such as the machining shape, machine rigidity, or work holding.
5. Please set up the drill so that the runout of the cutting edge is under 0.02 mm.
6. Please select a cutting fluid that is most suitable for the work material with minimal smoke formation.
7. When machining an inclined plane, adjust the rotational speed and the feed in accordance with the angle of the incline (β).
   - When the machining incline angle (β) is less than 30°, please reduce the feed to 40-60%.
   - When the machining incline angle (β) is over 30°, please reduce the speed to 60-80% , the feed to 40-60%.
8. Please use step drilling in pre-drilled holes to improve cutting chip separation.
9. If it is necessary to ensure the locating precision of the hole to be machined, adjust the rotational speed and the feed as indicated above (in accordance with the machining precision requirement).
10. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.

形状尺寸表 SPECIFICATION CHARTS
FX-ZDS ▶ P.365

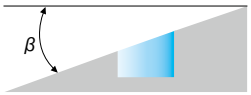
平头钻/沉孔切削条件基准表 CUTTING CONDITIONS FOR FLAT DRILLS / COUNTERBORING

FX-ZDS

加工材料 Work Material	一般构造用钢·碳素钢·铸铁 Mild Steel · Carbon Steel · Cast Iron SS400 · S55C · FC250 ～750N/mm²			合金钢·工具钢 Alloy Steel · Tool Steel SCM · SKT · SKS · SKD ～30HRC			调质钢·预硬钢(快削) Hardened Steel · Prehardened Steel(Free-Cutting) SKT · SKD · NAK55 · HPM1 30 ～40HRC			调质钢·不锈钢 Hardened Steel · Stainless Steel SKD · SUS304 40 ～45HRC		
切削速度 Cutting Speed	60～80m/min			40～63m/min			30～50m/min			20～40m/min		
直径 Mill Dia. (mm)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)
0.5	20,000	150	0.004～0.01	20,000	150	0.004～0.01	–	–	–	–	–	–
1	19,000	290	0.012～0.018	19,000	285	0.012～0.018	15,600	230	0.012～0.018	–	–	–
2	11,000	330	0.024～0.036	9,500	285	0.024～0.036	7,900	235	0.024～0.036	–	–	–
3	7,950	360	0.035～0.055	6,550	295	0.035～0.055	5,300	240	0.035～0.055	4,250	155	0.028～0.044
4	5,950	360	0.045～0.075	4,900	295	0.045～0.075	4,000	240	0.045～0.075	3,200	155	0.036～0.06
5	4,800	360	0.055～0.095	3,900	295	0.055～0.095	3,200	240	0.055～0.095	2,550	155	0.044～0.076
6	3,950	360	0.07 ～0.11	3,250	295	0.07 ～0.11	2,600	240	0.07 ～0.11	2,100	155	0.055～0.09
8	3,000	360	0.09 ～0.14	2,450	295	0.09 ～0.14	2,000	240	0.09 ～0.14	1,600	155	0.07 ～0.11
10	2,350	360	0.12 ～0.18	1,950	295	0.12 ～0.18	1,600	240	0.12 ～0.18	1,250	155	0.09 ～0.15
12	1,950	360	0.15 ～0.21	1,600	295	0.15 ～0.21	1,300	240	0.15 ～0.21	1,050	155	0.12 ～0.18
14	1,700	360	0.17 ～0.24	1,400	295	0.17 ～0.24	1,150	240	0.17 ～0.24	910	155	0.13 ～0.2
16	1,500	360	0.2 ～0.27	1,200	295	0.2 ～0.27	990	240	0.2 ～0.27	795	155	0.15 ～0.23
18	1,300	360	0.21 ～0.3	1,100	295	0.21 ～0.3	880	240	0.21 ～0.3	700	155	0.16 ～0.25
20	1,200	360	0.24 ～0.34	985	295	0.24 ～0.34	795	240	0.24 ～0.34	635	155	0.19 ～0.28

切削深度 Depth Of Cut

・H＝1D以下 H≦1D
・无底孔 Without pre-drilled hole



1. 上表参数是以工件表面平整，有用铣刀进行面铣的前置工序为前提。
2. 上表适用于孔深为1D 以下的情况。
3. 超过2D 时，推荐采用阶梯式加工。
4. 请使用高精度高刚性的机械以及夹具。
5. 请根据工件的形状以及固定方式来调整切削条件。
6. 安装铣刀时，请将刃尖振动控制在10μm以下。
7. 请使用适合加工材料，发烟性少的切削油剂。
8. 使用φ3 以下的刀具加工“合金钢·工具钢”、“调质钢· 预硬钢”时，推荐使用水溶性切削油剂。使用水溶性切削油剂时，请使用上表转速、进给速度的60%~80%。
9. 干式加工情况下，为了不造成切屑阻塞，请使用气冷方式除去切屑。
10. 工具径未满φ1时不推荐使用于斜面。
11. 加工斜面时，请根据加工面倾斜度 (β) 来调整转速、进给速度。
    ·加工面倾斜度 (β) 在30°以下时，请使用上表进给速度的40%~60%。
    ·加工面倾斜度 (β) 超过30°时，请使用上表转速的60%~80%，进给速度的20%~40%。
12. 有底孔时，由于切屑无法分断，请采用阶梯式加工。
13. 如果必须确保孔定位的精度，请结合加工精度调节上述转速和进给速度。
14. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。另外，请注意切屑的处理与管理，以免造成火灾。

1. This machining condition table applies to milling workpieces that have been flattened at the top through the removal of the forged surface (on a milling machine).
2. These machining conditions apply to hole depths of 1D or less. (D=outer diameter)
3. For hole depth of 2D or more, step milling is recommended.
4. Use a rigid and precise machine and holder.
5. Adjust the rotational speed and the feed rate in accordance with conditions such as the machining shape, machine rigidity, or work holding.
6. When chucking an end mill, keep the runout at the cutting edge below 10μm.
7. Please use a suitable fluid with high smoke retardant properties.
8. Water-soluble coolant is recommended when milling alloy steels, tool steels and hardened steels (free cutting steels) if the tool diameter is less than 3mm.
9. During Dry (no fluid) milling, please use air blow to remove cutting chips from the milling area and to eliminate chip packing.
10. Incline milling is not recommended if the tool diameter is less than 1 mm.
11. When machining an inclined plane,adjust the rotational speed and the feed rate in accordance with the angle of the incline (β).
    ・When the machining incline angle(β) is less than 30°, please reduce the feed to 40~60%.
    ・When the machining incline angle(β) is over 30°, please reduce the speed to 60~80% , the feed to 20~40%.
12. To avoid chip packing, step milling is recommended with pilot holes.
13. If it is necessary to ensure the locating precision of the hole to be machined, adjust the rotational speed and the feed rate as indicated above (in accordance with the machining precision requirement).
14. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.

形状尺寸表 SPECIFICATION CHARTS
VP-ZDS ▶ P.367

平头钻/沉孔切削条件基准表 CUTTING CONDITIONS FOR FLAT DRILLS / COUNTERBORING

VP-ZDS

加工材料 Work Material	一般构造用钢·碳素钢·铸铁 Mild Steel·Carbon Steel·Cast Iron SS400·S45C·FC250 ～750N/㎟			合金钢·工具钢 Alloy Steel·Tool Steel SCM·SKJ·SKS ～30HRC			调质钢·不锈钢 Hardened Steel·Stainless Steel SKD·SKT·SUS 30～40HRC			铝合金·铸造铝合金 Aluminum Alloy·Aluminum Alloy Casting A7075·＜Si 13%		
切削速度 Cutting Speed	16～30m/min			12～25m/min			10～20m/min			30～80m/min		
直径 Mill Dia. (mm)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	进给量 Feed Rate (mm/rev)
3	2,700	80	0.01 ～ 0.05	2,200	65	0.01 ～ 0.05	1,600	48	0.01 ～ 0.05	5,300	180	0.01 ～ 0.06
4	2,000	80	0.02 ～ 0.06	1,600	65	0.02 ～ 0.06	1,200	48	0.02 ～ 0.06	4,000	180	0.02 ～ 0.07
5	1,600	80	0.03 ～ 0.08	1,300	65	0.03 ～ 0.08	960	48	0.03 ～ 0.08	3,200	180	0.03 ～ 0.09
6	1,350	80	0.04 ～ 0.09	1,100	65	0.04 ～ 0.09	800	48	0.04 ～ 0.09	2,700	180	0.04 ～ 0.1
8	1,000	80	0.05 ～ 0.1	800	65	0.05 ～ 0.1	630	48	0.05 ～ 0.1	2,000	180	0.05 ～ 0.11
10	840	80	0.06 ～ 0.12	680	65	0.06 ～ 0.12	500	48	0.06 ～ 0.12	1,600	180	0.06 ～ 0.13
12	700	80	0.09 ～ 0.15	550	65	0.09 ～ 0.15	400	48	0.09 ～ 0.15	1,350	180	0.09 ～ 0.17
14	570	80	0.11 ～ 0.17	460	65	0.11 ～ 0.17	360	48	0.11 ～ 0.17	1,150	180	0.11 ～ 0.19
16	500	80	0.12 ～ 0.19	400	65	0.12 ～ 0.19	300	48	0.12 ～ 0.19	1,000	180	0.12 ～ 0.21
18	450	80	0.14 ～ 0.22	360	65	0.14 ～ 0.22	280	48	0.14 ～ 0.22	900	180	0.14 ～ 0.25
20	400	80	0.15 ～ 0.25	320	65	0.15 ～ 0.25	240	48	0.15 ～ 0.25	795	180	0.15 ～ 0.28
21	380	80	0.16 ～ 0.26	300	65	0.16 ～ 0.26	230	48	0.16 ～ 0.26	760	180	0.16 ～ 0.29
22	360	80	0.17 ～ 0.27	290	65	0.17 ～ 0.27	220	48	0.17 ～ 0.27	730	180	0.17 ～ 0.3
23	350	80	0.18 ～ 0.28	280	65	0.18 ～ 0.28	210	48	0.18 ～ 0.28	690	180	0.18 ～ 0.31
24	330	80	0.19 ～ 0.29	270	65	0.19 ～ 0.29	200	48	0.19 ～ 0.29	660	180	0.19 ～ 0.32
25	320	80	0.2 ～ 0.3	260	65	0.2 ～ 0.3	190	48	0.2 ～ 0.3	640	180	0.2 ～ 0.33
26	310	80	0.21 ～ 0.31	250	65	0.21 ～ 0.31	185	48	0.21 ～ 0.31	610	180	0.22 ～ 0.35
27	300	80	0.22 ～ 0.32	240	65	0.22 ～ 0.32	180	48	0.22 ～ 0.32	590	180	0.23 ～ 0.36
28	290	80	0.23 ～ 0.33	230	65	0.23 ～ 0.33	170	48	0.23 ～ 0.33	570	180	0.24 ～ 0.37
29	280	80	0.24 ～ 0.34	220	65	0.24 ～ 0.34	165	48	0.24 ～ 0.34	550	180	0.25 ～ 0.38
30	270	80	0.25 ～ 0.35	210	65	0.25 ～ 0.35	160	48	0.25 ～ 0.35	530	180	0.26 ～ 0.39
31	260	80	0.26 ～ 0.36	205	65	0.26 ～ 0.36	155	48	0.26 ～ 0.36	510	180	0.27 ～ 0.4
32	250	80	0.27 ～ 0.37	200	65	0.27 ～ 0.37	150	48	0.27 ～ 0.37	500	180	0.28 ～ 0.41

切削深度 Depth Of Cut

・H＝1D以下 H≦1D
・有底孔 With pre-drilled hole

1. 上表是以有底孔加工为前提的数据。推荐底孔径为使用工具外径的50%以上。
2. 上表适用于孔深为1D 以下的情况。
3. 无底孔加工时，请使用上表进给速度的40~70%。
4. 请使用高精度高刚性的机械以及夹具。
5. 请根据工件的形状以及固定方式来调整切削条件。
6. 请使用适合加工材料切削油剂，并充分供油。
7. 加工出现扩孔现象时请降低转速和进给量。
8. 需要切屑分断时，请务必采用阶梯式进给。
9. 使用卧式加工中心进行加工时，请特别注意切屑的排出情况。
10. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。另外，请注意切屑的处理与管理，以免造成火灾。
11. 推荐ADF系列或硬质合金ZDS系列进行斜面的预钻孔加工。

1. The chart above is based on the assumption that pilot holes are processed. Forthe diameter of the pilot hole, a value of over 50% of the selected tool's outer diameter is recommended.
2. These machining conditions apply to hole depths of 1D or less. (D=outer diameter)
3. For machining without pilot holes, set the feed rate to between 40 and 70% of the values indicated in the table above.
4. Use a rigid and precise machine and holder.
5. Adjust the rotational speed and the feed rate in accordance with conditions such as the machining shape, machine rigidity, or work holding.
6. Please use a suitable coolant for the work material and apply sufficiently.
7. If the problem of hole oversizing occurs, reduce the spindle RPM and feed amount lower than the amounts shown above.
8. We recommend step feeding when you require better chip breakage.
9. Pay particular attention to chip evacuation when using a horizontal machining center.
10. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
11. The ADF series or the ZDS carbide series are recommended for pre-drilling on inclined surfaces.

形状尺寸表 SPECIFICATION CHARTS PZAG SS ▶ P.370
形状尺寸表 SPECIFICATION CHARTS PZAG BORE ▶ P.364

平头钻/沉孔切削条件基准表 CUTTING CONDITIONS FOR FLAT DRILLS / COUNTERBORING

PZAG 沉孔加工 · 插铣加工通用 For both counterboring and plunge milling

	加工材料 Work Material	抗损强度·硬度 Tensile Strengh · Hardness	切削速度 Vc Cutting Speed (mm/min)	每转进给量 f Feed Rate (mm/rev)				
				φ 14～φ 17.5	φ 20～φ 23	φ 26～φ 48	φ 54～φ 72	φ 76～φ 82
P	软钢、低碳素钢 Mild Steel, Carbon Steel (SS400, S10C)	～180HB	160 (100～200)	0.14 (0.08～0.2)	0.18 (0.1～0.25)	0.2 (0.12～0.3)	0.4 (0.2～0.6)	0.4 (0.2～0.6)
	碳素钢、合金钢 Carbon Steel, Alloy Steel (S50C, SCM440)	～280HB	150 (100～200)	0.14 (0.08～0.2)	0.18 (0.1～0.25)	0.2 (0.12～0.3)	0.4 (0.2～0.6)	0.4 (0.2～0.6)
	模具钢 Die Steel (SKD11, SKD61)	～280HB	120 (80～180)	0.12 (0.08～0.15)	0.14 (0.1～0.2)	0.18 (0.12～0.25)	0.4 (0.2～0.5)	0.4 (0.2～0.5)
M	不锈钢 Stainless Steel (SUS304, SUS420)	～250HB	130 (80～180)	0.1 (0.08～0.15)	0.12 (0.1～0.2)	0.16 (0.12～0.25)	0.35 (0.2～0.5)	0.35 (0.2～0.5)
K	铸铁 Cast Iron (FC250)	～350N/mm²	200 (150～280)	0.16 (0.08～0.25)	0.2 (0.1～0.3)	0.3 (0.15～0.4)	0.6 (0.3～0.8)	0.6 (0.3～0.8)
	球墨铸铁 Ductile Cast Iron (FCD400)	～800N/mm²	160 (100～220)	0.14 (0.08～0.2)	0.18 (0.1～0.25)	0.2 (0.15～0.3)	0.4 (0.3～0.6)	0.4 (0.3～0.6)
N	铝合金 Aluminum Alloys	～13%Si	200 (100～800)	0.16 (0.08～0.25)	0.2 (0.1～0.3)	0.3 (0.15～0.4)	0.6 (0.3～0.8)	0.6 (0.3～0.8)
S	耐热合金(湿式) Superalloy(Wet) (Inconel 718)	—	50 (30～60)	0.08 (0.05～0.14)	0.08 (0.06～0.14)	0.12 (0.08～0.2)	0.25 (0.16～0.4)	0.25 (0.16～0.4)
	钛合金（湿式） Titanium Alloy(Wet) (Ti-6Al-4V)	—	60 (30～100)	0.08 (0.05～0.14)	0.1 (0.06～0.16)	0.14 (0.08～0.2)	0.3 (0.16～0.5)	0.3 (0.16～0.5)
H	预硬钢 Pre-hardened Steel (NAK80)	40～43HRC	100 (60～120)	0.08 (0.05～0.14)	0.1 (0.06～0.16)	0.14 (0.08～0.2)	0.3 (0.16～0.5)	0.3 (0.16～0.5)
	调质钢 Hardened Steel (SKD11)	50～55HRC	60 (40～80)	0.08 (0.05～0.14)	0.08 (0.05～0.14)	0.12 (0.08～0.2)	0.25 (0.16～0.4)	0.25 (0.16～0.4)

1. 此切削条件基准表的数值是根据实际切削速度的标准数据。请根据加工环境适当的调整。
2. 安装刀片时，请确保在整洁干净的状态下牢固安装。
3. 请保持加工材料在不变形、不弯曲、不振动的状态下。

1. The above cutting conditions are to be used as general guidelines. Adjustments may be necessary depending on actual cutting condition.
2. When installing an insert, please remove any scratches or dirt and attach firmly.
3. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.

■按加工材料推荐材质 Recommended Materials by Insert Type

刀片材质 Insert Grades	切削油剂 Coolant	P	M	K	N	S	H
XP8030	有 Wet	◎	◎	○	○	○	○
XC8035	无 Dry	○		◎			
	有 Wet		○				

◎ 第一推荐材质 Best　○ 第二推荐材质 Good

形状尺寸表 SPECIFICATION CHARTS
CRM ▶ P.373

硬质合金铰刀切削条件基准表 CUTTING CONDITIONS FOR CARBIDE REAMER

CRM

加工材料 Work Material	低碳素钢·软钢 Low Carbon Steel Mild Steel S15C·SS400 AISI1015		碳素钢 Carbon Steel S45C·S50C AISI1045·1050		合金钢 Alloy Steel SCM·SNC·SNCM		铸造铝合金 Aluminum Alloy Casting A7075·ADC DIN ALZnMgCul.5D		调质钢 Hardened Steel SKT·SKD ～40 HRC		调质钢 Hardened Steel SKT·SKD ～50 HRC		铸铁 Cast Iron FC250		铜·铜合金 Copper C1100 DIN ECu57	
切削速度 Cutting Speed	12～20m/min		10～16m/min		8～12m/min		15～30m/min		6～12m/min		4～10m/min		8～16m/min		10～25m/min	
刀具尺寸 Reamer Dia. (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)	进给量 Feed (mm/rev)	切削余量 Removal Amount (mm)
0.3	0.002～0.005	0.03～0.08	0.002～0.005	0.03～0.08	0.002～0.005	0.03～0.08	0.002～0.005	0.03～0.08	0.001～0.004	0.03～0.08	—	—	0.002～0.005	0.03～0.08	0.002～0.005	0.03～0.08
0.5	0.004～0.01	0.05～0.1	0.004～0.01	0.05～0.1	0.004～0.01	0.05～0.1	0.004～0.01	0.05～0.1	0.003～0.009	0.05～0.1	—	—	0.004～0.01	0.05～0.1	0.004～0.01	0.05～0.1
1	0.008～0.015	0.05～0.1	0.008～0.015	0.05～0.1	0.008～0.015	0.05～0.1	0.008～0.015	0.05～0.1	0.007～0.014	0.05～0.1	—	—	0.008～0.015	0.05～0.1	0.008～0.015	0.05～0.1
2	0.018～0.03	0.05～0.15	0.018～0.03	0.05～0.15	0.018～0.03	0.05～0.15	0.018～0.03	0.05～0.15	0.015～0.027	0.05～0.15	—	—	0.018～0.03	0.05～0.15	0.018～0.03	0.05～0.15
3	0.028～0.045	0.1～0.2	0.028～0.045	0.1～0.2	0.028～0.045	0.1～0.2	0.028～0.045	0.1～0.2	0.023～0.04	0.1～0.2	0.012～0.03	0.03～0.08	0.028～0.045	0.1～0.2	0.028～0.045	0.1～0.2
4	0.04～0.06	0.1～0.2	0.04～0.06	0.1～0.2	0.04～0.06	0.1～0.2	0.04～0.06	0.1～0.2	0.032～0.052	0.1～0.2	0.015～0.035	0.03～0.08	0.04～0.06	0.1～0.2	0.04～0.06	0.1～0.2
5	0.05～0.09	0.1～0.2	0.05～0.09	0.1～0.2	0.05～0.09	0.1～0.2	0.06～0.09	0.1～0.2	0.04～0.08	0.1～0.2	0.02～0.05	0.03～0.08	0.05～0.09	0.1～0.2	0.05～0.09	0.1～0.2
6	0.06～0.12	0.1～0.2	0.06～0.12	0.1～0.2	0.06～0.12	0.1～0.2	0.07～0.13	0.1～0.2	0.05～0.1	0.1～0.2	0.025～0.055	0.03～0.08	0.06～0.12	0.1～0.2	0.06～0.12	0.1～0.2
8	0.08～0.15	0.1～0.2	0.08～0.15	0.1～0.2	0.08～0.15	0.1～0.2	0.08～0.18	0.1～0.2	0.06～0.13	0.1～0.2	0.03～0.075	0.03～0.08	0.08～0.15	0.1～0.2	0.08～0.15	0.1～0.2
10	0.1～0.2	0.1～0.2	0.1～0.2	0.1～0.2	0.1～0.2	0.1～0.2	0.1～0.23	0.1～0.3	0.08～0.18	0.1～0.2	0.04～0.08	0.03～0.08	0.1～0.2	0.1～0.2	0.1～0.2	0.1～0.2
12	0.12～0.22	0.1～0.2	0.12～0.22	0.1～0.2	0.12～0.22	0.1～0.2	0.12～0.28	0.1～0.3	0.1～0.2	0.1～0.2	0.04～0.09	0.03～0.08	0.12～0.23	0.1～0.2	0.12～0.23	0.1～0.2
13	0.13～0.23	0.1～0.2	0.13～0.23	0.1～0.2	0.13～0.23	0.1～0.2	0.13～0.3	0.1～0.3	0.1～0.21	0.1～0.2	0.04～0.1	0.03～0.08	0.13～0.25	0.1～0.2	0.13～0.25	0.1～0.2

1. 请充分供应切削油剂。
2. 请使用高精度的夹头。
3. 请根据加工材料和机器的刚性改变加工条件。

1. Apply the appropriate amount of cutting fluid.
2. Use a rigid and precision holder.
3. The cutting conditions may need to be changed, depending on the work material and machine rigidity.

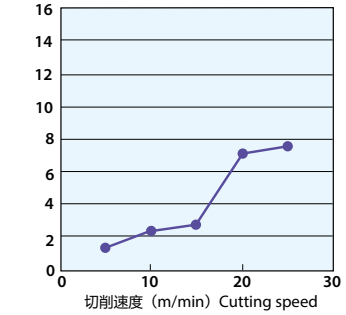
加工数据 CUTTING DATA

切削速度的变化引起的表面粗糙度和扩大量的变化 The surface roughness and amount of oversize at different cutting speeds.

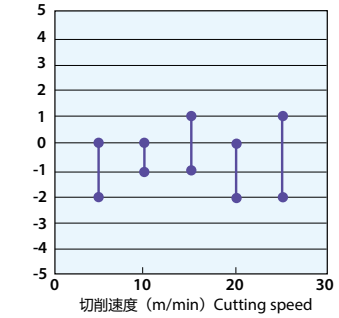
●切削条件 Cutting Conditions

加工材料 Work Material	S50C (JIS S50C,AISI 1050)
铰刀尺寸 Reamer Size	10mm
进给量 Feed	0.2mm/rev
底孔径 Drill Hole Size	9.8mm
切削油剂 Cutting Fluid	水溶性 Water-Soluble Fluid

▼切削速度和表面粗糙度



▼切削速度和扩大量

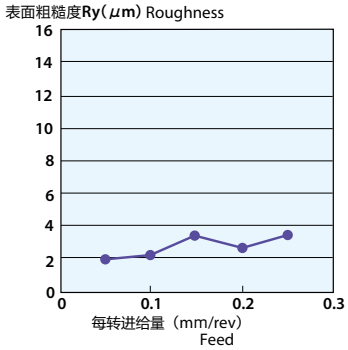


每转进给量不同时表面粗糙度和扩大量的变化 The surface roughness and amount of oversize at different feed rates per revolution.

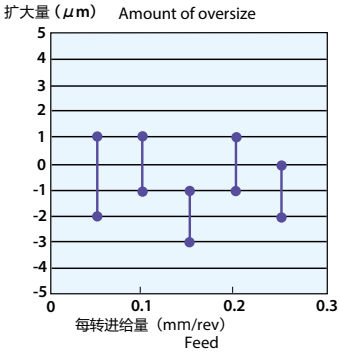
●切削条件 Cutting Conditions

加工材料 Work Material	S50C (JIS S50C,AISI 1050)
铰刀尺寸 Reamer Size	10mm
切削速度 Drilling Speed	15m/min
底孔径 Drill Hole Size	9.8mm
切削油剂 Cutting Fluid	水溶性 Water-Soluble Fluid

▼每转进给量和表面粗糙度



▼每转进给量和扩大量

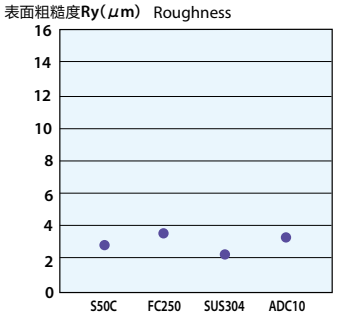


各种加工材料上的表面粗糙度和扩大量的比较 The surface roughness and amount of oversize for different work material.

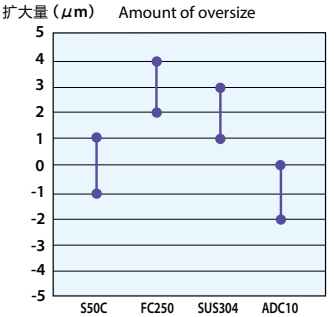
●切削条件 Cutting Conditions

铰刀尺寸 Reamer Size	10mm
切削速度 Drilling Speed	15m/min (ADC 10のみ30m/min)
进给量 Feed	0.2mm/rev
底孔径 Drill Hole Size	9.8mm
切削油剂 Cutting Fluid	水溶性 Water-Soluble Fluid

▼各种加工材料的表面粗糙度



▼各种加工材料的扩大量



真圆度和表面粗糙度的实例 Example of Circularity.

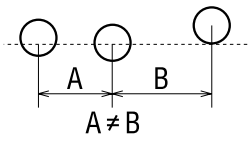
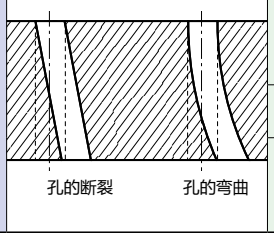
●切削条件 Cutting Conditions

加工材料 Work Material	S50C (JIS S50C,AISI 1050)
铰刀尺寸 Reamer Size	10mm
切削速度 Drilling Speed	15m/min
进给量 Feed	0.2mm
底孔径 Drill Hole Size	9.8mm

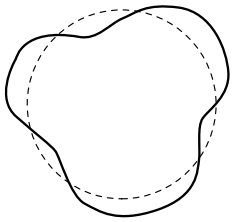
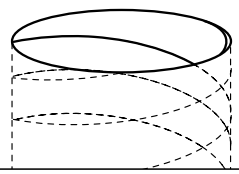
倍率：2,000倍
Magnification:X2,000

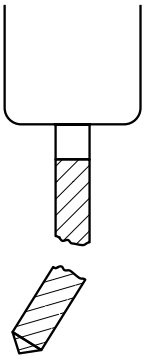
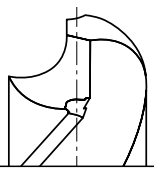
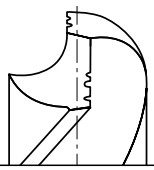
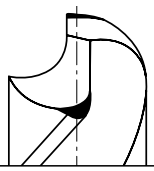
真圆度：3.64μm
Circularity

※扩大量是相对于铰刀径实测值而定的。The amount of over size was determined from the actual reamer size.

	现 象 Type of Trouble	原 因 Problem	对 策 Problem Origin / Solution(s)
孔 Hole	孔径扩大 Hole expansion	安装时的振动大 主轴跳动过大 Large run out after attachment to the machine Large spindle run out	选用质量好的刀柄夹具 校正主轴 安装时测定及调整 Check holder and/or select another one Check the spindle Check run out after fixing to the chuck
		锋角不对称 刃高差过大 横刃偏心 Non-symmetric point angle Large lip height Run out of chisel edge	适当再研磨 再研磨后精度检查 Regrind correctly Check precision after regrinding
	孔径的一致性不佳 Irregular hole size	锋角不对称 刃高差过大 横刃偏心 刃带棱面磨损过大 Non-symmetric point angle Large lip height Run out of chisel edge Major margin wear	适当再研磨 再研磨后精度检查 Regrind correctly Check precision after regrinding
		安装时的振动大 主轴跳动过大 工件装夹不牢固 Large run out after attachment to machine Loose hold Low work holding rigidity	选用质量好的刀柄夹具 校正主轴 安装时测定及调整 Check holder and/or select another one Check the spindle Check run out after fixing to the chuck
		进给速度过大 Feed rate is too high	降低进给速度 Decrease the feed rate
		切削油剂供给不足 Not enough coolant	改变切削油剂供给方法，增加流量 Change method of coolant supply, or increase volume
	孔中心位置精度不好 Poor accuracy Irregular pitch 	安装时的振动大 主轴跳动过大 Large run out after attachment to machine Large spindle run out	选用质量好的刀柄夹具 校正主轴 安装时测定及调整 Check holder and/or select another one Check the spindle Check run out after fixing to the chuck
		吃入时产生振动 Run out when cutting	提高刀具与机床的刚性 提高工件与夹具的刚性 采用吃入性好的钻型 预钻中心孔 先把吃刀面调整或加工成平面加导向套或钻磨 Increase rigidity of tools and machines Increase work clamping rigidity Select a thinning for low cutting resistance Use centering Double-check that the work piece is horizontal Use a drill bush
		顶尖与轴心不重合（车床） Poor alignment accuracy (lathing)	加工前仔细检查 Check alignment before operation
	直线度不好 垂直度不好 Bad hole perpendicularity 	刀具磨损过大 Excessive tool wear	再研磨 Regrind correctly
		中心孔精度不好 Poor position accuracy	提高中心孔的位置精度 Increase position accuracy
		锋角不对称 刃高差过大 横刃偏心 Non-symmetric point angle Large lip height Run out of chisel edge	适当再研磨 再研磨后精度检查 Regrind correctly Check precision after regrinding
		钻头刚性不足 Not enough drill rigidity	提高钻头刚性 Use a more rigid drill
		被切削面不平 顶尖与轴心不重合（机床） Drilling surface is not horizontal Poor alignment accuracy (lathing)	调为水平或预加工为水平面预钻中心孔 The work piece must be horizontal or pre-drilled Use centering

问题解答 TROUBLE SHOOTING

	现 象 Type of Trouble	原 因 Problem	对 策 Problem Origin / Solution(s)
孔 Hole	真圆度不好 Bad cylindrical accuracy 	锋角不对称 刃高差过大 横刃偏心 Non-symmetric point angle Large lip height Run out of chisel edge	适当再研磨 再研磨后精度检查 Regrind correctly Check precision after regrinding
		安装时的振动大 主轴跳动过大 工件装夹不牢固 Large run out after attachment to machine Large spindle run out Loose clamping of work material	选用质量好的刀柄夹具 校正主轴 安装时测定及调整 Check holder and/or select another one Check the spindle Check work clamping after fixing to the machine
		后角过大 Relief angle is too large	适当再研磨 Regrind correctly
		钻头刚性不足 Low drill rigidity	提高钻头刚性 Use a more rigid drill
	精加工面精度不良 Poor surface finish	再研磨不当 Poor regrinding	适当再研磨 Regrind correctly
		切削油剂供给不足或型号不适配 Not suitable coolant for the material Not enough coolant	改变切削油剂供给方法，增加流量 采用润滑性好的切削油剂 Change method of coolant supply, or increase volume Select higher quality coolant
		安装时的振动大 主轴跳动过大 Large run out after attachment to machineLarge spindle run out	选用质量好的刀柄及夹具 校正主轴 Check holder and/or select another one Check the spindle
		进给速度过大 Feed rate is too high	降低进给速度 Reduce the feed rate
		切削刃磨损过大 刃带棱面溶着严重 Excessive wear on cutting edge Build up on margin is too large	适当再研磨 使用有涂层的钻头 Regrind correctly Use a coated tool
		切屑阻塞 Chip packing	重选钻头（槽型，螺旋角等） 重选加工方法（进给速度的调整，阶梯式加工） Use the most suitable drill (consider flute form & helix angle) Change cutting conditions (feed rate, try step feed)
	圆柱度不好 Bad cylindrical shape 	锋角不对称 刃高差过大 横刃偏心 刃带棱面磨损过大 Non-symmetric point angle Large lip height Run out of chisel edge Large margin wear	适当再研磨 再研磨后精度检查 Regrind correctly Check precision after regrinding
		进给速度过低 Feed rate is too low	提高进给速度 Increase feed rate

	现 象 Type of Trouble	原 因 Problem	对 策 Problem Origin / Solution(s)
钻头 Drill	折 损 Breakage	机械、工件弯曲、变形、滑移 Deflection and recess of machine and work material	提高刀具、机械的刚性 提高工件、夹具的刚性 Increase the rigidity of machine, drill and work clamping
		后角过小 Relief angle is too small	正确再研磨 Regrind precisely
		相对切削速度，进给速度过高 Feed rate is too high	降低进给速度 Decrease the feed rate
		钻头磨损 Excessive tool wear	再研磨 Regrind
		切屑堵塞 Chip packing	重选钻头（槽型，螺旋角等） 重选加工方法（进给速度的调整，阶梯式加工） Use the most suitable drill (consider flute form & helix angle) Change cutting conditions (feed rate, try step feed)
		吃入性不好 Difficulty entering the material	提高刀具、机械的刚性 提高工件、夹具的刚性 采用吃入性好的钻型 预钻中心孔 先把吃刀面调整或加工成平面 加导向套或钻磨 Use a highly rigid tool and machine Increase work clamping rigidity Select a thinning for low cutting resistance Use centering The work piece should be horizontal Use drill bush
	圆弧角部破损 Chipping of corner edge	钻头材质不适合 Inappropriate tool material	改换钻头材质 Use the most suitable tool material
		被切削材料中有硬组织或硬块 Uneven hardness distribution on the work material	分析研究被切削材料的性质或换工件材质 改变切削参数（进给速度，切削速度 / 加工方法） Use the most suitable tool material Change cutting conditions (feed rate, drilling speed) or machining method
		切削速度、进给速度过快 Drilling speed or feed rate too high	降低切削速度，进给速度 Reduce drilling speed or feed rate
		切削油剂供给不足 Not enough coolant	改变切削油剂供给方法，增加流量 Change coolant method and increase volume
	卷刃 崩刃 Chipping of cutting edge	安装时的振动大 主轴跳动过大 Large run out after attachment to machine Large spindle run out	选用质量好的刀柄夹具 校正主轴 安装时测定及调整 Check holder and/or select another one Check the spindle Check run out after fixing to the chuck
		切削速度，进给速度过高 Drilling speed or feed rate	降低切削速度，进给速度 Reduce drilling or feed rate
		后角过大 Relief angle is too small	适当再研磨 Regrind correctly
		钻头材质不适合 Tool not suitable for work material	改换钻头材质 Use the most suitable tool material
	外周圆弧角部异常磨损 Abnormal wear on the corner part	再研磨太迟 Regrinding should have occurred earlier	及时再研磨，缩短再研磨周期 Regrind sooner
		顶尖与轴心不重合（车床） Poor alignment accuracy (lathing)	加工前仔细检查 Check /adjust alignment before drilling
		切削速度过高 Drilling speed or feed rate too high	降低切削速度 Decrease the drilling speed
		刃尖形状不合适 Point shape is inappropriate	选用适合加工对象的刃形 Select correct point dimensions
		钻头材质不适合 Tool not suitable for work material	改换钻头材质 Use the most suitable tool material
		切削油剂不正确 Inappropriate coolant type	更换切削油剂 Change coolant

问题解答 TROUBLE SHOOTING

	现 象 Type of Trouble	原 因 Problem	对 策 Problem Origin / Solution(s)
钻头 Drill	横刃部分的磨损破损 Wear, chipping and crushing of the chisel edge	进给速度过大 Feed rate is too high	降低进给速度 Decrease feed rate
		刃尖形状不合适 Point shape is inappropriate	选用适合加工对象的刃形 Select correct point dimensions
		钻头材质不合适 Tool not suitable for work material	改换钻头材质 Choose suitable tool material
		后角过小 Relief angle is too small	正确再研磨 Regrind precisely
	刃带棱面破损 Chipping of the margin	导向套或钻模尺寸过大 Bush size is too large	修改导向套或钻模的尺寸 Select correct bush size
	刃带棱面溶着 Margin build-up	切削刃磨损过大，发热过大 High heat generation due to large wear on the cutting edge	适当再研磨 Regrind correctly
		切削油剂供给不足 Coolant is not sufficient	改变切削油剂供给方式，增加流量 Change coolant method and increase volume
		切削油剂不正确 Coolant is not suitable	更换切削油剂 Change coolant
		切屑排屑性差 被切削材料过软 Bad chip discharging Ductile material	更换钻头或加工方法 Change drills or alter cutting conditions
	扁尾折断 Tang breakage	钻柄部有损伤或缺陷引起打滑 Shank slippage due to defect	消除损伤或缺陷 Eliminate the defect
		过度套有磨损或损伤 Defective inner surface of morse taper holder	更换或修复过渡套 Change holders or correct the surface of the morse taper holder
		再研磨精度差（切削阻力大） Inaccurate regrinding	适当再研磨 Regrind correctly
	发生振动音 Chattering sounds	后角过大 Relief angle is too large	适当再研磨 Regrind correctly
		钻头刚性不足 Low tool rigidity	提高钻头刚性 Use a more rigid drill
	切屑缠绕 Chips roll around the drill	切屑过长 切屑滞留 Long chips Chips are stuck in the flute	重新考虑加工方法，切削条件及钻头选型 Change drill and cutting conditions
	钻头单侧磨损 One-sided wear	顶尖与轴心不重合（车床） Poor alignment accuracy (lathing)	加工前仔细调整 Check/adjust the alignment
		钻头装夹不良 Large run out after attachment to machine	安装时抑制振动 Decrease run out when fixing to the chuck

丝锥
TAPS

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丝锥精度标识变更通知
Notice of change the tap limit

为了更容易辨识丝锥是否适用于JIS2级/ISO6H级内螺纹加工，对丝锥的包装盒标识做了变更。

＜适用于JIS2级/ISO6H级内螺纹加工的丝锥标识(STD)。

For more simple indication for class2 and 6H the case labeling is newly altered.(Valid: Items which are completed after Sep 1st 2014.)

＜The lable of tap limit for class2 and 6H is changed to "STD" from "OH"＞

变更前 Before

变更后 After

·STD标识的意义 ＜「STD」是「Standard」的缩写。＞
· About STD ＜ "STD" means "Standard". ＞

STD	适用于JIS2/6H内螺纹加工 Recommended tap for class2 and 6H
STD+1	适用于JIS2/6H加大一档中径的内螺纹加工 Recommended tap for 1 oversized class2 and 6H
STD+2	适用于JIS2/6H加大两档中径的内螺纹加工 Recommended tap for 2 oversized class2 and 6H

针对商品 - 丝锥计划品＜切削丝锥 / 挤压丝锥＞
(嵌套螺纹用丝锥，管用丝锥，螺纹铣刀，JIS精度丝锥，特殊精度丝锥等除外)
Applicable products ⇒ All standard tap ＜ Cutting tap/Forming tap ＞
(Except Insert tap, Pipe tap, Planet tap, JIS limit tap, and Special limit tap)

※丝锥刀身上的刻印依旧为OH精度/RH精度(精度等级没有变化)
＊The label of tap itself is remained as OH/RH limit.(Some OH limit may be changed.)

- 本样本登载的产品，虽标有库存，但由于新材料、新产品的开发，更改废番的情况也有。
- 式样，形状，表内数值也可能会有变动。
- The inventory status is indicated for respective products on this catalogue. However, the products may be improved or discontinued due to development of new materials and products, etc.
- Specifications, shapes, values in the tables, etc. are subject to change without prior notice.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

不同用途的丝锥 A WIDE VARIETY OF TAPS

螺纹铣刀系列 Thread Milling Cutter

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
	AT-1	EgiAs	M	One Revolution 螺纹铣刀 One Pass Thread Mill	螺距= 0.5 ~ 3 TP	503	○
		EgiAs	U	〃	牙数= 32 ~ 8 T.P.I	504	○
		EgiAs	Rc	〃	牙数= 28 ~ 11 T.P.I	505	○
		EgiAs	Rp	〃	牙数= 28 ~ 11 T.P.I	505	○
		EgiAs	NPT	〃	牙数= 27 ~ 11½ T.P.I	505	○
	AT-2	DUROREY	M	高硬度钢用带底刃螺纹铣刀 2D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2D Type	M3 ~ M20	506	○
		DUROREY	U	〃	No.8 ~ ½	506	○
		DUROREY	M	高硬度钢用带底刃螺纹铣刀 2.5D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2.5D Type	M3 ~ M20	507	○
		DUROREY	U	〃	No.8 ~ ½	507	○
		DUROREY	Rc	高硬度钢用带底刃螺纹铣刀 锥管螺纹型 Thread Mill With End-Cutting Edge For High Hardness Steels Tapered Pipe Thread Type	牙数= 28 ~ 11 T.P.I	508	○
		DUROREY	NPT	〃	牙数= 27 ~ 11½ T.P.I	508	○
	AT-2 R-SPEC	DLC-IGUSS	M	非铁用带底刃高效率螺纹铣刀 High-efficiency thread mill with end-cutting edge for non-ferrous materials	M3 ~ M12	509	○
	WH-VM-PNC	SS WXS	S	小径螺纹用螺纹铣刀 ® Small Diameter PLANET CUTTER	螺距= 0.25 ~ 0.3 TP	511	○
		SS WXS	M	〃	螺距= 0.25 ~ 0.8 TP	511	○
		SS WXS	U	〃	牙数= 32 T.P.I	511	○
	WX-ST-PNC	WX	M	钢用 NC 螺纹铣刀 ® PLANET CUTTER For Steels	螺距= 0.75 ~ 2 TP	512	○
		WX	U	〃	牙数= 28 ~ 8 T.P.I	512	○
		WX	Rc	〃	牙数= 19 T.P.I	513	○
		WX	Rp	〃	牙数= 28 ~ 11 T.P.I	513	○
		WX	NPT	〃	牙数= 11½ T.P.I	513	○
	WXO-ST-PNC	WX	M	内冷油孔钢用 NC 螺纹铣刀 ® PLANET CUTTER for Steels with Internal Coolant Supply	螺距= 0.5 ~ 3 TP	514	○
	WX-PNC	WX	M	非铁·耐热合金用螺纹铣刀 ® PLANET CUTTER for Nonferrous Metal and Heat-Resistant Alloy	螺距= 0.5 ~ 3 TP	515	○
		WX	U	〃	牙数= 28 ~ 8 T.P.I	515	○
		WX	Rc	〃	牙数= 28 ~ 11 T.P.I	516	○
		WX	Rp	〃	牙数= 28 ~ 11 T.P.I	516	○
		WX	NPT	〃	牙数= 27 ~ 11½ T.P.I	516	○
	OT-SFT-PNGT	FX	M	硬质合金通用螺旋槽螺纹铣刀 Solid Carbide Spiral PLANET CUTTER	螺距= 1.25 ~ 3 TP	517	○
	OT-PNGT	FX	M	硬质合金通用螺纹铣刀 Solid Carbide PLANET CUTTER	螺距= 1.25 ~ 3 TP	518	○
		FX	Rp	〃	牙数= 19 T.P.I	518	○
	PNGT	TiN	M	高速钢螺纹铣刀 ® HSS PLANET CUTTER	螺距= 1 ~ 3.5 TP	519	○
		TiN	Rc	〃	牙数= 19 ~ 11 T.P.I	520	○
		TiN	Rp	〃	牙数= 19 ~ 11 T.P.I	520	○
		TiN	G	〃	牙数= 19 ~ 11 T.P.I	520	○
	DR-PNAC	FX	M	复合加工用超级螺纹铣刀 Super-Planet Cutter for multifunction milling	M6 ~ M12	521	○
	DR-O-PNAC	FX	M	复合加工用 内冷油孔超级螺纹铣刀 Super-Planet Cutter for multifunction milling with Internal Coolant Supply	M6 ~ M12	522	○
	ED-PNT		M	陶瓷用电镀金刚石螺纹铣刀 Electroplated diamond taps for ceramics	螺距= 0.5 ~ 2 TP	522	

螺纹种类 Thread　**M** 公制螺纹 Metric　**U** 美制螺纹 Unified　**Rc、NPT** 锥管螺纹 Taper Pipe　**Rp、G** 平行管螺纹 Parallel Pipe

不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
	HY-PRO P	TiCN	M	HYPRO® 螺纹铣刀 单牙型 HYPRO PLANET CUTTER Single Point	螺距= 1.5～6 TP	531	○
		TiCN	U	〃	牙数= 16～4 T.P.I	531	○
	HY-PRO P	TiCN TiN	M	HYPRO® 螺纹铣刀 多牙型 HYPRO PLANET CUTTER Multi Point	螺距= 0.5～6 TP	533	○
		TiCN TiN	U	〃	牙数= 48～4 T.P.I	533	○
		TiCN TiN	G,Rc	〃	牙数= 19～11 T.P.I	533	○
		TiCN TiN	NPT,NPTF	〃	牙数= 14～8 T.P.I	533	○

※工具选定表请参照P.497～498。 ※Please see p.497～ 498 for selection chart.

挤压丝锥系列 Fluteless Taps

	A-XPF	特	M	高效率 · 多功能挤压丝锥 Highly Efficient Multi-Purpose Forming Tap	M1～M6	543	○
	S-XPF	V	M	XPF 挤压丝锥 X Performer	M1～M45	544	○
	LT-S-XPF	V	M	XPF 挤压丝锥长柄型 X Performer · Long Shank	M3～M12	546	○
	OIL-S-XPF	V	M	内冷油孔 XPF 挤压丝锥 X Performer with Internal Coolant Supply	M6～M16	547	○
	VP-NRT	V	M	VP 挤压丝锥 VP Nu-Roll	M1～M12	548	○
		V	U	〃	No.2～No.6	549	○
	VP-LT-NRT	V	M	VP 挤压丝锥 长柄型 VP Nu-Roll · Long Shank	M1～M12	550	○
		V	U	〃	No.2～No.6	551	○
	VP-SC-NRT	V	M	VP 挤压丝锥 短切削锥型 VP Nu-Roll · Short Chamfer Type	M1～M6	552	○
		V	U	〃	No.2～No.6	552	○
	VP-LT-SC-NRT	V	M	VP 挤压丝锥 短切削锥长柄型 VP Nu-Roll · Short Chamfer Type · Long Shank	M1～M6	553	○
		V	U	〃	No.2～No.6	553	○
	IT-NRT	V	M	IT 挤压丝锥 IT Nu-Roll	M1～M3	554	○
		V	U	〃	No.0～No.4	554	○
	UM-NRT	CrN	S	UM 挤压丝锥 UM Nu-Roll	S0.5～S0.9	555	
	VP-NRTS	V	M	VP 挤压丝锥 (短螺纹型) VP Nu-Roll (Short Thread)	M1～M2.6	556	○
	V-NRT	V	M	V 涂层 V coated	M14～M20	557	○
	V-LT-NRT	V	M	V 涂层长柄型 V coated · Long Shank	M3.5～M12	558	○
	V-SS-NRT	V	M	V 涂层薄板专用 V coated · for Sheet Steels	M1.4～M6	559	○
	V-EG-NRT	V	M	带小径精加工刃型 with Cutting Edges on Minor Dia. (EG-NRT)	M3～M12	560	○
	TIN-NRT	TiN	M	TiN 涂层 TiN coated	M1～M20	561	○
		TiN	U	〃	No.0～¼U	562	○
	TIN-LT-NRT	TiN	M	TiN 涂层长柄型 TiN coated · Long Shank	M3～M12	564	○
	NRT	H	M	钢用 for Steels	M1～M20	565	○
		H	U	〃	No.0～¼U	567	○
	LT-NRT	H	M	钢用长柄型 Long Shank · for Steels	M3～M12	568	○
	OT-NRT		M	硬质合金挤压丝锥 Carbide Fluteless (Nu-Roll)	M3～M12	569	○
	OT-LT-NRT		M	硬质合金挤压丝锥长柄型 Carbide Long Shank · Fluteless (Nu-Roll)	M3～M12	570	○

螺纹种类 Thread　**M** 公制螺纹 Metric　**U** 美制螺纹 Unified　**W** 惠氏螺纹 Whitworth　**Rc、NPTF** 锥管螺纹 Taper Pipe　**G** 平行管螺纹 Parallel Pipe　**S** 微型螺纹 Miniature

不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
挤压丝锥系列 Fluteless Taps							
	OT-IN-NRT		M	硬质合金镶刃挤压丝锥 Carbide Fluteless (Nu-Roll) with Brazed Inserts	M5 ~ M12	570	○
	B-NRT	N	M	非铁合金用 for Non-Ferrous Metals	M1 ~ M20	571	○
		N	U	〃	No.0 ~ ¼U	573	○
	LT-B-NRT	N	M	非铁合金用长柄型 Long Shank · for Non-Ferrous Metals	M3 ~ M12	575	○
	CU-NRT	CrN	M	铜用 for Copper	M3 ~ M12	576	
	HS-AL-NRT		M	铝用高速同步丝锥 Synchro Taps · for Aluminium	M1 ~ M6	577	
	US-AL-NRT	V	M	超高速同步丝锥 ULTRA Synchro Taps	M1 ~ M20	578	○
	V-LT-DH-NRT	V	M	V涂层深孔加工用 V coated · for Deep Hole	M2 ~ M6	579	○
	HRT	H	M	钢用 for Steels	M1 ~ M6	580	
		H	U	〃	No.5 ~ ¼U	580	
	B-HRT		M	非铁合金用 for Non-Ferrous Metals	M1 ~ M6	581	
			U	〃	No.0 ~ ¼U	582	
螺旋槽丝锥系列 Spiral Fluted Taps							
	A-SFT	V	M	一般用 General Application	M1.4 ~ M24	583	○
		V	M	大型部件加工用 For Machining Large Parts	M27 ~ M56	587	
		V	U	一般用 General Application	No.4 ~ ⅞U	588	○
		V	U	大型部件加工用 For Machining Large Parts	1 ~ 2U	589	
		V	M	一般用(铣刀柄) General Application (Endmill Shank)	M3 ~ M14	590	○
	A-LT-SFT	V	M	一般用长柄型 General Application Long Shank	M2 ~ M24	591	○
		V	M	一般用长柄型(铣刀柄) General Application Long Shank (Endmill Shank)	M3 ~ M24	594	○
	EX-SFT		M	一般用 General Application	M1 ~ M56	595	
			U	〃	No.4 ~ 1¾U	600	
			W	〃	W⅛ ~ 1½	602	
			SM	〃	SM3⁄32 ~ 9⁄32	602	
			M(L)	一般用(左螺纹) General Application (LH Thread)	M3 ~ M30	603	
			W(L)	〃	W¼ ~ 1	604	
	EXZ-SFT	NZ	M	一般用高耐久性型螺旋槽丝锥 Highly Durable General Purpose Spiral Tap	M3 ~ M16	605	
	EX-LT-SFT		M	一般用长柄型 Long Shank · General Application	M2 ~ M36	606	
			W	一般用长柄型 Long Shank · General Application	W¼ ~ 1	611	
			M(L)	一般用长柄型(左螺纹) Long Shank · General Application (LH Thread)	M3 ~ M12	612	
	EX-H-SFT	H	M	一般用氧化处理 General Application (with OX)	M1 ~ M42	613	

螺纹种类 Thread　**M** 公制螺纹 Metric　**U** 美制螺纹 Unified　**W** 惠氏螺纹 Whitworth　**SM** 缝纫机用螺纹 For Sewing Machines

不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
	EX-LT-H-SFT	H	M	一般用氧化处理长柄型 Long Shank· General Application (with OX)	M3 ~ M24	615	
	EX-SC-SFT		M	短切削锥型 Short Chamfer Type	M1 ~ M30	617	
	LT-SC-SFT		M	短切削锥形长柄型 Long Shank· Short Chamfer Type	M3 ~ M12	620	
	VP-SFT	V	M	高硬度钢用 for High Strength Steels	M3 ~ M12	621	○
	V-SFT	V	M	V涂层 V coated	M1.4 ~ M18	622	
	V-LT-SFT	V	M	V涂层长柄型 Long Shank· V coated	M3 ~ M22	623	
	HXL-SFT	H	M	大型部件加工用（卧式加工机用） For Machining Large Parts (For Horizontal Machines)	M16 ~ M56	624	
	VXL-SFT	H	M	大型部件加工用（立式加工机用） For Machining Large Parts (For Vertical Machines)	M16 ~ M56	625	
	TIN-SFT	TiN	M	TiN涂层 TiN coated	M1.4 ~ M33	626	
	TIN-LT-SFT	TiN	M	TiN涂层长柄型 TiN coated· Long shank	M3 ~ M24	627	
	CPM-SFT		M	难加工材料用 for Difficult To Machine Materials	M1.4 ~ M48	628	○
	CPM-LT-SFT		M	难加工材料用长柄型 Long Shank· For Difficult To Machine Materials	M3 ~ M24	629	○
	CC-SUS-SFT	CrN TiN	M	不锈钢加工用（适用水溶性切削油剂） for Stainless Steels (for Water-Soluble Fluid)	M2 ~ M24	630	
	EX-SUS-SFT	H	M	不锈钢加工用 for Stainless Steels	M2 ~ M42	631	
		H	U	//	No.4 ~ 1U	633	
		H	W	//	W⅛ ~ 1	634	
	EX-LT-SUS-SFT	H	M	不锈钢用长柄型 Long Shank· for Stainless Steels	M3 ~ M24	635	
	SUS-DH-SFT	H	M	不锈钢·深孔用 for Stainress Steels and Deep Holes	M2 ~ M12	637	
	LT-SUS-DH-SFT	H	M	不锈钢·深孔用长柄型 Long Shank· for Stainless Steels and Deep Holes	M2 ~ M12	638	
	MS-DH-SFT	H	M	软钢·深孔用 for Mild Steels and Deep Holes	M2 ~ M42	639	
		H	U	//	No4 ~ ½U	640	
	LT-MS-DH-SFT	H	M	软钢·深孔用长柄型 Long Shank· for Mild Steels and Deep Holes	M3 ~ M24	641	
	EX-B-DH-SFT		M	非铁合金·深孔用 for Non-Ferrous Metals and Deep Holes	M3 ~ M30	642	
	LW-SFT		M	小螺旋角型 Low Spiral	M3 ~ M30	643	
	OIL-SFT	H	M	内冷油孔型 with Internal Coolant Supply	M6 ~ M30	644	
	EX-AL-SFT		M	铝加工用 for Aluminium	M2 ~ M12	645	
	OT-SFT		M	硬质合金螺旋槽丝锥 Carbide Spiral Fluted	M3 ~ M12	646	○
	A-CSF	FX	M	内冷油孔硬质合金螺旋槽丝锥 Carbide Spiral Fluted Tap with Internal Coolant Supply	M6 ~ M12	647	○
		FX	M	内冷油孔硬质合金螺旋槽丝锥（铣刀柄） Carbide Spiral Fluted Tap With Internal Coolant Supply (End Mill Shank)	M6 ~ M12	647	○
	EX-HC-SFT		M	高碳素钢用 for High Carbon Steels	M3 ~ M18	648	
	CU-SFT	CrN	M	铜用 for Copper	M3 ~ M12	649	

螺纹种类 Thread　M 公制螺纹 Metric　U 美制螺纹 Unified　W 惠氏螺纹 Whitworth

不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
螺旋槽丝锥系列 Spiral Fluted Taps							
	V-TI-SFT	V	M	钛合金用 for Titanium Alloy	M3 ~ M12	650	○
		V	U	〃	No.6 ~ ½U	650	○
	WHR-NI-SFT	HR	M	HR涂层镍基超耐热合金用 HR coated for Nickel Alloy	M3 ~ M12	651	○
		HR	U	〃	No.8 ~ ½U	651	○
	NI-SFT		M	镍基超耐热合金用 for Nickel Alloy	M3 ~ M12	652	○
			U	〃	No.6 ~ ½U	652	○
	HS-SFT	TiN	M	高速同步丝锥 Synchro Taps	M3 ~ M14	653	
	J-HS-SFT	TiN	M	高速同步丝锥 JIS柄 Synchro Taps (JIS Shank)	M3 ~ M14	653	
	HS-LT-SFT	TiN	M	高速同步丝锥 长柄 Synchro Taps· Long Shank	M3 ~ M30	654	
	HS-AL-SFT		M	铝用高速同步丝锥 Synchro Taps ·for Aluminium	M2 ~ M6	655	
	US-AL-SFT	V N	M	超高速同步丝锥 ULTRA Synchro Taps	M3 ~ M24	655	
	VPO-US-SFT	V	M	钢加工用内冷油孔高速同步丝锥 ULTRA Synchro Taps with Internal Coolant Supply for Steel	M6 ~ M12	656	○
刃倾角丝锥系列 Spiral Pointed Taps							
	A-POT	V	M	一般用 General Application	M1.4 ~ M24	657	○
		V	U	〃	No.4 ~ 7/8U	660	○
		V	M	一般用 (铣刀柄) General Application (Endmill Shank)	M3 ~ M14	661	○
	A-LT-POT	V	M	一般用长柄型 General Application Long Shank	M2 ~ M24	662	○
		V	M	一般用长柄型 (铣刀柄) General Application Long Shank (Endmill Shank)	M3 ~ M24	664	○
	EX-POT		M	一般用 General Application	M1 ~ M48	665	
			U	〃	No.0 ~ 1½U	667	
			W	〃	W⅛ ~ 1½	668	
			SM	〃	SM3/32 ~ 9/32	669	
			M(L)	一般用(左螺纹) General Application (LH Thread)	M3 ~ M30	670	
	EX-LT-POT		M	一般用长柄型 Long Shank· General Application	M2 ~ M36	671	
			W	〃	W¼ ~ 1	673	
			M(L)	一般用长柄型(左螺纹) Long Shank· General Application (LH Thread)	M3 ~ M12	674	
	EX-H-POT	H	M	一般用氧化处理 General Application (with OX)	M1.4 ~ M42	675	
	EX-LT-H-POT	H	M	一般用氧化处理长柄型 Long Shank· General Application (with OX)	M3 ~ M24	676	
	V-POT	V	M	V涂层 V coated	M3 ~ M24	677	○
	V-LT-POT	V	M	V涂层长柄型 V coated· Long Shank	M3 ~ M24	678	○

螺纹种类 Thread　**M** 公制螺纹 Metric　**U** 美制螺纹 Unified　**W** 惠氏螺纹 Whitworth　**SM** 缝纫机用螺纹 For Sewing Machines

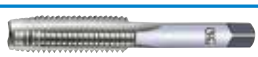
不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
	TIN-POT	TiN	M	TiN涂层 TiN coated	M1.4～M42	679	○
	TIN-LT-POT	TiN	M	TiN涂层长柄型 TiN coated · Long Shank	M3～M24	680	○
	CPM-POT		M	难加工材料用 for Diffficult to Machine Materials	M1.4～M48	681	○
	CPM-LT-POT		M	难加工材料用长柄型 Long Shank · for Diffficult to Machine Materials	M3～M24	682	○
	EX-SUS-POT	H	M	不锈钢用 for Stainless Steels	M1.4～M42	683	
		H	U	//	No.4～1U	684	
		H	W	//	W⅛～1	685	
	EX-LT-SUS-POT	H	M	不锈钢用长柄型 Long Shank · for Stainless Steels	M3～M24	686	
	EX-DH-POT	H	M	深孔用 for Deep Holes	M2～M42	687	
		H	U	//	No4～½U	688	
	EX-LT-DH-POT	H	M	深孔用长柄型 Long Shank · for Deep Holes	M3～M24	689	
	OIL-POT	H	M	内冷油孔型 with Internal Coolant Supply	M6～M30	690	
	EX-SS-POT	H	M	薄板用 for Sheet Steels	M1.4～M20	691	
	CU-POT	CrN	M	铜用 for Copper	M3～M12	692	
	V-TI-POT	V	M	钛合金用 for Titanium Alloy	M3～M12	693	○
		V	U	//	No.6～½U	693	○
	WHR-NI-POT	HR	M	HR涂层镍基超耐热合金用 HR coated for Nickel Alloy	M3～M12	694	○
		HR	U	//	No.8～½	694	○
	NI-POT		M	镍基超耐热合金用 for Nickel Alloy	M3～M12	695	○
			U	//	No.6～½U	695	○
	HS-RFT	TiN	M	高速同步丝锥 Synchro Taps	M3～M14	696	
	J-HS-RFT	TiN	M	高速同步丝锥 JIS柄 Synchro Taps (JIS shank)	M3～M14	696	
	HS-LT-RFT	TiN	M	高速同步丝锥 长柄型 Synchro Taps · Long Shank	M3～M30	697	
	VPO-US-POT	V	M	钢用内冷油孔高速同步丝锥 ULTRA Synchro Taps with Internal Coolant Supply for Steel	M6～M12	698	○
	HS-AL-RFT		M	铝用高速同步丝锥 Synchro Taps · for Aluminum	M2～M6	699	
	US-AL-RFT	V N	M	超高速同步丝锥 ULTRA Synchro Taps	M3～M24	700	

螺纹种类 Thread　**M** 公制螺纹 Metric　**U** 美制螺纹 Unified　**W** 惠氏螺纹 Whitworth

不同用途的丝锥 A WIDE VARIETY OF TAPS

直槽丝锥系列 Straight Fluted Taps (Hand Taps)

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
	HT		M	一般用 General Application	M1 ~ M100	701 ~ 718	
			U	〃	No.0 ~ 4U	719 ~ 723	
			W	〃	W⅛ ~ 3	724	
			SM	〃	SM3⁄32 ~ ½	725	
			M(L)	一般用(左螺纹) General Application (LH Thread)	M1.4 ~ M36	726 ~ 730	
			U(L)	〃	¼ ~ 1U	731 ~ 732	
			W(L)	〃	W⅛ ~ 1½	733	
	HT-4F		M	一般用(4槽) General Application (4F)	M4 ~ M6	734	
	HT-3F		M	一般用(3槽) General Application (3F)	M8 ~ M12	735	
	EX-OST		M	中径加大用 Oversized	M3 ~ M20	736	
	EX-LT		M	一般用长柄型 Long Shank· General Application	M2 ~ M48	737 ~ 739	
			U	〃	¼ ~ 1U	739	
			W	〃	W¼ ~ 1	740	
			M(L)	一般用长柄型(左螺纹) Long Shank· General Application (LH Thread)	M3 ~ M12	741	
	EX-LT-OST		M	中径加大用 长柄型 Long Shank· Oversized	M3 ~ M12	742	
	H-HT	H	M	一般用氧化处理 General Application (with OX)	M3 ~ M30	743	
	EX-H-LT	H	M	一般用氧化处理长柄型 Long Shank· General Aprication (with OX)	M3 ~ M24	744	
	EX-SST		M	深孔用(细柄型) for Deep Holes (Slim Shank)	M3 ~ M6	745	
	V-LT	V	M	V涂层长柄型 V coated · Long Shank	M3 ~ M24	746	
	TIN-HT	TiN	M	TiN涂层 TiN coated	M2 ~ M42	747	
	TIN-LT	TiN	M	TiN涂层长柄型 TiN coated· Long Shank	M3 ~ M24	748	
	CPM-HT		M	难加工材料用 for Difficult to Machine Materials	M3 ~ M48	749	○
	CPM-LT		M	难加工材料用长柄型 Long Shank· for Difficult to Machine Materials	M3 ~ M24	750	○
	OIL-HT	H	M	内冷油孔型 with Internal Coolant Supply	M6 ~ M30	751	
	EX-SUS-HT	H	M	不锈钢用 for Stainless Steels	M2 ~ M30	752	
	EX-FC-HT	N	M	铸铁用 for Cast Iron	M3 ~ M20	753	
	EX-FC-LT	N	M	铸铁用长柄型 Long Shank· for Cast Iron	M3 ~ M24	754	
	OTT		M	硬质合金直槽丝锥 Carbide Straight Fluted	M1.4 ~ M24	755	○
	LT-OTT		M	硬质合金直槽长柄型 Carbide Long Shank· Straight Fluted	M3 ~ M24	756	○

螺纹种类 Thread　**M** 公制螺纹 Metric　**U** 美制螺纹 Unified　**W** 惠氏螺纹 Whitworth　**SM** 缝纫机用螺纹 For Sewing Machines

不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
	AL-HT		M	铝合金用 for Aluminium	M3～M12	757	
	EX-PLA-HT	N	M	树脂用 for Plastic/Resin	M2～M12	757	○
	EX-DC-HT	N	M	铸件用 for Die Castings	M1.4～M20	758	
	A-CHT	FX	M	内冷油孔硬质合金直槽丝锥 Carbide Spiral Fluted Tap with Internal Coolant Supply	M6～M12	759	○
		FX	M	内冷油孔硬质合金直槽丝锥(铣刀柄) Carbide Spiral Fluted Tap with Internal Coolant Supply (End Mill Shank)	M6～M12	759	○
	OT-DC-HT		M	硬质合金铸件用直槽丝锥 Carbide Straight Fluted · for Die Castings	M3～M12	761	○
	HS-O-OTT	FX	M	硬质合金内冷油孔高速同步直槽丝锥 Carbide Synchro Taps with Internal Coolant Supply	M12	760	○
	VP-DC-HT	V	M	铸件用零前角丝锥 V coated · for Die Castings	M6～M12	762	○
	VO-DC-HT	V	M	铸件用零前角内冷油孔丝锥 V coated · for Die Castings with Internal Coolant Supply	M6～M12	762	
	EX-SH-HT		M	高硬度钢用 for High Strength Steels	M6～M20	763	
	V-XPM-HT	V	M	〃	M3～M12	764	○
	WH55-OT	V	M	高硬度钢(～55HRC)用 for High Strength Steels (～55HRC)	M3～M12	765	○
	VX-OT	V	M	硬质合金高硬度钢用直槽丝锥 Carbide Straight Fluted · for Hardened Steels (50HRC～60HRC)	M2～M20	766	○

锥管螺纹丝锥系列 Taper Pipe Thread Taps

	A-TPT	V	PT	螺旋槽丝锥(锥管螺纹，长螺纹型) Spiral Fluted Tap (Taper Pipe Thread)	PT1/16～1	767	
		V	Rc	〃	Rc1/16～1	767	
	A-S-TPT	V	PT	螺旋槽丝锥(锥管螺纹，短螺纹型) Spiral Fluted Tap (Taper Pipe Thread)	PT1/16～1	768	
	TPT		PT	一般用 General Application	PT1/16～4	769	
			Rc	〃	Rc1/16～1	769	
			PT(L)	一般用(左螺纹) General Application (LH Thread)	PT1/8～1	770	
	S-TPT		PT	一般用短螺纹 General Application (Short Thread)	PT1/16～3	770	
	H-TPT	H	PT	一般用氧化处理 General Application (with OX)	PT1/16～1½	771	
	H-S-TPT	H	PT	一般用短螺纹氧化处理 General Application (with OX, Short Thread)	PT1/16～1½	771	
	LT-TPT		PT	一般用长柄型 Long Shank · General Application	PT1/8～1	772	
	LT-S-TPT		PT	一般用短螺纹长柄型 Long Shank · General Application (Short Thread)	PT1/8～1	772	
	SFT-TPT		PT	螺旋槽丝锥 Spiral Fluted	PT1/8～1½	773	
	SFT-S-TPT		PT	螺旋槽丝锥短螺纹型 Spiral Fluted (Short Thread)	PT1/8～1	773	
	LT-SFT-TPT		PT	螺旋槽丝锥长柄型 Long Shank · Spiral Fluted	PT1/8～1	774	
	LT-SFT-S-TPT		PT	螺旋槽丝锥长柄短螺纹型 Long Shank · Spiral Fluted (Short Thread)	PT1/8～1	774	
	V-XPM-TPT	V	PT	高硬度钢用 for High Strength Steels	PT1/8～1	775	○

螺纹种类 Thread　**M** 公制螺纹 Metric　**PT、Rc** 锥管螺纹 Taper Pipe

不同用途的丝锥 A WIDE VARIETY OF TAPS

锥管螺纹丝锥系列 Taper Pipe Thread Taps

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
	VX-TPT	V	PT	硬质合金高硬度钢用锥管螺纹丝锥 Carbide Taper Pipe Thread Taps for Hardened Steel	PT1/8 ~ 1/2	776	○
	TIN-TPT	TiN	PT	TiN涂层 TiN coated	PT1/8 ~ 1	777	
	TIN-S-TPT	TiN	PT	TiN涂层短螺纹型 TiN coated (Short Thread)	PT1/8 ~ 1	777	
	TIN-LT-TPT	TiN	PT	TiN涂层长柄型 TiN coated · Long Shank	PT1/8 ~ 1	778	
	TIN-LT-S-TPT	TiN	PT	TiN涂层短螺纹长柄型 TiN coated · Long Shank (Short Thread)	PT1/8 ~ 1	778	
	CPM-TPT		PT	难加工材料用 for Difficult to Machine Materials	PT1/8 ~ 1	779	○
	CPM-S-TPT		PT	难加工材料用短螺纹型 for Difficult to Machine Materials (Short Thread)	PT1/8 ~ 1	780	○
	CPM-LT-S-TPT		PT	难加工材料用短螺纹长柄型 Long Shank · for Difficult to Machine Materials (Short Thread)	PT1/8 ~ 1	780	○
	STL-TPT	H	PT	软钢用 for Mild Steels	PT1/8 ~ 1	781	
	STL-S-TPT	H	PT	软钢用短螺纹型 for Mild Steels (Short Thread)	PT1/8 ~ 1	781	
	OIL-TPT	H	PT	内冷油孔型 with Internal Coolant Supply	PT1/8 ~ 1	782	
	V-AL-TPT	V	PT	铝用 for Aluminum Alloy	PT1/8 ~ 1	782	
	EX-FC-TPT	N	PT	铸铁用 for Cast Iron	PT1/8 ~ 1	783	
	OT-TPT		PT	硬质合金锥管丝锥 Carbide for Taper Pipe Threads	PT1/8 ~ 1	784	○
	OT-S-TPT		PT	硬质合金锥管丝锥短螺纹型 Carbide for Taper Pipe Threads (Short Thread)	PT1/8 ~ 1	784	○
	OT-LT-TPT		PT	硬质合金锥管丝锥长柄型 Carbide Long Shank · for Taper Pipe Threads	PT1/8 ~ 1	785	○
	EX-SUS-TPT	H	PT	不锈钢用 for Stainless Steels	PT1/8 ~ 1 1/2	786	
	EX-SUS-S-TPT	H	PT	不锈钢用短螺纹型 for Stainless Steels (Short Thread)	PT1/8 ~ 1	786	
	LT-SUS-TPT	H	PT	不锈钢用长柄型 Long Shank · for Stainless Steels	PT1/8 ~ 1	787	
	LT-SUS-S-TPT	H	PT	不锈钢用短螺纹长柄型 Long Shank · for Stainless Steels (Short Thread)	PT1/8 ~ 1	787	
	SUS-SFT-TPT	H	PT	不锈钢用螺旋槽丝锥 Spiral Fluted · for Stainless Steels	PT1/16 ~ 1	788	
	SUS-SFT-S-TPT	H	PT	不锈钢用螺旋槽丝锥短螺纹型 Spiral Fluted · for Stainless Steels (Short Thread)	PT1/16 ~ 1	788	
	EX-IRT	H	PT	跳牙型 with Interrupted Threads	PT1/8 ~ 3	789	
	EX-S-IRT	H	PT	跳牙短螺纹型 with Interrupted Threads (Short Thread)	PT1/8 ~ 2	789	
	EX-LT-IRT	H	PT	跳牙长柄型 Long Shank · with Interrupted Threads	PT1/8 ~ 1	790	
	EX-LT-S-IRT	H	PT	跳牙短螺纹长柄型 Long shank · with Interrupted Threads (Short Thread)	PT1/8 ~ 1	790	
	TIN-IRT	TiN	PT	TiN涂层跳牙型 TiN coated · with Interrupted Threads	PT1/8 ~ 1	791	
	TIN-S-IRT	TiN	PT	TiN涂层跳牙短螺纹型 TiN coated · with Interrupted Threads (Short Thread)	PT1/8 ~ 1	791	
	TIN-LT-S-IRT	TiN	PT	TiN涂层长柄型 TiN coated · Long Shank · with Interrupted Threads (Short Thread)	PT1/8 ~ 1	791	

不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
平行管用丝锥系列 Parallel Pipe Thread Taps							
	A-SPT	V	Rp	螺旋槽丝锥(平行管螺纹) Spiral Fluted Tap (Parallel Pipe Thread)	Rp1/16 ~ 1	792	
		V	G	〃	G1/16 ~ 1	796	
	SPT		PS	一般用 General Application	PS1/8 ~ 4	793	
			Rp	〃	Rp1/16 ~ 1	793	
			PF	一般用 General Application	PF1/8 ~ 4	797	
			G	〃	G1/16 ~ 1	797	
			PS(L)	一般用(左螺纹) General Application (LH Thread)	PS1/8 ~ 1	794	
			PF(L)	〃	PF1/8 ~ 1	798	
	LT-SPT		PS	一般用长柄型 Long Shank· General Application	PS1/8 ~ 1	794	
			PF	〃	PF1/8 ~ 1	799	
	SFT-SPT		PS	螺旋槽丝锥 Spiral Fluted	PS1/8 ~ 1½	795	
			PF	〃	PF1/8 ~ 1½	804	
	EX-SUS-SPT	H	PS	不锈钢用 for Stainless Steels	PS1/8 ~ 1	795	
		H	PF	〃	PF1/8 ~ 1	801	
	EX-SPT		PF	中径加大用 Oversize	PF1/8 ~ 1	798	
	H-SPT	H	PF	一般用氧化处理 General Application (with OX)	PF1/8 ~ 1	799	
	TIN-SPT	TiN	PF	TiN涂层 TiN coated	PF1/8 ~ 1	800	
	CPM-SPT		PF	难加工材料用 for Difficult to Machine Materials	PF1/8 ~ 1	800	○
	SUS-SFT-SPT	H	PF	不锈钢用螺旋槽型 Spiral Fluted· for Stainless Steels	PF1/8 ~ 1	801	
	OIL-SPT	H	PF	内冷油孔型 with Internal Coolant Supply	PF1/8 ~ 1	802	
	NRT-SPT	H	PF	NRT挤压丝锥 Fluteless (Nu-Roll)	PF1/8 ~ 1	802	○
	OT-SPT		PF	硬质合金平行管螺纹丝锥 Carbide for Parallel Pipe Threads	PF1/8 ~ 1	803	○
	OT-LT-SPT		PF	硬质合金平行管螺纹丝锥长柄型 Carbide Long Shank· for Parallel Pipe Threads	PF1/8 ~ 1	803	○
	LT-SFT-SPT		PF	螺旋槽丝锥长柄型 Long Shank· Spiral Fluted	PF1/8 ~ 1	805	
	EX-POT-SPT		PF	刃倾角丝锥 Spiral Pointed	PF1/8 ~ 1	806	

螺纹种类 Thread **PS、Rp、PF、G** 平行管螺纹 Parallel Pipe

不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
管螺纹丝锥系列 (美式) American Pire Thread Taps							
	A-TPT	V	NPT	螺旋槽丝锥(锥管螺纹，长螺纹型) Spiral Fluted Tap (Taper Pipe Thread)	NPT1/16 ～ 1	807	
	A-S-TPT	V	NPT	螺旋槽丝锥(锥管螺纹，短螺纹型) Spiral Fluted Tap (Taper Pipe Thread)	NPT1/16 ～ 1	808	
	TPT		NPT	一般用 General Application	NPT1/16 ～ 4	809	○
			NPTF	〃	NPTF1/16 ～ 2	810	○
	S-TPT		NPT	一般用短螺纹型 General Application (Short Thread)	NPT1/16 ～ 1	809	○
			NPTF	〃	NPTF1/16 ～ 3/8	810	○
	SFT-TPT		NPT	螺旋槽丝锥 Spiral Fluted	NPT1/16 ～ 1	811	○
	IRT	H	NPT	跳牙型 with Interrupted Threads	NPT1/16 ～ 2	812	○
	TIN-IRT	TiN	NPT	TiN涂层跳牙型 TiN-coated · with Interrupted Threads	NPT1/8 ～ 1	812	
	EX-IRT	H	NPTF	跳牙型 with Interrupted Threads	NPTF1/16 ～ 3/8	812	
	A-SPT	V	NPS	螺旋槽丝锥(平行管螺纹) Spiral Fluted Tap (Parallel Pipe Thread)	NPS1/16 ～ 1	813	
	SPT		NPS	一般用 General Application	NPS1/16 ～ 4	814	○
			NPSF	〃	NPSF1/16 ～ 1 1/2	814	○
嵌套螺纹用丝锥系列 Insert Screw Thread Taps							
	A-SFT HL	V	M	螺旋槽丝锥 Spiral Fluted	M2 ～ M12	815	○
		V	U	〃	No.10 ～ 3/8U	815	○
	A-LT-SFT HL	V	M	螺旋槽丝锥长柄型 Long Shank · Spiral Fluted	M3 ～ M10	816	○
	EX-HL-SFT		M	螺旋槽丝锥 Spiral Fluted	M2 ～ M12	817	
	HL-LT-SFT		M	螺旋槽丝锥长柄型 Long Shank · Spiral Fluted	M3 ～ M12	817	
	EX-HL-POT		M	刃倾角丝锥 Spiral Pointed	M3 ～ M12	818	
	HL-LT-POT		M	刃倾角丝锥长柄型 Long Shank · Spiral Pointed	M3 ～ M12	818	
	HL-HT		M	直槽丝锥 Straight Fluted	M2 ～ M30	819	
			U	〃	No.2 ～ 1U	821	
	HL-LT		M	直槽丝锥长柄型 Long Shank · Straight Fluted	M3 ～ M12	822	
			U	〃	No.4 ～ 1/2U	822	
	HL-B-NRT	N	M	非铁用挤压丝锥 Fluteless (Nu-Roll) · for Non-Ferrous Metals	M2 ～ M12	823	○
	HL-LT-B-NRT	N	M	非铁用挤压丝锥长柄型 Long Shank · Fluteless (Nu-Roll) · for Non-Ferrous Metals	M3 ～ M12	823	○

螺纹种类 Thread **M** 公制螺纹 Metric **U** 美制螺纹 Unified **NPS、NPSF** 平行管螺纹 Parallel Pipe **NPT、NPTF** 锥管螺纹 Taper Pipe

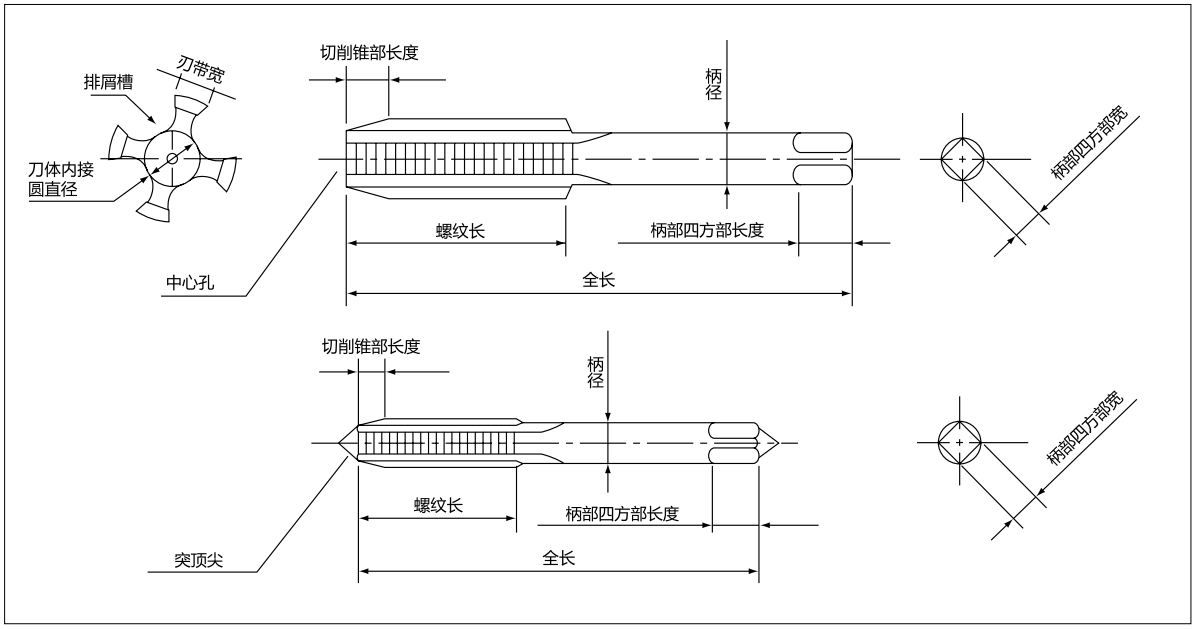
不同用途的丝锥 A WIDE VARIETY OF TAPS

形状 Appearance	产品记号 Abbreviation	表面处理 Surface Treatment	螺纹种类 Thread	式样 Specification	库存尺寸 Stocked Size	登载页面 Page	含钴 Cobalt
螺母丝锥系列 Nut Taps							
	NT		M	螺母丝锥 Nut Taps (Tapper Taps)	M2 ~ M39	824	
			U	螺母丝锥 Nut Taps (Tapper Taps)	No.6 ~ 1	825	
			W	//	W¼ ~ 1	824	
	O-NT		M	螺母丝锥中径加大用 Nut Taps (Tapper Taps)· Oversize	M3 ~ M12	825	
加工中心用丝锥系列 Machining Center Taps							
	EX-MCT	H	M	加工中心用长柄型 Machining Center Taps (Long Shank)	M6 ~ M24	826	
	EX-S-MCT	H	M	加工中心用短刃型 Machining Center Taps (Normal Length)	M6 ~ M24	826	
钻攻一体式丝锥系列 Drill Taps							
	DRT		M	钻攻一体式丝锥 Drill Taps	M3 ~ M16	827	
	V-DR-SFT	V	M	钻攻一体式螺旋槽丝锥 Spiral Fluted Tap Combined with Drill	M3 ~ M12	827	
修复用螺纹丝锥系列 Spatter Remove Hand Tap							
	SR-HT		M	修复用 for Spatter Remove	M5 ~ M14	828	
			U	//	7/16	828	
照相机三角架螺纹丝锥系列 Taps for Screw Threads for Camera Tripod Connections							
	TRP-SFT		U	照相机三角架螺纹用 Taps for Screw Threads for camera Tripod Connections	¼ ~ ⅜	829	

螺纹种类 Thread **M** 公制螺纹 Metric **U** 美制螺纹 Unified **W** 惠氏螺纹 Whitworth

丝锥选型之前

■各部的名称

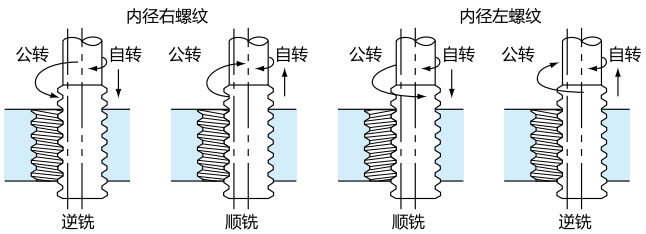


■代表性排屑槽形状的分类及特长

分　　类	特　　长	用　　途
螺旋槽丝锥	·螺旋槽 ·可攻丝至盲孔的最下部 ·切屑不会残留于孔内 ·易吃入至底孔 ·切削性能锋利	·切屑呈连续卷曲状的材料 ·盲孔 ·内壁带轴向切槽的孔
刃倾角丝锥	·刃倾角槽 ·切屑从前方排出 ·无切屑堵塞状况 ·抗折损强度大 ·切削性能锋利	·切屑呈连续卷曲状的材料 ·通孔 ·内壁带轴向切槽的孔 ·高速攻丝
挤压丝锥	·利用塑性原理加工内螺纹 ·无切屑排出 ·内螺纹精度稳定 ·抗折损强度大	·延伸性良好的材料 ·通孔，盲孔兼用
直槽丝锥	·直槽 ·刃尖强度大 ·切削锥长度选择容易 ·再研磨容易	·高硬度的加工材料 ·易引起刀具磨损的材料 ·切屑呈粉末状的材料 ·攻丝长度短的通孔，盲孔

■使用三轴连动功能进行螺纹铣削加工

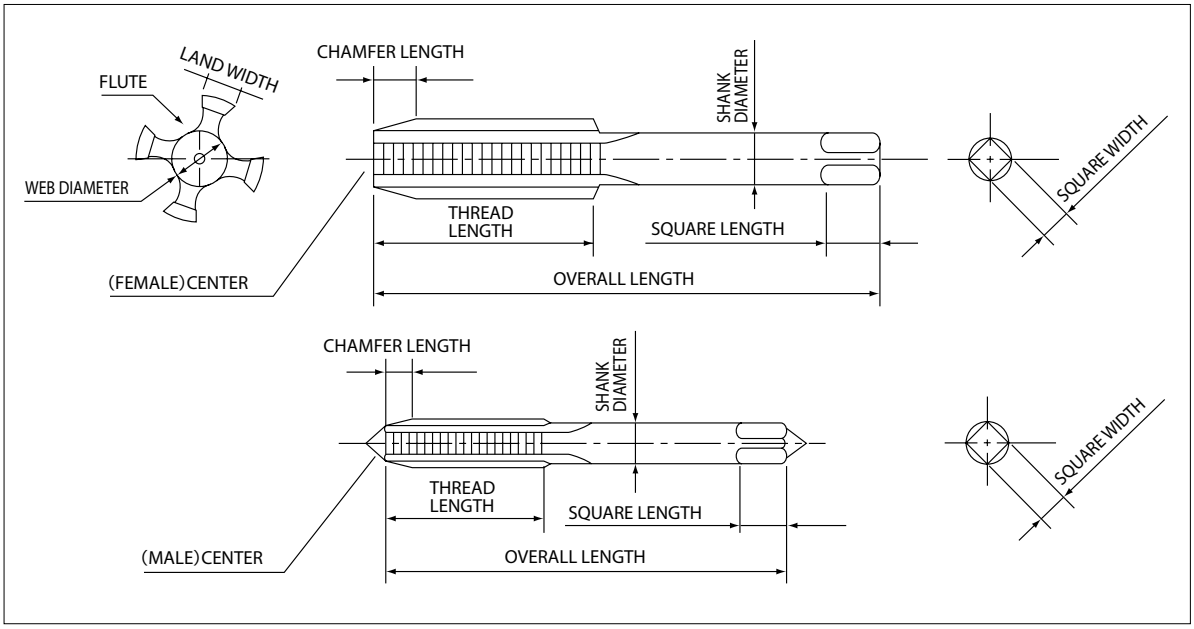
工具自转(主轴回转)和公转(切削进给)运动，公转一周轴向进给1个螺距用三轴联动铣削螺纹。OSG为您准备了"螺纹铣刀"。



※通常情况下推荐顺铣。

INFORMATION FOR THE USER

TERMINOLOGY

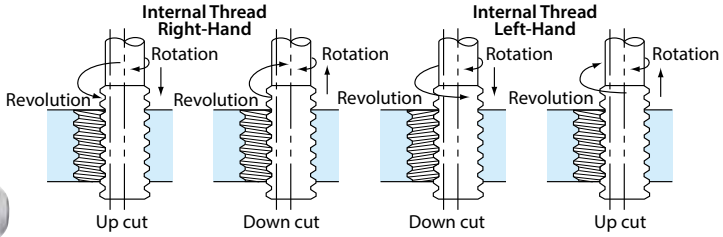


TYPE OF TAPS & FEATURES

Type	Features	Application
Spiral Fluted Taps	・Spiral flute ・Chips flow out against tapping direction(ejected from holes) ・Lower tapping torque and applicable for tapping to the bottom of holes ・Good cutting action	・For blind holes ・Materials where chips come out continuously in coil shape
Spiral Pointed Taps	・Spiral point(Chip Drive) ・Pushes chips forward with low cutting torque ・Shallow and unique flute form provides strong structure ・Good cutting action	・For through holes ・Materials where chips come out continuously in coil shape ・High speed tapping
Fluteless Taps(Forming Taps)	・Fluteless ・Taps do not produce chips ・Precise uniformity of tapped thread limit ・Excellent rigidity	・For both through & blind holes ・Materials with Formability
Straight Fluted Taps(Hand Taps)	・Straight flute ・Strong cutting edges ・Applicable for various cuttig conditions ・Easy to re-grind	・For both through & blind holes (short thread depth only) ・Materials where chips come out in powder form ・Hard materials

THREAD MILLING by CNC SIMULTANEOUS THREE-AXIS CONTROL

The OSG Thread Milling Cutter are designed for thread milling with 3 axis CNC controlled machines.Thread processing is accomplished by advancing one pitch feed per revolution in the axial direction, utilizing planet-like rotation and revolution.



※Climb milling is recommended in general.

丝锥选型基准表 TAP SELECTION CHART

通孔 Through Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number or Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 低碳素钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
刃倾角丝锥 Spiral Pointed Taps	A丝锥·A丝锥(立铣刀柄) A-TAP·A-TAP (Endmill Shank)	A-POT	657～661	V	5	◎	◎	◎	◎	◎	◎	◎
	A丝锥长柄型·A丝锥长柄型(立铣刀柄) A-TAP Long Shank·A-TAP Long Shank (Endmill Shank)	A-LT-POT	662～664	V	5	◎	◎	◎	◎	◎	◎	◎
	一般用 General Application	EX-POT	665～670		5	◎	◎	◎		○	○	○
	一般用长柄型 Long Shank·General Application	EX-LT-POT	671～674		5	◎	◎	◎		○	○	○
	一般用氧化处理 General Application (with OX)	EX-H-POT	675	氧化 OX	5	◎	◎	◎	◎	○	○	○
	一般用氧化处理长柄型 Long Shank·General Application (with OX)	EX-LT-H-POT	676	氧化 OX	5	◎	◎	◎	◎	○	○	○
	V涂层 V coated	V-POT	677	V	5	◎	◎	◎	◎	◎	◎	◎
	V涂层长柄型 V coated·Long Shank	V-LT-POT	678	V	5	◎	◎	◎	◎	◎	◎	◎
	TiN涂层 TiN coated	TIN-POT	679	TiN	5	◎	◎	◎	○	○	○	○
	TiN涂层长柄型 TiN coated·Long Shank	TIN-LT-POT	680	TiN	5	◎	◎	◎	○	○	○	○
	难加工材料用 For Difficult to Machine Materials	CPM-POT	681		5	◎	○				◎	
	难加工材料用长柄型 Long Shank·for Difficult to Machine Materials	CPM-LT-POT	682		5	◎	○				◎	
	不锈钢用 For Stainless Steels	EX-SUS-POT	683～685	氧化 OX	4	◎	◎	○				
	不锈钢用长柄型 Long Shank·for Stainless Steels	EX-LT-SUS-POT	686	氧化 OX	4	◎	◎	○				
	深孔用 For Deep Holes	EX-DH-POT	687～688	氧化 OX	4	◎	◎	◎	◎	◎		○
	深孔用长柄型 Long Shank·for Deep Holes	EX-LT-DH-POT	689	氧化 OX	4	◎	◎	◎	◎	◎		○
	内冷油孔型 With Internal Coolant Supply	OIL-POT	690	氧化 OX	4	◎	◎	◎	◎	◎	○	◎
	薄板用 For Sheet Steels	EX-SS-POT	691	氧化 OX	5	◎			◎			
	铜用 For Copper	CU-POT	692	CrN	5	◎	◎	◎				
	钛合金用 For Titanium Alloys	V-TI-POT	693	V	5	◎	◎					
	HR涂层镍基超耐热合金用 HR coated for Nickel Alloys	WHR-NI-POT	694	HR	5	◎	○					
	镍基超耐热合金用 For Nickel Alloys	NI-POT	695		5	◎	○					
	高速同步型 LH Synchro Tap	HS-RFT	696	TiN	6	◎	◎	○	◎	◎	○	○
	高速同步丝锥 JIS柄型 Synchro Tap·JIS Shank	J-HS-RFT	696	TiN	5	◎	◎	○	◎	◎	○	○
	高速同步长柄型 Synchro Tap·Long Shank	HS-LT-RFT	697	TiN	6	◎	◎	○	◎	◎	○	○
	钢用内冷油孔高速同步丝锥 Synchro Tap for Steel (oil hole)	VPO-US-POT	698	V	5	◎	◎	◎	◎	◎	○	○
	铝用高速同步型 LH Synchro Tap for Aluminum	HS-AL-RFT	699		6	◎	◎	○				
	超高速同步反螺旋槽型 LH Ultra Synchro Tap	US-AL-RFT	700	V or氮化 V or N	6	◎	○					
挤压丝锥 Fluteless Taps	高效率·多功能挤压丝锥 Highly Efficient Multi-Purpose Forming Tap	A-XPF	543	特	2	◎	◎	◎	◎	◎	◎	◎
	XPF挤压丝锥 X Performer	S-XPF	544	V	2	◎	◎	◎	◎	◎	◎	◎
	XPF挤压丝锥长柄型 X Performer·Long Shank	LT-S-XPF	546	V	2	◎	◎	◎	◎	◎	◎	◎
	内冷油孔XPF挤压丝锥 X Performer with Internal Coolant Supply	OIL-S-XPF	547	V	2	◎	◎	◎	◎	◎	◎	◎
	VP挤压丝锥 VP Nu-Roll	VP-NRT	548～549	V	4	◎	◎	◎	◎	◎	◎	◎
	VP挤压丝锥长柄型 VP Nu-Roll·Long Shank	VP-LT-NRT	550～551	V	4	◎	◎	◎	◎	◎	◎	◎
	V涂层 V coated	V-NRT	557	V	4	◎	◎	◎	◎	◎	○	○
	V挤压丝锥长柄型 V coated·Long Shank	V-LT-NRT	558	V	4	◎	◎	◎	◎	◎	○	○
	薄板用 For Sheet Steels	V-SS-NRT	559	V	8	◎			◎	○	○	○
	带小径精加工刃 With Cutting Edge on Minor Dia. (EG-NRT)	V-EG-NRT	560	V	4	◎	◎	◎				
	TiN涂层 TiN coated	TIN-NRT	561～563	TiN	4	◎	◎	◎	○	○	○	○

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

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

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

通孔 Through Hole

加工材料 Work Material																						
调质钢 Hardended Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○			
◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○			
								○	○	○	○	○	◎	○	○	○				○
								○	○	○	○	○	◎	○	○	○				○
						○														○
						○														○
○				◎	○	◎		◎	○	○	○	○	○	○	○	○	○			○
○				◎	○	◎		◎	○	○	○	○	○	○	○	○	○			○
○				◎	○	○		○	○	○	○	○	○	○	○	○	○			○
○				◎	○	○		○	○	○	○	○	○	○	○	○	○			○
◎	○				○	○	○	○						○			○	○		
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◎				◎※1		○			◎	◎	◎		◎	◎		◎				
				◎		○			◎	◎	◎		◎	◎		◎				
				◎		○			◎	◎	◎		◎	◎		◎				
				◎					◎	◎	◎		◎	◎		◎				
				◎					◎	◎	◎		◎	◎		◎				
				◎					◎	◎	◎		◎	◎		○				
														◎		◎				
				◎		○			○	○	○		○	○		○				

4. 丝锥的精度不能保证内螺纹的精度。
5. 攻丝深度减去丝锥的切削锥部长度为有效螺纹长。
6. 此表以外的丝锥请联系OSG代理店。
※1 不锈钢加工时，请使用油性切削油剂或者润滑性良好的水溶性切削油剂。

4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.
5. Tapping depth minus chamfer length is an effective tapped thread length.
6. For other special-purpose taps, contact your nearest agent or distributor.
※1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

丝锥选型基准表 TAP SELECTION CHART

通孔 Through Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number or Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 软碳素钢 Low Carbon Steel Mild Steel C ~0.25%	低碳素钢	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
挤压丝锥 Fluteless Taps	TiN涂层长柄型 TiN coated·Long Shank	TIN-LT-NRT	564	TiN	4	◎	◎	◎	○		○	○	○
	钢用 For Steels	NRT	565～567	氧化 OX	4	◎	◎	◎	○		○		
	钢用长柄型 Long Shank·for Steel	LT-NRT	568	氧化 OX	2	◎	◎	◎	○		○		
	硬质合金NRT型丝锥 Carbide Fluteless (Nu-Roll)	OT-NRT	569		4	◎	◎	◎	○				
	硬质合金NRT型丝锥长柄型 Carbide Long Shank·Fluteless (Nu-Roll)	OT-LT-NRT	570		4	◎	◎	◎	○				
	非铁合金用 For Non-Ferrous Metals	B-NRT	571～574	氮化 N	4	◎	◎	◎					
	非铁合金用长柄型 Long Shank·for Non-Ferrous Metals	LT-B-NRT	575	氮化 N	2	◎	◎	◎					
	铜用 For Copper	CU-NRT	576	CrN	2	◎	◎	◎					
	铝用高速同步型 Synchro Taps for Aluminum	HS-AL-NRT	577		4	◎	◎	◎					
	超高速同步进给NRT型 Ultra Synchro Taps for Aluminum	US-AL-NRT	578	V	2	◎	◎	◎					
	钢用 For Steels	HRT	580	氧化 OX	4	◎	◎	◎	○		○		
	非铁合金用 For Non-Ferrous Metals	B-HRT	581～582		4	◎	◎	◎					
直槽丝锥 Straight Fluted Taps	一般用 General Application	HT	701～733		5	◎	○				○		
					9	◎	○				○		
	一般用(4槽) General Application (4F)	HT-4F	734		5	◎	○						
	一般用(3槽) General Application (3F)	HT-3F	735		5	◎	○						
	中径加大用 Oversize	EX-OST	736		5	◎	○				○		○
	一般用长柄型 Long Shank·General Application	EX-LT	737～741		5	◎	○				○		○
	中径加大用长柄型 Long Shank·Oversize	EX-LT-OST	742		5	◎	○				○		○
	一般用氧化处理 General Application (with OX)	H-HT	743	氧化 OX	5	◎	○		◎		○		○
	一般用氧化处理长柄型 Long Shank·General Application (with OX)	EX-H-LT	744	氧化 OX	5	◎	○		◎		○		○
	深孔用(细柄型) For Deep Holes (Slim Shank)	EX-SST	745		5	◎	○				○		○
	V涂层长柄型 V coated·Long Shank	V-LT	746	V	5	◎	◎		○		○	○	○
	TiN涂层 TiN coated	TIN-HT	747	TiN	5	◎	◎		○		○	○	○
	TiN涂层长柄型 TiN coated·Long Shank	TIN-LT	748	TiN	5	◎	◎		○		○	○	○
	难加工材料用 For Difficult to Machine Materials	CPM-HT	749		5	◎	○					◎	
	难加工材料用长柄型 Long Shank·for Difficult to Machine Materials	CPM-LT	750		5	◎	○					◎	
	内冷油孔型 With Internal Coolant Supply	OIL-HT	751	氧化 OX	5	◎	◎	○	◎		○	○	○
	不锈钢用 For Stainless Steels	EX-SUS-HT	752	氧化 OX	5	◎	○						
	铸铁用 For Cast Iron	EX-FC-HT	753	氮化 N	3	◎	◎	○					
	铸铁用长柄型 Long Shank·for Cast Iron	EX-FC-LT	754	氮化 N	3	◎	◎	○					
	硬质合金直槽丝锥 Straight Fluted	OTT	755		3	◎	◎	○					
	硬质合金直槽丝锥长柄型 Long Shank·Straight Fluted	LT-OTT	756		3	◎	◎	○					
	铝用 For Aluminium	AL-HT	757		3	◎	◎						
	树脂用 For Plastic / Resin	EX-PLA-HT	757	氮化 N	3	◎	◎	○					
	铸件用 For Die Castings	EX-DC-HT	758	氮化 N	3	◎	◎	○					
	硬质合金铸件用直槽丝锥 Straight Fluted·for Die Castings	OT-DC-HT	761		3	◎	◎	○					
	硬质合金内冷油孔高速同步型直槽丝锥 Synchro Tungsten Carbide Taps with Internal Coolant Supply	HS-O-OTT	760	FX	5	◎	◎	○					

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

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

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

通孔 Through Hole

加工材料 Work Material																						
调质钢 Hardended Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
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3. 经常检查加工的内螺纹的精度。
4. 丝锥的精度不能保证内螺纹的精度。
5. 攻丝深度减去丝锥的切削锥部长度为有效螺纹长。
6. 此表以外的丝锥请联系OSG代理店。

3. Always check the required thread limit for the internal thread.
4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.
5. Tapping depth minus chamfer length is an effective tapped thread length.
6. For other special-purpose taps, contact your nearest agent or distributor.

丝锥选型基准表 TAP SELECTION CHART

通孔 Through Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number or Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 低碳素钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
直槽丝锥 Straight Fluted Taps	铸件用零前角 V coated for Die coastings	VP-DC-HT	762	V	1.5	◎	◎	○				
	铸件用零前角内冷油孔型 V Coated·For Die Castings·With Internal Coolant Supply	VO-DC-HT	762	V	1.5	◎	◎	◎				
	高硬度钢用 For High Strength Steels	EX-SH-HT	763		5	◎	◎			○	○	○
	高硬度钢用 For Hardened Steels (42-52 HRC)	V-XPM-HT	764	V	5	◎						
	硬质合金高硬度钢用直槽丝锥 Carbide Straight Fluted·for Hardened Steels (50HRC~)	VX-OT	766	V	3	◎						
	硬质合金高硬度钢用(~55HRC) Carbide Straight Fluted·for Hardened Steels (~55HRC)	WH55-OT	765	WXS	5	◎						
	螺纹修补用 Spatter Remove Hand Tap	SR-HT	828		5	◎	○		◎	◎		◎
螺纹铣刀 PLANET CUTTER	One Revolution 螺纹铣刀 One Pass Thread Mill	AT-1	503~505	EgiAs		◎※2			◎	◎	◎	◎
	高硬度钢用带底刃螺纹铣刀 2D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2D Type	AT-2	506	DUROREY	1	◎※3			○	○	○	
	高硬度钢用带底刃螺纹铣刀 2.5D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2.5D Type	AT-2	507	DUROREY	1	◎	◎		○	○	○	
	高硬度钢用带底刃螺纹铣刀 锥管螺纹型 Thread Mill With End-Cutting Edge For High Hardness Steels Tapered Pipe Thread Type	AT-2	508	DUROREY	1	◎	◎		○	○	○	
	非铁金属用带底刃高效率螺纹铣刀 2D型 High-efficiency thread mill with end-cutting edge for non-ferrous materials 2D Type	AT-2 R-SPEC	509	DLC-IGUSS	2	◎※3						
	非铁金属用带底刃高效率螺纹铣刀 2.5D型 High-efficiency thread mill with end-cutting edge for non-ferrous materials 2.5D Type	AT-2 R-SPEC	510	DLC-IGUSS	2	◎	◎					
	硬质合金小径螺纹用螺纹铣刀 Carbide Small Diameter PLANET CUTTER	WH-VM-PNC	511	WXS		◎			○	○	○	○
	硬质合金钢用螺纹铣刀 Carbide PLANET CUTTER for Steels	WX-ST-PNC	512~513	WX		◎			○	◎	◎	◎
	硬质合金钢用内冷油孔螺纹铣刀 Carbide PLANET CUTTER for Steels with Internal Coolant Supply	WXO-ST-PNC	514	WX		◎			○	◎	◎	◎
	硬质合金非铁·耐热合金用螺纹铣刀 Carbide PLANET CUTTER for Nonferrous Metal and Heat-Resistant Alloy	WX-PNC	515~516	WX		◎			○			
	高速钢螺纹铣刀 HSS PLANET CUTTER	PNGT	519~520	TiN		◎			○	○	○	○
	硬质合金通用螺纹铣刀 Solid Carbide PLANET CUTTER	OT-PNGT	518	FX		◎			◎	◎	○	○
	硬质合金通用螺旋槽螺纹铣刀 Solid Carbide Spiral PLANET CUTTER	OT-SFT-PNGT	517	FX		◎			◎	◎	○	○
	复合加工用硬质合金内冷油孔超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling with Internal Coolant Supply	DR-O-PNAC	522	FX		◎※3						
	复合加工用硬质合金超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling	DR-PNAC	521	FX		◎※3						
锥管螺纹丝锥 Taper Pipe Thread Taps	A-TAP 锥管螺纹用 A-TAP Taper Pipe Threads	A-TPT	767、807	V	2.5	◎	◎		◎	◎	◎	◎
	A-TAP 锥管螺纹用短螺纹型 A-TAP Taper Pipe Threads (Short Thread)	A-S-TPT	768	V	2.5	◎	○		◎	◎	◎	◎
	一般用 General Application	TPT	769~770、809~810		2.5	◎	◎			○	○	
	一般用短螺纹 General Application (Short Thread)	S-TPT	770、809~810		2.5	◎	◎			○	○	
	一般用氧化处理 General Application (with OX)	H-TPT	771	氧化 OX	2.5	◎	◎		◎	○		○
	一般用短螺纹氧化处理 General Application (with OX, Short Thread)	H-S-TPT	771	氧化 OX	2.5	◎	◎		◎	○		○
	一般用长柄型 Long Shank·General Application	LT-TPT	772		2.5	◎	◎			○	○	
	一般用短螺纹长柄型 Long Shank·General Application (Short Thread)	LT-S-TPT	772		2.5	◎	◎			○	○	
	高硬度钢用 For High Strength Steels	V-XPM-TPT	775	V	3	◎						
	硬质合金高硬度钢用锥管螺纹丝锥 Taper pipe thread tap for hardened steel	VX-TPT	776	V	3	◎						
	TiN 涂层 TiN coated	TIN-TPT	777	TiN	2.5	◎	◎		○	◎	◎	◎
	TiN 涂层短螺纹型 TiN coated (Short Thread)	TIN-S-TPT	777	TiN	2.5	◎	◎		○	◎	◎	◎
	TiN 涂层长柄型 TiN coated·Long Shank	TIN-LT-TPT	778	TiN	2.5	◎	◎		○	◎	◎	◎
	TiN 涂层短螺纹长柄型 TiN coated·Long Shank (Short Thread)	TIN-LT-S-TPT	778	TiN	2.5	◎	◎		○	◎	◎	◎
	难加工材料用 For Difficult to Machine Materials	CPM-TPT	779		2.5	◎	○				◎	
	难加工材料用短螺纹型 For Difficult to Machine Materials(Short Thread)	CPM-S-TPT	780		2.5	◎	○				◎	
	难加工材料用短螺纹长柄型 Long Shank· For Difficult to Machine Materials(Short Thread)	CPM-LT-S-TPT	780		2.5	◎	○				◎	
	软钢用 For Mild Steels	STL-TPT	781	氧化 OX	2.5	◎	◎		◎	○		○
	软钢用短螺纹型 For Mild Steels (Short Thread)	STL-S-TPT	781	氧化 OX	2.5	◎	◎		◎	○		○
	内冷油孔型 With Internal Coolant Supply	OIL-TPT	782	氧化 OX	2.5	◎	◎		○	◎	○	◎
	V 涂层铝合金用 For Aluminum Alloy	V-AL-TPT	782	V	2.5	◎	◎					

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

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

1. These recommendations are general, and may be altered depending on tapping conditions.
2. Oversized taps are appropriate when a standard tap produces a thread that is too small, or when tapping before plating. 3. Always check the required thread limit for the internal thread.
4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

通孔 Through Hole

加工材料 Work Material

调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
							◎	◎						◎	◎	◎				
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5. 攻丝深度减去丝锥的切削锥部长度为有效螺纹长。
6. 此表以外的丝锥请联系OSG代理店。
※1推荐对应40HRC以上加工材料。
※2 M·U螺纹用丝锥仅可加工至2D。详细请确认尺寸表。
※3 可加工至2D。

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

丝锥选型基准表 TAP SELECTION CHART

通孔 Through Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number of Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 低碳素钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C 0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
锥管螺纹丝锥 Taper Pipe Thread Taps	铸铁用 For Cast Iron	EX-FC-TPT	783	氮化 N	2.5	◎	◎					
	硬质合金锥管螺纹丝锥 Carbide For Taper Pipe Threads	OT-TPT	784		2.5	◎	◎					
	硬质合金锥管螺纹丝锥短螺纹型 Carbide For Taper Pipe Threads (Short Thread)	OT-S-TPT	784		2.5	◎	◎					
	硬质合金锥管螺纹丝锥长柄型 Carbide Long Shank·for Taper Pipe Threads	OT-LT-TPT	785		2.5	◎	◎					
	不锈钢用 For Stainless Steels	EX-SUS-TPT	786	氧化 OX	2.5	◎	◎					
	不锈钢用短螺纹型 For Stainless Steels (Short Thread)	EX-SUS-S-TPT	786	氧化 OX	2.5	◎	◎					
	不锈钢用长柄型 Long Shank·for Stainless Steels	LT-SUS-TPT	787	氧化 OX	2.5	◎	◎					
	不锈钢用短螺纹长柄型 Long Shank·for Stainless Steels (Short Thread)	LT-SUS-S-TPT	787	氧化 OX	2.5	◎	◎					
	跳牙型 With Interupted Threads	EX-IRT	789、812	氧化 OX	2.5	◎	◎		○			
	跳牙短螺纹型 With Interupted Threads (Short Thread)	EX-S-IRT	789	氧化 OX	2.5	◎	◎		○			
	跳牙长柄型 Long Shank·with Interupted Threads	EX-LT-IRT	790	氧化 OX	2.5	◎	◎		○			
	跳牙短螺纹长柄型 Long Shank·with Interupted Threads (Short Thread)	EX-LT-S-IRT	790	氧化 OX	2.5	◎	◎		○			
	TiN 涂层跳牙型 TiN coated with Interupted Threads	TIN-IRT	791、812	TiN	2.5	◎	◎		○	○		
	TiN 涂层短螺纹型 TiN coated with Interupted Threads (Short Thread)	TIN-S-IRT	791	TiN	2.5	◎	◎		○	○		
	TiN 涂层长柄型 TiN coated·Long Shank·with Interupted Threads (Short Thread)	TIN-LT-S-IRT	791	TiN	2.5	◎	◎		○	○		
	跳牙型 With Interupted Threads	IRT	812	氧化 OX	2.5	◎	◎		○			
平行管螺纹丝锥 Parallel Pipe Thread Taps	A-TAP 平行管螺纹 A-TAP Parallel Pipe Threads	A-SPT	792、796、813	V	2.5	◎	◎		◎	◎	◎	◎
					1.5	◎	◎		◎	◎	◎	◎
	一般用 General Application	SPT	793~794、797~798、814		4	◎	◎			○		
	一般用长柄型 Long Shank·General Application	LT-SPT	794、799		4	◎	◎			○		
	不锈钢用 For Stainless Steels	EX-SUS-SPT	795、801	氧化 OX	4	◎	◎					
	中径加大用 Over Size	EX-SPT	798		4	◎	◎			○		
	一般用氧化处理 General Application (with OX)	H-SPT	799	氧化 OX	4	◎	◎		◎	○		○
	TiN 涂层 TiN coated	TIN-SPT	800	TiN	4	◎	◎		○	◎	○	◎
	难加工材料用 For Difficult to Machine Materials	CPM-SPT	800		3	◎	○				◎	
	内冷油孔型 With Internal Coolant Supply	OIL-SPT	802	氧化 OX	4	◎	◎		◎	○	○	○
	NRT 型 Fluteless (Nu-Roll)	NRT-SPT	802	氧化 OX	2.5	◎	◎	◎	◎	○	○	○
	硬质合金平行管螺纹丝锥 Carbide For Parallel Pipe Threads	OT-SPT	803		3	◎	◎	○				
	硬质合金平行管螺纹丝锥长柄型 Carbide Long Shank·for Parallel Pipe Threads	OT-LT-SPT	803		3	◎	◎	○				
	刃倾角型 Spiral Pointed	EX-POT-SPT	806		4	◎	◎			◎		◎
嵌套螺纹用丝锥 Insert Screw Thread Taps	刃倾角型 Spiral Pointed	EX-HL-POT	818		5	◎	◎					
	刃倾角长柄型 Long Shank·Spiral Fluted	HL-LT-POT	818		5	◎	◎					
	直槽型 Straight Fluted	HL-HT	819~821		5·9	◎	○					
	直槽长柄型 Long Shank·Straight Fluted	HL-LT	822		5	◎	○					
	非铁用 NRT 丝锥 Fluteless (Nu-Roll)·for Non-Ferrous Metals	HL-B-NRT	823	氮化 N	2	◎	◎	◎				
	非铁用 NRT 丝锥长柄型 Long Shank·Fluteless (Nu-Roll)·for Non-Ferrous Metals	HL-LT-B-NRT	823	氮化 N	2	◎	◎	◎				
其他 Others	加工中心用长柄型 Machining Center Taps (Long Shank)	EX-MCT	826	氧化 OX	3	◎	◎		◎	◎	○	○
	加工中心用短刃型 Machining Center Taps (Normal Length)	EX-S-MCT	826	氧化 OX	3	◎	◎		◎	◎	○	○

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

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

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

通孔 Through Hole

加工材料 Work Material

调质钢 Hardended Steel 25～35 HRC	调质钢 Hardended Steel 35～45 HRC	调质钢 Hardended Steel 45～50 HRC	调质钢 Hardended Steel 50～60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic (酚醛树脂类) Bakelite Phenol	热可塑性塑料 Thermo-plastic 聚氯乙烯 Vinyl Chloride Nylon
							◎	◎		◎	◎	○		○	◎	○			○	
							◎	○		○	○	◎		◎	○	◎			◎	
							◎	○		○	○	◎		◎	○	◎			◎	
							◎	○		○	○	◎		◎	○	◎			◎	
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◎				○	○	○		○	○	○	○	○	○	○	○	○	○				
						○	○	○		○	○	○	○	○	○	○					
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				◎					○												
						○	○	○		○	○	○	○	○	○	○					
						○			○												
○										○	○	○	○	○	○	○					
	○				○		◎	○						○			○	○		
					○	○	○	○		○	○	○				○					
				◎					○												
							◎	○		○	○	◎		◎	○	◎			◎	
							◎	○		○	○	◎		◎	○	◎			◎	
						◎		○	○	○	○	○	○	○	○	○				○
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													◎	◎		◎				
													◎	◎		◎				
						◎	○	○													
						◎	○	○													

3. 经常检查加工的内螺纹的精度。
4. 丝锥的精度不能保证内螺纹的精度。
5. 攻丝深度减去丝锥的切削锥部长度为有效螺纹长。
6. 此表以外的丝锥请联系OSG代理店。

3. Always check the required thread limit for the internal thread.
4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.
5. Tapping depth minus chamfer length is an effective tapped thread length.
6. For other special-purpose taps, contact your nearest agent or distributor.

丝锥选型基准表 TAP SELECTION CHART

盲孔 Blind Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number of Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 低碳素钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C 0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
螺旋槽丝锥 Spiral Fluted Taps	A丝锥·A丝锥(立铣刀柄) A-TAP·A-TAP (Endmill Shank)	A-SFT	583～590	V	2.5	◎	◎		○	◎	◎	○
	A丝锥 A-TAP	A-SFT	590	V	1.5	◎	◎		○	◎	◎	○
	A丝锥长柄型·A丝锥长柄型(立铣刀柄) A-TAP Long Shank·A-TAP Long Shank (Endmill Shank)	A-LT-SFT	591～594	V	2.5	◎	◎		○	◎	◎	○
	一般用 General Application	EX-SFT	595～604		2.5	◎	○			○		○
	一般用高耐久型螺旋槽丝锥 Highly Durable General Purpose Spiral Tap	EXZ-SFT	605	NZ	2.5	◎	○		○	◎	○	○
	一般用长柄型 Long Shank·General Application	EX-LT-SFT	606～612		2.5	◎	○			○		○
	一般用氧化处理 General Application (with OX)	EX-H-SFT	613～614	氧化 OX	2.5	◎	○		○	○		
	一般用氧化处理长柄型 Long Shank·General Application (with OX)	EX-LT-H-SFT	615～616	氧化 OX	2.5	◎	○		○	○		
	短切削锥型 Short Chamfer type	EX-SC-SFT	617～619		1.5	◎	◎			○		
	长柄短切削锥型 Short Chamfer type·Long Shank	LT-SC-SFT	620		1.5	◎	◎			○		
	高硬度钢用 For High Strength Steels	VP-SFT	621	V	2.5	◎	◎	○			◎	◎
	V涂层 V coated	V-SFT	622	V	2.5	◎	◎		○	◎	◎	○
	V涂层长柄型 V coated·Long Shank	V-LT-SFT	623	V	2.5	◎	◎		○	◎	◎	○
	大型部件加工用 (卧式加工机用) For Machining Large Parts (For Horizontal Machines)	HXL-SFT	624	氧化 OX	2.5	◎			○	◎	○	○
	大型部件加工用 (立式加工机用) For Machining Large Parts (For Vertical Machines)	VXL-SFT	625	氧化 OX	2.5	◎	○		○	◎	○	○
	TiN涂层 TiN coated	TIN-SFT	626	TiN	2.5	◎	◎		○	○	○	○
	TiN涂层长柄型 TiN coated·Long Shank	TIN-LT-SFT	627	TiN	2.5	◎	◎		○	○	○	○
	难加工材料 For Difficult to Machine Materials	CPM-SFT	628		3	◎	○				◎	○
	难加工材料用长柄型 Long Shank·for Difficult to Machine Materials	CPM-LT-SFT	629		3	◎	○				◎	○
	不锈钢加工用(适用水溶性切削油剂) For Stainless Steels (with water-soluble)	CC-SUS-SFT	630	CrN	2.5	◎	◎			○		
	不锈钢用 For Stainless Steels	EX-SUS-SFT	631～634	氧化 OX	2.5	◎	◎					
	不锈钢用长柄型 Long Shank·for Stainless Steels	EX-LT-SUS-SFT	635～636	氧化 OX	2.5	◎	◎					
	不锈钢·深孔用 For Stainless Steels·Deep Holes	SUS-DH-SFT	637	氧化 OX	2.5	◎	◎	◎				
	不锈钢·深孔用长柄型 Long Shank·for Stainless Steels·Deep Holes	LT-SUS-DH-SFT	638	氧化 OX	2.5	◎	◎	◎				
	软钢·深孔用 For Mild Steels and Deep Holes	MS-DH-SFT	639～640	氧化 OX	2.5	◎	◎	◎	◎	○		○
	软钢·深孔用长柄型 Long Shank·for Mild Steels and Deep Holes	LT-MS-DH-SFT	641	氧化 OX	2.5	◎	◎	◎	◎	○		○
	非铁合金·深孔用 For Non-Ferous Metals and Deep Holes	EX-B-DH-SFT	642		2.5	◎	◎	◎				
	小螺旋角型 Low Spiral	LW-SFT	643		2.5	◎	◎			○	◎	○
	内冷油孔型 With Internal Coolant Supply	OIL-SFT	644	氧化 OX	2.5	◎	◎		◎	◎	○	◎
	铝用 For Aluminium	EX-AL-SFT	645		2.5	◎	◎					
	硬质合金螺旋槽丝锥 Carbide Spiral Fluted	OT-SFT	646		1.5	◎	◎	○				
					2.5	◎	◎	○				
	A-TAP硬质合金 A-TAP Carbide	A-CSF	647	FX	1.5	◎	◎	◎				
	高碳素钢用 For High Carbon Steels	EX-HC-SFT	648		3	◎	○				◎	○
	铜用 For Copper	CU-SFT	649	CrN	2.5	◎	○					
	钛合金用 For Titanium Alloys	V-TI-SFT	650	V	2.5	◎	○					
	HR涂层镍基超耐热合金用 HR coated for Nickel Alloys	WHR-NI-SFT	651	HR	2.5	◎	○					
	镍基超耐热合金用 For Nickel Alloys	NI-SFT	652		2.5	◎	○					

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

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

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

盲孔 Blind Hole

加工材料 Work Material																					
调质钢 Hardended Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
◎				○	○	○		○	○	○	○	○	○	◎	○	○				
◎				○	○	○		○	○	○	○	○	○	◎	○	○				
◎				○	○	○		○	○	○	○	○	○	◎	○	○				
								○	○	○	○	○	○	○	○	○				○
								○	○	○	○	○	○	○	○	○				○
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○				○	○	○		○	○	○	○	○	○	○	○	○				○
	○				○		○	○						○			○	○		
	○				○		○	○						○			○	○		
				◎																
				◎					◎											◎
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				◎					◎											◎
				◎					◎											◎
						◎														○
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									○	○	○	○	◎							○
							○	○		○	○	○		○		○				
						◎		○	○	○	○	○								○
													◎	◎	○					○
							○	◎		◎	◎	○		○	○	○			◎	○
							○	◎		◎	◎	○		○	○	○			◎	○
							◎	◎		◎	◎	○		○	○	○			◎	○
					○	○														
				○					◎	○	○			○						○
	○																◎			
	○																	◎		
	○																	◎		

3. 经常检查加工的内螺纹的精度。
4. 丝锥的精度不能保证内螺纹的精度。
5. 攻丝深度减去丝锥的切削锥部长度为有效螺纹长。
6. 此表以外的丝锥请联系OSG代理店。

3. Always check the required thread limit for the internal thread.
4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.
5. Tapping depth minus chamfer length is an effective tapped thread length.
6. For other special-purpose taps, contact your nearest agent or distributor.

丝锥选型基准表 TAP SELECTION CHART

盲孔 Blind Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number of Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 低碳素钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
螺旋槽丝锥 Spiral Fluted Taps	高速同步型 Synchro Tap	HS-SFT	653	TiN	3	◎	◎		◎	◎	○	○
	高速同步丝锥 JIS 柄型 Synchro Tap · JIS Shank	J-HS-SFT	653	TiN	3	◎	◎		◎	◎	○	○
	高速同步长柄型 Synchro Tap · JIS Shank	HS-LT-SFT	654	TiN	3	◎	◎		◎	◎	○	○
	铝用高速同步型 Synchro Tap · for Aluminum	HS-AL-SFT	655		3	◎	◎					
	Ultra 同步螺旋槽型 Ultra Synchro Tap	US-AL-SFT	655	Vor氮化 V or N	3	◎	○					
	钢用内冷油孔同步丝锥 Synchro Tap for Steel(oil hole)	VPO-US-SFT	656	V	3	◎	◎		◎	◎		○
	照相机三角架安装螺纹用 Screw Threads for Tripod Connections for Camera	TRP-SFT	829		1.5	◎	○	○		○		○
挤压丝锥 Fluteless Taps	高效率 · 多功能挤压丝锥 Highly Efficient Multi-Purpose Forming Tap	A-XPF	543	特	2	◎	◎	◎	◎	◎	◎	◎
	XPF 挤压丝锥 X Performer	S-XPF	544 ~ 545	V	2	◎	◎	◎	◎	◎	◎	◎
	XPF 挤压丝锥长柄型 X Performer · Long Shank	LT-S-XPF	546	V	2	◎	◎	◎	◎	◎	◎	◎
	内冷油孔 XPF 挤压丝锥 X Performer with Internal Coolant Supply	OIL-S-XPF	547	V	2	◎	◎	◎	◎	◎	◎	◎
	VP 挤压丝锥 VP Nu-Roll	VP-NRT	548 ~ 549	V	2	◎	◎	◎	◎	◎	◎	◎
	VP 挤压丝锥长柄型 VP Nu-Roll · Long Shank	VP-LT-NRT	550 ~ 551	V	2	◎	◎	◎	◎	◎	◎	◎
	VP 挤压丝锥短切削锥型 VP Nu-Roll · Short Chamfer	VP-SC-NRT	552	V	1	◎	◎	◎	◎	◎	◎	◎
	VP 挤压丝锥短切削锥长柄型 VP Nu-Roll · Short Chamfer · Long Shank	VP-LT-SC-NRT	553	V	1	◎	◎	◎	◎	◎	◎	◎
	IT 挤压丝锥 IT Nu-Roll	IT-NRT	554	V	2	◎	◎	◎	◎	◎	◎	◎
	UM 挤压丝锥 UM Nu-Roll	UM-NRT	555	CrN	2	◎	◎	◎	◎			
	VP 挤压丝锥(短螺纹型) VP Nu-Roll · Short Thread Type	VP-NRTS	556	V	2	◎	◎	◎	◎	◎	◎	◎
	V 涂层 V coated	V-NRT	557	V	2	◎	◎	◎	◎	◎	○	○
	V 涂层长柄型 V coated · Long Shank	V-LT-NRT	558	V	2	◎	◎	◎	◎	◎	○	○
	带小径精加工刃型 With Cutting Edge on Minor Dia. (EG-NRT)	V-EG-NRT	560	V	2	◎	◎	◎				
	TiN 涂层 TiN coated	TIN-NRT	561 ~ 563	TiN	2	◎	◎	◎	○	○	○	○
	TiN 涂层长柄型 TiN coated·Long Shank	TIN-LT-NRT	564	TiN	2	◎	◎	◎	○	○	○	○
	钢用 For Steels	NRT	565 ~ 567	氧化 OX	2	◎	◎	◎	○	○		
	钢用长柄型 Long Shank·for Steele	LT-NRT	568	氧化 OX	2	◎	◎	◎	○	○		
	硬质合金 NRT 型丝锥 Carbide Fluteless (Nu-Roll)	OT-NRT	569		2	◎	◎	◎	○			
	硬质合金 NRT 丝锥长柄型 Carbide Long Shank·Fluteless (Nu-Roll)	OT-LT-NRT	570		2	◎	◎	◎	○			
	硬质合金镶刃 NRT 丝锥 Carbide Brazed Type	OT-IN-NRT	570		2	◎	◎	◎	○			
	非铁合金用 For Non-Ferrous Metals	B-NRT	571 ~ 574	氮化 N	2	◎	◎	◎				
	非铁合金用长柄型 Long Shank·for Non-Ferrous Metals	LT-B-NRT	575	氮化 N	2	◎	◎	◎				
	铜用 For Copper	CU-NRT	576	CrN	2	◎	◎	◎				
	铝用高速同步型 Synchro Taps · for Aluminum	HS-AL-NRT	577		2	◎	◎	◎				
	超高速同步进给 NRT 型 Ultra Synchro Taps · for Aluminum	US-AL-NRT	578	V	2	◎	◎	◎				
	V 涂层深孔用 V Coated · Deep Holes	V-LT-DH-NRT	579	V	2	◎	◎	◎	◎	◎	○	○
	钢用 For Steels	HRT	580	氧化 OX	2	◎	◎	◎	○	○		○
	非铁合金用 For Non-Ferrous Metals	B-HRT	581 ~ 582		2	◎	◎	◎				
直槽丝锥 Straight Fluted Taps	一般用 General Application	HT	701 ~ 733		1.5	◎	○			○		
	一般用(4槽) General Application (4F)	HT-4F	734		1.5	◎	○					
	一般用(3槽) General Application (3F)	HT-3F	735		1.5	◎	○					

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

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

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

盲孔 Blind Hole

加工材料 Work Material																					
调质钢 Hardended Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
○						○			○				○	○	○					○
○						○			○				○	○	○					○
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								○					○	○	○	○				○

4. 丝锥的精度不能保证内螺纹的精度。
5. 攻丝深度减去丝锥的切削锥部长度为有效螺纹长。
6. 此表以外的丝锥请联系OSG代理店。
※1 不锈钢加工时，请使用油性切削油剂或者润滑性良好的水溶性切削油剂。

4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.
5. Tapping depth minus chamfer length is an effective tapped thread length.
6. For other special-purpose taps, contact your nearest agent or distributor.
※1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

丝锥选型基准表 TAP SELECTION CHART

盲孔 Blind Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number or Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 低碳素钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C 0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
直槽丝锥 Straight Fluted Taps	中径加大用 Oversize	EX-OST	736		1.5	◎	○			○		○
	一般用长柄型 Long Shank·General Application	EX-LT	737～741		1.5	◎	○			○		○
	中径加大用长柄型 Long Shank·Oversize	EX-LT-OST	742		1.5	◎	○			○		○
	一般用氧化处理 General Application (with OX)	H-HT	743	氧化 OX	1.5	◎	○		◎	○		○
	一般用氧化处理长柄型 Long Shank·General Application (with OX)	EX-H-LT	744	氧化 OX	1.5	◎	○		◎	○		○
	深孔用(细柄型) For Deep Holes (Slim Shank)	EX-SST	745		1.5	◎	○			○		○
	V涂层长柄型 V coated · Long Shank	V-LT	746	V	1.5	◎	◎		○	○	○	○
	TiN涂层 TiN coated	TIN-HT	747	TiN	1.5	◎	◎		○	○	○	○
	TiN涂层长柄型 TiN coated·Long Shank	TIN-LT	748	TiN	1.5	◎	◎		○	○	○	○
	难加工材料用 For Difficult to Machine Materials	CPM-HT	749		2	◎	○				◎	
	难加工材料用长柄型 Long Shank·for Difficult to Machine Materials	CPM-LT	750		2	◎	○				◎	
	内冷油孔型 With Internal Coolant Supply	OIL-HT	751	氧化 OX	1.5	◎	◎	○	◎	○	○	○
	不锈钢用 For Stainless Steels	EX-SUS-HT	752	氧化 OX	1.5	◎	○					
	铸铁用 For Cast Iron	EX-FC-HT	753	氮化 N	1.5	◎	◎	○				
					3	◎	◎	○				
	铸铁用长柄型 Long Shank·for Cast Iron	EX-FC-LT	754	氮化 N	1.5	◎	◎	○				
					3	◎	◎	○				
	硬质合金直槽丝锥 Carbide Straight Fluted	OTT	755		1.5	◎	◎	○				
	硬质合金直槽丝锥长柄型 Carbide Long Shank·Straight Fluted	LT-OTT	756		1.5	◎	◎	○				
	铝用 For Aluminium	AL-HT	757		1.5	◎	◎					
	树脂用 For Plastic / Resin	EX-PLA-HT	757	氮化 N	3	◎	◎	○				
	铸件用 For Die Castings	EX-DC-HT	758	氮化 N	1.5	◎	◎	○				
					3	◎	◎	○				
	硬质合金铸件用直槽丝锥 Carbide Straight Fluted·for Die Castings	OT-DC-HT	761		1.5	◎	◎	○				
	A-TAP硬质合金 A-TAP Carbide	A-CHT	759	FX	1.5	◎	◎	○				
	硬质合金内冷油孔高速同步型直槽丝锥 Carbide Synchro Tap Internal Coolant Supply	HS-O-OTT	760	FX	2	◎	◎	◎				
	铸件用零前角 V coated for Die Castings	VP-DC-HT	762	V	1.5	◎	◎	○				
	铸件用零前角内冷油孔型 V Coated · for Die Castings · With Internal Coolant Supply	VO-DC-HT	762	V	1.5	◎	◎	◎				
	高硬度钢用 For High Strength Steels	EX-SH-HT	763		2.5	◎	◎			○	○	○
	高硬度钢用 For Hardened Steels (42-52 HRC)	V-XPM-HT	764	V	2.5	◎						
	硬质合金高硬度钢用直槽丝锥 Carbide Straight Fluted·for Hardened Steels (50HRC～)	VX-OT	766	V	3	◎						
	硬质合金高硬度钢(～55HRC)用 Carbide Straight Fluted·for Hardened Steels (～55HRC)	WH55-OT	765	WXS	2.5	◎						
	螺纹修补用 Spatter Remove Hand Tap	SR-HT	828		5	◎	○		◎	◎		◎
螺纹铣刀 PLANET CUTTER	One Revolution 螺纹铣刀 One Pass Thread Mill	AT-1	503～505	EgiAs		◎※2			◎	◎	◎	◎
	高硬度钢用带底刃螺纹铣刀2D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2D Type	AT-2	506	DUROREY	1	◎※3			○	○	○	
	高硬度钢用带底刃螺纹铣刀2.5D型 Thread Mill With End-Cutting Edge For High Hardness Steels 2.5D Type	AT-2	507	DUROREY	1	◎	◎		○	○	○	
	高硬度钢用带底刃螺纹铣刀锥管螺纹型 Thread Mill With End-Cutting Edge For High Hardness Steels Tapered Pipe Thread Type	AT-2	508	DUROREY	1	◎	◎		○	○	○	
	非铁金属用带底刃高效率螺纹铣刀 2D型 High-efficiency thread mill with end-cutting edge for non-ferrous materials 2D Type	AT-2 R-SPEC	509	DLC-IGUSS	2	◎※3						
	非铁金属用带底刃高效率螺纹铣刀 2.5D型 High-efficiency thread mill with end-cutting edge for non-ferrous materials 2.5D Type	AT-2 R-SPEC	510	DLC-IGUSS	2	◎	◎					
	硬质合金小径螺纹用螺纹铣刀 Carbide Small Diameter PLANET CUTTER	WH-VM-PNC	511	WXS		◎			○	○	○	○
	硬质合金钢用螺纹铣刀 Carbide PLANET CUTTER for Steels	WX-ST-PNC	512～513	WX		◎			○	◎	◎	◎
	硬质合金钢用内冷油孔螺纹铣刀 Carbide PLANET CUTTER for Steels with Internal Coolant Supply	WXO-ST-PNC	514	WX		◎			○	◎	◎	◎
	硬质合金非铁·耐热合金用螺纹铣刀 Carbide PLANET CUTTER for Nonferrous Metal and Heat-Resistant Alloy	WX-PNC	515～516	WX		◎			○			

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

1. 此表是丝锥在一般条件下的选择标准，根据使用条件的不同而改变。
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3. 经常检查加工的内螺纹的精度。

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

盲孔 Blind Hole

加工材料 Work Material																						
调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
					○	○		○		◎	◎	◎	○	○	◎	◎			○	
					○	○		○		○	○	○	○	○	○	○				
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									○	○	○		○	◎	○	○				
◎	◎	◎	○	○		○	○	○			◎		◎	◎	◎	◎	◎	◎	○	○
○	○			◎		○	○	○											○	○
○	○			◎		○	○	○											○	○
						○	○	○	○	○	○	○	◎	◎	○	○	◎	◎	◎	◎

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

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

丝锥选型基准表 TAP SELECTION CHART

盲孔 Blind Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number or Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 低碳素钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C 0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
螺纹铣刀 PLANET CUTTER	高速钢螺纹铣刀 HSS PLANET CUTTER	PNGT	519～520	TiN		◎			○	○	○	○
	硬质合金通用螺纹铣刀 Solid Carbide PLANET CUTTER	OT-PNGT	518	FX		◎			◎	◎	○	○
	硬质合金通用螺旋槽螺纹铣刀 Solid Carbide Spiral PLANET CUTTER	OT-SFT-PNGT	517	FX		◎			◎	◎	○	○
	复合加工用硬质合金内冷油孔超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling with Internal Coolant Supply	DR-O-PNAC	522	FX		◎※2						
	复合加工用硬质合金超级螺纹铣刀 Carbide Super-Planet Cutter for multifunction milling	DR-PNAC	521	FX		◎※2						
锥管螺纹丝锥 Taper Pipe Thread Taps	A-TAP丝锥 A-TAP	A-TPT	767、807	V	2.5	◎	◎		◎	◎	◎	◎
	A-TAP丝锥短螺纹型 A-TAP (Short Thread)	A-S-TPT	768、808	V	2.5	◎	○		◎	◎	◎	◎
	一般用 General Application	TPT	769~770、809~810		2.5	◎	◎			○	○	
	一般用短螺纹型 General Application (Short Thread)	S-TPT	770、809～810		2.5	◎	◎			○	○	
	一般用氧化处理 General Application (with OX)	H-TPT	771	氧化 OX	2.5	◎	◎		◎	○		○
	一般用短螺纹氧化处理 General Application (with OX, Short Thread)	H-S-TPT	771	氧化 OX	2.5	◎	◎		◎	○		○
	一般用长柄型 Long Shank·General Application	LT-TPT	772		2.5	○	○			○	○	
	一般用短螺纹长柄型 Long Shank·General Application (Short Thread)	LT-S-TPT	772		2.5	○	○			○	○	
	螺旋槽型 Spiral Fluted	SFT-TPT	773、811		2.5	◎	◎			○		○
	螺旋槽长柄型 Spiral Fluted (Long Thread)	SFT-S-TPT	773		2.5	◎	◎			○		○
	螺旋槽丝锥长柄型 Long Shank· Spiral	LT-SFT-TPT	774		2.5	◎	○			○		○
	螺旋槽丝锥短螺纹长柄型 Long Shank· Spiral(Short Thread)	LT-SFT-S-TPT	774		2.5	◎	○			○		○
	高硬度钢用 For High Strength Steels	V-XPM-TPT	775	V	3	◎						
	高硬度钢用锥管螺纹丝锥 Taper Pipe Thread Tap for Hardened Steel	VX-TPT	776	V	3	◎						
	TiN涂层 TiN coated	TIN-TPT	777	TiN	2.5	◎	◎		○	◎	◎	◎
	TiN涂层短螺纹型 TiN coated (Short Thread)	TIN-S-TPT	777	TiN	2.5	◎	◎		○	◎	◎	◎
	TIN涂层长柄型 TiN coated·Long Shank	TIN-LT-TPT	778	TiN	2.5	◎	◎		○	◎	◎	◎
	TIN涂层短螺纹长柄型 TiN coated·Long Shank (Short Thread)	TIN-LT-S-TPT	778	TiN	2.5	◎	◎		○	◎	◎	◎
	难加工材料用 For Difficult to Machine Materials	CPM-TPT	779		2.5	◎	○				◎	
	难加工材料用短螺纹型 For Difficult to Machine Materials(Short thread)	CPM-S-TPT	780		2.5	◎	○				◎	
	难加工材料用短螺纹长柄型 Long Shank· for Difficult to Machine Materials(Short thread)	CPM-LT-S-TPT	780		2.5	◎	○				◎	
	软钢用 For Mild Steels	STL-TPT	781	氧化 OX	2.5	◎	◎		◎	○		○
	软钢用短螺纹型 For Mild Steels (Short Thread)	STL-S-TPT	781	氧化 OX	2.5	◎	◎		◎	○		○
	内冷油孔型 With Internal Coolant Supply	OIL-TPT	782	氧化 OX	2.5	◎	◎		○	◎	○	◎
	V涂层铝合金用 For Aluminum Alloy	V-AL-TPT	782	V	2.5	◎	◎					
	铸铁用 For Cast Iron	EX-FC-TPT	783	氮化 N	2.5	◎	◎					
	硬质合金锥管螺纹丝锥 Carbide For Taper Pipe Threads	OT-TPT	784		2.5	◎	◎					
	硬质合金锥管螺纹丝锥短螺纹型 Carbide For Taper Pipe Threads (Short Thread)	OT-S-TPT	784		2.5	◎	◎					
	硬质合金锥管螺纹丝锥长柄型 Carbide Long Shank·for Taper Pipe Threads	OT-LT-TPT	785		2.5	◎	◎					
	不锈钢用 For Stainless Steels	EX-SUS-TPT	786	氧化 OX	2.5	◎	◎					
	不锈钢用短螺纹型 For Stainless Steels (Short Thread)	EX-SUS-S-TPT	786	氧化 OX	2.5	◎	◎					
	不锈钢用长柄型 Long Shank·for Stainless Steels	LT-SUS-TPT	787	氧化 OX	2.5	◎	◎					
	不锈钢用短螺纹长柄型 Long Shank·for Stainless Steels (Short Thread)	LT-SUS-S-TPT	787	氧化 OX	2.5	◎	◎					

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

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

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

盲孔 Blind Hole

加工材料 Work Material																						
调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
				○		○	○	○	○	○	○	○	○	○	○	○			○	○
○				○		○	◎	◎	○	◎	◎	○	◎	◎	◎	◎			○	○
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				◎					○											○

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

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

丝锥选型基准表 TAP SELECTION CHART

盲孔 Blind Hole

	名称 Type	丝锥记号 Symbol	登载页码 Page No.	表面处理 Surface Treatment	切削锥(牙数) Chamfer Length (Number of Threads)	有效攻丝长度 (D:丝锥大径) Effective Tapping length (D:Thread dia.) <1.5D	<2.5D	>2.5D	加工材料 Work Material 软碳素钢 Low Carbon Steel Mild Steel C ~0.25%	低碳素钢	中碳素钢 Medium Carbon Steel C 0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45%~	合金钢 Alloy Steel SCM
锥管螺纹丝锥 Taper Pipe Thread Taps	不锈钢用螺旋槽型 Spiral Fluted·for Stainless Steels	SUS-SFT-TPT	788	氧化 OX	2.5	◎	◎						
	不锈钢用螺旋槽短螺纹型 Spiral Fluted·for Stainless Steels (Short Thread)	SUS-SFT-S-TPT	788	氧化 OX	2.5	◎	◎						
	跳牙型 With Interupted Threads	EX-IRT	789、812	氧化 OX	2.5	◎	◎		○				
	跳牙短螺纹型 With Interrupted Threads (Short Thread)	EX-S-IRT	789	氧化 OX	2.5	◎	◎		○				
	跳牙长柄型 Long Shank·with Interrupted Threads	EX-LT-IRT	790	氧化 OX	2.5	◎	◎		○				
	跳牙短螺纹长柄型 Long Shank·with Interrupted Threads (Short Thread)	EX-LT-S-IRT	790	氧化 OX	2.5	◎	◎		○				
	TiN 涂层跳牙型 TiN coated with Interrupted Threads	TIN-IRT	791、812	TiN	2.5	◎	◎		○		○		
	TiN 涂层短螺纹型 TiN coated with Interrupted Threads (Short Thread)	TIN-S-IRT	791	TiN	2.5	◎	◎		○		○		
	TiN 涂层长柄型 TiN coated·Long Shank·with Interrupted Threads (Short Thread)	TIN-LT-S-IRT	791	TiN	2.5	◎	◎		○		○		
平行管螺纹丝锥 Parallel Pipe Thread Taps	A-TAP A-TAP	A-SPT	792、796、813	V	2.5	◎	◎		◎		◎	◎	◎
					1.5	◎	◎		◎		◎	◎	◎
	一般用 General Application	SPT	793~794、797~798、814		4	○	○				○		
	一般用长柄型 Long Shank·General Application	LT-SPT	794、799		4	○	○				○		
	螺旋槽型 Spiral Fluted	SFT-SPT	795、804		2.5	◎	○				◎		◎
	不锈钢用 For Stainless Steels	EX-SUS-SPT	795、801	氧化 OX	4	○	○						
	中径加大用 Over Size	EX-SPT	798		4	○	○				○		
	一般用氧化处理 General Application (with OX)	H-SPT	799	氧化 OX	4	○	○		◎		○		○
	TiN 涂层 TiN coated	TIN-SPT	800	TiN	4	○	○		○		◎	○	◎
	难加工材料用 For Difficult to Machine Materials	CPM-SPT	800		3	◎	○					◎	
	不锈钢用螺旋槽型 Spiral Fluted·for Stainless Steels	SUS-SFT-SPT	801	氧化 OX	2.5	◎	○						
	内冷油孔型 With Internal Coolant Supply	OIL-SPT	802	氧化 OX	4	◎	◎		◎		○	○	○
	NRT 型 Fluteless (Nu-Roll)	NRT-SPT	802	氧化 OX	2.5	◎	◎	◎	◎		○	○	○
	硬质合金平行管螺纹丝锥 Carbide For Parallel Pipe Threads	OT-SPT	803		3	◎	◎	○					
	硬质合金平行管螺纹丝锥长柄型 Carbide Long Shank·for Parallel Pipe Threads	OT-LT-SPT	803		3	◎	◎	○					
	螺旋槽丝锥长柄型 Long Shank· Spiral	LT-SFT-SPT	805		2.5	◎	○				◎		◎
嵌套螺纹用丝锥 Insert Screw Thread Taps	A-TAP A-TAP	A-SFT HL	815	V	2.5	◎	◎		○		◎	◎	○
					1.5	◎	◎		○		◎	◎	○
	A-TAP 长柄型 Long Shank·A-TAP	A-LT-SFT HL	816	V	2.5	◎	◎		○		◎	◎	○
	螺旋槽型 Spiral Fluted	EX-HL-SFT	817		2.5	◎	◎						
	螺旋槽长柄型 Long Shank·Spiral Fluted	HL-LT-SFT	817		2.5	◎	◎						
	直槽型 Straight Fluted	HL-HT	819~821		1.5	◎	○						
	直槽长柄型 Long Shank·Straight Fluted	HL-LT	822		1.5	◎	○						
	非铁用 NRT 丝锥 Fluteless (Nu-Roll)·for Non-Ferrous Metals	HL-B-NRT	823	氮化 N	2	◎	◎	◎					
	非铁用 NRT 丝锥长柄型 Long Shank·Fluteless (Nu-Roll)·for Non-Ferrous Metals	HL-LT-B-NRT	823	氮化 N	2	◎	◎	◎					
其他 Others	加工中心长柄型 Machining Center Taps (Long Shank)	EX-MCT	826	氧化 OX	3	◎	○		◎		◎	○	○
	加工中心用短刃型 Machining Center Taps (Normal Length)	EX-S-MCT	826	氧化 OX	3	◎	○		◎		◎	○	○

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

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

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

丝锥选型基准表 TAP SELECTION CHART

◎最适合丝锥 ◎Excellent ○适用的丝锥 ○Good

盲孔 Blind Hole

加工材料 Work Material																				
调质钢 Hardended Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermosetting Plastic	热可塑性塑料 Thermo-plastic
25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC			(酚醛树脂类) Bakelite Phenol	聚氯乙烯 Vinyl Chloride Nylon
				◎																
				◎																
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◎				○	○	○		○	○	○	○	○	○	○	○	○				
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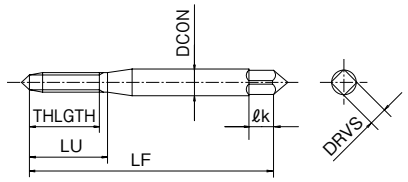
													◎	◎		◎				
						◎	○	○												
						◎	○	○												

4. 丝锥的精度不能保证内螺纹的精度。
5. 攻丝深度减去丝锥的切削锥部长度为有效螺纹长。
6. 此表以外的丝锥请联系OSG代理店。

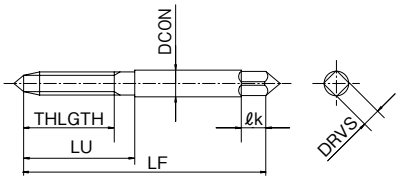
3. Always check the required thread limit for the internal thread.
4. TAP LIMIT does not guarantee thread limit for the internal thread after tapping.
5. Tapping depth minus chamfer length is an effective tapped thread length.
6. For other special-purpose taps, contact your nearest agent or distributor.

一般用SKS丝锥(J形) 库存尺寸表(公制螺纹) LIST OF JIS STANDARD STOCK ITEMS AND SIZES (METRIC)

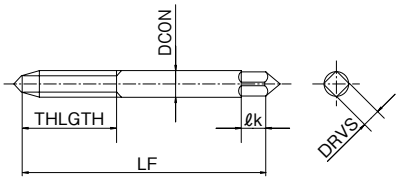
M1 ～ M2.2
M3
M4



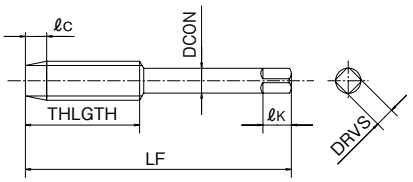
M2.3 ～ M2.6
M3.5
M4.5 ～ M5



M5.5 ～ M6



M7以上



尺寸 Thread size	形状 Dimensions					
	LF	THLGTH	LU	DCON	ℓk	DRVS
M 1 × 0.25	30	8	8.5	3	5	2.5
1.2 × 0.25	32	9	9.5	3	5	2.5
1.4 × 0.3	34	11	11.5	3	5	2.5
1.7 × 0.35	36	13	13.5	3	5	2.5
2 × 0.4	40	15	16	3	5	2.5
2.3 × 0.4	42	15	20	3	5	2.5
2.6 × 0.45	44	16	21	3	5	2.5
3 × 0.5	46	18	20	4	6	3.2
4 × 0.7	52	20	22	5	7	4
5 × 0.8	60	22	27	5.5	7	4.5
6 × 1	62	24	—	6	7	4.5

尺寸 Thread size	形状 Dimensions				
	LF	THLGTH	DCON	ℓk	DRVS
M 8 × 1.25	70	30	6.2	8	5
10 × 1.5	75	32	7	8	5.5
10 × 1.25					

HT的SKH 请参考 P.701 ～718。 HT(SKH), see p.701 ～718.

螺纹铣刀的3款辅助产品 3 Support Tools for Your Thread Milling Needs

3种工具实现

缩减调试时间

缩减加工时间

稳定刀具寿命

Reduce setup, machining time, and achieve stable tool life with these 3 support tools.

使用DCT，刀具半径的补偿更简单，寿命更稳定

Achieve Stable Tool Life with the DCT for Accurate Diameter Measurement

如果使用螺纹铣刀用 半径补偿工具(Diameter Correction Tool)

可将至今颇为困难的内螺纹孔口部的中径测量进行简单的数值化。

The internal thread effective diameter, which used to be difficult to determine, can now be measured with readable values.

基本式样 Specifications

结构上"测量部分＋筒套＋固定螺栓"三点。测定范围是内螺纹(6H)容许差100%～-50%，7个刻度。

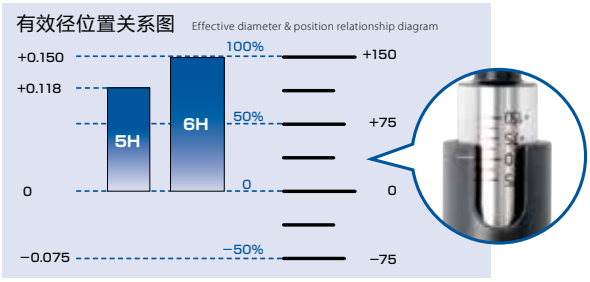
The DCT is made up of three components – the thread plug, scale sleeve and bolt for fixing the position. Measurable range from 100% ～-50% tolerance of thread size (6H); with 7 positions on the reading scale.

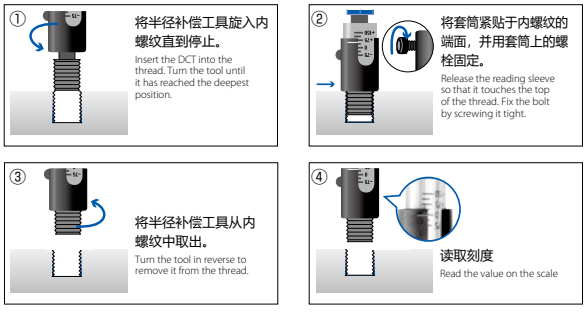
测定方法 Measuring Method

将半径补偿工具旋入内螺纹中，旋入停止后通过读取套筒上的刻度线位置，以此判断孔口部位内螺纹的中径尺寸。

Get the value of the effective diameter at a glance by simply inserting the DCT into the thread and releasing the scale sleeve once it has reached the deepest position (for the correction of value in step processing of thread milling).

例) M10×1的场合 Example: M10×1





※测量值仅供参考。判断内螺纹是否合格，请使用极限量规。
The reading value should be used as reference only. To inspect the screw thread please use the limit gauge.

※根据使用环境，本产品可能有不适用的场合。
Depending on work environment this product may not be applicable.

根据螺纹尺寸分类的刀具选定表 Tool Selection Guide by Screw Size

■公制内螺纹用 Metric screw thread (internal)

Page		P.503	P.506	P.509	P.511	P.512	P.514	P.515	P.517	P.518	P.519
		AT-1	AT-2	AT-2 R-SPEC	WH-VM-PNC	WX-ST-PNC	WXO-ST-PNC	WX-PNC	OT-SFT-PNGT	OT-PNGT	PNGT
螺距 Pitch	最小加工径 Min. Processing Dia.	One Revolution 螺纹铣刀 One Pass Thread Mill	高硬度钢用带底刃 Thread Mill with End-cutting Edge for High-hardness Steels	非铁金属用带底刃 高效率 High-efficiency thread mill with end-cutting edge for non-ferrous metals	小径 Small Dia.	钢用 for Steel	内冷油孔钢用 for Steel with Internal Coolant Supply	非铁·耐热合金用 for Nonferrous Metal · Heat-Resistant Alloy	通用螺旋槽 General Purpose Spiral	通用 General Purpose	高速钢 HSS
P0.25	M 1				3900495						
	M 1.2				3900496						
P0.3	M 1.4				3900497						
P0.35	M 1.6				3900498						
	M 1.7				3900499						
P0.4	M 2				3900500						
P0.45	M 2.5				3900501						
P0.5	M 3		8331200, 8331207	8331220, 8331227	3900502						
	M 8	8331002					8304710	3900009			
	M 14	8331012				8305736	8304740	3900036			
P0.7	M 4		8331201, 8331208	8331221, 8331228	3900503						
P0.75	M 6	8331000					8304700	3900000			
	M 14	8331013				8305741	8304741	3900041			
P0.8	M 5		8331202, 8331209	8331222, 8331229	3900504						
P1.0	M 6	8331001	8331203, 8331210	8331223, 8331230			8304701	3900001			
	M 8	8331003					8304711	3900011			
	M 10	8331005					8304721	3900021			
	M 12	8331008									
	M 14	8331014					8304742	3900042			8306012
	M 16	8331017					8304752	3900052			8306022
	M 20										8306032
	M 27										8306042
	M 34										8306052
P1.25	M 8	8331004	8331204, 8331211	8331224, 8331231			8304712	3900012			
	M 10	8331006									
	M 12	8331009				8305732	8304732	3900032	8306532	8306232	
P1.5	M 10	8331007	8331205, 8331212	8331225, 8331232			8304723	3900023			
	M 12	8331010					8304733	3900033			
	M 14	8331015					8304743	3900043			8306013
	M 16	8331018					8304753	3900053			8306023
	M 20	8331021					8304773	3900073		8306273	8306033
	M 24	8331023					8304783				
	M 27							3900083	8306583		8306043
	M 34										8306053
	M 42										8306063
P1.75	M 12	8331011	8331206, 8331213	8331226, 8331233			8304734	3900034	8306534		
P2.0	M 14	8331016					8304744	3900044	8306544		
	M 16	8331019	8331240, 8331243				8304754	3900054	8306554		8306024
	M 20										8306034
	M 24	8331024				8305784	8304784				
	M 27							3900084	8306584	8306285	8306044
	M 34										8306054
	M 42										8306064
P2.5	M 18	8331020	8331241, 8331244			8305765		3900065			
	M 20	8331022	8331242, 8331245			8305775	8304775	3900075	8306575	8306276	8306035
P3.0	M 20										8306036
	M 24	8331025					8304786				
	M 27							3900086	8306586	8306287	8306046
	M 34										8306056
	M 42										8306066
P3.5	M 27										8306047

根据螺纹尺寸分类的刀具选定表 Tool Selection Guide by Screw Size

■美制内螺纹用 Unified screw thread (internal)

Page		P.504	P.506	P.511	P.512	P.515
牙数 TPI	最小加工径 Min. Processing Dia.	AT-1	AT-2	WH-VM-PNC	WX-ST-PNC	WX-PNC
32	No.8		8331246, 8331254	3900513		
	5/16	8331030				
	3/8	8331033				
28	1/4	8331027	8331249, 8331257		8305801	3900351
	1/2	8331038				
24	No.10		8331247, 8331255			
	5/16	8331029			8305806	3900356
	3/8	8331032			8305811	3900361
	5/8	8331043				
20	1/4	8331026	8331248, 8331256		8305800	3900350
	7/16	8331035			8305816	3900366
	1/2	8331037			8305821	3900371
	1	8331049				
18	5/16	8331028	8331250, 8331258		8305805	3900355
	9/16	8331040			8305830	3900380
	5/8	8331042				
16	3/8	8331031	8331251, 8331259		8305810	3900360
	3/4	8331045				
14	7/16	8331034	8331252, 8331260		8305815	3900365
	7/8	8331047				
13	1/2	8331036	8331253, 8331261		8305820	3900370
12	9/16	8331039			8305825	3900375
	7/8				8305840	3900390
11	5/8	8331041			8305832	3900382
10	3/4	8331044			8305835	3900385
9	7/8	8331046			8305838	3900388
8	1	8331048			8305842	3900392

■管螺纹用：R(PT)・Rc(PT) Pipe screw thread

Page		P.505	P.508	P.513	P.516	P.518	P.520
牙数 TPI	适用加工尺寸 Range of Thread Size	AT-1	AT-2	WX-ST-PNC	WX-PNC	OT-PNGT	PNGT
28	1/16	8331075	8331214		3900199		
	1/8	8331075, 8331076	8331215		3900199, 3900201		
19	1/4	8331077	8331216		3900211		
	3/8	8331077, 8331078	8331217	8305912	3900211, 3900212		8306111
14	1/2	8331079	8331218		3900214		8306114
	3/4	8331079, 8331080			3900214, 3900215	8306316	8306114, 8306115
11	1	8331081	8331219		3900218		8306118
	1 1/4						8306118
	1 1/2						8306118, 8306119
	2						8306118, 8306119

■管螺纹用：Rp(PS)・G(PF) Pipe screw thread

螺纹种类		Rp(PS)・G(PF)				Rp(PS)	G(PF)
Page		P.505	P.513	P.516	P.518	P.520	
牙数 TPI	适用加工尺寸 Range of Thread Size	AT-1	WX-ST-PNC	WX-PNC	OT-PNGT	PNGT	
28	1/16	8331082	8305949	3900299			
	1/8	8331082, 8331083	8305949, 8305951	3900299, 3900301			
19	1/4	8331084	8305961	3900311			
	3/8	8331084, 8331085	8305961, 8305962	3900311, 3900312	8306410	8306121	8306131
14	1/2	8331086	8305964	3900314		8306124	8306134
	5/8	8331086	8305964	3900314		8306124	8306134
	3/4	8331086, 8331087	8305964, 8305965	3900314, 3900315		8306124, 8306125	8306134, 8306135
	7/8	8331086, 8331087	8305964, 8305965	3900314, 3900315		8306124, 8306125	8306134, 8306135
11	1	8331088	8305968	3900318		8306128	8306138
	1 1/8					8306128	8306138
	1 1/4					8306128	8306138
	1 1/2					8306128, 8306129	8306138, 8306139
	1 3/4					8306128, 8306129	8306138, 8306139
	2					8306128, 8306129	8306138, 8306139

■管螺纹用：NPT Pipe screw thread

Page		P.505	P.508	P.513	P.516
牙数 TPI	适用加工尺寸 Range of Thread Size	AT-1	AT-2	WX-ST-PNC	WX-PNC
27	1/16	8331089	8331234	8305859	3900259
	1/8	8331089, 8331090	8331235		
18	1/4	8331091	8331236	8305861	3900261
	3/8	8331091, 8331092	8331237		
14	1/2	8331093	8331238	8305865	3900265
	3/4				
11½	1	8331094	8331239	8305868	3900268
	1 1/4				
	1 1/2				
	2				

G-LIST No. | GG1008

螺纹铣刀用径补偿工具

DIAMETER CORRECTION TOOL FOR THREAD MILLS

DCT75

TiN

螺纹种类：M・MJ

单位:mm Unit:mm

商品号 EDP No.	尺寸 Thread Size	螺纹长 THLGTH	盲孔可测定深度(mm) Measurable Depth (mm) in Blind Hole	柄径 DCON	锥度 Taper	推荐高度规 Height Master Recommended	重量 (g)	库存 Stock
9342019	M6 × 1	6.2	6.2 ～	φ 10	1/25	⑧	30	
9342020	M8 × 1.25	7.3	7.3 ～	φ 10	1/25	⑧	32	
9342021	M8 × 1	6.2	6.2 ～	φ 10	1/25	⑧	32	
9342022	M10 × 1.5	8.3	8.3 ～	φ 10	1/25	⑦	34	
9342023	M10 × 1.25	7.3	7.3 ～	φ 10	1/25	⑦	34	●
9342024	M10 × 1	6.2	6.2 ～	φ 10	1/25	⑦	33	
9342025	M12 × 1.75	9.7	9.7 ～	φ 12	1/25	⑦	42	
9342026	M14 × 1.5	8.7	8.7 ～	φ 14	1/25	⑦	56	
9342027	M16 × 1.5	8.7	8.7 ～	φ 16	1/25	⑦	67	

1. 以上是已经设定为可测定6H精度的形状，所以在4H,5H,JIS Ⅰ,JIS Ⅱ中也可使用。
2. 内螺纹是盲孔的情况下，要确认内螺纹长度要比DCT75的螺纹要长。
3. 内螺纹中外径超过+1.5mm的倒角·沉孔时，需选定高度规。详情请咨询当地销售。

1. Since it is made to measure class 6H, it can also be used as is for 4H, 5H, JIS I and JIS II.
2. If the internal thread is a blind hole, please confirm that the internal thread length is longer than the screw length of the DCT75.
3. The selection of the Height Master is required if the nominal diameter of the internal thread has a chamfer or counterbore over 1.5mm. Please consult with your local sales representative.

螺纹种类：U・UNJ

单位:mm Unit:mm

商品号 EDP No.	尺寸 Thread Size	螺纹长 THLGTH	盲孔可测定深度(mm) Measurable Depth (mm) in Blind Hole	柄径 DCON	锥度 Taper	推荐高度规 Height Master Recommended	重量 (g)	库存 Stock
9342028	1/4 - 20 UNC	7	7 ～	φ 10	1/25	⑧	30	
9342029	1/4 - 28 UNF	5	5 ～	φ 10	1/25	⑧	30	
9342030	5/16 - 18 UNC	7.8	7 ～	φ 10	1/25	⑧	32	
9342031	5/16 - 24 UNF	7	7 ～	φ 10	1/25	⑧	32	
9342032	5/16 - 32 UNEF	5	5 ～	φ 10	1/25	⑧	32	
9342033	3/8 - 16 UNC	8.8	8.8 ～	φ 10	1/25	⑦	34	●
9342034	3/8 - 24 UNF	7	7 ～	φ 10	1/25	⑦	34	
9342035	7/16 - 14 UNC	10	10 ～	φ 12	1/25	⑦	41	
9342036	7/16 - 20 UNF	7	7 ～	Φ 12	1/25	⑦	41	
9342037	1/2 - 13 UNC	10.8	10.8 ～	φ 13	1/25	⑦	48	
9342038	1/2 - 20 UNF	7	7 ～	φ 13	1/25	⑦	47	

1. 以上是已经设定为可测定2B精度的形状，所以在3B中也可使用。
2. 内螺纹是盲孔的情况下，要确认内螺纹长度要比DCT75的螺纹要长。
3. 内螺纹中外径超过+1.5mm的倒角·沉孔时，需选定高度规。详情请咨询当地销售。

1. Since it is made to measure class 2B, it can also be used as is for 3B.
2. If the internal thread is a blind hole, please confirm that the internal thread length is longer than the screw length of the DCT75.
3. The selection of the Height Master is required if the nominal diameter of the internal thread has a chamfer or counterbore over 1.5mm. Please consult with your local sales representative.

螺纹种类：R(PT)

单位:mm Unit:mm

商品号 EDP NO.	尺寸 Thread Size	螺纹长 THLGTH	柄径 DCON	锥度 Taper	推荐高度规 Height Master Recommended	重量 (g)	库存 Stock
9342039	R (PT) 1/16	6.01	φ 10	1/16	⑨	31	
9342040	R (PT) 1/8	6.01	φ 10	1/16	⑨	33	●
9342041	R (PT) 1/4	9.02	φ 14	1/16	⑨	53	
9342042	R (PT) 3/8	9.36	φ 17	1/16	⑨	77	

1. R螺纹，PT螺纹的内螺纹精度相同，使用哪种都可以。
2. DCT75的螺纹部的切口形状是配合PT锥管螺纹用塞规形状来设定的，所以各部制作公差是根据DCT75标准形状设定的。
3. 内螺纹沉孔加工或特殊式样的螺纹量规判定是否合格的情况下，请咨询当地销售。

1. Since the internal thread class is the same for R screw and PT screw, it can be used for both.
2. Although the DCT75's screw and notch portions are shaped based on the PT internal thread taper plug gauge, each part tolerance is based on the DCT75's original specification.
3. In the case where there is a counterbore in the internal thread or if you need to make a pass / fail judgment with a special thread gauge, please consult with your local sales representative.

也可定制非标品。详细请咨询本公司销售人员。

Special tool available. Please contact your sales representative for details.

●=标准库存品 ●=Standard stock item.

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

■数字显示器 Digital Indicator

单位:mm Unit:mm

商品号 EDP NO.	对应尺寸 Applicable Size	套筒外径 Sleeve Dia.	套筒孔径 Sleeve Hole Dia.	对应锥度 Applicable Taper	库存 Stock
9342052	M6 ～ M16	φ 23.5	φ 17.5	1/25	●
	U¼ ～ ½				
9342053	R (PT) 1/16 ～ ⅜	φ 23.5	φ 17.5	1/16	

1. 在确认内螺纹形状，套筒外径，孔径后，请确认内螺纹孔口部的形状。
2. 数字显示部分是采用已经预加载DCT75专用程序的三丰制电子读表器。

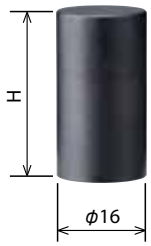
※DCT75及高度规请务必以套装形式购买。

1. After confirming the shape of the internal thread, the sleeve's outer diameter and the hole diameter, please confirm the shape of the internal thread's entrance where the sleeve is fitted against.
2. The digital unit uses the Digimatic Indicator manufactured by Mitutoyo, paired with programs exclusively made for the DCT75.

※Please be sure to purchase the DCT75 and the Height Master as a set.

■高度规 Height Master

单位:mm Unit:mm



	商品号 EDP No.	尺寸(H) Size	库存 Stock
①	9342043	28	
②	9342044	28.25	
③	9342045	28.5	
④	9342046	28.75	
⑤	9342047	29	●
⑥	9342048	29.25	
⑦	9342049	29.5	
⑧	9342050	29.75	
⑨	9342051	30	

1. 材质：钢 50~55HRC
2. H部容许差：±0.015

※DCT75及数字显示器请务必以套装形式购买。

1. Material: Steel 50 - 55 HRC
2. Tolerance of H : ±0.015

※Please be sure to purchase the DCT75 and the digital display unit as a set.

ThreadPro

NC编程软件
Thread Milling NC Code Generator Software

※详细请参考 P.540
See p.540 for details

操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

●=标准库存品 ●=Standard stock item.

G-LIST No. | GG1007

螺纹铣刀用径补偿工具

DIAMETER CORRECTION TOOL FOR THREAD MILLS

DCT

6H用带刻度 for 6H with scale

商品号 EDP No.	尺寸 Thread Size	螺纹长 THLGTH	盲孔可测定深度(mm) Measurable Depth (mm) in Blind Hole	套筒外径 Sleeve Dia.	重量 (g)	库存 Stock
9342000	M6 × 1 — 1.5D	9	9～	φ 13	72	
9342001	M8 × 1.25 — 1.5D	12	12～	φ 13	76	
9342002	M8 × 1 — 1.5D	12	12～	φ 13	76	
9342003	M10 × 1.5 — 1.2D	12	12～	φ 15	86	
9342004	M10 × 1 — 1.2D	12	12～	φ 15	87	
9342005	M12 × 1.75 — 1.2D	14.4	14.4～	φ 17	135	
9342006	M12 × 1.5 — 1.2D	14.4	14.4～	φ 17	136	
9342007	M12 × 1.25 — 1.2D	14.4	14.4～	φ 17	136	
9342008	M14 × 2 — 1.2D	16.8	16.8～	φ 19	155	
9342009	M14 × 1.5 — 1.2D	16.8	16.8～	φ 19	156	●
9342010	M14 × 1 — 1.2D	16.8	16.8～	φ 19	158	
9342011	M16 × 2 — 1 D	16	16～	φ 21	226	
9342012	M16 × 1.5 — 1 D	16	16～	φ 21	220	
9342013	M18 × 2.5 — 1 D	18	18～	φ 23	262	
9342014	M18 × 1.5 — 1 D	18	18～	φ 23	257	
9342015	M20 × 2.5 — 1 D	20	20～	φ 25	344	
9342016	M20 × 1.5 — 1 D	20	20～	φ 25	347	
9342017	M24 × 3 — 1 D	24	24～	φ 29	415	

1. 刻度径超过+1mm 倒角时，套筒外径以下的沉孔需要用非标品对应。
2. 5H、2级、1级内螺纹也可使用。
3. 内螺纹是盲孔的情况下，要确认内螺纹长度要比DCT 的螺纹要长。

1. Customization is required for chamfer exceeding thread size + 1 mm and counterboring applications with a diameter less than the scale sleeve.
2. Accommodates 5H, 2 and 1 classes of fit.
3. If the internal thread is a blind hole, please confirm that the internal thread length is longer than the screw length of the DCT.

3B用带刻度 for 3B with scale

商品号 EDP No.	尺寸 Thread Size	螺纹长 THLGTH	盲孔可测定深度(mm) Measurable Depth (mm) in Blind Hole	套筒外径 Sleeve Dia.	重量 (g)	库存 Stock
9342018	5/16—24UNJF—1.5D	11.9	11.9～	φ 13	74	D

1. 刻度径超过+1mm 倒角时，套筒外径以下的沉孔需要用非标品对应。
2. 内螺纹是盲孔的情况下，要确认内螺纹长度要比DCT 的螺纹要长。

1. Customization is required for chamfer exceeding thread size + 1 mm and counterboring applications with a diameter less than the scale sleeve.
2. If the internal thread is a blind hole, please confirm that the internal thread length is longer than the screw length of the DCT.

ThreadPro

NC编程软件
Thread Milling NC Code Generator Software

※详细请参考 P.540
See p.540 for details

操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

●=标准库存品 ●=Standard stock item.

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

NC 编程软件 ThreadPro

Revamped Thread Milling NC Code Generator Software "ThreadPro"

使用NC螺纹铣刀编程软件「ThreadPro」，任何操作者都能简单容易的编制程序。
即使是没有电脑的外出目的地，也可使用智 能手机或平板电脑进行访问。

Generate codes for complex machining couldn't be easier. Create machining programs at ease with OSG's revamped NC code generator software ThreadPro. ThreadPro can be accessed via smartphones and PC tablets even when you are on the road without a computer.

使用DCT，刀具半径的补偿更简单，寿命更稳定

Achieve Stable Tool Life with the DCT75 for Accurate Diameter Measurement

螺纹铣刀用半径补偿工具使至今颇为困难的内螺纹孔口部的中径测量也可以简单的数值化。

The internal thread effective diameter, which used to be difficult to determine, can now be measured with readable values.

加工时有没有这样的烦恼?

Troubled by the following problems?

半径补偿值的误差调整。 使调试加工次数增加， 延长生产准备时间。

因内螺纹孔口部的中径数值可以测量，所以调试切削次数可以大幅减少，调试时间缩短。并且，DCT的测量范围包括中径负偏差，所以即使螺纹通规无法通过时，也可测量螺纹中径。

Unsure of diameter correction value. Increase passes which results in longer setup time.

Visibility of internal thread pitch diameter at entry enables the reduction of passes to minimize setup time significantly. Moreover, the DCT is able to measure pitch diameter smaller than the tolerance limit. The DCT can measure the pitch diameter of the female internal thread even if it does not fit into the Go-Gauge.

半径补偿错误， 内螺纹加工精度不良 （螺纹塞规止规不止）。

因内螺纹孔口部的中径数值可以测量，可以准确的进行半径补偿，以此有效降低工件的不良率。

An incorrect diameter correction that result in a defective internal thread (gauge-out).

Visibility of internal thread pitch diameter at entry enables reliable diameter corrections. The DCT is useful for reducing defective workpieces.

刀具寿命不稳定。

因内螺纹孔口部的中径数值可见化，可以使刀具更换后的内螺纹中径基本一致。通过使起始位置相同，目标位置（刀具寿命）也一致，实现刀具寿命的稳定化。

Unstable tool life

Digitized measurement ensures consistent internal thread pitch diameters after tool changes. The same starting and finishing position ensures consistent and stable tool life.

通过半径补偿工具DCT 就可以解决

Solve them with the Diameter Correction Tool (DCT)

DCT (P.501)

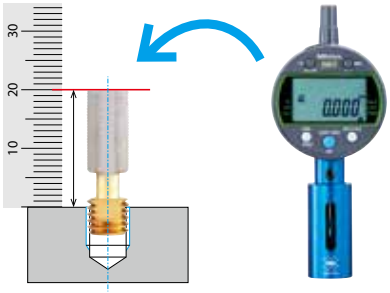
在有效测量范围内目测判断

Simple measurement of pitch diameter by visual judgment

DCT75 (P.499)

简易经济型
通过实测与计算确定测量值

Low-cost type
Measurement and calculation system



高性能型
数码显示

High-performance type
Digital display system

数码显示表与简易经济型结合后可以自动显示测量数值

Eliminate measurement and calculation with the combination of a digital display.

G-LIST No. | TW1033

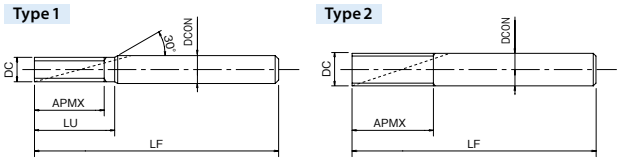
One Revolution 螺纹铣刀

ONE PASS THREAD MILL

The A Brand

AT-1

切削条件 Cutting Conditions | P.844



CARBIDE | EgiAs | 9～13° | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8331000	M 6	0.75	4.5	75	13.5	16	6	4	1	●	26
8331001		1			14					●	26
8331002	M 8	0.5	5.7	75	17	–	6		2	●	28
8331003		1			18					●	27
8331004		1.25			18.75					●	27
8331005	M10	1	7.7	85	22	–	8		2	●	54
8331006		1.25			22.5					●	53
8331007		1.5			24					●	52
8331008	M12	1	9.7	100	26	–	10		2	●	99
8331009		1.25			27.5					●	98
8331010		1.5			27					●	98
8331011		1.75			28					●	97
8331012	M14	0.5	11.7	120	29	–	12	5	2	●	177
8331013		0.75			30					●	176
8331014		1								●	175
8331015		1.5	10.7		31.5	34.5			1	●	166
8331016		2	9.7	100	32	–	10		2	●	93
8331017	M16	1	13.7	135	34	39	16		1	●	329
8331018		1.5			36					●	324
8331019		2	11.7	120		–	12		2	●	168
8331020	M18	2.5	11.7	120	42.5	–	12		2	●	162
8331021	M20	1.5	15.7	135	43.5	–	16		2	●	337
8331022		2.5	13.7		45	50			1	●	306
8331023	M24	1.5	19.7	150	51	–	20	6	2	●	575
8331024		2			52					●	566
8331025		3			54					●	558

AT-1 (M) 为内螺纹加工专用。
1. ThreadPro 的路径类型请选择"多刃同时进给"。

AT-1 (M) is only for milling internal threads.
1. Please select "stairs" for the path type in ThreadPro.

ThreadPro
NC编程软件
Thread Milling NC Code Generator Software
※详细请参考 P.540
See p.540 for details
操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
AT-1	◎	◎	◎	◎	○	○			◎		◎	◎	◎	○	○	○	○	◎	◎	◎	◎			○	○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

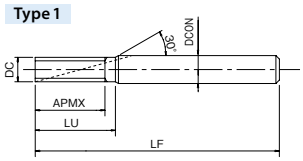
One Revolution 螺纹铣刀

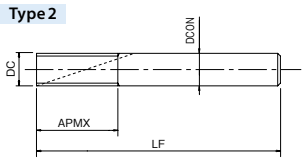
ONE PASS THREAD MILL

The A Brand

AT-1

切削条件 Cutting Conditions | P.844





CARBIDE | EgiAs | 9~13° | SHANK h6

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8331026	1/4	20	4.55	75	15.24	17.7	6	4	1	●	26
8331027		28			15.42	17.2				●	26
8331028	5/16	18	5.7	75	19.75	–	6		2	●	27
8331029		24			19.04					●	27
8331030		32			17.47					●	28
8331031	3/8	16	6.7	85	22.23	25.4	8		1	●	50
8331032		24			22.22	24.3				●	50
8331033		32			20.64	22.2				●	52
8331034	7/16	14	7.7	85	27.21	–	8		2	●	50
8331035		20			25.40					●	52
8331036	1/2	13	8.7	100	29.31	33.2	10	5	1	●	88
8331037		20			27.94	30.4				●	91
8331038		28			28.12	29.9				●	92
8331039	9/16	12	9.7	100	33.87	–	10		2	●	94
8331040		18			32.45					●	96
8331041	5/8	11	10.7	120	36.94	41.5	12		1	●	157
8331042		18			35.28	38.1				●	164
8331043		24			34.91	37				●	167
8331044	3/4	10	11.7	120	43.18	–	12		2	●	162
8331045		16			41.29					●	166
8331046	7/8	9	13.7	135	50.80	56.4	16		1	●	297
8331047		14			48.98	52.6				●	305
8331048	1	8	18.7	150	57.15	63.5	20	6	1	●	536
8331049		20			53.34	55.8				●	559

AT-1 (U,UNJ) 为内螺纹加工专用。
1. ThreadPro 的路径类型请选择"多刃同时进给"。

AT-1 (U,UNJ) is only for milling internal threads.
1. Please select "stairs" for the path type in ThreadPro.

螺纹铣刀用径补偿工具

Diameter Correction Tool for Thread Mills

※详细请参考 ▶P.496或499
See p.496 or 499 for details

使用DCT75可将孔口部中径数值化，使径补偿变得简单。

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
AT-1	◎	◎	◎	◎	○	○			◎		◎	◎	◎	○	○	○	○	◎	◎	◎	◎			○	○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1033

One Revolution 螺纹铣刀

ONE PASS THREAD MILL

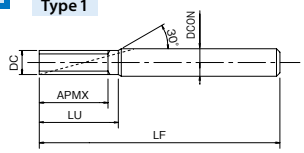
The A Brand

AT-1

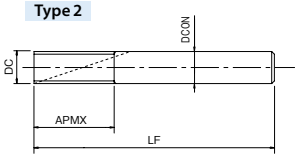
切削条件 Cutting Conditions | P.844

CARBIDE | EgiAs | 9~13° | SHANK h6

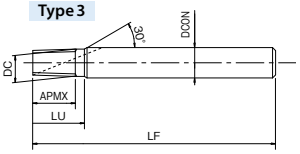
Type 1



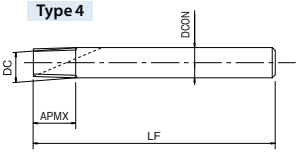
Type 2



Type 3



Type 4



螺纹种类：R(PT) , Rc(PT)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8331075	1/16 · 1/8	28	5.67	60	9.1	–	6	4	4	●	22
8331076	1/8	28	7.67	60	9.1	–	8		4	●	48
8331077	1/4 · 3/8	19	9.67	75	14.7	–	10	5	4	●	81
8331078	3/8	19	11.67	85	14.7	–	12		4	●	125
8331079	1/2 · 3/4	14	11.67	85	20	–	12		4	●	119
8331080	3/4	14	15.67	95	20	–	16		4	●	242
8331081	1~2	11	19.67	105	27.7	–	20	6	4	●	412

1. ThreadPro的路径类型请选择"多刃同时进给"。

1. Please select "stairs" for the path type in ThreadPro.

螺纹种类：Rp(PS) , G(PF)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8331082	1/16 · 1/8	28	5.67	60	11.8	–	6	4	2	●	22
8331083	1/8	28	7.67	65	14.5	–	8		2	●	41
8331084	1/4 · 3/8	19	9.67	80	20.1	–	10	5	2	●	80
8331085	3/8	19	11.67	100	25.4	–	12		2	●	144
8331086	1/2 ~ 7/8	14	11.67	100	32.7	–	12		2	●	137
8331087	3/4 · 7/8	14	15.67	115	39.9	–	16		2	●	281
8331088	1~2	11	19.67	130	50.8	–	20	6	2	●	483

1. ThreadPro的路径类型请选择"多刃同时进给"。

1. Please select "stairs" for the path type in ThreadPro.

螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8331089	1/16 · 1/8	27	5.67	60	10.35	–	6	4	4	●	22
8331090	1/8	27	7.67	60	10.35	–	8		4	●	22
8331091	1/4 · 3/8	18	9.67	75	15.52	–	10	5	4	●	75
8331092	3/8	18	11.67	85	15.52	–	12		4	●	124
8331093	1/2 · 3/4	14	15.67	95	19.96	–	16		4	●	244
8331094	1~2	11½	18.72	105	24.3	28.7	20	6	3	●	402

1. ThreadPro的路径类型请选择"多刃同时进给"。

1. Please select "stairs" for the path type in ThreadPro.

ThreadPro

NC编程软件
Thread Milling NC Code Generator Software

※详细请参考 P.540
See p.540 for details

操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
AT-1	◎	◎	◎	◎	○	○			◎		◎	◎	◎	○	○	○	○	◎	◎	◎	◎			○	○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1034 NEW

高硬度钢用带底刃螺纹铣刀 2D型

THREAD MILL WITH END-CUTTING EDGE FOR HIGH-HARDNESS STEELS 2D TYPE

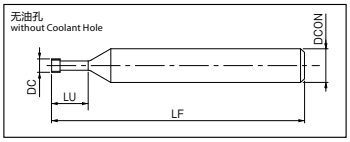
The A Brand

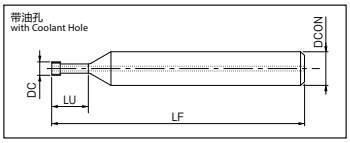
AT-2

切削条件 Cutting Conditions | P.845

因为是左刃，所以请主轴逆转使用。
Spindle rotation must be counterclockwise due to the left-hand cut configuration.

CARBIDE | DURAREY | SHANK h6





螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	直径 Thread Size	最大加工径※1 Max. Processing Dia.	外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331200	M 3×0.5	4.2	2.4	50	6	7.2	6	4	—	●	17
8331201	M 4×0.7	5.3	3.1	50	8	9.7	6		—	●	17
8331202	M 5×0.8	7	4	50	10	12	6		—	●	17
8331203	M 6×1	8	4.6	50	12	14.5	6		—	●	17
8331204	M 8×1.25	10.9	6.2	70	16	19.1	10		—	●	64
8331205	M10×1.5	13.2	7.5	70	20	23.7	10		Yes	●	63
8331206	M12×1.75	15.9	9	80	24	28.3	10		Yes	●	75
8331240	M16×2	21.1	11.7	100	32	37	12		Yes	○	141
8331241	M18×2.5	25.1	14	135	36	42.2	16		Yes	○	329
8331242	M20×2.5	28.5	15.7	135	40	46.2	16		Yes	○	340

AT-2为内螺纹加工专用。
1. ThreadPro 的路径类型请选择“单刃进给”
※1. 螺旋铣孔和螺纹铣削同时加工时的最大值。
加工超过最大加工径的内螺纹尺寸时，请进行底孔加工。

AT-2 is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.
※1. This is the maximum value when helical drilling and threading take place at the same time. Please make a pre-drilled hole when machining an internal thread size that exceeds the maximum processing diameter.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	直径 Thread Size	最大加工直径※1 Max. Processing Dia.	外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331246	No. 8 - 32UNC	5.2	3.1	50	8.33	10.3	6	4	—	○	17
8331247	No.10 - 24UNC	6.1	3.7	70	9.65	12.2	6		—	○	26
8331248	1/4 - 20UNC	7.6	4.55	70	12.7	15.8	6		—	○	26
8331249	1/4 - 28UNF	8	4.55	70	12.7	14.9	6		—	○	26
8331250	5/16 - 18UNC	9.7	5.7	80	15.88	19.4	10		—	○	74
8331251	3/8 - 16UNC	11.6	6.7	80	19.05	23	10		—	○	73
8331252	7/16 - 14UNC	13.3	7.7	80	22.22	26.7	10		Yes	○	73
8331253	1/2 - 13UNC	16.2	9.2	80	25.4	30.2	10		Yes	○	74

AT-2为内螺纹加工专用。
1. ThreadPro 的路径类型请选择“单刃进给”
※1. 螺旋铣孔和螺纹铣削同时加工时的最大值。
加工超过最大加工径的内螺纹尺寸时，请进行底孔加工。

AT-2 is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.
※1. This is the maximum value when helical drilling and threading take place at the same time. Please make a pre-drilled hole when machining an internal thread size that exceeds the maximum processing diameter.

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

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TW1034 NEW

高硬度钢用带底刃螺纹铣刀 2.5D型

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

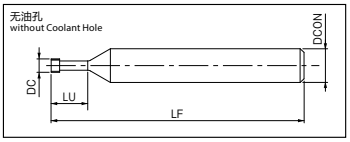
The A Brand

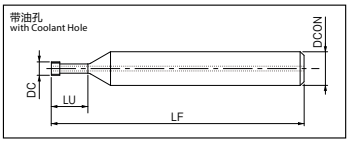
AT-2

切削条件 Cutting Conditions | P.845

因为是左刃，所以请主轴逆转使用。
Spindle rotation must be counterclockwise due to the left-hand cut configuration.

CARBIDE | DURAREY | SHANK h6





螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	加工径 Thread Size	最大加工径※1 Max. Processing Dia.	外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331207	M 3×0.5	4.2	2.4	50	7.5	8.7	6	4	–	●	17
8331208	M 4×0.7	5.3	3.1	50	10	11.7	6		–	●	17
8331209	M 5×0.8	7	4	50	12.5	14.5	6		–	●	17
8331210	M 6×1	8	4.6	50	15	17.5	6		–	●	16
8331211	M 8×1.25	10.9	6.2	70	20	23.1	10		–	●	59
8331212	M10×1.5	13.2	7.5	70	25	28.7	10		Yes	●	59
8331213	M12×1.75	15.9	9	80	30	34.3	10		Yes	●	72
8331243	M16×2	21.1	11.7	100	40	45	12		Yes	○	138
8331244	M18×2.5	25.1	14	135	45	51.2	16		Yes	○	316
8331245	M20×2.5	28.5	15.7	135	50	56.2	16		Yes	○	330

AT-2为内螺纹加工专用。
1. ThreadPro的路径类型请选择"单刃进给"
※1. 螺旋铣孔和螺纹铣削同时加工时的最大值。
加工超过最大加工径的内螺纹尺寸时，请进行底孔加工。

AT-2 is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.
※1. This is the maximum value when helical drilling and threading take place at the same time. Please make a pre-drilled hole when machining an internal thread size that exceeds the maximum processing diameter.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	加工径 Thread Size	最大加工径※1 Max. Processing Dia.	外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331254	No. 8 - 32UNC	5.2	3.1	50	10.42	12.4	6	4	–	○	16
8331255	No.10 - 24UNC	6.1	3.7	70	12.07	14.7	6		–	○	25
8331256	1/4 - 20UNC	7.6	4.55	70	15.88	19	6		–	○	25
8331257	1/4 - 28UNF	8	4.55	70	15.88	18.1	6		–	○	26
8331258	5/16 - 18UNC	9.7	5.7	80	19.85	23.3	10		–	○	71
8331259	3/8 - 16UNC	11.6	6.7	80	23.81	27.7	10		–	○	69
8331260	7/16 - 14UNC	13.3	7.7	80	27.78	32.3	10		Yes	○	67
8331261	1/2 - 13UNC	16.2	9.2	80	31.75	36.6	10		Yes	○	70

AT-2为内螺纹加工专用。
1. ThreadPro的路径类型请选择"单刃进给"
※1. 螺旋铣孔和螺纹铣削同时加工时的最大值。
加工超过最大加工径的内螺纹尺寸时，请进行底孔加工。

AT-2 is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.
※1. This is the maximum value when helical drilling and threading take place at the same time. Please make a pre-drilled hole when machining an internal thread size that exceeds the maximum processing diameter.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1034 NEW

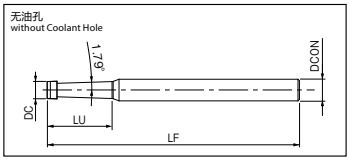
高硬度钢用带底刃螺纹铣刀 锥管螺纹型

THREAD MILL WITH END-CUTTING EDGE FOR HIGH-HARDNESS STEELS TAPERED PIPE THREAD TYPE

The A Brand

AT-2

切削条件 Cutting Conditions | P.845



因为是左刃，所以请主轴逆转使用。
Spindle rotation must be counterclockwise due to the left-hand cut configuration.

CARBIDE | DURAREY | SHANK h6

螺纹种类：Rc(PT)

单位:mm Unit:mm

商品号 EDP No.	加工径 Thread Size	底孔适用尺寸※1 Applicable size for pre-drilled hole	牙数 TPI	标准外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331214	1/16 - 28	1/8 - 28(φ4～8.2)	28	4.86	70	15.8	18	6	4	–	●	26
8331215	1/8 - 28	–	28	5.76	70	16.8	19	6		–	●	27
8331216	1/4 - 19	3/8 - 19(φ6～14.4)	19	7.98	80	24.76	28	10		–	●	78
8331217	3/8 - 19	–	19	9.68	80	24.76	28	10		–	●	84
8331218	1/2 - 14	3/4 - 14(φ8～23)	14	11.61	110	30.6	35	12		–	●	164
8331219	1 - 11	1 - 11(φ10～29)	11	15.54	135	39.4	45	16		–	○	356

AT-2为内螺纹加工专用。
1. ThreadPro的路径类型请选择"单刃进给"。
※1. 加工底孔后进行螺纹加工时的可加工尺寸。
Rc(PT)1-11和1-11 1/2NPT需要底孔加工。

AT-2 is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.
※1. Machinable size for threading after pre-drilled hole.
Rc (PT) 1-11 and 1-11 ½ NPT require pre-drilled hole.

螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	加工径 Thread Size	底孔适用尺寸※1 Applicable size for pre-drilled hole	牙数 TPI	标准外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331234	1/16 - 27	1/8 - 27(φ4～8.43)	27	4.86	70	15.7	18	6	4	–	○	25
8331235	1/8 - 27	–	27	5.76	70	16.7	19	6		–	○	28
8331236	1/4 - 18	3/8 - 18(φ6～14.27)	18	7.98	80	24.5	28	10		–	○	76
8331237	3/8 - 18	–	18	9.68	80	24.5	28	10		–	○	80
8331238	1/2 - 14	3/4 - 14(φ8～17.86)	14	11.61	110	30.5	35	12		–	○	162
8331239	1 - 11 1/2	1 - 11 1/2(φ10～28.98)	11.5	15.54	135	39.6	45	16		–	○	356

AT-2为内螺纹加工专用。
1. ThreadPro的路径类型请选择"单刃进给"。
※1. 加工底孔后进行螺纹加工时的可加工尺寸。
Rc(PT)1-11和1-11 1/2NPT需要底孔加工。

AT-2 is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.
※1. Machinable size for threading after pre-drilled hole.
Rc (PT) 1-11 and 1-11 ½ NPT require pre-drilled hole.

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

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TW1035 NEW

非铁金属用带底刃高效率螺纹铣刀 2D型

HIGH-EFFICIENCY THREAD MILL WITH END-CUTTING EDGE FOR NON-FERROUS MATERIALS 2D TYPE

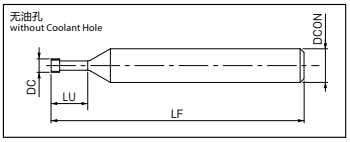
The A Brand

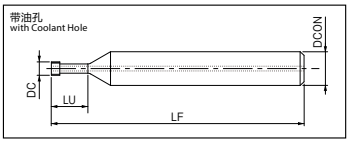
AT-2 R-SPEC

切削条件 Cutting Conditions | P.850

因为是左刃，所以请主轴逆转使用。
Spindle rotation must be counterclockwise due to the left-hand cut configuration.

CARBIDE | DLC-IGUSS | SHANK h6





螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	加工径 Thread Size	标准外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331220	M 3 × 0.5	2.4	50	6	7.75	6	2	—	○	16
8331221	M 4 × 0.7	3.1	50	8	10.45	6		—	○	16
8331222	M 5 × 0.8	4	50	10	12.8	6		—	○	4
8331223	M 6 × 1	4.6	50	12	15.5	6		Yes	○	17
8331224	M 8 × 1.25	6.2	70	16	20.38	8		Yes	○	42
8331225	M10 × 1.5	7.5	80	20	25.25	10		Yes	○	72
8331226	M12 × 1.75	9	80	24	30.13	10		Yes	○	72

AT-2 R-SPEC为内螺纹加工专用。
1. ThreadPro的路径类型请选择"单刃进给"。

AT-2 R-SPEC is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.

ThreadPro

NC编程软件
Thread Milling NC Code Generator Software

※详细请参考 P.540
See p.540 for details

操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1035 NEW

非铁金属用带底刃高效率螺纹铣刀 2.5D型

HIGH-EFFICIENCY THREAD MILL WITH END-CUTTING EDGE FOR NON-FERROUS MATERIALS 2.5D TYPE

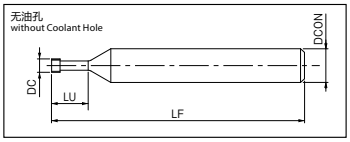
The A Brand

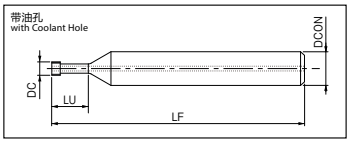
AT-2 R-SPEC

切削条件 Cutting Conditions | P.850

因为是左刃，所以请主轴逆转使用。
Spindle rotation must be counterclockwise due to the left-hand cut configuration.

CARBIDE | DLC-IGUSS | SHANK h6





螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	加工径 Thread Size	标准外径 DC	全长 LF	最大螺纹长度 Maximum threading length	颈长 LU	柄径 DCON	槽数 Flutes	油孔 Oil Hole	库存 Stock	重量 (g)
8331227	M 3 × 0.5	2.4	50	7.5	9.25	6	2	—	○	17
8331228	M 4 × 0.7	3.1	50	10	12.45	6		—	○	16
8331229	M 5 × 0.8	4	50	12.5	15.3	6		—	○	3
8331230	M 6 × 1	4.6	50	15	18.5	6		Yes	○	16
8331231	M 8 × 1.25	6.2	70	20	24.38	8		Yes	○	41
8331232	M10 × 1.5	7.5	80	25	30.25	10		Yes	○	68
8331233	M12 × 1.75	9	80	30	36.13	10		Yes	○	66

AT-2 R-SPEC为内螺纹加工专用。
1. ThreadPro的路径类型请选择"单刃进给"。

AT-2 R-SPEC is only for milling internal threads.
1. Please select "continuous" for the path type in ThreadPro.

螺纹铣刀用径补偿工具

Diameter Correction Tool for Thread Mills

※详细请参考 ▶ P.496或499
See p.496 or 499 for details

使用DCT75可将孔口部中径数值化，使径补偿变得简单。

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

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

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

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

△ = 停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1024

小径螺纹用螺纹铣刀
SMALL DIAMETER PLANET CUTTER

WH-VM-PNC

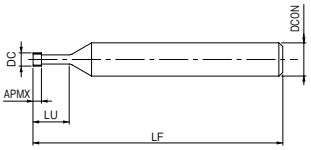
切削条件 Cutting Conditions | P.851

M1-M5的小径螺纹铣刀，适合于加工附加价值高的工件，防止它产生不良品，以及底孔余量较少的螺纹加工。

A planet cutter for small sizes M1-M5. Best for an expensive work material which cannot have scraps and not much cleanse at the bottom of the hole.

S1～1.4
M1～1.8

M2～5
No.8



CARBIDE | SS (DC ≦ 1.3) or WXS (1.5≦ DC) | 11° | SHANK h6

螺纹种类：S

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	螺纹的牙数 Thread per cutting part	颈长 LU	柄径 DCON	槽数 Flutes	库存 Stock	重量 (g)
3900495	S1	0.25	0.72	40	0.25		2.75			●	9
3900496	S1.2	0.25	0.91	40	0.25	1	3.25	3	3	●	9
3900497	S1.4	0.3	1.05	40	0.3		3.8			●	9

WH-VM-PNC(S) 为内螺纹加工专用。

WH-VM-PNC (S) is only for milling internal threads.

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	螺纹的牙数 Thread per cutting part	颈长 LU	柄径 DCON	槽数 Flutes	库存 Stock	重量 (g)
3900495	M1	0.25	0.72	40	0.25		2.75			●	9
3900496	M1.2	0.25	0.91	40	0.25		3.25			●	9
3900497	M1.4	0.3	1.05	40	0.3	1	3.8	3	3	●	9
3900498	M1.6	0.35	1.2	40	0.35		4.35			●	9
3900499	M1.7	0.35	1.3	40	0.35		4.85			●	9

WH-VM-PNC(M) 为内螺纹加工专用。

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	螺纹的牙数 Thread per cutting part	颈长 LU	柄径 DCON	槽数 Flutes	库存 Stock	重量 (g)
3900500	M2	0.4	1.5	40	1.2		4.4			●	21
3900501	M2.5	0.45	1.9	40	1.4		5.6			●	21
3900502	M3	0.5	2.4	40	1.5	3	6.5	6	3	●	21
3900503	M4	0.7	3.1	40	2.1		8.7			●	20
3900504	M5	0.8	4	40	2.4		10.8			●	20

WH-VM-PNC (M) is only for milling internal threads.

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	螺纹牙数量 Thread per cutting part	颈长 LU	柄径 DCON	槽数 Flutes	库存 Stock	重量 (g)
3900513	No.8	32	3.2	40	2.4	3	9.1	6	3	●	20

WH-VM-PNC(U,UNJ) 为内螺纹加工专用。

WH-VM-PNC (U,UNJ) is only for milling internal threads.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
WH-VM-PNC																										
M1 ～ M1.8	○	○	○						◎		○	○	○			◎		◎	◎	◎	◎	○		○	○
M2 ～	○	○	○	○	◎	◎	◎	○	○		○	○	○			○	○	○	○	○	○	◎	◎	○	○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1021

钢用螺纹铣刀
PLANET CUTTER FOR STEELS

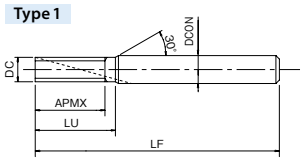
WX-ST-PNC

切削条件 Cutting Conditions | P.851

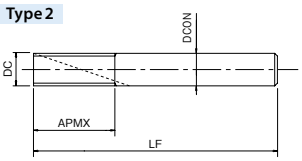
与传统的同尺寸产品相比、多一槽。
因此加工效率更高，特别适用于碳素钢、不锈钢、调质钢。

One more extra flute than WX-PNC made higher performance possible. Suitable for carbon steel, stainress steeel, prehardened steel applications.

Type 1



Type 2



CARBIDE | WX | 11° | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	螺纹长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305732	M12	1.25	9.5	85	26.3	28	10	5	1	▲	84
8305741	M14	0.75	10	85	29.3	—	10		2	▲	86

WX-ST-PNC(M) 为内螺纹加工专用。
1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

▲此产品已停止生产，由 AT-1 (P.503) 替代。

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	螺纹长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305765	M18	2.5	14	105	40	45	16	5	1	▲	240
8305784	M24	2	20	120	50	—	20	6	2	▲	456

WX-ST-PNC (M) is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲= The products have been stopped producing and replaced by AT-1 (p.503).

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305800	1/4	20	4.55	60	10.2	11.4	6	4	1	▲	22
8305801		28			10	10.9				▲	22
8305806	5/16	24	6.2	65	12.7	14.1	8		1	▲	41
8305811	3/8	24	7.6	65	14.8	—	8		2	▲	42
8305815	7/16	14	8.8	75	18.1	19.9	10		1	▲	72
8305816		20			17.8	19.1				▲	74

WX-ST-PNC(U,UNJ) 为内螺纹加工专用。
1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

▲此产品已停止生产，由 AT-1 (P.504) 替代。

商品号 EDP No.	最小加工径 Min. Processing Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305820	1/2	13	9.4	75	19.5	21.5	10	5	1	▲	75
8305830	9/16	18	11.4	85	22.6	24	12		1	▲	125
8305832	5/8	11	10.9	85	25.4	27.7	12		1	▲	118
8305835	3/4	10	15.7	95	30.5	—	16		2	▲	243
8305838	7/8	9	18.9	110	33.9	36.7	20	6	1	▲	420
8305842	1	8	18.9	110	38.1	41.3	20		1	▲	404

WX-ST-PNC (U,UNJ) is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲= The products have been stopped producing and replaced by AT-1 (p.504).

螺纹铣刀用径补偿工具
Diameter Correction Tool for Thread Mills

※详细请参考 ▶ P.496或499
See p.496 or 499 for details

使用DCT75可将孔口部中径数值化，使径补偿变得简单。

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

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
△ = 停产产品(请确认库存。) Discontinued item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

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

G-LIST No. | **TW1021**

钢用螺纹铣刀
PLANET CUTTER FOR STEELS

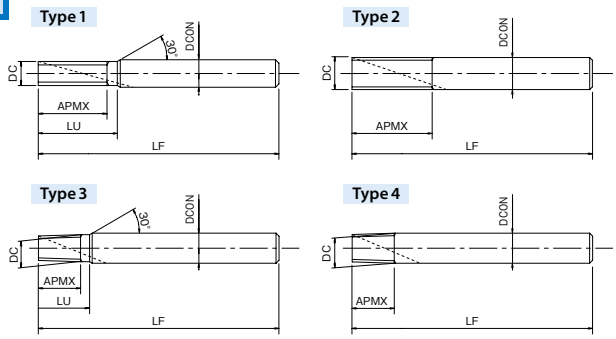
WX-ST-PNC

切削条件 Cutting Conditions | P.851

CARBIDE | WX | 11° | SHANK h6

与传统的同尺寸产品相比、多一槽。
因此加工效率更高，特别适用于碳素钢、不锈钢、调质钢。

One more extra flute than WX-PNC made higher performance possible. Suitable for carbon steel, stainress steeel, prehardened steel applications.



螺纹种类：R(PT) , Rc(PT)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305912	3/8	19	11	85	14.7	20	12	5	3	▲	129

1. 切削油剂请参考P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

▲此产品已停止生产，由AT-1 (P.505) 替代。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲=The products have been stopped producing and replaced by AT-1 (p.505).

螺纹种类：Rp(PS) , G(PF)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305949	1/16・1/8	28	5.9	60	11.8	—	6	4	2	▲	23
8305962	3/8	19	11	85	25.4	26.7	12	5	1	▲	120

1. 切削油剂请参考P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

▲此产品已停止生产，由AT-1 (P.505) 替代。

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305965	3/4・7/8	14	16	110	39.9	—	16	5	2	▲	277
8305968	1~2	11	20	125	50.8	—	20	6	2	▲	465

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲=The products have been stopped producing and replaced by AT-1 (p.505).

螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8305868	1~2	11½	20	95	24.3	—	20	6	4	▲	370

1. 切削油剂请参考P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

▲此产品已停止生产，由AT-1 (P.505) 替代。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲=The products have been stopped producing and replaced by AT-1 (p.505).

ThreadPro
NC编程软件
Thread Milling NC Code Generator Software
※详细请参考 P.540
See p.540 for details
操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1022

内冷油孔钢用螺纹铣刀

PLANET CUTTER FOR STEELS WITH INTERNAL COOLANT SUPPLY

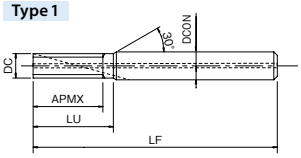
WXO-ST-PNC

切削条件 Cutting Conditions | P.851

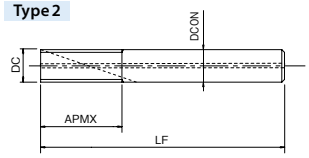
内冷油孔使得切屑的排出更加顺畅。在切屑难以排出的卧式加工中心上、或是底孔深度不够充裕的盲孔加工中，可有效防止由切屑产生的崩刃现象。

Oil hole makes better chip ejection good for horizontal machining center which is more difficult chip clearance and blind hole without enough clearance on the bottom of the hole.

Type 1



Type 2



CARBIDE | WX | 11° | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8304700	M6	0.75	4.5	60	12.8	15	6		1	●	21
8304701		1			13					●	20
8304710	M8	0.5	6	65	16.5	—	6	4	2	●	24
8304711		1			17					●	24
8304712		1.25			17.5					●	24
8304721	M10	1	7.5	70	21	26	8		1	●	43
8304723		1.5			22.5					●	42
8304732	M12	1.25	9.5	85	26.3	28	10	5	1	●	82
8304733		1.5			25.5					●	82
8304734		1.75			26.3					●	82
8304740	M14	0.5	10	85	28.5	—	10		2	●	84
8304741		0.75			29.3					●	84

WXO-ST-PNC(M) 为内螺纹加工专用。
1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择“多刃同时进给”。

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8304742	M14	1	10	85	29	—	10	5	2	●	84
8304743		1.5			30					●	81
8304744		2			30					●	81
8304752	M16	1	12	95	33	—	12		2	●	134
8304753		1.5			34.5					●	134
8304754		2			34					●	132
8304773	M20	1.5	16	105	42	—	16		2	●	260
8304775		2.5			42.5					●	255
8304783	M24	1.5	20	120	49.5	—	20	6	2	●	448
8304784		2			50					●	444
8304786		3			51					●	436

WXO-ST-PNC (M) is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹铣刀用径补偿工具
Diameter Correction Tool for Thread Mills

※详细请参考 ▶P.496或499
See p.496 or 499 for details

使用DCT75可将孔口部中径数值化，使径补偿变得简单。

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **TW1020**

非铁 · 耐热合金用 螺纹铣刀

PLANET CUTTER FOR NONFERROUS METAL AND HEAT-RESISTANT ALLOY

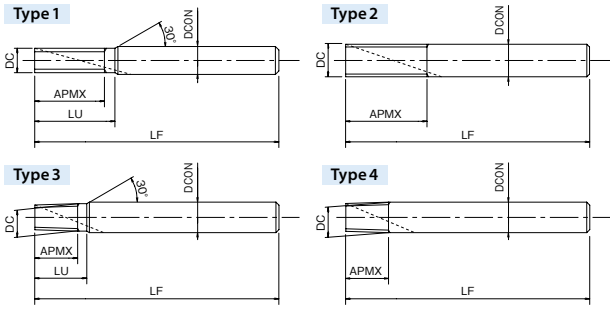
WX-PNC

切削条件 Cutting Conditions | P.851

使用加工中心的三轴连动机能，利用游星运动，能进行螺纹切削加工。
如果是相同螺距，能同时加工不同的螺纹。并且，左右螺纹均可加工。

These taps cut threads by using the planetary drive of a CNC machining center, 3 axis simultaneous control systems. One tool is capable of processing different threads, provided they are the same pitch. This tap is also capable of processing both right and left handed threads.

CARBIDE | WX | 30° | SHANK h6



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	适用加工寸 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	螺纹长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
3900000	M6	0.75	4.5	60	12.8	15	6		1	●	21
3900001		1			13					●	20
3900009	M8	0.5	6	65	16.5	—	6	3	2	●	24
3900011		1			17					●	24
3900012		1.25			17.5					●	23
3900021	M10	1	7.5	70	21	26	8		1	●	43
3900023		1.5			22.5					●	41
3900032	M12	1.25	9.5	85	26.3	28	10	4	1	●	84
3900033		1.5			25.5					●	84
3900034		1.75			26.3					●	83
3900036	M14	0.5	10	85	28.5	—	10		2	●	87
3900041		0.75			29.3					●	86

WX-PNC(M) 为内螺纹加工专用。
1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

商品号 EDP No.	适用加工寸 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	螺纹长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
3900042	M14	1	10	85	29	—	10	4	2	●	85
3900043		1.5			30					●	85
3900044		2			30					●	85
3900052	M16	1	12	95	33	—	12		2	●	137
3900053		1.5			34.5					●	135
3900054		2			34					●	135
3900065	M18	2.5	14	105	40	45	16		1	●	239
3900073	M20	1.5	16	105	42	—	16		2	●	260
3900075		2.5			42.5					●	256
3900083	M27	1.5	20	120	49.5	—	20	5	2	●	449
3900084		2			50					●	442
3900086		3			51					●	436

WX-PNC (M) is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹种类：U, UNJ

单位:mm Unit:mm

商品号 EDP No.	适用加工寸 Min. Processing Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
3900350	1/4	20	4.55	60	10.2	11.4	6	3	1	●	22
3900351		28			10	10.9				●	22
3900355	5/16	18	6.2	65	12.7	14.1	8		1	●	41
3900356		24								●	41
3900360	3/8	16	7.6	65	14.3	—	8		2	●	42
3900361		24			14.8					●	42
3900365	7/16	14	8.8	75	18.1	19.9	10		1	●	72
3900366		20			17.8	19.1				●	73
3900370	1/2	13	9.4	75	19.5	21.5	10	4	1	●	75

WX-PNC(U,UNJ) 为内螺纹加工专用。
1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

商品号 EDP No.	适用加工寸 Min. Processing Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
3900371	1/2	20	9.4	75	19.1	20.4	10	4	1	●	76
3900375	9/16	12	10.9	85	23.3	25.4	12		1	●	120
3900380		18	11.4		22.6	24				●	125
3900382	5/8	11	10.9	85	25.4	27.7	12		1	●	118
3900385	3/4	10	15.7	95	30.5	—	16		2	●	240
3900388	7/8	9	18.9	110	33.9	36.7	20		1	●	418
3900390		12				36				●	422
3900392	1	8	18.9	110	38.1	41.3	20		1	●	403

WX-PNC (U,UNJ) is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

ThreadPro
NC编程软件
Thread Milling NC Code Generator Software
※详细请参考 P.540
See p.540 for details
操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

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

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

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

▲ = 由新产品及后续产品替代(请确认库存。)
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△ = 停产产品(请确认库存。)
Discontinued item

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

非铁·耐热合金用 螺纹铣刀

PLANET CUTTER FOR NONFERROUS METAL AND HEAT-RESISTANT ALLOY

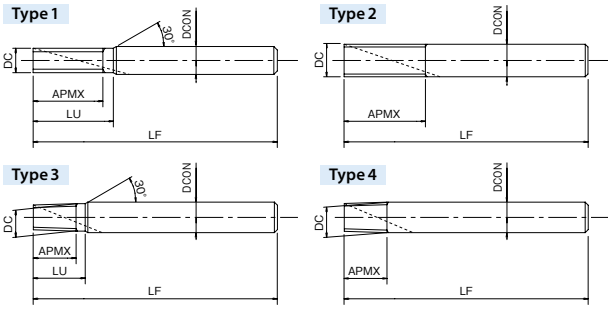
WX-PNC

切削条件 Cutting Conditions | P.851

使用加工中心的三轴连动机能，利用游星运动，能进行螺纹切削加工。如果是相同螺距，能同时加工不同的螺纹。并且，左右螺纹均可加工。

These taps cut threads by using the planetary drive of a CNC machining center, 3 axis simultaneous control systems. One tool is capable of processing different threads, provided they are the same pitch. This tap is also capable of processing both right and left handed threads.

CARBIDE | WX | 30° | SHANK h6



螺纹种类：R(PT)，Rc(PT)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
3900199	1/16·1/8	28	5.9	60	9.1	—	6	3	4	●	23
3900201	1/8	28	7.5	60	9.1	12.7	8		3	●	40
3900211	1/4·3/8	19	10	75	14.7	—	10	4	4	●	78
3900212	3/8	19	11	85	14.7	20	12		3	●	128
3900214	1/2·3/4	14	12	85	20	—	12	4	4	●	123
3900215	3/4	14	16	85	20	—	16		4	●	223
3900218	1~2	11	20	95	27.7	—	20	5	4	●	357

1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择“多刃同时进给”。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹种类：Rp(PS)，G(PF)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
3900299	1/16·1/8	28	5.9	60	11.8	—	6	3	2	●	23
3900301	1/8	28	7.5	65	14.5	15.4	8		1	●	43
3900311	1/4·3/8	19	10	75	20.1	—	10	4	2	●	76
3900312	3/8	19	11	85	25.4	26.7	12		1	●	121
3900314	1/2~7/8	14	12	95	32.7	—	12	4	2	●	134
3900315	3/4·7/8	14	16	110	39.9	—	16		2	●	272
3900318	1~2	11	20	125	50.8	—	20	5	2	●	451

1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择“多刃同时进给”。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
3900259	1/16·1/8	27	5.9	60	10.3	—	6	3	4	●	23
3900261	1/4·3/8	18	10	75	15.5	—	10	4	4	●	77
3900265	1/2·3/4	14	16	85	20	—	16	4	4	●	220
3900268	1~2	11½	20	95	24.3	—	20	5	4	●	362

1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择“多刃同时进给”。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹铣刀用径补偿工具
Diameter Correction Tool for Thread Mills

※详细请参考 ▶P.496或499
See p.496 or 499 for details

使用DCT75可将孔口部中径数值化，使径补偿变得简单。

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

△＝停产产品(请确认库存。) Discontinued item

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

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

G-LIST No. | **TW1016**

硬质合金通用螺旋槽螺纹铣刀
SOLID CARBIDE SPIRAL PLANET CUTTER

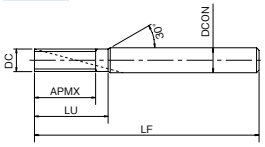
OT-SFT-PNGT

切削条件 Cutting Conditions | P.851

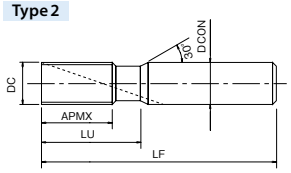
因为是螺旋槽，所以可以降低切削时的负荷，可比直槽型进行更高进给、高效率加工。

Due to helix flute, cutting torque is decreased. It is capable of more highly efficient operation than that one with straight flute with high feed.

Type 1



Type 2



CARBIDE | FX | 15° | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock		重量 (g)
8306532	M 12	1.25	9	90	24	–	10	4	1	B	▲	87
8306544	M 14	2	10	90	25	–	10		2		▲	86
8306575	M 20	2.5	16	125	40	–	16		2		▲	304
8306583	M 27	1.5	20	145	50	60	20	5	2		▲	556
8306584		2				–					▲	553
8306586		3									▲	545

OT-SFT-PNGT(M)为内螺纹加工专用。
1. 切削油剂请参考P.1004。
2. ThreadPro的路径类型请选择"多刃同时进给"。

▲=此产品已停止生产，由AT-1(P.503)替代。

OT-SFT-PNGT (M) is available only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲=The products have been stopped producing and replaced by AT-1 (p.503).

ThreadPro
NC编程软件
Thread Milling NC Code Generator Software
※详细请参考 P.540
See p.540 for details
操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

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

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TW1015

硬质合金通用螺纹铣刀
SOLID CARBIDE PLANET CUTTER

OT-PNGT

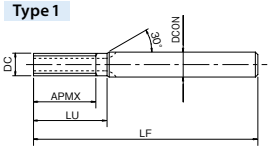
切削条件 Cutting Conditions | P.852

由硬质合金制成，与高速钢工具相比大幅缩短了加工时间。FX涂层可实现更长的寿命。

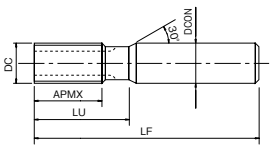
Compared to HSS tools, deflection-resistant tungsten carbide tools have a much shorter processing time. The FX coating provides extended tool life.

CARBIDE | FX | SHANK h6

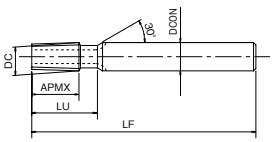
Type 1



Type 2



Type 3



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock		重量 (g)
8306232	M 12	1.25	9	90	24	–	10	4	1	B	▲	86
8306273	M 20	1.5	16	125	40	50	16		2		▲	303
8306276		2.5				–					▲	297
8306287	M 27	3	20	145	50	–	20	5	2		▲	541

OT-PNGT(M)为内螺纹加工专用。
1. 切削油剂请参考P.1004。
2. ThreadPro的路径类型请选择"多刃同时进给"。

▲=此产品已停止生产，由AT-1(P.503)替代。

OT-PNGT (M) is available only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲=The products have been stopped producing and replaced by AT-1 (p.503).

螺纹种类：Rp(PS) , G(PF)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock		重量 (g)
8306410	3/8	19	10	80	16	23	10	4	2	B	▲	80

1. 切削油剂请参考P.1004。
2. ThreadPro的路径类型请选择"多刃同时进给"。

▲=此产品已停止生产，由AT-1(P.505)替代。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

▲=The products have been stopped producing and replaced by AT-1 (p.505).

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1082

高速钢螺纹铣刀

HSS PLANET CUTTER

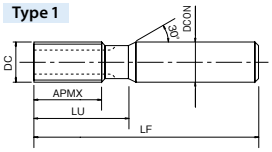
PNGT

切削条件 Cutting Conditions | P.852

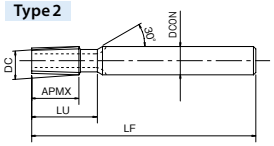
使用加工中心的三轴连动机能，利用游星运动，能进行螺纹铣削加工，如果是相同螺旋，能同时加工不同的螺纹，并且，左右螺纹均可加工。
These taps cut threads by using the planetary drive of a CNC machining center, 3 axis simultaneous control systems. One tool is capable of processing different threads, provided they are the same pitch. This tap is also capable of processing both right and left handed threads.

HSS-Co | TiN | SHANK h6

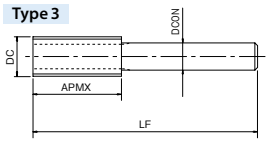
Type 1



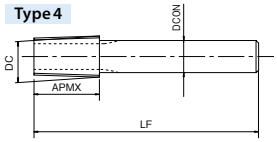
Type 2



Type 3



Type 4



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	最小加工径 Min. Processing Dia.	螺距 TP	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8306012	M14	1	10	90	25	32	10	4	1	●	52
8306013		1.5								●	52
8306022	M16	1	12	105	30	38	12		1	●	88
8306023		1.5								●	87
8306024		2								●	87
8306032	M20	1	16	125	40	50	16		1	●	177
8306033		1.5								●	175
8306034		2								●	173
8306035		2.5								●	173
8306036		3								●	170
8306042	M27	1	20	145	50	60	20	5	1	●	320
8306043		1.5								●	317
8306044		2								●	315
8306046		3								●	310
8306047		3.5								●	306
8306052	M34	1	25	165	65	—	20	6	3	●	441
8306053		1.5								●	439
8306054		2								●	436
8306056		3								●	419
8306063	M42	1.5	32	210	80	—	25		3	●	906
8306064		2								●	901
8306066		3								●	890

PNGT(M) 为内螺纹加工专用。
1. 切削油剂请参考P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

PNGT (M) is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹铣刀用径补偿工具
Diameter Correction Tool for Thread Mills

※详细请参考 ▶ P.496或499
See p.496 or 499 for details

使用DCT75可将孔口部中径数值化，使径补偿变得简单。

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | **TH1082**

高速钢 螺纹铣刀

HSS PLANET CUTTER

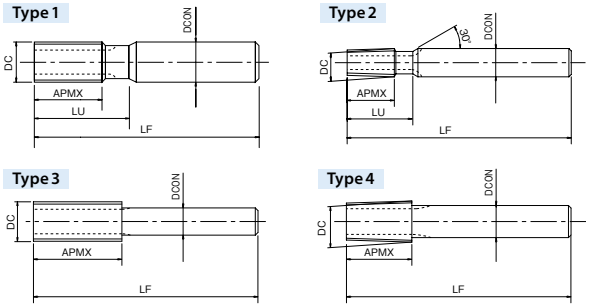
PNGT

切削条件 Cutting Conditions | **P.852**

使用加工中心的三轴连动机能，利用游星运动，能进行螺纹铣削加工，如果是相同螺旋，能同时加工不同的螺纹，并且，左右螺纹均可加工。

These taps cut threads by using the planetary drive of a CNC machining center, 3 axis simultaneous control systems. One tool is capable of processing different threads, provided they are the same pitch. This tap is also capable of processing both right and left handed threads.

HSS-Co | TiN | SHANK h6



螺纹种类：R(PT)，Rc(PT)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8306111	3/8	19	10	80	16	23	10	4	2	●	47
8306114	1/2 · 3/4	14	12	95	20	28	12		2	●	82
8306115	3/4	14	16	110	25	35	16		2	●	162
8306118	1～2	11	20	125	32	42.5	20	5	2	●	284
8306119	1-1/2·2～6	11	32	175	50	–	25	6	4	●	733

1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹种类：Rp(PS)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8306121	3/8	19	10	80	16	23	10	4	1	●	48
8306124	1/2 ～7/8	14	12	95	20	–	12		1	●	83
8306125	3/4 ·7/8	14	16	110	25	35	16		1	●	158
8306128	1～3-1/2	11	20	125	32	42.5	20	5	1	●	282
8306129	1-1/2～6	11	32	175	50	–	25	6	1	●	723

1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

螺纹种类：G(PF)

单位:mm Unit:mm

商品号 EDP No.	适用加工尺寸 Range of Thread Size Dia.	牙数 TPI	外径 DC	全长 LF	刃长 APMX	颈长 LU	柄径 DCON	槽数 Flutes	形状类型 Type	库存 Stock	重量 (g)
8306131	3/8	19	10	80	16	23	10	4	1	●	47
8306134	1/2 ～7/8	14	12	95	20	–	12		1	●	82
8306135	3/4 ·7/8	14	16	110	25	35	16		1	●	164
8306138	1～3-1/2	11	20	125	32	42.5	20	5	1	●	283
8306139	1-1/2～6	11	32	175	50	–	25	6	3	●	723

PNGT(G(PF))为内螺纹加工专用。
1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

PNGT (G (PF)) is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1013

复合加工用 超级螺纹铣刀

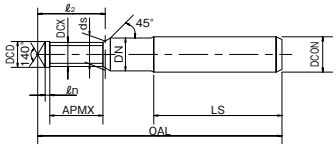
SUPER-PLANET CUTTER FOR MULTIFUNCTION MILLING

DR-PNAC

切削条件 Cutting Conditions | P.852

此工具是底孔加工，内螺纹加工的复合工具，可以不替换工具，减少非加工时间，提高生产效率。

With this one tool, you can drill the hole, cut thread and cut the chamfer.



CARBIDE | FX | 25° | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	尺寸 Mill Dia	螺纹外径 DCX	全长 OAL	APMX	钻头长 ℓn	ℓ2	柄长 LS	钻头径 DCD	倒角径 ds	颈径 DN	柄径 DCON	槽数 Flutes	库存 Stock	重量 (g)
8330400	M 6 × 1 -2D	4.8	62	12.1	1	14.7	36	5	6.3	7	8		●	34
8330412	M 8 × 1.25 -2D	6.5	75	15.1	1.3	18.5	40	6.8	8.3	9	10		●	65
8330413	M 8 × 1 -2D	6.7	75	15.1	1.3	18.5	40	7	8.3	9	10		●	66
8330424	M 10 × 1.5 -2D	8.2	79	19.6	1.5	23.7	45	8.5	10.3	11	12		●	95
8330425	M 10 × 1.25 -2D	8.5	79	20.1	1.5	24	45	8.8	10.3	11	12	2	●	96
8330426	M 10 × 1 -2D	8.7	79	20.1	1.5	24	45	9	10.3	11	12		●	96
8330436	M 12 × 1.75 -2D	9.9	89	22.9	1.8	27.4	48	10.3	12.3	13.5	16		●	178
8330437	M 12 × 1.5 -2D	10.2	89	24.1	1.8	28.6	48	10.5	12.3	13.5	16		●	179
8330438	M 12 × 1.25 -2D	10.2	89	23.9	1.8	28.3	48	10.8	12.3	13.5	16		●	180

DR-PNAC为内螺纹加工专用。
1. 切削油剂请参考P.1004。
2. 加工螺纹深度＝外径x2

DR-PNAC is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. Tapping length=thread dia.×2

螺纹铣刀用径补偿工具
Diameter Correction Tool for Thread Mills

※详细请参考 ▶ P.496或499
See p.496 or 499 for details

使用DCT75可将孔口部中径数值化，使径补偿变得简单。

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

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TW1014

复合加工用内冷油孔超级螺纹铣刀

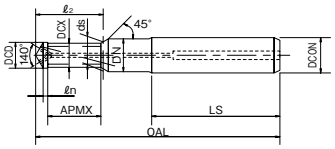
SUPER-PLANET CUTTER FOR MULTIFUNCTION MILLING WITH INTERNAL COOLANT SUPPLY

DR-O-PNAC

切削条件 Cutting Conditions | P.852

此工具是底孔加工，内螺纹加工的复合工具，可以不替换工具，减少非加工时间，提高生产效率。

With this one tool, you can drill the hole, cut thread and cut the chamfer.



CARBIDE | FX | 25° | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	尺寸 Mill Dia	外径 DCX	全长 OAL	APMX	钻头长 ℓn	ℓ2	柄长 LS	钻头径 DCD	倒角径 ds	颈径 DN	柄径 DCON	槽数 Flutes	库存 Stock	重量 (g)
8330500	M 6 × 1 -2D	4.8	62	12.1	1	14.7	36	5	6.3	7	8	2	●	32
8330512	M 8 × 1.25 -2D	6.5	75	15.1	1.3	18.5	40	6.8	8.3	9	10		●	59
8330524	M 10 × 1.5 -2D	8.2	79	19.6	1.5	23.7	45	8.5	10.3	11	12		●	107
8330536	M 12 × 1.75 -2D	9.9	89	22.9	1.8	27.4	48	10.3	12.3	13.5	16		●	175

DR-O-PNAC为内螺纹加工专用。
1. 切削油剂请参考 P.1004。
2. DR-O-PNAC底刃的第二后刃面有油孔。
3. 加工螺纹深度 = 外径x2

DR-O-PNAC is only for milling internal threads.
1. Cutting fluid and Paste : Please refer to p.1004.
2. DR-O-PNAC has oil hole.
3. Tapping length=thread dia.×2

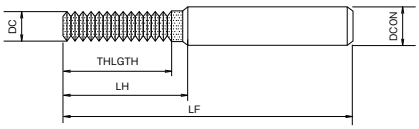
G-LIST No. | TP1000

陶瓷用电镀金刚石螺纹铣刀

ELECTROPLATED DIAMOND TAPS FOR CERAMICS

ED-PNT

切削条件 Cutting Conditions | P.843



单位:mm Unit:mm

商品号 EDP No.	尺寸 Mill Dia	外径 DC	螺距 TP	全长 LF	螺纹长 THLGTH	颈长 LH	柄径 DCON	电镀长 Length of electroplating	最小加工径 Min. Processing Dia.	粒度 Grit Size	库存 Stock	重量 (g)
8315981	2.2 × 7.5 × P0.5	2.2	0.5	50	7.5	8.5	4	8.5	3	#600	●	7
8315982	3 × 9.8 × P0.7	3	0.7	60	9.8	12	6	12	4	#400	●	15
8315983	3.7 × 12 × P0.8	3.7	0.8	60	12	14	6	14	5	#400	●	15
8315984	4.5 × 15 × P1	4.5	1	70	15	18	8	18	6	#400	●	26
8315985	6 × 20 × P1.25	6	1.25	70	20	23	8	23	8	#400	●	26
8315986	7.5 × 24 × P1.5	7.5	1.5	80	24	27	10	27	10	#400	●	45
8315987	9 × 30 × P1.75	9	1.75	80	30	33	10	33	12	#400	●	48
8315988	10 × 34 × P2	10	2	80	34	39	10	39	14	#400	●	48

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

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

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

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

△ = 停产产品(请确认库存。)
Discontinued item

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

工具选定表 Selection Chart

■公制内螺纹用 Metric screw thread (internal)

螺距 Pitch	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
P0.5	M 13～	TMC12-2、TMC20-2	2I 0.5 ISO TM2		
	M 17～	TMC16-3 124/001	3I 0.5 ISO TM2		
		TMNC16-3	3I 0.5 ISO TM2		
	M 19～	TM2C20-2	2I 0.5 ISO TM2		
		TMC16-3	3I 0.5 ISO TM2		
	M 21～	TMNC20-3	3I 0.5 ISO TM2		
	M 22～	TMC20-3	3I 0.5 ISO TM2		
	M 24～	TMLC25-3	3I 0.5 ISO TM2		
	M 28～	TM2C25-3	3I 0.5 ISO TM2		
	M 51～	TMSH-D50-FMA25.4-3	3I 0.5 ISO TM2		
P0.75	M 14～	TMC12-2、TMC20-2	2I 0.75 ISO TM2		
	M 18～	TMC16-3 124/001、TMNC16-3	3I 0.75 ISO TM2		
	M 19～	TM2C20-2	2I 0.75 ISO TM2		
		TMC16-3	3I 0.75 ISO TM2		
	M 22～	TMNC20-3	3I 0.75 ISO TM2		
	M 23～	TMC20-3	3I 0.75 ISO TM2		
	M 25～	TMLC25-3	3I 0.75 ISO TM2		
	M 29～	TM2C25-3	3I 0.75 ISO TM2		
	M 52～	TMSH-D50-FMA25.4-3	3I 0.75 ISO TM2		
P1	M 15～	TMC12-2、TMC20-2	2I 1.0 ISO TM2		
	M 19～	TMC16-3 124/001	3I 1.0 ISO TM2		
		TMNC16-3	3I 1.0 ISO TM2		
	M 20～	TM2C20-2	2I 1.0 ISO TM2		
		TMC16-3	3I 1.0 ISO TM2		
	M 22～	TMNC20-3	3I 1.0 ISO TM2		
	M 23～	TMC20-3	3I 1.0 ISO TM2		
	M 25～	TMLC25-3	3I 1.0 ISO TM2		
	M 28～	TMC25-5 124/004	5I 1.0 ISO TM2		
	M 29～	TM2C25-3	3I 1.0 ISO TM2		
	M 33～	TMC25-5、TMLC25-5	5I 1.0 ISO TM2		
	M 41～	TMC32-5、TMLC32-5、TMNC32-5	5I 1.0 ISO TM2		
	M 46～	TM2C32-5	5I 1.0 ISO TM2		
	M 53～	TMSH-D50-FMA25.4-3	3I 1.0 ISO TM2		
	M 66～	TMSH-D63-FMA25.4-5	5I 1.0 ISO TM2		
	M 83～	TMSH-D80-FMA25.4-5	5I 1.0 ISO TM2		
	M103～	TMSH-D100-FMA31.75-5	5I 1.0 ISO TM2		
	M128～	TMSH-D125-FMA38.1-5	5I 1.0 ISO TM2		
P1.25	M 16～	TMC12-2、TMC20-2	2I 1.25 ISO TM2		
	M 20～	TMC16-3 124/001	3I 1.25 ISO TM2		
		TMNC16-3	3I 1.25 ISO TM2		
	M 21～	TM2C20-2	2I 1.25 ISO TM2		
		TMC16-3	3I 1.25 ISO TM2		
	M 23～	TMNC20-3	3I 1.25 ISO TM2		
	M 24～	TMC20-3	3I 1.25 ISO TM2		
	M 26～	TMLC25-3	3I 1.25 ISO TM2		
	M 29～	TMC25-5 124/004	5I 1.25 ISO TM2		
	M 30～	TM2C25-3	3I 1.25 ISO TM2		
	M 35～	TMC25-5、TMLC25-5	5I 1.25 ISO TM2		
	M 42～	TMC32-5、TMLC32-5、TMNC32-5	5I 1.25 ISO TM2		
	M 48～	TM2C32-5	5I 1.25 ISO TM2		
	M 55～	TMSH-D50-FMA25.4-3	3I 1.25 ISO TM2		
	M 68～	TMSH-D63-FMA25.4-5	5I 1.25 ISO TM2		
	M 85～	TMSH-D80-FMA25.4-5	5I 1.25 ISO TM2		
	M105～	TMSH-D100-FMA31.75-5	5I 1.25 ISO TM2		
	M130～	TMSH-D125-FMA38.1-5	5I 1.25 ISO TM2		
P1.5	M 16～	TMC12-2、TMC20-2	2I 1.5 ISO TM2		
	M 20～	TMC16-3 124/001	3I 1.5 ISO TM2		
		TMNC16-3	3I 1.5 ISO TM2		

※蓝色字体部分为特别订制产品。

※ Blue characteres are special order items.

下一页
尺寸 Size M22～M52 NEXT

工具选定表 Selection Chart

上一页
FROM 尺寸 Size M13 ~ M20

螺距 Pitch	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
P1.5	M 22 ~	TM2C20-2	2I 1.5 ISO TM2		
		TMC16-3	3I 1.5 ISO TM2		
	M 24 ~	TMNC20-3	3I 1.5 ISO TM2		
	M 25 ~	TMC20-3	3I 1.5 ISO TM2		
	M 26 ~			TM2SC 18C23-86-2U	2UIDB60 TM
	M 27 ~	TMLC25-3	3I 1.5 ISO TM2		
	M 28 ~			TM3SC 20C26-105-2U	2UIDB60 TM
	M 30 ~	TMC25-5 124/004	5I 1.5 ISO TM2		
	M 31 ~	TM2C25-3	3I 1.5 ISO TM2		
	M 33 ~			TM4SC 25C31-115-2U	2UIDB60 TM
	M 35 ~	TMC25-5、TMLC25-5	5I 1.5 ISO TM2		
	M 39 ~			TM3SC 28C36-144-3U	3UIDB60 TM
	M 40 ~	TMC32-6B	6BI 1.5 ISO TM2		
	M 43 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 1.5 ISO TM2		
	M 45 ~			TM4SC D42-16-3U	3UIDB60 TM
	M 48 ~	TM2C32-5	5I 1.5 ISO TM2		
	M 51 ~	TMC40-6B	6BI 1.5 ISO TM2		
	M 52 ~			TM5SC D48-22-3U	3UIDB60 TM
	M 56 ~	TMSH-D50-FMA25.4-3	5I 1.5 ISO TM2		
	M 59 ~	TMLC42-6B	6BI 1.5 ISO TM2		
	M 60 ~			TM6SC D56-22-3U	3UIDB60 TM
	M 69 ~	TMSH-D63-FMA25.4-5	5I 1.5 ISO TM2		
	M 86 ~	TMSH-D80-FMA25.4-6B	6BI 1.5 ISO TM2		
		TMSH-D80-FMA25.4-5	5I 1.5 ISO TM2		
	M106 ~	TMSH-D100-FMA31.75-5	5I 1.5 ISO TM2		
	M131 ~	TMSH-D125-FMA38.1-5	5I 1.5 ISO TM2		
P1.75	M 21 ~	TMC16-3 124/001、TMNC16-3	3I 1.75 ISO TM2		
	M 23 ~	TMC16-3	3I 1.75 ISO TM2		
	M 25 ~	TMNC20-3	3I 1.75 ISO TM2		
	M 26 ~	TMC20-3	3I 1.75 ISO TM2		
	M 28 ~	TMLC25-3	3I 1.75 ISO TM2		
	M 31 ~	TMC25-5 124/004	5I 1.75 ISO TM2		
	M 32 ~	TM2C25-3	3I 1.75 ISO TM2		
	M 36 ~	TMC25-5、TMLC25-5	5I 1.75 ISO TM2		
	M 44 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 1.75 ISO TM2		
	M 49 ~	TM2C32-5	5I 1.75 ISO TM2		
	M 57 ~	TMSH-D50-FMA25.4-3	3I 1.75 ISO TM2		
	M 70 ~	TMSH-D63-FMA25.4-5	5I 1.75 ISO TM2		
	M 87 ~	TMSH-D80-FMA25.4-5	5I 1.75 ISO TM2		
	M107 ~	TMSH-D100-FMA31.75-5	5I 1.75 ISO TM2		
	M132 ~	TMSH-D125-FMA38.1-5	5I 1.75 ISO TM2		
P2	M 14 ~ M21	TMC12-2、TMC20-2	2I 2.0 ISO TM 028/004		
	M 22 ~	TMC16-3 124/001、TMNC16-3	3I 2.0 ISO TM2		
	M 23 ~	TMC16-3	3I 2.0 ISO TM2		
	M 25 ~	TMNC20-3	3I 2.0 ISO TM2		
	M 26 ~	TMC20-3	3I 2.0 ISO TM2	TM2SC 18C23-86-2U	2UIDB60 TM
	M 28 ~	TMLC25-3	3I 2.0 ISO TM2		
	M 29 ~			TM3SC 20C26-105-2U	2UIDB60 TM
	M 32 ~	TMC25-5 124/004	5I 2.0 ISO TM2		
	M 33 ~	TM2C25-3	3I 2.0 ISO TM2		
	M 34 ~			TM4SC 25C31-115-2U	2UIDB60 TM
	M 37 ~	TMC25-5、TMLC25-5	5I 2.0 ISO TM2		
	M 39 ~			TM3SC 28C36-144-3U	3UIDB60 TM
	M 42 ~	TMC32-6B	6BI 2.0 ISO TM2		
	M 44 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 2.0 ISO TM2		
	M 45 ~			TM4SC D42-16-3U	3UIDB60 TM
	M 50 ~	TM2C32-5	5I 2.0 ISO TM2		
	M 52 ~			TM5SC D48-22-3U	3UIDB60 TM

※蓝色字体部分为特别订制产品。

※ Blue characteres are special order items.

下一页
尺寸 Size M53 ~ M94 NEXT

HYPRO 螺纹铣刀 HYPRO PLANET CUTTER (THREAD MILLING CUTTER)

工具选定表 Selection Chart

上一页
FROM 尺寸 Size M22 ~ M52

螺距 Pitch	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
P2	M 53 ~	TMC40-6B	6BI 2.0 ISO TM2		
	M 57 ~	TMSH-D50-FMA25.4-3	3I 2.0 ISO TM2		
	M 60 ~	TMLC42-6B	6BI 2.0 ISO TM2	TM6SC D56-22-3U	3UIDB60 TM
	M 70 ~	TMSH-D63-FMA25.4-5	5I 2.0 ISO TM2		
	M 87 ~	TMSH-D80-FMA25.4-6B	6BI 2.0 ISO TM2		
		TMSH-D80-FMA25.4-5	5I 2.0 ISO TM2		
	M107 ~	TMSH-D100-FMA31.75-5	5I 2.0 ISO TM2		
	M132 ~	TMSH-D125-FMA38.1-5	5I 2.0 ISO TM2		
P2.5	M 20 ~ M21	TMC16-3 124/001	3I 2.5 ISO TM 028/005		
	M 22 ~ M34	TMC25-4 124/002	4I 2.5 ISO TM 028/006		
	M 27 ~			TM2SC 18C23-86-2U	2UIDC60 TM
	M 30 ~			TM3SC 20C26-105-2U	2UIDC60 TM
	M 34 ~	TMC25-5 124/004	5I 2.5 ISO TM2	TM4SC 25C31-115-2U	2UIDC60 TM
	M 40 ~	TMC25-5、TMLC25-5	5I 2.5 ISO TM2	TM3SC 28C36-144-3U	3UIDE60 TM
	M 46 ~			TM4SC D42-16-3U	3UIDE60 TM
	M 47 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 2.5 ISO TM2		
	M 52 ~	TM2C32-5	5I 2.5 ISO TM2	TM5SC D48-22-3U	3UIDE60 TM
	M 60 ~			TM6SC D56-22-3U	3UIDE60 TM
	M 73 ~	TMSH-D63-FMA25.4-5	5I 2.5 ISO TM2		
	M 90 ~	TMSH-D80-FMA25.4-5	5I 2.5 ISO TM2		
	M110 ~	TMSH-D100-FMA31.75-5	5I 2.5 ISO TM2		
	M135 ~	TMSH-D125-FMA38.1-5	5I 2.5 ISO TM2		
P3	M 24 ~ M35	TMC25-4 124/002	4I 3.0 ISO TM 028/007		
	M 27 ~			TM2SC 18C23-86-2U	2UIDC60 TM
	M 30 ~			TM3SC 20C26-105-2U	2UIDC60 TM
	M 35 ~			TM4SC 25C31-115-2U	2UIDC60 TM
	M 36 ~ M42	TMC25-5、TMLC25-5	5I 3.0 ISO TM 028/009		
	M 37 ~	TMC25-5 124/004	5I 3.0 ISO TM2		
	M 41 ~			TM3SC 28C36-144-3U	3UIDE60 TM
	M 42 ~	TMC25-5、TMLC25-5	5I 3.0 ISO TM2		
	M 47 ~	TMC32-6B	6BI 3.0 ISO TM2		
	M 48 ~			TM4SC D42-16-3U	3UIDE60 TM
	M 50 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 3.0 ISO TM2		
	M 52 ~			TM5SC D48-22-3U	3UIDE60 TM
	M 55 ~	TM2C32-5	5I 3.0 ISO TM2		
	M 58 ~	TMC40-6B、TMLC42-6B	6BI 3.0 ISO TM2		
	M 60 ~			TM6SC D56-22-3U	3UIDE60 TM
	M 75 ~	TMSH-D63-FMA25.4-5	5I 3.0 ISO TM2		
	M 92 ~	TMSH-D80-FMA25.4-6B	6BI 3.0 ISO TM2		
		TMSH-D80-FMA25.4-5	5I 3.0 ISO TM2		
	M112 ~	TMSH-D100-FMA31.75-5	5I 3.0 ISO TM2		
	M137 ~	TMSH-D125-FMA38.1-5	5I 3.0 ISO TM2		
P3.5	M 30 ~			TM2SC 18C23-86-2U	2UIDC60 TM
				TM3SC 20C26-105-2U	2UIDC60 TM
	M 30 ~ M37	TMC25-5 124/004	5I 3.5 ISO TM 028/008		
	M 36 ~			TM4SC 25C31-115-2U	2UIDC60 TM
	M 41 ~	TMC25-5 124/004	5I 3.5 ISO TM2		
	M 42 ~			TM3SC 28C36-144-3U	3UIDE60 TM
	M 46 ~	TMC25-5、TMLC25-5	5I 3.5 ISO TM2		
	M 48 ~			TM4SC D42-16-3U	3UIDE60 TM
	M 53 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 3.5 ISO TM2		
	M 54 ~			TM5SC D48-22-3U	3UIDE60 TM
	M 58 ~	TM2C32-5	5I 3.5 ISO TM2		
	M 62 ~			TM6SC D56-22-3U	3UIDE60 TM
	M 77 ~	TMSH-D63-FMA25.4-5	5I 3.5 ISO TM2		
	M 94 ~	TMSH-D80-FMA25.4-5	5I 3.5 ISO TM2		

※蓝色字体部分为特别订制产品。

※ Blue characteres are special order items.

下一页
尺寸 Size M114 ~ M103 NEXT

工具选定表 Selection Chart

上一页
FROM 尺寸 Size M53 ~ M94

螺距 Pitch	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
P3.5	M114 ~	TMSH-D100-FMA31.75-5	5I 3.5 ISO TM2		
	M139 ~	TMSH-D125-FMA38.1-5	5I 3.5 ISO TM2		
P4	M 36 ~			TM2SC 18C23-86-2U	2UIDC60 TM
				TM3SC 20C26-105-2U	2UIDC60 TM
				TM4SC 25C31-115-2U	2UIDC60 TM
	M 36 ~ M42	TMC25-5、TMLC25-5	5I 4.0 ISO TM 028/010		
	M 42 ~			TM3SC 28C36-144-3U	3UIDH60 TM
	M 44 ~	TMC25-5 124/004	5I 4.0 ISO TM2		
	M 48 ~	TMC25-5、TMLC25-5	5I 4.0 ISO TM2	TM4SC D42-16-3U	3UIDH60 TM
	M 54 ~	TMC32-6B	6BI 4.0 ISO TM2		
	M 55 ~			TM5SC D48-22-3U	3UIDH60 TM
	M 56 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 4.0 ISO TM2		
	M 60 ~	TMC40-6B	6BI 4.0 ISO TM2		
	M 62 ~	TM2C32-5	5I 4.0 ISO TM2		
	M 64 ~			TM6SC D56-22-3U	3UIDH60 TM
	M 68 ~	TMLC42-6B	6BI 4.0 ISO TM2		
	M 78 ~	TMSH-D63-FMA25.4-5	5I 4.0 ISO TM2		
	M 95 ~	TMSH-D80-FMA25.4-6B	6BI 4.0 ISO TM2		
		TMSH-D80-FMA25.4-5	5I 4.0 ISO TM2		
	M115 ~	TMSH-D100-FMA31.75-5	5I 4.0 ISO TM2		
	M140 ~	TMSH-D125-FMA38.1-5	5I 4.0 ISO TM2		
P4.5	M 42 ~			TM3SC 28C36-144-3U	3UIDH60 TM
	M 42 ~ M52	TMC25-5、TMLC25-5	5I 4.5 ISO TM 028/011		
	M 48 ~	TMC25-5 124/004	5I 4.5 ISO TM2	TM4SC D42-16-3U	3UIDH60 TM
	M 53 ~	TMC25-5、TMLC25-5	5I 4.5 ISO TM2		
	M 54 ~			TM5SC D48-22-3U	3UIDH60 TM
	M 58 ~	TMC32-6B	6BI 4.5 ISO TM2		
	M 60 ~	TMC32-5、TMLC32-5、TMNC32-5	5I 4.5 ISO TM2		
		TMC40-6B	6BI 4.5 ISO TM2		
	M 62 ~			TM6SC D56-22-3U	3UIDH60 TM
	M 66 ~	TM2C32-5	5I 4.5 ISO TM2		
	M 70 ~	TMLC42-6B	6BI 4.5 ISO TM2		
	M 80 ~	TMSH-D63-FMA25.4-5	5I 4.5 ISO TM2		
	M 97 ~	TMSH-D80-FMA25.4-6B	6BI 4.5 ISO TM2		
		TMSH-D80-FMA25.4-5	5I 4.5 ISO TM2		
	M117 ~	TMSH-D100-FMA31.75-5	5I 4.5 ISO TM2		
	M142 ~	TMSH-D125-FMA38.1-5	5I 4.5 ISO TM2		
P5	M 48 ~	TMC32-6B	6BI 5.0 ISO TM2	TM3SC 28C36-144-3U	3UIDH60 TM
				TM4SC D42-16-3U	3UIDH60 TM
	M 54 ~			TM5SC D48-22-3U	3UIDH60 TM
	M 58 ~	TMC40-6B	6BI 5.0 ISO TM2		
	M 62 ~			TM6SC D56-22-3U	3UIDH60 TM
	M 72 ~	TMLC42-6B	6BI 5.0 ISO TM2		
	M 99 ~	TMSH-D80-FMA25.4-6B	6BI 5.0 ISO TM2		
P5.5	M 56 ~	TMC32-6B	6BI 5.5 ISO TM2	TM3SC 28C36-144-3U	3UIDH60 TM
				TM4SC D42-16-3U	3UIDH60 TM
				TM5SC D48-22-3U	3UIDH60 TM
	M 60 ~	TMC40-6B	6BI 5.5 ISO TM2		
	M 63 ~			TM6SC D56-22-3U	3UIDH60 TM
	M 74 ~	TMLC42-6B	6BI 5.5 ISO TM2		
	M101 ~	TMSH-D80-FMA25.4-6B	6BI 5.5 ISO TM2		
P6	M 64 ~	TMC32-6B、TMC40-6B	6BI 6.0 ISO TM2	TM3SC 28C36-144-3U	3UIDH60 TM
				TM4SC D42-16-3U	3UIDH60 TM
				TM5SC D48-22-3U	3UIDH60 TM
				TM6SC D56-22-3U	3UIDH60 TM
	M 76 ~	TMLC42-6B	6BI 6.0 ISO TM2		
	M103 ~	TMSH-D80-FMA25.4-6B	6BI 6.0 ISO TM2		

※蓝色字体部分为特别订制产品。

※ Blue characteres are special order items.

HYPRO螺纹铣刀 HYPRO PLANET CUTTER (THREAD MILLING CUTTER)

工具选定表 Selection Chart

■美制内螺纹用 Unified screw thread (internal)

牙数 T.P.I.	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
48	1/2 ～	TMC12-2、TMC20-2	2I 48 UN TM2		
	3/4 ～	TM2C20-2	2I 48 UN TM2		
32	9/16～	TMC12-2、TMC20-2	2I 32 UN TM2		
	11/16～	TMC16-3 124/001 TMNC16-3	3I 32 UN TM2		
	3/4 ～	TM2C20-2	2I 32 UN TM2		
		TMC16-3	3I 32 UN TM2		
	7/8 ～	TMNC20-3、TMC20-3	3I 32 UN TM2		
	1 ～	TMLC25-3	3I 32 UN TM2		
	1 1/8 ～	TM2C25-3	3I 32 UN TM2		
28	9/16～	TMC12-2、TMC20-2	2I 28 UN TM2		
	3/4 ～	TMC16-3、TMC16-3 124/001 TMNC16-3	3I 28 UN TM2		
	13/16～	TM2C20-2	2I 28 UN TM2		
		TMC16-3	3I 28 UN TM2		
	7/8 ～	TMNC20-3	3I 28 UN TM2		
	15/16～	TMC20-3	3I 28 UN TM2		
	1 ～	TMLC25-3	3I 28 UN TM2		
	1 3/16 ～	TM2C25-3	3I 28 UN TM2		
24	9/16 ～	TMC12-2、TMC20-2	2I 24 UN TM2		
	3/4 ～	TMC16-3 124/001 TMNC16-3	3I 24 UN TM2		
	13/16 ～	TM2C20-2	2I 24 UN TM2		
		TMC16-3	3I 24 UN TM2		
	7/8 ～	TMNC20-3	3I 24 UN TM2		
	15/16～	TMC20-3	3I 24 UN TM2		
	1 ～	TMLC25-3	3I 24 UN TM2		
	1 1/8 ～	TMC25-5 124/004	5I 24 UN TM2		
	1 3/16 ～	TM2C25-3	3I 24 UN TM2		
	1 5/16 ～	TMC25-5、TMLC25-5	5I 24 UN TM2		
	1 5/8 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 24 UN TM2		
	1 7/8 ～	TM2C32-5	5I 24 UN TM2		
20	5/8 ～	TMC12-2、TMC20-2	2I 20 UN TM2		
	13/16 ～	TMC16-3 124/001 TMNC16-3	3I 20 UN TM2		
	7/8 ～	TM2C20-2	2I 20 UN TM2		
		TMC16-3	3I 20 UN TM2		
	15/16～	TMNC20-3	3I 20 UN TM2		
	1 ～	TMC20-3	3I 20 UN TM2		
	1 1/16 ～	TMLC25-3	3I 20 UN TM2		
	1 3/16 ～	TM2C25-3	3I 20 UN TM2		
		TMC25-5 124/004	5I 20 UN TM2		
	1 3/8 ～	TMC25-5、TMLC25-5	5I 20 UN TM2		
	1 5/8 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 20 UN TM2		
	1 7/8 ～	TM2C32-5	5I 20 UN TM2		
18	11/16 ～	TMC12-2、TMC20-2	2I 18 UN TM2		
	13/16 ～	TMC16-3 124/001 TMNC16-3	3I 18 UN TM2		
	7/8 ～	TM2C20-2	2I 18 UN TM2		
		TMC16-3	3I 18 UN TM2		
	15/16～	TMNC20-3	3I 18 UN TM2		
	1 ～	TMC20-3	3I 18 UN TM2		
	1 1/16 ～	TMLC25-3	3I 18 UN TM2		
	1 3/16 ～	TMC25-5 124/004	5I 18 UN TM2		
	1 1/4 ～	TM2C25-3	3I 18 UN TM2		
	1 3/8 ～	TMC25-5、TMLC25-5	5I 18 UN TM2		

※蓝色字体部分为特别订制产品。

※ Blue characteres are special order items.

下一页
尺寸 Size 1 11/16 ～ 1 1/8 NEXT

工具选定表 Selection Chart

上一页
FROM 尺寸 Size ½ ~ 1⅜

牙数 T.P.I.	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
18	1 11/16 ~	TMC32-5、TMLC32-5 TMNC32-5	5I 18 UN TM2		
	1 15/16 ~	TM2C32-5	5I 18 UN TM2		
16	11/16 ~	TMC12-2、TMC20-2	2I 16 UN TM2		
	13/16 ~	TMC16-3 124/001 TMNC16-3	3I 16 UN TM2		
	7/8 ~	TM2C20-2	2I 16 UN TM2		
		TMC16-3	3I 16 UN TM2		
	15/16 ~	TMNC20-3	3I 16 UN TM2		
	1 ~	TMC20-3	3I 16 UN TM2	TM2SC 18C23-86-2U	2UIDB60 TM
	1 1/16 ~	TMLC25-3	3I 16 UN TM2		
	1 1/8 ~			TM3SC 20C26-105-2U	2UIDB60 TM
	1 3/16 ~	TMC25-5 124/004	5I 16 UN TM2		
	1 1/4 ~	TM2C25-3	3I 16 UN TM2		
	1 3/8 ~			TM4SC 25C31-115-2U	2UIDB60 TM
	1 7/16 ~	TMC25-5、TMLC25-5	5I 16 UN TM2		
	1 9/16 ~			TM3SC 28C36-144-3U	3UIDB60 TM
	1 11/16 ~	TMC32-5、TMLC32-5 TMNC32-5	5I 16 UN TM2		
	1 3/4 ~			TM4SC D42-16-3U	3UIDB60 TM
	1 15/16 ~	TM2C32-5	5I 16 UN TM2		
	2 ~			TM5SC D48-22-3U	3UIDB60 TM
	2 3/8 ~			TM6SC D56-22-3U	3UIDB60 TM
14	11/16 ~	TMC12-2、TMC20-2	2I 14 UN TM2		
	7/8 ~	TMC16-3 124/001 TMNC16-3	3I 14 UN TM2		
	15/16 ~	TM2C20-2	2I 14 UN TM2		
		TMC16-3	3I 14 UN TM2		
	1 ~	TMNC20-3、TMC20-3	3I 14 UN TM2	TM2SC 18C23-86-2U	2UIDB60 TM
	1 1/8 ~	TMLC25-3	3I 14 UN TM2	TM3SC 20C26-105-2U	2UIDB60 TM
	1 1/4 ~	TM2C25-3	3I 14 UN TM2		
		TMC25-5 124/004	5I 14 UN TM2		
	1 3/8 ~			TM4SC 25C31-115-2U	2UIDB60 TM
	1 7/16 ~	TMC25-5、TMLC25-5	5I 14 UN TM2		
	1 5/8 ~			TM3SC 28C36-144-3U	3UIDB60 TM
	1 3/4 ~	TMC32-5、TMLC32-5 TMNC32-5	5I 14 UN TM2	TM4SC D42-16-3U	3UIDB60 TM
	1 15/16 ~	TM2C32-5	5I 14 UN TM2		
	2 ~			TM5SC D48-22-3U	3UIDB60 TM
	2 3/8 ~			TM6SC D56-22-3U	3UIDB60 TM
13	7/8 ~	TMC16-3、124/001 TMNC16-3	3I 13 UN TM2		
	15/16 ~	TMC16-3	3I 13 UN TM2		
	1 ~	TMNC20-3	3I 13 UN TM2		
	1 1/16 ~	TMC20-3	3I 13 UN TM2		
	1 1/8 ~	TMLC25-3	3I 13 UN TM2		
	1 1/4 ~	TMC25-5 124/004	5I 13 UN TM2		
	1 5/16 ~	TM2C25-3	3I 13 UN TM2		
	1 1/2 ~	TMC25-5、TMLC25-5	5I 13 UN TM2		
	1 3/4 ~	TMC32-5、TMLC32-5 TMNC32-5	5I 13 UN TM2		
	2 ~	TM2C32-5	5I 13 UN TM2		
12	7/8 ~	TMC16-3 124/001 TMNC16-3	3I 12 UN TM2		
	15/16 ~	TMC16-3	3I 12 UN TM2		
	1 ~	TMNC20-3	3I 12 UN TM2		
	1 1/16 ~	TMC20-3	3I 12 UN TM2	TM2SC 18C23-86-2U	2UIDB60 TM
	1 1/8 ~	TMLC25-3	3I 12 UN TM2		

※蓝色字体部分为特别订制产品。

※ Blue characteres are special order items.

下一页
尺寸 Size 1 3/16 ~ 2 3/8 NEXT

HYPRO 螺纹铣刀 HYPRO PLANET CUTTER (THREAD MILLING CUTTER)

工具选定表 Selection Chart

上一页
FROM 尺寸 Size 1 11/16 ～ 1 1/8

牙数 T.P.I.	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
12	1 3/16 ～			TM3SC 20C26-105-2U	2UIDB60 TM
	1 1/4 ～	TMC25-5 124/004	5I 12 UN TM2		
	1 5/16 ～	TM2C25-3	3I 12 UN TM2		
	1 3/8 ～			TM4SC 25C31-115-2U	2UIDB60 TM
	1 1/2 ～	TMC25-5、TMLC25-5	5I 12 UN TM2		
	1 9/16 ～			TM3SC 28C36-144-3U	3UIDB60 TM
	1 3/4 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 12 UN TM2		
	1 13/16 ～			TM4SC D42-16-3U	3UIDB60 TM
	2 ～	TM2C32-5	5I 12 UN TM2	TM5SC D48-22-3U	3UIDB60 TM
	2 3/8 ～			TM6SC D56-22-3U	3UIDB60 TM
11.5	7/8 ～	TMC16-3 124/001 TMNC16-3	3I 11.5 UN TM2		
	15/16 ～	TMC16-3	3I 11.5 UN TM2		
	1 1/16 ～	TMNC20-3、TMC20-3	3I 11.5 UN TM2		
	1 3/16 ～	TMLC25-3	3I 11.5 UN TM2		
	1 1/4 ～	TMC25-5 124/004	5I 11.5 UN TM2		
	1 5/16 ～	TM2C25-3	3I 11.5 UN TM2		
	1 1/2 ～	TMC25-5、TMLC25-5	5I 11.5 UN TM2		
	1 13/16 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 11.5 UN TM2		
	2 ～	TM2C32-5	5I 11.5 UN TM2		
11	1 1/4 ～	TMC25-5 124/004	5I 11 UN TM2		
	1 1/2 ～	TMC25-5、TMLC25-5	5I 11 UN TM2		
	1 3/16 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 11 UN TM2		
	2 ～	TM2C32-5	5I 11 UN TM2		
10	1 1/16 ～			TM2SC 18C23-86-2U	2UIDC60 TM
	1 1/4 ～			TM3SC 20C26-105-2U	2UIDC60 TM
	1 5/16 ～	TMC25-5 124/004	5I 10 UN TM2		
	1 3/8 ～			TM4SC 25C31-115-2U	2UIDC60 TM
	1 9/16 ～	TMC25-5、TMLC25-5	5I 10 UN TM2		
	1 5/8 ～			TM3SC 28C36-144-3U	3UIDE60 TM
	1 7/8 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 10 UN TM2	TM4SC D42-16-3U	3UIDE60 TM
	2 1/16 ～	TM2C32-5	5I 10 UN TM2		
	2 1/4 ～			TM5SC D48-22-3U	3UIDE60 TM
	2 1/2 ～			TM6SC D56-22-3U	3UIDE60 TM
9	1 3/8 ～	TMC25-5 124/004	5I 9 UN TM2		
	1 11/16 ～	TMC25-5、TMLC25-5	5I 9 UN TM2		
	2 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 9 UN TM2		
	2 3/16 ～	TM2C32-5	5I 9 UN TM2		
8	1 1/16 ～			TM2SC 18C23-86-2U	2UIDC60 TM
	1 3/16 ～			TM3SC 20C26-105-2U	2UIDC60 TM
	1 3/8 ～	TMC25-5 124/004	5I 8 UN TM2		
	1 7/16 ～			TM4SC 25C31-115-2U	2UIDC60 TM
	1 5/8 ～			TM3SC 28C36-144-3U	3UIDE60 TM
	1 11/16 ～	TMC25-5、TMLC25-5	5I 8 UN TM2		
	1 13/16 ～			TM4SC D42-16-3U	3UIDE60 TM
	2 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 8 UN TM2		
	2 1/8 ～			TM5SC D48-22-3U	3UIDE60 TM
	2 3/16 ～	TM2C32-5	5I 8 UN TM2		
	2 3/8 ～			TM6SC D56-22-3U	3UIDE60 TM

※蓝色字体部分为特别订制产品。

※ Blue characteres are special order items.

下一页
尺寸 Size 1 1/8 ～ 2 1/2 NEXT

工具选定表 Selection Chart

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FROM 尺寸 Size 1 3/16 ～ 2 3/8

牙数 T.P.I.	尺寸 Thread Size	多牙型 Multi Point		单牙型 Single Point	
		适用刀体 Tool Body	适用刀片 Insert	适用刀体 Tool Body	适用刀片 Insert
7	1 1/8 ～			TM2SC 18C23-86-2U	2UIDC60 TM
	1 1/4 ～			TM3SC 20C26-105-2U	2UIDC60 TM
	1 1/2 ～	TMC25-5 124/004	5I 7 UN TM2		
	1 13/16 ～	TMC25-5、TMLC25-5	5I 7 UN TM2		
	2 1/8 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 7 UN TM2		
	2 11/16 ～	TM2C32-5	5I 7 UN TM2		
6	1 3/8 ～			TM2SC 18C23-86-2U	2UIDC60 TM
				TM3SC 20C26-105-2U	2UIDC60 TM
	1 1/2 ～			TM4SC 25C31-115-2U	2UIDC60 TM
	1 5/8 ～	TMC25-5 124/004	5I 6 UN TM2	TM3SC 28C36-144-3U	3UIDH60 TM
	1 15/16 ～			TM4SC D42-16-3U	3UIDH60 TM
	2 ～	TMC25-5、TMLC25-5	5I 6 UN TM2		
	2 1/8 ～			TM5SC D48-22-3U	3UIDH60 TM
	2 3/16 ～	TMC32-6B	6BI 6 UN TM2		
	2 1/4 ～	TMC32-5、TMLC32-5 TMNC32-5	5I 6 UN TM2		
	2 7/16 ～	TM2C32-5	5I 6 UN TM2		
	2 3/8 ～	TMC40-6B	6BI 6 UN TM2		
	2 1/2 ～			TM6SC D56-22-3U	3UIDH60 TM
	2 9/16 ～	TMLC42-6B	6BI 6 UN TM2		
5	1 3/4 ～			TM3SC 28C36-144-3U	3UIDH60 TM
	1 7/8 ～	TMC32-6B	6BI 5 UN TM2		
	1 15/16 ～			TM4SC D42-16-3U	3UIDH60 TM
	2 3/16 ～			TM5SC D48-22-3U	3UIDH60 TM
	2 5/16 ～	TMC40-6B	6BI 5 UN TM2		
	2 1/2 ～			TM6SC D56-22-3U	3UIDH60 TM
	2 7/8 ～	TMLC42-6B	6BI 5 UN TM2		
4.5	2 ～	TMC32-6B	6BI 4.5 UN TM2	TM3SC 28C36-144-3U	3UIDH60 TM
				TM4SC D42-16-3U	3UIDH60 TM
	2 1/4 ～	TMLC42-6B	6BI 4.5 UN TM2	TM5SC D48-22-3U	3UIDH60 TM
	2 3/8 ～	TMC40-6B	6BI 4.5 UN TM2		
	1 15/16 ～	TMLC42-6B	6BI 4.5 UN TM2		
	2 1/2 ～			TM6SC D56-22-3U	3UIDH60 TM
4	2 1/16 ～	TMLC42-6B	6BI 4 UN TM2		
	2 1/2 ～	TMC32-6B、TMC40-6B	6BI 4 UN TM2	TM3SC 28C36-144-3U	3UIDH60 TM
				TM4SC D48-16-3U	3UIDH60 TM
				TM5SC D48-22-3U	3UIDH60 TM
				TM6SC D56-22-3U	3UIDH60 TM

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※ Blue characteres are special order items.

G-LIST No. | **FL1062**

HYPRO 螺纹铣刀单牙型 HYPRO PLANET CUTTER (THREAD MILLING CUTTER) SINGLE POINT

HY-PRO P PNTC 单牙型

切削条件 Cutting Conditions | P.852

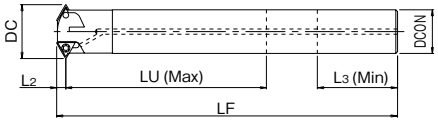
直柄型刀体的名称记号一览表 Explanation

T M 4 S C 2 5 C 3 1 - 1 1 5 - 2 U

表示螺纹铣刀的意思 Thread Milling	刃数 No.of Flutes	形状型号 Shape Type	有无油孔 Oil hole	柄径 Shank Size	柄部形状 Shank Shape	工具径 DC	最大加工长 LU	可使用刀片尺寸 Insert Size
		S 单牙型 Single Point (全部为S) All sizes are listed as S.	C 有油孔 Internal Coolant (全部为C) All sizes are with oil hole.		C 直柄 Single Shank (全部为C) All sizes are listed as C.			

刀片尺寸编号 Insert Size No.	刀片尺寸 Insert Size	刀片内接圆直径 Inscribed Circle
2U	1/4"U	6.35mm
3U	3/8"U	10 mm

■单牙刀体(直柄)
Single point body (Straight Shank)



单位 :mm Unit:mm

商品号 EDP No.	名称 Type	刀片尺寸编号 Insert Size No.	全长 LF	最大加工长 LU	牙的位置 L2	最小把持长度 L3	柄径 DCON	外径 DC	刃数 ZEFP	库存 Stock
7710871	**TM2SC 18C23- 86-2U**	2U	166	86	5.4	40	18	23.3	2	●
7710872	**TM3SC 20C26-105-2U**		186	105	5.4	40	20	26	3	
7710873	**TM4SC 25C31-115-2U**		196	115	5.4	46	25	31	4	
7710874	**TM3SC 28C36-144-3U**	3U	222	144	8	60	28	36.5	3	

·单牙刀体为内螺纹专用。 · Single point body is available only for milling internal threads.
·最大加工长度，是一般使用场合下的参考值。 · The maximum milling length is a reference value for general use.
·最小把持长度为参考值。请优先使用刀具的最小把持长度。
· The minimum holding length is a reference value. The minimum holding length of the tooling to be used takes precedence.
·安装刀片时，请参照「工具选定表(P.523~)」及NC 编程软件「ThreadPro」的自动工具检索结果。
· To use in combination with a insert, please refer to the "Tool Selection Guide by Screw Size" on p.523~ or utilize our NC code generator software"ThreadPro" to automatically select the best option available.

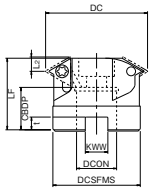
刀盘型刀体的名称记号一览表 Explanation

T M 6 S C D 5 6 - 2 2 - 3 U

表示螺纹铣刀的意思 Thread Milling	刃数 No. of Flutes	形状型号 Shape Type	有无油孔	D+外径 D + DC	孔径 DCON	可使用刀片尺寸 Insert Size
		S 单牙型 Single point (全部为S) All sizes are listed as S.	C 有油孔 Internal Coolant (全部为C) All sizes are with oil hole.	DC尺寸为 ϕ42, 48, 56 D2 sizes: ϕ42, 48, 56	DCON尺寸为 ϕ16, 22 d1 sizes: ϕ16, 22	

刀片尺寸编号 Insert Size No.	刀片尺寸 Insert Size	刀片内接圆直径 Inscribed Circle
3U	3/8"U	10mm

■单牙刀体(刀盘型)
Single point body (Bore Type)



单位 :mm Unit:mm

商品号 EDP No.	名称 Type	刀片尺寸编号 Insert Size No.	外径 DC	KWW	孔径 DCON	DCSFMS	全长 LF	CBDP	t	牙的位置 L2	刃数 ZEFP	夹具紧固螺丝 Clamping Bolt	库存 Stock
—	**TM4SC D42-16-3U**	3U	42	8.4	16	34	40	19.6	5.6	8	4	M 8 ×1.25	*
—	**TM5SC D48-22-3U**		48	10.4	22	40	40	21.1	6.3	8	5	M10 ×1.5	
7710881	**TM6SC D56-22-3U**		56	10.4	22	48	40	21.1	6.3	8	6	M10 ×1.5	●

·单牙刀体为内螺纹专用。 · Single point body is available only for milling internal threads.
*印有*的是定制产品。标准价格请咨询销售。 · Sizes marked with * are special order items.
·请配合FMH型面铣刀夹具使用。 · Please use with FMH type face mill arbor.
·安装刀片时，请参照「工具选定表(P.523~)」及NC 编程软件「ThreadPro」的自动工具检索结果。
· To use in combination with a insert, please refer to the "Tool Selection Guide by Screw Size" on p.523~ or utilize our NC code generator software"ThreadPro" to automatically select the best option available.

●=标准库存品 ●=Standard stock item.

HYPRO 螺纹铣刀单牙型 HYPRO PLANET CUTTER (THREAD MILLING CUTTER) SINGLE POINT

HY-PRO P PC-CTI 单牙型

刀片 PC-CTI 的名称记号一览表 Explanation

2 U I D B 6 0 T M

刀片尺寸编号 Insert Size No.	刀片尺寸 Insert Size	刀片内接圆直径 Inscribed Circle
2U	¼"U	6.35mm
3U	⅜"U	10 mm

内螺纹用 Internal thread

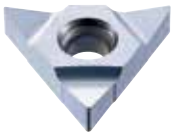
适用螺距・牙数 Pitch and T.P.I.	适用螺距 Pitch	适用牙数 T.P.I
DB	1.5-2	16-12
DC	2.5-4	10- 6
DE	2.5-3.5	10- 7
DH	4 -6	6- 4

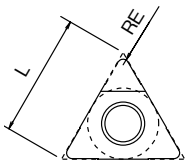
适用螺纹种类 Applicable thread types	
60	公制螺纹，美制螺纹 Metric・Unified Screw Thread

表示螺纹铣刀的意思 Thread Milling

■公制内螺纹用・美制内螺纹用刀片 Inserts for Metric and Unified screw thread (internal)

CARBIDE TiCN





刀片材质 Tool Material	表面处理 Surface Treatment	用途 Application	
		一般用 General Application	铝合金・铝合金铸件用 Aluminum Alloy・Aluminum Alloy Casting
VBX	TiCN	◎	◎

单位 :mm Unit:mm

商品号 EDP No.	名称 Type	刀片尺寸编号 Insert Size No.	适用螺纹 Applicable Thread 螺距 TP	适用螺纹 Applicable Thread 牙数 TPI	L	圆弧角 RE	材质 Tool Material	库存 Stock
7716551	**2UIDB60 TM**	2U	1.5 ～ 2	16 ～ 12	11	0.06	VBX	
7716552	**2UIDC60 TM**		2.5 ～ 4	10 ～ 6	11	0.14	VBX	
7716553	**3UIDB60 TM**	3U	1.5 ～ 2	16 ～ 12	16	0.06	VBX	●
7716554	**3UIDE60 TM**		2.5 ～ 3.5	10 ～ 7	16	0.14	VBX	
7716555	**3UIDH60 TM**		4 ～ 6	6 ～ 4	16	0.25	VBX	

・安装刀片时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
・To use in combination with bodies, please refer to the "Tool Selection Guide by Screw Size" on p.523 or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
・单面可使用三个圆弧角。 ・Three corners per side can be used.

■零件(直柄型) Spare Parts（Straight Shank)

刀片尺寸编号 Insert Size No.	紧固螺丝 Screw				扳手 Wrench	
	商品号 EDP No.	型号 Designation	螺纹尺寸 Thread Size	全长※ OAL	商品号 EDP No.	型号 Designation
2U	7710942	SN2T	M2.6×0.45	6.5	7808205	T8-D(Torx8)
3U	7710973	SA3T	No.5-40UNC	12	7808207	T10-D(Torx10)

※全长包括螺钉头部。Overall Length includes screw head.

■零件(刀盘型) Spare Parts（Bore Type)

刀片尺寸编号 Insert Size No.	紧固螺丝 Screw				扳手 Wrench	
	商品号 EDP No.	型号 Designation	螺纹尺寸 Thread Size	全长※ OAL	商品号 EDP No.	型号 Designation
3U	7710943	SN3T	No.5-40UNC	9.5	7808207	T10-D(Torx10)

※全长包括螺钉头部。Overall Length includes screw head.

●=标准库存品 ●=Standard stock item.

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

G-LIST No. | **FL1062**

HYPRO 螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PNTC 多牙型

切削条件 Cutting Conditions | P.852

直柄型刀体的名称记号一览表 Explanation

T M N C 2 0 - 3 L H

表示螺纹铣刀的意思 Thread Milling

形状型号 Shape Type	
无 Non	单刃标准型 Standard, 1 Insert
L	单刃长柄型 Long Neck, 1 Insert
2	2刃高效率型 with 2 Inserts
N	单刃锥管螺纹用 for Taper Pipe Threads

有无油孔 Oil hole	
C	有油孔 Internal Coolant

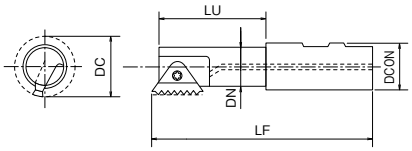
(全部为C) All sizes are with oil hole.

柄径 Shank Size: 柄径尺寸为 ϕ12~42. Shank Sizes: ϕ12 to 42

可使用刀片尺寸 Insert Size		
刀片尺寸编号 Insert Size No.	刀片尺寸 Insert Size	刀片内接圆直径 Inscribed Circle
2	1/4"	6.35 mm
3	3/8"	10 mm
4	1/2"	12.7 mm
5	5/8"	15.875mm
6B	3/4"B	19.05 mm

加工方向型号 Type	
无 Non	右手用刀体 Right Hand
124/***	
LH	左手用刀体 Left Hand

■TMC刀体 (单刃·标准型) (with 1 insert• Standard)



2019年10月起，刀体颜色将依次变更。
The color of the tool body will change sequentially from October 2019 单位:mm Unit:mm

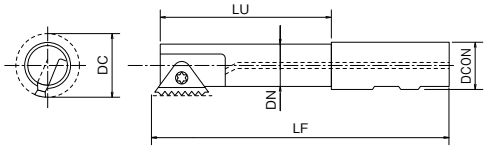
商品号 EDP No.	名称 Type	刀片尺寸编号 Insert Size No.	全长 LF	颈长 LU	柄径 DCON	颈径 DN	外径 DC	库存 Stock
7710112	**TMC12- 2**	2	70	12	12	8.9	11.5	●
7710132	**TMC20- 2**		85	20	20	8.9	11.5	
7710232	**TMC20- 2 LH**		85	20	20	8.9	11.5	
7710023	**TMC16- 3 124/001**	3	91	20.5	16	12.2	15.5	
7710123	**TMC16- 3**		90	22	16	13.6	17	
7710133	**TMC20- 3**		95	43	20	16.6	20	
7710044	**TMC25- 4 124/002**	4	88	30	25	13.4	18	
7710045	**TMC25- 5 124/004**	5	98	40	25	19	25	
7710145	**TMC25- 5**		110	52	25	24	30	
7710245	**TMC25- 5 LH**		110	52	25	24	30	
7710155	**TMC32- 5**		120	58	32	31	37	
7710156	**TMC32- 6 B**	6B	115	53	32	27	35	
–	**TMC40- 6 B**		135	63	40	38	46	*

*印有*的是定制产品。标准价格请咨询销售。
Sizes marked with * are special order items.

・LH刀体的注意点请参照 P.534。
For cautions of using LH Body : please refer to p.534.

1. 切削油剂请参考 P.1004。
1. Cutting fluid and Paste : Please refer to p.1004.
2. 安装刀片时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with a insert, please refer to the "Tool Selection Guide by Screw Size" on p.523~ or utilize our NC code generator software "ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。
3. Please select "stairs" for the path type in ThreadPro.

■TMLC刀体(单刃·长柄型) (with 1 insert• Long)



2019年10月起，刀体颜色将依次变更。
The color of the tool body will change sequentially from October 2019 单位:mm Unit:mm

商品号 EDP No.	名称 Type	刀片尺寸编号 Insert Size No.	全长 LF	颈长 LU	柄径 DCON	颈径 DN	外径 DC	库存 Stock
7710343	**TMLC25 - 3**	3	125	25	25	18.6	22	●
7710345	**TMLC25 - 5**	5	150	92	25	24	30	
7710355	**TMLC32 - 5**		160	98	32	31	37	
7710366	**TMLC42 - 6B**	6B	200	80	42	45	53	

1. 切削油剂请参考 P.1004。
1. Cutting fluid and Paste : Please refer to p.1004.
2. 安装刀片时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with a insert, please refer to the "Tool Selection Guide by Screw Size" on p.523~ or utilize our NC code generator software "ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。
3. Please select "stairs" for the path type in ThreadPro.

●=标准库存品 ●=Standard stock item.

HYPRO螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PNTC 多牙型

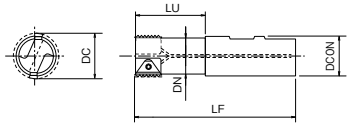
切削条件 Cutting Conditions | P.852

■TM2C刀体(2刃·高效率型)
(with 2 inserts)

2019年10月起，刀体颜色将依次变更。
The color of the tool body will change sequentially from October 2019

单位:mm Unit:mm

商品号 EDP No.	名称 Type	刀片尺寸编号 Insert Size No.	全长 LF	颈长 LU	柄径 DCON	颈径 DN	外径 DC	库存 Stock
7710532	**TM2C20 - 2**	2	85	20	20	14.4	17	●
7710543	**TM2C25 - 3**	3	100	43	25	22.5	26	
7710555	**TM2C32 - 5**	5	120	45	32	36	42	



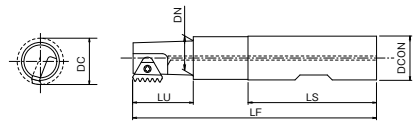
1. 切削油剂请参考P.1004。
1. Cutting fluid and Paste : Please refer to p.1004.
2. ThreadPro 的路径类型请选择"多刃同时进给"。
2. Please select "stairs" for the path type in ThreadPro.

■TMNC刀体 (单刃·锥管螺纹用)
(with 1 insert• for Taper pipe threads)

2019年10月起，刀体颜色将依次变更。
The color of the tool body will change sequentially from October 2019

单位:mm Unit:mm

商品号 EDP No.	名称 Type	刀片尺寸编号 Insert Size No.	全长 LF	颈长 LU	柄径 DCON	柄长 LS	颈径 DN	外径 DC	库存 Stock
7710723	**TMNC16 - 3**	3	90	22	16	48	12.5	15.5	●
7710823	**TMNC16 - 3LH**		90	22	16	48	12.5	15.5	
7710733	**TMNC20 - 3**		85	23	20	50.9	15	19	
7710833	**TMNC20 - 3LH**		85	23	20	50.9	15	19	
—	**TMNC32- 5**	5	120	58	32	60.3	31	37	*
—	**TMNC32- 5LH**		120	58	32	60.3	31	37	



印有*的是定制产品。标准价格请咨询销售。
Sizes marked with * are special order items.
・LH刀体请参考下列说明。
For cautions of using LH Body : please refer to the precautions below.
1. 切削油剂请参考P.1004。
1. Cutting fluid and Paste : Please refer to p.1004.
2.安装刀片时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2.To use in combination with a insert, please refer to the "Tool Selection Guide by Screw Size" on p.523~ or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。
3. Please select "stairs" for the path type in ThreadPro.

■零件 Spare Parts

刀片尺寸编号 Insert Size No.	适用刀体 Applicable Body	紧固螺丝 Screw				扳手 Wrench	
		商品号 EDP No.	型号 Designation	螺纹尺寸 Thread Size	全长※ OAL	商品号 EDP No.	尺寸 Designation
2	所有	7710902	SN2TM	M 2.6 × 0.45	5.9	7808205	T8-D(Torx8)
3	TMLC25-3 TM2C25-3	7710943	SN3T	No.5-40UNC	9.5	7808207	T10-D(Torx10)
	上述以外的	7710903	SN3TM	No.5-40UNC	8		
4	所有	7710904	SN4TM	No.8-32UNC	10.7	7808209	T20-D(Torx20)
5	TMC25-5 124/004	7710955	SA5TM	M 5 × 0.8	12.8	7808210	T25-D(Torx25)
	上述以外的	7710905	SN5TM	M 5 × 0.8	15		
6B	所有	7710907	SM7T	M 7 × 1	15	7808212	T30-T(Torx30)

※全长包括螺钉头部。 Overall Length includes screw head.

管用刀片用刀体选型时的注意
Precautions for selecting bodies for pipe inserts:

・管用刀片有R字记号(或没有)及L字号两面可以使用。
・在使用带R字记号(或没有)的一面时，请使用刀柄末尾不带LH记号的刀体。
・在使用带L字记号的一面时，请使用刀体尾部有LH记号的刀体。
※ 由于刀片的倾斜角不同，同一刀片不能正反两面配合刀体使用。

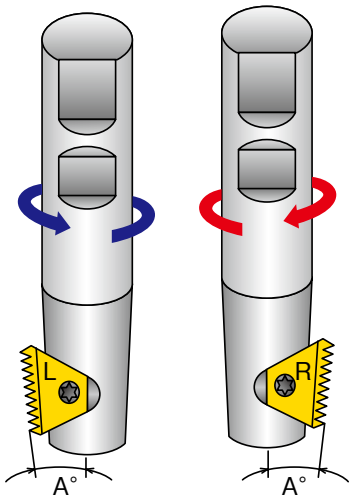
・Two faces of pipe inserts can be used, one marked with (or without) the letter R, and another with the letter L.
・To use a pipe insert with a face marked with (or without) the letter R, use a body that does not have code the LH at the end of its designation.
・To use a pipe insert with a face marked with letter L, use a body that has the code LH at the end of its designation.
※Because an insert is sloped, both faces of an insert cannot be used on the same body.

LH刀体的使用注意点
Precautions for using LH body

・LH刀体为左手用刀体，在加工时请将主轴逆转。
・能加工右螺纹及左螺纹。
・The LH body is left-handed. To mill threads, operate the main shaft in reverse.
・The LH body can be used to mill both right and left-handed threads.

普通刀体的使用注意点
Precautions for using normal body

・普通刀体为右手用刀体。
・能加工右螺纹及左螺纹。
・The normal body is right-handed.
・The normal body can be used to mill both right and left-handed threads.



LH 刀体 LH Body　　普通刀体 Normal Body

●=标准库存品 ●=Standard stock item.

G-LIST No. | **FL1062**

HYPRO螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PNTC 多牙型

切削条件 Cutting Conditions | P.852

刀盘型刀体的名称记号一览表 Explanation

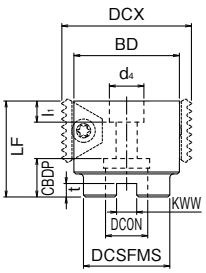
T M S H - D 1 0 0 - F M A 3 1 . 7 5 - 5

表示螺纹铣刀刀盘型的意思 Thread Milling Bore Type	D＋外径 D＋DCX	FMA型 面铣刀夹具用 FMA type face mill arbor	夹具安装孔径 DCON	可使用刀片尺寸 Insert Size
	DCX尺寸 ϕ50～125 DCX sizes: ϕ 50 to 125			

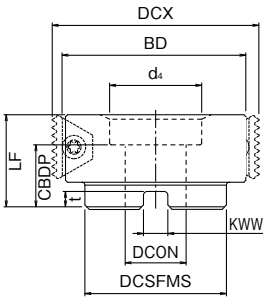
刀片尺寸编号 Insert Size No.	刀片尺寸 Insert Size	刀片内接圆直径 Inscribed Circle
3	3/8"	10 mm
5	5/8"	15.875 mm
6B	3/4"B	19.05 mm

■刀盘型(Bore Type)

Type 1



Type 2



2019年10月起，刀体颜色将依次变更。
The color of the tool body will change sequentially from October 2019

单位:mm Unit:mm

商品号 EDP No.	名称 Description	刀片尺寸编号 Insert Size No.	外径 DCX	BD	KWW	孔径 DCON	d4	DCSFMS	全长 LF	l1	CBDP	t	刃数 ZEFP	形状类型 Type	夹具紧固螺丝 Clamping Bolt	库存 Stock
7710891	**TMSH-D50-FMA25.4-3**	3	50	46.5	9.5	25.4	20	46.5	48	12.5	26	6.3	6	1	M12	●
7710892	**TMSH-D63-FMA25.4-5**	5	63	57	9.5	25.4	20	54.8	48	12.5	26	6.3	4	1	M12	
7710893	**TMSH-D80-FMA25.4-5**		80	74	9.5	25.4	20	54.8	48	12.5	26	6.3	6	1	M12	
7710894	**TMSH-D80-FMA25.4-6B**	6B	80	72	9.5	25.4	20	54.8	48	12.5	26	6.3	5	1	M12	
7710895	**TMSH-D100-FMA31.75-5**	5	100	94	12.7	31.75	48	73.8	48	—	32.3	8	7	2	MBA-M16	
7710896	**TMSH-D125-FMA38.1-5**		125	119	15.9	38.1	60	98.8	61	—	38	10	9	2	MBA-M20	

※请配合FMA型面铣刀夹具使用。 ※Please use with FMA type face mill arbor.

1. 切削油剂请参考P.1004。 1. Cutting fluid and Paste : Please refer to p.1004.
2. 安装刀片时，请参照「工具选定表(P.523～)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with a insert, please refer to the "Tool Selection Guide by Screw Size" on p.523～ or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。 3. Please select "stairs" for the path type in ThreadPro.

■零件 Spare Parts

刀片尺寸编号 Insert Size No.	紧固螺丝 Screw				扳手 Wrench	
	商品号 EDP No.	型号 Designation	螺纹尺寸 Thread Size	全长※ OAL	商品号 EDP No.	型号 Designation
3	7710903	SN3TM	No.5-40UNC	8	7808207	T10-D(Torx10)
5	7710905	SN5TM	M5×0.8	15	7808210	T25-D(Torx25)
6B	7710907	SM7T	M7×1	15	7808212	T30-T(Torx30)

※全长包括螺钉头部。Overall Length includes screw head.

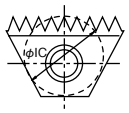
●=标准库存品 ●=Standard stock item.

HYPRO螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PC-CTI 多牙型

刀片PC-CTI的名称记号一览表 Explanation

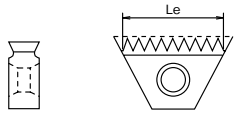
3 I 1.5 I S O T M 2



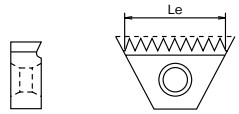
刀片尺寸 Insert Size			用途 Applications		螺距 or 牙数 Pitch or T.P.I.	加工螺纹种类 Thread Type		表示螺纹铣刀的意思 Thread Milling	刀片枚数 Insert	
刀片尺寸编号 Insert Size No.	刀片尺寸 Insert Size	刀片内接圆直径 (IC) Inscribed Circle								
2	¼"	6.35 mm	I	内螺纹用 Internal thread		ISO	公制螺纹 Metric screw threads		028/***	单刃 for 1 piece insert type （粗牙） (applying to corse pitch thread)
3	⅜"	10 mm	E	外螺纹用 External thread		BSPT	英式锥管螺纹 British taper pipe thread		2	单刃及2刃通用 for both 1 and 2 pieces insert type
4	½"	12.7 mm	EI	外螺纹 内螺纹·外螺纹兼用 for both applications		NPTF	美式锥管密封用螺纹 National taper pipe thread for dry sealing			
5	⅝"	15.875mm				W	平行管螺纹 Parallel pipe threads			
6B	¾"B	19.05 mm				UN	美制螺纹 Unified screw threads			

■公制内螺纹用刀片 Inserts for Metric screw thread (internal)

Type 1



Type 2



刀片材质 Tool Material	表面处理 Surface Treatment	库存 Stock
VBX	TiCN	●
VTX	TiAlN	*
VK2	无	*

印有*的是定制产品。标准价格请咨询销售。
・Sizes marked with * are special order items.

CARBIDE　TiCN

单位:mm　Unit:mm

名称 Description	刀片尺寸编号 Insert Size No.	螺距 TP	Le	刃长间的牙数 No. of threads	形状类型 Type	VBX 材质 Material EDP No.	库存 Stock
2I 0.5 ISO TM2	2	0.5	10	20	1	7711082	●
2I 0.75 ISO TM2		0.75	10.5	14	1	7711092	
2I 1.0 ISO TM2		1	10	10	1	7711102	
2I 1.25 ISO TM2		1.25	8.75	7	1	7711112	
2I 1.5 ISO TM2		1.5	10.5	7	1	7711122	
2I 2.0 ISO TM 028/004		2	10	5	1	7711542	
3I 0.5 ISO TM2	3	0.5	15	30	1	7711083	
3I 0.75 ISO TM2		0.75	15	20	1	7711093	
3I 1.0 ISO TM2		1	15	15	1	7711103	
3I 1.25 ISO TM2		1.25	15	12	1	7711113	
3I 1.5 ISO TM2		1.5	15	10	1	7711123	
3I 1.75 ISO TM2		1.75	14	8	1	7711133	
3I 2.0 ISO TM2		2	14	7	1	7711143	
3I 2.5 ISO TM 028/005		2.5	12.5	5	2	7711553	
4I 2.5 ISO TM 028/006	4	2.5	17.5	7	2	7711554	
4I 3.0 ISO TM 028/007		3	18	6	2	7711564	
5I 1.0 ISO TM2	5	1	26	26	1	7711105	
5I 1.25 ISO TM2		1.25	25	20	1	7711115	
5I 1.5 ISO TM2		1.5	25.5	17	1	7711125	
5I 1.75 ISO TM2		1.75	24.5	14	1	7711135	
5I 2.0 ISO TM2		2	24	12	1	7711145	
5I 2.5 ISO TM2		2.5	25	10	1	7711155	
5I 3.0 ISO TM2		3	24	8	1	7711165	
5I 3.0 ISO TM 028/009		3	24	8	1	7711565	
5I 3.5 ISO TM2		3.5	24.5	7	1	7711175	
5I 3.5 ISO TM 028/008		3.5	24.5	7	1	7711575	
5I 4.0 ISO TM2		4	24	6	1	7711185	
5I 4.0 ISO TM 028/010		4	24	6	1	7711585	
5I 4.5 ISO TM2		4.5	22.5	5	1	7711195	
5I 4.5 ISO TM 028/011		4.5	22.5	5	1	7711595	

1. 切削油剂请参考 P.1004。　1. Cutting fluid and Paste : Please refer to p.1004.
2. 安装刀片时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with bodies, please refer to the "Tool Selection Guide by Screw Size" on p.523 or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。　3. Please select "stairs" for the path type in ThreadPro.

下一页
尺寸 Description 6BI NEXT

●=标准库存品　●=Standard stock item.

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

HY-PRO P PC-CTI 多牙型

■公制内螺纹用刀片 Inserts for Metric screw thread (internal)

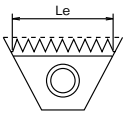
上一页
FROM 尺寸 Description 2I ～ 5I

单位:mm Unit:mm

名称 Description			刀片尺寸编号 Insert Size No.	螺距 TP	Le	刃长间的牙数 No. of threads	形状类型 Type	VBX 材质 Material EDP No.	库存 Stock
6BI	1.5	ISO TM2	6B	1.5	36	24	1	7715456	●
6BI	2.0	ISO TM2		2	36	18	1	7715466	
6BI	3.0	ISO TM2		3	36	12	1	7715476	
6BI	4.0	ISO TM2		4	32	8	1	7715486	
6BI	4.5	ISO TM2		4.5	31.5	7	1	7715496	
6BI	5.0	ISO TM2		5	30	6	1	7715506	
6BI	5.5	ISO TM2		5.5	33	6	1	7715516	
6BI	6.0	ISO TM2		6	30	5	1	7715526	

1. 切削油剂请参考P.1004。 1. Cutting fluid and Paste : Please refer to p.1004.
2.安装刀片时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with bodies, please refer to the "Tool Selection Guide by Screw Size" on p.523 or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。 3. Please select "stairs" for the path type in ThreadPro.

■公制外螺纹用刀片 Inserts for Metric screw thread (external)



刀片材质 Tool Material	表面处理 Surface Treatment	库存 Stock
VBX	TiCN	●
VTX	TiAlN	*
VK2	无	*

印有*的是定制产品。标准价格请咨询销售。
・Sizes marked with * are special order items.

CARBIDE TiCN

单位:mm Unit:mm

名称 Description			刀片尺寸编号 Insert Size No.	螺距 TP	Le	刃长间的牙数 No. of threads	VBX 材质 Material EDP No.	库存 Stock
2E	0.75	ISO TM2	2	0.75	10.5	14	7712092	●
2E	1.0	ISO TM2		1	10	10	7712102	
2E	1.25	ISO TM2		1.25	10	8	7712112	
2E	1.5	ISO TM2		1.5	9	6	7712122	
3E	0.75	ISO TM2	3	0.75	15	20	7712093	
3E	1.0	ISO TM2		1	14	14	7712103	
3E	1.25	ISO TM2		1.25	15	12	7712113	
3E	1.5	ISO TM2		1.5	15	10	7712123	
3E	1.75	ISO TM2		1.75	14	8	7712133	
3E	2.0	ISO TM2		2	14	7	7712143	
5E	1.0	ISO TM2	5	1	26	26	7712105	
5E	1.25	ISO TM2		1.25	25	20	7712115	
5E	1.5	ISO TM2		1.5	25.5	17	7712125	
5E	1.75	ISO TM2		1.75	24.5	14	7712135	
5E	2.0	ISO TM2		2	24	12	7712145	
5E	2.5	ISO TM2		2.5	25	10	7712155	
5E	3.0	ISO TM2		3	24	8	7712165	
5E	3.5	ISO TM2		3.5	24.5	7	7712175	
5E	4.0	ISO TM2		4	24	6	7712185	
5E	4.5	ISO TM2		4.5	22.5	5	7712195	
6BE	1.5	ISO TM2	6B	1.5	36	24	7716456	
6BE	2.0	ISO TM2		2	36	18	7716466	
6BE	3.0	ISO TM2		3	36	12	7716476	
6BE	4.0	ISO TM2		4	32	8	7716486	
6BE	4.5	ISO TM2		4.5	31.5	7	7716496	
6BE	5.0	ISO TM2		5	30	6	7716506	
6BE	5.5	ISO TM2		5.5	33	6	7716516	
6BE	6.0	ISO TM2		6	30	5	7716526	

1. 切削油剂请参考P.1004。 1. Cutting fluid and Paste : Please refer to p.1004.
2.安装刀片时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with bodies, please refer to the "Tool Selection Guide by Screw Size" on p.523 or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。 3. Please select "stairs" for the path type in ThreadPro.

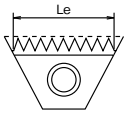
●=标准库存品 ●=Standard stock item.

HYPRO螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PC-CTI 多牙型

■平行管螺纹用刀片(外螺纹,内螺纹通用) Inserts for straight pipe threads (external & internal)

CARBIDE TiCN



刀片材质 Tool Material	表面处理 Surface Treatment	库存 Stock
VBX	TiCN	●
VTX	TiAlN	*
VK2	无	*

印有*的是定制产品。标准价格请咨询销售。
・Sizes marked with * are special order items.

■平行螺纹 Rp(PS),G(PF)

单位:mm Unit:mm

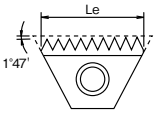
名称 Description	刀片尺寸编号 Insert Size No.	牙数 TPI	Le	刃长间的牙数 No. of threads	适用刀体 Tool body	适用螺纹 Screw thread size	VBX 材质 Material EDP No.	库存 Stock
2EI 19 W TM2	2	19	9.36	7	TMC12-2, TMC20-2	3/8"	7713542	●
2EI 14 W TM2		14	9.07	5	TMC12-2, TMC20-2	1/2" – 5/8"	7713572	
					TM2C20-2	–		
3EI 14 W TM2	3	14	14.51	8	TMC16-3, TMC20-3	3/4", 7/8"	7713573	
3EI 11 W TM2		11	13.85	6	TMC16-3, TMC20-3	1" – 1-1/8"	7713593	
					TM2C25-3	–		
5EI 11 W TM2	5	11	23.09	10	TMC25-5	1-1/4" – 1-1/2", 1-3/4", 2"	7713595	
					TMC32-5	–		
					TM2C32-5	–		

1. 切削油剂请参考 P.1004。
2. ThreadPro 的路径类型请选择"多刃同时进给"。

1. Cutting fluid and Paste : Please refer to p.1004.
2. Please select "stairs" for the path type in ThreadPro.

■锥管螺纹用刀片(外螺纹,内螺纹通用) Inserts for Taper pipe threads (external & internal)

CARBIDE TiCN



■R(PT),Rc(PT)

单位:mm Unit:mm

名称 Description	刀片尺寸编号 Insert Size No.	牙数 TPI	Le	刃长间的牙数 No. of threads	适用刀体 Tool body	适用螺纹 Screw thread size	VBX 材质 Material EDP No.	库存 Stock
2EI 19 BSPT TM2	2	19	9.36	7	TMC12-2, TMC20-2, TMC20-2LH	3/8"	7713042	●
3EI 14 BSPT TM2	3	14	14.51	8	TMNC16-3, TMNC16-3LH	1/2", 3/4"	7713073	
					TMNC20-3, TMNC20-3LH	3/4"		
3EI 11 BSPT TM2		11	13.85	6	TMNC16-3, TMNC16-3LH TMNC20-3, TMNC20-3LH	1", 1-1/4", 1-1/2"	7713093	
5EI 11 BSPT TM2	5	11	23.09	10	TMC25-5 124/004	1-1/4" ~ 4"	7713095	
					TMC25-5, TMC25-5LH, TMLC25-5	1-1/4" ~		
					TMC32-5, TMLC32-5 TMNC32-5*, TMNC32-5LH* TM2C32-5	2" ~		

印有*的是定制产品。标准价格请咨询销售。
1. 切削油剂请参考 P.1004。
2. LH刀体使用时的注意点请参考 P.534。
3. ThreadPro 的路径类型请选择"多刃同时进给"。
4. 螺纹长度比规格短的情况下，也有除上述组合外可使用的情况。

・Sizes marked with * are special order items.
1. Cutting fluid and Paste : Please refer to p.1004.
2. For cautions of using LH Body : please refer to p.534.
3. Please select "stairs" for the path type in ThreadPro.
4. When tapping length is shorter than Le, other options for holder + insert combination may be possible.

ThreadPro

NC编程软件
Thread Milling NC Code Generator Software

※详细请参考 P.540
See p.540 for details

操作者无需选择就可制作加工编程！可对应12国语言，8种NC语言。

●=标准库存品 ●=Standard stock item.

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

G-LIST No. | **FW1008**

HYPRO螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PC-CTI 多牙型

■NPT

单位:mm Unit:mm

名称 Description	刀片尺寸编号 Insert Size No.	牙数 TPI	Le	刃长间的牙数 No. of threads	适用刀体 Tool body	适用螺纹 Screw thread size	VBX 材质 Material EDP No.	库存 Stock
3EI 14 NPT TM2	3	14	14.51	8	TMNC16-3, TMNC16-3LH	½"	7713163	●
					TMC16-3 124/001 TMNC16-3, TMNC16-3LH TMNC20-3, TMNC20-3LH	¾"		
3EI 11.5 NPT TM2	3	11.5	13.25	6		1"～2"	7713183	
5EI 11.5 NPT TM2	5	11.5	24.3	11	TMC25-5 124/004 TMC25-5, TMC25-5LH TMLC25-5	1-¼"	7713285	
					TMC25-5 124/004 TMC25-5, TMC25-5LH TMLC25-5 TMC32-5, TMLC32-5 TMNC32-5*, TMNC32-5LH*	1-½"		
					TMC25-5 124/004 TMC25-5, TMC25-5LH TMLC25-5, TM2C32-5 TMC32-5, TMLC32-5 TMNC32-5*, TMNC32-5LH*	2		
5EI 8 NPT TM2	5	8	22.23	7	TMC25-5 124/004 TMNC32-5*, TMNC32-5LH*	2-½",3"	7713305	

■NPTF

单位:mm Unit:mm

型号 Description	刀片尺寸编号 Insert Size No.	牙数 TPI	Le	刃长间的牙数 No. of threads	适用刀体 Tool body	适用螺纹 Screw thread size	VBX 材质 Material EDP No.	库存 Stock
3EI 14 NPTF TM2	3	14	14.51	8	TMNC16-3, TMNC16-3LH	½"	7713173	●
3EI 14 NPTF TM2		14	14.51	8	TMNC16-3, TMNC16-3LH TMNC20-3, TMNC20-3LH	¾"	7713173	
3EI 11.5 NPTF TM2		11.5	13.25	6		1"～2"	7713193	
5EI 11.5 NPTF TM2	5	11.5	24.3	11	TMC25-5, TMC25-5LH, TMLC25-5 TMC25-5 124/004	1-¼"～2"	7713295	
					TMC32-5, TMLC32-5, TM2C32-5	2"		
5EI 8 NPTF TM2		8	22.23	7	TMNC32-5*, TMNC32-5LH*	2-½",3"	7713315	

印有*的是定制产品。标准价格请咨询销售。
1. 切削油剂请参考P.1004。
2. LH刀体使用时的注意点请参考P.534。
3. ThreadPro 的路径类型请选择"多刃同时进给"。

・Sizes marked with * are special order items.
1. Cutting fluid and Paste : Please refer to p.1004.
2.For cautions of using LH Body : please refer to p.534.
3. Please select "stairs" for the path type in ThreadPro.

■刀片材质一览 Type of Inserts

材质 Material		特点 Features
	VBX	第一推荐一般钢・铸铁 **For general steel and cast iron** ・硬质合金超微粒子+TiCN涂层 Ultra-fine grain carbide and TiCN coating ・耐欠损性和耐磨损性优良的材质 Material with excellent chipping and wear resistance
	VTX	第一推荐不锈钢 **For stainless steel** ・硬质合金超微粒子+TiAlN涂层 Ultra-fine grain carbide and TiAlN coating ・耐欠损性和耐磨损性优良的材质 Material with excellent chipping and wear resistance
	VK2	硬质合金无涂层 **Carbide non-coated** ・最适合铝合金等非铁金属，耐热钢，钛合金的加工 For non-ferrous metals such as aluminum, heat-resistance alloy and titanium alloy

●=标准库存品 ●=Standard stock item.

NC 编程软件 ThreadPro

Revamped Thread Milling NC Code Generator Software "ThreadPro"

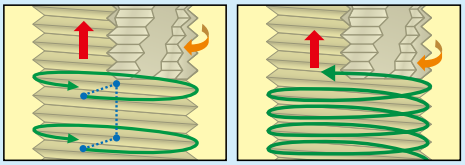
使用NC螺纹铣刀编程软件「ThreadPro」，任何操作者都能简单容易的编制程序。即使是没有电脑的外出目的地，也可使用智能手机或平板电脑进行访问。

Generate codes for complex machining couldn't be easier. Create machining programs at ease with OSG's revamped NC code generator software ThreadPro. ThreadPro can be accessed via smartphones and PC tablets even when you are on the road without a computer.

■ ThreadPro具更全面的功能！ ThreadPro with Comprehensive Features

1) 可轻松制作Zero Cut削程序
Generate programs for zero cut at ease

2) 高品质的同步进给加工
High quality machining by continuous passes



多刃同时阶梯进给 Pass type : stairs　　单刃进给 Pass type : continuous

3) 可以检查加工轨迹从而减少刀具的损伤
Capability to review machining trajectory to reduce tool damage

下载地址
homepage https://www.chinaosg.com/

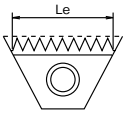
G-LIST No. | **FW1008**

HYPRO螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PC-CTI 多牙型

■美制内螺纹用刀片 Inserts for Unified screw thread (internal)

CARBIDE | TiCN



刀片材质 Tool Material	表面处理 Surface Treatment	库存 Stock
VBX	TiCN	●
VTX	TiAlN	*
VK2	无	*

印有*的是定制产品。标准价格请咨询销售。
・Sizes marked with * are special order items.

单位:mm Unit:mm

名称 Description	刀片尺寸编号 Insert Size No.	牙数 TPI	Le	刃长间的牙数 No. of threads	VBX 材质 Material EDP No.	库存 Stock
2I 48 UN TM2	2	48	10.05	19	7711202	
2I 40 UN TM2		40	10.16	16	7711212	
2I 32 UN TM2		32	10.32	13	7711222	
2I 28 UN TM2		28	9.98	11	7711232	
2I 27 UN TM2		27	10.35	11	7711242	
2I 24 UN TM2		24	9.53	9	7711252	
2I 20 UN TM2		20	10.16	8	7711262	
2I 18 UN TM2		18	9.88	7	7711272	
2I 16 UN TM2		16	9.53	6	7711282	
2I 14 UN TM2		14	9.07	5	7711292	
3I 40 UN TM2	3	40	14.61	23	7711193	
3I 32 UN TM2		32	15.08	19	7711203	
3I 28 UN TM2		28	14.51	16	7711213	
3I 27 UN TM2		27	14.11	15	7711223	
3I 24 UN TM2		24	14.82	14	7711233	
3I 20 UN TM2		20	13.97	11	7711243	
3I 18 UN TM2		18	14.11	10	7711253	
3I 16 UN TM2		16	14.29	9	7711263	
3I 14 UN TM2		14	14.51	8	7711273	
3I 13 UN TM2		13	13.68	7	7711283	
3I 12 UN TM2		12	14.82	7	7711293	●
3I 11.5 UN TM2		11.5	13.25	6	7711303	
5I 24 UN TM2	5	24	25.4	24	7711235	
5I 20 UN TM2		20	25.4	20	7711245	
5I 18 UN TM2		18	25.4	18	7711255	
5I 16 UN TM2		16	25.4	16	7711265	
5I 14 UN TM2		14	25.4	14	7711275	
5I 13 UN TM2		13	25.4	13	7711285	
5I 12 UN TM2		12	25.4	12	7711295	
5I 11.5 UN TM2		11.5	24.3	11	7711315	
5I 11 UN TM2		11	25.4	11	7711325	
5I 10 UN TM2		10	25.4	10	7711335	
5I 9 UN TM2		9	22.58	8	7711345	
5I 8 UN TM2		8	22.23	7	7711305	
5I 7 UN TM2		7	25.4	7	7711355	
5I 6 UN TM2		6	25.4	6	7711365	
6BI 6 UN TM2	6B	6	33.87	8	7715606	
6BI 5 UN TM2		5	30.48	6	7715616	
6BI 4.5 UN TM2		4.5	33.87	6	7715626	
6BI 4 UN TM2		4	31.75	5	7715636	

标准价格 : 每件 Listed price : per insert

1. 切削油剂请参考P.1004。 1. Cutting fluid and Paste : Please refer to p.1004.
2. 安装刀体时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with bodies, please refer to the "Tool Selection Guide by Screw Size" on p.523 or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。 3. Please select "stairs" for the path type in ThreadPro.

●=标准库存品 ●=Standard stock item.

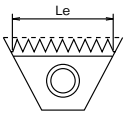
■记号说明请参考P1页。 See p.1 for explanation of icons.

HYPRO螺纹铣刀 多牙型 HYPRO PLANET CUTTER MULTI POINT (THREAD MILLING CUTTER)

HY-PRO P PC-CTI 多牙型

■美制外螺纹用刀片 Inserts for Unified screw thread (external)

CARBIDE | TiCN



刀片材质 Tool Material	表面处理 Surface Treatment	库存 Stock
VBX	TiCN	●
VTX	TiAlN	*
VK2	无	*

印有*的是定制产品。标准价格请咨询销售。
・Sizes marked with * are special order items.

单位:mm Unit:mm

名称 Description	刀片尺寸编号 Insert Size No.	牙数 TPI	Le	刃长间的牙数 No. of threads	VBX 材质 Material EDP No.	库存 Stock
2E 28 UN TM2	2	28	9.98	11	7712202	●
2E 24 UN TM2		24	9.53	9	7712212	
2E 20 UN TM2		20	10.16	8	7712222	
2E 18 UN TM2		18	9.88	7	7712232	
2E 16 UN TM2		16	9.53	6	7712242	
2E 14 UN TM2		14	9.07	5	7712252	
3E 28 UN TM2	3	28	14.51	16	7712203	
3E 27 UN TM2		27	14.11	15	7712213	
3E 24 UN TM2		24	14.82	14	7712223	
3E 20 UN TM2		20	13.97	11	7712233	
3E 18 UN TM2		18	14.11	10	7712243	
3E 16 UN TM2		16	14.29	9	7712253	
3E 14 UN TM2		14	14.51	8	7712263	
3E 13 UN TM2		13	13.68	7	7712273	
3E 12 UN TM2		12	14.82	7	7712283	
5E 24 UN TM2	5	24	25.4	24	7712205	
5E 20 UN TM2		20	25.4	20	7712215	
5E 18 UN TM2		18	25.4	18	7712225	
5E 16 UN TM2		16	25.4	16	7712235	
5E 14 UN TM2		14	25.4	14	7712245	
5E 13 UN TM2		13	25.4	13	7712255	
5E 12 UN TM2		12	25.4	12	7712265	
5E 11 UN TM2		11	25.4	11	7712275	
5E 10 UN TM2		10	22.86	9	7712285	
5E 9 UN TM2		9	22.58	8	7712295	
5E 8 UN TM2		8	22.23	7	7712305	
5E 7 UN TM2		7	21.77	6	7712315	
5E 6 UN TM2		6	21.17	5	7712325	

1. 切削油剂请参考P.1004。 1. Cutting fluid and Paste : Please refer to p.1004.
2. 安装刀体时，请参照「工具选定表(P.523~)」及NC编程软件「ThreadPro」的自动工具检索结果。
2. To use in combination with bodies, please refer to the "Tool Selection Guide by Screw Size" on p.523 or utilize our NC code generator software"ThreadPro" to automatically select the best option available.
3. ThreadPro 的路径类型请选择"多刃同时进给"。 3. Please select "stairs" for the path type in ThreadPro.

●=标准库存品 ●=Standard stock item.

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

G-LIST No. | TH1319 NEW

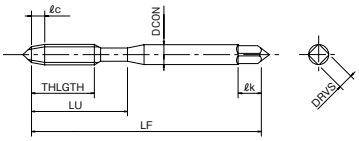
高效率·多功能挤压丝锥

HIGHLY EFFICIENT MULTI-PURPOSE FORMING TAP

A The A Brand

A-XPF

切削条件 Cutting Conditions | P.839



CPM 表面处理 丝锥专用特殊涂层
Surface treatment : special tap coating

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8327814	M1 × 0.25	STD	RH4	2P	30	5.5	—	3	—	●	—
8327816	M1.2 × 0.25			2P	32	5.5	—	3	—	●	—
8327818	M1.4 × 0.3			2P	34	7	—	3	—	●	—
8327820	M1.6 × 0.35			2P	36	8	—	3	—	●	—
8327822	M1.6 × 0.2			2P	36	8	—	3	—	●	—
8327824	M1.7 × 0.35			2P	36	8	—	3	—	●	—
8327828	M2 × 0.4			2P	40	8	—	3	—	●	—
8327832	M2.3 × 0.4			2P	42	9.5	—	3	—	●	—
8327834	M2.5 × 0.45			2P	44	9.5	—	3	—	●	—

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
   中径的上公差和 RH 精度相同，但是公差为18μm。
2. 丝锥精度不能保证内螺纹的精度。
3. M2.6以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8327836	M2.6 × 0.45	STD	RH4	2P	44	9.5	—	3	—	●	—
8327837	M3 × 0.5	STD	RH5	4P	46	9	18	4	Yes	●	—
8327838				2P					—	●	—
8327841	M4 × 0.7	STD	RH6	4P	52	10	20	5	Yes	●	—
8327842				2P					—	●	—
8327845	M5 × 0.8			4P	60	11	22	5.5	Yes	●	—
8327846				2P					—	●	—
8327849	M6 × 1	STD	RH7	4P	62	10	24	6	Yes	●	—
8327850				2P					—	●	—

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standards.
   Upper limit of pitch diameter tolerance is same as RH limit,
   but tolerance is 18μm. (see p.836)
2. TAP Limit does not gurantee thread limit for the internal thread after tapping.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P:P (for through holes), 2P:B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-XPF	◎	◎	◎	◎	◎				◎※1		○			◎	◎	◎		◎	◎		◎				

※1 加工不锈钢请使用油性切削油剂或润滑性优良的水溶性切削油剂。
※1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1175

XPF挤压丝锥

X PERFORMER

The A Brand

S-XPF

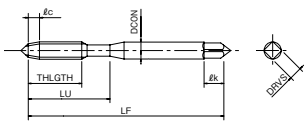
切削条件 Cutting Conditions | P.841

NU-ROLL 丝锥 NU-ROLL

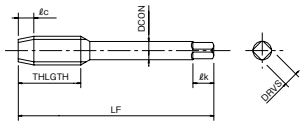
针对碳素钢、合金钢加工可得到良好的工具寿命，与传统切削丝锥相比，加工时没有切屑问题。特别是针对汽车零部件中的锻造钢零部件加工中可发挥巨大威力。

Long tool life is possible in carbon and alloy steels, as there are no problems with chips typically found with cutting taps. This is particularly effective for machining steel forgings for automotive applications.

Type 1



Type 2



CPM M1～M2.6 | HSSE M3～ | V

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8321960	M 1 ×0.25	STD	RH4	4P	30	5.5	—	3	1	Yes	●	3
8321961				2P					1	—	●	3
8321964	M 1.2×0.25			4P	32	5.5	—	3	1	Yes	●	3
8321965				2P					1	—	●	3
8321968	M 1.4×0.3			4P	34	7	—	3	1	Yes	●	3
8321969				2P					1	—	●	3
8321972	M 1.6×0.35			4P	36	8	—	3	1	Yes	●	3
8321973				2P					1	—	●	3
8321976	M 1.6×0.2			4P	36	8	—	3	1	Yes	●	3
8321977				2P					1	—	●	3
8321980	M 1.7×0.35			4P	36	8	—	3	1	Yes	●	3
8321981				2P					1	—	●	3
8321984	M 2 ×0.4			4P	40	8	—	3	1	Yes	●	3
8321985				2P					1	—	●	3
8321988	M 2.3×0.4			4P	42	9.5	—	3	1	Yes	●	3
8321989				2P					1	—	●	3
8321992	M 2.5×0.45			4P	44	9.5	—	3	1	Yes	●	3
8321993				2P					1	—	●	3
8321996	M 2.6×0.45			4P	44	9.5	—	3	1	Yes	●	3
8321997				2P					1	—	●	3
8322008	M 3 ×0.5	STD	RH5	4P	46	9	18	4	1	Yes	●	4
8322009				2P					1	—	●	4
8322032	M 4 ×0.7	STD	RH6	4P	52	10	20	5	1	Yes	●	7
8322033				2P					1	—	●	7
8322044	M 5 ×0.8			4P	60	11	22	5.5	1	Yes	●	11
8322045				2P					1	—	●	11
8322056	M 6 ×1	STD	RH7	4P	62	10	24	6	1	Yes	●	13
8322057				2P					1	—	●	13
8322059		STD+2	RH9	2P					1	—	●	13

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
   中径的上公差和 RH 精度相同，但是公差为18μm。
2. 丝锥精度不能保证内螺纹的精度。
3. M2.6以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P 左右距离。
6. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8322075	M 8 ×1.25	STD-2	RH5	2P	70	12	—	6.2	2	—	●	20
8322076		STD	RH7	4P					2	—	●	19
8322077				2P					2	—	●	19
8322079		STD+1	RH8	2P					2	—	●	19
8322090	M 8 ×1	STD	RH7	4P	70	12	—	6.2	2	—	●	19
8322091				2P					2	—	●	20
8322107	M10 ×1.5	STD-2	RH5	2P	75	15	—	7	2	—	●	29
8322108		STD	RH7	4P					2	—	●	28
8322109	M10 ×1.5	STD	RH7	2P	75	15	—	7	2	—	●	28
8322111		STD+2	RH9	2P					2	—	●	29
8322121	M10 ×1.25	STD-2	RH5	2P	75	15	—	7	2	—	●	29
8322122		STD	RH7	4P					2	—	●	28
8322123				2P					2	—	●	28
8322125		STD+1	RH8	2P					2	—	●	29
8322134	M10 ×1	STD	RH7	4P	75	15	—	7	2	—	●	28
8322135				2P					2	—	●	29
8322145	M12 ×1.75	STD-2	RH6	2P	82	17	—	8.5	2	—	●	45
8322146		STD	RH8	4P					2	—	●	45
8322147				2P					2	—	●	45
8322149		STD+2	RH10	2P					2	—	●	45
8322160	M12 ×1.5	STD	RH7	4P	82	17	—	8.5	2	—	●	46
8322161				2P					2	—	●	46
8322176	M12 ×1.25			4P	82	17	—	8.5	2	—	●	46
8322177				2P					2	—	●	46
8322194	M12 ×1			4P	82	17	—	8.5	2	—	●	46
8322195				2P					2	—	●	46

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standards.
   Upper limit of pitch diameter tolerance is same as RH limit,
   but tolerance is 18μm. (see p.836)
2. TAP Limit does not gurantee thread limit for the internal thread after tapping.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P:P (for through holes), 2P:B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

下一页
尺寸 Size M14～M45 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
S-XPF	◎	◎	◎	◎	◎				◎※1		○			◎	◎	◎		◎	◎		◎				

※1 加工不锈钢请使用油性切削油剂或润滑性优良的水溶性切削油剂。
※1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1175

XPF挤压丝锥

X PERFORMER

The A Brand

S-XPF

切削条件 Cutting Conditions | P.841

CPM M1～M2.6 上一页

HSSE M3 ～

V

FROM 尺寸 Size M1 ～ M12

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8322217	M14 × 2	STD	RH10	2P	88	20	—	10.5	2	—	●	75
8322227	M14 × 1.5	STD	RH9	2P	88	20	—	10.5	2	—	●	75
8322245	M16 × 2	STD	RH10	2P	95	20	—	12.5	2	—	●	107
8322255	M16 × 1.5	STD	RH9	2P	95	20	—	12.5	2	—	●	109
8322263	M18 × 2.5	STD	RH11	2P	125	20	—	14	2	—	●	165
8322267	M18 × 1.5	STD	RH10	2P	110	15	—	14	2	—	●	142
8322273	M20 × 2.5	STD	RH11	2P	140	20	—	15	2	—	●	214
8322277	M20 × 1.5	STD	RH10	2P	125	15	—	15	2	—	●	192
8322283	M22 × 2.5	STD	RH11	2P	140	20	—	17	2	—	●	269

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
   中径的上公差和RH精度相同，但是公差为18μm。
2. 丝锥精度不能保证内螺纹的精度。
3. M2.6以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8322287	M22 × 1.5	STD	RH10	2P	125	15	—	17	2	—	●	242
8322295	M24 × 3	STD	RH13	2P	160	18	—	19	2	—	●	380
8322299	M24 × 1.5	STD	RH10	2P	140	15	—	19	2	—	●	332
8322305	M27 × 3	STD	RH13	2P	160	18	—	20	2	—	●	431
8322313	M30 × 3.5	STD	RH14	2P	180	21	—	23	2	—	●	621
8322321	M33 × 3.5			2P	180	21	—	25	2	—	●	741
8322329	M36 × 4	STD	RH15	2P	200	24	—	28	2	—	●	1,021
8322337	M42 × 4.5	STD	RH16	2P	200	27	—	32	2	—	●	1,352
8322345	M45 × 4.5			2P	220	27	—	35	2	—	●	1,771

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standards.
   Upper limit of pitch diameter tolerance is same as RH limit,
   but tolerance is 18μm. (see p.836)
2. TAP Limit does not gurantee thread limit for the internal thread after tapping.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P:P (for through holes), 2P:B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. Cutting fluid and Paste : Please refer to p.1004.

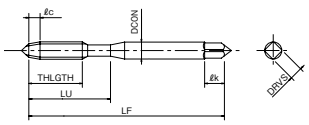
※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

NU-ROLL 丝锥 NU-ROLL

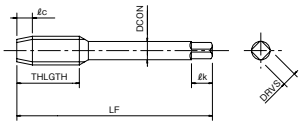
针对碳素钢、合金钢加工可得到良好的工具寿命，与传统切削丝锥相比，加工时没有切屑问题。特别是针对汽车零部件中的锻造钢零部件加工中可发挥巨大威力。

Long tool life is possible in carbon and alloy steels, as there are no problems with chips typically found with cutting taps. This is particularly effective for machining steel forgings for automotive applications.

Type 1



Type 2



加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
S-XPF	◎	◎	◎	◎	◎				◎※1		○			◎	◎	◎		◎	◎		◎				

※1 加工不锈钢请使用油性切削油剂或润滑性优良的水溶性切削油剂。
※1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1177

XPF挤压丝锥 长柄型

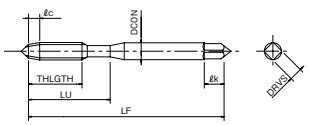
X PERFORMER LONG SHANK

The A Brand

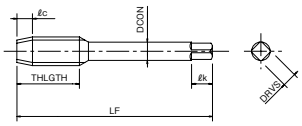
LT-S-XPF

切削条件 Cutting Conditions | P.841

Type 1



Type 2



HSSE | V

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8323654	M3 ×0.5× 80	STD	RH5	4P	80	9	18	4	1	Yes	●	9
8323655				2P					1	—	●	9
8323658	M3 ×0.5× 120			4P	120	9	18	4	1	Yes	●	13
8323659				2P					1	—	●	13
8323670	M4 ×0.7× 80			4P	80	10	20	5	1	Yes	●	13
8323671				2P					1	—	●	13
8323674	M4 ×0.7× 120			4P	120	10	20	5	1	Yes	●	19
8323675				2P					1	—	●	20
8323678	M5 ×0.8× 100			4P	100	11	22	5.5	1	Yes	●	20
8323679				2P					1	—	●	20
8323683	M5 ×0.8× 150			2P	150	11	22	5.5	1	—	●	29
8323684	M6 ×1 × 100	STD	RH7	4P	100	10	24	6	1	Yes	●	25
8323685				2P					1	—	●	24
8323689	M6 ×1 × 150			2P	150	10	24	6	1	—	●	34

D

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
   中径的上公差和RH精度相同，螺距1以上的产品公差不是通常的12.7μm，而是18μm。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
4. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
5. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8323698	M8 ×1.25×100	STD	RH7	4P	100	12	—	6.2	2	—	●	27
8323699				2P					2	—	●	27
8323703	M8 ×1.25×150			2P	150	12	—	6.2	2	—	●	39
8323712	M10×1.5× 100			4P	100	15	—	7	2	—	●	39
8323713				2P					2	—	●	39
8323717	M10×1.5× 150			2P	150	15	—	7	2	—	●	53
8323720	M10×1.25×100			4P	100	15	—	7	2	—	●	37
8323721				2P					2	—	●	37
8323725	M10×1.25×150			2P	150	15	—	7	2	—	●	53
8323738	M12×1.75×150	STD	RH8	4P	150	17	—	8.5	2	—	●	75
8323739				2P					2	—	●	76
8323747	M12×1.5× 150	STD	RH7	2P	150	17	—	8.5	2	—	●	76
8323755	M12×1.25×150			2P	150	17	—	8.5	2	—	●	76

D

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standards. The upper limit of the pitch diameter is the same as the RH Limit. For taps with a pitch above one, the limit will be 18μm instead of the standard 12.7μm. (see p.836)
2. TAP Limit does not gurantee thread limit for the internal thread after tapping.
3. ℓc: 4P:P (for through holes), 2P:B (for blind holes)
4. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
LT-S-XPF	◎	◎	◎	◎	◎				◎※1		○			◎	◎	◎		◎	◎		◎				

※1 加工不锈钢请使用油性切削油剂或润滑性优良的水溶性切削油剂。
※1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1176

内冷油孔XPF挤压丝锥

X PERFORMER WITH INTERNAL COOLANT SUPPLY

The A Brand

OIL-S-XPF

切削条件 Cutting Conditions | P.841

HSSE

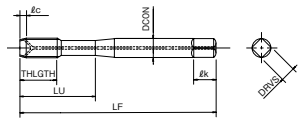
V

NU-ROLL 丝锥 NU-ROLL

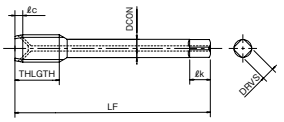
S-XPF的性能加上各油槽上均设有油孔，实现了优异的润滑性和冷却效果、高速 · 高效率和高耐久性能兼顾。

Putting oil holes at each oil groove on superior S-XPF design, obtained superior lubrication and cooling down, materialized both high speed productivity and high wear resistance.

Type 1



Type 2



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	啮合长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8322557	M6 ×1	STD	RH7	2P	62	8	24	6	1	—	●	13
8322577	M8 ×1.25				70	10	—	6.2	2	—	●	18
8322609	M10 ×1.5				75	12	—	7	2	—	●	25

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
   中径的上公差和 RH 精度相同，但是公差为18μm。
2. 丝锥精度不能保证内螺纹的精度。
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P 左右距离。
4. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	啮合长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	形状 Type	突顶尖 External Center	库存 Stock	重量 (g)
8322647	M12 ×1.75	STD	RH8	2P	82	14	—	8.5	2	—	●	40
8322727	M14 ×1.5	STD	RH9		88	12	—	10.5	2	—	●	68
8322755	M16 ×1.5				95	12	—	12.5	2	—	●	97

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standards.
   Upper limit of pitch diameter tolerance is same as RH limit,
   but tolerance is 18μm. (see p.836)
2. TAP Limit does not gurantee thread limit for the internal thread after tapping.
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OIL-S-XPF	◎	◎	◎	◎	◎				◎※1		○			◎	◎	◎		◎	◎		◎				

※1 加工不锈钢请使用油性切削油剂或润滑性优良的水溶性切削油剂。
※1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1150

VP挤压丝锥

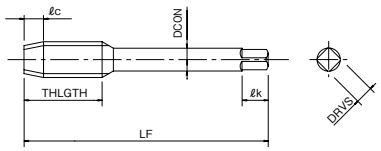
VP NU-ROLL

VP-NRT

■NU-ROLL 丝锥 NU-ROLL

粉末高速钢材质加上特殊螺纹设计，使得此系列具有适用范围广，刀具寿命长的特点。

By powder metallurgy H.S.S. and special thread form, long tool life processing is possible at wide.



CPM　V

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	啮合长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8317410	M 1 × 0.25	STD	RH4	4P	30	7	—	3	Yes	●	3
8317411				2P					—	●	3
8317414	M 1.2 × 0.25	STD	RH4	4P	32	8	—	3	Yes	●	3
8317415				2P					—	●	3
8317418	M 1.4 × 0.3	STD	RH4	4P	34	9	—	3	Yes	●	3
8317419				2P					—	●	3
8317420		STD+1	RH5	4P					Yes	●	3
8317421				2P					—	●	3
8317424	M 1.6 × 0.35	STD	RH4	4P	36	10	—	3	Yes	●	3
8317425				2P					—	●	3
8317430	M 1.7 × 0.35	STD	RH4	4P	36	11	—	3	Yes	●	3
8317431				2P					—	●	3
8317432		STD+1	RH5	4P					Yes	●	3
8317433				2P					—	●	3
8317442	M 2 × 0.4	STD	RH4	4P	40	12	—	3	Yes	●	3
8317443				2P					—	●	3
8317444		STD+1	RH5	4P					Yes	●	3
8317445				2P					—	●	3
8317446	M 2.3 × 0.4	STD	RH4	4P	42	13	—	3	Yes	●	4
8317447				2P					—	●	4
8317478	M 2.5 × 0.45	STD	RH4	4P	44	14	—	3	Yes	●	4
8317479				2P					—	●	4
8317490	M 2.6 × 0.45	STD	RH4	4P	44	14	—	3	Yes	●	4
8317491				2P					—	●	4
8317492		STD+1	RH5	4P					Yes	●	4
8317493				2P					—	●	4
8317502	M 3 × 0.5	STD	RH5	4P	46	9	18	4	Yes	●	5
8317503				2P					—	●	5
8317504		STD+1	RH6	4P					Yes	●	5
8317505				2P					—	●	5
8317514	M 3.5 × 0.6	STD	RH4	4P	48	9	18	4	Yes	●	5

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
   (精度栏 是适合加工3级内螺纹的丝锥推荐精度)
2. 2002年7月前生产品中2P：M2.3以下为突顶尖。
3. M2.6 以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	啮合长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8317515	M 3.5 × 0.6	STD	RH4	2P	48	9	18	4	—	●	6
8317526	M 4 × 0.7	STD	RH6	4P	52	10	20	5	Yes	●	8
8317527				2P					—	●	8
8317528		STD+1	RH7	4P					Yes	●	8
8317529				2P					—	●	8
8317538	M 5 × 0.8	STD	RH6	4P	60	11	22	5.5	Yes	●	12
8317539				2P					—	●	12
8317542		STD+2	RH8	4P					Yes	●	12
8317543				2P					—	●	12
8317550	M 6 × 1	STD	RH7	4P	62	12	24	6	Yes	●	14
8317551				2P					—	●	14
8317554		STD+2	RH9	4P					Yes	●	14
8317555				2P					—	●	14
8317568	M 8 × 1.25	STD	RH7	4P	70	18	—	6.2	—	●	20
8317569				2P					—	●	21
8317574	M 8 × 1	STD	RH7	4P	70	18	—	6.2	—	●	21
8317575				2P					—	●	21
8317586	M 10 × 1.5	STD	RH7	4P	75	19	—	7	—	●	30
8317587				2P					—	●	30
8317592	M 10 × 1.25	STD	RH7	4P	75	19	—	7	—	●	30
8317593				2P					—	●	30
8317598	M 10 × 1	STD	RH7	4P	75	19	—	7	—	●	31
8317599				2P					—	●	31
8317610	M 12 × 1.75	STD	RH8	4P	82	23	—	8.5	—	●	48
8317611				2P					—	●	48
8317616	M 12 × 1.5	STD	RH7	4P	82	23	—	8.5	—	●	48
8317617				2P					—	●	48
8317622	M 12 × 1.25	STD	RH7	4P	82	23	—	8.5	—	●	49
8317623				2P					—	●	49
8317628	M 12 × 1	STD	RH7	4P	82	23	—	8.5	—	●	49
8317629				2P					—	●	49

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
   (The recommended TAP Limit corresponds to JIS class 3 internal thread standard.)
2. Taps of M2.3 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P:P (for through holes), 2P:B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1150

VP挤压丝锥

VP NU-ROLL

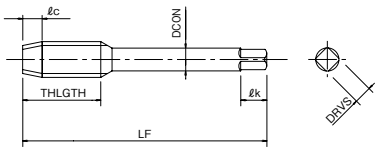
VP-NRT

CPM V

■NU-ROLL 丝锥 NU-ROLL

粉末高速钢材质加上特殊螺纹设计，使得此系列具有适用范围广，刀具寿命长的特点。

By powder metallurgy H.S.S. and special thread form, long tool life processing is possible at wide.



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8317724	No.2- 56UNC	STD	RH4	4P	42	13	—	3	Yes	●	3
8317725				2P					—	●	3
8317754	No.4- 40UNC	STD-1	RH4	4P	44	15	—	3	Yes	●	4
8317755				2P					—	●	4

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：NO.2以下为突顶尖。
3. NO.4以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8317756	No.4- 40UNC	STD	RH5	4P	44	15	—	3	Yes	●	4
8317757				2P					—	●	4
8317788	No.6- 32UNC			4P	48	9	18	4	Yes	●	5
8317789				2P					—	●	5

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Taps of No.2 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ No.4: without oil groove.
4. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

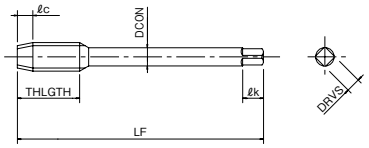
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1154

VP挤压丝锥长柄型

VP NU-ROLL LONG SHANK

VP-LT-NRT



CPM　V

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8319422	M 1 ×0.25	STD	RH4	4P	60	7	—	3	Yes	●	5
8319423				2P					—	●	5
8319426	M 1.2 ×0.25			4P	60	8	—	3	Yes	●	5
8319427				2P					—	●	5
8319430	M 1.4 ×0.3			4P	60	9	—	3	Yes	●	5
8319431				2P					—	●	5
8319434	M 1.7 ×0.35			4P	60	11	—	3	Yes	●	5
8319435				2P					—	●	5
8319438	M 2 ×0.4			4P	80	12	—	3	Yes	●	6
8319439				2P					—	●	6
8319442	M 2.3 ×0.4			4P	80	13	—	3	Yes	●	7
8319443				2P					—	●	6
8319446	M 2.5 ×0.45			4P	80	14	—	3	Yes	●	7
8319447				2P					—	●	6
8319450	M 2.6 ×0.45			4P	80	14	—	3	Yes	●	7
8319451				2P					—	●	6
8319454	M 3 ×0.5	STD	RH5	4P	80	9	18	4	Yes	●	9
8319455				2P					—	●	9
8319458				4P	120				Yes	●	13
8319459				2P					—	●	13
8319462	M 3.5 ×0.6	STD	RH4	4P	80	9	18	4	Yes	●	9
8319463				2P					—	●	10
8319466				4P	120				Yes	●	14
8319467				2P					—	●	13
8319470	M 4 ×0.7	STD	RH6	4P	80	10	20	5	Yes	●	13
8319471				2P					—	●	13
8319474				4P	120				Yes	●	19
8319475				2P					—	●	19
8319478	M 5 ×0.8			4P	100	11	22	5.5	Yes	●	20
8319479				2P					—	●	20
8319482				4P	150				Yes	●	29
8319483				2P					—	●	29
8319484	M 6 ×1	STD	RH7	4P	100	12	24	6	Yes	●	25
8319485				2P					—	●	25
8319488				4P	150				Yes	●	35
8319489				2P					—	●	35

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：M2.3以下为突顶尖。
3. M2.6 以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8319498	M 8 ×1.25	STD	RH7	4P	100	18	—	6.2	—	●	28
8319499				2P					—	●	28
8319502				4P	150				—	●	41
8319503				2P					—	●	41
8319506	M 8 ×1			4P	100	18	—	6.2	—	●	29
8319507				2P					—	●	29
8319510				4P	150				—	●	42
8319511				2P					—	●	42
8319512	M10 ×1.5			4P	100	19	—	7	—	●	38
8319513				2P					—	●	37
8319516				4P	150				—	●	53
8319517				2P					—	●	55
8319520	M10 ×1.25			4P	100	19	—	7	—	●	38
8319521				2P					—	●	38
8319524				4P	150				—	●	55
8319525				2P					—	●	54
8319528	M10 ×1			4P	100	19	—	7	—	●	40
8319529				2P					—	●	40
8319532				4P	150				—	●	57
8319533				2P					—	●	56
8319538	M12 ×1.75	STD	RH8	4P	150	23	—	8.5	—	●	81
8319539				2P					—	●	80
8319540				4P	200				—	●	105
8319541				2P					—	●	103
8319546	M12 ×1.5			4P	150	23	—	8.5	—	●	81
8319547				2P					—	●	81
8319548				4P	200				—	●	106
8319549				2P					—	●	105
8319554	M12 ×1.25	STD	RH7	4P	150	23	—	8.5	—	●	81
8319555				2P					—	●	80
8319556				4P	200				—	●	104
8319557				2P					—	●	105
8319562	M12 ×1			4P	150	23	—	8.5	—	●	83
8319563				2P					—	●	82
8319564				4P	200				—	●	107
8319565				2P					—	●	108

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Taps of M2.3 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P : P (for through holes), 2P : B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1154

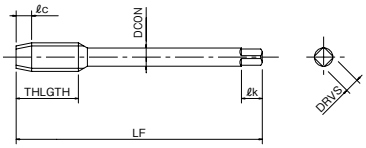
VP挤压丝锥长柄型

VP NU-ROLL LONG SHANK

VP-LT-NRT

■NU-ROLL 丝锥 NU-ROLL

CPM V



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8319610	No.2- 56UNC	STD	RH4	4P	80	13	—	3	Yes	●	6
8319611				2P					—	●	7
8319614	No.4- 40UNC	STD-1	RH4	4P	80	15	—	3	Yes	●	7
8319615				2P					—	●	6
8319618	No.4- 40UNC	STD	RH5	4P	80	15	—	3	Yes	●	7
8319619				2P					—	●	7
8319623	No.6- 32UNC			4P	80	9	18	4	Yes	●	10
8319624				2P					—	●	9

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：No.2以下为突顶尖。
3. No.4以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Taps of No.2 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ No.4: without oil groove.
4. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1153

VP 挤压丝锥 短切削锥型

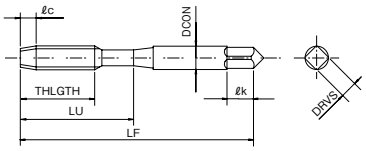
VP NU-ROLL· SHORT CHAMFER TYPE

VP-SC-NRT

NU-ROLL 丝锥 NU-ROLL

粉末高速钢材质加上特殊螺纹设计，使得此系列具有适用范围广，刀具寿命长的特点。

By powder metallurgy H.S.S. and special thread form, long tool life processing is possible at wide.



CPM V

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8318001	M1 ×0.25	STD	RH4	1P	30	7	—	3	—	●	3
8318004	M1.2 ×0.25				32	8	—	3	—	●	3
8318006	M1.4 ×0.3				34	9	—	3	—	●	3
8318008	M1.6 ×0.35				36	10	—	3	—	●	3
8318011	M1.7 ×0.35				36	11	—	3	—	●	3
8318017	M2 ×0.4				40	12	—	3	—	●	3
8318025	M2.5 ×0.45				44	14	—	3	—	●	4
8318027	M2.6 ×0.45	STD	RH4	1P	44	14	—	3	—	●	4
8318031	M3 ×0.5	STD	RH5		46	9	18	4	—	●	4
8318033	M3.5 ×0.6	STD	RH4		48	9	18	4	—	●	6
8318037	M4 ×0.7	STD	RH6		52	10	20	5	—	●	7
8318042	M5 ×0.8				60	11	22	5.5	—	●	11
8318048	M6 ×1	STD	RH7		62	12	24	6	—	●	14

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. M2.6 以下无油槽。
3. 丝锥的精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Thread Size ≦ M2.6: without oil groove.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8318104	No.2- 56UNC	STD	RH4	1P	42	13	—	3	—	●	3
8318108	No.4- 40UNC	STD	RH5		44	15	—	3	—	●	4
8318112	No.6- 32UNC	STD	RH5	1P	48	9	18	4	—	●	5

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B 内螺纹的丝锥推荐精度。(参照P.836)
2. NO.4 以下无油槽。
3. 丝锥的精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Thread Size ≦ No.4: without oil groove.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

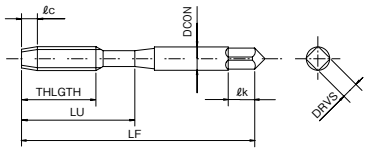
G-LIST No. | TH1152

VP挤压丝锥 短切削锥长柄型

VP NU-ROLL· SHORT CHAMFER· LONG SHANK

VP-LT-SC-NRT

CPM V



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8318201	M1 ×0.25	STD	RH4	1P	60	7	—	3	—	●	5
8318207	M1.2 ×0.25				60	8	—	3	—	●	5
8318211	M1.4 ×0.3				60	9	—	3	—	●	5
8318221	M1.7 ×0.35				60	11	—	3	—	●	5
8318233	M2 ×0.4				80	12	—	3	—	●	6
8318249	M2.5 ×0.45				80	14	—	3	—	●	6
8318253	M2.6 ×0.45	STD	RH4	1P	80	14	—	3	—	●	7
8318261	M3 ×0.5	STD	RH5		80	9	18	4	—	●	9
8318265	M3.5 ×0.6	STD	RH4		80	9	18	4	—	●	10
8318273	M4 ×0.7	STD	RH6		80	10	20	5	—	●	13
8318283	M5 ×0.8				100	11	22	5.5	—	●	20
8318295	M6 ×1	STD	RH7		100	12	24	6	—	●	24

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. M2.6 以下无油槽。
3. 丝锥的精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Thread Size ≦ M2.6: without oil groove.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8318407	No.2- 56UNC	STD	RH4	1P	80	13	—	3	—	●	6
8318415	No.4- 40UNC	STD	RH5		80	15	—	3	—	●	7
8318423	No.6- 32UNC	STD	RH5	1P	80	9	18	4	—	D ●	10

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.836)
2. No.4以下无油槽。
3. 丝锥的精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Thread Size ≦ No.4: without oil groove.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

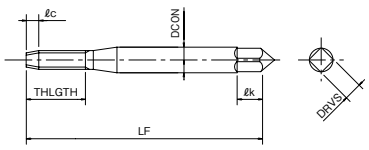
IT挤压丝锥

IT NU-ROLL

IT-NRT

CPM V

■NU-ROLL 丝锥 NU-ROLL



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8319811	M1 ×0.25	STD	RH4	2P	30	5	—	3	—	●	3
8319815	M1.2 ×0.25				32	5	—	3	—	●	3
8319819	M1.4 ×0.3				34	6.5	—	3	—	●	3
8319825	M1.6 ×0.35				36	7	—	3	—	●	3
8319831	M1.7 ×0.35				36	8	—	3	—	●	4
8319843	M2 ×0.4	STD	RH4	2P	40	8	—	3	—	●	3
8319847	M2.3 ×0.4				42	9	—	3	—	●	4
8319879	M2.5 ×0.45				44	9	—	3	—	●	4
8319891	M2.6 ×0.45				44	9.5	—	3	—	●	4
8319903	M3 ×0.5	STD	RH5		46	9	18	4	—	●	5

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削锥长 2P：B(盲孔用)
4. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
5. M2.6以下无油槽。
6. 切削油剂请参考P.1004。

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. ℓc: 2P：B (for blind holes)
4. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
5. Thread size ≦ M2.6 : without oil groove.
6. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
*	No.0- 80UNF	STD	RH3	2P	36	7	3	—	*	—
*	No.1- 64UNC				36	8	3	—	*	—
*	No.1- 72UNF				36	8	3	—	*	—
8319925	No.2- 56UNC	STD	RH4		42	9.5	3	—	●	3
*	No.2- 64UNF	STD	RH3		42	9.5	3	—	*	—
*	No.3- 48UNC	STD	RH4	2P	44	9.5	3	—	*	—
*	No.3- 56UNF				44	9.5	3	—	*	—
8319957	No.4- 40UNC	STD	RH5		44	11	3	—	●	3
*	No.4- 48UNF	STD	RH4		44	11	3	—	*	—

＊为特别订制产品。
1. 精度栏 是适合加工2B 内螺纹的丝锥推荐精度。(参照P.836)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削锥长2P：B(盲孔用)
4. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
5. 切削油剂请参考P.1004。

Sizes marked with ＊ are special order items.
1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. ℓc: 2P：B (for blind holes)
4. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
5. Cutting fluid and Paste : Please refer to p.1004.

■螺纹底孔径表 Recommended Drill Hole Size

公制螺纹 Metric Screw Threads

螺纹尺寸 Thread Size	RH 精度 RH Limit	IT-NRT
M 1 × 0.25	4	0.89
M 1.2 × 0.25	4	1.09
M 1.4 × 0.3	4	1.26
M 1.6 × 0.35	4	1.43
M 1.7 × 0.35	4	1.53
M 2 × 0.4	4	1.8
M 2.3 × 0.4	4	2.1
M 2.5 × 0.45	4	2.27
M 2.6 × 0.45	4	2.37
M 3 × 0.5	5	2.75

1. 上表的底孔径因加工材料不同而会有所变化，上表仅为参考。
2. 底孔径因加工材料、硬度、形状等因素，塑性多少会有变化，因此请在试加工后决定。
3. 底孔径较大利于寿命，请按照需求选型。
4. 底孔弯曲、振纹、错位等将导致加工困难，请注意。
5. IT-NRT 的底孔为铰刀加工后的目标值。
6. IT-NRT 为完全挤压后的底孔径。

美制粗牙螺纹 Unified Coarse Screw Threads

螺纹尺寸 Thread Size	RH 精度 RH Limit	IT-NRT
No.2 - 56UNC	4	1.95
No.4 - 40UNC	5	2.51

1. The proper drill hole size may change due to material variety. Use the recommended drill hole size as a benchmark.
2. As the hole diameter may vary by behavior of plasticity depending on the material, hardness and shapes of workpiece, the hole diameter should be determined through trial tapping prior to final machining.
3. A larger drill hole size is better for extending tool life. Select a drill hole size based on your particular application.
4. To avoid tapping trouble,correct hole must be maintained free from warp, deformation, stagger and the like.
5. The hole for the IT-NRT indicates a target value using a reamer.
6. The hole sizes for the IT-NRT are aimed at complete top rolls.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1173

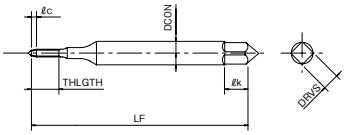
UM挤压丝锥

UM NU-ROLL

UM-NRT

■NU-ROLL 丝锥 NU-ROLL

CPM CrN



螺纹种类：S

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8317965	S0.5 ×0.125	STD	RH2	2P	30	2	3	Yes	●	3
8317971	S0.6 ×0.15				30	2.5	3	Yes	●	3
8317977	S0.7 ×0.175				30	2.5	3	Yes	●	3
8317983	S0.8 ×0.2 ×3				30	3	3	Yes	●	3
8317989	S0.8 ×0.2 ×5	STD	RH2	2P	30	5	3	Yes	●	3
8317992	S0.8 ×0.15				30	5	3	Yes	●	3
8317995	S0.9 ×0.225				30	3	3	Yes	●	3

1. 精度栏 是适合加工4H5内螺纹的丝锥推荐精度。(参照P.836)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削锥长 2P：B(盲孔用)
4. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
5. 切削油剂请参考P.1004。

1. The recommended TAP Limit corresponds to JIS class 4H5 internal thread standard. (see p.836)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. ℓc: 2P：B (for blind holes)
4. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
5. Cutting fluid and Paste : Please refer to p.1004.

4H5螺纹用底孔径 for JIS class 4H5 drill hole dia.

螺纹尺寸 Thread Size	UM-NRT	
	最小 Min	最大 Max
S0.5 × 0.125	0.46	0.47
S0.6 × 0.15	0.54	0.56
S0.7 × 0.175	0.63	0.64
S0.8 × 0.2	0.71	0.73
S0.8 × 0.15	0.74	0.76
S0.9 × 0.225	0.8	0.82

切削条件基准表 Cutting conditions

加工材料 Work Material		切削速度(m/min) Cutting Speed
低碳素钢 Low Carbon Steels	～C0.25%	2～10
不锈钢 Stainless Steels	SUS	1～5
变形铝 Aluminum Rolled	AL	2～12
铝合金铸件 Aluminum Alloy Castings	～Si16%	2～12
锌合金铸件 Zinc Alloy Castings	ZDC	2～10

1. 请确认成孔状态必须与以前的挤压丝锥一致。
2. 请使用润滑性高的水溶性切削油剂或者非水溶性切削油剂。
3. 请使用跳动较小的刀柄及机器。
4. 根据工件、机器及夹头的刚性等适当改变加工条件。
5. 塑性变形后的内螺纹牙顶有间隙存在。

1. Check the forming condition in the same way as for conventional nu-roll taps.
2. Highly lubricating water-soluble coolant or non-water-soluble coolant is recommended for the coolant.
3. Select the machine and the holder with high run out tolerance.
4. Cutting conditions may change depending on the strength of the work material, machines, and the holders.
5. The formed thread has a small slit at the crest.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

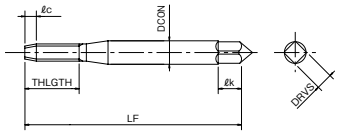
G-LIST No. | TH1165

VP挤压丝锥短螺纹型

VP NU-ROLL (SHORT THREAD)

VP-NRTS

CPM V



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8317811	M1 ×0.25	STD	RH4	2P	30	5	3	—	●	3
8317815	M1.2 ×0.25				32	5	3	—	●	3
8317819	M1.4 ×0.3				34	6.5	3	—	●	3
8317825	M1.6 ×0.35				36	7	3	—	●	3
8317831	M1.7 ×0.35				36	8	3	—	●	3

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削锥长 2P：B(盲孔用)
4. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
5. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8317843	M2 ×0.4	STD	RH4	2P	40	8	3	—	●	3
8317847	M2.3 ×0.4				42	9	3	—	●	3
8317879	M2.5 ×0.45				44	9	3	—	●	4
8317891	M2.6 ×0.45				44	9.5	3	—	●	4

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. ℓc: 2P : B (for blind holes)
4. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
5. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1095

V涂层
V COATED

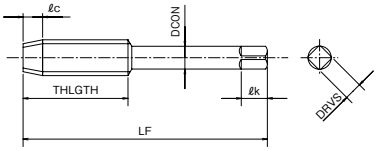
V-NRT

HSSE | V

■NU-ROLL 丝锥 NU-ROLL

适用于钢、非铁合金。
V 涂层摩擦系数小，并且耐粘着性、耐热性好，在水溶性高稀释攻丝中可发挥高性能。

Suitable for tapping steels and nonferrous metal alloys. V coating greatly reduces friction and provides superior welding and heat resistance.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8310640	**M14 ×2**	STD	RH10	4P	88	25	—	10.5	—	▲	78
8310677	**M18 ×2.5**	STD	RH11	2P	100	29	—	14	—	▲	135

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产的产品2P：M2.3以下为突顶尖。
3. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
4. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
5. 丝锥的精度不能保证内螺纹的精度。
6. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲= 该产品已停止生产，由TIN-NRT(P.561)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8310682	**M18 ×1.5**	STD	RH10	4P	100	29	—	14	—	▲	138
8310700	**M20 ×1.5**			4P	105	30	—	15	—	▲	175

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Taps of M2.3 (2P) or less producted before July 2002 have external center.
3. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
4. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
5. TAP Limit does not guarantee thread limit for the internal thread after tapping.
6. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by TIN-NRT(p.561).

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

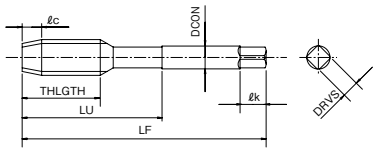
■记号说明请参考P1页。 See p.1 for explanation of icons.

V涂层长柄型
V COATED · LONG SHANK

V-LT-NRT

■ NU-ROLL 丝锥 NU-ROLL

HSSE V



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8316462	M3.5 ×0.6	STD	RH4	4P	80	9	18	4	Yes	▲	8
8316463				2P					—	▲	10
8316466				4P	120				Yes	▲	13
8316467				2P					—	▲	13
8316482	M5 ×0.8	STD	RH6	4P	150	11	22	5.5	Yes	▲	30
8316506	M8 ×1	STD	RH7	4P	100	18	37	6.2	—	▲	29
8316507				2P					—	▲	29
8316510				4P	150				—	▲	40
8316511				2P					—	▲	41
8316512	M10 ×1.5			4P	100	19	41	7	—	▲	40
8316516				4P	150				—	▲	60
8316520	M10 ×1.25			4P	100	19	41	7	—	▲	40
8316524				4P	150				—	▲	55
8316528	M10 ×1			4P	100	19	41	7	—	▲	40
8316529				2P					—	▲	40
8316532				4P	150				—	▲	56

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲=该产品已停止生产，由VP-LT-NRT(P.550)、TIN-LT-NRT(P.564)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8316538	M12 ×1.75	STD	RH8	4P	150	23	48	8.5	—	▲	80
8316539				2P					—	▲	79
8316540				4P	200				—	▲	103
8316541				2P					—	▲	170
8316546	M12 ×1.5	STD	RH7	4P	150	23	48	8.5	—	▲	80
8316548				4P	200				—	▲	103
8316549				2P					—	▲	104
8316554	M12 ×1.25			4P	150	23	48	8.5	—	▲	81
8316556				4P	200				—	▲	104
8316557				2P					—	▲	104
8316562	M12 ×1			4P	150	23	48	8.5	—	▲	82
8316563				2P					—	▲	87
8316564				4P	200				—	▲	113
8316565				2P					—	▲	123

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps. Please see p.867 for drill hole size for fluteless taps.

▲=The products have been stopped producing and replaced by VP-LT-NRT(p.550) and TIN-LT-NRT(p.564).

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1148

V涂层薄板用

V COATED · FOR SHEET STEELS

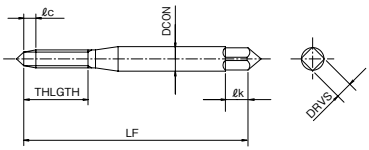
V-SS-NRT

HSSE | V

■NU-ROLL 丝锥 NU-ROLL

适用于强度700N/mm²以下的软钢薄板攻丝。
并且能抑制毛刺，毛边，烂牙的产生。

Good for tapping in thin mild steel plate under 700N/㎟. Burrs are prevented and surface finish is good.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8310819	M 1.4 ×0.3	STD	RH4	8P	34	9	3	Yes	●	3
8310831	M 1.7 ×0.35				36	11	3	Yes	●	3
8310843	M 2 ×0.4				40	12	3	Yes	●	3
8310847	M 2.3 ×0.4				42	13	3	Yes	●	4
8310879	M 2.5 ×0.45				44	14	3	Yes	●	4
8310891	M 2.6 ×0.45				44	14	3	Yes	●	3

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8310903	M 3 ×0.5	STD	RH5	8P	46	18	4	Yes	●	5
8310915	M 3.5 ×0.6	STD	RH4		48	18	4	Yes	△	5
8310927	M 4 ×0.7	STD	RH6		52	20	5	Yes	●	7
8310939	M 5 ×0.8				60	22	5.5	Yes	●	11
8310951	M 6 ×1	STD	RH7		62	24	6	Yes	●	14

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 为了提升底孔插入性，先端面与不完全牙部分预留了1P 左右距离。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Thread Size ≦ M2.6: without oil groove.
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1129

V涂层 带小径精加工刃型

V COATED · WITH CUTTING EDGE ON MINOR DIAMETER (EG-NRT)

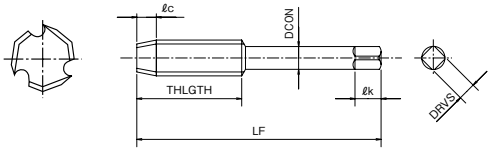
V-EG-NRT

HSSE | V

■NU-ROLL 丝锥 NU-ROLL

丝锥正转时，可由切削刃切削内螺纹小径。这样即使底孔管理不太严格的时候也不至于造成过度挤压。另外，选择适当的底孔直径，也可将内螺纹牙顶的凹陷部除去。

These taps cut the thread crest while entering the hole. If the drilled hole is too small for a standard Nu-Roll tap, then this tap should be used to form the complete thread.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8321400	M 3 ×0.5	STD	RH5	4P	46	9	18	4		Yes	▲	5
8321401				2P						—	●	5
8321412	M 4 ×0.7	STD	RH6	4P	52	10	20	5	2	Yes	▲	8
8321413				2P						—	●	8
8321424	M 5 ×0.8			4P	60	11	22	5.5		Yes	▲	11
8321425				2P						—	●	11
8321436	M 6 ×1	STD	RH7	4P	62	12	24	6	3	Yes	▲	13
8321437				2P						—	●	13
8321448	M 8 ×1.25			4P	70	18	—	6.2		—	▲	19
8321449				2P						—	●	19
8321450	M 8 ×1			4P	70	18	—	6.2		—	▲	19
8321451				2P						—	●	19

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考P.1004。
▲=该产品已停止生产，由V-EG-NRT(切削锥：2P)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8321460	M10×1.5	STD	RH7	4P	75	19	—	7	4	—	▲	28
8321461				2P						—	●	28
8321462	M10×1.25			4P	75	19	—	7		—	▲	28
8321463				2P						—	●	28
8321464	M10×1			4P	75	19	—	7		—	▲	29
8321465				2P						—	●	29
8321472	M12×1.75	STD	RH8	4P	82	23	—	8.5		—	▲	44
8321473				2P						—	●	44
8321474	M12×1.5	STD	RH7	4P	82	23	—	8.5		—	▲	44
8321475				2P						—	●	44
8321476	M12×1.25			4P	82	23	—	8.5		—	▲	46
8321477				2P						—	●	46

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.
▲=The products have been stopped producing and replaced by V-EG-NRT(ℓc:2P).

■螺纹底孔径表 Recommended Drill Hole Size

丝锥寿命 Tool Life		△	○	◎
内螺纹牙顶凹陷 Incomplete Crest of the Thread		能去除 Can be removed	能去除 Can be removed	有残留可能 Can be left over
螺纹尺寸 Thread Size	M 3×0.5	2.6 ～ 2.65	2.65 ～ 2.72	2.72 ～ 2.81
	M 4×0.7	3.43 ～ 3.5	3.5 ～ 3.6	3.6 ～ 3.7
	M 5×0.8	4.34 ～ 4.42	4.42 ～ 4.53	4.53 ～ 4.66
	M 6×1	5.16 ～ 5.26	5.26 ～ 5.41	5.41 ～ 5.57
	M 8×1.25	6.93 ～ 7.06	7.06 ～ 7.23	7.23 ～ 7.41
	M 8×1	7.16 ～ 7.26	7.26 ～ 7.41	7.41 ～ 7.57

1. 上表的底孔径因加工材料不同而会有所变化，上表仅为参考。
2. 底孔径较大利于寿命，请按照需求选型。
3. 建议切削速度在30m/min以下，并使用油性切削油剂。

丝锥寿命 Tool Life		△	○	◎
内螺纹牙顶凹陷 Incomplete Crest of the Thread		能去除 Can be removed	能去除 Can be removed	有残留可能 Can be left over
螺纹尺寸 Thread Size	M 10×1.5	8.7 ～ 8.85	8.85 ～ 9.06	9.06 ～ 9.28
	M 10×1.25	8.93 ～ 9.06	9.06 ～ 9.23	9.23 ～ 9.41
	M 10×1	9.16 ～ 9.26	9.26 ～ 9.41	9.41 ～ 9.57
	M 12×1.75	10.48 ～ 10.66	10.66 ～ 10.91	10.91 ～ 11.15
	M 12×1.5	10.7 ～ 10.85	10.85 ～ 11.06	11.06 ～ 11.28
	M 12×1.25	10.93 ～ 11.06	11.06 ～ 11.23	11.23 ～ 11.41

1. The proper drill hole size may change due to material variety. Use the recommended drill hole size as a benchmark.
2. A larger drill hole size is better for extending tool life. Select a drill hole size based on your particular application.
3. We recommend using oil, and tapping at a speed of 30 m/min.

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

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1065

TiN涂层
TiN COATED

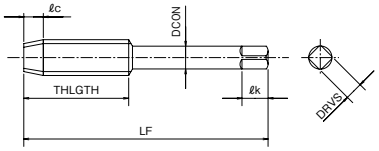
TIN-NRT

HSSE | TiN

■NU-ROLL 丝锥 NU-ROLL

适用于钢、非铁合金。可实现高速切削，寿命大幅提高，高效率攻丝。

Suitable for tapping steels and nonferrous metal alloys. Capable of efficient, long life, high speed tapping.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
21590	M1 ×0.25	STD	RH4	4P	30	7	—	3	Yes	●	3
21591				2P					—	●	3
21592		STD+1	RH5	4P					Yes	●	3
21593				2P					—	●	3
21602	M1.2 ×0.25	STD	RH4	4P	32	8	—	3	Yes	●	3
21603				2P					—	●	3
21604		STD+1	RH5	4P					Yes	●	3
21605				2P					—	●	3
21608	M1.4 ×0.3	STD	RH4	4P	34	9	—	3	Yes	●	3
21609				2P					—	●	3
21610		STD+1	RH5	4P					Yes	●	3
21611				2P					—	●	3
21614	M1.6 ×0.35	STD	RH4	4P	36	10	—	3	Yes	●	3
21615				2P					—	●	3
21616		STD+1	RH5	4P					Yes	●	3
21617				2P					—	●	3
21620	M1.7 ×0.35	STD	RH4	4P	36	11	—	3	Yes	●	3
21621				2P					—	●	3
21622		STD+1	RH5	4P					Yes	●	3
21623				2P					—	●	3
21624		STD+2	RH6	4P					Yes	●	3
21625				2P					—	●	3
21626	M1.8 ×0.35	STD	RH4	4P	36	11	—	3	Yes	●	3
21627				2P					—	●	3
21628		STD+1	RH5	4P					Yes	●	3
21629				2P					—	●	3
21632	M2 ×0.4	STD	RH4	4P	40	12	—	3	Yes	●	3
21633				2P					—	●	3
21634		STD+1	RH5	4P					Yes	●	3
21635				2P					—	●	3
21636		STD+2	RH6	4P					Yes	●	3
21637				2P					—	●	3
21656	M2.3 ×0.4	STD	RH4	4P	42	13	—	3	Yes	●	4
21657				2P					—	●	4
21658		STD+1	RH5	4P					Yes	●	4
21659				2P					—	●	4
21660		STD+2	RH6	4P					Yes	●	4
21661				2P					—	●	4
21668	M2.5 ×0.45	STD	RH4	4P	44	14	—	3	Yes	●	4
21669				2P					—	●	4
21670		STD+1	RH5	4P					Yes	●	4
21671				2P					—	●	3
21672		STD+2	RH6	4P					Yes	●	4
21673				2P					—	●	3
21680	M2.6 ×0.45	STD	RH4	4P	44	14	—	3	Yes	●	4
21681				2P					—	●	4
21682		STD+1	RH5	4P					Yes	●	4
21683				2P					—	●	4

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品2P：M2.3以下为突顶尖。
3. M2.6以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
21684	M2.6 ×0.45	STD+2	RH6	4P	44	14	—	3	Yes	●	4
21685				2P					—	●	4
10730	M3 ×0.5	STD	RH5	4P	46	9	18	4	Yes	●	5
10731				2P					—	●	5
10734	M3.5 ×0.6	STD	RH4	4P	48	9	18	4	Yes	●	5
10735				2P					—	●	5
10738	M4 ×0.7	STD	RH6	4P	52	10	20	5	Yes	●	8
10739				2P					—	●	8
10742	M5 ×0.8	STD		4P	60	11	22	5.5	Yes	●	11
10743				2P					—	●	11
10746	M6 ×1	STD	RH7	4P	62	12	24	6	Yes	●	13
10747				2P					—	●	13
10750	M7 ×1	STD	RH6	4P	65	13	26	6.2	—	●	18
10751				2P					—	●	18
10754	M8 ×1.25	STD	RH7	4P	70	18	—	6.2	—	●	20
10755				2P					—	●	20
10758	M8 ×1			4P	70	18	—	6.2	—	●	21
10759				2P					—	●	21
10762	M10 ×1.5			4P	75	19	—	7	—	●	30
10763				2P					—	●	30
10766	M10 ×1.25			4P	75	19	—	7	—	●	30
10767				2P					—	●	30
10770	M10 ×1			4P	75	19	—	7	—	●	31
10771				2P					—	●	31
10774	M12 ×1.75	STD	RH8	4P	82	23	—	8.5	—	●	48
10775				2P					—	●	48
10776	M12 ×1.5	STD	RH7	4P	82	23	—	8.5	—	●	49
10777				2P					—	●	49
10778	M12 ×1.25			4P	82	23	—	8.5	—	●	50
10779				2P					—	●	50
10780	M12 ×1			4P	82	23	—	8.5	—	●	50
10781				2P					—	●	50
10782	M14 ×2	STD	RH10	4P	88	25	—	10.5	—	●	78
10783				2P					—	●	78
10784	M14 ×1.5	STD	RH9	4P	88	25	—	10.5	—	●	79
10785				2P					—	●	80
10786	M16 ×2	STD	RH10	4P	95	27	—	12.5	—	●	111
10787				2P					—	●	113
10788	M16 ×1.5	STD	RH9	4P	95	27	—	12.5	—	●	114
10789				2P					—	●	114
10790	M18 ×2.5	STD	RH11	4P	100	29	—	14	—	●	133
10791				2P					—	●	136
10792	M18 ×1.5	STD	RH10	4P	100	29	—	14	—	●	141
10793				2P					—	●	141
10794	M20 ×2.5	STD	RH11	4P	105	30	—	15	—	●	170
10795				2P					—	●	171
10796	M20 ×1.5	STD	RH10	4P	105	30	—	15	—	●	175
10797				2P					—	●	176

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Taps of M2.3 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307400	No. 0 - 80UNF	STD	RH3	4P	36	10	—	3	Yes	●	3
8307401				2P					Yes	●	3
8307404		STD+2	RH5	4P					Yes	●	3
8307405				2P					Yes	●	3
8307408	No. 1 - 64UNC	STD	RH3	4P	36	11	—	3	Yes	●	3
8307409				2P					Yes	●	3
8307412		STD+2	RH5	4P					Yes	●	3
8307413				2P					Yes	●	3
8307416	No. 1 - 72UNF	STD	RH3	4P	36	11	—	3	Yes	●	3
8307417				2P					Yes	●	3
8307420		STD+2	RH5	4P					Yes	●	3
8307421				2P					Yes	●	3
8307424	No. 2 - 56UNC	STD	RH4	4P	42	13	—	3	Yes	●	4
8307425				2P					Yes	●	3
8307428		STD+2	RH6	4P					Yes	●	4
8307429				2P					Yes	●	4
8307432	No. 2 - 64UNF	STD	RH3	4P	42	13	—	3	Yes	●	4
8307433				2P					Yes	●	4
8307436		STD+2	RH5	4P					Yes	●	4
8307437				2P					Yes	●	4
8307440	No. 3 - 48UNC	STD	RH4	4P	44	14	—	3	Yes	●	4
8307441				2P					—	●	4
8307444		STD+2	RH6	4P					Yes	●	4
8307445				2P					—	●	4
8307448	No. 3 - 56UNF	STD	RH4	4P	44	14	—	3	Yes	●	4
8307449				2P					—	●	4
8307452		STD+2	RH6	4P					Yes	●	4
8307453				2P					—	●	4
8307456	No. 4 - 40UNC	STD	RH5	4P	44	15	—	3	Yes	●	4
8307457				2P					—	●	4
8307460		STD+2	RH7	4P					Yes	●	4
8307461				2P					—	●	4
8307464	No. 4 - 48UNF	STD	RH4	4P	44	15	—	3	Yes	●	4
8307465				2P					—	●	4
8307468		STD+2	RH6	4P					Yes	●	4
8307469				2P					—	●	4
8307472	No. 5 - 40UNC	STD	RH5	4P	46	9	18	4	Yes	●	5

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照 P.836)
2. 2002年7月前生产品2P：NO.2以下为突顶尖。
3. NO.4以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307473	No. 5 - 40UNC	STD	RH5	2P	46	9	18	4	—	●	5
8307476		STD+2	RH7	4P					Yes	●	5
8307477				2P					—	●	5
8307480	No. 5 - 44UNF	STD	RH5	4P	46	9	18	4	Yes	●	5
8307481				2P					—	●	5
8307484		STD+2	RH7	4P					Yes	●	5
8307485				2P					—	●	5
8307488	No. 6 - 32UNC	STD	RH5	4P	48	9	18	4	Yes	●	5
8307489				2P					—	●	5
8307492		STD+2	RH7	4P					Yes	●	5
8307493				2P					—	●	5
8307496	No. 6 - 40UNF	STD	RH5	4P	48	9	18	4	Yes	●	6
8307497				2P					—	●	6
8307500		STD+2	RH7	4P					Yes	●	6
8307501				2P					—	●	6
8307504	No. 8 - 32UNC	STD	RH5	4P	52	10	20	5	Yes	●	8
8307505				2P					—	●	7
8307508		STD+2	RH7	4P					Yes	●	8
8307509				2P					—	●	8
8307512	No. 8 - 36UNF	STD	RH5	4P	52	10	20	5	Yes	●	8
8307513				2P					—	●	8
8307516		STD+2	RH7	4P					Yes	●	8
8307517				2P					—	●	8
8307520	No.10 - 24UNC	STD	RH6	4P	60	11	22	5.5	Yes	●	11
8307521				2P					—	●	10
8307524		STD+2	RH8	4P					Yes	●	11
8307525				2P					—	●	11
8307528	No.10 - 32UNF	STD	RH5	4P	60	11	22	5.5	Yes	●	11
8307529				2P					—	●	10
8307532		STD+2	RH7	4P					Yes	●	11
8307533				2P					—	●	10
8307536	No.12 - 24UNC	STD	RH6	4P	60	11	22	5.5	Yes	●	11
8307537				2P					—	●	12
8307540		STD+2	RH8	4P					Yes	●	12
8307541				2P					—	●	12
8307544	No.12 - 28UNF	STD	RH5	4P	60	11	22	5.5	Yes	●	12
8307545				2P					—	●	12

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Taps of No.2 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ No.4: without oil groove.
4. ℓc: 4P : P (for through holes), 2P : B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

下一页
尺寸 Size NO.12 ~ ¼ NEXT

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

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

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

△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1065

TiN涂层

TiN COATED

TIN-NRT

HSSE | TiN

上一页
FROM 尺寸 Size NO.0 ~ NO.12

螺纹种类：U

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307548	No.12- 28UNF	STD+2	RH7	4P	60	11	22	5.5	Yes	●	12
8307549				2P					—	●	12
8307552	1/4 - 20UNC	STD	RH6	4P	62	14	24	6	Yes	●	14
8307553				2P					—	●	14
8307556		STD+2	RH8	4P					Yes	●	14

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

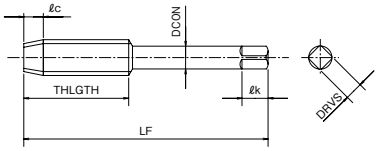
1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照 P.836)
2. 2002年7月前生产品中2P：NO.2以下为突顶尖。
3. NO.4以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

■NU-ROLL 丝锥 NU-ROLL

适用于钢、非铁合金。可实现高速切削，寿命大幅提高，高效率攻丝。

Suitable for tapping steels and nonferrous metal alloys. Capable of efficient, long life, high speed tapping.



単位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307557	1/4 - 20UNC	STD+2	RH8	2P	62	14	24	6	—	●	14
8307560	1/4 - 28UNF	STD	RH5	4P	62	14	24	6	Yes	●	14
8307561				2P					—	●	14
8307564		STD+2	RH7	4P					Yes	●	14
8307565				2P					—	●	14

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Taps of No.2 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ No.4: without oil groove.
4. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

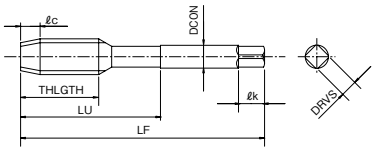
G-LIST No. | TH1108

TiN涂层

TiN COATED · LONG SHANK

TIN-LT-NRT

HSSE | TiN



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8308354	M 3 ×0.5	STD	RH5	4P	80	9	18	4	Yes	●	10
8308355				2P					—	●	10
8308358				4P	120				Yes	●	13
8308359				2P					—	●	13
8308362	M 3.5 ×0.6	STD	RH4	4P	80	9	18	4	Yes	●	10
8308363				2P					—	●	10
8308366				4P	120				Yes	●	13
8308367				2P					—	●	13
8308370	M 4 ×0.7	STD	RH6	4P	80	10	20	5	Yes	●	13
8308371				2P					—	●	13
8308374				4P	120				Yes	●	19
8308375				2P					—	●	19
8308378	M 5 ×0.8			4P	100	11	22	5.5	Yes	●	20
8308379				2P					—	●	19
8308382				4P	150				Yes	●	29
8308383				2P					—	●	29
8308384	M 6 ×1	STD	RH7	4P	100	12	24	6	Yes	●	25
8308385				2P					—	●	24
8308388				4P	150				Yes	●	35
8308389				2P					—	●	34
8308398	M 8 ×1.25			4P	100	18	37	6.2	—	●	28
8308399				2P					—	●	28
8308402				4P	150				—	●	40
8308403				2P					—	●	41
8308406	M 8 ×1			4P	100	18	37	6.2	—	●	29
8308407				2P					—	●	29
8308410				4P	150				—	●	42
8308411				2P					—	●	41

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲= 该产品已停止生产，由LT-S-XPF(P.546)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8308412	M10 ×1.5	STD	RH7	4P	100	19	41	7	—	●	34
8308413				2P					—	●	39
8308416				4P	150				—	●	55
8308417				2P					—	●	55
8308420	M10 ×1.25			4P	100				—	●	39
8308421				2P					—	●	39
8308424				4P	150				—	●	55
8308425				2P					—	●	55
8308428	M10 ×1			4P	100				—	●	40
8308429				2P					—	●	40
8308432				4P	150				—	●	62
8308433				2P					—	●	56
8308438	M12 ×1.75	STD	RH8	4P	150	23	48	8.5	—	●	80
8308439				2P					—	●	79
8308440				4P	200				—	△	100
8308441				2P					—	△	103
8308446	M12 ×1.5			4P	150	23	48	8.5	—	▲	81
8308447				2P					—	▲	87
8308448				4P	200				—	△	110
8308449				2P					—	△	110
8308454	M12 ×1.25			4P	150	23	48	8.5	—	▲	81
8308455				2P					—	▲	81
8308456				4P	200				—	△	104
8308457				2P					—	△	112
8308462	M12 ×1			4P	150	23	48	8.5	—	△	83
8308463				2P					—	△	81
8308464				4P	200				—	△	112
8308465				2P					—	△	113

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 4P : P (for through holes), 2P : B (for blind holes)
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by LT-S-XPF (p.546).

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1032

钢铁用
FOR STEELS

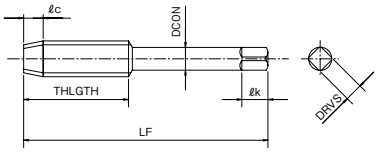
NRT

HSS | H

■NU-ROLL 丝锥 NU-ROLL

通过塑性变形形成螺纹，适用于延展性大的低碳钢，低碳素合金钢，不锈钢等材料。无切屑排出，对于盲孔特别有效。

Using plastic deformation to produce internal threads, this tap is suitable for tapping low carbon steels, alloy steels and stainless steels. It is especially efficient for tapping blind holes because it creates no chips.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
21090	M1 ×0.25	STD	RH4	4P	30	7	—	3	Yes	▲	3
21091				2P					—	●	3
21092		STD+1	RH5	4P					Yes	●	3
21093				2P					—	●	3
21096	M1.1 ×0.25	STD	RH4	4P	32	8	—	3	Yes	●	3
21097				2P					—	●	3
21098		STD+1	RH5	4P					Yes	●	3
21099				2P					—	●	3
21102	M1.2 ×0.25	STD	RH4	4P	32	8	—	3	Yes	●	3
21103				2P					—	●	3
21104		STD+1	RH5	4P					Yes	●	3
21105				2P					—	●	3
21108	M1.4 ×0.3	STD	RH4	4P	34	9	—	3	Yes	●	3
21109				2P					—	●	3
21110		STD+1	RH5	4P					Yes	●	3
21111				2P					—	●	3
21114	M1.6 ×0.35	STD	RH4	4P	36	10	—	3	Yes	●	3
21115				2P					—	●	3
21116		STD+1	RH5	4P					Yes	●	3
21117				2P					—	●	3
21120	M1.7 ×0.35	STD	RH4	4P	36	11	—	3	Yes	●	3
21121				2P					—	●	3
21122		STD+1	RH5	4P					Yes	●	3
21123				2P					—	●	3
21124		STD+2	RH6	4P					Yes	●	3
21125				2P					—	●	3
21126	M1.8 ×0.35	STD	RH4	4P	36	11	—	3	Yes	●	3
21127				2P					—	●	3
21128		STD+1	RH5	4P					Yes	●	3
21129				2P					—	●	3
21132	M2 ×0.4	STD	RH4	4P	40	12	—	3	Yes	●	3
21133				2P					—	●	3
21134		STD+1	RH5	4P					Yes	●	3
21135				2P					—	●	3
21136		STD+2	RH6	4P					Yes	●	3
21137				2P					—	●	3
21138	M2 ×0.25	STD	RH4	4P	40	12	—	3	Yes	●	3
21139				2P					—	●	4
21140		STD+1	RH5	4P					Yes	●	4
21141				2P					—	●	4
21144	M2.2 ×0.45	STD	RH4	4P	42	13	—	3	Yes	●	3
21145				2P					—	●	4
21146		STD+1	RH5	4P					Yes	●	4
21147				2P					—	●	4
21156	M2.3 ×0.4	STD	RH4	4P	42	13	—	3	Yes	●	3
21157				2P					—	●	3
21158		STD+1	RH5	4P					Yes	●	4
21159				2P					—	●	4
21160		STD+2	RH6	4P					Yes	●	4
21161				2P					—	●	4
21168	M2.5 ×0.45	STD	RH4	4P	44	14	—	3	Yes	●	3
21169				2P					—	●	3
21170		STD+1	RH5	4P					Yes	●	4
21171				2P					—	●	4
21172		STD+2	RH6	4P					Yes	●	4
21173				2P					—	●	4

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
21180	M2.6 ×0.45	STD	RH4	4P	44	14	—	3	Yes	●	3
21181				2P					—	●	3
21182		STD+1	RH5	4P					Yes	●	3
21183				2P					—	●	3
21184		STD+2	RH6	4P					Yes	●	3
21185				2P					—	●	3
12410	M3 ×0.5	STD-2	RH3	4P	46	9	18	4	Yes	●	5
12411				2P					—	●	5
12414		STD	RH5	4P					Yes	●	5
12415				2P					—	●	5
12418		STD+3	RH8	4P					Yes	●	5
12419				2P					—	●	5
12420	M3.5 ×0.6	STD-2	RH3	4P	48	9	18	4	Yes	●	5
12421				2P					—	●	5
12424		STD	RH5	4P					Yes	●	5
12425				2P					—	●	5
12430	M4 ×0.7	STD-2	RH4	4P	52	10	20	5	Yes	●	8
12431				2P					—	●	8
12434		STD	RH6	4P					Yes	●	8
12435				2P					—	●	8
12438		STD+3	RH9	4P					Yes	●	8
12439				2P					—	●	8
12440	M5 ×0.8	STD-2	RH4	4P	60	11	22	5.5	Yes	●	11
12441				2P					—	●	11
12444		STD	RH6	4P					Yes	●	11
12445				2P					—	●	11
12448		STD+3	RH9	4P					Yes	●	11
12449				2P					—	●	11
12450	M6 ×1	STD-3	RH4	4P	62	12	24	6	Yes	●	14
12451				2P					—	●	14
12456		STD	RH7	4P					Yes	●	13
12457				2P					—	●	13
12460		STD+2	RH9	4P					Yes	●	14
12461				2P					—	●	14
12466	M7 ×1	STD	RH6	4P	65	13	26	6.2	—	●	17
12467				2P					—	●	18
12472	M8 ×1.25	STD-2	RH5	4P	70	18	—	6.2	—	●	20
12473				2P					—	●	21
12476		STD	RH7	4P					—	●	20
12477				2P					—	●	20
12478		STD+1	RH8	4P					—	●	20
12479				2P					—	●	20
12484	M8 ×1	STD-3	RH4	4P	70	18	—	6.2	—	●	20
12485				2P					—	●	20
12490		STD	RH7	4P					—	●	20
12491				2P					—	●	21
12504	M10 ×1.5	STD-2	RH5	4P	75	19	—	7	—	●	29
12505				2P					—	●	30
12508		STD	RH7	4P					—	●	30
12509				2P					—	●	30
12512		STD+2	RH9	4P					—	●	30
12513				2P					—	●	30
12518	M10 ×1.25	STD-2	RH5	4P	75	19	—	7	—	●	30
12519				2P					—	●	30
12522		STD	RH7	4P					—	●	31
12523				2P					—	●	31

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尺寸 Size M10 ～ M20 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

上一页
FROM 尺寸 Size M1 ~ M10

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12524	M10 ×1.25	STD+1	RH8	4P	75	19	—	7	—	●	30
12525				2P					—	●	30
12530	M10 ×1	STD-2	RH5	4P	75	19	—	7	—	●	30
12531				2P					—	●	30
12534		STD	RH7	4P					—	●	30
12535				2P					—	●	30
12536		STD+1	RH8	4P					—	●	30
12537				2P					—	●	30
12542	M12 ×1.75	STD-2	RH6	4P	82	23	—	8.5	—	●	48
12543				2P					—	●	48
12546		STD	RH8	4P					—	●	48
12547				2P					—	●	49
12550		STD+2	RH10	4P					—	●	48
12551				2P					—	●	48
12556	M12 ×1.5	STD-2	RH5	4P	82	23	—	8.5	—	●	48
12557				2P					—	●	48
12560		STD	RH7	4P					—	●	48
12561				2P					—	●	48
12564		STD+2	RH9	4P					—	●	48
12565				2P					—	●	48
12572	M12 ×1.25	STD-2	RH5	4P	82	23	—	8.5	—	●	48
12573				2P					—	●	50
12576		STD	RH7	4P					—	●	49

■突顶尖长·柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：M2.3以下为突顶尖。
3. M2.6以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲=该产品已停止生产，由S-XPF(P.544)替代。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12577	M12 ×1.25	STD	RH7	2P	82	23	—	8.5	—	●	50
12584		STD+4	RH11	4P					—	●	49
12585				2P					—	●	50
12594	M12 ×1	STD	RH7	4P	82	23	—	8.5	—	●	50
12595				2P					—	●	50
12598		STD+2	RH9	4P					—	●	50
12599				2P					—	●	50
12612	M14 ×2	STD	RH10	4P	88	25	—	10.5	—	▲	77
12613				2P					—	▲	78
12626	M14 ×1.5	STD	RH9	4P	88	25	—	10.5	—	▲	78
12627				2P					—	▲	79
12640	M16 ×2	STD	RH10	4P	95	27	—	12.5	—	▲	111
12641				2P					—	▲	112
12654	M16 ×1.5	STD	RH9	4P	95	27	—	12.5	—	▲	112
12655				2P					—	▲	114
12668	M18 ×2.5	STD	RH11	4P	100	29	—	14	—	▲	132
12669				2P					—	▲	132
12684	M18 ×1.5	STD	RH10	4P	100	29	—	14	—	▲	139
12685				2P					—	▲	141
12686	M20 ×2.5	STD	RH11	4P	105	30	—	15	—	▲	175
12687				2P					—	▲	175
12688	M20 ×1.5	STD	RH10	4P	105	30	—	15	—	▲	175
12689				2P					—	▲	178

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Taps of M2.3 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲=The products have been stopped producing and replaced by S-XPF(p.544).

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1032

钢铁用
FOR STEELS

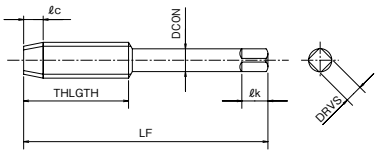
NRT

HSS | H

■NU-ROLL 丝锥 NU-ROLL

通过塑性变形形成螺纹，适用于延展性大的低碳钢，低碳素合金钢，不锈钢等材料。由于不产生切屑，因而在加工盲孔时格外有效。

Using plastic deformation to produce internal threads, this tap is suitable for tapping low carbon steels, alloy steels and stainless steels. It is especially efficient for tapping blind holes because it creates no chips.



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307001	No. 0 - 80UNF	STD	RH3	2P	36	10	—	3	Yes	▲	3
8307004		STD+2	RH5	4P					Yes	▲	3
8307005				2P					Yes	▲	3
8307008	No. 1 - 64UNC	STD	RH3	4P	36	11	—	3	Yes	▲	3
8307009				2P					Yes	▲	3
8307012		STD+2	RH5	4P					Yes	▲	3
8307013				2P					Yes	▲	3
8307016	No. 1 - 72UNF	STD	RH3	4P	36	11	—	3	Yes	▲	3
8307020		STD+2	RH5	4P					Yes	▲	3
8307021				2P					Yes	▲	3
8307024	No. 2 - 56UNC	STD	RH4	4P	42	13	—	3	Yes	▲	4
8307028		STD+2	RH6	4P					Yes	▲	4
8307029				2P					Yes	▲	4
8307032	No. 2 - 64UNF	STD	RH3	4P	42	13	—	3	Yes	▲	4
8307033				2P					Yes	▲	4
8307036		STD+2	RH5	4P					Yes	▲	4
8307037				2P					Yes	▲	4
8307040	No. 3 - 48UNC	STD	RH4	4P	44	14	—	3	Yes	▲	4
8307044		STD+2	RH6	4P					Yes	▲	4
8307045				2P					—	▲	4
8307048	No. 3 - 56UNF	STD	RH4	4P	44	14	—	3	Yes	▲	4
8307049				2P					—	▲	4
8307052		STD+2	RH6	4P					Yes	▲	4
8307053				2P					—	▲	4
8307060	No. 4 - 40UNC	STD+2	RH7	4P	44	15	—	3	Yes	▲	4
8307061				2P					—	▲	4
8307064	No. 4 - 48UNF	STD	RH4	4P	44	15	—	3	Yes	▲	4
8307068		STD+2	RH6	4P					Yes	▲	4
8307069				2P					—	▲	4
8307072	No. 5 - 40UNC	STD	RH5	4P	46	9	18	4	Yes	▲	5
8307073				2P					—	▲	5
8307076		STD+2	RH7	4P					Yes	▲	5
8307077				2P					—	▲	5

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：NO.2以下为突顶尖。
3. NO.4以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲=该产品已停止生产，由TIN-NRT(P.562) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307080	No. 5 - 44UNF	STD	RH5	4P	46	9	18	4	Yes	▲	5
8307081				2P					—	▲	5
8307084		STD+2	RH7	4P					Yes	▲	5
8307085				2P					—	▲	5
8307092	No. 6 - 32UNC			4P	48	9	18	4	Yes	▲	5
8307096	No. 6 - 40UNF	STD	RH5	4P	48	9	18	4	Yes	▲	5
8307097				2P					—	▲	5
8307100		STD+2	RH7	4P					Yes	▲	5
8307101				2P					—	▲	5
8307104	No. 8 - 32UNC	STD	RH5	4P	52	10	20	5	Yes	▲	8
8307108		STD+2	RH7	4P					Yes	▲	8
8307109				2P					—	▲	8
8307112	No. 8 - 36UNF	STD	RH5	4P	52	10	20	5	Yes	▲	8
8307113				2P					—	▲	8
8307117		STD+2	RH7	2P					—	▲	8
8307120	No.10 - 24UNC	STD	RH6	4P	60	11	22	5.5	Yes	▲	11
8307121				2P					—	▲	11
8307124		STD+2	RH8	4P					Yes	▲	11
8307125				2P					—	▲	11
8307136	No.12 - 24UNC	STD	RH6	4P	60	11	22	5.5	Yes	▲	12
8307137				2P					—	▲	12
8307140		STD+2	RH8	4P					Yes	▲	12
8307141				2P					—	▲	12
8307144	No.12 - 28UNF	STD	RH5	4P	60	11	22	5.5	Yes	▲	12
8307145				2P					—	▲	12
8307148		STD+2	RH7	4P					Yes	▲	12
8307149				2P					—	▲	12
8307156	¼ - 20UNC	STD+2	RH8	4P	62	14	24	6	Yes	▲	14
8307157				2P					—	▲	14
8307160	¼ - 28UNF	STD	RH5	4P	62	14	24	6	Yes	▲	14
8307164		STD+2	RH7	4P					Yes	▲	14
8307165				2P					—	▲	14

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Taps of No.2 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ No.4: without oil groove.
4. ℓc: 4P : P (for through holes), 2P : B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by TIN-NRT(p.562).

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1030

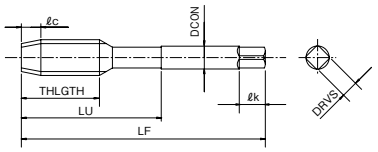
钢用长柄型

LONG SHANK· FOR STEELS

LT-NRT

■NU-ROLL 丝锥 NU-ROLL

HSS　H



螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
14801	M 3 ×0.5	STD	RH5	2P	80	9	18	4	—	●	9
14805					120				—	●	13
14811	M 4 ×0.7	STD	RH6		80	10	20	5	—	●	13
14815					120				—	●	18
14823	M 5 ×0.8				100	11	22	5.5	—	●	20
14827					150				—	●	29
14833	M 6 ×1	STD	RH7		100	12	24	6	—	●	25
14837					150				—	●	34
14843	M 8 ×1.25				100	18	37	6.2	—	●	29
14847					150				—	●	41

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲＝该产品已停止生产，由LT-S-XPF(P.546) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
14853	M10 ×1.5	STD	RH7	2P	100	19	41	7	—	●	38
14857					150				—	●	52
14863	M10 ×1.25				100	19	41	7	—	●	39
14867					150				—	●	55
14877	M12 ×1.75	STD	RH8		150	23	48	8.5	—	▲	80
14879					200				—	△	102
14887	M12 ×1.5	STD	RH7		150	23	48	8.5	—	▲	78
14889					200				—	△	108
14897	M12 ×1.25	STD	RH7		150	23	48	8.5	—	▲	80
14899					200				—	△	101

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲＝The products have been stopped producing and replaced by LT-S-XPF (p.546).

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TW1006

硬质合金挤压丝锥

CARBIDE FLUTELESS (NU-ROLL)

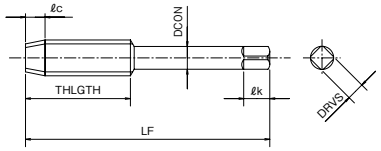
OT-NRT

CARBIDE

■NU-ROLL 丝锥 NU-ROLL

用于铝合金，镁合金、铜合金的大量高精度的加工，通过塑性变形形成螺纹，无切屑、可稳定连续加工。

Suitable for high production with high precision in automatic machines. This tap is ideal for tapping materials such as aluminum alloys and copper alloys. Stable and continuous operation is possible because no chips are generated during deformation.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8315054	M 3×0.5	STD	RH5	4P	46	11	19	4	Yes	▲	7
8315055				2P					—	●	7
8315060	M 4×0.7	STD	RH6	4P	52	13	21	5	Yes	▲	12
8315061				2P					—	●	12
8315066	M 5×0.8	STD	RH6	4P	60	16	24	5.5	Yes	▲	18
8315067				2P					—	●	18
8315072	M 6×1	STD	RH7	4P	62	19	29	6	—	▲	21
8315073				2P					—	●	21
8315084	M 8×1.25	STD	RH7	4P	70	22	—	6.2	—	▲	33
8315085				2P					—	●	33

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲=该产品已停止生产，由OT- NRT(切削锥：2P)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8315096	M10×1.5	STD	RH7	4P	75	24	—	7	—	▲	49
8315097				2P					—	●	49
8315102	M10×1.25	STD	RH7	4P	75	24	—	7	—	▲	50
8315103				2P					—	●	49
8315114	M12×1.75	STD	RH8	4P	82	29	—	8.5	—	▲	79
8315115				2P					—	●	79
8315120	M12×1.5	STD	RH7	4P	82	29	—	8.5	—	▲	79
8315121				2P					—	●	79
8315126	M12×1.25	STD	RH7	4P	82	29	—	8.5	—	▲	81
8315127				2P					—	●	80

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲=The products have been stopped producing and replaced by OT-NRT(ℓc:2P).

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

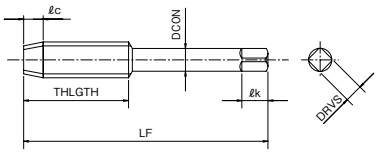
G-LIST No. | TW1010

硬质合金挤压丝锥长柄型

CARBIDE LONG SHANK· FLUTELESS (NU-ROLL)

OT-LT-NRT

CARBIDE



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	在库 Stock	重量 (g)
8315620	M 3 ×0.5	STD	RH5	4P	100	11	19	4	Yes	▲	18
8315621				2P					—	●	18
8315624	M 4 ×0.7	STD	RH6	4P	100	13	21	5	Yes	▲	26
8315625				2P					—	●	26
8315628	M 5 ×0.8	STD	RH6	4P	100	16	24	5.5	Yes	▲	32
8315629				2P					—	●	32
8315632	M 6 ×1	STD	RH7	4P	100	19	29	6	—	▲	39
8315633				2P					—	●	39
8315638	M 8 ×1.25	STD	RH7	4P	150	22	—	6.2	—	▲	68
8315639				2P					—	●	68

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲＝该产品已停止生产，由OT-LT-NRT(切削锥：2P) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	在庫 Stock	重量 (g)
8315644	M10 ×1.5	STD	RH7	4P	150	24	—	7	—	▲	91
8315645				2P					—	●	90
8315648	M10 ×1.25	STD	RH7	4P	150	24	—	7	—	▲	90
8315649				2P					—	●	91
8315652	M12 ×1.75	STD	RH8	4P	150	29	—	8.5	—	▲	133
8315653				2P					—	●	133
8315656	M12 ×1.5	STD	RH7	4P	150	29	—	8.5	—	▲	135
8315657				2P					—	●	135
8315660	M12 ×1.25	STD	RH7	4P	150	29	—	8.5	—	▲	135
8315661				2P					—	●	134

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲＝The products have been stopped producing and replaced by OT-LT-NRT (ℓc:2P).

G-LIST No. | TW1019

镶刃式硬质合金挤压丝锥

CARBIDE BRAZED TYPE· FLUTELESS(NU-ROLL)

OT-IN-NRT

CARBIDE

螺纹种类：M

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8315829	M 5 ×0.8	STD	RH6	2P	60	10	24	5.5	—	△	11
8315833	M 6 ×1	STD	RH7		62	12	29	6	—	△	13
8315839	M 8 ×1.25	STD	RH7		70	15	36	7	—	△	23
8315845	M10 ×1.5	STD	RH7		75	18	41	8.5	—	△	37

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

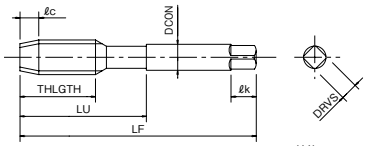
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 丝锥精度不能保证内螺纹的精度。
3. 全尺寸均有中心孔。
4. 切削锥长2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

■NU-ROLL 丝锥 NU-ROLL

超微粒子硬质合金镶刃丝锥，兼具韧性优越的高速钢母材之耐磨性，高刚性折损强度高，可实现长寿命稳定加工。

Strong against breakage and very consistent tool life provided by high rigidity high speed steel base material and soldered with ultra fine micro grain carbide material tip.



单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8315849	M10 ×1.25	STD	RH7	2P	75	18	41	8.5	—	△	38
8315853	M12 ×1.75	STD	RH8		82	21	43	8.5	—	△	61
8315857	M12 ×1.5	STD	RH7		82	21	43	8.5	—	△	61
8315861	M12 ×1.25	STD	RH7		82	21	43	8.5	—	△	62

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. All size:with female center
4. ℓc:2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1033

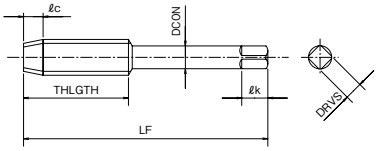
非铁合金用
FOR NON-FERROUS METALS

B-NRT

HSS | N

■NU-ROLL 丝锥 NU-ROLL

适用于铝、锌、铜等非铁合金加工。
Suitable for tapping aluminum, zinc, copper, and nonferrous metal alloys.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
21390	M 1 ×0.25	STD	RH4	4P	30	7	—	3	Yes	▲	3
21391				2P					—	●	3
21392		STD+1	RH5	4P					Yes	▲	3
21393				2P					—	●	3
21396	M 1.1 ×0.25	STD	RH4	4P	32	8	—	3	Yes	▲	3
21397				2P					—	●	3
21398		STD+1	RH5	4P					Yes	▲	3
21399				2P					—	●	3
21402	M 1.2 ×0.25	STD	RH4	4P	32	8	—	3	Yes	▲	3
21403				2P					—	●	3
21404		STD+1	RH5	4P					Yes	▲	3
21405				2P					—	●	3
21408	M 1.4 ×0.3	STD	RH4	4P	34	9	—	3	Yes	▲	3
21409				2P					—	●	3
21410		STD+1	RH5	4P					Yes	▲	3
21411				2P					—	●	3
21414	M 1.6 ×0.35	STD	RH4	4P	36	10	—	3	Yes	▲	3
21415				2P					—	●	3
21416		STD+1	RH5	4P					Yes	▲	3
21417				2P					—	●	3
21420	M 1.7 ×0.35	STD	RH4	4P	36	11	—	3	Yes	▲	3
21421				2P					—	●	3
21422		STD+1	RH5	4P					Yes	▲	3
21423				2P					—	●	3
21424		STD+2	RH6	4P					Yes	▲	3
21425				2P					—	●	3
21426	M 1.8 ×0.35	STD	RH4	4P	36	11	—	3	Yes	▲	3
21427				2P					—	●	3
21428		STD+1	RH5	4P					Yes	▲	3
21429				2P					—	●	3
21432	M 2 ×0.4	STD	RH4	4P	40	12	—	3	Yes	▲	3
21433				2P					—	●	3
21434		STD+1	RH5	4P					Yes	▲	3
21435				2P					—	●	3
21436		STD+2	RH6	4P					Yes	▲	3
21437				2P					—	●	3
21438	M 2 ×0.25	STD	RH4	4P	40	12	—	3	Yes	▲	3
21439				2P					—	●	3
21440		STD+1	RH5	4P					Yes	▲	3
21441				2P					—	●	3
21444	M 2.2 ×0.45	STD	RH4	4P	42	13	—	3	Yes	▲	4
21445				2P					—	●	4
21446		STD+1	RH5	4P					Yes	▲	4
21447				2P					—	●	4
21456	M 2.3 ×0.4	STD	RH4	4P	42	13	—	3	Yes	▲	3
21457				2P					—	●	3
21458		STD+1	RH5	4P					Yes	▲	4
21459				2P					—	●	4
21460		STD+2	RH6	4P					Yes	▲	4
21461				2P					—	●	4
21468	M 2.5 ×0.45	STD	RH4	4P	44	14	—	3	Yes	▲	3
21469				2P					—	●	3
21470		STD+1	RH5	4P					Yes	▲	4
21471				2P					—	●	4
21472		STD+2	RH6	4P					Yes	▲	4
21473				2P					—	●	4
21480	M 2.6 ×0.45	STD	RH4	4P	44	14	—	3	Yes	▲	3

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
21481	M 2.6 ×0.45	STD	RH4	2P	44	14	—	3	—	●	3
21482		STD+1	RH5	4P					Yes	▲	3
21483				2P					—	●	3
21484		STD+2	RH6	4P					Yes	▲	3
21485				2P					—	●	4
12710	M 3 ×0.5	STD-2	RH3	4P	46	9	18	4	Yes	▲	5
12711				2P					—	●	5
12714		STD	RH5	4P					Yes	▲	5
12715				2P					—	●	5
12718		STD+3	RH8	4P					Yes	▲	5
12719				2P					—	●	5
12720	M 3.5 ×0.6	STD-2	RH3	4P	48	9	18	4	Yes	▲	8
12721				2P					—	●	6
12724		STD	RH5	4P					Yes	▲	5
12725				2P					—	●	5
12730	M 4 ×0.7	STD-2	RH4	4P	52	10	20	5	Yes	▲	8
12731				2P					—	●	8
12734		STD	RH6	4P					Yes	▲	8
12735				2P					—	●	8
12738		STD+3	RH9	4P					Yes	▲	8
12739				2P					—	●	8
12740	M 5 ×0.8	STD-2	RH4	4P	60	11	22	5.5	Yes	▲	6
12741				2P					—	●	11
12744		STD	RH6	4P					Yes	▲	8
12745				2P					—	●	11
12748		STD+3	RH9	4P					Yes	▲	11
12749				2P					—	●	11
12750	M 6 ×1	STD-3	RH4	4P	62	12	24	6	Yes	▲	14
12751				2P					—	●	14
12756		STD	RH7	4P					Yes	▲	13
12757				2P					—	●	13
12760		STD+2	RH9	4P					Yes	▲	13
12761				2P					—	●	13
12766	M 7 ×1	STD	RH6	4P	65	13	26	6.2	—	▲	17
12767				2P					—	●	17
12772	M 8 ×1.25	STD-2	RH5	4P	70	18	—	6.2	—	▲	18
12773				2P					—	●	20
12776		STD	RH7	4P					—	▲	20
12777				2P					—	●	20
12778		STD+1	RH8	4P					—	▲	20
12779				2P					—	●	20
12784	M 8 ×1	STD-3	RH4	4P	70	18	—	6.2	—	▲	20
12785				2P					—	●	20
12790		STD	RH7	4P					—	▲	20
12791				2P					—	●	20
12804	M10 ×1.5	STD-2	RH5	4P	75	19	—	7	—	▲	30
12805				2P					—	●	30
12808		STD	RH7	4P					—	▲	30
12809				2P					—	●	30
12812		STD+2	RH9	4P					—	▲	30
12813				2P					—	●	30
12818	M10 ×1.25	STD-2	RH5	4P	75	19	—	7	—	▲	30
12819				2P					—	●	30
12822		STD	RH7	4P					—	▲	30
12823				2P					—	●	30
12824		STD+1	RH8	4P					—	▲	30
12825				2P					—	●	30

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尺寸 Size M10 ~ M20 NEXT

库存记号 Inventory symbols
●＝标准库存品
Standard stock item
○＝准标准库存品(请确认库存。)
Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。)
Discontinued item

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

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

上一页
FROM 尺寸 Size M1 ~ M10

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12830	M10×1	STD-2	RH5	4P	75	19	—	7	—	▲	30
12831				2P					—	●	30
12834		STD	RH7	4P					—	▲	30
12835				2P					—	●	30
12836		STD+1	RH8	4P					—	▲	30
12837				2P					—	●	30
12842	M12×1.75	STD-2	RH6	4P	82	23	—	8.5	—	▲	46
12843				2P					—	●	46
12846		STD	RH8	4P					—	▲	46
12847				2P					—	●	48
12850		STD+2	RH10	4P					—	▲	46
12851				2P					—	●	46
12856	M12×1.5	STD-2	RH5	4P	82	23	—	8.5	—	▲	46
12857				2P					—	●	46
12860		STD	RH7	4P					—	▲	46
12861				2P					—	●	48
12864		STD+2	RH9	4P					—	▲	46
12865				2P					—	●	46
12872	M12×1.25	STD-2	RH5	4P	82	23	—	8.5	—	▲	46
12873				2P					—	●	46
12876		STD	RH7	4P					—	▲	46
12877				2P					—	●	49

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：M2.3以下为突顶尖。
3. M2.6以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. M1.4以上氮化处理。
7. 丝锥精度不能保证内螺纹的精度。
8. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲=该产品已停止生产，由TIN-NRT(P.561)、B-NRT(切削锥：2P)替代。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12884	M12×1.25	STD+4	RH11	4P	82	23	—	8.5	—	▲	46
12885				2P					—	●	46
12894	M12×1	STD	RH7	4P	82	23	—	8.5	—	▲	46
12895				2P					—	●	50
12898		STD+2	RH9	4P					—	▲	46
12899				2P					—	●	46
12912	M14×2	STD	RH10	4P	88	25	—	10.5	—	▲	79
12913				2P					—	▲	79
12926	M14×1.5	STD	RH9	4P	88	25	—	10.5	—	▲	79
12927				2P					—	▲	79
12940	M16×2	STD	RH10	4P	95	27	—	12.5	—	▲	112
12941				2P					—	▲	112
12954	M16×1.5	STD	RH9	4P	95	27	—	12.5	—	▲	112
12955				2P					—	▲	113
12968	M18×2.5	STD	RH11	4P	100	29	—	14	—	▲	141
12969				2P					—	▲	141
12984	M18×1.5	STD	RH10	4P	100	29	—	14	—	▲	141
12985				2P					—	▲	141
12986	M20×2.5	STD	RH11	4P	105	30	—	15	—	▲	171
12987				2P					—	▲	172
12988	M20×1.5	STD	RH10	4P	105	30	—	15	—	▲	176
12989				2P					—	▲	176

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Taps of M2.3 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P : P (for through holes), 2P : B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. M1.4≧ : with nitriding
7. TAP Limit does not guarantee thread limit for the internal thread after tapping.
8. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by TIN-NRT (p.561) and B-NRT (ℓc:2P).

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1033

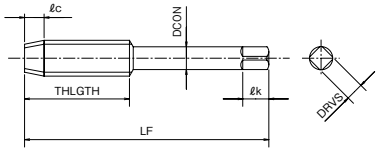
非铁合金用
FOR NON-FERROUS METALS

B-NRT

HSS | N

■NU-ROLL 丝锥 NU-ROLL

适用于铝、锌、铜等非铁合金加工。
Suitable for tapping aluminum, zinc, copper, and nonferrous metal alloys.



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307200	No. 0 - 80UNF	STD	RH3	4P	36	10	—	3	Yes	▲	3
8307204		STD+2	RH5	4P					Yes	▲	3
8307205				2P					—	▲	3
8307208	No. 1 - 64UNC	STD	RH3	4P	36	11	—	3	Yes	▲	3
8307209				2P					—	▲	3
8307212		STD+2	RH5	4P					Yes	▲	3
8307213				2P					—	▲	3
8307216	No. 1 - 72UNF	STD	RH3	4P	36	11	—	3	Yes	▲	3
8307217				2P					—	▲	3
8307220		STD+2	RH5	4P					Yes	▲	3
8307221				2P					—	▲	3
8307224	No. 2 - 56UNC	STD	RH4	4P	42	13	—	3	Yes	▲	4
8307228		STD+2	RH6	4P					Yes	▲	4
8307229				2P					—	▲	4
8307232	No. 2 - 64UNF	STD	RH3	4P	42	13	—	3	Yes	▲	4
8307233				2P					—	▲	4
8307236		STD+2	RH5	4P					Yes	▲	4
8307237				2P					—	▲	4
8307240	No. 3 - 48UNC	STD	RH4	4P	44	14	—	3	Yes	▲	4
8307241				2P					—	▲	4
8307244		STD+2	RH6	4P					Yes	▲	4
8307245				2P					—	▲	4
8307248	No. 3 - 56UNF	STD	RH4	4P	44	14	—	3	Yes	▲	4
8307249				2P					—	▲	4
8307252		STD+2	RH6	4P					Yes	▲	4
8307253				2P					—	▲	4
8307256	No. 4 - 40UNC	STD	RH5	4P	44	15	—	3	Yes	▲	4
8307260		STD+2	RH7	4P					Yes	▲	4
8307261				2P					—	▲	4
8307264	No. 4 - 48UNF	STD	RH4	4P	44	15	—	3	Yes	▲	4
8307265				2P					—	▲	4
8307268		STD+2	RH6	4P					Yes	▲	4
8307269				2P					—	▲	4

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307272	No. 5 - 40UNC	STD	RH5	4P	46	9	18	4	Yes	▲	5
8307273				2P					—	▲	5
8307276		STD+2	RH7	4P					Yes	▲	5
8307277				2P					—	▲	5
8307280	No. 5 - 44UNF	STD	RH5	4P	46	9	18	4	Yes	▲	5
8307284		STD+2	RH7	4P					Yes	▲	5
8307285				2P					—	▲	5
8307288	No. 6 - 32UNC	STD	RH5	4P	48	9	18	4	Yes	▲	5
8307292		STD+2	RH7	4P					Yes	▲	5
8307293				2P					—	▲	5
8307296	No. 6 - 40UNF	STD	RH5	4P	48	9	18	4	Yes	▲	5
8307297				2P					—	▲	5
8307300		STD+2	RH7	4P					Yes	▲	5
8307301				2P					—	▲	5
8307308	No. 8 - 32UNC	STD+2	RH7	4P	52	10	20	5	Yes	▲	8
8307309				2P					—	▲	8
8307312	No. 8 - 36UNF	STD	RH5	4P	52	10	20	5	Yes	▲	8
8307313				2P					—	▲	8
8307316		STD+2	RH7	4P					Yes	▲	8
8307317				2P					—	▲	8
8307324	No.10 - 24UNC	STD+2	RH8	4P	60	11	22	5.5	Yes	▲	11
8307328	No.10 - 32UNF	STD	RH5	4P	60	11	22	5.5	Yes	▲	11
8307332		STD+2	RH7	4P					Yes	▲	11
8307333				2P					—	▲	11
8307336	No.12 - 24UNC	STD	RH6	4P	60	11	22	5.5	Yes	▲	11
8307337				2P					—	▲	11
8307340		STD+2	RH8	4P					Yes	▲	11
8307341				2P					—	▲	11
8307344	No.12 - 28UNF	STD	RH5	4P	60	11	22	5.5	Yes	▲	11
8307345				2P					—	▲	11

下一页
尺寸 Size NO.12 ~ ¼ NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

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

上一页 FROM 尺寸 Size NO.0 ~ NO.12

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307348	No.12 - 28UNF	STD+2	RH7	4P	60	11	22	5.5	Yes	▲	11
8307349				2P					—	▲	11
8307356	1/4 - 20UNC	STD+2	RH8	4P	62	14	24	6	Yes	▲	14
8307357				2P					—	▲	14

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：NO.2以下为突顶尖。
3. NO.4以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲＝该产品已停止生产，由TIN-NRT(P.562)替代。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307360	1/4 - 28UNF	STD	RH5	4P	62	14	24	6	Yes	▲	14
8307364		STD+2	RH7	4P					Yes	▲	14
8307365				2P					—	▲	14

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. Taps of No.2 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ No.4: without oil groove.
4. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲＝The products have been stopped producing and replaced by TIN-NRT (p.562)

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1031

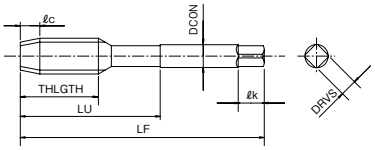
非铁合金用长柄型

LONG SHANK· FOR NON-FERROUS METALS

LT-B-NRT

HSS | N

■NU-ROLL 丝锥 NU-ROLL



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
14901	M 3 ×0.5	STD	RH5	2P	80	9	18	4	—	●	9
14905					120				—	●	13
14911	M 4 ×0.7	STD	RH6		80	10	20	5	—	●	13
14915					120				—	●	19
14923	M 5 ×0.8				100	11	22	5.5	—	●	20
14927					150				—	●	29
14933	M 6 ×1	STD	RH7		100	12	24	6	—	●	25
14937					150				—	●	34
14943	M 8 ×1.25				100	18	37	6.2	—	●	28
14947					150				—	●	41

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 切削锥长2P：B(盲孔用)
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P 左右距离。
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲＝该产品已停止生产，由 LT-S-XPF(P.546) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
14953	M 10 ×1.5	STD	RH7	2P	100	19	41	7	—	●	38
14957					150				—	●	54
14963	M 10 ×1.25				100	19	41	7	—	●	38
14967					150				—	●	55
14977	M 12 ×1.75	STD	RH8		150	23	48	8.5	—	▲	78
14979					200				—	△	99
14987	M 12 ×1.5	STD	RH7		150	23	48	8.5	—	▲	79
14989					200				—	△	102
14997	M 12 ×1.25				150	23	48	8.5	—	▲	80
14999					200				—	△	102

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 2P：B (for blind holes)
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲＝The products have been stopped producing and replaced by LT-S-XPF (p.546).

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1133

铜用
FOR COPPER

CU-NRT

HSSE | CrN

螺纹种类：M

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
28960	M 3 × 0.5	STD	RH5	2P	46	9	18	4	—	●	5
28963	M 4 × 0.7	STD	RH6		52	10	20	5	—	●	8
28966	M 5 × 0.8				60	11	22	5.5	—	●	11
28969	M 6 × 1	STD	RH7		62	12	24	6	—	●	14
28972	M 8 × 1.25				70	18	—	6.2	—	●	20
28974	M 8 × 1				70	18	—	6.2	—	●	21
28976	M10 × 1.5				75	19	—	7	—	●	30

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

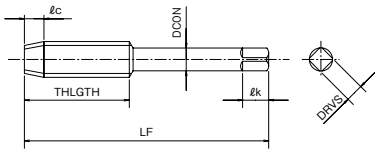
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 切削锥长2P：B(盲孔用)
3. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

■NU-ROLL 丝锥 NU-ROLL

CrN涂层对于铜有良好的耐磨损性、抗溶着性。由于采用高速钢为母材，对铜加工可以实现长寿命。

Employs CrN coating for superior wear and welding resistance, especially when working with copper materials. The HSSE body (vanadium high speed steel) provides extended tool life.



单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
28978	M10 × 1.25	STD	RH7	2P	75	19	—	7	—	●	31
28980	M10 × 1				75	19	—	7	—	●	31
28982	M12 × 1.75	STD	RH8		82	23	—	8.5	—	●	48
28984	M12 × 1.5				82	23	—	8.5	—	●	49
28986	M12 × 1.25	STD	RH7		82	23	—	8.5	—	●	49
28988	M12 × 1				82	23	—	8.5	—	●	50

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 2P : B (for blind holes)
3. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

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

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

△ = 停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1086

铝用高速同步丝锥

SYNCHRO TAPS· FOR ALUMINIUM

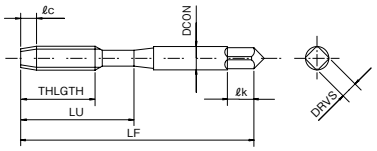
HS-AL-NRT

HSSE | SHANK h7

■NU-ROLL 丝锥 NU-ROLL

用于铝和铝合金，挤压丝锥利用材料自身的塑性变形，无切屑排出，实现高精度内螺纹加工。

For high precision internal thread processing of aluminum and aluminum alloys. Fluteless taps use the process of plastic deformation to imprint thread on material, without creating chips.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8305213	M1 ×0.25	STD	RH4	4P	30	6	—	3	Yes	▲	3
8305214				2P					—	▲	3
8305223	M1.2 ×0.25			4P	32	8	—	3	Yes	▲	3
8305224				2P					—	▲	3
8305233	M1.4 ×0.3			4P	34	9	—	3	Yes	▲	3
8305234				2P					—	▲	3
8305253	M1.7 ×0.35			4P	36	11	—	3	Yes	▲	3
8305254				2P					—	▲	3
8305273	M2 ×0.4			4P	40	12	—	3	Yes	▲	3
8305274				2P					—	●	3

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 2002年7月前生产品中2P：M1.7以下为突顶尖。
3. M2.6以下无油槽。
4. 切削锥长4P：P(通孔用)、2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲＝该产品已停止生产，由 US-AL-NRT(P.578) 替代。

※高速同步丝锥是完全同步进给功能设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8305323	M2.6 ×0.45	STD	RH4	4P	44	14	—	3	Yes	▲	4
8305324				2P					—	●	3
8305333	M3 ×0.5	STD	RH5	4P	46	5	19	4	Yes	▲	5
8305334				2P					—	●	4
8305363	M4 ×0.7	STD	RH6	4P	52	7	21	6	Yes	▲	10
8305364				2P					—	●	9
8305383	M5 ×0.8			4P	60	8	24	6	Yes	▲	12
8305384				2P					—	●	11
8305403	M6 ×1	STD	RH7	4P	62	10	29	6	Yes	▲	13
8305404				2P					—	●	13

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Taps of M1.7 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 4P：P (for through holes), 2P：B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲＝ The products have been stopped producing and replaced by US-AL-NRT (p.578).

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1127

ULTRA同步丝锥

ULTRA SYNCHRO TAPS

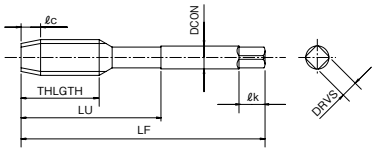
US-AL-NRT

HSSE | V | SHANK h7

■NU-ROLL 丝锥 NU-ROLL

通过铝，铝合金的塑性变形不产生切屑，进行超高速，高精度的螺纹加工。

For high speed / high precision internal thread processing of aluminum and aluminum alloys. Fluteless taps use the process of plastic deformation to imprint thread on material, without creating chips.



螺纹种类：M

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8312053	M 1 ×0.25	STD	RH4	2P	30	6	—	3	—	●	3
8312077	M 1.2 ×0.25				32	8	—	3	—	●	3
8312089	M 1.4 ×0.3				34	9	—	3	—	●	3
8312113	M 1.7 ×0.35				36	11	—	3	—	●	3
8312137	M 2 ×0.4				40	12	—	3	—	●	3
8312191	M 2.6 ×0.45				44	14	—	3	—	●	3
8312203	M 3 ×0.5	STD	RH5		46	5	19	4	—	●	4
8312227	M 4 ×0.7	STD	RH6		52	7	21	6	—	●	9
8312239	M 5 ×0.8				60	8	24	6	—	●	12
8312251	M 6 ×1	STD	RH7		62	10	29	6	—	●	12
8312275	M 8 ×1.25				70	13	37	8	—	●	25
8312281	M 8 ×1				70	13	37	8	—	●	24
8312293	M10 ×1.5				75	15	41	8	—	●	34

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 2002年7月前生产品中2P：M1.7以下为突顶尖。
3. M2.6以下无油槽。
4. 切削锥长2P：B(盲孔用)
5. 为了提升底孔插入性，先端面与不完全牙部分预留了1P左右距离。
6. 丝锥的精度不能保证内螺纹的精度。
7. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

※高速同步丝锥是完全同步进给功能设备的专用工具。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8312299	M10 ×1.25	STD	RH7	2P	75	15	41	8	—	●	34
8312305	M10 ×1				75	15	41	8	—	●	34
8312317	M12 ×1.75	STD	RH8		82	18	48	10	—	●	55
8312323	M12 ×1.5	STD	RH7		82	18	48	10	—	●	56
8312329	M12 ×1.25				82	18	48	10	—	●	56
8312353	M14 ×2	STD	RH10		88	20	48	12	—	●	86
8312359	M14 ×1.5	STD	RH9		88	20	48	12	—	●	87
8312371	M16 ×2	STD	RH10		95	20	52	16	—	●	135
8312377	M16 ×1.5	STD	RH9		95	20	52	16	—	●	136
8312389	M18 ×2.5	STD	RH11		100	25	55	16	—	●	152
8312395	M18 ×1.5	STD	RH10		100	25	55	16	—	●	155
8312407	M20 ×2.5	STD	RH11		105	25	58	16	—	●	178
8312413	M20 ×1.5	STD	RH10		105	25	58	16	—	●	182

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Taps of M1.7 (2P) or less producted before July 2002 have external center.
3. Thread Size ≦ M2.6: without oil groove.
4. ℓc: 2P : B (for blind holes)
5. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
6. TAP Limit does not guarantee thread limit for the internal thread after tapping.
7. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

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

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

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

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

△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1172

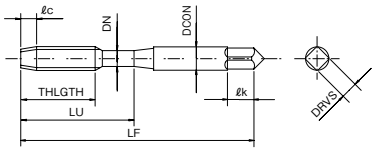
V涂层深孔用长柄型

V COATED· LONG SHANK· FOR DEEP HOLES

V-LT-DH-NRT

HSS　V

■NU-ROLL 丝锥 NU-ROLL



螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	颈径 DN	突顶尖 External Center	库存 Stock	重量 (g)
8318839	M 2 × 0.4	STD	RH4	2P	80	4.8	20	3	1.5	—	●	6
8318843	M 2.3 × 0.4				80	4.8	20	3	1.8	—	●	6
8318847	M 2.5 × 0.45				80	5.4	25	3	1.9	—	●	6
8318851	M 2.6 × 0.45				80	5.4	26	3	2	—	●	6

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. M2.6以下无油槽。
3. 切削锥长2P：B(盲孔用)
4. 为了提升底孔插入性，先端面与不完全牙部分预留了1p左右的距离。
5. 丝锥精度不能保证内螺纹的精度。
6. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	颈径 DN	突顶尖 External Center	库存 Stock	重量 (g)
8318859	M 3 × 0.5	STD	RH5	2P	120	6	59	4	2.4	—	●	10
8318875	M 4 × 0.7	STD	RH6		120	8.4	60	5	3.1	—	●	15
8318881	M 5 × 0.8				120	9.6	61	5.5	4	—	●	20
8318887	M 6 × 1	STD	RH7		120	12	62	6	4.7	—	●	24

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. Thread Size ≦ M2.6: without oil groove.
3. ℓc: 2P：B (blind holes)
4. 1P of center surface and incomplete thread is remained to improve tap insertion of the drill holes.
5. TAP Limit does not guarantee thread limit for the internal thread after tapping.
6. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

钢用
FOR STEELS

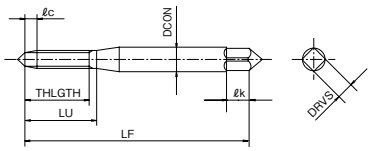
HRT

HSS | H

■HI-ROLL 丝锥 HI-ROLL

通过塑性变形形成螺纹，适用于延展性大的低碳钢，低碳素合金钢，不锈钢等材料。无切屑排出，对于盲孔特别有效。

Using plastic deformation to produce internal threads, this tap is suitable for tapping low carbon steels, alloy steels and stainless steels. It is especially efficient for tapping blind holes because it creates no chips.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12011	M1 ×0.25	STD	RH4	2.5P	30	6	6.5	3	Yes	▲	3
12015	M1.2 ×0.25				32	6	7.3	3	Yes	▲	3
12019	M1.4 ×0.3				34	6.5	7.9	3	Yes	▲	3
12023	M1.6 ×0.35				36	7	8.6	3	Yes	▲	3
12027	M1.7 ×0.35				36	8	9.6	3	Yes	▲	3
12031	M1.8 ×0.35				36	8	9.6	3	Yes	▲	3
12035	M2 ×0.4				40	9	11.2	3	Yes	▲	3
12039	M2 ×0.25				40	8	9.8	3	Yes	▲	4
12043	M2.3 ×0.4				42	10	12.2	3	Yes	▲	3
12046	M2.5 ×0.45	STD	RH5	4P	44	11	13.4	3	Yes	▲	3
12047				2.5P					—	▲	3
12048		STD+3	RH8	4P					Yes	▲	4
12049				2.5P					—	▲	4
12052	M2.6 ×0.45	STD	RH5	4P	44	11	13.4	3	Yes	▲	3
12053				2.5P					—	▲	3
12054		STD+3	RH8	4P					Yes	▲	4
12055				2.5P					—	▲	4
12056	M3 ×0.6	STD	RH5	4P	46	18	20	4	Yes	△	4
12057				2.5P					—	△	5
12066	M3 ×0.5	STD	RH6	4P	46	18	20	4	Yes	▲	4
12067				2.5P					—	▲	4
12068		STD+3	RH9	4P					Yes	▲	5
12069				2.5P					—	▲	4

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.836)
2. 切削锥长4P：P(通孔用)、2.5P：B(盲孔用)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲=该产品已停止生产，由NRT(P.565)、TIN-NRT(P.561)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12071	M3 ×0.35	STD	RH5	2.5P	46	10	12	4	—	△	5
12076	M3.5 ×0.6			4P	48	18	20	4	Yes	▲	5
12077				2.5P					—	▲	5
12084	M4 ×0.75	STD	RH6	4P	52	20	22	5	Yes	△	8
12085				2.5P					—	△	8
12094	M4 ×0.7	STD	RH7	4P	52	20	22	5	Yes	▲	7
12095				2.5P					—	▲	7
12098		STD+3	RH10	4P					Yes	▲	6
12099				2.5P					—	▲	6
12101	M4 ×0.5	STD	RH6		52	15	17	5	—	△	9
12104	M5 ×0.9	STD	RH7	4P	60	22	24	5.5	Yes	△	11
12105				2.5P					—	△	11
12116	M5 ×0.8	STD	RH8	4P	60	22	24	5.5	Yes	▲	11
12117				2.5P					—	▲	11
12118		STD+2	RH10	4P					Yes	▲	11
12119				2.5P					—	▲	11
12121	M5 ×0.5	STD	RH6		52	15	17	5.5	—	△	11
12130	M6 ×1	STD	RH7	4P	62	24	30	6	Yes	▲	13
12131				2.5P					—	▲	13
12132		STD+3	RH10	4P					Yes	▲	13
12133				2.5P					—	▲	14
12135	M6 ×0.75	STD	RH7		62	24	30	6	—	△	14

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 4P：P (for through holes), 2.5P：B (for blind holes)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by NRT (p.565) and TIN-NRT (p.561).

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12171	No. 5- 40UNC	STD	RH5	2.5P	46	18	18	4	—	▲	5
12173	No. 5- 44UNF				46	18	18	4	—	▲	5
12175	No. 6- 32UNC	STD	RH6		48	18	18	4	—	▲	5
12177	No. 6- 40UNF	STD	RH5		48	18	18	4	—	▲	6
12179	No. 8- 32UNC	STD	RH6		52	20	20	5	—	▲	8

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照 P.836)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照 P.867。

▲=该产品已停止生产，由TIN-NRT(P.562)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12181	No. 8- 36UNF	STD	RH6	2.5P	52	20	20	5	—	▲	8
12183	No.10- 24UNC	STD	RH7		60	22	22	5.5	—	▲	11
12185	No.10- 32UNF	STD	RH6		60	22	22	5.5	—	▲	11
12191	¼- 20UNC	STD	RH7		62	24	30	6	—	▲	14
12193	¼- 28UNF				62	24	30	6	—	▲	14

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by TIN-NRT (p.562).

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

库存记号 Inventory symbols

●=标准库存品
Standard stock item

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

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

△=停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1055

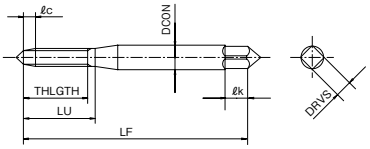
非铁合金用
FOR NON-FERROUS METALS

B-HRT

HSS

■HI-ROLL 丝锥 HI-ROLL

适用于铝、镁、锌、铜等非铁合金。
Suitable for tapping aluminum, zinc, copper, and nonferrous metal alloys.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12211	M 1 ×0.25	STD	RH4	2.5P	30	6	6.5	3	Yes	▲	3
12215	M 1.2 ×0.25				32	6	7.3	3	Yes	▲	3
12219	M 1.4 ×0.3				34	6.5	7.9	3	Yes	▲	3
12223	M 1.6 ×0.35				36	7	8.6	3	Yes	▲	3
12227	M 1.7 ×0.35				36	8	9.6	3	Yes	▲	3
12231	M 1.8 ×0.35				36	8	9.6	3	Yes	▲	4
12235	M 2 ×0.4				40	9	11.2	3	Yes	▲	3
12237		STD+2	RH6						Yes	▲	4
12243	M 2.3 ×0.4	STD	RH4		42	10	12.2	3	Yes	▲	3
12245		STD+2	RH6						Yes	▲	4
12246	M 2.5 ×0.45	STD	RH5	4P	44	11	13.4	3	Yes	▲	3
12247				2.5P					—	▲	3
12248		STD+3	RH8	4P					Yes	△	4
12249				2.5P					—	△	4
12252	M 2.6 ×0.45	STD	RH5	4P	44	11	13.4	3	Yes	▲	3
12253				2.5P					—	▲	3
12254		STD+3	RH8	4P					Yes	△	4
12255				2.5P					—	△	4
12256	M 3 ×0.6	STD	RH5	4P	46	18	20	4	Yes	△	5
12257				2.5P					—	△	5
12266	M 3 ×0.5		RH6	4P	46	18	20	4	Yes	▲	3
12267				2.5P					—	▲	3

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.836)
2. 切削锥长4P：P(通孔用)、2.5P：B(盲孔用)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲=该产品已停止生产，由B-NRT(P.571)、TIN-NRT(P. 561)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12270	M 3 ×0.5	STD+3	RH9	4P	46	18	20	4	Yes	△	5
12271				2.5P					—	△	5
12276	M 3.5 ×0.6	STD	RH5	4P	48	18	20	4	Yes	▲	5
12277				2.5P					—	▲	5
12284	M 4 ×0.75	STD	RH6	4P	52	20	22	5	Yes	△	8
12285				2.5P					—	△	8
12294	M 4 ×0.7	STD	RH7	4P	52	20	22	5	Yes	▲	7
12295				2.5P					—	▲	7
12298		STD+3	RH10	4P					Yes	△	8
12299				2.5P					—	△	8
12301	M 4 ×0.5	STD	RH6		52	15	17	5	—	△	9
12304	M 5 ×0.9	STD	RH7	4P	60	22	24	5.5	Yes	△	11
12305				2.5P					—	△	11
12316	M 5 ×0.8	STD	RH8	4P	60	22	24	5.5	Yes	▲	11
12317				2.5P					—	▲	11
12318		STD+2	RH10	4P					Yes	△	11
12319				2.5P					—	△	11
12321	M 5 ×0.5	STD	RH6		52	15	17	5.5	—	△	11
12330	M 6 ×1	STD	RH7	4P	62	24	30	6	Yes	▲	13
12331				2.5P					—	▲	13
12332		STD+3	RH10	4P					Yes	△	14
12333				2.5P					—	△	14

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 4P : P (for through holes), 2.5P : B (for blind holes)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by B-NRT (p.571) and TIN-NRT (p.561).

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

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

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12361	No. 0 - 80UNF				36	7	—	3	Yes	▲	3
12362	No. 1 - 64UNC				36	8	—	3	Yes	▲	3
12363	No. 1 - 72UNF				36	8	—	3	Yes	▲	3
12364	No. 2 - 56UNC	STD	RH4		42	10	—	3	Yes	▲	4
12365	No. 2 - 64UNF			2.5P	42	10	—	3	Yes	▲	4
12366	No. 3 - 48UNC				44	11	—	3	—	▲	4
12367	No. 3 - 56UNF				44	11	—	3	—	▲	4
12368	No. 4 - 40UNC	STD	RH5		44	12.5	—	3	—	▲	4
12369	No. 4 - 48UNF	STD	RH4		44	12.5	—	3	—	▲	4
12371	No. 5 - 40UNC	STD	RH5		46	18	18	4	—	▲	5

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.836)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

※ 挤压丝锥与切削丝锥的底孔径不同。
挤压丝锥的底孔尺寸请参照P.867。

▲=该产品已停止生产，由TIN-NRT(P.562)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
12373	No. 5 - 44UNF	STD	RH5		46	18	18	4	—	▲	5
12375	No. 6 - 32UNC	STD	RH6		48	18	18	4	—	▲	5
12377	No. 6 - 40UNF	STD	RH5		48	18	18	4	—	▲	5
12379	No. 8 - 32UNC	STD	RH6		52	20	20	5	—	▲	8
12381	No. 8 - 36UNF			2.5P	52	20	20	5	—	▲	8
12383	No.10 - 24UNC	STD	RH7		60	22	22	5.5	—	▲	11
12385	No.10 - 32UNF	STD	RH6		60	22	22	5.5	—	▲	11
12391	¼ - 20UNC	STD	RH7		62	24	30	6	—	▲	14
12393	¼ - 28UNF				62	24	30	6	—	▲	15

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.836)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ The drill hole diameter for fluteless taps differs from fluted taps.
Please see p.867 for drill hole size for fluteless taps.

▲= The products have been stopped producing and replaced by TIN-NRT (p.562).

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1182

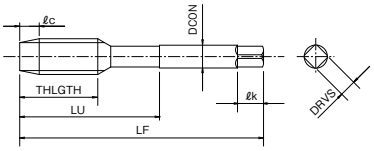
螺旋槽丝锥

SPIRAL FLUTED TAP

The A Brand

A-SFT

切削条件 Cutting Conditions | P.837



CPM ＜M27 | HSSE M27≦ | V | 45°

螺纹种类：**M**

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325234	M 1.4 × 0.3	STD	OH1	2.5P	34	6	—	3	2	—	●	2
8325239	M 1.6 × 0.35	STD	OH1.5		36	7	—	3		—	●	2
8325244	M 1.7 × 0.35	STD	OH1.5		36	8	—	3		—	●	2
8325249	M 2 × 0.4	STD	OH1.5		40	3.2	10	3		—	●	3
8325630		STD+1	OH2.5								●	3
8325631		STD+2	OH3.5								●	3
8327449		STD	OH1.5	1.5P							●	3
8325250	M 2 × 0.25	STD	OH1	2.5P	40	3.2	10	3		—	●	3
8325632		STD+1	OH2								●	3
8327450		STD	OH1	1.5P							●	3
8325252	M 2.2 × 0.45	STD	OH2	2.5P	42	3.6	11	3		—	●	3
8325634		STD+1	OH3								●	3
8327452		STD	OH2	1.5P							●	3
8325253	M 2.2 × 0.25	STD	OH1	2.5P	42	3.6	11	3		—	●	3
8325636		STD+1	OH2								●	3
8327453		STD	OH1	1.5P							●	3
8325254	M 2.3 × 0.4	STD	OH1.5	2.5P	42	3.6	12	3		—	●	3
8325638		STD+1	OH2.5								●	3
8327454		STD	OH1.5	1.5P							●	3
8325259	M 2.5 × 0.45	STD	OH2	2.5P	44	3.6	13	3		—	●	3
8325640		STD+1	OH3								●	3
8325641		STD+2	OH4								●	3
8327459		STD	OH2	1.5P							●	3
8325262	M 2.5 × 0.35	STD	OH1.5	2.5P	44	3.6	13	3		—	●	3
8325642		STD+1	OH2.5								●	3
8327462		STD	OH1.5	1.5P							●	3
8325264	M 2.6 × 0.45	STD	OH2	2.5P	44	3.6	13	3		—	●	3
8325644		STD+1	OH3								●	3
8327464		STD	OH2	1.5P							●	3
8325269	M 3 × 0.5	STD	OH2	2.5P	46	4	19	4	3	—	●	4
8325650		STD+1	OH3								●	4
8325651		STD+2	OH4								●	4
8326711		STD	OH2	1.5P							●	4
8326811		STD	OH2	1P							●	5
8325272	M 3 × 0.35	STD	OH2	2.5P	46	4	19	4		—	●	4
8325652		STD+1	OH3								●	4
8327472		STD	OH2	1.5P							●	4
8325276	M 3.5 × 0.6	STD	OH2	2.5P	48	4.8	20	4		—	●	4
8325654		STD+1	OH3								●	5
8327476		STD	OH2	1.5P							●	5
8325279	M 3.5 × 0.35	STD	OH2	2.5P	48	4.8	20	4		—	●	5
8325655		STD+1	OH3								●	5
8327479		STD	OH2	1.5P							●	5
8325283	M 4 × 0.7	STD	OH3	2.5P	52	5.6	21	5		—	●	6
8325660		STD+1	OH4								●	7
8325661		STD+2	OH5								●	7
8326714		STD	OH3	1.5P							●	7
8326814		STD	OH3	1P							●	7
8325286	M 4 × 0.5	STD	OH2	2.5P	52	5.6	21	5		—	●	7
8325662		STD+1	OH3								●	7
8327486		STD	OH2	1.5P							●	7
8325287	M 4.5 × 0.75	STD	OH2	2.5P	55	6	21	5		—	●	7
8325664		STD+1	OH3								●	8
8327487		STD	OH2	1.5P							●	7
8325288	M 4.5 × 0.5	STD	OH2	2.5P	55	6	21	5		—	●	8
8325665		STD+1	OH3								●	8
8327488		STD	OH2	1.5P							●	8

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尺寸 Size M5 ~ M9 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

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FROM 尺寸 Size M1.4 ~ M4.5

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325290	M 5 × 0.8	STD	OH3	2.5P	60	6.4	24	5.5	3	–	●	9
8325668		STD+1	OH4								●	8
8325669		STD+2	OH5								●	10
8326717		STD	OH3	1.5P							●	10
8326817		STD	OH3	1P							●	10
8325293	M 5 × 0.5	STD	OH2	2.5P	60	6.4	24	5.5		–	●	10
8325673		STD+1	OH3								●	10
8327493		STD	OH2	1.5P							●	10
8325295	M 5.5 × 0.5	STD	OH2	2.5P	60	7.2	25	5.5		–	●	10
8325676		STD+1	OH3								●	10
8327495		STD	OH2	1.5P							●	10
8325297	M 6 × 1	STD	OH3	2.5P	62	8	29	6		–	●	11
8325678		STD+1	OH4								●	11
8325679		STD+2	OH5								●	11
8326720		STD	OH3	1.5P							●	11
8326820		STD	OH3	1P							●	12
8325300	M 6 × 0.75	STD	OH2	2.5P	62	8	29	6		–	●	11
8325680		STD+1	OH3								●	12
8327500		STD	OH2	1.5P							●	11
8325302	M 6 × 0.5	STD	OH2	2.5P	62	8	29	6		–	●	12
8325681		STD+1	OH3								●	12
8327502		STD	OH2	1.5P							●	11
8325304	M 7 × 1	STD	OH3	2.5P	65	12	33	6.2		–	●	14
8325684		STD+1	OH4								●	14
8327504		STD	OH3	1.5P							●	14
8325305	M 7 × 0.75	STD	OH2	2.5P	65	9	33	6.2		–	●	14
8325685		STD+1	OH3								●	14
8327505		STD	OH2	1.5P							●	14
8325307	M 8 × 1.25	STD	OH3	2.5P	70	15	37	6.2		–	●	15
8325688		STD+1	OH4								●	16
8325689		STD+2	OH5								●	16
8326723		STD	OH3	1.5P							●	16
8326823		STD	OH3	1P							●	16
8325311	M 8 × 1	STD	OH3	2.5P	70	12	37	6.2		–	●	16
8325690		STD+1	OH4								●	16
8327511		STD	OH3	1.5P							●	16
8325312	M 8 × 0.75	STD	OH3	2.5P	70	12	37	6.2		–	●	16
8325691		STD+1	OH4								●	16
8327512		STD	OH3	1.5P							●	16
8325314	M 9 × 1.25	STD	OH3	2.5P	72	15	38	7		–	●	21
8325694		STD+1	OH4								●	22
8327514		STD	OH3	1.5P							●	22
8325315	M 9 × 1	STD	OH3	2.5P	72	12	38	7		–	●	22
8325695		STD+1	OH4								●	22
8327515		STD	OH3	1.5P							●	23
8325316	M 9 × 0.75	STD	OH3	2.5P	72	12	38	7		–	●	22
8325696		STD+1	OH4								●	22
8327516		STD	OH3	1.5P							●	23

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

下一页
尺寸 Size M10 ~ M16 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1182

螺旋槽丝锥

SPIRAL FLUTED TAP

The A Brand

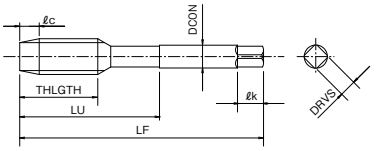
A-SFT

切削条件 Cutting Conditions | P.837

CPM | HSSE | V | 45°

< M27 | M27≦

上一页
FROM 尺寸 Size | M5 ~ M9



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325317	M 10 × 1.5	STD	OH3	2.5P	75	18	41	7	3	–	●	22
8325700		STD+1	OH4								●	24
8325701		STD+2	OH5								●	24
8326726		STD	OH3	1.5P							●	24
8326826		STD	OH3	1P							●	24
8325321	M 10 × 1.25	STD	OH3	2.5P	75	15	41	7		–	●	22
8325702		STD+1	OH4								●	24
8326729		STD	OH3	1.5P							●	24
8326829		STD	OH3	1P							●	24
8325324	M 10 × 1	STD	OH3	2.5P	75	15	41	7		–	●	24
8325703		STD+1	OH4								●	24
8327524		STD	OH3	1.5P							●	24
8325325	M 10 × 0.75	STD	OH3	2.5P	75	15	41	7		–	●	24
8325704		STD+1	OH4								●	24
8327525		STD	OH3	1.5P							●	24
8325327	M 11 × 1.5	STD	OH3	2.5P	80	18	48	8		–	●	32
8325710		STD+1	OH4								●	32
8327527		STD	OH3	1.5P							●	32
8325328	M 11 × 1	STD	OH3	2.5P	80	15	48	8		–	●	32
8325714		STD+1	OH4								●	32
8327528		STD	OH3	1.5P							●	32
8325329	M 11 × 0.75	STD	OH3	2.5P	80	15	48	8		–	●	32
8325715		STD+1	OH4								●	32
8327529		STD	OH3	1.5P							●	32
8325330	M 12 × 1.75	STD	OH4	2.5P	82	21	48	8.5		–	●	36
8325718		STD+1	OH5								●	37
8325719		STD+2	OH6								●	37
8326732		STD	OH4	1.5P							●	37
8326832		STD	OH4	1P							●	37
8325334	M 12 × 1.5	STD	OH3	2.5P	82	18	48	8.5		–	●	36
8325720		STD+1	OH4								●	37
8327534		STD	OH3	1.5P							●	38
8325337	M 12 × 1.25	STD	OH3	2.5P	82	18	48	8.5		–	●	36
8325721		STD+1	OH4								●	37
8326736		STD	OH3	1.5P							●	37
8326836		STD	OH3	1P							●	37
8325340	M 12 × 1	STD	OH3	2.5P	82	18	48	8.5		–	●	35
8325722		STD+1	OH4								●	37
8327540		STD	OH3	1.5P							●	37
8325347	M 14 × 2	STD	OH4	2.5P	88	24	48	10.5		–	●	56
8325730		STD+1	OH5								●	62
8327547		STD	OH4	1.5P							●	63
8325350	M 14 × 1.5	STD	OH3	2.5P	88	18	48	10.5		–	●	56
8325731		STD+1	OH4								●	62
8327550		STD	OH3	1.5P							●	63
8325352	M 14 × 1.25	STD	OH3	2.5P	88	18	48	10.5		–	●	62
8325732		STD+1	OH4								●	63
8327552		STD	OH3	1.5P							●	83
8325354	M 14 × 1	STD	OH3	2.5P	88	18	48	10.5		–	●	62
8325733		STD+1	OH4								●	63
8325355	M 15 × 1.5	STD	OH3		95	18	52	10.5		–	●	68
8325736		STD+1	OH4								●	69
8325356	M 15 × 1	STD	OH3		95	18	52	10.5		–	●	68
8325737		STD+1	OH4								●	69
8325357	M 16 × 2	STD	OH4		95	24	52	12.5		–	●	83
8325740		STD+1	OH5								●	88
8327557		STD	OH4	1.5P							●	89
8325360	M 16 × 1.5	STD	OH3	2.5P	95	18	52	12.5		–	●	83
8325741		STD+1	OH4								●	89
8327560		STD	OH3	1.5P							●	90

下一页
尺寸 Size | M16 ~ M24 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

上一页

FROM 尺寸 Size M10 ~ M16

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325362	M 16 × 1	STD	OH3	2.5P	95	18	52	12.5	3	–	●	89
8325742		STD+1	OH4								●	89
8325364	M 17 × 1.5	STD	OH3	2.5P	100	18	55	13		–	●	93
8325745		STD+1	OH4								●	94
8325366	M 17 × 1	STD	OH3								●	94
8325746		STD+1	OH4								●	95
8325367	M 18 × 2.5	STD	OH5		100	30	55	14	4	–	●	110
8325749		STD+1	OH6								●	112
8327567		STD	OH5	1.5P							●	110
8325369	M 18 × 2	STD	OH4	2.5P	100	24	55	14		–	●	111
8325750		STD+1	OH5								●	112
8327569		STD	OH4	1.5P							●	110
8325370	M 18 × 1.5	STD	OH4	2.5P	100	24	55	14		–	●	110
8325751		STD+1	OH5								●	112
8327570		STD	OH4	1.5P							●	110
8325372	M 18 × 1	STD	OH3	2.5P	100	24	55	14		–	●	112
8325752		STD+1	OH4								●	113
8325377	M 20 × 2.5	STD	OH5		105	30	58	15		–	●	138
8325757		STD+1	OH6								●	138
8327577		STD	OH5	1.5P							●	138
8325379	M 20 × 2	STD	OH4	2.5P	105	24	58	15		–	●	137
8325758		STD+1	OH5								●	138
8327579		STD	OH4	1.5P							●	138
8325380	M 20 × 1.5	STD	OH4	2.5P	105	24	58	15		–	●	138
8325759		STD+1	OH5								●	138
8327580		STD	OH4	1.5P							●	138
8325382	M 20 × 1	STD	OH3	2.5P	105	24	58	15		–	●	139
8325760		STD+1	OH4								●	139
8325387	M 22 × 2.5	STD	OH5		115	30	63	17		–	●	186
8325763		STD+1	OH6								●	187
8327587		STD	OH5	1.5P							●	187
8325389	M 22 × 2	STD	OH4	2.5P	115	24	63	17		–	●	186
8325764		STD+1	OH5								●	187
8327589		STD	OH4	1.5P							●	186
8325390	M 22 × 1.5	STD	OH4	2.5P	115	24	63	17		–	●	186
8325765		STD+1	OH5								●	187
8327590		STD	OH4	1.5P							●	186
8325392	M 22 × 1	STD	OH3	2.5P	115	24	63	17		–	●	187
8325766		STD+1	OH4								●	187
8325397	M 24 × 3	STD	OH5		120	36	66	19		–	●	238
8325769		STD+1	OH6								●	241
8327597		STD	OH5	1.5P							●	239
8325399	M 24 × 2	STD	OH4	2.5P	120	24	66	19		–	●	238
8325770		STD+1	OH5								●	237
8327599		STD	OH4	1.5P							●	236
8325400	M 24 × 1.5	STD	OH4	2.5P	120	24	66	19		–	●	238
8325771		STD+1	OH5								●	238
8327600		STD	OH4	1.5P							●	237
8325402	M 24 × 1	STD	OH3	2.5P	120	24	66	19		–	●	240
8325772		STD+1	OH4								●	240

■突顶尖长·柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1182

螺旋槽丝锥 大型部件加工用

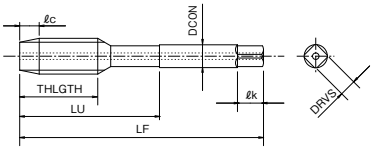
SPIRAL FLUTED TAP · FOR THREADING LARGE DIAMETER HOLES

The A Brand

A-SFT

切削条件 Cutting Conditions | P.837

HSSE | V | 45°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	油孔 Oil Hole	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326605	M 27 × 3	Yes	STD	OH5	2.5P	160	36	79	20	4	–	●	346
8326608	M 27 × 1.5	Yes		OH4		140	24	79	20		–	●	297
8326614	M 30 × 3.5	Yes		OH5		180	42	88	23		–	●	502
8326615	M 30 × 3	Yes				180	36	88	23		–	●	507
8326618	M 30 × 1.5	Yes		OH4		150	36	88	23		–	●	412
8326624	M 33 × 3.5	Yes		OH5		180	42	95	25		–	●	589
8326625	M 33 × 3	Yes		OH5		180	36	95	25		–	●	589
8326628	M 33 × 1.5	Yes		OH4		160	36	92	25		–	●	520
8326633	M 36 × 4	Yes		OH6		200	48	104	28		–	●	793
8326635	M 36 × 3	Yes				200	36	104	28		–	●	782
8326638	M 36 × 1.5	Yes		OH4		170	36	97	28		–	●	658
8326643	M 39 × 4	Yes		OH6		200	48	112	30		–	●	907
8326652	M 42 × 4.5	Yes				200	54	118	32		–	●	1,054
8326655	M 42 × 3	Yes				200	48	118	32		–	●	1,049
8326658	M 42 × 1.5	Yes		OH4		170	48	88	32		–	●	911
8326659	M 45 × 4.5	Yes		OH6		220	54	128	35		–	●	1,352
8326661	M 48 × 5	Yes		OH6		250	60	137	38		–	●	1,810
8326665	M 48 × 3	Yes				225	48	137	38		–	●	1,600
8326668	M 52 × 5	Yes		OH7		250	60	147	42		–	●	2,150
8326670	M 56 × 5.5	Yes		OH8		250	66	153	44		–	●	2,420

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

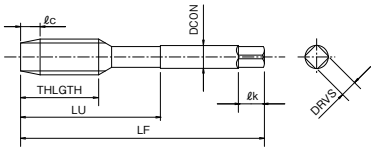
螺旋槽丝锥
SPIRAL FLUTED TAP

The A Brand

A-SFT

切削条件 Cutting Conditions | P.837

CPM | V | 45°



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8327221	No. 4 – 40UNC	STD	OH2	2.5P	44	5.1	17	3	2	–	●	4
8327227	No. 5 – 40UNC				46	5.1	19	4		–	●	4
8327233	No. 6 – 32UNC				48	6.4	21	4		–	●	5
8327240	No. 8 – 32UNC				52	6.4	21	5		–	●	7
8327246	No. 10 – 24UNC				60	8.5	24	5.5		–	●	10
8327249	No. 10 – 32UNF				60	8.5	24	5.5		–	●	10
8327258	¼ – 20UNC		OH3		62	10.2	29	6		–	●	12
8327261	¼ – 28UNF		OH2		62	10.2	29	6		–	●	12
8327267	5/16 – 18UNC		OH3		70	17	37	6.1	3	–	●	16
8327270	5/16 – 24UNF				70	13	37	6.1		–	●	15
8327276	⅜ – 16UNC				75	19	41	7		–	●	24
8327282	⅜ – 24UNF				75	13	41	7		–	●	23
8327291	7/16 – 14UNC				80	22	48	8		–	●	32
8327294	7/16 – 20UNF				80	15	48	8		–	●	45
8327300	½ – 13UNC				85	23	48	9		–	●	44
8327306	½ – 20UNF				85	15	48	9		–	●	44
8327312	9/16 – 12UNC		OH4		90	25	48	10.5		–	●	66
8327315	9/16 – 18UNF		OH3		90	17	48	10.5		–	●	64
8327319	⅝ – 11UNC		OH4		95	28	52	12		–	●	84
8327321	⅝ – 18UNF		OH3		95	17	52	12		–	●	84
8327325	¾ – 10UNC		OH4		105	31	58	14	4	–	●	121
8327327	¾ – 16UNF		OH3		105	19	58	14		–	●	120
8327331	⅞ – 9UNC		OH5		115	34	63	17		–	●	187
8327333	⅞ – 14UNF		OH4		115	22	63	17		–	●	185

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS 2B internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

SynchroMaster

与A-TAP完美搭配的攻丝刀柄

※详情请参照▶P.831
See p.831 for details

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

G-LIST No. | TH1182

螺旋槽丝锥 大型部件加工用

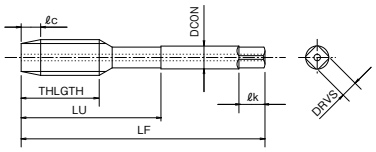
SPIRAL FLUTED TAP · FOR THREADING LARGE DIAMETER HOLES

The A Brand

A-SFT

切削条件 Cutting Conditions | P.837

HSSE | V | 45°



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	油孔 Oil Hole	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8327337	1 – 8UNC	Yes	STD	OH5	2.5P	160	38	88	20	4	–	●	314
8327345	1 1/8 – 8UN	Yes				180	38	97	22		–	●	447
8327352	1 1/4 – 8UN	Yes				180	38	100	24		–	●	542
8327358	1 3/8 – 8UN	Yes				200	38	115	26		–	●	704
8327364	1 1/2 – 8UN	Yes		OH6		200	38	115	30		–	●	921
8327367	1 5/8 – 8UN	Yes				200	38	115	32		–	●	1,043
8327370	1 3/4 – 8UN	Yes				200	51	103	35		–	●	1,290
8327374	1 7/8 – 8UN	Yes				225	51	130	38		–	●	1,590
8327376	2 – 8UN	Yes				225	51	122	40		–	●	1,839

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS 2B internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

螺旋槽丝锥(铣刀柄)

SPIRAL FLUTED TAP (END MILL SHANK)

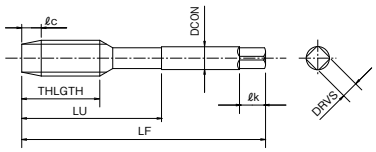
The A Brand

A-SFT

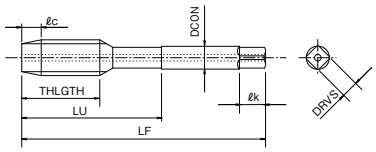
切削条件 Cutting Conditions | P.837

CPM | V | 45° | SHANK h7

无油孔 without Coolant Hole



有油孔 with Coolant Hole



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	油孔 Oil Hole	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325900	M 3 × 0.5 - 4	—	STD	OH3	2.5P	46	4	19	4	3	—	●	5
8325901	M 4 × 0.7 - 6	—				52	5.6	21	6		—	●	9
8325902	M 5 × 0.8 - 6	—				60	6.4	24	6		—	●	11
8325903	M 6 × 1 - 6	—				62	8	29	6		—	●	11
8326951		Yes										●	11
8326952	M 6 × 0.75 - 6	Yes				62	19	29	6		—	●	11
8325904	M 8 × 1.25 - 8	—		OH4		70	15	37	8		—	●	21
8326953		Yes										●	20
8326954	M 8 × 1 - 8	Yes		OH3		70	22	37	8		—	●	20
8325906	M 10 × 1.5 - 8	—		OH4		75	18	41	8		—	●	27
8326955		Yes										●	26
8325905	M 10 × 1.25 - 8	—				75	15	41	8		—	●	27
8326956		Yes										●	25
8325907	M 12 × 1.75 - 10	—				82	21	48	10		—	●	45
8326957		Yes										●	43
8326958	M 12 × 1.5 - 10	Yes				82	18	48	10		—	●	42
8326959	M 12 × 1.25 - 10	Yes				82	18	48	10		—	●	43
8325908	M 14 × 2 - 12	—		OH5		88	24	48	12		—	●	73

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 铣刀柄产品对应筒夹柄，铣刀柄等，请使用周边紧固的刀柄。
2. 精度栏 保证高精度与完全同步进给的组合为前提，2级相当的丝锥推荐精度。
3. 丝锥精度不能保证内螺纹的精度。
4. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Although taps with end mill shank are compatible with a collet holder, milling holder and etc., use a holder with a detent.
2. The recommended tap limit corresponds to JIS class 2 internal thread standards only if combination of maintaining the high accuracy and complete synchronous feed is applied.
3. Tap limit does not guarantee thread limit for the internal thread after tapping.
4. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

SynchroMaster

与A-TAP完美搭配的攻丝刀柄

※详情请参照▶P.831
See p.831 for details

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

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

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

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

△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1184

螺旋槽丝锥长柄型

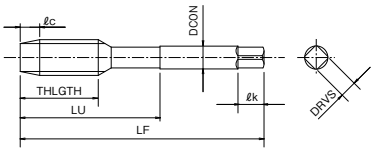
SPIRAL FLUTED TAP WITH LONG SHANK

The A Brand

A-LT-SFT

切削条件 Cutting Conditions | P.837

CPM | V | 45°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326202	M 2 × 0.4 × 80	STD	OH1.5	2.5P	80	3.2	10	3	2	–	●	6
8326201	M 2 × 0.25 × 80		OH1		80	3.2	10	3		–	●	6
8326204	M 2.2 × 0.45 × 80		OH2		80	3.6	11	3		–	●	6
8326203	M 2.2 × 0.25 × 80		OH1		80	3.6	11	3		–	●	6
8326205	M 2.3 × 0.4 × 80		OH1.5		80	3.6	12	3		–	●	6
8326207	M 2.5 × 0.45 × 80		OH2		80	3.6	13	3		–	●	6
8326206	M 2.5 × 0.35 × 80		OH1.5		80	3.6	13	3		–	●	6
8326208	M 2.6 × 0.45 × 80		OH2		80	3.6	13	3		–	●	6
8326210	M 3 × 0.5 ×100				100	4	19	4	3	–	●	11
8326209	M 3 × 0.35 ×100				100	4	19	4		–	●	11
8326212	M 3.5 × 0.6 ×100				100	4.8	19	4		–	●	11
8326211	M 3.5 × 0.35 ×100				100	4.8	19	4		–	●	11
8326214	M 4 × 0.7 ×100		OH3		100	5.6	21	5		–	●	16
8326213	M 4 × 0.5 ×100		OH2		100	5.6	21	5		–	●	16
8326216	M 4.5 × 0.75 ×100				100	6	21	5		–	●	16
8326215	M 4.5 × 0.5 ×100				100	6	21	5		–	●	16
8326218	M 5 × 0.8 ×100		OH3		100	6.4	24	5.5		–	●	19
8326217	M 5 × 0.5 ×100		OH2		100	6.4	24	5.5		–	●	19
8326219	M 5.5 × 0.5 ×100				100	7.2	25	5.5		–	●	20
8326222	M 6 × 1 ×100		OH3		100	8	29	6		–	●	23
8326223	×150				150						●	33
8326220	M 6 × 0.75 ×100		OH2		100	8	29	6		–	●	23
8326221	×150				150						●	32
8326226	M 7 × 1 ×100		OH3		100	12	33	6.2		–	●	24
8326227	×150				150						●	37
8326224	M 7 × 0.75 ×100		OH2		100	9	33	6.2		–	●	24
8326225	×150				150						●	37
8326232	M 8 × 1.25 ×100		OH3		100	15	37	6.2		–	●	25
8326233	×150				150						●	38
8326230	M 8 × 1 ×100				100	12	37	6.2		–	●	25
8326231	×150				150						●	37
8326228	M 8 × 0.75 ×100				100	12	37	6.2		–	●	25
8326229	×150				150						●	38
8326238	M 9 × 1.25 ×100				100	15	38	7		–	●	31
8326239	×150				150						●	48
8326236	M 9 × 1 ×100				100	12	38	7		–	●	31
8326237	×150				150						●	48
8326234	M 9 × 0.75 ×100				100	12	38	7		–	●	32
8326235	×150				150						●	48

下一页
尺寸 Size M10 ~ M17 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

上一页
FROM 尺寸 Size M2 ~ M9

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size		精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326246	M10 × 1.5	×100	STD	OH3	2.5P	100	18	41	7	3	–	●	32
8326247		×150				150						●	49
8326244	M10 × 1.25	×100				100	15	41	7		–	●	32
8326245		×150				150						●	48
8326242	M10 × 1	×100				100	15	41	7		–	●	32
8326243		×150				150						●	49
8326240	M10 × 0.75	×100				100	15	41	7		–	●	33
8326241		×150				150						●	49
8326252	M11 × 1.5	×100				100	18	48	8		–	●	42
8326253		×150				150						●	61
8326292	M11 × 1.25	×100				100	15	48	8		–	●	42
8326293		×150				150						●	61
8326250	M11 × 1	×100				100	15	48	8		–	●	42
8326251		×150				150						●	61
8326248	M11 × 0.75	×100				100	15	48	8		–	●	42
8326249		×150				150						●	61
8326260	M12 × 1.75	×100		OH4		100	21	48	8.5		–	●	47
8326261		×150				150						●	69
8326258	M12 × 1.5	×100		OH3		100	18	48	8.5		–	●	47
8326259		×150				150						●	68
8326256	M12 × 1.25	×100				100	18	48	8.5		–	●	47
8326257		×150				150						●	68
8326254	M12 × 1	×100				100	18	48	8.5		–	●	47
8326255		×150				150						●	68
8326265	M14 × 2	×150		OH4		150	24	50	10.5		–	●	101
8326264	M14 × 1.5	×150		OH3		150	18	50	10.5		–	●	101
8326263	M14 × 1.25	×150				150	18	50	10.5		–	●	101
8326262	M14 × 1	×150				150	18	50	10.5		–	●	101
8326267	M15 × 1.5	×150				150	18	52	10.5		–	●	105
8326266	M15 × 1	×150				150	18	52	10.5		–	●	105
8326270	M16 × 2	×150		OH4		150	24	56	12.5		–	●	139
8326271		×200				200						●	189
8326269	M16 × 1.5	×150		OH3		150	18	56	12.5		–	●	139
8326268	M16 × 1	×150				150	18	56	12.5		–	●	139
8326273	M17 × 1.5	×150				150	18	58	13		–	●	152
8326272	M17 × 1	×150				150	18	58	13		–	●	152

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

下一页
尺寸 Size M18 ~ M24 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | TH1184

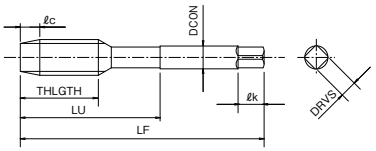
螺旋槽丝锥长柄型

SPIRAL FLUTED TAP WITH LONG SHANK

The A Brand

A-LT-SFT

切削条件 Cutting Conditions | P.837



CPM | V | 45°

上一页
FROM 尺寸 Size M10 ~ M17

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326277	M18 × 2.5 ×150	STD	OH5	2.5P	150	30	64	14	4	—	●	175
8326276	M18 × 2 ×150		OH4		150	24	64	14		—	●	175
8326275	M18 × 1.5 ×150				150	24	64	14		—	●	175
8326274	M18 × 1 ×150		OH3		150	24	64	14		—	●	175
8326281	M20 × 2.5 ×150		OH5		150	30	70	15		—	●	202
8326282	×200				200						●	272
8326280	M20 × 2 ×150		OH4		150	24	70	15		—	●	202
8326279	M20 × 1.5 ×150				150	24	70	15		—	●	202
8326278	M20 × 1 ×150		OH3		150	24	70	15		—	●	202
8326286	M22 × 2.5 ×150		OH5		150	30	76	17		—	●	246
8326285	M22 × 2 ×150		OH4		150	24	76	17		—	●	246
8326284	M22 × 1.5 ×150				150	24	76	17		—	●	246
8326283	M22 × 1 ×150		OH3		150	24	76	17		—	●	246
8326290	M24 × 3 ×150		OH5		150	36	83	19		—	●	300
8326291	×200				200						●	416
8326289	M24 × 2 ×150		OH4		150	24	83	19		—	●	297
8326288	M24 × 1.5 ×150				150	24	83	19		—	●	300
8326287	M24 × 1 ×150		OH3		150	24	83	19		—	●	300

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1184

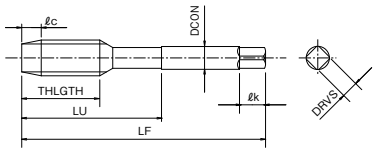
螺旋槽丝锥长柄型(铣刀柄)

SPIRAL FLUTED TAP WITH LONG SHANK (END MILL SHANK)

The A Brand

A-LT-SFT

切削条件 Cutting Conditions | P.837



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size		精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326500	M 3 ×0.5	×100 - 4	STD	OH3	2.5P	100	4	19	4	3	–	●	11
8326520		×150 - 4				150						●	16
8326501	M 4 ×0.7	×100 - 6				100	5.6	21	6		–	●	21
8326521		×150 - 6				150						●	33
8326502	M 5 ×0.8	×100 - 6				100	6.4	24	6		–	●	21
8326522		×150 - 6				150						●	33
8326503	M 6 ×1	×100 - 6				100	8	29	6		–	●	21
8326523		×150 - 6				150						●	33
8326524		×200 - 6				200						●	44
8326504	M 8 ×1.25	×100 - 8		OH4		100	15	37	8		–	●	34
8326525		×150 - 8				150						●	55
8326526		×200 - 8				200						●	76
8326506	M10 ×1.5	×100 - 8				100	18	41	8		–	●	38
8326527		×150 - 8				150		60				●	60
8326528		×200 - 8				200		80				●	79
8326505	M10 ×1.25	×100 - 8				100	15	41	8		–	●	38
8326529		×150 - 8				150		60				●	59
8326530		×200 - 8				200		80				●	80
8326507	M12 ×1.75	×100 - 10				100	21	48	10		–	●	58
8326531		×150 - 10				150		60				●	89
8326532		×200 - 10				200		80				●	120
8326508	M14 ×2	×150 - 12		OH5		150	24	50	12		–	●	126
8326533		×200 - 12				200		80				●	169
8326509	M16 ×2	×150 - 16				150	24	60	16		–	●	192
8326534		×200 - 16				200						●	272
8326510	M20 ×2.5	×150 - 16				150	30	75	16	4	–	●	214
8326535		×200 - 16				200		80				●	293
8326511	M24 ×3	×150 - 20				150	36	90	20		–	●	309
8326536		×200 - 20				200						●	436

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 铣刀柄产品对应筒夹柄，铣刀柄等，请使用周边紧固的刀柄。
2. 精度栏 保证高精度与完全同步进给的组合为前提，2级相当的丝锥推荐精度。
3. 丝锥精度不能保证内螺纹的精度。
4. 不推荐再研磨。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Although taps with end mill shank are compatible with a collet holder, milling holder and etc., use a holder with a detent.
2. The recommended tap limit corresponds to JIS class 2 internal thread standards only if combination of maintaining the high accuracy and complete synchronous feed is applied.
3. Tap limit does not guarantee thread limit for the internal thread after tapping.
4. Regrinding is not recommended.

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

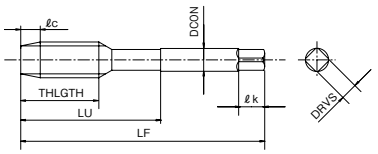
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1040

一般用
GENERAL APPLICATION

EX-SFT

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



HSSE | 35° < M52 | 15° M52 ≦

螺纹种类：M

单位 :mm Unit:mm

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

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

下一页
尺寸 Size M3 ~ M8 NEXT

SynchroMaster

与A-TAP完美搭配的攻丝刀柄

※详情请参照 ▶P.831
See p.831 for details

库存记号 Inventory symbols

●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

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

上一页
FROM 尺寸 Size M1 ~ M2.6

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18040	M 3 × 0.6	2.5P	STD	OH1	46	6	19	4	OH1	46	11	19	4	3	—	●	4
18041			STD+1	OH2					OH2						—	●	4
11544	M 3 × 0.5		STD	OH2	46	6	19	4	OH2	46	11	19	4		—	●	4
18045			STD+1	OH3					OH3						—	●	4
19942			STD+2	OH4					OH4						—	●	4
18046	M 3 × 0.35		STD	OH1	46	6	19	4	OH1	46	11	19	4		—	●	5
18048	M 3.5 × 0.6				48	7.2	20	4		48	13	20	4		Yes	●	4
18049			STD+1	OH2					OH2						Yes	●	5
18050	M 3.5 × 0.35		STD	OH1	48	7.2	20	4	OH1	48	13	20	4		Yes	●	5
18053	M 4 × 0.75			OH2	52	8.4	21	5	OH2	52	13	21	5		Yes	●	7
18054			STD+1	OH3					OH3						Yes	●	7
11556	M 4 × 0.7		STD	OH2	52	8.4	21	5	OH2	52	13	21	5		Yes	●	7
18057			STD+1	OH3					OH3						Yes	●	7
19946			STD+2	OH4					OH4						Yes	●	7
18059	M 4 × 0.5		STD	OH2	52	8.4	21	5	OH2	52	13	21	5		Yes	●	7
18062	M 4.5 × 0.75				55	9	21	5		55	13	21	5		Yes	●	9
18068	M 5 × 0.9				60	9.6	24	5.5		60	16	24	5.5		Yes	●	10
18069			STD+1	OH3					OH3						Yes	●	10
11571	M 5 × 0.8		STD	OH2	60	9.6	24	5.5	OH2	60	16	24	5.5		Yes	●	10
18072			STD+1	OH3					OH3						Yes	●	10
19950			STD+2	OH4					OH4						Yes	●	10
18073	M 5 × 0.75		STD	OH2	60	9.6	24	5.5	OH2	60	16	24	5.5		Yes	●	10
18074	M 5 × 0.5				60	9.6	24	5.5		60	16	24	5.5		Yes	●	11
18077	M 5.5 × 0.9				60	10.8	25	5.5		60	17	25	5.5		Yes	●	11
18079	M 5.5 × 0.5				60	10.8	25	5.5		60	17	25	5.5		Yes	●	11
11583	M 6 × 1				62	12	29	6		62	19	29	6		Yes	●	11
18084			STD+1	OH3					OH3						Yes	●	11
19954			STD+2	OH4					OH4						Yes	●	12
18086	M 6 × 0.75		STD	OH2	62	12	29	6	OH2	62	19	29	6		Yes	●	12
18087			STD+1	OH3					OH3						Yes	●	12
18088	M 6 × 0.5		STD	OH2	62	12	29	6	OH2	62	19	29	6		Yes	●	12
18092	M 7 × 1				65	12	33	6.2		65	19	33	6.2		—	●	15
18094	M 7 × 0.75				65	12	33	6.2		65	19	33	6.2		—	●	15
18096	M 7 × 0.5				65	12	33	6.2		65	19	33	6.2		—	●	15
11601	M 8 × 1.25			OH3	70	15	37	6.2		70	22	37	6.2		—	●	17
18102			STD+1	OH4					OH3						—	●	16
19958			STD+2	OH5					OH4						—	●	17
18104	M 8 × 1		STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2		—	●	17
18105			STD+1	OH3					OH3						—	●	17
18107	M 8 × 0.75		STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2		—	●	18

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。
5. 新形状逐步取代旧形状。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

下一页
尺寸 Size M8 ~ M12 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

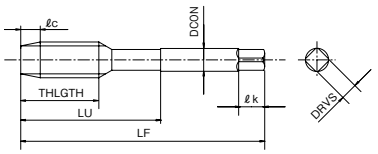
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1040

一般用
GENERAL APPLICATION

EX-SFT

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



HSSE | 35° | 15°
< M52 | M52 ≦

上一页
FROM 尺寸 Size M3 ~ M8

螺纹种类：M

单位 :mm Unit:mm

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

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。
5. 新形状逐步取代旧形状。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

下一页
尺寸 Size M13 ~ M23 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

上一页
FROM 尺寸 Size M8 ~ M12

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18168	M 13 × 1.75	STD	OH2	2.5P	88	30	48	9.5	3	–	●	56
18171	M 13 × 1.5				88	30	48	9.5		–	●	57
18175	M 13 × 1				88	30	48	9.5		–	●	58
11680	M 14 × 2				88	30	48	10.5		–	●	64
18181		STD+1	OH3							–	●	64
11683	M 14 × 1.5	STD	OH2		88	30	48	10.5		–	●	65
18184		STD+1	OH3							–	●	65
18186	M 14 × 1.25	STD	OH2		88	30	48	10.5		–	●	66
18187	M 14 × 1				88	30	48	10.5		–	●	66
18193	M 15 × 2				95	32	52	10.5		–	●	72
18196	M 15 × 1.5				95	32	52	10.5		–	●	74
18199	M 15 × 1				95	32	52	10.5		–	●	74
11705	M 16 × 2				95	32	52	12.5		–	●	91
18206		STD+1	OH3							–	●	92
11708	M 16 × 1.5	STD	OH2		95	32	52	12.5		–	●	92
18209		STD+1	OH3							–	●	93
18211	M 16 × 1	STD	OH2		95	32	52	12.5		–	●	93
18221	M 17 × 2		OH3		100	37	55	13	4	–	●	97
18224	M 17 × 1.5		OH2		100	37	55	13		–	●	100
18227	M 17 × 1				100	37	55	13		–	●	100
11730	M 18 × 2.5		OH3		100	37	55	14		–	●	109
18231		STD+1	OH4							–	●	110
18233	M 18 × 2	STD	OH3		100	37	55	14		–	●	110
11735	M 18 × 1.5		OH2		100	37	55	14		–	●	110
18236		STD+1	OH3							–	●	112
18238	M 18 × 1	STD	OH2		100	37	55	14		–	●	111
18248	M 19 × 2.5		OH3		105	37	58	14		–	●	120
18252	M 19 × 1.5		OH2		105	37	58	14		–	●	122
18254	M 19 × 1				105	37	58	14		–	●	123
11757	M 20 × 2.5		OH3		105	37	58	15		–	●	135
18258		STD+1	OH4							–	●	136
18260	M 20 × 2	STD	OH3		105	37	58	15		–	●	137
11762	M 20 × 1.5		OH2		105	37	58	15		–	●	138
18263		STD+1	OH3							–	●	138
18266	M 20 × 1	STD	OH2		105	37	58	15		–	●	139
11772	M 22 × 2.5		OH3		115	38	63	17		–	●	183
18273		STD+1	OH4							–	●	183
18275	M 22 × 2	STD	OH3		115	38	63	17		–	●	185
11777	M 22 × 1.5		OH2		115	38	63	17		–	●	185
18278		STD+1	OH3							–	●	186
18282	M 22 × 1	STD	OH2		115	38	63	17		–	●	187
18287	M 23 × 2.5		OH3		120	45	66	18		–	●	216
18290	M 23 × 2				120	45	66	18		–	●	217

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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尺寸 Size M24 ~ M56 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

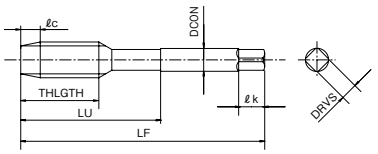
△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | TH1040

一般用
GENERAL APPLICATION

EX-SFT

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



HSSE | 35° < M52 | 15° M52 ≦

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FROM 尺寸 Size M13 ~ M23

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11799	M 24 × 3	STD	OH3	2.5P	120	45	66	19	4	–	●	235
18300		STD+1	OH4							–	●	241
18302	M 24 × 2	STD	OH3		120	45	66	19		–	●	239
11804	M 24 × 1.5		OH2		120	45	66	19		–	●	242
18305		STD+1	OH3							–	●	242
18308	M 24 × 1	STD	OH2		120	45	66	19		–	●	241
18311	M 25 × 3		OH3		130	45	71	19		–	●	268
18314	M 25 × 2				130	45	71	19		–	●	272
18316	M 25 × 1.5		OH2		130	45	71	19		–	●	274
18323	M 26 × 3		OH3		130	45	71	20		–	●	300
18325	M 26 × 2				130	45	71	20		–	●	303
18328	M 26 × 1.5		OH2		130	45	71	20		–	●	306
18338	M 27 × 3		OH3		130	45	71	20		–	●	317
18339		STD+1	OH4							–	●	316
18341	M 27 × 2	STD	OH3		130	45	71	20		–	●	323
18343	M 27 × 1.5		OH2		130	45	71	20		–	●	323
18344		STD+1	OH3							–	●	321
18346	M 27 × 1	STD	OH2		130	45	71	20		–	●	322
18350	M 28 × 3		OH3		135	48	74	21		–	●	368
18353	M 28 × 2				135	48	74	21		–	●	368
18355	M 28 × 1.5		OH2		135	48	74	21		–	●	367
18362	M 30 × 3.5		OH3		135	48	74	23		–	●	414
18363		STD+1	OH4							–	●	415
18365	M 30 × 3	STD	OH3		135	48	74	23		–	●	417
18368	M 30 × 2				135	48	74	23		–	●	429
18370	M 30 × 1.5		OH2		135	48	74	23		–	●	429
18371		STD+1	OH3							–	●	429
18383	M 32 × 1.5	STD	OH3		110	37	47	24		–	●	387
18389	M 33 × 3.5				145	51	77	25		–	●	532
18395	M 33 × 2				110	37	47	25		–	●	413
18401	M 33 × 1.5				110	37	47	25		–	●	409
18413	M 35 × 1.5				110	39	49	26		–	●	453
18420	M 36 × 4		OH4	3P	155	57	82	28		–	●	662
18424	M 36 × 3				155	57	82	28		–	●	660
18426	M 36 × 2		OH3		110	39	49	28		–	●	475
18431	M 36 × 1.5				110	39	49	28		–	●	482
18443	M 39 × 4		OH4		165	60	87	30		–	●	819
18459	M 42 × 4.5				175	60	93	32		–	●	987
18463	M 42 × 3				175	60	93	32		–	●	989
18467	M 42 × 2		OH3		120	39	49	32		–	●	715
18470	M 42 × 1.5				120	39	49	32		–	●	715
18479	M 45 × 4.5		OH4		180	67	95	35		–	●	1,190
18482	M 45 × 3				180	67	95	35		–	●	1,196
18485	M 45 × 2		OH3		120	45	55	35		–	●	822
18488	M 45 × 1.5				120	45	55	35		–	●	822
18499	M 48 × 5		OH4		185	67	98	38		–	●	1,429
18502	M 48 × 3				185	67	98	38		–	●	1,415
18504	M 48 × 2		OH3		125	45	55	38		–	●	1,005
18506	M 48 × 1.5				125	45	55	38		–	●	1,006
19750	M 52 × 5		OH4	2.5P	195	70	103	42		–	●	1,762
19763	M 56 × 5.5				205	70	108	44		–	●	2,250

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

HSSE　35°

螺纹种类：U

单位 :mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18821	No. 4 - 40UNC	2.5P	STD	OH1	44	7.7	17	3	OH1	44	15	—	3	2	—	●	4
18824	No. 4 - 48UNF				44	7.7	17	3		44	15	—	3		—	●	4
18827	No. 5 - 40UNC				46	7.7	19	4		46	11	19	4	3	Yes	●	5
18830	No. 5 - 44UNF				46	7.7	19	4		46	11	19	4		Yes	●	5
18833	No. 6 - 32UNC			OH2	48	9.6	21	4	OH2	48	13	21	4		Yes	●	5
18836	No. 6 - 40UNF			OH1	48	9.6	21	4	OH1	48	13	21	4		Yes	●	5
18840	No. 8 - 32UNC			OH2	52	9.6	21	5	OH2	52	13	21	5		Yes	●	8
18842	No. 8 - 36UNF				52	9.6	21	5		52	13	21	5		Yes	●	8
18846	No. 10 - 24UNC				60	12.7	24	5.5		60	16	24	5.5		Yes	●	10
18849	No. 10 - 32UNF				60	12.7	24	5.5		60	16	24	5.5		Yes	●	10
18852	No. 12 - 24UNC				60	12.7	25	5.5		60	17	25	5.5		Yes	●	11
18855	No. 12 - 28UNF				60	12.7	25	5.5		60	17	25	5.5		Yes	●	11
18858	1/4 - 20UNC			OH3	62	15.3	29	6	OH2	62	19	29	6		Yes	●	13
18861	1/4 - 28UNF			OH2	62	15.3	29	6		62	19	29	6		Yes	●	13
18867	5/16 - 18UNC			OH3	70	17	37	6.1		70	22	37	6.1		—	●	17
18870	5/16 - 24UNF			OH2	70	17	37	6.1		70	22	37	6.1		—	●	17
18876	3/8 - 16UNC			OH3	75	19	41	7		75	24	41	7		—	●	25
18882	3/8 - 24UNF			OH2	75	19	41	7		75	24	41	7		—	●	26
18891	7/16 - 14UNC			OH3	80	22	48	8		80	25	48	8		—	●	35
18894	7/16 - 20UNF				80	22	48	8		80	25	48	8		—	●	42
18900	1/2 - 13UNC				85	23	48	9		85	29	48	9		—	●	47
18906	1/2 - 20UNF				85	23	48	9		85	29	48	9		—	●	44

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　　是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中NO.4以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。
5. 新形状逐步取代旧形状。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. Taps of No.4 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

下一页
尺寸 Size 9/16 ~ 1 3/4 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1040

一般用
GENERAL APPLICATION

EX-SFT

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

HSSE | 35°

上一页
FROM 尺寸 Size NO.4 ～1/2

螺纹种类：U

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18912	9/16 - 12UNC	STD	OH2	2.5P	90	30	48	10.5	3	–	●	66
18915	9/16 - 18UNF		OH2		90	30	48	10.5		–	●	70
18919	5/8 - 11UNC		OH3		95	32	52	12		–	●	86
18921	5/8 - 18UNF		OH2		95	32	52	12		–	●	86
18925	3/4 - 10UNC		OH3		105	37	58	14	4	–	●	119
18927	3/4 - 16UNF		OH2		105	37	58	14		–	●	122
18931	7/8 - 9UNC		OH3		115	38	63	17		–	●	186
18933	7/8 - 14UNF		OH2		115	38	63	17		–	●	186
18937	1 - 8UNC		OH3		125	45	68	20		–	●	281
18940	1 - 12UNF				125	45	68	20		–	●	279
18943	1 - 14UNS				125	45	68	20		–	●	282
18945	1 1/8 - 7UNC		OH4		135	48	72	22		–	●	379
18947	1 1/8 - 12UNF		OH3		105	37	47	22		–	●	300
18952	1 1/4 - 7UNC		OH4		145	51	77	24		–	●	496
18955	1 1/4 - 12UNF		OH3		105	37	47	24		–	●	368
18958	1 3/8 - 6UNC		OH4		155	57	82	26		–	●	622
18960	1 3/8 - 12UNF		OH3		110	39	49	26		–	●	447
18964	1 1/2 - 6UNC		OH4	3P	160	60	85	30		–	●	771
18966	1 1/2 - 12UNF		OH3		115	39	49	30		–	●	577
18970	1 3/4 - 5UNC		OH4		175	67	93	35		–	●	1,141
18972	1 3/4 - 12UN		OH3		120	45	55	35		–	●	825

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS请参考 P.1009。

1. 精度栏 是适合加工2B 内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 No.4以下有突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. Taps of NO.4 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

SynchroMaster

※详情请参照 ▶P.831
See p.831 for details

与A-TAP完美搭配的攻丝刀柄

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

HSSE　35°

螺纹种类：W

单位 :mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18704	W 1/8 - 40	STD	OH1	2.5P	46	11	19	4	3	Yes	●	4
18707	W 3/16 - 24				60	16	24	5.5		Yes	●	10
18710	W 1/4 - 20		OH2		62	19	29	6		Yes	●	12
18714	W 5/16 - 18				70	22	37	6.1		–	●	17
18718	W 3/8 - 16				75	24	41	7		–	●	25
18722	W 7/16 - 14				80	25	48	8		–	●	34
18726	W 1/2 - 12				85	29	48	9		–	●	46
18730	W 5/8 - 11				95	32	52	12		–	●	86
18734	W 3/4 - 10				105	37	58	14	4	–	●	119
18738	W 7/8 - 9				115	38	63	17		–	●	184
18742	W 1 - 8		OH3		125	45	68	20		–	●	275
18746	W 1 1/8 - 7				135	48	72	22		–	●	388
18750	W 1 1/4 - 7				145	51	77	24		–	●	493
18758	W 1 1/2 - 6			3P	160	60	85	30		–	●	770

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：SM

单位 :mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19901	SM 3/32 - 56	STD	OH1	2.5P	42	13	20	3	2	Yes	●	3
19903	SM 1/8 - 44				46	11	19	4	3	Yes	●	4
19905	SM 9/64 - 40				48	13	21	4		Yes	●	5
19907	SM 11/64 - 40		OH2		55	13	21	5		Yes	●	8
19910	SM 3/16 - 28				60	16	24	5.5		Yes	●	10
19911	SM 3/16 - 32				60	16	24	5.5		Yes	●	10
19915	SM 15/64 - 28				62	19	29	6		Yes	●	12
19917	SM 1/4 - 24				62	19	29	6		Yes	●	11
19920	SM 1/4 - 40				62	19	29	6		Yes	●	13
19921	SM 9/32 - 20				65	22	33	6.5		–	●	16
19922	SM 9/32 - 28				65	22	33	6.5		–	●	16

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

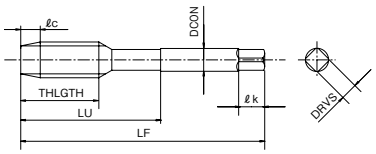
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1040

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

EX-SFT



HSSE | 35°

螺纹种类：**M(L)**

单位 :mm Unit:mm

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

1. 新形状逐步取代旧形状。

1. Conventional dimension is replaced with new one accordingly.

单位 :mm Unit:mm

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

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

EX-SFT

HSSE | 35°

螺纹种类：W(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19703	W 1/4 - 20 - L	STD	OH2	2.5P	62	19	29	6	3	Yes	△	13
19704	W 5/16 - 18 - L				70	22	37	6.1		—	△	17
19705	W 3/8 - 16 - L				75	24	41	7		—	△	24
19707	W 1/2 - 12 - L				85	29	48	9		—	△	47
19709	W 5/8 - 11 - L				95	32	52	12		—	△	86
19710	W 3/4 - 10 - L				105	37	58	14	4	—	△	121
19711	W 7/8 - 9 - L				115	38	63	17		—	△	184
19712	W 1 - 8 - L		OH3		125	45	68	20		—	△	286

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

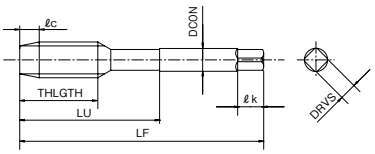
G-LIST No. | TH1336 NEW

一般用高耐久型螺旋槽丝锥

HIGHLY DURABLE GENERAL PURPOSE SPIRAL TAP

EXZ-SFT

切削条件 Cutting Conditions | P.840



HSSE | NZ | 35°

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
1154480	M 3 × 0.5	STD	OH2	2.5P	46	6	19	4	3	—	●	4
1155680	M 4 × 0.7				52	8.4	21	5		—	●	7
1157180	M 5 × 0.8				60	9.6	24	5.5		—	●	10
1158380	M 6 × 1				62	12	29	6		—	●	11
1160180	M 8 × 1.25		OH3		70	15	37	6.2		—	●	17
1162180	M 10 × 1.5				75	18	41	7		—	●	26
1165080	M 12 × 1.75				82	21	48	8.5		—	●	40
1168080	M 14 × 2		OH2		88	30	48	10.5		—	●	64
1170580	M 16 × 2				95	32	52	12.5		—	●	91

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

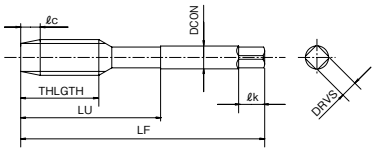
△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | TH1043

一般用 长柄型

LONG SHANK· GENERAL APPLICATION

EX-LT-SFT



HSSE | 35°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17760	M 2 × 0.4	STD	OH1	2.5P	80	12	–	3	2	–	●	6
17761					100					–	●	8
17764	M 2.3 × 0.4				80	13	–	3		–	●	6
17765					100					–	●	7
17768	M 2.5 × 0.45				80	14	–	3		–	●	6
17769					100					–	●	8
17772	M 2.6 × 0.45				80	14	–	3		–	●	6
17773					100					–	●	8

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

下一页
尺寸 Size M3 ~ M12 NEXT

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

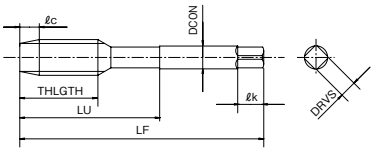
G-LIST No. | TH1043

一般用 长柄型

LONG SHANK· GENERAL APPLICATION

EX-LT-SFT

标准螺旋槽丝锥螺纹部悬长不足的情况下使用本系列。
This tap is used when a standard spiral fluted tap is too short.



HSSE | 35°

上一页 FROM 尺寸 Size M2 ~ M2.6

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13310	M 3 × 0.5	2.5P	STD	OH2	100	6	19	4	OH2	100	11	19	4	3	–	●	11
13311					120					120					–	●	12
13312					150					150					–	●	15
13875			STD+2	OH4	100				OH4	100					–	●	11
13318	M 4 × 0.7		STD	OH2	100	8.4	21	5	OH2	100	13	21	5		Yes	●	15
13319					120					120					Yes	●	18
13320					150					150					Yes	●	23
13876			STD+2	OH4	100				OH4	100					Yes	●	16
13326	M 5 × 0.8		STD	OH2	100	9.6	24	5.5	OH2	100	16	24	5.5		Yes	●	18
13327					120					120					Yes	●	22
13328					150					150					Yes	●	28
13877			STD+2	OH4	100				OH4	100					Yes	●	18
13334	M 6 × 1		STD	OH2	100	12	29	6	OH2	100	19	29	6		Yes	●	22
13335					120					120					Yes	●	26
13336					150					150					Yes	●	32
13337					200					200					Yes	●	46
13878			STD+2	OH4	100				OH4	100					Yes	●	23
13879					150					150					Yes	●	33
13338	M 6 × 0.75		STD	OH2	100	12	29	6	OH2	100	19	29	6		Yes	●	23
13342	M 8 × 1.25			OH3	100	15	37	6.2		100	22	37	6.2		–	●	25
13343					120					120					–	●	31
13344					150					150					–	●	38
13345					200					200					–	●	50
13880			STD+2	OH5	100				OH4	100					–	●	25
13881					150					150					–	●	37
13346	M 8 × 1		STD	OH2	100	15	37	6.2	OH2	100	22	37	6.2		–	●	26
13347					120					120					–	●	31
13348					150					150					–	●	38
13349	M 8 × 0.75				100	15	37	6.2		100	22	37	6.2		–	●	26
13350	M 10 × 1.5			OH3	100	18	41	7		100	24	41	7		–	●	34
13351					120					120					–	●	41
13352					150					150					–	●	50
13353					200					200					–	●	66
13882			STD+2	OH5	150				OH4	150					–	●	50
13358	M 10 × 1.25		STD	OH3	100	18	41	7	OH2	100	24	41	7		–	●	35
13359					120					120					–	●	42
13360					150					150					–	●	50
13361					200					200					–	●	67
13883			STD+2	OH5	150				OH4	150					–	●	50
13362	M 10 × 1		STD	OH2	100	18	41	7	OH2	100	24	41	7		–	●	35
13363					120					120					–	●	42
13364					150					150					–	●	50
13366	M 12 × 1.75			OH3	100	21	48	8.5		100	29	48	8.5		–	●	50
13367					120					120					–	●	55
13368					150					150					–	●	71
13369					200					200					–	●	94
13884			STD+2	OH5	150				OH4	150					–	●	72
13374	M 12 × 1.5		STD	OH3	100	21	48	8.5	OH2	100	29	48	8.5		–	●	50
13375					120					120					–	●	55
13376					150					150					–	●	71
13377					200					200					–	●	94
13885			STD+2	OH5	150				OH4	150					–	●	72

下一页 尺寸 Size M12 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

上一页
FROM 尺寸 Size M3 ~ M12

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13382	M 12 × 1.25	2.5P	STD	OH3	100	21	48	8.5	OH2	100	29	48	8.5	3	—	●	51
13383					120					120					—	●	56
13384					150					150					—	●	72
13385					200					200					—	●	94
13886			STD+2	OH5	150				OH4	150					—	●	72
13386	M 12 × 1		STD	OH2	100	21	48	8.5	OH2	100	29	48	8.5		—	●	52
13387					120					120					—	●	57
13388					150					150					—	●	73

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。
5. 新形状逐步取代旧形状。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

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尺寸 Size M14 ~ M27 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

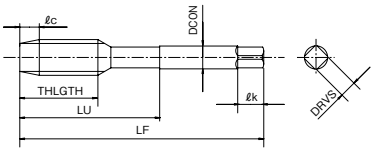
G-LIST No. | TH1043

一般用 长柄型

LONG SHANK· GENERAL APPLICATION

EX-LT-SFT

标准螺旋槽丝锥螺纹部悬长不足的情况下使用本系列。
This tap is used when a standard spiral fluted tap is too short.



HSSE | 35°

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FROM 尺寸 Size M12

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13390	M 14 × 2	STD	OH3	2.5P	100	30	48	10.5	3	–	●	73
13391					120					–	●	79
13392					150					–	●	103
13393					200					–	●	137
13398	M 14 × 1.5				100	30	48	10.5		–	●	74
13399					120					–	●	80
13400					150					–	●	103
13401					200					–	●	137
13404	M 14 × 1		OH2		150	30	48	10.5		–	●	104
13406	M 16 × 2				120	32	52	12.5		–	●	110
13407					150					–	●	141
13408					200					–	●	192
13409					250					–	●	244
13414	M 16 × 1.5				120	32	52	12.5		–	●	112
13415					150					–	●	145
13416					200					–	●	191
13417					250					–	●	247
13419	M 16 × 1				150	32	52	12.5		–	●	145
13423	M 18 × 2.5		OH3		150	37	55	14	4	–	●	175
13424					200					–	●	236
13425					250					–	●	302
13427	M 18 × 2		OH2		150	37	55	14		–	●	176
13431	M 18 × 1.5				150	37	55	14		–	●	176
13432					200					–	●	237
13433					250					–	●	303
13439	M 20 × 2.5		OH3		150	37	58	15		–	●	202
13440					200					–	●	136
13441					250					–	●	353
13443	M 20 × 2		OH2		150	37	58	15		–	●	203
13447	M 20 × 1.5				150	37	58	15		–	●	204
13448					200					–	●	280
13449					250					–	●	357
13455	M 22 × 2.5		OH3		150	38	63	17		–	●	249
13456					200					–	●	340
13457					250					–	●	438
13463	M 22 × 1.5		OH2		150	38	63	17		–	●	252
13464					200					–	●	342
13465					250					–	●	442
13471	M 24 × 3		OH3		150	45	66	19		–	●	309
13472					200					–	●	422
13473					250					–	●	542
13475	M 24 × 2		OH2		150	45	66	19		–	●	313
13479	M 24 × 1.5				150	45	66	19		–	●	318
13480					200					–	●	427
13481					250					–	●	546
13487	M 27 × 3		OH3		200	45	71	20		–	●	493
13488					250					–	●	633
13890	M 27 × 2				250	45	71	20		–	●	647
13892	M 27 × 1.5		OH2		250	45	71	20		–	●	636

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尺寸 Size M30 ~ M36 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

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FROM 尺寸 Size M14 ~ M27

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13490	M 30 × 3.5	STD	OH3	2.5P	200	48	74	23	4	—	●	628
13489					250					—	●	823
13491					300					—	●	990
13898	M 30 × 2				250	48	74	23		—	●	830
13899	M 30 × 1.5		OH2		250	48	74	23		—	●	821
13492	M 33 × 3.5		OH3		250	51	77	25		—	●	979
13493					300					—	●	1,163
13496	M 36 × 4			3P	250	57	82	28		—	●	1,152
13497					300					—	●	1,398

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1043

一般用 长柄型

LONG SHANK· GENERAL APPLICATION

EX-LT-SFT

标准螺旋槽丝锥螺纹部悬长不足的情况下使用本系列。
This tap is used when a standard spiral fluted tap is too short.

HSSE | 35°

螺纹种类：W

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13923	W 1/4 - 20	STD	OH2	2.5P	150	19	29	6	3	Yes	△	33
13924	W 5/16 - 18				150	22	37	6.1		—	△	36
13925	W 3/8 - 16				150	24	41	7		—	△	49
13927	W 1/2 - 12				150	29	48	9		—	△	78
13929	W 5/8 - 11				150	32	52	12		—	△	131
13930	W 3/4 - 10				150	37	58	14	4	—	△	179
13932	W 1 - 8		OH3		150	45	68	20		—	△	337

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | **TH1043**

一般用长柄 (左螺旋)

LONG SHANK· GENERAL APPLICATION(LH THREAD)

EX-LT-SFT

标准螺旋槽丝锥螺纹部悬长不足的情况下使用本系列。
This tap is used when a standard spiral fluted tap is too short.

HSSE | 35°

螺纹种类：M(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削推长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21510	M 3 ×0.5 - L	2.5P	STD	OH2	100	6	19	4	OH2	100	11	19	4	3	Yes	●	11
21518	M 4 ×0.7 - L				100	8.4	21	5		100	13	21	5		Yes	●	16
21526	M 5 ×0.8 - L				100	9.6	24	5.5		100	16	24	5.5		Yes	●	19
21534	M 6 ×1 - L				100	12	29	6		100	19	29	6		Yes	●	21
21536					150					150					Yes	●	32
21542	M 8 ×1.25 - L			OH3	100	15	37	6.2		100	22	37	6.2		–	●	25
21544					150					150					–	●	37
21552	M10 ×1.5 - L				150	18	41	7		150	24	41	7		–	●	50
21568	M12 ×1.75 - L				150	21	48	8.5		150	29	48	8.5		–	●	71

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。
4. 新形状逐步取代旧形状。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
4. Conventional dimension is replaced with new one accordingly.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

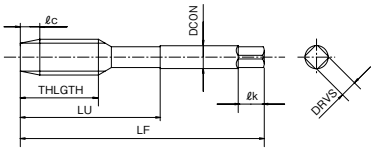
△＝停产产品(请确认库存。)
Discontinued item

G-LIST No. | TH1020

一般用氧化处理

GENERAL APPLICATION (WITH OX)

EX-H-SFT



HSSE | H | 35°

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18590	M 1 × 0.25	STD	OH1	2.5P	30	7	—	3	2	—	△	3
18592	M 1.2 × 0.25				32	8	—	3		—	△	3
18594	M 1.4 × 0.3				34	9	—	3		—	▲	3
18596	M 1.6 × 0.35				36	10	—	3		—	▲	3
18598	M 1.7 × 0.35				36	11	—	3		—	▲	3
18602	M 2 × 0.4				40	12	—	3		—	▲	3
18604	M 2.3 × 0.4				42	13	—	3		—	▲	3
18606	M 2.5 × 0.45				44	14	—	3		—	▲	3
18608	M 2.6 × 0.45				44	14	—	3		—	▲	3

▲=该产品已停止生产，由A-SFT(P.583)、MS-DH-SFT(P.639)替代。

▲=The products have been stopped producing and replaced by A-SFT(p.583) and MS-DH-SFT(p.639).

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18612	M 3 ×0.5	2.5P	STD	OH2	46	6	19	4	OH2	46	11	19	4	3	—	●	4
18613			STD+1	OH3					OH3						—	●	4
18614	M 3.5×0.6		STD	OH1	48	7.2	20	4	OH1	48	13	20	4		Yes	●	5
18615			STD+1	OH2					OH2						Yes	●	5
18616	M 4 ×0.7		STD	OH2	52	8.4	21	5		52	13	21	5		Yes	●	7
18617			STD+1	OH3					OH3						Yes	●	7
18620	M 5 ×0.8		STD	OH2	60	9.6	24	5.5	OH2	60	16	24	5.5		Yes	●	9
18621			STD+1	OH3					OH3						Yes	●	10
18624	M 6 ×1		STD	OH2	62	12	29	6	OH2	62	19	29	6		Yes	●	11
18625			STD+1	OH3					OH3						Yes	●	11
18628	M 8 ×1.25		STD	OH3	70	15	37	6.2	OH2	70	22	37	6.2		—	●	17
18629			STD+1	OH4					OH3						—	●	17
18630	M 8 ×1		STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2		—	●	17
18632	M10 ×1.5			OH3	75	18	41	7		75	24	41	7		—	●	25
18633			STD+1	OH4					OH3						—	●	25
18634	M10 ×1.25		STD	OH3	75	18	41	7	OH2	75	24	41	7		—	●	26
18636			STD+1	OH4					OH3						—	●	26
18637	M10 ×1		STD	OH2	75	18	41	7	OH2	75	24	41	7		—	●	26
18638	M12 ×1.75			OH3	82	21	48	8.5		82	29	48	8.5		—	●	40
18639			STD+1	OH4					OH3						—	●	40
18640	M12 ×1.5		STD	OH3	82	21	48	8.5	OH2	82	29	48	8.5		—	●	40
18641			STD+1	OH4					OH3						—	●	40
18642	M12 ×1.25		STD	OH3	82	21	48	8.5	OH2	82	29	48	8.5		—	●	40
18643			STD+1	OH4					OH3						—	●	40
18644	M12 ×1		STD	OH2	82	21	48	8.5	OH2	82	29	48	8.5		—	●	40

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。
5. 新形状逐步取代旧形状。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004
5. Conventional dimension is replaced with new one accordingly.

下一页
尺寸 Size M14 ~ M42 NEXT

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

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

上一页
FROM 尺寸 Size M3 ~ M12

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18649	M 14 × 2	STD	OH2	2.5P	88	30	48	10.5	3	–	●	64
18651	M 14 × 1.5				88	30	48	10.5		–	●	66
18655	M 16 × 2				95	32	52	12.5		–	●	90
18657	M 16 × 1.5				95	32	52	12.5		–	●	93
18661	M 18 × 2.5		OH3		100	37	55	14	4	–	●	109
18663	M 18 × 1.5		OH2		100	37	55	14		–	●	112
18667	M 20 × 2.5		OH3		105	37	58	15		–	●	135
18669	M 20 × 1.5		OH2		105	37	58	15		–	●	138
18673	M 22 × 2.5		OH3		115	38	63	17		–	●	183
18675	M 22 × 1.5		OH2		115	38	63	17		–	●	186
18679	M 24 × 3		OH3		120	45	66	19		–	●	236
18681	M 24 × 1.5		OH2		120	45	66	19		–	●	241
18685	M 27 × 3		OH3		130	45	71	20		–	●	317
18687	M 27 × 1.5		OH2		130	45	71	20		–	▲	324
18691	M 30 × 3.5		OH3		135	48	74	23		–	●	413
18693	M 30 × 1.5		OH2		135	48	74	23		–	▲	420
18695	M 33 × 3.5		OH3		145	51	77	25		–	●	539
18697	M 33 × 1.5				110	37	47	25		–	▲	410
18699	M 36 × 4		OH4	3P	155	57	82	28		–	●	664
18763	M 36 × 1.5		OH3		110	39	49	28		–	▲	478
18765	M 42 × 4.5		OH4		175	60	93	32		–	●	979
18767	M 42 × 1.5		OH3		120	39	49	32		–	▲	725

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 　 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲＝该产品已停止生产，由 A-SFT(P.583)、MS-DH-SFT(P.639) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by A-SFT (p.583) and MS-DH-SFT (p.639).

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

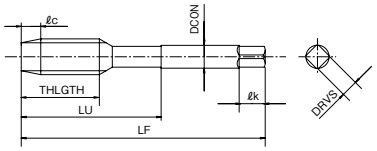
G-LIST No. | TH1045

一般用氧化处理长柄型

LONG SHANK· GENERAL APPLICATION (WITH OX)

EX-LT-H-SFT

HSSE | H | 35°



螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17310	M 3 × 0.5	2.5P	STD	OH2	100	6	19	4	OH2	100	11	19	4	3	–	●	11
17318	M 4 × 0.7				100	8.4	21	5		100	13	21	5		Yes	●	16
17326	M 5 × 0.8				100	9.6	24	5.5		100	16	24	5.5		Yes	●	19
17334	M 6 × 1				100	12	29	6		100	19	29	6		Yes	●	23
17336					150					150					Yes	●	33
17342	M 8 × 1.25			OH3	100	15	37	6.2		100	22	37	6.2		–	●	25
17344					150					150					–	●	37
17352	M 10 × 1.5				150	18	41	7		150	24	41	7		–	●	50
17368	M 12 × 1.75				150	21	48	8.5		150	29	48	8.5		–	●	71
17370					200					200					–	△	93
17372	M 12 × 1.5				150	21	48	8.5		150	29	48	8.5		–	●	71
17376	M 12 × 1.25				150	21	48	8.5		150	29	48	8.5		–	●	71

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。
5. 新形状逐步取代旧形状。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

下一页
尺寸 Size M14 ~ M24 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

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

上一页

FROM 尺寸 Size M3 ~ M12

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
79104	M 14 × 2	STD	OH2	2.5P	150	30	48	10.5	3	–	●	101
79106					200					–	△	139
79112	M 14 × 1.5				150	30	48	10.5		–	●	103
79114					200					–	△	275
79120	M 16 × 2				150	32	52	12.5		–	●	141
79122					200					–	▲	194
79128	M 16 × 1.5				150	32	52	12.5		–	●	143
79130					200					–	△	190
79136	M 18 × 2.5		OH3		150	37	55	14	4	–	●	174
79138					200					–	△	260
79144	M 18 × 1.5		OH2		150	37	55	14		–	●	178
79146					200					–	△	240
79152	M 20 × 2.5		OH3		150	37	58	15		–	●	202
79154					200					–	▲	272
79160	M 20 × 1.5		OH2		150	37	58	15		–	●	204
79162					200					–	△	275
79168	M 22 × 2.5		OH3		150	38	63	17		–	●	250
79170					200					–	△	339
79176	M 22 × 1.5		OH2		150	38	63	17		–	●	253
79178					200					–	△	340
79184	M 24 × 3		OH3		150	45	66	19		–	●	310
79186					200					–	▲	422
79192	M 24 × 1.5		OH2		150	45	66	19		–	●	314
79194					200					–	△	434

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

▲＝该产品已停止生产，由A-LT-SFT(P.591)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by A-LT-SFT(p.591).

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

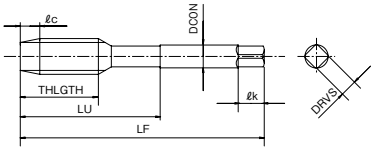
G-LIST No. | TH1088

短切削锥型
SHORT CHAMFER TYPE

EX-SC-SFT

本丝锥切削锥部长为1.5牙。当一般的螺旋槽丝锥(切削锥部长为2.5牙)盲孔攻丝时不能确保有效螺纹长度时可选用此短切削锥型。

This tap is used to tap blind holes with 1.5 threads chamfer lengh when ordinary spiral fluted taps with a chamfer length of 2.5 threads cannot guarantee effective screw length.



HSSE | 45°

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8320281	M 1 × 0.25	STD	OH1	1.5P	30	7	–	3	2	–	●	5
8320284	M 1.2 × 0.25				32	8	–	3		–	●	3
8320287	M 1.4 × 0.3				34	9	–	3		–	●	3
8320290	M 1.6 × 0.35				36	10	–	3		–	●	3
8320293	M 1.7 × 0.35				36	11	–	3		–	●	3
8320296	M 1.8 × 0.35				36	11	–	3		–	●	3
8320299	M 2 × 0.4				40	12	–	3		–	●	3
8320302	M 2.3 × 0.4				42	13	–	3		–	●	3
8320305	M 2.5 × 0.45				44	14	–	3		–	●	3
8320308	M 2.6 × 0.45				44	14	–	3		–	●	3

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M1.8以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M1.8 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

下一页
尺寸 Size M3 ~ M12 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

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

上一页
FROM 尺寸 Size M1 ~ M2.6

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8320311	M 3 ×0.5	1.5P	STD	OH2	46	6	19	4	OH2	46	11	19	4	3	–	●	4
8320411			STD+1	OH3					OH3						–	●	4
8320314	M 4 ×0.7		STD	OH2	52	8.4	21	5	OH2	52	13	21	5		–	●	7
8320414			STD+1	OH3					OH3						–	●	7
8320317	M 5 ×0.8		STD	OH2	60	9.6	24	5.5	OH2	60	16	24	5.5		–	●	10
8320417			STD+1	OH3					OH3						–	●	10
8320320	M 6 ×1		STD	OH2	62	12	29	6	OH2	62	19	29	6		–	●	11
8320420			STD+1	OH3					OH3						–	●	12
8320323	M 8 ×1.25		STD	OH3	70	15	37	6.2	OH2	70	22	37	6.2		–	●	17
8320423			STD+1	OH4					OH3						–	●	17
8320324	M 8 ×1		STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2		–	●	17
8320424			STD+1	OH3					OH3						–	●	17
8320326	M10 ×1.5		STD	OH3	75	18	41	7	OH2	75	24	41	7		–	●	26
8320426			STD+1	OH4					OH3						–	●	25
8320329	M10 ×1.25		STD	OH3	75	18	41	7	OH2	75	24	41	7		–	●	26
8320429			STD+1	OH4					OH3						–	●	26
8320330	M10 ×1		STD	OH2	75	18	41	7	OH2	75	24	41	7		–	●	26
8320430			STD+1	OH3					OH3						–	●	26
8320332	M12 ×1.75		STD	OH3	82	21	48	8.5	OH2	82	29	48	8.5		–	●	40
8320432			STD+1	OH4					OH3						–	●	40
8320334	M12 ×1.5		STD	OH3	82	21	48	8.5	OH2	82	29	48	8.5		–	●	40
8320434			STD+1	OH4					OH3						–	●	40
8320336	M12 ×1.25		STD	OH3	82	21	48	8.5	OH2	82	29	48	8.5		–	●	41
8320436			STD+1	OH4					OH3						–	●	41
8320338	M12 ×1		STD	OH2	82	21	48	8.5	OH2	82	29	48	8.5		–	●	41
8320438			STD+1	OH3					OH3						–	●	41

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M1.8以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。
5. 新形状逐步取代旧形状。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M1.8 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

下一页
尺寸 Size M14 ~ M30 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

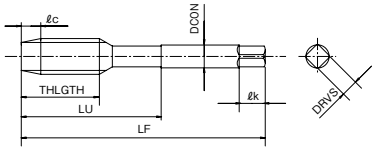
G-LIST No. | **TH1088**

短切削锥型
SHORT CHAMFER TYPE

EX-SC-SFT

本丝锥切削锥部长为1.5牙。当一般的螺旋槽丝锥(切削锥部长为2.5牙)盲孔攻丝时不能确保有效螺纹长度时可选用此短切削锥型。

This tap is used to tap blind holes with 1.5 threads chamfer lengh when ordinary spiral fluted taps with a chamfer length of 2.5 threads cannot guarantee effective screw length.



HSSE | 45°

上一页
FROM 尺寸 Size M3 ~ M12

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8320341	M 14 × 2	STD	OH2	1.5P	88	30	48	10.5	3	—	●	65
8320344	M 14 × 1.5				88	30	48	10.5		—	●	66
8320347	M 16 × 2				95	32	52	12.5		—	●	92
8320350	M 16 × 1.5				95	32	52	12.5		—	●	94
8320353	M 18 × 2.5				100	37	55	14	4	—	●	111
8320356	M 18 × 1.5				100	37	55	14		—	●	116
8320359	M 20 × 2.5		OH3		105	37	58	15		—	●	139
8320362	M 20 × 1.5		OH2		105	37	58	15		—	●	144
8320365	M 22 × 2.5		OH3		115	38	63	17		—	●	191
8320368	M 22 × 1.5		OH2		115	38	63	17		—	●	191
8320371	M 24 × 3		OH3		120	45	66	19		—	●	240
8320374	M 27 × 3				130	45	71	20		—	●	320
8320377	M 30 × 3.5				135	48	74	23		—	●	418

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M1.8以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M1.8 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

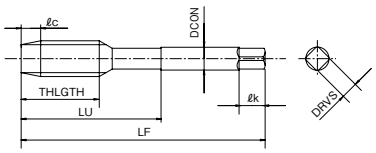
△＝停产产品(请确认库存。)
Discontinued item

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

长柄短切削锥型

SHORT CHAMFER TYPE· LONG SHANK

LT-SC-SFT



HSSE

45°

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8320510	M 3 × 0.5	1.5P	STD	OH2	100	6	19	4	OH2	100	11	19	4	3	—	●	11
8320513	M 4 × 0.7				100	8.4	21	5		100	13	21	5		—	●	15
8320516	M 5 × 0.8				100	9.6	24	5.5		100	16	24	5.5		—	●	18
8320519	M 6 × 1				100	12	29	6		100	19	29	6		—	●	23
8320520					120					120					—	●	26
8320521					150					150					—	●	32
8320523	M 8 × 1.25			OH3	100	15	37	6.2		100	22	37	6.2		—	●	25
8320525					150					150					—	●	38
8320527	M 8 × 1			OH2	100	15	37	6.2		100	22	37	6.2		—	●	26
8320532	M 10 × 1.5			OH3	150	18	41	7		150	24	41	7		—	●	50
8320536	M 10 × 1.25				150	18	41	7		150	24	41	7		—	●	50
8320540	M 10 × 1			OH2	150	18	41	7		150	24	41	7		—	●	50
8320543	M 12 × 1.75			OH3	150	21	48	8.5		150	29	48	8.5		—	●	70
8320547	M 12 × 1.5				150	21	48	8.5		150	29	48	8.5		—	●	70
8320551	M 12 × 1.25				150	21	48	8.5		150	29	48	8.5		—	●	72
8320555	M 12 × 1			OH2	150	21	48	8.5		150	29	48	8.5		—	●	71

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。
4. 新形状逐步取代旧形状。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
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加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
LT-SC-SFT		○																○	○	○						

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1169

V涂层粉末高速钢

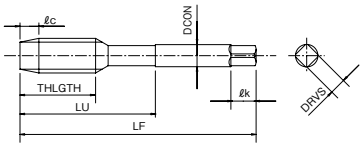
V COATED · POWDER METALLURGY H.S.S

VP-SFT

CPM | V | 45°

最适合 35~42HRC 合金钢、预硬钢的加工。

Best choice for machining pre-hardened material with hardness HRC35-42.



螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8319269	M 3 ×0.5	STD	OH2	2.5P	46	3.5	19	4	3	—	●	4
8319283	M 4 ×0.7				52	4.9	21	5		Yes	●	7
8319290	M 5 ×0.8				60	5.6	24	5.5		Yes	●	10
8319297	M 6 ×1				62	7	29	6		Yes	●	12
8319307	M 8 ×1.25	STD	OH3		70	8.5	37	6.2		—	●	17

■ 突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8319317	M10 ×1.5	STD	OH3	2.5P	75	10.5	41	7	3	—	●	25
8319321	M10 ×1.25				75	10.5	41	7		—	●	25
8319330	M12 ×1.75				82	12	48	8.5		—	●	38
8319334	M12 ×1.5				82	12	48	8.5		—	●	38
8319337	M12 ×1.25				82	12	48	8.5		—	●	38

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **TH1093**

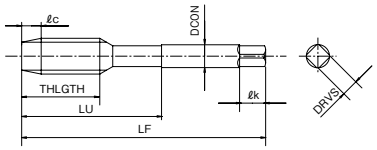
V涂层
V COATED

V-SFT

HSSE | V | 45°

适用范围广，尤其是在高速加工或使用稀释倍率大的水溶性切削液时的效果显著。

This tap is capable of a wide range of applications, on both soft or hard materials. It is particularly suited for high speed tapping (with a highly diluted water soluble oil).



螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8310234	M 1.4 × 0.3				34	9	—	3		—	▲	3
8310239	M 1.6 × 0.35				36	10	—	3		—	▲	3
8310244	M 1.7 × 0.35				36	11	—	3		—	▲	3
8310249	M 2 × 0.4	STD	OH1		40	2.8	16	3	2	—	▲	3
8310254	M 2.3 × 0.4				42	2.8	16	3		—	▲	3
8310259	M 2.5 × 0.45				44	3.2	16	3		—	▲	3
8310264	M 2.6 × 0.45				44	3.2	16	3		—	▲	3
8310269	M 3 × 0.5	STD	OH2		46	3.5	19	4		—	▲	5
8310270		STD+1	OH3							—	▲	4
8310276	M 3.5 × 0.6	STD	OH2	2.5P	48	4.2	20	4		Yes	▲	5
8310277		STD+1	OH3							Yes	▲	5
8310283	M 4 × 0.7	STD	OH2		52	4.9	21	5		Yes	▲	7
8310284		STD+1	OH3							Yes	▲	7
8310290	M 5 × 0.8	STD	OH2		60	5.6	24	5.5	3	Yes	▲	10
8310291		STD+1	OH3							Yes	▲	10
8310297	M 6 × 1	STD	OH2		62	7	29	6		Yes	▲	11
8310298		STD+1	OH3							Yes	▲	11
8310307	M 8 × 1.25	STD	OH3		70	8.5	37	6.2		—	▲	16
8310308		STD+1	OH4							—	▲	16
8310311	M 8 × 1	STD	OH2		70	8.5	37	6.2		—	▲	17
8310312		STD+1	OH3							—	▲	16

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

▲＝该产品已停止生产，由A-SFT(P.583)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8310317	M10 × 1.5	STD	OH3		75	10.5	41	7		—	▲	24
8310318		STD+1	OH4							—	▲	23
8310321	M10 × 1.25	STD	OH3		75	10.5	41	7		—	▲	24
8310322		STD+1	OH4							—	▲	23
8310324	M10 × 1	STD	OH3		75	10.5	41	7		—	▲	24
8310325		STD+1	OH4							—	▲	23
8310330	M12 × 1.75	STD	OH3		82	12	48	8.5		—	▲	37
8310331		STD+1	OH4							—	▲	36
8310334	M12 × 1.5	STD	OH3		82	12	48	8.5		—	▲	38
8310335		STD+1	OH4	2.5P					3	—	▲	37
8310337	M12 × 1.25	STD	OH3		82	12	48	8.5		—	▲	37
8310338		STD+1	OH4							—	▲	36
8310340	M12 × 1	STD	OH3		82	12	48	8.5		—	▲	38
8310341		STD+1	OH4							—	▲	37
8310347	M14 × 2				88	14	48	10.5		—	▲	61
8310350	M14 × 1.5				88	14	48	10.5		—	▲	62
8310357	M16 × 2	STD	OH3		95	14	52	12.5		—	▲	87
8310360	M16 × 1.5				95	14	52	12.5		—	▲	87
8310370	M18 × 1.5				100	17.5	55	14	4	—	▲	108

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-SFT(p.583).

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

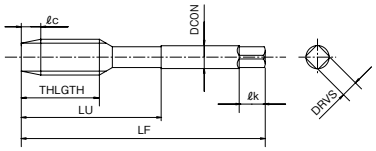
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1140

V涂层长柄型

V COATED · LONG SHANK

V-LT-SFT



HSSE | V | 45°

螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	刻痕尖 External Center	库存 Stock	重量 (g)
8316310	M 3 ×0.5	STD	OH2	2.5P	100	3.5	19	4	3	—	▲	11
8316313	M 4 ×0.7				100	4.9	21	5		Yes	▲	15
8316316	M 5 ×0.8				100	5.6	24	5.5		Yes	▲	18
8316319	M 6 ×1				100	7	29	6		Yes	▲	22
8316321					150					Yes	▲	32
8316323	M 8 ×1.25	STD	OH3		100	8.5	37	6.2		—	▲	24
8316325					150					—	▲	37
8316332	M10 ×1.5				150	10.5	41	7		—	▲	48
8316336	M10 ×1.25				150	10.5	41	7		—	▲	48
8316343	M12 ×1.75				150	12	48	8.5		—	▲	67
8316347	M12 ×1.5				150	12	48	8.5		—	▲	68

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	刻痕尖 External Center	库存 Stock	重量 (g)
8316351	M12 ×1.25	STD	OH3	2.5P	150	12	48	8.5	3	—	▲	69
8316358	M14 ×2				150	14	48	10.5		—	▲	98
8316362	M14 ×1.5				150	14	48	10.5		—	▲	100
8316365	M16 ×2				150	14	52	12.5		—	▲	138
8316369	M16 ×1.5				150	14	52	12.5		—	▲	140
8316372	M18 ×2.5				150	17.5	55	14	4	—	▲	173
8316381	M20 ×1.5				150	17.5	58	15		—	▲	203
8316384	M22 ×2.5	STD	OH4		200	17.5	63	17		—	▲	337
8316387	M22 ×1.5	STD	OH3		200	17.5	63	17		—	▲	341

■ 突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

▲＝该产品已停止生产，由A-LT-SFT(P.591)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-LT-SFT(p.591).

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **TH1180**

大径卧式加工中心用

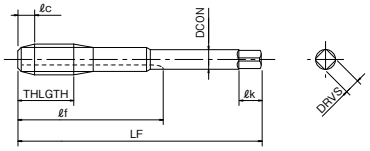
LARGE-DIAMETER TAPS FOR HORIZONTAL MACHINES

HXL-SFT

最适合卧式加工中心的大径螺纹加工。小螺旋角(15°)形状分断切屑。

Large-diameter taps for horizontal machines. Low spiral (15°) shape to break up chips.

HSSE | H | 15°



螺纹种类：M

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 ℓf	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8324062	**M 16 × 2**	STD	OH4	2.5P	110	16	60	12.5	4	●	99
8324064	**M 16 × 1.5**				100	16	50	12.5		●	95
8324070	**M 18 × 2.5**	STD	OH5		125	20	70	14		●	134
8324072	**M 18 × 1.5**	STD	OH4		110	20	55	14		●	119
8324078	**M 20 × 2.5**	STD	OH5		140	20	85	15		●	167
8324082	**M 20 × 1.5**	STD	OH4		125	20	70	15		●	159
8324086	**M 22 × 2.5**	STD	OH5		140	20	80	17		●	209
8324088	**M 22 × 1.5**	STD	OH4		125	20	65	17		●	198
8324090	**M 24 × 3**	STD	OH5		160	24	98	19	5	●	314
8324092	**M 24 × 1.5**	STD	OH4		140	24	78	19		●	293

■ 突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

单位 :mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 ℓf	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8324094	**M 27 × 3**	STD	OH5	2.5P	160	24	92	20	5	●	379
8324096	**M 27 × 1.5**	STD	OH4		140	24	72	20		●	352
8324098	**M 30 × 3.5**	STD	OH5		180	28	110	23		●	534
8324100	**M 30 × 1.5**	STD	OH4		150	28	80	23		●	470
8324107	**M 33 × 3.5**	STD	OH5		180	28	105	25		●	642
8324111	**M 36 × 4**	STD	OH6		200	32	120	28		●	868
8324118	**M 39 × 4**				200	32	115	30		●	1,022
8324125	**M 42 × 4.5**				200	36	110	32	6	●	1,228
8324133	**M 48 × 5**				250	40	155	38		●	2,083
8324142	**M 56 × 5.5**	STD	OH8		250	44	140	44		●	2,896

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

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

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

△ = 停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1181

大径立式加工中心用

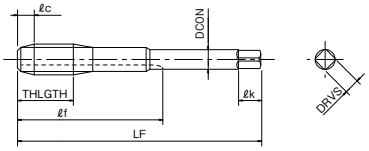
LARGE-DIAMETER TAPS FOR VERTICAL MACHINES

VXL-SFT

立式加工机大径螺纹加工适用。大螺旋(35°, 45°)形状，可以顺畅排出切屑。

Large-diameter taps for vertical machines. High spiral (35°, 45°) shape to smoothly discharge continuous chips.

HSSE | H | 35~45°



螺纹种类：M

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 ℓf	柄径 DCON	槽数 NOF	螺旋角 FHA	库存 Stock	重量 (g)
8324362	M 16 × 2	STD	OH4	2.5P	110	16	60	12.5	4	45°	●	100
8324364	M 16 × 1.5				100	16	50	12.5		45°	▲	95
8324370	M 18 × 2.5	STD	OH5		125	20	70	14		45°	●	130
8324372	M 18 × 1.5		OH4		110	20	55	14		45°	▲	119
8324378	M 20 × 2.5	STD	OH5		140	20	85	15		45°	●	166
8324382	M 20 × 1.5		OH4		125	20	70	15		45°	▲	158
8324386	M 22 × 2.5	STD	OH5		140	20	80	17		45°	●	210
8324388	M 22 × 1.5		OH4		125	20	65	17		45°	▲	199
8324390	M 24 × 3	STD	OH5		160	24	98	19		45°	●	288
8324392	M 24 × 1.5		OH4		140	24	78	19		45°	▲	276

■ 突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

▲＝该产品已停止生产，由A-SFT(P.583)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 ℓf	柄径 DCON	槽数 NOF	螺旋角 FHA	库存 Stock	重量 (g)
8324394	M 27 × 3	STD	OH5	2.5P	160	24	92	20	4	35°	●	350
8324396	M 27 × 1.5	STD	OH4		140	24	72	20		35°	▲	325
8324398	M 30 × 3.5	STD	OH5		180	28	110	23	5	35°	●	514
8324400	M 30 × 1.5	STD	OH4		150	28	80	23		35°	▲	458
8324407	M 33 × 3.5	STD	OH5		180	28	105	25		35°	●	636
8324411	M 36 × 4	STD	OH6		200	32	120	28		35°	●	844
8324418	M 39 × 4				200	32	115	30		35°	●	1,000
8324425	M 42 × 4.5				200	36	110	32		35°	●	1,140
8324433	M 48 × 5				250	40	155	38		35°	●	1,940
8324442	M 56 × 5.5	STD	OH8		250	44	140	44		35°	●	2,666

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-SFT(p.583).

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1087

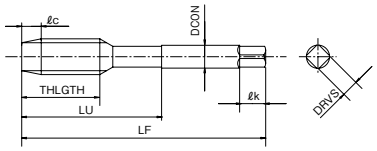
TiN涂层

TiN COATED

TIN-SFT

适用于攻丝深度为2D以下，适用于使用水溶性切削油剂进行低・中碳素钢的攻丝。

This tap is suitable for tapping depths less than 2D, in low-medium carbon steels and stainless steels. Requires water soluble lubricant.



HSSE | TiN | 45°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10900	M 1.4×0.3	STD	OH1	2.5P	34	9	—	3	2	—	●	3
10901	M 1.6×0.35				36	10	—	3		—	●	3
10902	M 1.7×0.35				36	11	—	3		—	●	3
10903	M 2 ×0.4				40	2.8	16	3		—	●	3
10905	M 2.3×0.4				42	2.8	16	3		—	●	3
10907	M 2.5×0.45				44	3.2	16	3		—	●	3
10909	M 2.6×0.45				44	3.2	16	3		—	●	3
10911	M 3 ×0.5	STD	OH2		46	3.5	19	4		—	●	4
10912	M 3.5×0.6				48	4.2	20	4		Yes	●	4
10913		STD-1	OH1							Yes	●	5
10914	M 4 ×0.7	STD	OH2		52	4.9	21	5		Yes	●	7
10917	M 5 ×0.8				60	5.6	24	5.5	3	Yes	●	10
10919	M 5 ×0.5				60	5.6	24	5.5		Yes	●	10
10920	M 6 ×1				62	7	29	6		Yes	●	11
10921	M 6 ×0.75				62	7	29	6		Yes	●	12
10922	M 7 ×1				65	7	33	6.2		—	●	14

■突顶尖长・柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

▲＝该产品已停止生产，由A-SFT(P.583)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10923	M 8 ×1.25	STD	OH3	2.5P	70	8.5	37	6.2	3	—	●	16
10924	M 8 ×1	STD	OH2		70	8.5	37	6.2		—	●	16
10926	M10 ×1.5	STD	OH3		75	10.5	41	7		—	●	23
10929	M10 ×1.25				75	10.5	41	7		—	●	24
10930	M10 ×1	STD	OH2		75	10.5	41	7		—	●	24
10931	M10 ×0.75				75	10.5	41	7		—	●	24
10932	M12 ×1.75	STD	OH3		82	12	48	8.5		—	●	36
10935	M12 ×1.5	STD	OH3		82	12	48	8.5		—	●	37
10938	M12 ×1.25				82	12	48	8.5		—	●	37
10939	M12 ×1	STD	OH2		82	12	48	8.5		—	●	37
10945	M14 ×2	STD	OH3		88	14	48	10.5		—	●	61
10947	M14 ×1.5				88	14	48	10.5		—	●	61
10951	M16 ×2				95	14	52	12.5		—	●	86
10953	M16 ×1.5				95	14	52	12.5		—	●	86
10987	M33 ×3.5	STD	OH4		145	24.5	77	25	4	—	▲	468

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-SFT(p.583).

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

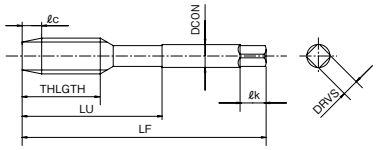
G-LIST No. | TH1079

TiN涂层长柄型

TiN COATED · LONG SHANK

TIN-LT-SFT

HSSE | TiN | 45°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78910	M 3 ×0.5	STD	OH2	2.5P	100	3.5	19	4	3	—	●	11
78913	M 4 ×0.7	STD	OH2	2.5P	100	4.9	21	5	3	Yes	●	15
78916	M 5 ×0.8	STD	OH2	2.5P	100	5.6	24	5.5	3	Yes	●	19
78919	M 6 ×1	STD	OH2	2.5P	100	7	29	6	3	Yes	●	23
78921	M 6 ×1	STD	OH2	2.5P	150	7	29	6	3	Yes	●	32
78923	M 8 ×1.25	STD	OH3	2.5P	100	8.5	37	6.2	3	—	●	25
78925	M 8 ×1.25	STD	OH3	2.5P	150	8.5	37	6.2	3	—	●	37
78932	M10 ×1.5	STD	OH3	2.5P	150	10.5	41	7	3	—	●	49
78936	M10 ×1.25	STD	OH3	2.5P	150	10.5	41	7	3	—	●	48
78943	M12 ×1.75	STD	OH3	2.5P	150	12	48	8.5	3	—	●	68
78947	M12 ×1.5	STD	OH3	2.5P	150	12	48	8.5	3	—	●	68

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

▲=该产品已停止生产，由A-LT-SFT(P.591)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78951	M12 ×1.25	STD	OH3	2.5P	150	12	48	8.5	3	—	●	68
78958	M14 ×2	STD	OH3	2.5P	150	14	48	10.5	3	—	●	98
78962	M14 ×1.5	STD	OH3	2.5P	150	14	48	10.5	3	—	●	98
78965	M16 ×2	STD	OH3	2.5P	150	14	52	12.5	3	—	●	136
78969	M16 ×1.5	STD	OH3	2.5P	150	14	52	12.5	3	—	●	138
78972	M18 ×2.5	STD	OH3	2.5P	150	17.5	55	14	4	—	▲	174
78984	M22 ×2.5	STD	OH4	2.5P	200	17.5	63	17	4	—	▲	335
78987	M22 ×1.5	STD	OH3	2.5P	200	17.5	63	17	4	—	▲	337
78993	M24 ×1.5	STD	OH3	2.5P	200	21	66	19	4	—	▲	410

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-LT-SFT(p.591).

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

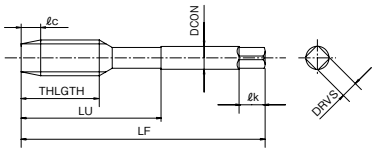
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

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

难加工材料用
FOR DIFFICULT TO MACHINE MATERIALS

CPM-SFT



CPM	15°	35°	40°
	M3～	M1.4～1.7	M2～2.6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22250	M 1.4×0.3	STD	OH1	3P	34	6	—	3	2	—	●	3
22252	M 1.6×0.35	STD	OH2		36	7	—	3		—	●	3
22254	M 1.7×0.35				36	8	—	3		—	●	3
22256	M 2 ×0.4				40	9	—	3		—	●	3
22258	M 2.5×0.45				44	11	—	3		—	●	3
22260	M 2.6×0.45				44	11	—	3		—	●	3
22262	M 3 ×0.5	STD	OH3		46	11	19	4	3	—	●	4
22270	M 4 ×0.7				52	13	21	5		Yes	●	7
22276	M 5 ×0.8				60	16	24	5.5		Yes	●	10
22280	M 6 ×1				62	19	29	6		Yes	●	12
22288	M 8 ×1.25				70	22	37	6.2		—	●	18
22296	M10 ×1.5				75	24	41	7		—	●	26
22300	M10 ×1.25				75	24	41	7		—	●	26
22316	M12 ×1.75				82	29	48	8.5		—	●	41
22320	M12 ×1.5				82	29	48	8.5		—	●	42
22324	M12 ×1.25	STD	OH4		82	29	48	8.5		—	●	42
22328	M14 ×2				88	30	48	10.5		—	●	60
22332	M14 ×1.5	STD	OH3		88	30	48	10.5		—	●	64

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22336	M16 ×2	STD	OH4	3P	95	32	52	12.5	3	—	●	90
22340	M16 ×1.5	STD	OH3		95	32	52	12.5		—	●	90
22344	M18 ×2.5	STD	OH4		100	37	55	14	4	—	●	110
22348	M18 ×1.5				100	37	55	14		—	●	110
22352	M20 ×2.5				105	37	58	15		—	●	135
22356	M20 ×1.5				105	37	58	15		—	●	136
22360	M22 ×2.5				115	38	63	17		—	●	183
22364	M22 ×1.5				115	38	63	17		—	●	185
22368	M24 ×3				120	45	66	19		—	●	233
22372	M24 ×1.5				120	45	66	19		—	●	237
22376	M27 ×3				130	45	71	20		—	●	303
22380	M27 ×1.5				130	45	71	20		—	●	311
22384	M30 ×3.5				135	48	74	23		—	●	396
22388	M30 ×1.5				135	48	74	23		—	●	410
22390	M33 ×3.5				145	51	77	25		—	●	523
22393	M36 ×4	STD	OH5		155	57	82	28		—	●	690
22396	M42 ×4.5				175	60	93	32		—	●	1,016
22399	M48 ×5				185	67	98	38		—	●	1,471

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

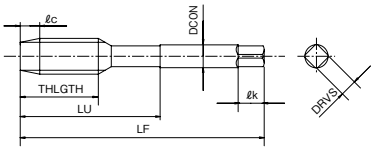
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1067

难加工材料用 长柄型

LONG SHANK· FOR DIFFICULT TO MACHINE MATERIALS

CPM-LT-SFT



CPM | 15°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78710	M 3 ×0.5	STD	0H3	3P	100	11	19	4	3	—	●	11
78713	M 4 ×0.7				100	13	21	5		Yes	●	16
78716	M 5 ×0.8				100	16	24	5.5		Yes	●	19
78719	M 6 ×1				100	19	29	6		Yes	●	23
78721					150					Yes	●	33
78723	M 8 ×1.25				100	22	37	6.2		—	●	26
78725					150					—	●	39
78732	M10×1.5				150	24	41	7		—	●	50
78736	M10×1.25				150	24	41	7		—	●	51
78743	M12×1.75				150	29	48	8.5		—	●	73
78747	M12×1.5				150	29	48	8.5		—	●	74
78751	M12×1.25	STD	0H4		150	29	48	8.5		—	●	73

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78758	M14×2	STD	0H4	3P	150	30	48	10.5	3	—	●	102
78762	M14×1.5	STD	0H3		150	30	48	10.5		—	●	103
78765	M16×2	STD	0H4		150	32	52	12.5		—	●	142
78769	M16×1.5	STD	0H3		150	32	52	12.5		—	●	141
78772	M18×2.5	STD	0H4		150	37	55	14	4	—	●	175
78775	M18×1.5				150	37	55	14		—	●	177
78778	M20×2.5				150	37	58	15		—	●	204
78781	M20×1.5				150	37	58	15		—	●	204
78785	M22×2.5				200	38	63	17		—	●	344
78788	M22×1.5				200	38	63	17		—	●	347
78791	M24×3				200	45	66	19		—	●	428
78794	M24×1.5				200	45	66	19		—	●	429

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | **TH1174**

不锈钢用(水溶性切削油剂对应型)

FOR STAINLESS STEELS (WITH WATER SOLUBLE COOLANT TYPE)

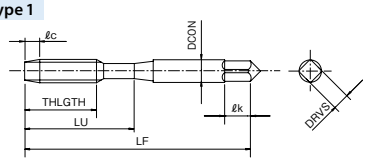
CC-SUS-SFT

切削条件 Cutting Conditions | P.841

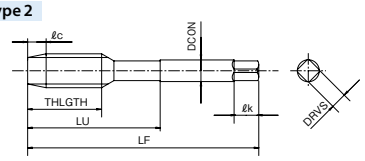
实现使用水溶性切削油剂加工不锈钢内螺纹。
Able to tap stainless steel with water soluble coolant.

HSSE	TiN	CrN	47°	45°
	≦M6	M6<	≦M6	M6<

M2～M6(2槽) Flutes — **Type 1**



M8(3槽)～ Flutes — **Type 2**



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	形状类型 Type	库存 Stock	重量 (g)
8320608	M2 × 0.4	STD	OH1	2.5P	40	4	16	3	2	–	1	●	3
8320611	M2.5 × 0.45	STD	OH2		44	4.5	16	3		–	1	●	3
8320614	M2.6 × 0.45				44	4.5	16	3		–	1	●	3
8320617	M3 × 0.5	STD	OH3		46	5	19	4		–	1	●	4
8320620	M4 × 0.7				52	7	21	5		–	1	●	7
8320623	M5 × 0.8				60	8	24	5.5		–	1	●	10
8320626	M6 × 1				62	10	29	6		–	1	●	12
8320627		STD+1	OH4		62	10	29	6		–	1	●	11
8320628	M8 × 1.25	STD	OH3		70	13	37	6.2	3	–	2	●	16
8320629		STD+1	OH4		70	13	37	6.2		–	2	▲	16
8320632	M10 × 1.5	STD	OH3		75	15	41	7		–	2	●	23
8320633		STD+1	OH4		75	15	41	7		–	2	▲	23
8320638	M12 × 1.75	STD	OH3		82	18	48	8.5		–	2	●	37
8320639		STD+1	OH4		82	18	48	8.5		–	2	▲	36
8320655	M16 × 2	STD	OH3		95	20	52	12.5		–	2	●	86
8320656		STD+2	OH5		95	20	52	12.5		–	2	▲	86
8320667	M20 × 2.5	STD	OH3		105	25	58	15	4	–	2	●	134
8320668		STD+2	OH5		105	25	58	15		–	2	▲	136
8320679	M24 × 3	STD	OH4		120	30	66	19		–	2	●	233
8320680		STD+1	OH5		120	30	66	19		–	2	▲	235

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲＝该产品已停止生产，由 A-SFT(P.583) 替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-SFT(p.583).

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
CC-SUS-SFT	**M2 ～ M6(2槽)**																								
	○	○		◎					◎																
	M8(3槽)～																								
		○							◎																

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

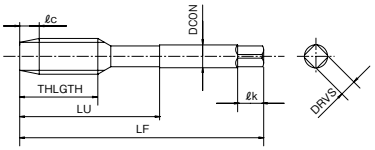
■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1027

不锈钢用
FOR STAINLESS STEELS

EX-SUS-SFT

适用于不锈钢、铜、热加塑性塑料的盲孔加工。
Suitable for tapping blind holes in materials such as stainless steels, copper and thermo plastic.



HSSE | H | 45° ≦M24 | 35° M27≦

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24101	M 2 × 0.4	STD	OH1	2.5P	40	12	–	3	2	–	●	3
24104	M 2.3 × 0.4				42	13	–	3		–	●	3
24105	M 2.5 × 0.45		OH2		44	14	–	3		–	●	3
24107	M 2.6 × 0.45				44	14	–	3		–	●	3

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24110	M 3 × 0.6	2.5P	STD	OH2	46	6	19	4	OH2	46	11	19	4	3	–	●	5
15111	M 3 × 0.5				46	6	19	4		46	11	19	4		–	●	4
24113			STD+2	OH4					OH4						–	●	5
24114	M 3.5 × 0.6		STD	OH2	48	7.2	20	4	OH2	48	13	20	4		Yes	●	5
24115	M 4 × 0.75				52	8.4	21	5		52	13	21	5		Yes	●	8
15116	M 4 × 0.7				52	8.4	21	5		52	13	21	5		Yes	●	7
24118			STD+2	OH4					OH4						Yes	●	7
24119	M 5 × 0.9		STD	OH2	60	9.6	24	5.5	OH2	60	16	24	5.5		Yes	●	10
15120	M 5 × 0.8				60	9.6	24	5.5		60	16	24	5.5		Yes	●	10
24122			STD+2	OH4					OH4						Yes	●	10
15124	M 6 × 1		STD	OH2	62	12	29	6	OH2	62	19	29	6		Yes	●	12
24126			STD+2	OH4					OH4						Yes	●	12
15132	M 8 × 1.25		STD	OH3	70	15	37	6.2	OH3	70	22	37	6.2		–	●	17
24133			STD+2	OH5					OH5						–	●	17
24134	M 8 × 1		STD	OH2	70	15	37	6.2	OH2	70	22	37	6.2		–	●	18
15142	M 10 × 1.5			OH3	75	18	41	7	OH3	75	24	41	7		–	●	26
24143			STD+2	OH5					OH5						–	●	25
15144	M 10 × 1.25		STD	OH3	75	18	41	7	OH3	75	24	41	7		–	●	26
24145			STD+2	OH5					OH5						–	●	26
24146	M 10 × 1		STD	OH2	75	18	41	7	OH2	75	24	41	7		–	●	26
15154	M 12 × 1.75			OH3	82	21	48	8.5	OH3	82	29	48	8.5		–	●	39
24155			STD+2	OH5					OH5						–	●	40
24156	M 12 × 1.5		STD	OH3	82	21	48	8.5	OH3	82	29	48	8.5		–	●	40
24157			STD+2	OH5					OH5						–	●	40
24158	M 12 × 1.25		STD	OH3	82	21	48	8.5	OH3	82	29	48	8.5		–	●	41
24159			STD+2	OH5					OH5						–	●	41
24160	M 12 × 1		STD	OH2	82	21	48	8.5	OH2	82	29	48	8.5		–	●	41

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。
5. 新形状逐步取代旧形状。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

※ Stable feed control machines are recommended to avoid over size tapping.

下一页
尺寸 Size M14 ～ M42 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

上一页

FROM 尺寸 Size M2 ~ M12

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24168	M 14 × 2	STD	OH3	2.5P	88	30	48	10.5	3	—	●	64
24169		STD+2	OH5							—	●	65
24170	M 14 × 1.5	STD	OH3		88	30	48	10.5		—	●	65
24172		STD+2	OH5							—	●	65
24176	M 16 × 2	STD	OH3		95	32	52	12.5		—	●	90
24177		STD+2	OH5							—	●	92
24178	M 16 × 1.5	STD	OH3		95	32	52	12.5		—	●	92
24180		STD+2	OH5							—	●	92
24184	M 18 × 2.5	STD	OH3		100	37	55	14	4	—	●	111
24185		STD+2	OH5							—	●	111
24186	M 18 × 1.5	STD	OH3		100	37	55	14		—	●	112
24188		STD+2	OH5							—	●	112
24192	M 20 × 2.5	STD	OH3		105	37	58	15		—	●	137
24194		STD+2	OH5							—	●	137
24196	M 20 × 1.5	STD	OH3		105	37	58	15		—	●	139
24197		STD+2	OH5							—	●	138
24198	M 22 × 2.5	STD	OH4		115	38	63	17		—	●	185
24199		STD+2	OH6							—	●	191
24200	M 22 × 1.5	STD	OH3		115	38	63	17		—	●	188
24201		STD+2	OH5							—	●	188
24202	M 24 × 3	STD	OH4		120	45	66	19		—	●	239
24203		STD+2	OH6							—	●	237
24204	M 24 × 1.5	STD	OH3		120	45	66	19		—	●	239
24205		STD+2	OH5							—	●	240
24206	M 27 × 3	STD	OH4		130	45	71	20		—	●	321
24207	M 27 × 1.5		OH3		130	45	71	20		—	▲	319
24208	M 30 × 3.5		OH4		135	48	74	23		—	●	411
24209	M 30 × 1.5		OH3		135	48	74	23		—	▲	420
24961	M 33 × 3.5		OH4		145	51	77	25		—	●	534
24963	M 33 × 1.5		OH3		110	37	47	25		—	▲	406
24965	M 36 × 4		OH4	3P	155	57	82	28		—	●	667
24967	M 36 × 1.5		OH3		110	39	49	28		—	▲	486
24969	M 42 × 4.5		OH4		175	60	93	32		—	●	979
24971	M 42 × 1.5		OH3		120	39	49	32		—	▲	714

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

▲=该产品已停止生产，由A-SFT(P.583)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-SFT(p.583).

※ Stable feed control machines are recommended to avoid over size tapping.

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1027

不锈钢用
FOR STAINLESS STEELS

EX-SUS-SFT

适用于不锈钢,铜、热可塑性塑料的盲孔加工。
Suitable for tapping blind holes in materials such as stainless steels, copper and thermo plastic.

HSSE | H | 45°

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15302	No. 4 - 40UNC	2.5P	STD	OH2	44	7.7	17	3	OH2	44	15	—	3	2	—	●	4
15303	No. 4 - 48UNF				44	7.7	17	3		44	15	—	3		—	●	3
15306	No. 5 - 40UNC				46	7.7	19	4		46	11	19	4	3	Yes	●	5
15307	No. 5 - 44UNF				46	7.7	19	4		46	11	19	4		Yes	●	5
15310	No. 6 - 32UNC				48	9.6	21	4		48	13	21	4		Yes	●	5
15311	No. 6 - 40UNF				48	9.6	21	4		48	13	21	4		Yes	●	5
15314	No. 8 - 32UNC				52	9.6	21	5		52	13	21	5		Yes	●	7
15315	No. 8 - 36UNF				52	9.6	21	5		52	13	21	5		Yes	●	7
15318	No. 10 - 24UNC				60	12.7	24	5.5		60	16	24	5.5		Yes	●	10
15319	No. 10 - 32UNF				60	12.7	24	5.5		60	16	24	5.5		Yes	●	10
15325	1/4 - 20UNC			OH3	62	15.3	29	6	OH3	62	19	29	6		Yes	●	12
15326	1/4 - 28UNF			OH2	62	15.3	29	6	OH2	62	19	29	6		Yes	●	12
15329	5/16 - 18UNC			OH3	70	17	37	6.1	OH3	70	22	37	6.1		—	●	17
15330	5/16 - 24UNF			OH2	70	17	37	6.1	OH2	70	22	37	6.1		—	●	17
15333	3/8 - 16UNC			OH3	75	19	41	7	OH3	75	24	41	7		—	●	24
15334	3/8 - 24UNF			OH2	75	19	41	7	OH2	75	24	41	7		—	●	25
15337	7/16 - 14UNC			OH3	80	22	48	8	OH3	80	25	48	8		—	●	34
15338	7/16 - 20UNF				80	22	48	8		80	25	48	8		—	●	35
15342	1/2 - 13UNC				85	23	48	9		85	29	48	9		—	●	47
15345	1/2 - 20UNF				85	23	48	9		85	29	48	9		—	●	49

1. 新形状逐步取代旧形状。

1. Conventional dimension is replaced with new one accordingly.

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15348	5/8 - 11UNC	STD	OH3	2.5P	95	32	52	12	3	—	●	85
15349	5/8 - 18UNF				95	32	52	12		—	●	90
15352	3/4 - 10UNC				105	37	58	14	4	—	●	122
15353	3/4 - 16UNF				105	37	58	14		—	●	126
15356	7/8 - 9UNC		OH4		115	38	63	17		—	●	186
15357	7/8 - 14UNF		OH3		115	38	63	17		—	●	190
15360	1 - 8UNC		OH4		125	45	68	20		—	●	280
15361	1 - 12UNF		OH3		125	45	68	20		—	●	285

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2B 内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月之前生产的NO.4以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. Taps of No.4 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ Stable feed control machines are recommended to avoid over size tapping.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

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

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

△＝停产产品(请确认库存。)
Discontinued item

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

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

HSSE　H　45°

螺纹种类：W

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24471	W 1/8 - 40	STD	OH2	2.5P	46	11	19	4	3	Yes	●	4
24472	W 3/16 - 24				60	16	24	5.5		Yes	●	10
24473	W 1/4 - 20				62	19	29	6		Yes	●	13
24474	W 5/16 - 18		OH3		70	22	37	6.1		—	●	16
24475	W 3/8 - 16				75	24	41	7		—	●	24
24477	W 1/2 - 12				85	29	48	9		—	●	46
24479	W 5/8 - 11				95	32	52	12		—	●	84
24480	W 3/4 - 10				105	37	58	14	4	—	●	122
24481	W 7/8 - 9		OH4		115	38	63	17		—	●	186
24482	W 1 - 8				125	45	68	20		—	●	279

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ Stable feed control machines are recommended to avoid over size tapping.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

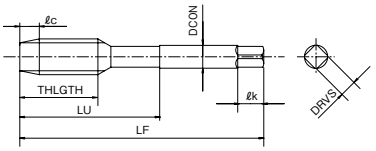
G-LIST No. | TH1035

不锈钢用 长柄型

LONG SHANK· FOR STAINLESS STEELS

EX-LT-SUS-SFT

HSSE | H | 45°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15901	M 3 × 0.5	2.5P	STD	OH2	100	6	19	4	OH2	100	11	19	4	3	–	●	11
15903					150					150					–	●	15
15905	M 4 × 0.7				100	8.4	21	5		100	13	21	5		Yes	●	16
15907					150					150					Yes	●	23
15909	M 5 × 0.8				100	9.6	24	5.5		100	16	24	5.5		Yes	●	18
15911					150					150					Yes	●	28
15913	M 6 × 1				100	12	29	6		100	19	29	6		Yes	●	23
15915					150					150					Yes	●	32
15918	M 8 × 1.25			OH3	100	15	37	6.2	OH3	100	22	37	6.2		–	●	25
15920					150					150					–	●	38
15927	M10 × 1.5				100	18	41	7		100	24	41	7		–	●	34
15929					150					150					–	●	50
15932	M10 × 1.25				100	18	41	7		100	24	41	7		–	●	34
15934					150					150					–	●	51
15943	M12 × 1.75				150	21	48	8.5		150	29	48	8.5		–	●	70
15944					200					200					–	△	93
15948	M12 × 1.5				150	21	48	8.5		150	29	48	8.5		–	●	71
15949					200					200					–	△	94
15953	M12 × 1.25				150	21	48	8.5		150	29	48	8.5		–	●	72
15954					200					200					–	△	94

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。
5. 新形状逐步取代旧形状。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
5. Conventional dimension is replaced with new one accordingly.

※ Stable feed control machines are recommended to avoid over size tapping.

下一页
尺寸 Size M14 ～ M24 NEXT

库存记号 Inventory symbols

●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

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

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

上一页

FROM 尺寸 Size M3 ~ M12

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15960	M 14 × 2	STD	OH3	2.5P	150	30	48	10.5	3	–	●	102
15961					200					–	△	135
15964	M 14 × 1.5				150	30	48	10.5		–	●	103
15965					200					–	△	137
15967	M 16 × 2				150	32	52	12.5		–	●	142
15968					200					–	△	188
15971	M 16 × 1.5				150	32	52	12.5		–	●	141
15972					200					–	△	191
15974	M 18 × 2.5				150	37	55	14	4	–	●	176
15975					200					–	△	236
15977	M 18 × 1.5				150	37	55	14		–	●	177
15978					200					–	△	266
15980	M 20 × 2.5				150	37	58	15		–	●	204
15981					200					–	△	274
15983	M 20 × 1.5				150	37	58	15		–	●	206
15984					200					–	△	279
15986	M 22 × 2.5		OH4		150	38	63	17		–	●	257
15987					200					–	△	342
15989	M 22 × 1.5		OH3		150	38	63	17		–	●	253
15990					200					–	△	345
15992	M 24 × 3		OH4		150	45	66	19		–	●	312
15993					200					–	△	424
15995	M 24 × 1.5		OH3		150	45	66	19		–	●	312
15996					200					–	△	422

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

※ Stable feed control machines are recommended to avoid over size tapping.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

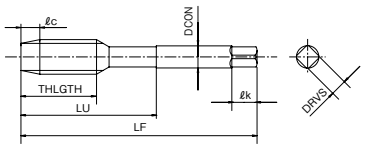
G-LIST No. | TH1167

不锈钢·深孔用
FOR STAINLESS AND DEEP HOLES

SUS-DH-SFT

最适合加工超过2D的不锈钢深孔加工。
Best for stainless steel over 2D deep hole drilling.

HSSE | H | 45~49°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8301402	M 2 ×0.4	STD	OH1	2.5P	40	12	—	3	2	—	●	3
8301411	M 2.5 ×0.45	STD	OH2		44	14	—	3		—	●	4
8301416	M 2.6 ×0.45				44	14	—	3		—	●	4
8301422	M 3 ×0.5				46	5	19	4		—	●	4
8301426	M 4 ×0.7				52	7	21	5	3	Yes	●	7
8301430	M 5 ×0.8				60	8	24	5.5		Yes	●	10
8301434	M 6 ×1				62	10	29	6		Yes	●	12

■突顶尖长·柄部四方部尺寸ℓk，DRVS请参考P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。
▲=该产品已停止生产，由EX-SUS-SFT(P.631)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8301438	M 8 ×1.25	STD	OH3	2.5P	70	13	37	6.2	3	—	●	16
8301442	M10 ×1.5				75	15	41	7		—	●	24
8301444	M10 ×1.25				75	15	41	7		—	▲	25
8301448	M12 ×1.75				82	18	48	8.5		—	●	39
8301451	M12 ×1.5				82	18	48	8.5		—	▲	39
8301454	M12 ×1.25				82	18	48	8.5		—	▲	39

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
▲=The products have been stopped producing and replaced by EX-SUS-SFT(p.631).

※ Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

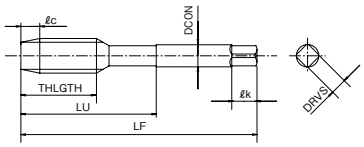
■记号说明请参考P1页。 See p.1 for explanation of icons.

不锈钢·深孔用长柄型

LONG SHANK· FOR STAINLESS STEELS AND DEEP HOLES

LT-SUS-DH-SFT

HSSE | H | 45~49°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8302211	M 2 X0.4 X100	STD	OH1	2.5P	100	12	—	3	2	—	△	7
8302219	M 2.5X0.45 X100	STD	OH2	2.5P	100	14	—	3	2	—	△	8
8302223	M 2.6X0.45 X100	STD	OH2	2.5P	100	14	—	3	2	—	△	8
8302232	M 3 X0.5 X120	STD	OH2	2.5P	120	5	59	4	2	—	△	9
8302236	M 4 X0.7 X120	STD	OH2	2.5P	120	7	60	5	3	Yes	△	13
8302240	M 5 X0.8 X120	STD	OH2	2.5P	120	8	61	5.5	3	Yes	△	18
8302244	M 6 X1 X120	STD	OH2	2.5P	120	10	62	6	3	Yes	△	21

■突顶尖长·柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

▲=该产品已停止生产，由EX-LT-SUS-SFT(P.635)替代。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8302250	M 8 X1.25 X150	STD	OH3	2.5P	150	13	63	6.2	3	—	▲	35
8302259	M10 X1.5 X150	STD	OH3	2.5P	150	15	65	7	3	—	▲	47
8302264	M10 X1.25 X150	STD	OH3	2.5P	150	15	65	7	3	—	▲	47
8302273	M12 X1.75 X150	STD	OH3	2.5P	150	18	68	8.5	3	—	▲	69
8302278	M12 X1.5 X150	STD	OH3	2.5P	150	18	68	8.5	3	—	▲	70
8302283	M12 X1.25 X150	STD	OH3	2.5P	150	18	68	8.5	3	—	▲	70

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by EX-LT-SUS-SFT (p.635).

※Stable feed control machines are recommended to avoid over size tapping.

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

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1019

软钢·深孔用

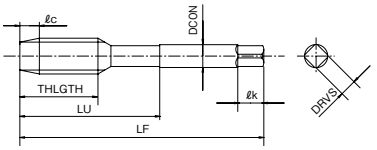
FOR MILD STEELS AND DEEP HOLES

MS-DH-SFT

HSSE | H | 35~51°

用于加工盲孔，可有效地防止切屑堵塞造成的丝锥损伤及内螺纹划伤。

This tap is suitable for tapping blind holes. The design reduces damage caused by chip packing and minimizes the problem of galling.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19586	M 2 × 0.4	STD	OH1	2.5P	40	4	16	3	2	—	●	3
19596	M 2.3 × 0.4				42	4	16	3		—	●	3
19601	M 2.5 × 0.45				44	4.5	16	3		—	●	3
19606	M 2.6 × 0.45				44	4.5	16	3		—	●	4
19612	M 3 × 0.5				46	5	19	4		—	●	4
19614	M 3.5 × 0.6				48	6	20	4		Yes	●	5
19616	M 4 × 0.7				52	7	21	5		Yes	●	7
19620	M 5 × 0.8				60	8	24	5.5		Yes	●	10
19624	M 6 × 1				62	10	29	6		Yes	●	12
19628	M 8 × 1.25				70	13	37	6.2		—	●	17
19632	M10 × 1.5				75	15	41	7		—	●	25
19634	M10 × 1.25	STD	OH2		75	15	41	7	3	—	●	25
19638	M12 × 1.75				82	18	48	8.5		—	●	39
19641	M12 × 1.5				82	18	48	8.5		—	●	39
19644	M12 × 1.25				82	18	48	8.5		—	●	39
19654	M14 × 2				88	20	48	10.5		—	●	63
19656	M14 × 1.5				88	20	48	10.5		—	●	63
19662	M16 × 2				95	20	52	12.5		—	●	90
19664	M16 × 1.5				95	20	52	12.5		—	●	92

■突顶尖长·柄部四方部尺寸ℓk，DRVS 请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19670	M18 × 2.5	STD	OH3	2.5P	100	25	55	14	4	—	●	109
19672	M18 × 1.5	STD	OH2		100	25	55	14		—	●	113
19678	M20 × 2.5	STD	OH3		105	25	58	15		—	●	135
19682	M20 × 1.5	STD	OH2		105	25	58	15		—	●	139
19686	M22 × 2.5	STD	OH3		115	25	63	17		—	●	184
19688	M22 × 1.5	STD	OH2		115	25	63	17		—	●	187
19690	M24 × 3	STD	OH3		120	30	66	19		—	●	236
19692	M24 × 1.5	STD	OH2		120	30	66	19		—	●	241
19694	M27 × 3	STD	OH3		130	30	71	20		—	●	309
19696	M27 × 1.5	STD	OH2		130	30	71	20		—	●	313
19698	M30 × 3.5	STD	OH3		135	35	74	23		—	●	404
19700	M30 × 1.5	STD	OH2		135	35	74	23		—	●	418
19787	M33 × 3.5	STD	OH3		145	28	77	25		—	●	511
19789	M33 × 1.5				110	20	47	25		—	●	392
19791	M36 × 4	STD	OH4		155	32	82	28		—	●	642
19793	M36 × 1.5	STD	OH3		110	20	49	28		—	●	465
19795	M42 × 4.5	STD	OH4		175	36	93	32		—	●	957
19797	M42 × 1.5	STD	OH3		120	20	49	32		—	●	691

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

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

螺纹种类：U

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21801	No. 4 - 40UNC	STD	OH1	2.5P	44	6	16	3	2	—	△	4
21803	No. 4 - 48UNF				44	6	16	3		—	△	4
21805	No. 5 - 40UNC				46	6	19	4		Yes	△	5
21807	No. 5 - 44UNF				46	6	19	4		Yes	△	5
21809	No. 6 - 32UNC	STD	OH2		48	8	21	4	3	Yes	△	5
21811	No. 6 - 40UNF	STD	OH1		48	8	21	4		Yes	△	5
21813	No. 8 - 32UNC				52	8	21	5		Yes	△	8
21815	No. 8 - 36UNF	STD	OH2		52	8	21	5		Yes	△	8
21817	No.10 - 24UNC				60	11	24	5.5		Yes	△	10
21819	No.10 - 32UNF				60	11	24	5.5		Yes	△	10

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS请参考 P.1009。

1. 精度栏　是适合加工2B内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月之前生产 NO.4以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21825	1/4 - 20UNC	STD	OH2	2.5P	62	12	29	6	3	Yes	△	12
21827	1/4 - 28UNF				62	12	29	6		Yes	△	13
21829	5/16 - 18UNC				70	14	37	6.1		—	△	16
21831	5/16 - 24UNF				70	14	37	6.1		—	△	17
21833	3/8 - 16UNC				75	16	41	7		—	△	24
21835	3/8 - 24UNF				75	16	41	7		—	△	24
21837	7/16 - 14UNC				80	18	48	8		—	△	34
21839	7/16 - 20UNF				80	18	48	8		—	△	34
21841	1/2 - 13UNC				85	20	48	9		—	△	46
21843	1/2 - 20UNF				85	20	48	9		—	△	47

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. Taps of No.4 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

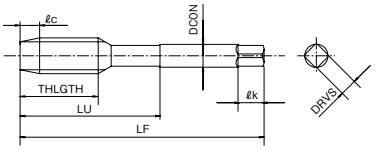
G-LIST No. | TH1096

软钢·深孔用长柄型

LONG SHANK· FOR MILD STEELS AND DEEP HOLES

LT-MS-DH-SFT

HSSE | H | 45°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13980	M 3 ×0.5	STD	OH2	2.5P	120	9	59	4	2	—	●	10
13982	M 4 ×0.7				120	10	60	5		Yes	●	13
13984	M 5 ×0.8				120	11	61	5.5		Yes	●	18
13986	M 6 ×1				120	12	62	6		Yes	●	21
13988	M 8 ×1.25				150	13	63	6.2		—	●	36
13990	M10 ×1.5				150	15	65	7	3	—	●	47
13992	M10 ×1.25				150	15	65	7		—	●	46
13994	M12 ×1.75				150	18	68	8.5		—	●	68
13996	M12 ×1.5				150	18	68	8.5		—	●	69
13998	M12 ×1.25				150	18	68	8.5		—	●	69
18772	M14 ×2				150	20	70	10.5		—	●	97

■突顶尖长·柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18776	M14 ×1.5	STD	OH2	2.5P	150	20	70	10.5	3	—	●	100
18779	M16 ×2				150	20	70	12.5		—	●	136
18783	M16 ×1.5				150	20	70	12.5		—	●	134
18786	M18 ×2.5	STD	OH3		150	25	75	14	4	—	●	166
18789	M18 ×1.5	STD	OH2		150	25	75	14		—	●	172
18792	M20 ×2.5	STD	OH3		150	25	75	15		—	●	195
18795	M20 ×1.5	STD	OH2		150	25	75	15		—	●	200
18799	M22 ×2.5	STD	OH3		200	25	75	17		—	△	333
18802	M22 ×1.5	STD	OH2		200	25	75	17		—	△	327
18805	M24 ×3	STD	OH3		200	30	80	19		—	△	412
18808	M24 ×1.5	STD	OH2		200	30	80	19		—	△	416

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

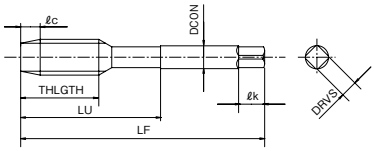
△=停产产品(请确认库存。) Discontinued item

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

非铁合金·深孔用

FOR NON-FERROUS METALS AND DEEP HOLES

EX-B-DH-SFT



HSSE | 45°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19041	M 3 ×0.5	STD	OH2	2.5P	46	5	19	4	2	—	▲	4
19056	M 4 ×0.7				52	7	21	5	3	Yes	▲	7
19071	M 5 ×0.8				60	8	24	5.5		Yes	▲	10
19083	M 6 ×1				62	10	29	6		Yes	▲	12
19101	M 8 ×1.25				70	13	37	6.2		—	▲	17
19121	M10 ×1.5				75	15	41	7		—	▲	25
19124	M10 ×1.25				75	15	41	7		—	▲	21
19150	M12 ×1.75				82	18	48	8.5		—	▲	39
19153	M12 ×1.5				82	18	48	8.5		—	▲	39
19156	M12 ×1.25				82	18	48	8.5		—	▲	40
19180	M14 ×2				88	20	48	10.5		—	▲	63
19183	M14 ×1.5				88	20	48	10.5		—	▲	64
19205	M16 ×2				95	20	52	12.5		—	▲	90

■突顶尖长·柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

▲=该产品已停止生产，由EX-AL-SFT(P.645)，EX-SFT(P.595)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19208	M16 ×1.5	STD	OH2	2.5P	95	20	52	12.5	4	—	▲	77
19230	M18 ×2.5	STD	OH3		100	25	55	14		—	▲	108
19235	M18 ×1.5	STD	OH2		100	25	55	14		—	▲	111
19246	M20 ×2.5	STD	OH3		105	25	58	15		—	▲	135
19250	M20 ×1.5	STD	OH2		105	25	58	15		—	▲	139
19256	M22 ×2.5	STD	OH3		115	25	63	17		—	▲	184
19260	M22 ×1.5	STD	OH2		115	25	63	17		—	▲	184
19266	M24 ×3	STD	OH3		120	30	66	19		—	▲	239
19270	M24 ×1.5	STD	OH2		120	30	66	19		—	▲	241
19281	M27 ×3	STD	OH3		130	30	71	20		—	▲	308
19285	M27 ×1.5	STD	OH2		130	30	71	20		—	▲	313
19291	M30 ×3.5	STD	OH3		135	35	74	23		—	▲	418
19298	M30 ×1.5	STD	OH2		135	35	74	23		—	▲	413

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by EX-AL-SFT (p.645) and EX-SFT (p.595).

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

库存记号 Inventory symbols

●=标准库存品 Standard stock item

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

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

△=停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1124

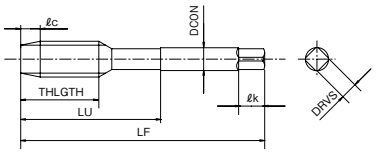
小螺旋角型

LOW SPIRAL

LW-SFT

小螺旋角可将切屑分断得很细并从后方排出，加工稳定，抗崩损性好。

The low spiral angle of this tap creates finely cut chips that are ejected smoothly out of the hole. The LW-SFT also has superior chipping resistance.



HSSE

15°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8301012	M 3 × 0.5	STD	OH2	2.5P	46	5	19	4	2	—	●	5
8301016	M 4 × 0.7				52	7	21	5		Yes	●	8
8301020	M 5 × 0.8				60	8	24	5.5		Yes	●	11
8301024	M 6 × 1				62	10	29	6		Yes	●	12
8301028	M 8 × 1.25				70	13	37	6.2	3	—	●	17
8301032	M10 × 1.5				75	15	41	7		—	●	25
8301034	M10 × 1.25				75	15	41	7		—	●	24
8301038	M12 × 1.75				82	18	48	8.5		—	●	38
8301040	M12 × 1.5				82	18	48	8.5		—	●	39
8301044	M12 × 1.25				82	18	48	8.5		—	●	38
8301054	M14 × 2				88	20	48	10.5		—	●	60
8301056	M14 × 1.5				88	20	48	10.5		—	●	60
8301062	M16 × 2				95	20	52	12.5		—	●	86

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 2002年7月前生产品中 M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8301064	M16 × 1.5	STD	OH2	2.5P	95	20	52	12.5	3	—	●	87
8301070	M18 × 2.5	STD	OH3		100	25	55	14	4	—	●	104
8301072	M18 × 1.5				100	25	55	14		—	●	106
8301078	M20 × 2.5				105	25	58	15		—	●	130
8301082	M20 × 1.5				105	25	58	15		—	●	131
8301086	M22 × 2.5				115	25	63	17		—	●	177
8301088	M22 × 1.5				115	25	63	17		—	●	177
8301090	M24 × 3				120	30	66	19		—	●	224
8301092	M24 × 1.5				120	30	66	19		—	●	228
8301094	M27 × 3				130	30	71	20		—	●	297
8301096	M27 × 1.5				130	30	71	20		—	●	302
8301098	M30 × 3.5				135	35	74	23		—	●	381
8301100	M30 × 1.5				135	35	74	23		—	●	391

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

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

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

△＝停产产品(请确认库存。) Discontinued item

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

G-LIST No. | TH1023

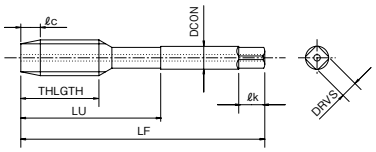
内冷油孔型
WITH INTERNAL COOLANT SUPPLY

OIL-SFT

对于水平方向的盲孔加工及深孔加工有效果。
切削液可经由内冷油孔供给至刃尖部，因此加工速度高，精度好。

Effective for horizontal, deep hole tapping of blind holes. Because cutting fluid is sufficiently supplied to the cutting edge, high speed and precise operation is possible.

HSS | H | 35°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10480	M 6 ×1	STD	OH2	2.5P	80	19	28	6	3	—	●	15
10481					100					—	●	22
10482					120					—	●	25
10486	M 8 ×1.25				80	22	31	6.2		—	●	17
10487					100					—	●	23
10488					120					—	●	28
10494	M10 ×1.5				80	24	34	7		—	●	26
10496					120					—	●	39
10497					150					—	●	47
10501	M10 ×1.25				120	24	34	7		—	●	38
10509	M12 ×1.75				100	29	41	8.5		—	●	48
10510					120					—	●	52
10511					150					—	●	67
10514	M12 ×1.5				120	29	41	8.5		—	●	52
10518	M12 ×1.25				120	29	41	8.5		—	●	54
10525	M14 ×2				100	30	43	10.5		—	●	69
10527					150					—	●	96
10532	M14 ×1.5				150	30	43	10.5		—	●	97
10535	M16 ×2				100	32	45	12.5		—	●	93
10537					150					—	●	138

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 油孔先端中央部1个孔。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10538	M16 ×2	STD	OH2	2.5P	200	32	45	12.5	3	—	●	184
10542	M16 ×1.5				150	32	45	12.5		—	●	137
10545	M18 ×2.5	STD	OH3		100	37	49	14	4	—	●	106
10547					150					—	●	168
10551	M18 ×1.5	STD	OH2		150	37	49	14		—	△	169
10554	M20 ×2.5	STD	OH3		120	37	50	15		—	●	153
10555					150					—	●	196
10556					200					—	●	265
10559	M20 ×1.5	STD	OH2		150	37	50	15		—	△	200
10562	M22 ×2.5	STD	OH3		120	38	51	17		—	●	186
10563					150					—	●	239
10567	M22 ×1.5	STD	OH2		150	38	51	17		—	△	241
10570	M24 ×3	STD	OH3		120	45	59	19		—	●	226
10571					150					—	●	294
10572					200					—	●	400
10575	M24 ×1.5	STD	OH2		150	45	59	19		—	△	299
10578	M27 ×3	STD	OH3		150	45	63	20		—	●	357
10580					250					—	●	608
10584	M30 ×3.5	STD	OH3		150	48	67	23		—	●	450
10586					250		74			—	●	786

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. This tool has a single oil hole at its tip.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols

● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

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

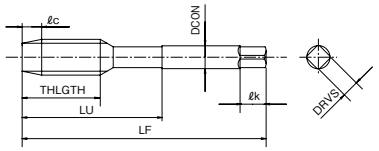
G-LIST No. | TH1083

铝用
FOR ALUMINIUM

EX-AL-SFT

HSSE | 51°

适用于铝、铝合金、铝合金铸件等非铁金属的盲孔攻丝。
Suitable for tapping blind holes in aluminum and aluminum alloys, as well as die casts and nonferrous metals.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8320101	M 2 ×0.4	STD	OH1	2.5P	40	12	—	3	2	—	●	3
8320104	M 2.3 ×0.4				42	13	—	3		—	●	3
8320105	M 2.5 ×0.45				44	14	—	3		—	●	3
8320107	M 2.6 ×0.45				44	14	—	3		—	●	3
8320111	M 3 ×0.5	STD	OH2		46	4	19	4		—	●	4
8320115	M 3.5 ×0.6				48	4.8	20	4		—	●	3
8320116	M 4 ×0.7				52	5.6	21	5		—	●	7
8320120	M 5 ×0.8				60	6.4	24	5.5		—	●	9
8320124	M 6 ×1				62	8	29	6		—	●	12

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8320132	M 8 ×1.25	STD	OH3	2.5P	70	10	37	6.2	2	—	●	16
8320134	M 8 ×1	STD	OH2		70	10	37	6.2		—	●	16
8320142	M10 ×1.5	STD	OH3		75	12	41	7		—	●	23
8320144	M10 ×1.25				75	12	41	7		—	●	23
8320146	M10 ×1	STD	OH2		75	12	41	7		—	●	23
8320154	M12 ×1.75	STD	OH3		82	14	48	8.5		—	●	36
8320156	M12 ×1.5				82	14	48	8.5		—	●	36
8320158	M12 ×1.25				82	14	48	8.5		—	●	37

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

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

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TW1005

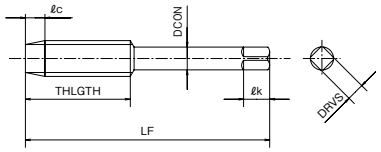
硬质合金螺旋槽丝锥

CARBIDE SPIRAL FLUTED

OT-SFT

适于铝合金、镁合金、铜合金、热可塑性塑料的盲孔高精度加工。

This tap is suitable for numerous operations with high precision in automatic machines. It Is ideal for tapping materials such as aluminum alloys, magnesium alloys, copper alloys and thermoplastics.



CARBIDE 15°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8315254	M3 ×0.5	STD	OH3	2.5P	46	11	19	4	3	Yes	●	7
8315255				1.5P						Yes	●	7
8315260	M4 ×0.7			2.5P	52	13	21	5		Yes	●	12
8315261				1.5P						Yes	●	12
8315266	M5 ×0.8			2.5P	60	16	24	5.5		Yes	●	17
8315267				1.5P						Yes	●	17
8315272	M6 ×1			2.5P	62	19	29	6		—	●	20
8315273				1.5P						—	●	19
8315284	M8 ×1.25	STD	OH4	2.5P	70	22	—	6.2		—	●	29
8315285				1.5P						—	●	30

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8315296	M10×1.5	STD	OH4	2.5P	75	24	—	7	3	—	●	43
8315297				1.5P						—	●	43
8315302	M10×1.25			2.5P	75	24	—	7		—	●	43
8315303				1.5P						—	●	43
8315314	M12×1.75			2.5P	82	29	—	8.5		—	●	68
8315315				1.5P						—	●	68
8315320	M12×1.5			2.5P	82	29	—	8.5		—	●	67
8315321				1.5P						—	●	68
8315326	M12×1.25			2.5P	82	29	—	8.5		—	●	69
8315327				1.5P						—	●	69

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OT-SFT												○	◎	◎	◎	◎	○	○	○	○	○			◎	○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TW1031

内冷油孔硬质合金螺旋槽丝锥

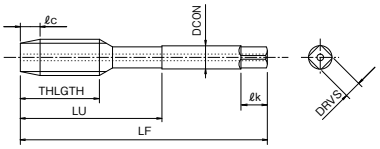
CARBIDE SPIRAL FLUTED TAP WITH INTERNAL COOLANT SUPPLY

The A Brand

A-CSF

切削条件 Cutting Conditions | P.838

CARBIDE | FX | SHANK h6 | 15°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330810	M 6 × 1	STD	OH3	1.5P	62	19	30	6	3	–	●	19
8330820	M 8 × 1.25		OH4		70	22	–	6.2		–	●	28
8330830	M 10 × 1.5				75	24	–	7		–	●	40
8330831	M 10 × 1.25				75	24	–	7		–	●	41
8330840	M 12 × 1.75				82	29	–	8.5		–	●	64
8330842	M 12 × 1.25				82	29	–	8.5		–	●	64

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 推荐底孔径是旧 JIS2级内螺纹用。(除旧JIS 的规格中没有的内螺纹) JIS 规格中没有的内螺纹的底孔径仅供参考。

※高速同步丝锥中用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. The recommended tap limit corresponds to JIS class 2 internal thread standard. The recommended drill hole size that are not listed on JIS is as reference.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

G-LIST No. | TW1031

内冷油孔硬质合金螺旋槽丝锥(铣刀柄)

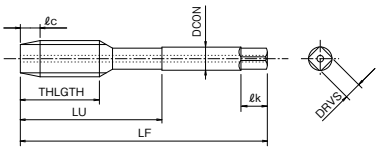
CARBIDE SPIRAL FLUTED TAP WITH INTERNAL COOLANT SUPPLY (END MILL SHANK)

The A Brand

A-CSF

切削条件 Cutting Conditions | P.838

CARBIDE | FX | SHANK h6 | 15°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330860	M 6×1 - 6	STD	OH3	1.5P	80	19	30	6	3	–	●	26
8330870	M 8×1.25 - 8		OH4		90	22	37	8		–	●	50
8330880	M 10×1.5 - 8				100	24	–	8		–	●	63
8330881	M 10×1.25 - 8				100	24	–	8		–	●	64
8330890	M 12×1.75 - 10				110	29	–	10		–	●	110
8330892	M 12×1.25 - 10				100	29	–	10		–	●	100

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 推荐底孔径是旧 JIS2级内螺纹用。(除旧JIS 的规格中没有的内螺纹) JIS 规格中没有的内螺纹的底孔径仅供参考。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. The recommended tap limit corresponds to JIS class 2 internal thread standard. The recommended drill hole size that are not listed on JIS is as reference.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-CSF												◎	◎		◎	◎	○		○	○	○			◎	○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

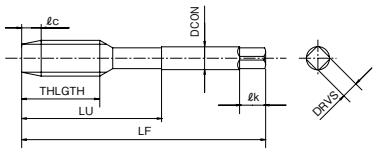
G-LIST No. | **TH1004**

高碳素钢用
FOR HIGH CARBON STEELS

EX-HC-SFT

HSSE | 35°

适用于高碳钢、模具钢、合金钢的盲孔攻丝。
Suitable for tapping blind holes in high content carbon steels, dies steels, and alloy steels.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19341	M 3×0.5	STD	OH2	3P	46	11	19	4	3	—	▲	3
19356	M 4×0.7				52	13	21	5		Yes	▲	7
19371	M 5×0.8				60	16	24	5.5		Yes	▲	10
19383	M 6×1				62	19	29	6		Yes	▲	12
19401	M 8×1.25				70	22	37	6.2		—	▲	17
19421	M10×1.5				75	24	41	7		—	▲	25
19424	M10×1.25				75	24	41	7		—	▲	26
19450	M12×1.75				82	29	48	8.5		—	▲	40

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
19453	M12×1.5	STD	OH2	3P	82	29	48	8.5	3	—	▲	41
19456	M12×1.25				82	29	48	8.5		—	▲	41
19480	M14×2				88	30	48	10.5		—	▲	64
19483	M14×1.5				88	30	48	10.5		—	▲	65
19505	M16×2				95	32	52	12.5		—	▲	90
19508	M16×1.5				95	32	52	12.5		—	▲	90
19530	M18×2.5	STD	OH3		100	37	55	14	4	—	▲	108
19535	M18×1.5	STD	OH2		100	37	55	14		—	▲	112

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。
▲=该产品已停止生产，由EXZ-SFT(P.605)、EX-SFT(P.595)、CPM-SFT(P.628)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
▲= The products have been stopped producing and replaced by EXZ-SFT (p.605) and EX-SFT (p.595) and CPM-SFT (p.628).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-HC-SFT			◎	○						○	○														

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

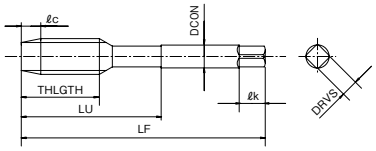
G-LIST No. | TH1135

铜用
FOR COPPER

CU-SFT

丝锥表面施有CrN涂层，具有优良的耐磨性，抗溶着性好。
刀具材料采用了HSSE，铜加工中实现刀具长寿命。Employs CrN coating for superior wear and welding resistance, especially when working with copper materials. The HSSE body (vanadium high speed steel) provides extended tool life.

HSSE | CrN | 45°



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
28910	M 3 ×0.5	STD	OH2	2.5P	46	3.5	19	4	3	—	●	5
28913	M 4 ×0.7				52	5	21	5		—	●	8
28916	M 5 ×0.8				60	5.5	24	5.5		—	●	10
28919	M 6 ×1				62	7	29	6		—	●	12
28922	M 8 ×1.25	STD	OH3		70	8.5	37	6.2		—	●	16
28924	M 8 ×1	STD	OH2		70	8.5	37	6.2		—	●	16
28926	M10 ×1.5	STD	OH3		75	10.5	41	7		—	●	24

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
28928	M10 ×1.25	STD	OH3	2.5P	75	10.5	41	7	3	—	●	24
28930	M10 ×1				75	10.5	41	7		—	●	24
28932	M12 ×1.75				82	12	48	8.5		—	●	37
28934	M12 ×1.5				82	12	48	8.5		—	●	36
28936	M12 ×1.25				82	12	48	8.5		—	●	37
28938	M12 ×1				82	12	48	8.5		—	●	37

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
CU-SFT									○					◎	○	○			○							○

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

钛合金用
FOR TITANIUM ALLOY

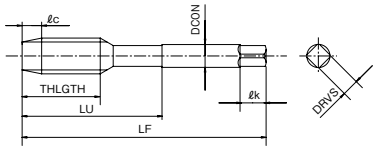
V-TI-SFT

切削条件 Cutting Conditions | P.842

CPM | V | 10°

适用于航空航天、化学工业中经过时效处理的硬度为40 ~ 45HRC的钛合金(Ti-6Al-4V)等加工。具有寿命长，效率高，稳定性能好的特点。

This tap provides high performance and longer tool life when tapping titanium alloy steels (Ti-6Al-4V etc.), which are used in the aerospace and chemical industries. These materials have a hardness of 40 ~ 45 HRC after the process of age hardening by solution treatment.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
28810	M 3 ×0.5	STD	OH3	2.5P	46	11	19	4	3	—	●	5
28813	M 4 ×0.7				52	13	21	5		Yes	●	8
28816	M 5 ×0.8				60	16	29	5.5		Yes	●	12
28819	M 6 ×1				62	19	—	6		Yes	●	14
28822	M 8 ×1.25				70	22	36	7		—	●	21
28824	M 8 ×1				70	22	36	7		—	●	21
28826	M10 ×1.5				75	24	41	8.5		—	●	34
28828	M10 ×1.25	STD	OH3	2.5P	75	24	41	8.5	3	—	●	33
28830	M10 ×1				75	24	41	8.5		—	●	34
28832	M12 ×1.75	STD	OH4		82	29	43	10.5		—	●	54
28834	M12 ×1.5	STD	OH3		82	29	43	10.5		—	●	54
28836	M12 ×1.25	STD	OH4		82	29	43	10.5		—	●	55
28838	M12 ×1	STD	OH3		82	29	43	10.5		—	●	55

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8316833	No. 6 - 32UNJC	STD	OH2	2.5P	48	13	26	4	3	Yes	●	5
8316836	No. 6 - 40UNJF				48	13	26	4		Yes	●	5
8316840	No. 8 - 32UNJC				52	13	21	5		Yes	●	8
8316842	No. 8 - 36UNJF				52	13	21	5		Yes	●	9
8316846	No.10 - 24UNJC				60	16	29	5.5		Yes	●	11
8316849	No.10 - 32UNJF				60	16	29	5.5		Yes	●	11
8316858	1/4 - 20UNJC	STD	OH3		62	19	—	6		Yes	●	14
8316861	1/4 - 28UNJF	STD	OH2		62	19	—	6		Yes	●	14
8316867	5/16 - 18UNJC	STD	OH3	2.5P	70	22	36	7	3	—	●	20
8316870	5/16 - 24UNJF				70	22	36	7		—	●	20
8316876	3/8 - 16UNJC				75	24	41	8.5		—	●	31
8316882	3/8 - 24UNJF				75	24	41	8.5		—	●	32
8316891	7/16 - 14UNJC				80	25	40	10.5		—	●	49
8316894	7/16 - 20UNJF				80	25	40	10.5		—	●	50
8316900	1/2 - 13UNJC	STD	OH4		85	29	45	10.5		—	●	59
8316906	1/2 - 20UNJF	STD	OH3		85	29	45	10.5		—	●	61

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
V-TI-SFT						○																◎				

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | **TH1178**

HR涂层 镍基超耐热合金用

HR COATED FOR NICKEL ALLOY

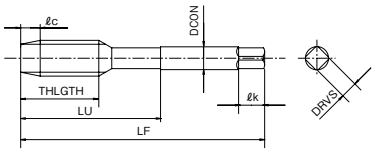
WHR-NI-SFT

切削条件 Cutting Conditions | **P.842**

CPM | HR | 11°

POT的先端槽型与螺旋槽丝锥相结合，实现了刃部的高刚性，针对时效处理后的镍基合金，丝锥寿命长，可以获得稳定的加工。

Created tough cutting edge by additional special flute on spiral fluted tap. Possible for longer tool life and stable machining on agring threated Nickel Alloy steel (HRC40 ~ 45).



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3901410	M 3 ×0.5	STD	OH3	2.5P	46	11	19	4	3	—	●	5
3901413	M 4 ×0.7				52	13	21	5		Yes	●	8
3901416	M 5 ×0.8				60	16	29	5.5		Yes	●	11
3901419	M 6 ×1				62	19	—	6		Yes	●	13

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3901422	M 8 ×1.25	STD	OH3	2.5P	70	22	36	7	3	—	●	21
3901426	M10 ×1.5				75	24	41	8.5		—	●	33
3901432	M12 ×1.75	STD	OH4		82	29	43	10.5		—	●	54

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3901446	No. 8 - 32UNJC	GH3	2.5P	52	13	21	5	3	Yes	●	8
3901455	No.10 - 32UNJF	GH3		60	16	29	5.5		Yes	●	11
3901467	1/4 - 28UNJF	GH4		62	19	—	6		Yes	●	14
3901473	5/16 - 24UNJF	GH4		70	22	36	7		—	●	21

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3901479	3/8 - 24UNJF	GH4	2.5P	75	24	41	8.5	3	—	●	32
3901485	7/16 - 20UNJF	GH5		80	25	40	10.5		—	●	33
3901491	1/2 - 20UNJF	GH5		85	29	45	10.5		—	●	60

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

GH 精度 GH LIMIT

为了与高精度要求的飞机零件螺纹加工相对应，采用了比OH精度公差带更窄的GH精度。

Applied tighter torerance GH limits to satisfy high precision demand from Aerospace parts threading operation.

GH1, 2 GH1,2

上公差：0.013×n upper limit : 0.013×n

下公差：上公差−0.013 lower limit : (upper limit) −0.013

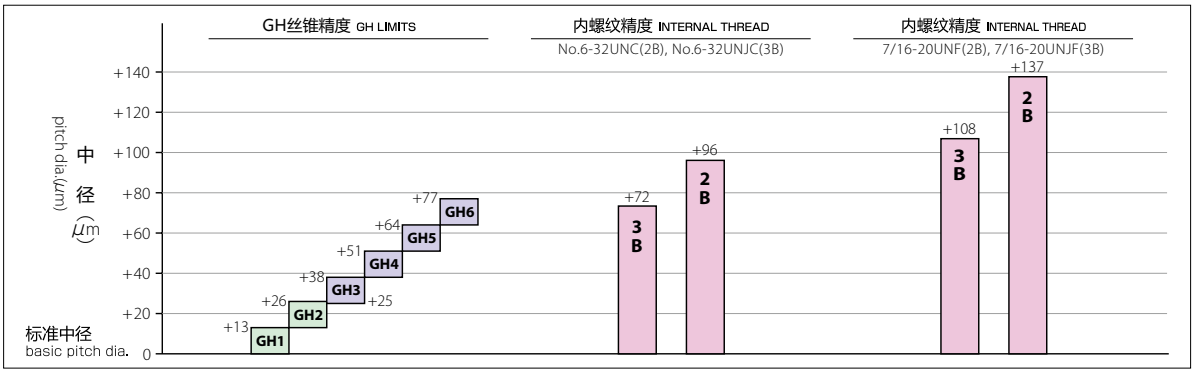
单位： mm Unit : mm (n=GH号) (n=GH number)

GH3以上 GH3 over

上公差：0.013×(n-2) +0.025 upper limit : 0.013×(n-2)+0.025

下公差：上公差−0.013 lower limit : (upper limit) −0.013

单位: mm Unit: mm (n=GH号) (n=GH number)



加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
WHR-NI-SFT						○																	◎			

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

镍基超耐热合金用

FOR NICKEL ALLOY

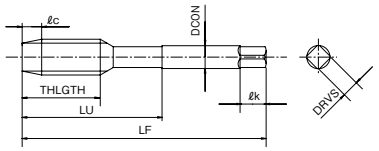
NI-SFT

切削条件 Cutting Conditions | P.842

CPM　10°

适用于航空、航天、化学工业中经过时效处理的硬度为40 ~ 45HRC的镍基耐热合金加工(Inconel 718等)刀具寿命长。

This tap provides high performance when tapping heat resistant alloy steels that are used in the aerospace and chemical industries. These materials, such as nickel alloy or inconel®718, have a hardness of 40 ~ 45 HRC after the process of age hardening by solution treatment.



螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
29060	M 3 ×0.5	STD	OH3	2.5P	46	11	19	4	3	—	●	5
29063	M 4 ×0.7				52	13	21	5		Yes	●	8
29066	M 5 ×0.8				60	16	29	5.5		Yes	●	11
29069	M 6 ×1				62	19	—	6		Yes	●	13
29072	M 8 ×1.25				70	22	36	7		—	●	21
29074	M 8 ×1				70	22	36	7		—	●	21
29076	M10×1.5				75	24	41	8.5		—	●	33
29078	M10×1.25	STD	OH3	2.5P	75	24	41	8.5	3	—	●	34
29080	M10×1				75	24	41	8.5		—	●	34
29082	M12×1.75	STD	OH4		82	29	43	10.5		—	●	54
29084	M12×1.5	STD	OH3		82	29	43	10.5		—	●	53
29086	M12×1.25	STD	OH4		82	29	43	10.5		—	●	55
29088	M12×1	STD	OH3		82	29	43	10.5		—	●	54

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 2002年7月前生产品中M3以下为突顶尖。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Taps of M3 or less producted before July 2002 have external center.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U,UNJ

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8317233	No. 6 - 32UNJC	STD	OH2	2.5P	48	13	26	4	3	Yes	●	6
8317236	No. 6 - 40UNJF				48	13	26	4		Yes	●	5
8317240	No. 8 - 32UNJC				52	13	21	5		Yes	●	9
8317242	No. 8 - 36UNJF				52	13	21	5		Yes	●	8
8317246	No.10 - 24UNJC				60	16	29	5.5		Yes	●	11
8317249	No.10 - 32UNJF				60	16	29	5.5		Yes	●	11
8317258	1/4 - 20UNJC	STD	OH3		62	19	—	6		Yes	●	14
8317261	1/4 - 28UNJF	STD	OH2		62	19	—	6		Yes	●	14
8317267	5/16 - 18UNJC	STD	OH3	2.5P	70	22	36	7	3	—	●	21
8317270	5/16 - 24UNJF				70	22	36	7		—	●	21
8317276	3/8 - 16UNJC				75	24	41	8.5		—	●	32
8317282	3/8 - 24UNJF				75	24	41	8.5		—	●	32
8317291	7/16 - 14UNJC				80	25	40	10.5		—	●	49
8317294	7/16 - 20UNJF				80	25	40	10.5		—	●	50
8317300	1/2 - 13UNJC	STD	OH4		85	29	45	10.5		—	●	59
8317306	1/2 - 20UNJF	STD	OH3		85	29	45	10.5		—	●	61

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏　　是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
NI-SFT						○																	◎			

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1056

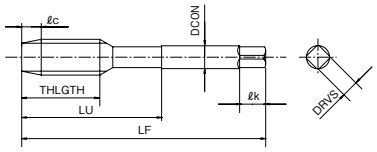
高速同步型丝锥

SYNCHRO TAPS

HS-SFT

同步进给设备专用的高速，高精度盲孔攻丝用丝锥。
另有长柄系列和JIS柄系列。

Suitable for high speed / high precision, blind hole tapping. This tap must be used with machines that have perfectly synchronized feed control (one pitch feed per revolution).



HSSE | TiN | 45° | SHANK h7

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20810	M 3 ×0.5	STD	OH3	3P	46	4	19	4	3	—	●	5
20814	M 4 ×0.7				52	5.6	21	6		—	●	9
20818	M 5 ×0.8				60	6.4	24	6		—	●	11
20822	M 6 ×1				62	8	29	6		—	●	12
20828	M 8 ×1.25	STD	OH4		70	10	37	8		—	●	22
20834	M10 ×1.5				75	12	41	8		—	●	28

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20836	M10 ×1.25	STD	OH4	3P	75	12	41	8	3	—	●	28
20839	M12 ×1.75				82	14	48	10		—	●	46
20842	M12 ×1.5				82	14	48	10		—	●	46
20845	M12 ×1.25				82	14	48	10		—	●	48
20849	M14 ×2	STD	OH5		88	16	48	12		—	●	74
20851	M14 ×1.5	STD	OH4		88	16	48	12		—	●	74

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

G-LIST No. | TH1119

高速同步型丝锥 JIS柄型

SYNCHRO TAPS (JIS SHANK)

J-HS-SFT

HSSE | TiN | 45° | SHANK h7

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8305610	M 3 ×0.5	STD	OH3	3P	46	4	19	4	3	—	▲	4
8305614	M 4 ×0.7				52	5.6	21	5		—	▲	7
8305618	M 5 ×0.8				60	6.4	24	5.5		—	▲	10
8305622	M 6 ×1				62	8	29	6		—	▲	11
8305628	M 8 ×1.25	STD	OH4		70	10	37	6.2		—	▲	16
8305634	M10 ×1.5				75	12	41	7		—	▲	24

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。
▲=该产品已停止生产，由 A-SFT(P.583) 替代。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8305636	M10 ×1.25	STD	OH4	3P	75	12	41	7	3	—	▲	24
8305639	M12 ×1.75				82	14	48	8.5		—	▲	38
8305642	M12 ×1.5				82	14	48	8.5		—	▲	39
8305645	M12 ×1.25				82	14	48	8.5		—	▲	40
8305649	M14 ×2	STD	OH5		88	16	48	10.5		—	▲	63
8305651	M14 ×1.5	STD	OH4		88	16	48	10.5		—	▲	64

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
▲=The products have been stopped producing and replaced by A-SFT (p.583).

※SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HS-SFT	◎	◎	○	○	○						○			○				○	○	○					○
J-HS-SFT	◎	◎	○	○	○						○			○				○	○	○					○

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

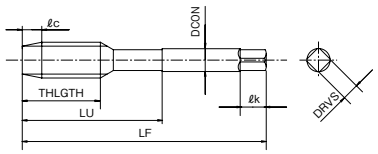
■记号说明请参考 P1页。 See p.1 for explanation of icons.

高速同步丝锥 长柄型

SYNCHRO TAPS· LONG SHANK

HS-LT-SFT

HSSE | TiN | 45° | SHANK h7



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8304210	M 3 ×0.5	STD	OH3	3P	100	4	19	4	3	—	●	11
8304211					120					—	●	12
8304213	M 4 ×0.7				100	5.6	21	6		—	●	20
8304215					150					—	●	31
8304216	M 5 ×0.8				100	6.4	24	6		—	●	20
8304218					150					—	●	32
8304219	M 6 ×1				100	8	29	6		—	●	22
8304221					150					—	●	32
8304223	M 8 ×1.25	STD	OH4		100	10	37	8		—	●	35
8304225					150					—	●	55
8304230	M10×1.5				100	12	41	8		—	●	39
8304232					150					—	●	60
8304234	M10×1.25				100	12	41	8		—	●	39
8304236					150					—	●	60
8304241	M12×1.75				100	14	48	10		—	●	59
8304243					150					—	●	89
8304245	M12×1.5				100	14	48	10		—	●	59

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8304247	M12×1.5	STD	OH4	3P	150	14	48	10	3	—	●	89
8304249	M12×1.25				100	14	48	10		—	●	59
8304251					150					—	●	90
8304258	M14×2	STD	OH5		150	16	48	12		—	●	123
8304262	M14×1.5	STD	OH4		150	16	48	12		—	●	124
8304265	M16×2	STD	OH5		150	16	60	16		—	●	186
8304269	M16×1.5	STD	OH4		150	16	60	16		—	●	187
8304272	M18×2.5	STD	OH5		150	20	70	16	4	—	●	191
8304275	M18×1.5	STD	OH4		150	20	70	16		—	●	195
8304278	M20×2.5	STD	OH5		150	20	75	16		—	●	204
8304281	M20×1.5	STD	OH4		150	20	75	16		—	●	207
8304284	M22×2.5	STD	OH5		150	20	80	20		—	●	280
8304287	M22×1.5	STD	OH4		150	20	80	20		—	●	284
8304290	M24×3	STD	OH5		150	24	90	20		—	●	298
8304293	M24×1.5	STD	OH4		150	24	90	20		—	●	298
8304298	M27×3	STD	OH5		200	24	98	20		—	●	446
8304306	M30×3.5	STD	OH6		200	28	110	25		—	●	619

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
HS-LT-SFT	◎	◎	○	○	○						○			○				○	○	○						○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1084

铝用高速同步进给丝锥

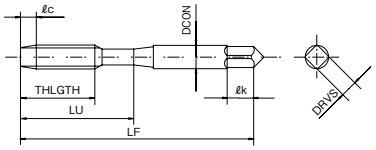
SYNCHRO TAPS· FOR ALUMINIUM

HS-AL-SFT

HSSE | 45°·51° | SHANK h7

同步进给设备专用丝锥。可进行铝、铝合金的高速攻丝加工。

For high speed / high precision tapping of aluminum and aluminum alloys. This tap must be used with machines that have perfectly synchronizes feed control (one pitch feed per revolution).



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8305102	M2 ×0.4	STD	OH2	3P	40	12	—	3	2	—	●	3
8305108	M2.6×0.45	STD	OH2	3P	44	14	—	3	2	—	●	3
8305110	M3 ×0.5	STD	OH3	3P	46	4	19	4	2	—	●	4
8305114	M4 ×0.7	STD	OH3	3P	52	5.6	21	6	2	—	●	9
8305118	M5 ×0.8	STD	OH3	3P	60	6.4	24	6	2	—	●	11
8305122	M6 ×1	STD	OH3	3P	62	8	29	6	2	—	●	12

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

G-LIST No. | TH1125

ULTRA同步进给丝锥

ULTRA SYNCHRO TAPS

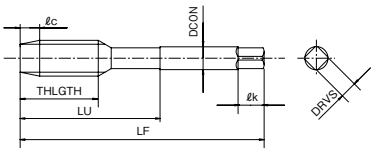
US-AL-SFT

HSSE | V | N | 45°·51° | SHANK h7

DC≦16　16< DC

同步进给设备专用丝锥。由于使用了耐磨损性，耐粘着性高的V涂层，可进行铝、铝合金等的超高速攻丝加工。

Capable of high speed processing of materials such as aluminum and aluminum alloys, thanks to the superior abrasion and wear resistance of V coating. For use with machines that have perfectly synchronized feed control.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8311669	M 3 ×0.5	STD	OH3	3P	46	4	19	4	2	—	●	4
8311683	M 4 ×0.7	STD	OH3	3P	52	5.6	21	6	2	—	●	9
8311697	M 5 ×0.8	STD	OH3	3P	60	6.4	24	6	2	—	●	11
8311711	M 6 ×1	STD	OH3	3P	62	8	29	6	2	—	●	11
8311725	M 8 ×1.25	STD	OH4	3P	70	10	37	8	2	—	●	20
8311739	M10 ×1.5	STD	OH4	3P	75	12	41	8	2	—	●	27
8311743	M10 ×1.25	STD	OH4	3P	75	12	41	8	2	—	●	27
8311757	M12 ×1.75	STD	OH4	3P	82	14	48	10	2	—	●	44
8311761	M12 ×1.5	STD	OH4	3P	82	14	48	10	2	—	●	44
8311765	M12 ×1.25	STD	OH4	3P	82	14	48	10	2	—	●	45
8311779	M14 ×2	STD	OH5	3P	88	16	48	12	2	—	●	70
8311783	M14 ×1.5	STD	OH4	3P	88	16	48	12	2	—	●	71
8311797	M16 ×2	STD	OH5	3P	95	16	52	16	2	—	●	106
8311801	M16 ×1.5	STD	OH4	3P	95	16	52	16	2	—	●	109
8311815	M18 ×2.5	STD	OH5	3P	100	20	55	16	2	—	●	117
8311819	M18 ×1.5	STD	OH4	3P	100	20	55	16	2	—	●	118
8311833	M20 ×2.5	STD	OH5	3P	105	20	58	16	2	—	●	136
8311837	M20 ×1.5	STD	OH4	3P	105	20	58	16	2	—	●	138
8311869	M24 ×3	STD	OH5	3P	120	24	66	20	2	—	●	230

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ULTRA SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
HS-AL-SFT																		◎	◎	○	◎				○
US-AL-SFT																		◎	◎	◎	◎				○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1159

钢用内冷油孔高速同步型丝锥

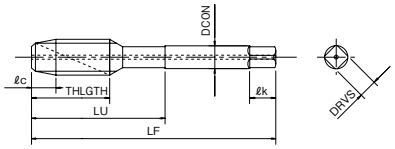
ULTRA SYNCHRO TAP WITH INTERNAL COOLANT SUPPLY FOR STEELS

VPO-US-SFT

同步进给设备专用丝锥
可在碳素钢上进行50m/mim以上的高速攻丝加工。

VPO-US-SFT are not recommended for use on machines without synchronized feed control. This tap is capable of tapping above 50m/min on carbon steels.

CPM | V | 35° | SHANK h7



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8313311	M 6 ×1	STD	OH3	2P	62	8	29	6	3	—	●	10
8313325	M 8 ×1.25	STD	OH4	2P	70	10	37	8	3	—	●	20
8313339	M10×1.5	STD	OH4	2P	75	12	41	8	3	—	●	26
8313343	M10×1.25	STD	OH4	2P	75	12	41	8	3	—	●	27

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8313357	M12×1.75	STD	OH4	2P	82	14	48	10	3	—	●	44
8313361	M12×1.5	STD	OH4	2P	82	14	48	10	3	—	●	44
8313365	M12×1.25	STD	OH4	2P	82	14	48	10	3	—	●	42

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ULTRA SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
VPO-US-SFT	◎	◎		○					○																

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1183

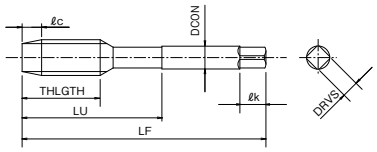
刃倾角丝锥
SPIRAL POINTED TAP

A The A Brand

A-POT

切削条件 Cutting Conditions | P.838

CPM V



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325034	M 1.4 × 0.3	STD	OH1	5P	34	9	—	3	2	Yes	●	2
8325039	M 1.6 × 0.35	STD	OH1.5		36	10	—	3		Yes	●	3
8325044	M 1.7 × 0.35	STD	OH1.5		36	11	—	3		Yes	●	3
8325049	M 2 × 0.4	STD	OH1.5		40	12	—	3		Yes	●	3
8325430		STD+1	OH2.5								●	3
8325431		STD+2	OH3.5								●	3
8325050	M 2 × 0.25	STD	OH1		40	12	—	3		Yes	●	3
8325432		STD+1	OH2								●	3
8325052	M 2.2 × 0.45	STD	OH2		42	13	—	3		Yes	●	3
8325434		STD+1	OH3								●	3
8325053	M 2.2 × 0.25	STD	OH1		42	13	—	3		Yes	●	3
8325436		STD+1	OH2								●	3
8325054	M 2.3 × 0.4	STD	OH1.5		42	13	—	3		Yes	●	3
8325438		STD+1	OH2.5								●	3
8325059	M 2.5 × 0.45	STD	OH2		44	14	—	3		Yes	●	3
8325440		STD+1	OH3								●	3
8325441		STD+2	OH4								●	3
8325062	M 2.5 × 0.35	STD	OH2		44	14	—	3		Yes	●	3
8325442		STD+1	OH3								●	3
8325064	M 2.6 × 0.45	STD	OH2		44	14	—	3		Yes	●	3
8325444		STD+1	OH3								●	3
8325069	M 3 × 0.5	STD	OH3		46	11	19	4	3	Yes	●	4
8325450		STD+1	OH4								●	4
8325451		STD+2	OH5								●	4
8325072	M 3 × 0.35	STD	OH2		46	11	19	4		Yes	●	6
8325452		STD+1	OH3								●	4
8325076	M 3.5 × 0.6	STD	OH2		48	13	20	4		Yes	●	5
8325454		STD+1	OH3								●	4
8325079	M 3.5 × 0.35	STD	OH2		48	13	20	4		Yes	●	5
8325455		STD+1	OH3								●	5
8325083	M 4 × 0.7	STD	OH3		52	13	21	5		Yes	●	7
8325460		STD+1	OH4								●	7
8325461		STD+2	OH5								●	8
8325086	M 4 × 0.5	STD	OH3		52	13	21	5		Yes	●	7
8325462		STD+1	OH4								●	8
8325087	M 4.5 × 0.75	STD	OH3		55	13	21	5		Yes	●	8
8325464		STD+1	OH4								●	8
8325088	M 4.5 × 0.5	STD	OH3		55	13	21	5		Yes	●	8
8325465		STD+1	OH4								●	8
8325090	M 5 × 0.8	STD	OH3		60	16	24	5.5		Yes	●	10
8325468		STD+1	OH4								●	10
8325469		STD+2	OH5								●	10
8325093	M 5 × 0.5	STD	OH3		60	16	24	5.5		Yes	●	10
8325473		STD+1	OH4								●	10
8325095	M 5.5 × 0.5	STD	OH3		60	17	25	5.5		Yes	●	11
8325476		STD+1	OH4								●	11

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

下一页
尺寸 Size M6 ~ M16 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-POT	◎	◎	◎	◎	◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○			

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FROM 尺寸 Size M1.4 ~ M5.5

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325097	M 6 × 1	STD	OH3	5P	62	19	29	6	3	Yes	●	12
8325478		STD+1	OH4								●	12
8325479		STD+2	OH5								●	12
8325100	M 6 × 0.75	STD	OH3		62	19	29	6		Yes	●	12
8325480		STD+1	OH4								●	13
8325102	M 6 × 0.5	STD	OH3		62	19	29	6		Yes	●	12
8325481		STD+1	OH4								●	13
8325104	M 7 × 1	STD	OH3		65	19	33	6.2		Yes	●	16
8325484		STD+1	OH4								●	16
8325105	M 7 × 0.75	STD	OH3		65	19	33	6.2		Yes	●	16
8325485		STD+1	OH4								●	16
8325107	M 8 × 1.25	STD	OH3		70	22	37	6.2		Yes	●	18
8325488		STD+1	OH4								●	18
8325489		STD+2	OH5								●	19
8325111	M 8 × 1	STD	OH3		70	22	37	6.2		Yes	●	18
8325490		STD+1	OH4								●	19
8325112	M 8 × 0.75	STD	OH3		70	22	37	6.2		Yes	●	21
8325491		STD+1	OH4								●	19
8325114	M 9 × 1.25	STD	OH3		72	22	38	7		Yes	●	25
8325494		STD+1	OH4								●	25
8325115	M 9 × 1	STD	OH3		72	22	38	7		Yes	●	25
8325495		STD+1	OH4								●	26
8325116	M 9 × 0.75	STD	OH3		72	22	38	7		Yes	●	26
8325496		STD+1	OH4								●	26
8325117	M 10 × 1.5	STD	OH4		75	24	41	7		–	●	25
8325500		STD+1	OH5								●	27
8325501		STD+2	OH6								●	27
8325121	M 10 × 1.25	STD	OH3		75	24	41	7		–	●	26
8325502		STD+1	OH4								●	28
8325124	M 10 × 1	STD	OH3		75	24	41	7		–	●	27
8325503		STD+1	OH4								●	28
8325125	M 10 × 0.75	STD	OH3		75	24	41	7		–	●	29
8325504		STD+1	OH4								●	29
8325127	M 11 × 1.5	STD	OH4		80	25	48	8		–	●	38
8325510		STD+1	OH5								●	38
8325128	M 11 × 1	STD	OH3		80	25	48	8		–	●	39
8325514		STD+1	OH4								●	39
8325129	M 11 × 0.75	STD	OH3		80	25	48	8		–	●	40
8325515		STD+1	OH4								●	40
8325130	M 12 × 1.75	STD	OH4		82	29	48	8.5		–	●	42
8325518		STD+1	OH5								●	44
8325519		STD+2	OH6								●	44
8325134	M 12 × 1.5	STD	OH4		82	29	48	8.5		–	●	43
8325520		STD+1	OH5								●	44
8325137	M 12 × 1.25	STD	OH4		82	29	48	8.5		–	●	43
8325521		STD+1	OH5								●	44
8325140	M 12 × 1	STD	OH3		82	29	48	8.5		–	●	44
8325522		STD+1	OH4								●	46
8325147	M 14 × 2	STD	OH4		88	30	48	10.5		–	●	64
8325530		STD+1	OH5								●	71
8325150	M 14 × 1.5	STD	OH4		88	30	48	10.5		–	●	65
8325531		STD+1	OH5								●	71
8325152	M 14 × 1.25	STD	OH4		88	30	48	10.5		–	●	71
8325532		STD+1	OH5								●	71
8325154	M 14 × 1	STD	OH3		88	30	48	10.5		–	●	72
8325533		STD+1	OH4								●	71
8325155	M 15 × 1.5	STD	OH4		95	32	52	10.5		–	●	79
8325536		STD+1	OH5								●	79
8325156	M 15 × 1	STD	OH3		95	32	52	10.5		–	●	81
8325537		STD+1	OH4								●	80
8325157	M 16 × 2	STD	OH4		95	32	52	12.5		–	●	95
8325540		STD+1	OH5								●	101
8325160	M 16 × 1.5	STD	OH4		95	32	52	12.5		–	●	96
8325541		STD+1	OH5								●	101

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尺寸 Size M16 ~ M24 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

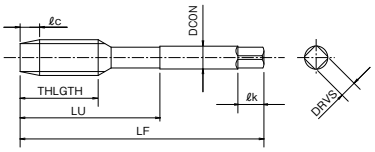
G-LIST No. | TH1183

刃倾角丝锥
SPIRAL POINTED TAP

A The A Brand

A-POT

切削条件 Cutting Conditions | P.838



CPM | V

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FROM 尺寸 Size M6 ~ M16

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325162	M 16 × 1	STD	OH3	5P	95	32	52	12.5	3	–	●	101
8325542		STD+1	OH4								●	101
8325164	M 17 × 1.5	STD	OH4		100	37	55	13		–	●	109
8325545		STD+1	OH5								●	109
8325166	M 17 × 1	STD	OH3		100	37	55	13		–	●	111
8325546		STD+1	OH4								●	111
8325167	M 18 × 2.5	STD	OH5		100	37	55	14		–	●	123
8325549		STD+1	OH6								●	124
8325169	M 18 × 2	STD	OH4		100	37	55	14		–	●	123
8325550		STD+1	OH5								●	123
8325170	M 18 × 1.5	STD	OH4		100	37	55	14		–	●	123
8325551		STD+1	OH5								●	124
8325172	M 18 × 1	STD	OH3		100	37	55	14		–	●	127
8325552		STD+1	OH4								●	126
8325177	M 20 × 2.5	STD	OH5		105	37	58	15		–	●	154
8325557		STD+1	OH6								●	154
8325179	M 20 × 2	STD	OH4		105	37	58	15		–	●	152
8325558		STD+1	OH5								●	153
8325180	M 20 × 1.5	STD	OH4		105	37	58	15		–	●	153
8325559		STD+1	OH5								●	155
8325182	M 20 × 1	STD	OH3		105	37	58	15		–	●	156
8325560		STD+1	OH4								●	126
8325187	M 22 × 2.5	STD	OH5		115	38	63	17		–	●	209
8325563		STD+1	OH6								●	209
8325189	M 22 × 2	STD	OH4		115	38	63	17		–	●	210
8325564		STD+1	OH5								●	210
8325190	M 22 × 1.5	STD	OH4		115	38	63	17		–	●	209
8325565		STD+1	OH5								●	209
8325192	M 22 × 1	STD	OH3		115	38	63	17		–	●	211
8325566		STD+1	OH4								●	212
8325197	M 24 × 3	STD	OH5		120	45	66	19		–	●	265
8325569		STD+1	OH6								●	266
8325199	M 24 × 2	STD	OH4		120	45	66	19		–	●	265
8325570		STD+1	OH5								●	265
8325200	M 24 × 1.5	STD	OH4		120	45	66	19		–	●	266
8325571		STD+1	OH5								●	267
8325202	M 24 × 1	STD	OH3		120	45	66	19		–	●	269
8325572		STD+1	OH4								●	271

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-POT	◎	◎	◎	◎	◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

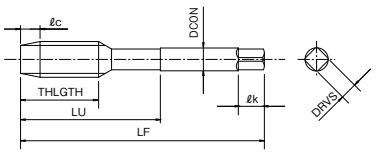
刃倾角丝锥
SPIRAL POINTED TAP

The A Brand

A-POT

切削条件 Cutting Conditions | P.838

CPM V



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8327012	No. 4 – 40UNC	STD	OH2	5P	44	15	–	3	2	Yes	●	3
8327018	No. 5 – 40UNC				46	11	19	4	3	Yes	●	5
8327024	No. 6 – 32UNC				48	13	21	4		Yes	●	5
8327030	No. 8 – 32UNC				52	13	21	5		Yes	●	8
8327036	No.10 – 24UNC				60	16	24	5.5		Yes	●	10
8327039	No.10 – 32UNF				60	16	24	5.5		Yes	●	10
8327049	¼ – 20UNC		OH3		62	19	29	6		Yes	●	13
8327051	¼ – 28UNF		OH2		62	19	29	6		Yes	●	13
8327058	5⁄16 – 18UNC		OH3		70	22	37	6.1		Yes	●	18
8327061	5⁄16 – 24UNF				70	22	37	6.1		Yes	●	19
8327067	⅜ – 16UNC				75	24	41	7		–	●	26
8327073	⅜ – 24UNF				75	24	41	7		–	●	28
8327080	7⁄16 – 14UNC				80	25	48	8		–	●	37
8327083	7⁄16 – 20UNF				80	25	48	8		–	●	39
8327090	½ – 13UNC		OH4		85	29	48	9		–	●	51
8327096	½ – 20UNF		OH3		85	29	48	9		–	●	52
8327105	9⁄16 – 12UNC		OH4		90	30	48	10.5		–	●	72
8327108	9⁄16 – 18UNF		OH3		90	30	48	10.5		–	●	74
8327111	⅝ – 11UNC		OH4		95	32	52	12		–	●	94
8327114	⅝ – 18UNF		OH3		95	32	52	12		–	●	95
8327120	¾ – 10UNC		OH4		105	37	58	14		–	●	134
8327123	¾ – 16UNF				105	37	58	14		–	●	134
8327130	⅞ – 9UNC		OH5		115	38	63	17		–	●	209
8327132	⅞ – 14UNF		OH4		115	38	63	17		–	●	208

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS 2B internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

SynchroMaster

与A-TAP完美搭配的攻丝刀柄

※详情请参照▶P.831
See p.831 for details

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
A-POT	◎	◎	◎	◎	◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | **TH1183**

刃倾角丝锥(铣刀柄)

SPIRAL POINTED TAP (END MILL SHANK)

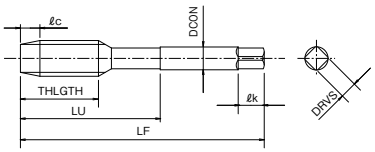
A The A Brand

A-POT

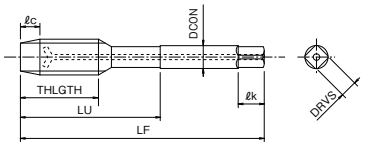
切削条件 Cutting Conditions | P.838

CPM | V | SHANK h7

不带内冷 without Coolant Hole



带内冷 with Coolant Hole



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	油孔 Oil Hole	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8325800	M 3 × 0.5 - 4	—	STD	OH3	5P	46	11	19	4	3	Yes	●	5
8325801	M 4 × 0.7 - 6	—				52	13	21	6		Yes	●	9
8325802	M 5 × 0.8 - 6	—				60	16	24	6		Yes	●	13
8325803	M 6 × 1 - 6	—				62	19	29	6		Yes	●	13
8326901		Yes									—	●	12
8326902	M 6 × 0.75 - 6	Yes				62	19	29	6		—	●	12
8325804	M 8 × 1.25 - 8	—		OH4		70	22	37	8		Yes	●	24
8326903		Yes									—	●	23
8326904	M 8 × 1 - 8	Yes		OH3		70	22	37	8		—	●	24
8325806	M 10 × 1.5 - 8	—		OH4		75	24	41	8		—	●	32
8326905		Yes										●	30
8325805	M 10 × 1.25 - 8	—				75	24	41	8		—	●	32
8326906		Yes										●	30
8325807	M 12 × 1.75 - 10	—				82	29	48	10		—	●	53
8326907		Yes										●	49
8326908	M 12 × 1.5 - 10	Yes				82	29	48	10		—	●	50
8326909	M 12 × 1.25 - 10	Yes				82	29	48	10		—	●	49
8325808	M 14 × 2 - 12	—		OH5		88	30	48	12		—	●	81

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 铣刀柄产品对应筒夹柄，铣刀柄等，请使用周边紧固的刀柄。
2. 精度栏 保证高精度与完全同步进给的组合为前提，2级相当的丝锥推荐精度。
3. 丝锥精度不能保证内螺纹的精度。
4. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Although taps with end mill shank are compatible with a collet holder, milling holder and etc., use a holder with a detent.
2. The recommended tap limit corresponds to JIS class 2 internal thread standards only if combination of maintaining the high accuracy and complete synchronous feed is applied.
3. Tap limit does not guarantee thread limit for the internal thread after tapping.
4. Regrinding is not recommended.

※Stable feed control machines are recommended to avoid over size tapping.

SynchroMaster

与A-TAP完美搭配的攻丝刀柄

※详情请参照 ▶P.831
See p.831 for details

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
A-POT	◎	◎	◎	◎	◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

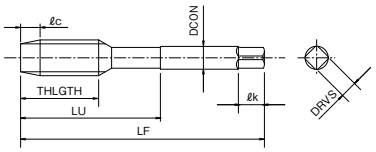
刃倾角丝锥 长柄型

SPIRAL POINTED TAP WITH LONG SHANK

The A Brand

A-LT-POT

切削条件 Cutting Conditions | P.838



CPM V

螺纹种类：**M**

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326002	M 2 × 0.4 × 80	STD	OH1.5	5P	80	12	—	3	2	Yes	●	6
8326001	M 2 × 0.25 × 80		OH1		80	12	—	3		Yes	●	6
8326004	M 2.2 × 0.45 × 80		OH2		80	13	—	3		Yes	●	6
8326003	M 2.2 × 0.25 × 80		OH1		80	13	—	3		Yes	●	6
8326005	M 2.3 × 0.4 × 80		OH1.5		80	13	—	3		Yes	●	6
8326007	M 2.5 × 0.45 × 80		OH2		80	14	—	3		Yes	●	6
8326006	M 2.5 × 0.35 × 80				80	14	—	3		Yes	●	6
8326008	M 2.6 × 0.45 × 80				80	14	—	3		Yes	●	6
8326010	M 3 × 0.5 ×100		OH3		100	11	20	4	3	Yes	●	11
8326009	M 3 × 0.35 ×100		OH2		100	11	20	4		Yes	●	11
8326012	M 3.5 × 0.6 ×100				100	13	24	4		Yes	●	11
8326011	M 3.5 × 0.35 ×100				100	13	24	4		Yes	●	11
8326014	M 4 × 0.7 ×100		OH3		100	13	27	5		Yes	●	16
8326013	M 4 × 0.5 ×100				100	13	27	5		Yes	●	16
8326016	M 4.5 × 0.75 ×100				100	13	30	5		Yes	●	16
8326015	M 4.5 × 0.5 ×100				100	13	30	5		Yes	●	16
8326018	M 5 × 0.8 ×100				100	16	33	5.5		Yes	●	18
8326017	M 5 × 0.5 ×100				100	16	33	5.5		Yes	●	18
8326019	M 5.5 × 0.5 ×100				100	17	37	5.5		Yes	●	21
8326022	M 6 × 1 ×100				100	19	40	6		Yes	●	23
8326023	×150				150						●	33
8326020	M 6 × 0.75 ×100				100	19	40	6		Yes	●	23
8326021	×150				150						●	33
8326026	M 7 × 1 ×100				100	19	40	6.2		Yes	●	26
8326027	×150				150		60				●	38
8326024	M 7 × 0.75 ×100				100	19	40	6.2		Yes	●	27
8326025	×150				150		60				●	38
8326032	M 8 × 1.25 ×100				100	22	40	6.2		Yes	●	28
8326033	×150				150		60				●	40
8326030	M 8 × 1 ×100				100	22	40	6.2		Yes	●	28
8326031	×150				150		60				●	40
8326028	M 8 × 0.75 ×100				100	22	40	6.2		Yes	●	29
8326029	×150				150		60				●	40
8326038	M 9 × 1.25 ×100				100	22	40	7		Yes	●	36
8326039	×150				150		60				●	51
8326036	M 9 × 1 ×100				100	22	40	7		Yes	●	36
8326037	×150				150		60				●	51
8326034	M 9 × 0.75 ×100				100	22	40	7		Yes	●	37
8326035	×150				150		60				●	52
8326046	M10 × 1.5 ×100		OH4		100	24	41	7		—	●	36
8326047	×150				150		60				●	52
8326044	M10 × 1.25 ×100		OH3		100	24	41	7		—	●	37
8326045	×150				150		60				●	53

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※Stable feed control machines are recommended to avoid over size tapping.

下一页
尺寸 Size M10 ~ M24 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
A-LT-POT	◎	◎	◎	◎	◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1185

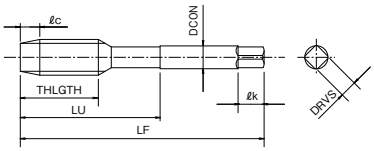
刃倾角丝锥 长柄型

SPIRAL POINTED TAP WITH LONG SHANK

The A Brand

A-LT-POT

切削条件 Cutting Conditions | P.838



CPM V

上一页
FROM 尺寸 Size M2 ~ M10

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size			精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326042	M10	× 1	×100	STD	OH3	5P	100	24	41	7	3	–	●	37
8326043			×150				150		60				●	54
8326040	M10	× 0.75	×100				100	24	41	7		–	●	38
8326041			×150				150		60				●	54
8326052	M11	× 1.5	×100		OH4		100	25	48	8		–	●	48
8326053			×150				150		60				●	67
8326092	M11	× 1.25	×100		OH3		100	25	48	8		–	●	48
8326093			×150				150		60				●	67
8326050	M11	× 1	×100				100	25	48	8		–	●	49
8326051			×150				150		60				●	68
8326048	M11	× 0.75	×100				100	25	48	8		–	●	50
8326049			×150				150		60				●	69
8326060	M12	× 1.75	×100		OH4		100	29	48	8.5		–	●	54
8326061			×150				150		60				●	76
8326058	M12	× 1.5	×100				100	29	48	8.5		–	●	54
8326059			×150				150		60				●	75
8326056	M12	× 1.25	×100				100	29	48	8.5		–	●	54
8326057			×150				150		60				●	75
8326054	M12	× 1	×100		OH3		100	29	48	8.5		–	●	56
8326055			×150				150		60				●	77
8326065	M14	× 2	×150		OH4		150	30	60	10.5		–	●	110
8326064	M14	× 1.5	×150				150	30	60	10.5		–	●	110
8326063	M14	× 1.25	×150				150	30	60	10.5		–	●	109
8326062	M14	× 1	×150		OH3		150	30	60	10.5		–	●	109
8326067	M15	× 1.5	×150		OH4		150	32	60	10.5		–	●	115
8326066	M15	× 1	×150		OH3		150	32	60	10.5		–	●	116
8326070	M16	× 2	×150		OH4		150	32	60	12.5		–	●	152
8326071			×200				200		80				●	202
8326069	M16	× 1.5	×150				150	32	60	12.5		–	●	154
8326068	M16	× 1	×150		OH3		150	32	60	12.5		–	●	153
8326073	M17	× 1.5	×150		OH4		150	37	60	13		–	●	169
8326072	M17	× 1	×150		OH3		150	37	60	13		–	●	169
8326077	M18	× 2.5	×150		OH5		150	37	60	14		–	●	190
8326076	M18	× 2	×150		OH4		150	37	60	14		–	●	189
8326075	M18	× 1.5	×150				150	37	60	14		–	●	191
8326074	M18	× 1	×150		OH3		150	37	60	14		–	●	193
8326081	M20	× 2.5	×150		OH5		150	37	60	15		–	●	222
8326082			×200				200		80				●	292
8326080	M20	× 2	×150		OH4		150	37	60	15		–	●	220
8326079	M20	× 1.5	×150				150	37	60	15		–	●	224
8326078	M20	× 1	×150		OH3		150	37	60	15		–	●	225
8326086	M22	× 2.5	×150		OH5		150	38	63	17		–	●	277
8326085	M22	× 2	×150		OH4		150	38	63	17		–	●	277
8326084	M22	× 1.5	×150				150	38	63	17		–	●	282
8326083	M22	× 1	×150		OH3		150	38	63	17		–	●	280
8326090	M24	× 3	×150		OH5		150	45	66	19		–	●	341
8326091			×200				200						●	456
8326089	M24	× 2	×150		OH4		150	45	66	19		–	●	340
8326088	M24	× 1.5	×150				150	45	66	19		–	●	342
8326087	M24	× 1	×150		OH3		150	45	66	19		–	●	345

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1185

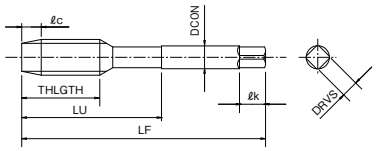
刃倾角丝锥 长柄型(铣刀柄)

SPIRAL POINTED TAP WITH LONG SHANK (END MILL SHANK)

The A Brand

A-LT-POT

切削条件 Cutting Conditions | P.838



CPM | V | SHANK h7

螺纹种类：**M**

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size		精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8326400	M 3×0.5	×100 - 4	STD	OH3	5P	100	11	20	4	3	Yes	●	11
8326420		×150 - 4				150						●	16
8326401	M 4×0.7	×100 - 6				100	13	27	6		Yes	●	20
8326421		×150 - 6				150						●	31
8326402	M 5×0.8	×100 - 6				100	16	33	6		Yes	●	20
8326422		×150 - 6				150						●	32
8326403	M 6×1	×100 - 6				100	19	40	6		Yes	●	22
8326423		×150 - 6				150						●	33
8326424		×200 - 6				200						●	46
8326404	M 8×1.25	×100 - 8		OH4		100	22	53	8		Yes	●	35
8326425		×150 - 8				150						●	56
8326426		×200 - 8				200						●	78
8326406	M10×1.5	×100 - 8				100	24	41	8		–	●	43
8326427		×150 - 8				150		60				●	64
8326428		×200 - 8				200		80				●	84
8326405	M10×1.25	×100 - 8				100	24	41	8		–	●	42
8326429		×150 - 8				150		60				●	64
8326430		×200 - 8				200		80				●	84
8326407	M12×1.75	×100 -10				100	29	48	10		–	●	66
8326431		×150 -10				150		60				●	96
8326432		×200 -10				200		80				●	127
8326408	M14×2	×150 -12		OH5		150	30	60	12		–	●	133
8326433		×200 -12				200		80				●	179
8326409	M16×2	×150 -16				150	32	60	16		–	●	209
8326434		×200 -16				200		80				●	281
8326410	M20×2.5	×150 -16				150	37	75	16		–	●	238
8326435		×200 -16				200		80				●	322
8326411	M24×3	×150 -20				150	45	90	20		–	●	359
8326436		×200 -20				200						●	486

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 铣刀柄产品对应筒夹柄，铣刀柄等，请使用周边紧固的刀柄。
2. 精度栏 保证高精度与完全同步进给的组合为前提，2级相当的丝锥推荐精度。
3. 丝锥精度不能保证内螺纹的精度。
4. 不推荐再研磨。

※请注意，如果使用进给不稳定的设备，有可能会产生内螺纹扩大的现象。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Although taps with end mill shank are compatible with a collet holder, milling holder and etc., use a holder with a detent.
2. The recommended tap limit corresponds to JIS class 2 internal thread standards only if combination of maintaining the high accuracy and complete synchronous feed is applied.
3. Tap limit does not guarantee thread limit for the internal thread after tapping.
4. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-LT-POT	◎	◎	◎	◎	◎	○			◎	○	◎		◎	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1041

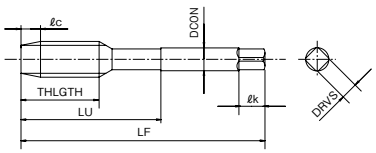
一般用
GENERAL APPLICATION

EX-POT

HSSE

一般用型刃倾角丝锥。适用于碳素钢、合金钢、非铁金属等。切屑呈连续卷曲状的材料。由于切屑是向前排出的，因此无需担心切屑对丝锥、对内螺纹的损伤。

Suitable for through hole tapping of carbon steels, alloy steels and nonferrous metals whose chips are produced in continuous coil form. These taps discharge chips through the hole.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16006	M 1 × 0.25	STD	OH1	5P	30	6	—	3	2	Yes	●	3
16007	M 1.1 × 0.25				32	8	—	3		Yes	●	3
16008	M 1.2 × 0.25				32	8	—	3		Yes	●	3
16010										Yes	●	3
16011	M 1.4 × 0.3	STD+1	OH2		34	9	—	3		Yes	●	3
16012		STD+2	OH3							Yes	●	3
16014		STD	OH1							Yes	●	3
16015	M 1.6 × 0.35	STD+1	OH2		36	10	—	3		Yes	●	3
16016		STD+2	OH3							Yes	●	3
16019		STD	OH1							Yes	●	3
16020	M 1.7 × 0.35	STD+1	OH2		36	11	—	3		Yes	●	3
16021		STD+2	OH3							Yes	●	3
16022		STD+3	OH4							Yes	●	3
16024	M 1.8 × 0.35	STD	OH2		36	11	—	3		Yes	●	3
16031		STD	OH1							Yes	●	3
16032	M 2 × 0.4	STD+1	OH2		40	12	—	3		Yes	●	3
16033		STD+2	OH3							Yes	●	3
16034		STD+3	OH4							Yes	●	3
16038	M 2 × 0.25	STD	OH1		40	12	—	3		Yes	●	3
16042	M 2.2 × 0.45	STD	OH2		42	13	—	3		Yes	●	3
16043		STD	OH1							Yes	●	3
16044	M 2.3 × 0.4	STD+1	OH2		42	13	—	3		Yes	●	3
16045		STD+2	OH3							Yes	●	3
16046		STD+3	OH4							Yes	●	4
16053		STD	OH2							Yes	●	3
16054	M 2.5 × 0.45	STD+1	OH3		44	14	—	3		Yes	●	3
16055		STD+2	OH4							Yes	●	4
16056	M 2.5 × 0.35	STD	OH2		44	14	—	3		Yes	●	4
16059										Yes	●	4
16060	M 2.6 × 0.45	STD+1	OH3		44	14	—	3		Yes	●	3
16061		STD+2	OH4							Yes	●	3
16062	M 2.6 × 0.35	STD	OH2		44	14	—	3		Yes	●	4
16065	M 3 × 0.6				46	11	19	4	3	Yes	●	4
16066		STD+1	OH3							Yes	●	4
15368		STD	OH2							Yes	●	5
16069	M 3 × 0.5	STD+1	OH3		46	11	19	4		Yes	●	4
17942		STD+2	OH4							Yes	●	5
16071	M 3 × 0.35	STD	OH2		46	11	19	4		Yes	●	5
16074	M 3.5 × 0.6				48	13	20	4		Yes	●	4
16075		STD+1	OH3							Yes	●	5
16081	M 3.5 × 0.35	STD	OH2		48	13	20	4		Yes	●	5
16083	M 4 × 0.75				52	13	21	5		Yes	●	7
16084		STD+1	OH3							Yes	●	7
15386		STD	OH2							Yes	●	7
16087	M 4 × 0.7	STD+1	OH3		52	13	21	5		Yes	●	7
17946		STD+2	OH4							Yes	●	8
16089	M 4 × 0.5	STD	OH2		52	13	21	5		Yes	●	8
16092	M 4.5 × 0.75				55	13	21	5		Yes	●	8
16098	M 5 × 0.9				60	16	24	5.5		Yes	●	10
16099		STD+1	OH3							Yes	●	10
15401		STD	OH2							Yes	●	10
16102	M 5 × 0.8	STD+1	OH3		60	16	24	5.5		Yes	●	10
17950		STD+2	OH4							Yes	●	11
16103	M 5 × 0.75	STD	OH2		60	16	24	5.5		Yes	●	11
16105	M 5 × 0.5				60	16	24	5.5		Yes	●	11
16108	M 5.5 × 0.9				60	17	25	5.5		Yes	●	11
16110	M 5.5 × 0.5				60	17	25	5.5		Yes	●	11
15413	M 6 × 1				62	19	29	6		Yes	●	10

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16114	M 6 × 1	STD+1	OH3	5P	62	19	29	6	3	Yes	●	12
17954		STD+2	OH4							Yes	●	13
16116	M 6 × 0.75	STD	OH2		62	19	29	6		Yes	●	12
16117		STD+1	OH3							Yes	●	12
16120	M 6 × 0.5	STD	OH2		62	19	29	6		Yes	●	13
16122	M 7 × 1				65	19	33	6.2		Yes	●	16
16127	M 7 × 0.75				65	19	33	6.2		Yes	●	16
16129	M 7 × 0.5				65	19	33	6.2		Yes	●	17
15431		STD	OH3		70	22	37	6.2		Yes	●	19
16132	M 8 × 1.25	STD+1	OH4							Yes	●	19
17958		STD+2	OH5							Yes	●	19
16134	M 8 × 1	STD	OH2		70	22	37	6.2		Yes	●	19
16135		STD+1	OH3							Yes	●	19
16137	M 8 × 0.75	STD	OH2		70	22	37	6.2		Yes	●	20
16141	M 8 × 0.5				70	22	37	6.2		Yes	●	20
16144	M 9 × 1.25	STD	OH3		72	22	38	7		Yes	●	25
16148	M 9 × 1	STD	OH2		72	22	38	7		Yes	●	26
15456		STD	OH3		75	24	41	7		—	●	27
16157	M10 × 1.5	STD+1	OH4							—	●	28
17962		STD+2	OH5							—	●	27
15460	M10 × 1.25	STD	OH3		75	24	41	7		—	●	28
16161		STD+1	OH4							—	●	28
16163	M10 × 1	STD	OH3		75	24	41	7		—	●	28
16164		STD+1	OH4							—	●	28
16165	M10 × 0.75	STD	OH2		75	24	41	7		—	●	29
16167	M10 × 0.5				75	24	41	7		—	●	29
16169	M11 × 1.5	STD	OH3		80	25	48	8		—	●	38
16172	M11 × 1.25				80	25	48	8		—	●	38
16174	M11 × 1				80	25	48	8		—	●	39
16176	M11 × 0.75	STD	OH2		80	25	48	8		—	●	40
15480		STD	OH4		82	29	48	8.5		—	●	43
16181	M12 × 1.75	STD+1	OH5							—	●	43
17968		STD+2	OH6							—	●	44
15483	M12 × 1.5	STD	OH3		82	29	48	8.5		—	●	44
16184		STD+1	OH4							—	●	44
15488	M12 × 1.25	STD	OH4		82	29	48	8.5		—	●	44
16189		STD+1	OH5							—	●	44
16191	M12 × 1	STD	OH3		82	29	48	8.5		—	●	44
16192		STD+1	OH4							—	●	44
16193	M12 × 0.75	STD	OH2		82	29	48	8.5		—	●	45
16194	M12 × 0.5				82	29	48	8.5		—	●	45
16195	M13 × 1.75	STD	OH3		88	30	48	9.5		—	●	60
16199	M13 × 1.5				88	30	48	9.5		—	●	61
16203	M13 × 1	STD	OH2		88	30	48	9.5		—	●	63
15509	M14 × 2	STD	OH4		88	30	48	10.5		—	●	70
16210		STD+1	OH5							—	●	70
15512	M14 × 1.5	STD	OH3		88	30	48	10.5		—	●	71
16213		STD+1	OH4							—	●	71
16216	M14 × 1.25	STD	OH3		88	30	48	10.5		—	●	71
16220	M14 × 1				88	30	48	10.5		—	●	72
16232	M15 × 2				95	32	52	10.5		—	●	77
16236	M15 × 1.5				95	32	52	10.5		—	●	78
16244	M15 × 1				95	32	52	10.5		—	●	80
15557	M16 × 2	STD	OH4		95	32	52	12.5		—	●	100
16258		STD+1	OH5							—	●	100
15560	M16 × 1.5	STD	OH3		95	32	52	12.5		—	●	100
16261		STD+1	OH4							—	●	100
16268	M16 × 1	STD	OH3		95	32	52	12.5		—	●	100

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尺寸 Size M17 ~ M48 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-POT		○	○	○									○	○	○	○	○	◎	○	○	○				○

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FROM 尺寸 Size **M1 ~ M16**

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16281	M17 × 2	STD	OH4	5P	100	37	55	13	3	—	●	105
16286	M17 × 1.5	STD	OH3		100	37	55	13		—	●	106
16282	M17 × 1				100	37	55	13		—	●	109
15593	M18 × 2.5	STD	OH4		100	37	55	14		—	●	121
16294		STD+1	OH5							—	●	122
16297	M18 × 2	STD	OH4		100	37	55	14		—	●	120
15601	M18 × 1.5				100	37	55	14		—	●	121
16302		STD+1	OH5							—	●	122
16304	M18 × 1	STD	OH3		100	37	55	14		—	●	123
16313	M19 × 2.5	STD	OH4		105	37	58	14		—	●	133
16320	M19 × 1.5	STD	OH3		105	37	58	14		—	●	134
16324	M19 × 1	STD	OH2		105	37	58	14		—	●	264
15629	M20 × 2.5	STD	OH4		105	37	58	15		—	●	150
16330		STD+1	OH5							—	●	151
16333	M20 × 2	STD	OH4		105	37	58	15		—	●	149
15637	M20 × 1.5				105	37	58	15		—	●	153
16338		STD+1	OH5							—	●	153
16341	M20 × 1	STD	OH3		105	37	58	15		—	●	153
15645	M22 × 2.5	STD	OH4		115	38	63	17		—	●	207
16346		STD+1	OH5							—	●	205
16349	M22 × 2	STD	OH4		115	38	63	17		—	●	204
15653	M22 × 1.5				115	38	63	17		—	●	204
16354		STD+1	OH5							—	●	205
16358	M22 × 1	STD	OH2		115	38	63	17		—	●	207
16361	M23 × 2.5	STD	OH4		120	45	66	18		—	●	238
16365	M23 × 2				120	45	66	18		—	●	264
15673	M24 × 3				120	45	66	19		—	●	261
16374		STD+1	OH5							—	●	266
16377	M24 × 2	STD	OH4		120	45	66	19		—	●	262
15681	M24 × 1.5				120	45	66	19		—	●	264
16382		STD+1	OH5							—	●	260
16385	M24 × 1	STD	OH2		120	45	66	19		—	●	262
16389	M25 × 3	STD	OH4		130	45	71	19		—	●	289
16393	M25 × 2				130	45	71	19		—	●	304
16397	M25 × 1.5				130	45	71	19		—	●	296
16405	M26 × 3				130	45	71	20		—	●	318
16407	M26 × 2	STD	OH3		130	45	71	20		—	●	325
16409	M26 × 1.5	STD	OH4		130	45	71	20		—	●	325

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 一般用SM、W螺纹有库存。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16417	M27 × 3	STD	OH4	5P	130	45	71	20	3	—	●	334
16418		STD+1	OH5							—	●	337
16421	M27 × 2	STD	OH4		130	45	71	20		—	●	337
16425	M27 × 1.5				130	45	71	20		—	●	342
16426		STD+1	OH5							—	●	341
16428	M27 × 1	STD	OH2		130	45	71	20		—	●	348
16434	M28 × 3	STD	OH4		135	48	74	21		—	●	384
16437	M28 × 2				135	48	74	21		—	●	392
16441	M28 × 1.5				135	48	74	21		—	●	390
16450	M30 × 3.5	STD	OH5		135	48	74	23		—	●	434
16451		STD+1	OH6							—	●	433
16453	M30 × 3	STD	OH4		135	48	74	23		—	●	440
16457	M30 × 2				135	48	74	23		—	●	445
16461	M30 × 1.5				135	48	74	23		—	●	448
16462		STD+1	OH5							—	●	450
16465	M30 × 1	STD	OH2		135	48	74	23		—	●	456
16467	M32 × 1.5	STD	OH4		110	37	47	24		—	●	402
16474	M33 × 3.5	STD	OH5		145	51	77	25		—	●	569
16478	M33 × 2	STD	OH3		110	37	47	25		—	●	421
16482	M33 × 1.5	STD	OH4		110	37	47	25		—	●	431
16491	M35 × 1.5				110	39	49	26	4	—	●	461
16498	M36 × 4	STD	OH5		155	57	82	28		—	●	721
16500	M36 × 3	STD	OH4		155	57	82	28		—	●	730
16502	M36 × 2	STD	OH3		110	39	49	28		—	●	509
16506	M36 × 1.5	STD	OH4		110	39	49	28		—	●	508
16519	M39 × 4	STD	OH5		165	60	87	30		—	●	886
16534	M42 × 4.5				175	60	93	32		—	●	1,076
16538	M42 × 3	STD	OH4		175	60	93	32		—	●	1,117
16541	M42 × 2	STD	OH3		120	39	49	32		—	●	743
16544	M42 × 1.5				120	39	49	32		—	●	749
16546	M45 × 4.5	STD	OH5		180	67	95	35		—	●	1,285
16549	M45 × 3	STD	OH4		180	67	95	35		—	●	1,348
16552	M45 × 2	STD	OH3		120	45	55	35		—	●	874
16555	M45 × 1.5				120	45	55	35		—	●	862
16558	M48 × 5	STD	OH5		185	67	98	38		—	●	1,563
16561	M48 × 3	STD	OH4		185	67	98	38		—	●	1,590
16564	M48 × 2	STD	OH3		125	45	55	38		—	●	1,037
16567	M48 × 1.5				125	45	55	38		—	●	1,051

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. General Purpose taps: Whitworth and Sewing Machine threaded taps are available from stock.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1041

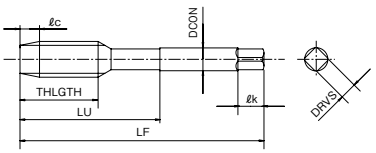
一般用
GENERAL APPLICATION

EX-POT

HSSE

一般用型刃倾角丝锥。适用于碳素钢、合金钢、非铁金属等。切屑呈连续卷曲状的材料。由于切屑是向前排出的，因此无需担心切屑对丝锥、对内螺纹的损伤。

Suitable for through hole tapping of carbon steels, alloy steels and nonferrous metals whose chips are produced in continuous coil form. These taps discharge chips through the hole.



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16891	No. 0-80UNF				36	10	13.5	3		Yes	●	3
16894	No. 1-64UNC				36	11	13.5	3		Yes	●	3
16897	No. 1-72UNF				36	11	13.5	3		Yes	●	3
16900	No. 2-56UNC	STD	OH1		42	13	16	3		Yes	●	4
16903	No. 2-64UNF				42	13	16	3	2	Yes	●	4
16906	No. 3-48UNC				44	14	21	3		Yes	●	4
16909	No. 3-56UNF				44	14	21	3		Yes	●	4
16912	No. 4-40UNC				44	15	21	3		Yes	●	4
16915	No. 4-48UNF				44	15	21	3		Yes	●	4
16918	No. 5-40UNC				46	11	19	4		Yes	●	5
16921	No. 5-44UNF			5P	46	11	19	4		Yes	●	5
16924	No. 6-32UNC				48	13	21	4		Yes	●	5
16927	No. 6-40UNF	STD	OH2		48	13	21	4		Yes	●	5
16930	No. 8-32UNC				52	13	21	5		Yes	●	8
16933	No. 8-36UNF				52	13	21	5		Yes	●	8
16936	No.10-24UNC				60	16	24	5.5	3	Yes	●	10
16939	No.10-32UNF				60	16	24	5.5		Yes	●	12
16942	No.12-24UNC				60	17	25	5.5		Yes	●	11
16945	No.12-28UNF				60	17	25	5.5		Yes	●	11
16949	1/4-20UNC	STD	OH3		62	19	29	6		Yes	●	12
16951	1/4-28UNF	STD	OH2		62	19	29	6		Yes	●	13
16958	5/16-18UNC	STD	OH3		70	22	37	6.1		Yes	●	18

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16961	5/16-24UNF				70	22	37	6.1		Yes	●	19
16967	3/8-16UNC				75	24	41	7		—	●	27
16973	3/8-24UNF				75	24	41	7		—	●	28
16980	7/16-14UNC				80	25	48	8		—	●	36
16983	7/16-20UNF				80	25	48	8		—	●	38
16990	1/2-13UNC				85	29	48	9		—	●	50
16996	1/2-20UNF	STD	OH3		85	29	48	9		—	●	51
17005	9/16-12UNC				90	30	48	10.5		—	●	71
17008	9/16-18UNF				90	30	48	10.5		—	●	72
17011	5/8-11UNC				95	32	52	12	3	—	●	92
17014	5/8-18UNF			5P	95	32	52	12		—	●	94
17020	3/4-10UNC				105	37	58	14		—	●	135
17023	3/4-16UNF				105	37	58	14		—	●	133
17030	7/8- 9UNC	STD	OH4		115	38	63	17		—	●	203
17032	7/8-14UNF	STD	OH3		115	38	63	17		—	●	204
17036	1 - 8UNC	STD	OH4		125	45	68	20		—	●	306
17038	1 -12UNF	STD	OH3		125	45	68	20		—	●	304
17051	1 1/4- 7UNC	STD	OH4		145	51	77	24		—	●	524
17053	1 1/4-12UNF	STD	OH3		105	37	47	24		—	●	379
17063	1 1/2- 6UNC	STD	OH4		160	60	85	30	4	—	●	853
17065	1 1/2-12UNF	STD	OH3		115	39	49	30		—	●	620

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-POT		○	○	○									○	○	○	○	○	◎	○	○	○				○

HSSE

螺纹种类：W

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16800	W 1/8 - 40				46	11	19	4		Yes	●	5
16802	W 3/16 - 24		OH2		60	16	24	5.5		Yes	△	10
16804	W 1/4 - 20				62	19	29	6		Yes	●	13
16807	W 5/16 - 18	STD		5P	70	22	37	6.1	3	Yes	△	18
16810	W 3/8 - 16		OH3		75	24	41	7		—	●	27
16813	W 7/16 - 14				80	25	48	8		—	△	36
16816	W 1/2 - 12				85	29	48	9		—	●	50

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16819	W 5/8 - 11				95	32	52	12		—	●	92
16822	W 3/4 - 10				105	37	58	14		—	●	133
16825	W 7/8 - 9				115	38	63	17	3	—	●	204
16830	W 1 - 8	STD	OH3	5P	125	45	68	20		—	●	301
16834	W 1 1/8 - 7				135	48	72	22		—	●	397
16837	W 1 1/4 - 7				145	51	77	24		—	●	518
16843	W 1 1/2 - 6				160	61	85	30	4	—	●	841

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1041

一般用
GENERAL APPLICATION

EX-POT

一般用型刃倾角丝锥。适用于碳素钢、合金钢、非铁金属等。切屑呈连续卷曲状的材料。由于切屑是向前排出的，因此无需担心切屑对丝锥、对内螺纹的损伤。

Suitable for through hole tapping of carbon steels, alloy steels and nonferrous metals whose chips are produced in continuous coil form. These taps discharge chips through the hole.

HSSE

螺纹种类：SM

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17901	SM 3/32 - 56	STD	OH2	5P	42	13	20	3	2	Yes	●	3
17903	SM 1/8 - 44				46	11	19	4	3	Yes	●	5
17905	SM 9/64 - 40				48	13	21	4		Yes	●	5
17907	SM 11/64 - 40				55	13	21	5		Yes	●	8
17910	SM 3/16 - 28				60	16	24	5.5		Yes	●	10
17911	SM 3/16 - 32				60	16	24	5.5		Yes	●	11

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17915	SM 15/64 - 28	STD	OH2	5P	62	19	29	6	3	Yes	●	13
17917	SM 1/4 - 24				62	19	29	6		Yes	●	13
17920	SM 1/4 - 40				62	19	29	6		Yes	●	14
17921	SM 9/32 - 20				65	22	33	6.5		Yes	●	17
17922	SM 9/32 - 28				65	22	33	6.5		Yes	●	17

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

EX-POT

HSSE

螺纹种类：M(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16570	M 3 ×0.5	STD	OH2	5P	46	11	19	4	3	Yes	●	5
16574	M 4 ×0.7				52	13	21	5		Yes	●	8
16578	M 5 ×0.8				60	16	24	5.5		Yes	●	11
16582	M 6 ×1				62	19	29	6		Yes	●	13
16586	M 8 ×1.25	STD	OH3		70	22	37	6.2		Yes	●	19
16590	M10×1.5				75	24	41	7		—	●	28
16592	M10×1.25				75	24	41	7		—	●	27
16596	M12×1.75	STD	OH4		82	29	48	8.5		—	●	43
16598	M12×1.5	STD	OH3		82	29	48	8.5		—	●	44
16600	M12×1.25	STD	OH4		82	29	48	8.5		—	●	43
16604	M14×2				88	30	48	10.5		—	●	70
16606	M14×1.5	STD	OH3		88	30	48	10.5		—	●	70
16610	M16×2	STD	OH4		95	32	52	12.5		—	●	102

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16612	M16×1.5	STD	OH3	5P	95	32	52	12.5	3	—	●	99
16616	M18×2.5	STD	OH4		100	37	55	14		—	●	120
16618	M18×1.5				100	37	55	14		—	●	120
16622	M20×2.5				105	37	58	15		—	●	150
16624	M20×1.5				105	37	58	15		—	●	153
16628	M22×2.5				115	38	63	17		—	●	205
16630	M22×1.5				115	38	63	17		—	●	206
16634	M24×3				120	45	66	19		—	●	259
16636	M24×1.5				120	45	66	19		—	●	260
16640	M27×3				130	45	71	20		—	●	339
16642	M27×1.5				130	45	71	20		—	●	338
16646	M30×3.5	STD	OH5		135	48	74	23		—	●	437
16648	M30×1.5	STD	OH4		135	48	74	23		—	●	447

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-POT		○	○	○									○	○	○	○	○	◎	○	○	○				○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1044

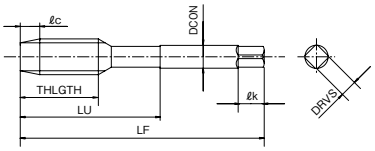
一般用 长柄型

LONG SHANK· GENERAL APPLICATION

EX-LT-POT

HSSE

标准刃倾角丝锥螺纹部悬长不足时使用本系列。
This tap is used when a standard spiral pointed tap is too short.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17740	M 2 ×0.4	STD	OH1	5P	80	12	—	3	2	Yes	●	6
17741					100					Yes	●	8
17744	M 2.3 ×0.4				80	13	—	3		Yes	●	6
17745					100					Yes	●	8
17748	M 2.5 ×0.45				80	14	—	3		Yes	●	6
17749					100					Yes	●	8
17752	M 2.6 ×0.45		OH2		80	14	—	3		Yes	●	8
17753					100					Yes	●	8
13010	M 3 ×0.5				100	11	19	4		Yes	●	11
13011					120					Yes	●	13
13012					150					Yes	●	15
13855		STD+2	OH4		100					Yes	●	11
13018	M 4 ×0.7	STD	OH2		100	13	21	5		Yes	●	16
13019					120					Yes	●	19
13020					150					Yes	●	23
13856		STD+2	OH4		100					Yes	●	16
13026	M 5 ×0.8	STD	OH2		100	16	24	5.5		Yes	●	19
13027					120					Yes	●	23
13028					150					Yes	●	29
13857		STD+2	OH4		100					Yes	●	19
13034	M 6 ×1	STD	OH2		100	19	29	6		Yes	●	23
13035					120					Yes	●	27
13036					150					Yes	●	33
13037					200					Yes	●	47
13858		STD+2	OH4		100					Yes	●	24
13859					150					Yes	●	33
13038	M 6 ×0.75	STD	OH2		100	19	29	6		Yes	●	24
13042	M 8 ×1.25	STD	OH3		100	22	37	6.2		Yes	●	28
13043					120					Yes	●	33
13044					150					Yes	●	39
13045					200					Yes	●	53
13860		STD+2	OH5		100					Yes	●	27
13861					150					Yes	●	39
13046	M 8 ×1	STD	OH2		100	22	37	6.2		Yes	●	28
13047					120					Yes	●	33
13048					150					Yes	●	40
13049	M 8 ×0.75	STD			100	22	37	6.2		Yes	●	28
13050	M10 ×1.5	STD	OH3		100	24	41	7		—	●	36
13051					120					—	●	43
13052					150					—	●	51
13053					200					—	●	67

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13862	M10 ×1.5	STD+2	OH5	5P	150	24	41	7	3	—	●	52
13058	M10 ×1.25	STD	OH3		100	24	41	7		—	●	37
13059					120					—	●	44
13060					150					—	●	52
13061					200					—	●	68
13863		STD+2	OH5		150					—	●	52
13062	M10 ×1	STD	OH3		100	24	41	7		—	●	37
13063					120					—	●	44
13064					150					—	●	52
13066	M12 ×1.75	STD	OH3		100	29	48	8.5		—	●	53
13067					120					—	●	59
13068					150					—	●	74
13069					200					—	●	97
13864		STD+2	OH5		150					—	●	75
13074	M12 ×1.5	STD	OH3		100	29	48	8.5		—	●	54
13075					120					—	●	59
13076					150					—	●	75
13077					200					—	●	99
13865		STD+2	OH5		150					—	●	75
13082	M12 ×1.25	STD	OH3		100	29	48	8.5	3	—	●	54
13083					120					—	●	59
13084					150					—	●	74
13085					200					—	●	98
13866		STD+2	OH5		150					—	●	75
13086	M12 ×1	STD	OH3		100	29	48	8.5		—	●	54
13087					120					—	●	58
13088					150					—	●	76
13090	M14 ×2	STD	OH3		100	30	48	10.5		—	●	79
13091					120					—	●	84
13092					150					—	●	108
13093					200					—	●	141
13098	M14 ×1.5	STD	OH3		100	30	48	10.5		—	●	79
13099					120					—	●	86
13100					150					—	●	108
13101					200					—	●	143
13104	M14 ×1	STD	OH2		150	30	48	10.5		—	●	109
13106	M16 ×2	STD	OH3		120	32	52	12.5		—	●	118
13107					150					—	●	150
13108					200					—	●	198
13109					250					—	●	257
13114	M16 ×1.5	STD	OH3		120	32	52	12.5		—	●	117

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

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尺寸 Size M16 ~ M36 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-LT-POT		○	○	○									○	○	○	○	○	◎	○	○	○				○

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FROM 尺寸 **Size** **M2 ~ M16**

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13115					150					—	●	150
13116	**M 16 × 1.5**	STD	OH3		200	32	52	12.5		—	●	198
13117					250					—	●	256
13119	**M 16 × 1**	STD	OH2		150	32	52	12.5		—	●	150
13123					150					—	●	185
13124	**M 18 × 2.5**				200	37	55	14		—	●	247
13125					250					—	●	315
13127	**M 18 × 2**				150	37	55	14		—	●	186
13131					150					—	●	189
13132	**M 18 × 1.5**				200	37	55	14		—	●	250
13133				5P	250				3	—	●	318
13139					150					—	●	216
13140	**M 20 × 2.5**	STD	OH3		200	37	58	15		—	●	288
13141					250					—	●	366
13143	**M 20 × 2**				150	37	58	15		—	●	216
13147					150					—	●	220
13148	**M 20 × 1.5**				200	37	58	15		—	●	291
13149					250					—	●	359
13155					150					—	●	271
13156	**M 22 × 2.5**				200	38	63	17		—	●	361
13157					250					—	●	459

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13163					150					—	●	272
13164	**M 22 × 1.5**	STD	OH3		200	38	63	17		—	●	361
13165					250					—	●	461
13171					150					—	●	333
13172	**M 24 × 3**	STD	OH4		200	45	66	19		—	●	446
13173					250					—	●	577
13175	**M 24 × 2**				150	45	66	19		—	●	333
13179		STD	OH3		150					—	●	335
13180	**M 24 × 1.5**				200	45	66	19		—	●	446
13181					250				3	—	●	577
13187	**M 27 × 3**			5P	200	45	71	20		—	●	517
13188		STD	OH4		250	45	71	20		—	●	659
13190	**M 27 × 2**				250	45	71	20		—	●	664
13192	**M 27 × 1.5**	STD	OH3		250	45	71	20		—	●	660
13195					200					—	●	649
13196	**M 30 × 3.5**	STD	OH4		250	48	74	23		—	●	829
13197					300					—	●	995
13198	**M 30 × 2**				250	48	74	23		—	●	857
13199	**M 30 × 1.5**	STD	OH3		250	48	74	23		—	●	857
13201	**M 33 × 3.5**	STD	OH4		300	51	77	25	4	—	●	1,187
13205	**M 36 × 4**				300	57	82	28		—	●	1,451

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1044

一般用 长柄型

LONG SHANK· GENERAL APPLICATION

EX-LT-POT

标准刃倾角丝锥螺纹部悬长不足时使用本系列。

This tap is used when a standard spiral pointed tap is too short.

HSSE

螺纹种类：W

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13903	W 1/4 - 20	STD	OH2	5P	150	19	29	6	3	Yes	△	34
13904	W 5/16 - 18				150	22	37	6.1		Yes	△	38
13905	W 3/8 - 16		OH3		150	24	41	7		—	△	51
13907	W 1/2 - 12				150	29	48	9		—	△	81

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13909	W 5/8 - 11	STD	OH3	5P	150	32	52	12	3	—	△	138
13910	W 3/4 - 10				150	37	58	14		—	△	195
13912	W 1 - 8				150	45	68	20		—	△	365

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1044

一般用 长柄型(左螺纹)

LONG SHANK· GENERAL APPLICATION(LH THREAD)

EX-LT-POT

标准刃倾角丝锥螺纹部悬长不足时使用本系列。

This tap is used when a standard spiral pointed tap is too short.

HSSE

螺纹种类：M(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21310	M3 ×0.5 - L	STD	OH2	5P	100	11	19	4	3	Yes	△	12
21318	M4 ×0.7 - L				100	13	21	5		Yes	△	16
21326	M5 ×0.8 - L				100	16	24	5.5		Yes	△	19
21334	M6 ×1 - L				100	19	29	6		Yes	△	21
21336					150					Yes	△	34

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21342	M8 ×1.25 - L	STD	OH3	5P	100	22	37	6.2	3	Yes	△	28
21344					150					Yes	△	40
21352	M10×1.5 - L				150	24	41	7		—	△	52
21368	M12×1.75 - L				150	29	48	8.5		—	△	75

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-LT-POT		○	○	○									○	○	○	○	○	◎	○	○	○					○

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

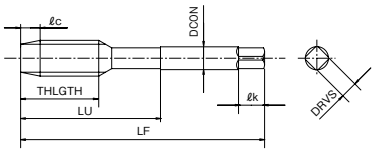
G-LIST No. | TH1021

一般用氧化处理

GENERAL APPLICATION (WITH OX)

EX-H-POT

HSSE | H



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16698	M 1.4 ×0.3	STD	OH1	5P	34	9	—	3	2	Yes	▲	3
16700	M 1.7 ×0.35				36	11	—	3		Yes	▲	3
16702	M 2 ×0.4				40	12	—	3		Yes	●	3
16704	M 2.3 ×0.4				42	13	—	3		Yes	●	3
16706	M 2.5 ×0.45	STD	OH2		44	14	—	3		Yes	●	4
16708	M 2.6 ×0.45				44	14	—	3		Yes	●	4
16710	M 3 ×0.5	STD	OH2		46	11	19	4	3	Yes	●	5
16711		STD+1	OH3							Yes	●	5
16712	M 3.5 ×0.6	STD	OH2		48	13	20	4		Yes	●	5
16713		STD+1	OH3							Yes	●	5
16714	M 4 ×0.7	STD	OH2		52	13	21	5		Yes	●	8
16715		STD+1	OH3							Yes	●	8
16718	M 5 ×0.8	STD	OH2		60	16	24	5.5		Yes	●	10
16719		STD+1	OH3							Yes	●	10
16722	M 6 ×1	STD	OH2		62	19	29	6		Yes	●	12
16723		STD+1	OH3							Yes	●	13
16728	M 8 ×1.25	STD	OH3		70	22	37	6.2		Yes	●	19
16729		STD+1	OH4							Yes	●	19
16730	M 8 ×1	STD	OH2		70	22	37	6.2		Yes	●	19
16734	M10 ×1.5	STD	OH3		75	24	41	7		—	●	27
16735		STD+1	OH4							—	●	27
16736	M10 ×1.25	STD	OH3		75	24	41	7		—	●	28
16737		STD+1	OH4							—	●	28
16738	M10 ×1	STD	OH3		75	24	41	7		—	●	28
16739	M12 ×1.75	STD	OH4		82	29	48	8.5		—	●	43
16740		STD+1	OH5							—	●	43
16742	M12 ×1.5	STD	OH3		82	29	48	8.5		—	●	43

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由 A-POT(P.657) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
16743	M12 ×1.5	STD+1	OH4	5P	82	29	48	8.5	3	—	●	44
16745	M12 ×1.25	STD	OH4		82	29	48	8.5		—	●	44
16746		STD+1	OH5							—	●	44
16747	M12 ×1	STD	OH3		82	29	48	8.5		—	●	45
16749	M14 ×2	STD	OH4		88	30	48	10.5		—	●	70
16751	M14 ×1.5	STD	OH3		88	30	48	10.5		—	●	70
16755	M16 ×2	STD	OH4		95	32	52	12.5		—	●	101
16757	M16 ×1.5	STD	OH3		95	32	52	12.5		—	●	100
16761	M18 ×2.5	STD	OH4		100	37	55	14		—	●	121
16763	M18 ×1.5				100	37	55	14		—	●	121
16767	M20 ×2.5				105	37	58	15		—	●	150
16769	M20 ×1.5				105	37	58	15		—	●	151
16773	M22 ×2.5				115	38	63	17		—	●	204
16775	M22 ×1.5				115	38	63	17		—	●	204
16779	M24 ×3				120	45	66	19		—	●	260
16781	M24 ×1.5				120	45	66	19		—	●	264
16785	M27 ×3				130	45	71	20		—	●	332
16787	M27 ×1.5				130	45	71	20		—	△	343
16791	M30 ×3.5	STD	OH5		135	48	74	23		—	●	435
16793	M30 ×1.5	STD	OH4		135	48	74	23		—	△	452
16851	M33 ×3.5	STD	OH5		145	51	77	25		—	●	563
16853	M33 ×1.5	STD	OH4		110	37	47	25		—	△	424
16855	M36 ×4	STD	OH5		155	57	82	28	4	—	●	717
16857	M36 ×1.5	STD	OH4		110	39	49	28		—	△	510
16859	M42 ×4.5	STD	OH5		175	60	93	32		—	●	1,075
16861	M42 ×1.5	STD	OH3		120	39	49	32		—	△	750

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by A-POT (p.657).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-H-POT	◎	○	○	○							○														○

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

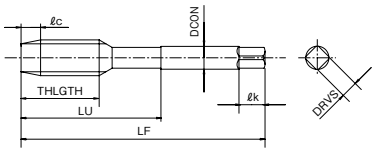
△=停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

一般用氧化处理 长柄型

LONG SHANK· GENERAL APPLICATION (WITH OX)

EX-LT-H-POT



HSSE H

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17110	M 3 ×0.5				100	11	19	4		Yes	●	11
17118	M 4 ×0.7				100	13	21	5		Yes	●	16
17126	M 5 ×0.8	STD	OH2		100	16	24	5.5		Yes	●	19
17134	M 6 ×1				100	19	29	6		Yes	●	24
17136					150					Yes	●	33
17142	M 8 ×1.25				100	22	37	6.2		Yes	●	27
17144					150					Yes	●	40
17152	M10 ×1.5				150	24	41	7		—	●	52
17168	M12 ×1.75			5P	150	29	48	8.5	3	—	●	75
17170					200					—	△	98
17176	M12 ×1.5				150	29	48	8.5		—	●	75
17184	M12 ×1.25	STD	OH3		150	29	48	8.5		—	●	74
79004	M14 ×2				150	30	48	10.5		—	●	107
79006					200					—	△	141
79012	M14 ×1.5				150	30	48	10.5		—	●	108
79020	M16 ×2				150	32	52	12.5		—	●	153
79022					200					—	▲	200
79028	M16 ×1.5				150	32	52	12.5		—	●	150

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲＝该产品已停止生产，由 A-LT-POT(P.662) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
79030	M16 ×1.5				200	32	52	12.5		—	△	200
79036	M18 ×2.5				150	37	55	14		—	●	186
79038					200					—	△	248
79044	M18 ×1.5				150	37	55	14		—	●	186
79046					200					—	△	248
79052	M20 ×2.5	STD	OH3		150	37	58	15		—	●	217
79054					200					—	▲	288
79060	M20 ×1.5				150	37	58	15		—	●	217
79062				5P	200				3	—	△	287
79068	M22 ×2.5				150	38	63	17		—	▲	275
79070					200					—	△	359
79076	M22 ×1.5				150	38	63	17		—	▲	271
79078					200					—	△	360
79084	M24 ×3	STD	OH4		150	45	66	19		—	▲	338
79086					200					—	▲	445
79092	M24 ×1.5	STD	OH3		150	45	66	19		—	▲	338
79094					200					—	△	445

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by A-LT-POT (p.662).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-LT-H-POT	◎	○	○	○							○														○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1094

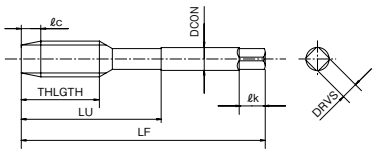
V涂层
V COATED

V-POT

HSSE | V

适用范围广，特别是在高速高稀释倍率水溶性切削油剂的条件下，可以发挥优异排屑性能。也可用于干式加工。

This tap is capable of a wide range of applications, on both soft or hard materials. It is particularly suited for high speed tapping (with a highly diluted water soluble oil). This tap is also suitable for dry tapping.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8310069	M 3 ×0.5	STD	OH2	5P	46	11	19	4	3	Yes	▲	5
8310070		STD+1	OH3							Yes	▲	5
8310076	M 3.5 ×0.6	STD	OH2		48	13	20	4		Yes	▲	5
8310077		STD+1	OH3							Yes	▲	5
8310083	M 4 ×0.7	STD	OH2		52	13	21	5		Yes	▲	8
8310084		STD+1	OH3							Yes	▲	7
8310090	M 5 ×0.8	STD	OH2		60	16	24	5.5		Yes	▲	11
8310091		STD+1	OH3							Yes	▲	11
8310097	M 6 ×1	STD	OH2		62	19	29	6		Yes	▲	13
8310098		STD+1	OH3							Yes	▲	12
8310107	M 8 ×1.25	STD	OH3		70	22	37	6.2		Yes	▲	19
8310108		STD+1	OH4							Yes	▲	19
8310111	M 8 ×1	STD	OH2		70	22	37	6.2		Yes	▲	19
8310112		STD+1	OH3							Yes	▲	19
8310117	M10 ×1.5	STD	OH3		75	24	41	7		—	▲	28
8310118		STD+1	OH4							—	▲	28
8310121	M10 ×1.25	STD	OH3		75	24	41	7		—	▲	28
8310122		STD+1	OH4							—	▲	28
8310124	M10 ×1	STD	OH3		75	24	41	7		—	▲	29
8310125		STD+1	OH4							—	▲	29

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲＝该产品已停止生产，由 A-POT(P.657) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8310130	M12 ×1.75	STD	OH4	5P	82	29	48	8.5	3	—	▲	44
8310131		STD+1	OH5							—	▲	44
8310134	M12 ×1.5	STD	OH3		82	29	48	8.5		—	▲	44
8310135		STD+1	OH4							—	▲	44
8310137	M12 ×1.25	STD	OH4		82	29	48	8.5		—	▲	44
8310138		STD+1	OH5							—	▲	44
8310140	M12 ×1	STD	OH3		82	29	48	8.5		—	▲	46
8310141		STD+1	OH4							—	▲	46
8310147	M14 ×2	STD	OH4		88	30	48	10.5		—	▲	70
8310150	M14 ×1.5	STD	OH3		88	30	48	10.5		—	▲	71
8310157	M16 ×2	STD	OH4		95	32	52	12.5		—	▲	100
8310160	M16 ×1.5	STD	OH3		95	32	52	12.5		—	▲	100
8310167	M18 ×2.5	STD	OH4		100	37	55	14		—	▲	121
8310170	M18 ×1.5				100	37	55	14		—	▲	122
8310177	M20 ×2.5				105	37	58	15		—	▲	151
8310180	M20 ×1.5				105	37	58	15		—	▲	153
8310187	M22 ×2.5				115	38	63	17		—	▲	207
8310190	M22 ×1.5				115	38	63	17		—	▲	207
8310197	M24 ×3				120	45	66	19		—	▲	262
8310200	M24 ×1.5				120	45	66	19		—	▲	264

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by A-POT (p.657).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
V-POT	◎	◎	◎	◎	○				◎	○	◎		◎	○	○	○	○	○	○	○	○	○				○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

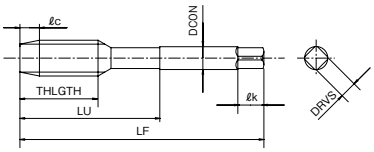
△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

V涂层 长柄型

V COATED · LONG SHANK

V-LT-POT



HSSE | V

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8316210	M 3 ×0.5	STD	OH2	5P	100	11	19	4	3	Yes	▲	11
8316213	M 4 ×0.7				100	13	21	5		Yes	▲	16
8316216	M 5 ×0.8				100	16	24	5.5		Yes	▲	19
8316219	M 6 ×1				100	19	29	6		Yes	▲	23
8316221					150					Yes	▲	34
8316223	M 8 ×1.25	STD	OH3		100	22	37	6.2		Yes	▲	28
8316225					150					Yes	▲	39
8316232	M10 ×1.5				150	24	41	7		—	▲	52
8316236	M10 ×1.25				150	24	41	7		—	▲	52
8316243	M12 ×1.75	STD	OH4		150	29	48	8.5		—	▲	75
8316247	M12 ×1.5	STD	OH3		150	29	48	8.5		—	▲	75
8316251	M12 ×1.25	STD	OH4		150	29	48	8.5		—	▲	75

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

▲=该产品已停止生产，由A-LT-POT(P.662),TIN-LT-POT(P.680)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8316258	M14 ×2	STD	OH4	5P	150	30	48	10.5	3	—	▲	109
8316262	M14 ×1.5	STD	OH3		150	30	48	10.5		—	▲	109
8316265	M16 ×2	STD	OH4		150	32	52	12.5		—	▲	151
8316269	M16 ×1.5	STD	OH3		150	32	52	12.5		—	▲	153
8316272	M18 ×2.5	STD	OH4		150	37	55	14		—	▲	188
8316275	M18 ×1.5				150	37	55	14		—	▲	189
8316278	M20 ×2.5				150	37	58	15		—	▲	218
8316281	M20 ×1.5				150	37	58	15		—	▲	220
8316285	M22 ×2.5				200	38	63	17		—	▲	367
8316288	M22 ×1.5				200	38	63	17		—	▲	368
8316291	M24 ×3				200	45	66	19		—	▲	453
8316294	M24 ×1.5				200	45	66	19		—	▲	453

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-LT-POT (p.662) and TIN-LT-POT (p.680).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
V-LT-POT	◎	◎	◎	◎	○				◎	○	◎		◎	○	○	○	○	○	○	○	○	○				○

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1074

TiN涂层

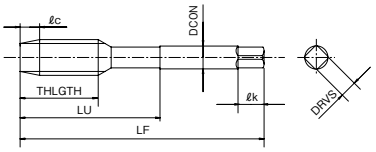
TiN COATED

TIN-POT

HSSE | TiN

适用范围广，特别是不锈钢、调质钢的通孔加工。

This tap is capable of tapping a wide range of materials, but is especially suited for high speed tapping of stainless steels and quenched and tempered steels.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10800	M 1.4×0.3	STD	OH1	5P	34	9	—	3	2	Yes	●	3
10802	M 1.7×0.35				36	11	—	3		Yes	●	3
10803	M 2 ×0.4				40	12	—	3		Yes	●	3
10805	M 2.3×0.4				42	13	—	3		Yes	●	3
10807	M 2.5×0.45	STD	OH2		44	14	—	3		Yes	●	3
10809	M 2.6×0.45				44	14	—	3		Yes	●	3
10811	M 3 ×0.5				46	11	19	4	3	Yes	●	5
10812	M 3.5×0.6				48	13	20	4		Yes	●	6
10814	M 4 ×0.7				52	13	21	5		Yes	●	7
10817	M 5 ×0.8				60	16	24	5.5		Yes	●	10
10820	M 6 ×1				62	19	29	6		Yes	●	12
10823	M 8 ×1.25	STD	OH3		70	22	37	6.2		Yes	●	19
10826	M10 ×1.5				75	24	41	7		—	●	27
10829	M10 ×1.25				75	24	41	7		—	●	28
10832	M12 ×1.75	STD	OH4		82	29	48	8.5		—	●	44
10835	M12 ×1.5	STD	OH3		82	29	48	8.5		—	●	44
10838	M12 ×1.25	STD	OH4		82	29	48	8.5		—	●	44
10845	M14 ×2				88	30	48	10.5		—	●	71
10847	M14 ×1.5	STD	OH3		88	30	48	10.5		—	●	72
10851	M16 ×2	STD	OH4		95	32	52	12.5		—	●	101

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10853	M16 ×1.5	STD	OH3	5P	95	32	52	12.5	3	—	●	101
10857	M18 ×2.5	STD	OH4		100	37	55	14		—	●	122
10859	M18 ×1.5				100	37	55	14		—	●	122
10863	M20 ×2.5				105	37	58	15		—	●	152
10865	M20 ×1.5				105	37	58	15		—	●	153
10869	M22 ×2.5				115	38	63	17		—	●	208
10871	M22 ×1.5				115	38	63	17		—	●	206
10875	M24 ×3				120	45	66	19		—	●	263
10877	M24 ×1.5				120	45	66	19		—	●	263
10879	M27 ×3				130	45	71	20		—	●	338
10881	M27 ×1.5				130	45	71	20		—	●	347
10883	M30 ×3.5	STD	OH5		135	48	74	23		—	●	439
10885	M30 ×1.5	STD	OH4		135	48	74	23		—	●	453
10887	M33 ×3.5	STD	OH5		145	51	77	25		—	●	567
10889	M33 ×1.5	STD	OH4		110	37	47	25		—	●	429
10891	M36 ×4	STD	OH5		155	57	82	28	4	—	●	723
10893	M36 ×1.5	STD	OH4		110	39	49	28		—	●	516
10895	M42 ×4.5	STD	OH5		175	60	93	32		—	●	1,096
10897	M42 ×1.5	STD	OH4		120	39	49	32		—	●	761

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

SynchroMaster

与A-TAP完美搭配的攻丝刀柄

※详情请参照 ▶P.831
See p.831 for details

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
TIN-POT	○	○	○	○	○				◎	○	○		○	○	○	○	○	○	○	○	○	○				○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

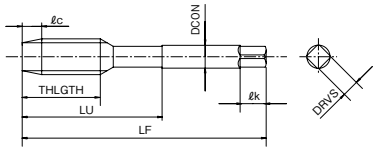
G-LIST No. | **TH1072**

TiN涂层 长柄型

TiN COATED · LONG SHANK

TIN-LT-POT

HSSE | TiN



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78810	**M 3 ×0.5**				100	11	19	4		Yes	●	11
78813	**M 4 ×0.7**				100	13	21	5		Yes	●	16
78816	**M 5 ×0.8**	STD	0H2		100	16	24	5.5		Yes	●	19
78819	**M 6 ×1**				100	19	29	6		Yes	●	24
78821					150					Yes	●	40
78823	**M 8 ×1.25**			5P	100	22	37	6.2	3	Yes	●	28
78825		STD	0H3		150					Yes	●	40
78832	**M10 ×1.5**				150	24	41	7		—	●	52
78836	**M10 ×1.25**				150	24	41	7		—	●	53
78843	**M12 ×1.75**	STD	0H4		150	29	48	8.5		—	●	75
78847	**M12 ×1.5**	STD	0H3		150	29	48	8.5		—	●	75
78851	**M12 ×1.25**	STD	0H4		150	29	48	8.5		—	●	76

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78858	**M14 ×2**	STD	0H4		150	30	48	10.5		—	●	108
78862	**M14 ×1.5**	STD	0H3		150	30	48	10.5		—	●	110
78865	**M16 ×2**	STD	0H4		150	32	52	12.5		—	●	152
78869	**M16 ×1.5**	STD	0H3		150	32	52	12.5		—	●	152
78872	**M18 ×2.5**				150	37	55	14		—	●	188
78875	**M18 ×1.5**				150	37	55	14		—	●	189
78878	**M20 ×2.5**			5P	150	37	58	15	3	—	●	219
78881	**M20 ×1.5**	STD	0H4		150	37	58	15		—	●	221
78885	**M22 ×2.5**				200	38	63	17		—	●	365
78888	**M22 ×1.5**				200	38	63	17		—	●	361
78891	**M24 ×3**				200	45	66	19		—	●	453
78894	**M24 ×1.5**				200	45	66	19		—	●	449

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
TIN-LT-POT	○	○	○	○	○				◎	○	○		○	○	○	○	○	○	○	○	○	○				○

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

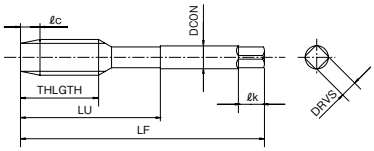
△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1039

难加工材料用
FOR DIFFICULT TO MACHINE MATERIALS

CPM-POT



CPM

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22098	M 1.4×0.3	STD	OH1	5P	34	9	—	3	2	Yes	●	3
22100	M 1.6×0.35	STD	OH2		36	10	—	3		Yes	●	3
22102	M 1.7×0.35				36	11	—	3		Yes	●	3
22104	M 2 ×0.4				40	12	—	3		Yes	●	3
22108	M 2.5×0.45				44	14	—	3		Yes	●	3
22110	M 2.6×0.45				44	14	—	3		Yes	●	3
22112	M 3 ×0.5	STD	OH3		46	11	19	4	3	Yes	●	4
22120	M 4 ×0.7				52	13	21	5		Yes	●	7
22126	M 5 ×0.8				60	16	24	5.5		Yes	●	11
22130	M 6 ×1				62	19	29	6		Yes	●	13
22138	M 8 ×1.25				70	22	37	6.2		Yes	●	19
22146	M10 ×1.5				75	24	41	7		—	●	28
22150	M10 ×1.25				75	24	41	7		—	●	29
22166	M12 ×1.75				82	29	48	8.5		—	●	44
22170	M12 ×1.5				82	29	48	8.5		—	●	45
22174	M12 ×1.25	STD	OH4		82	29	48	8.5		—	●	46
22178	M14 ×2				88	30	48	10.5		—	●	70
22182	M14 ×1.5	STD	OH3		88	30	48	10.5		—	●	70

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22186	M16 ×2	STD	OH4	5P	95	32	52	12.5	4	—	●	100
22190	M16 ×1.5	STD	OH3		95	32	52	12.5		—	●	100
22194	M18 ×2.5	STD	OH4		100	37	55	14		—	●	121
22198	M18 ×1.5				100	37	55	14		—	●	125
22202	M20 ×2.5				105	37	58	15		—	●	152
22206	M20 ×1.5				105	37	58	15		—	●	157
22210	M22 ×2.5				115	38	63	17		—	●	207
22214	M22 ×1.5				115	38	63	17		—	●	215
22218	M24 ×3				120	45	66	19		—	●	263
22222	M24 ×1.5				120	45	66	19		—	●	276
22226	M27 ×3				130	45	71	20		—	●	344
22230	M27 ×1.5				130	45	71	20		—	●	355
22234	M30 ×3.5				135	48	74	23		—	●	451
22238	M30 ×1.5				135	48	74	23		—	●	469
22240	M33 ×3.5	STD	OH5		145	51	77	25		—	●	581
22243	M36 ×4				155	57	82	28		—	●	758
22246	M42 ×4.5				175	60	93	32		—	●	1,132
22249	M48 ×5				185	67	98	38		—	●	1,619

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
CPM-POT			◎		◎	○				○	○	○	○						○			○	○			

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

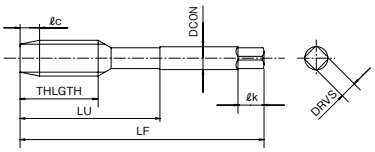
△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

难加工材料用 长柄型

LONG SHANK· FOR DIFFICULT TO MACHINE MATERIALS

CPM-LT-POT



CPM

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78610	M 3 ×0.5	STD	OH3	5P	100	11	19	4	3	Yes	●	12
78613	M 4 ×0.7				100	13	21	5		Yes	●	16
78616	M 5 ×0.8				100	16	24	5.5		Yes	●	20
78619	M 6 ×1				100	19	29	6		Yes	●	24
78621					150					Yes	●	34
78623	M 8 ×1.25				100	22	37	6.2		Yes	●	28
78625					150					Yes	●	41
78632	M10 ×1.5				150	24	41	7		—	●	53
78636	M10 ×1.25				150	24	41	7		—	●	54
78643	M12 ×1.75				150	29	48	8.5		—	●	76
78647	M12 ×1.5				150	29	48	8.5		—	●	76
78651	M12 ×1.25	STD	OH4		150	29	48	8.5		—	●	77

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78658	M14 ×2	STD	OH4	5P	150	30	48	10.5	3	—	●	111
78662	M14 ×1.5	STD	OH3		150	30	48	10.5		—	●	110
78665	M16 ×2	STD	OH4		150	32	52	12.5	4	—	●	152
78669	M16 ×1.5	STD	OH3		150	32	52	12.5		—	●	154
78672	M18 ×2.5	STD	OH4		150	37	55	14		—	●	186
78675	M18 ×1.5				150	37	55	14		—	●	193
78678	M20 ×2.5				150	37	58	15		—	●	220
78681	M20 ×1.5				150	37	58	15		—	●	226
78685	M22 ×2.5				200	38	63	17		—	●	367
78688	M22 ×1.5				200	38	63	17		—	●	376
78691	M24 ×3				200	45	66	19		—	●	452
78694	M24 ×1.5				200	45	66	19		—	●	446

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
CPM-LT-POT			◎		◎	○				○	○	○	○						○			○	○		

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

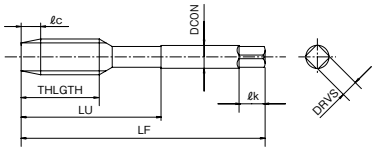
G-LIST No. | TH1028

不锈钢用
FOR STAINLESS STEELS

EX-SUS-POT

HSSE | H

适用于不锈钢、铜、热塑性塑料的通孔加工。
Suitable for tapping through holes in materials such as stainless steels, copper and thermo plastic.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15010	M 1.4×0.3	STD	OH1	4P	34	9	—	3	2	Yes	●	3
15013	M 1.6×0.35				36	10	—	3		Yes	●	3
15015	M 1.7×0.35				36	11	—	3		Yes	●	3
15019	M 2 ×0.4				40	12	—	3		Yes	●	3
15025	M 2.3×0.4				42	13	—	3		Yes	●	3
15027	M 2.5×0.45	STD	OH2		44	14	—	3		Yes	●	4
15029	M 2.6×0.45				44	14	—	3		Yes	●	4
24210	M 3 ×0.6				46	11	19	4	3	Yes	●	5
14125	M 3 ×0.5	STD	OH2		46	11	19	4		Yes	●	4
24213		STD+2	OH4							Yes	●	5
24214	M 3.5×0.6	STD	OH2		48	13	20	4		Yes	●	5
24215	M 4 ×0.75				52	13	21	5		Yes	●	8
14130	M 4 ×0.7	STD	OH2		52	13	21	5		Yes	●	7
24218		STD+2	OH4							Yes	●	8
24219	M 5 ×0.9	STD	OH2		60	16	24	5.5		Yes	●	11
14135	M 5 ×0.8	STD	OH2		60	16	24	5.5		Yes	●	10
24222		STD+2	OH4							Yes	●	11
14139	M 6 ×1	STD	OH2		62	19	29	6		Yes	●	13
24226		STD+2	OH4							Yes	●	13
14147	M 8 ×1.25	STD	OH3		70	22	37	6.2	3	Yes	●	19
24233		STD+2	OH5							Yes	●	19
24234	M 8 ×1	STD	OH2		70	22	37	6.2		Yes	●	19
14157	M10 ×1.5	STD	OH3		75	24	41	7		—	●	27
24243		STD+2	OH5							—	●	28
14159	M10 ×1.25	STD	OH3		75	24	41	7		—	●	27
24245		STD+2	OH5							—	●	28
24246	M10 ×1	STD	OH3		75	24	41	7		—	●	28
14169	M12 ×1.75	STD	OH3		82	29	48	8.5		—	●	43
24255		STD+2	OH5							—	●	43
24256	M12 ×1.5	STD	OH3		82	29	48	8.5		—	●	44
24257		STD+2	OH5							—	●	44
24258	M12 ×1.25	STD	OH3		82	29	48	8.5		—	●	43
24259		STD+2	OH5							—	●	44
24260	M12 ×1	STD	OH3		82	29	48	8.5		—	●	43

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24268	M14 ×2	STD	OH3	4P	88	30	48	10.5	3	—	●	70
24269		STD+2	OH5							—	●	70
24270	M14 ×1.5	STD	OH3		88	30	48	10.5		—	●	71
24272		STD+2	OH5							—	●	70
24276	M16 ×2	STD	OH3		95	32	52	12.5		—	●	101
24277		STD+2	OH5							—	●	100
24278	M16 ×1.5	STD	OH3		95	32	52	12.5		—	●	99
24280		STD+2	OH5							—	●	100
24284	M18 ×2.5	STD	OH3		100	37	55	14		—	●	120
24285		STD+2	OH5							—	●	120
24286	M18 ×1.5	STD	OH3		100	37	55	14		—	●	121
24288		STD+2	OH5							—	●	121
24292	M20 ×2.5	STD	OH3		105	37	58	15		—	●	151
24294		STD+2	OH5							—	●	152
24296	M20 ×1.5	STD	OH3		105	37	58	15		—	●	153
24297		STD+2	OH5							—	●	152
24300	M22 ×2.5	STD	OH4		115	38	63	17		—	●	208
24301		STD+2	OH6							—	●	205
24302	M22 ×1.5	STD	OH4		115	38	63	17		—	●	204
24303		STD+2	OH6							—	●	205
24304	M24 ×3	STD	OH4		120	45	66	19		—	●	260
24305		STD+2	OH6							—	●	260
24306	M24 ×1.5	STD	OH4		120	45	66	19		—	●	263
24307		STD+2	OH6							—	●	261
24308	M27 ×3	STD	OH4		130	45	71	20		—	●	341
24310	M27 ×1.5				130	45	71	20		—	●	344
24312	M30 ×3.5	STD	OH5		135	48	74	23		—	●	432
24314	M30 ×1.5	STD	OH4		135	48	74	23		—	●	447
24981	M33 ×3.5	STD	OH5		145	51	77	25		—	●	570
24983	M33 ×1.5	STD	OH4		110	37	47	25		—	●	427
24985	M36 ×4	STD	OH5		155	57	82	28	4	—	●	722
24987	M36 ×1.5	STD	OH4		110	39	49	28		—	●	517
24989	M42 ×4.5	STD	OH5		175	60	93	32		—	●	1,078
24991	M42 ×1.5	STD	OH4		120	39	49	32		—	●	763

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

不锈钢用
FOR STAINLESS STEELS

EX-SUS-POT

HSSE | H

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15162	No. 4- 40UNC	STD	OH2	4P	44	15	21	3	2	Yes	●	4
15163	No. 4- 48UNF				44	15	21	3		Yes	●	3
15166	No. 5- 40UNC				46	11	19	4	3	Yes	●	5
15167	No. 5- 44UNF				46	11	19	4		Yes	●	5
15170	No. 6- 32UNC				48	13	21	4		Yes	●	5
15171	No. 6- 40UNF				48	13	21	4		Yes	●	5
15174	No. 8- 32UNC				52	13	21	5		Yes	●	8
15175	No. 8- 36UNF				52	13	21	5		Yes	●	8
15178	No. 10- 24UNC				60	16	24	5.5		Yes	●	10
15179	No. 10- 32UNF				60	16	24	5.5		Yes	●	10
15185	1/4- 20UNC	STD	OH3		62	19	29	6		Yes	●	12
15186	1/4- 28UNF	STD	OH2		62	19	29	6		Yes	●	13
15189	5/16- 18UNC	STD	OH3		70	22	37	6.1		Yes	●	18
15190	5/16- 24UNF	STD	OH2		70	22	37	6.1		Yes	●	19

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15193	3/8- 16UNC	STD	OH3	4P	75	24	41	7	3	—	●	26
15194	3/8- 24UNF	STD	OH2		75	24	41	7		—	●	27
15197	7/16- 14UNC	STD	OH3		80	25	48	8		—	●	37
15198	7/16- 20UNF				80	25	48	8		—	●	38
15202	1/2- 13UNC				85	29	48	9		—	●	51
15205	1/2- 20UNF				85	29	48	9		—	●	51
15208	5/8- 11UNC				95	32	52	12		—	●	93
15209	5/8- 18UNF				95	32	52	12		—	●	93
15212	3/4- 10UNC				105	37	58	14		—	●	136
15213	3/4- 16UNF				105	37	58	14		—	●	133
15216	7/8- 9UNC	STD	OH4		115	38	63	17		—	●	204
15217	7/8- 14UNF	STD	OH3		115	38	63	17		—	●	204
15220	1- 8UNC	STD	OH4		125	45	68	20		—	●	302
15221	1- 12UNF	STD	OH3		125	45	68	20		—	●	300

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-SUS-POT									◎					◎											◎

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1028

不锈钢用
FOR STAINLESS STEELS

EX-SUS-POT

HSSE | H

螺纹种类：W

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24451	W 1/8 - 40	STD	OH2	4P	46	11	19	4	3	Yes	●	4
24452	W 3/16 - 24				60	16	24	5.5		Yes	●	10
24453	W 1/4 - 20		OH3		62	19	29	6		Yes	●	13
24454	W 5/16 - 18				70	22	37	6.1		Yes	●	18
24455	W 3/8 - 16				75	24	41	7		—	●	26

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24457	W 1/2 - 12	STD	OH3	4P	85	29	48	9	3	—	●	50
24459	W 5/8 - 11				95	32	52	12		—	●	93
24460	W 3/4 - 10				105	37	58	14		—	●	136
24461	W 7/8 - 9		OH4		115	38	63	17		—	●	207
24462	W 1 - 8				125	45	68	20		—	●	304

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

再研磨 · 再涂层

可一次性接受。实现和新品一样的性能。

※详情请参照▶P.9
See p.9 for details

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-SUS-POT									◎					◎											◎

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

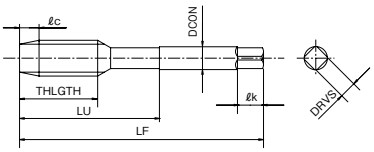
△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

不锈钢用 长柄型

LONG SHANK· FOR STAINLESS STEELS

EX-LT-SUS-POT



HSSE H

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15801	M 3 ×0.5	STD	OH2	4P	100	11	19	4	3	Yes	●	11
15803					150					Yes	●	15
15805	M 4 ×0.7				100	13	21	5		Yes	●	16
15807					150					Yes	●	23
15809	M 5 ×0.8				100	16	24	5.5		Yes	●	19
15811					150					Yes	●	28
15813	M 6 ×1				100	19	29	6		Yes	●	23
15815					150					Yes	●	33
15818	M 8 ×1.25	STD	OH3		100	22	37	6.2		Yes	●	28
15820					150					Yes	●	40
15827	M10 ×1.5				100	24	41	7		—	●	36
15829					150					—	●	51
15832	M10 ×1.25				100	24	41	7		—	●	37
15834					150					—	●	52
15843	M12 ×1.75				150	29	48	8.5		—	●	75
15844					200					—	△	96
15848	M12 ×1.5				150	29	48	8.5		—	●	75

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15849	M12 ×1.5	STD	OH3	4P	200	29	48	8.5	3	—	△	95
15853	M12 ×1.25				150	29	48	8.5		—	●	74
15854					200					—	△	96
15860	M14 ×2				150	30	48	10.5		—	●	108
15861					200					—	△	141
15864	M14 ×1.5				150	30	48	10.5		—	●	107
15865					200					—	△	142
15868	M16 ×2				200	32	52	12.5		—	●	201
15872	M16 ×1.5				200	32	52	12.5		—	△	201
15875	M18 ×2.5				200	37	55	14		—	●	250
15878	M18 ×1.5				200	37	55	14		—	△	242
15881	M20 ×2.5				200	37	58	15		—	●	287
15884	M20 ×1.5				200	37	58	15		—	△	281
15887	M22 ×2.5	STD	OH4		200	38	63	17		—	●	362
15890	M22 ×1.5				200	38	63	17		—	△	361
15893	M24 ×3				200	45	66	19		—	●	446
15896	M24 ×1.5				200	45	66	19		—	△	435

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-LT-SUS-POT									◎					◎											◎

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1059

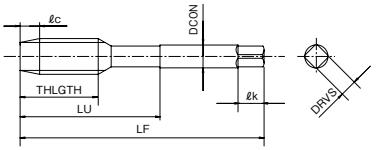
深孔用
FOR DEEP HOLES

EX-DH-POT

HSSE | H

适用于深的通孔攻丝。

For tapping deep through holes, especially in materials that are prone to seizure during machining.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17386	M 2 ×0.4	STD	OH1	5P	40	6	16	3	2	Yes	●	3
17392	M 2.3×0.4				42	6	15	3		Yes	●	3
17395	M 2.5×0.45				44	7	16	3		Yes	●	4
17398	M 2.6×0.45	STD	OH2		44	7	16	3		Yes	●	3
17401	M 3 ×0.6				46	9	19	4		Yes	△	5
17402		STD+1	OH3							Yes	△	5
17405	M 3 ×0.5	STD	OH2		46	9	19	4		Yes	●	4
17406		STD+1	OH3							Yes	●	4
17412	M 3.5×0.6	STD	OH2		48	9	20	4		Yes	▲	5
17413		STD+1	OH3							Yes	▲	5
17425	M 4 ×0.75	STD	OH2		52	10	21	5		Yes	△	7
17426		STD+1	OH3							Yes	△	7
17429	M 4 ×0.7	STD	OH2		52	10	21	5		Yes	●	7
17430		STD+1	OH3							Yes	●	8
17449	M 5 ×0.9	STD	OH2		60	11	24	5.5		Yes	△	11
17450		STD+1	OH3							Yes	△	11
17453	M 5 ×0.8	STD	OH2	4P	60	11	24	5.5		Yes	●	10
17454		STD+1	OH3							Yes	●	10
17469	M 6 ×1	STD	OH2		62	12	29	6	3	Yes	●	12
17470		STD+1	OH3							Yes	●	13
17486	M 8 ×1.25	STD	OH3		70	13	37	6.2		Yes	●	19
17487		STD+1	OH4							Yes	●	19
17489	M 8 ×1	STD	OH2		70	13	37	6.2		Yes	▲	19
17490		STD+1	OH3							Yes	▲	19
17510	M10 ×1.5	STD	OH3		75	15	41	7		—	●	27
17511		STD+1	OH4							—	●	27
17514	M10 ×1.25	STD	OH3		75	15	41	7		—	●	27
17515		STD+1	OH4							—	●	27
17518	M10 ×1	STD	OH3		75	15	41	7		—	▲	27
17519		STD+1	OH4							—	▲	27
17539	M12 ×1.75	STD	OH4		82	18	48	8.5		—	●	42
17540		STD+1	OH5							—	●	42
17542	M12 ×1.5	STD	OH3		82	18	48	8.5		—	●	43

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲＝该产品已停止生产，由 A-POT(P.657),EX-H-POT(P.675) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17543	M12 ×1.5	STD+1	OH4	4P	82	18	48	8.5	3	—	●	42
17547	M12 ×1.25	STD	OH4		82	18	48	8.5		—	▲	43
17548		STD+1	OH5							—	▲	42
17550	M12 ×1	STD	OH3		82	18	48	8.5		—	▲	42
17551		STD+1	OH4							—	▲	46
17567	M14 ×2	STD	OH4		88	20	48	10.5		—	●	69
17568		STD+1	OH5							—	●	69
17570	M14 ×1.5	STD	OH3		88	20	48	10.5		—	●	70
17571		STD+1	OH4							—	●	70
17591	M16 ×2	STD	OH4		95	20	52	12.5		—	●	99
17592		STD+1	OH5							—	●	97
17594	M16 ×1.5	STD	OH3		95	20	52	12.5		—	●	100
17595		STD+1	OH4							—	●	100
17611	M18 ×2.5	STD	OH4		100	25	55	14	3	—	▲	120
17612		STD+1	OH5							—	▲	123
17619	M18 ×1.5	STD	OH4		100	25	55	14		—	▲	123
17620		STD+1	OH5							—	▲	122
17630	M20 ×2.5	STD	OH3		105	25	58	15		—	▲	150
17636	M20 ×1.5				105	25	58	15		—	▲	150
17647	M22 ×2.5				115	25	63	17		—	▲	204
17653	M22 ×1.5				115	25	63	17		—	▲	203
17664	M24 ×3	STD	OH4		120	30	66	19		—	▲	264
17671	M24 ×1.5	STD	OH3		120	30	66	19		—	▲	261
17682	M27 ×3	STD	OH4		130	30	71	20		—	▲	335
17686	M27 ×1.5	STD	OH3		130	30	71	20		—	▲	348
17693	M30 ×3.5	STD	OH4		135	35	74	23		—	▲	432
17698	M30 ×1.5	STD	OH3		135	35	74	23		—	▲	441
17787	M33 ×3.5	STD	OH4		145	35	77	25		—	▲	564
17789	M33 ×1.5	STD	OH3		110	20	47	25		—	▲	416
17791	M36 ×4	STD	OH4		155	40	82	28	4	—	▲	736
17793	M36 ×1.5	STD	OH3		110	20	49	28		—	▲	514
17795	M42 ×4.5	STD	OH5		175	45	93	32		—	▲	1,080
17797	M42 ×1.5	STD	OH3		120	20	49	32		—	▲	770

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by A-POT (p.657) and EX-H-POT (p.675).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-DH-POT	◎	◎		○							○														○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

△＝停产产品(请确认库存。) Discontinued item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

深孔用
FOR DEEP HOLES

EX-DH-POT

HSSE | H

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削深长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21701	No. 4-40UNC	STD	OH2	4P	44	8	16	3	2	Yes	△	4
21703	No. 4-48UNF				44	8	16	3		Yes	△	4
21705	No. 5-40UNC				46	8	19	4	3	Yes	▲	5
21707	No. 5-44UNF				46	8	19	4		Yes	△	5
21709	No. 6-32UNC				48	8	21	4		Yes	▲	6
21711	No. 6-40UNF				48	8	21	4		Yes	△	6
21713	No. 8-32UNC				52	10	21	5		Yes	▲	8
21715	No. 8-36UNF				52	10	21	5		Yes	△	8
21717	No.10-24UNC				60	11	24	5.5		Yes	▲	10
21719	No.10-32UNF				60	11	24	5.5		Yes	△	10

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。
1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。
▲=该产品已停止生产，由A-POT(P.660)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削深长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21725	1/4-20UNC	STD	OH3	4P	62	12	29	6	3	Yes	▲	13
21727	1/4-28UNF	STD	OH2		62	12	29	6		Yes	▲	13
21729	5/16-18UNC	STD	OH3		70	14	37	6.1		Yes	▲	18
21731	5/16-24UNF				70	14	37	6.1		Yes	▲	18
21733	3/8-16UNC				75	16	41	7		—	▲	26
21735	3/8-24UNF				75	16	41	7		—	▲	26
21737	7/16-14UNC				80	18	48	8		—	▲	37
21739	7/16-20UNF				80	18	48	8		—	▲	37
21741	1/2-13UNC				85	20	48	9		—	▲	50
21743	1/2-20UNF				85	20	48	9		—	▲	50

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
▲=The products have been stopped producing and replaced by A-POT(p.660).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-DH-POT	◎	◎		○							○														○

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

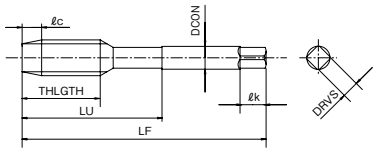
G-LIST No. | TH1097

深孔用 长柄型

LONG SHANK· FOR DEEP HOLES

EX-LT-DH-POT

HSSE | H



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
13950	M 3 ×0.5	STD	OH2	4P	120	9	59	4	3	Yes	●	10
13952	M 4 ×0.7	STD	OH2	4P	120	10	60	5	3	Yes	●	14
13954	M 5 ×0.8	STD	OH2	4P	120	11	61	5.5	3	Yes	●	20
13956	M 6 ×1	STD	OH2	4P	120	12	62	6	3	Yes	●	24
13958	M 8 ×1.25	STD	OH3	4P	150	13	63	6.2	3	Yes	●	39
13960	M 10 ×1.5	STD	OH3	4P	150	15	65	7	3	—	●	51
13962	M 10 ×1.25	STD	OH3	4P	150	15	65	7	3	—	●	51
13964	M 12 ×1.75	STD	OH3	4P	150	18	68	8.5	3	—	●	73
13966	M 12 ×1.5	STD	OH3	4P	150	18	68	8.5	3	—	●	74
13968	M 12 ×1.25	STD	OH3	4P	150	18	68	8.5	3	—	●	73
15231	M 14 ×2	STD	OH4	4P	150	20	70	10.5	3	—	▲	105

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由 A-LT-POT(P.662)、EX-LT-H-POT(P.676)、TIN-LT-POT(P.680) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15237	M 14 ×1.5	STD	OH3	4P	150	20	70	10.5	3	—	▲	106
15240	M 16 ×2	STD	OH4	4P	150	20	70	12.5	3	—	▲	150
15244	M 16 ×1.5	STD	OH3	4P	150	20	70	12.5	3	—	▲	148
15247	M 18 ×2.5	STD	OH4	4P	150	25	75	14	3	—	▲	185
15250	M 18 ×1.5	STD	OH4	4P	150	25	75	14	3	—	▲	185
15253	M 20 ×2.5	STD	OH3	4P	150	25	75	15	3	—	▲	214
15256	M 20 ×1.5	STD	OH3	4P	150	25	75	15	3	—	▲	214
15260	M 22 ×2.5	STD	OH3	4P	200	25	75	17	3	—	▲	359
15263	M 22 ×1.5	STD	OH3	4P	200	25	75	17	3	—	▲	359
15266	M 24 ×3	STD	OH4	4P	200	30	80	19	3	—	▲	445
15269	M 24 ×1.5	STD	OH3	4P	200	30	80	19	3	—	▲	448

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by A-LT-POT (p.662) and EX-LT-H-POT (p.676) and TIN-LT-POT (p.680).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-LT-DH-POT	◎	◎		○							○														○

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1024

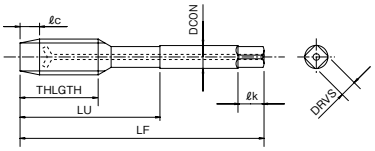
内冷油孔型

WITH INTERNAL COOLANT SUPPLY

OIL-POT

用于水平的通孔，深孔的加工。由于切削油剂作用于刀刃，使高速高精度的攻丝成为可能。

Effective for horizontal deep hole tapping of through holes. Because cutting fluid is sufficiently applied to the cutting edges, high speed, precise operation is possible.



HSS　H

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10350	M 6 ×1	STD	OH2	4P	80	19	28	6	3	—	●	16
10351					100					—	●	22
10352					120					—	●	26
10356	M 8 ×1.25	STD	OH3		80	22	31	6.2		—	●	19
10357					100					—	●	25
10358					120					—	●	30
10364	M10×1.5				80	24	34	7		—	●	27
10366					120					—	●	40
10367					150					—	●	48
10371	M10×1.25				120	24	34	7		—	●	40
10379	M12×1.75				100	29	41	8.5		—	●	50
10380					120					—	●	55
10381					150					—	●	70
10384	M12×1.5				120	29	41	8.5		—	●	55
10388	M12×1.25				120	29	41	8.5		—	●	55
10395	M14×2				100	30	43	10.5		—	●	74
10397					150					—	●	100
10402	M14×1.5				150	30	43	10.5		—	●	100
10405	M16×2				100	32	45	12.5		—	●	100
10407					150					—	●	188

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 每个油槽各有一个油孔
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10408	M16×2	STD	OH3	4P	200	32	45	12.5	3	—	●	188
10412	M16×1.5				150	32	45	12.5		—	●	145
10415	M18×2.5				100	37	49	14		—	●	116
10417					150					—	△	178
10421	M18×1.5				150	37	49	14		—	●	176
10424	M20×2.5				120	37	50	15		—	●	164
10425					150					—	●	207
10426					200					—	●	274
10429	M20×1.5				150	37	50	15		—	△	210
10432	M22×2.5				120	38	51	17		—	●	200
10433					150					—	●	255
10437	M22×1.5				150	38	51	17		—	△	254
10440	M24×3	STD	OH4		120	45	59	19		—	●	251
10441					150					—	●	315
10442					200					—	●	421
10445	M24×1.5	STD	OH3		150	45	59	19		—	△	317
10448	M27×3	STD	OH4		150	45	63	20		—	●	365
10450					250					—	●	625
10454	M30×3.5				150	48	67	23		—	●	464
10456					250					—	●	793

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Each flute has its own oil hole.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
OIL-POT	◎	◎	○	◎							◎		○	○	○	○	○									○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1064

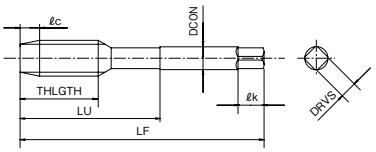
薄板用
FOR SHEET STEELS

EX-SS-POT

HSSE | H

抗拉强度700N/mm²以下的软钢薄板(通孔)的攻丝加工的最佳选择。可抑制毛刺、毛屑的产生，得到精美的内螺纹。

For tapping through holes in soft/mild sheet steels with tensile strength below 700N/㎟. This tap is especially desinged to prevent torn thread, burrs and splinters from punched holes or burred holes. It produces a smooth machined surface.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17708	M 1.4 ×0.3	STD	OH2	5P	34	9	—	3	2	Yes	▲	3
17712	M 1.7 ×0.35				36	11	—	3		Yes	▲	3
17714	M 2 ×0.4				40	12	—	3		Yes	●	3
17716	M 2.3 ×0.4				42	13	—	3		Yes	●	3
17718	M 2.5 ×0.45				44	14	—	3		Yes	●	4
17720	M 2.6 ×0.45				44	14	—	3		Yes	●	4
17722	M 3 ×0.5	STD	OH3		46	11	19	4		Yes	●	4
17725	M 3.5 ×0.6				48	13	20	4		Yes	●	5
17726	M 4 ×0.7				52	13	21	5		Yes	●	7
17728	M 5 ×0.8				60	16	24	5.5		Yes	●	10
17730	M 6 ×1				62	19	29	6		Yes	●	12
18980	M 8 ×1.25				70	22	37	6.2		Yes	●	19
18981	M 8 ×1				70	22	37	6.2		Yes	▲	19
18983	M10 ×1.5	STD	OH4		75	24	41	7		—	●	27

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS 请参考P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。
▲=该产品已停止生产，由EX-SUS-POT(P.683)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
18984	M10 ×1.25	STD	OH4	5P	75	24	41	7	2	—	●	27
18985	M10 ×1	STD	OH3		75	24	41	7		—	▲	29
18987	M12 ×1.75	STD	OH4		82	29	48	8.5		—	●	44
18988	M12 ×1.5				82	29	48	8.5		—	●	44
18989	M12 ×1.25				82	29	48	8.5		—	▲	44
18990	M12 ×1	STD	OH3		82	29	48	8.5		—	▲	45
18991	M14 ×2	STD	OH4		88	30	48	10.5		—	▲	71
18992	M14 ×1.5				88	30	48	10.5		—	▲	72
18993	M16 ×2				95	32	52	12.5		—	▲	101
18994	M16 ×1.5				95	32	52	12.5		—	▲	102
18995	M18 ×2.5				100	37	55	14		—	▲	122
18996	M18 ×1.5				100	37	55	14		—	▲	128
18997	M20 ×2.5				105	37	58	15		—	▲	152
18998	M20 ×1.5				105	37	58	15		—	▲	155

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
▲=The products have been stopped producing and replaced by EX-SUS-POT(p.683).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-SS-POT	◎								○					○												

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

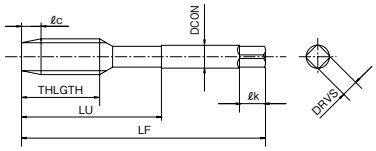
铜用
FOR COPPER

CU-POT

HSSE | CrN

丝锥表面带有CrN 涂层，具有优良的耐磨性，抗溶着性好。刀具材料采用了HSSE，铜加工中实现刀具长寿命。

Employs CrN coating for superior wear and welding resistance, especially when working with copper materials. The HSSE body (vanadium high speed steel) provides extended tool life.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
28860	M 3×0.5	STD	OH2	5P	46	11	19	4	3	Yes	●	5
28863	M 4×0.7				52	13	21	5		Yes	●	8
28866	M 5×0.8				60	16	24	5.5		Yes	●	11
28869	M 6×1				62	19	29	6		Yes	●	13
28872	M 8×1.25	STD	OH3		70	22	40.5	6.2		Yes	●	19
28874	M 8×1	STD	OH2		70	22	40.5	6.2		Yes	●	19
28876	M10×1.5	STD	OH3		75	24	41	7		—	●	27

■突顶尖长·柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
28878	M10×1.25	STD	OH3	5P	75	24	41	7	3	—	●	28
28880	M10×1				75	24	41	7		—	●	28
28882	M12×1.75	STD	OH4		82	29	48	8.5		—	●	43
28884	M12×1.5	STD	OH3		82	29	48	8.5		—	●	43
28886	M12×1.25	STD	OH4		82	29	48	8.5		—	●	44
28888	M12×1	STD	OH3		82	29	48	8.5		—	●	45

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
CU-POT									○					◎	○	○			○						

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1137

钛合金用
FOR TITANIUM ALLOY

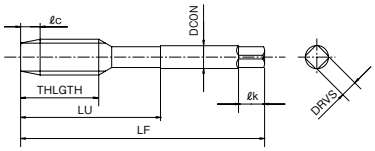
V-TI-POT

切削条件 Cutting Conditions | P.842

CPM | V

适用于航空工业、化学工业中经过时效处理的硬度为40 ~ 45HRC的钛合金(Ti-6Al-4V)等加工。具有寿命长，效率高、稳定性好的特点。

This tap provides high performance and longer tool life when tapping titanium alloy steels (Ti-6Al-4V etc.), which are used in the aerospace and chemical industries. These materials have a hardness of 40 ~ 45 HRC after the process of age hardening by solution treatment.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
28760	M 3 ×0.5	STD	OH3	5P	46	18	19	4	3	Yes	●	5
28763	M 4 ×0.7				52	20	21	5		Yes	●	8
28766	M 5 ×0.8				60	22	29	5.5		Yes	●	11
28769	M 6 ×1				62	24	—	6		Yes	●	14
28772	M 8 ×1.25				70	22	39.5	7		Yes	●	22
28774	M 8 ×1				70	22	39.5	7		Yes	●	22
28776	M10×1.5				75	24	41	8.5		—	●	25

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
28778	M10×1.25	STD	OH3	5P	75	24	41	8.5	3	—	●	35
28780	M10×1				75	24	41	8.5		—	●	36
28782	M12×1.75	STD	OH4		82	29	43	10.5		—	●	55
28784	M12×1.5	STD	OH3		82	29	43	10.5		—	●	55
28786	M12×1.25	STD	OH4		82	29	43	10.5		—	●	56
28788	M12×1	STD	OH3		82	29	43	10.5		—	●	56

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8316633	No. 6 -32UNJC	STD	OH2	5P	48	18	26	4	3	Yes	●	6
8316636	No. 6 -40UNJF				48	18	26	4		Yes	●	5
8316640	No. 8 -32UNJC				52	20	21	5		Yes	●	8
8316642	No. 8 -36UNJF				52	20	21	5		Yes	●	8
8316646	No.10 -24UNJC				60	22	29	5.5		Yes	●	10
8316649	No.10 -32UNJF				60	22	29	5.5		Yes	●	11
8316658	1/4 -20UNJC	STD	OH3		62	24	—	6		Yes	●	14
8316661	1/4 -28UNJF	STD	OH2		62	24	—	6		Yes	●	15

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8316667	5/16 -18UNJC	STD	OH3	5P	70	22	36	7	3	Yes	●	21
8316670	5/16 -24UNJF				70	22	36	7		Yes	●	22
8316676	3/8 -16UNJC				75	24	41	8.5		—	●	33
8316682	3/8 -24UNJF				75	24	41	8.5		—	●	33
8316691	7/16 -14UNJC				80	25	40	10.5		—	●	50
8316694	7/16 -20UNJF				80	25	40	10.5		—	●	51
8316700	1/2 -13UNJC	STD	OH4		85	29	45	10.5		—	●	60
8316706	1/2 -20UNJF	STD	OH3		85	29	45	10.5		—	●	61

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
V-TI-POT						○																◎				

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

△=停产产品(请确认库存。) Discontinued item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | **TH1179**

HR涂层 镍基超耐热合金用

HR COATED FOR NICKEL ALLOY

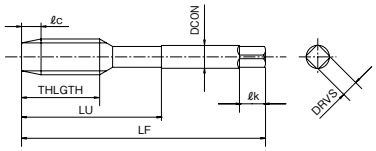
WHR-NI-POT

切削条件 Cutting Conditions | P.842

针对镍基合金，采用耐溶着性较高的HR涂层。针对时效处理后的镍基合金，丝锥寿命长，可以获得稳定的加工。

HR Coating is effective with anti-welding character against Nickel Alloy steels. HR Coating shows long tool life against Nickel Alloy steel with aging treated HRC40 ~ 45.

CPM HR



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突颈尖 External Center	库存 Stock	重量 (g)
3901210	M3 ×0.5	STD	OH3	5P	46	18	19	4	3	Yes	●	5
3901213	M4 ×0.7				52	20	21	5		Yes	●	7
3901216	M5 ×0.8				60	22	29	5.5		Yes	●	11
3901219	M6 ×1				62	24	—	6		Yes	●	14
3901222	M 8×1.25				70	22	36	7		Yes	●	22
3901226	M10×1.5				75	24	41	8.5		—	●	34
3901232	M12×1.75				82	29	43	10.5		—	●	55

■突颈尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突颈尖 External Center	库存 Stock	重量 (g)
3901246	No. 8-32UNJC	GH3	5P	52	20	21	5	3	Yes	●	8
3901255	No.10-32UNJF	GH3		60	22	29	5.5		Yes	●	11
3901267	1/4-28UNJF	GH4		62	24	—	6		Yes	●	14
3901273	5/16-24UNJF	GH4		70	22	36	7		Yes	●	22
3901279	3/8-24UNJF	GH4	5P	75	24	41	8.5	3	—	●	33
3901285	7/16-20UNJF	GH5		80	25	40	10.5		—	●	51
3901291	1/2-20UNJF	GH5		85	29	45	10.5		—	●	63

■突颈尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

GH 精度 GH LIMIT

为了与高精度要求的飞机零件螺纹加工相对应，采用了比OH精度公差带更窄的GH精度。

Applied tighter torerance GH limits to satisfy high precision demand from Aerospace parts threading operation.

GH1, 2 GH1,2

上公差：0.013×n upper limit : 0.013×n

下公差：上公差−0.013 lower limit : (upper limit) −0.013

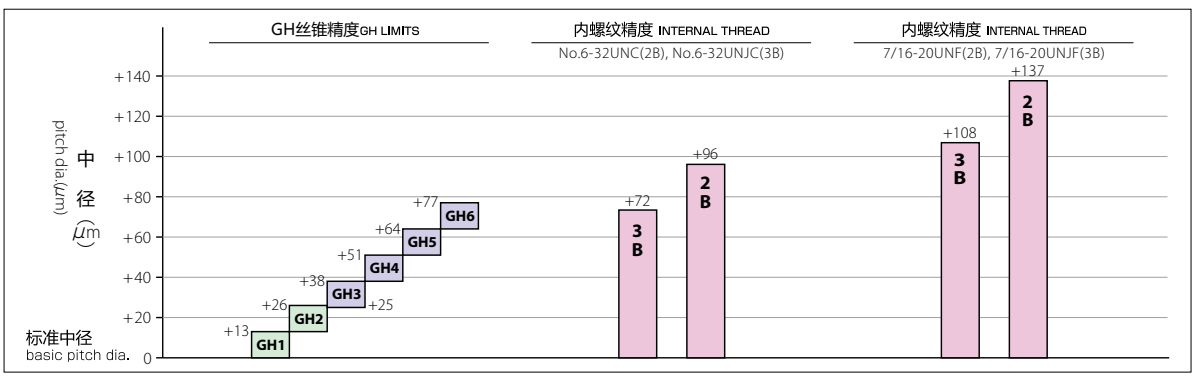
单位：mm Unit : mm (n=GH号)(n=GH number)

GH3以上 GH3 over

上公差：0.013×(n-2)+0.025 upper limit : 0.013×(n-2)+0.025

下公差：上公差−0.013 lower limit : (upper limit) −0.013

单位:mm Unit:mm (n=GH号)(n=GH number)



加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
WHR-NI-POT						○																○	◎			

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1139

镍基超耐热合金用

FOR NICKEL ALLOY

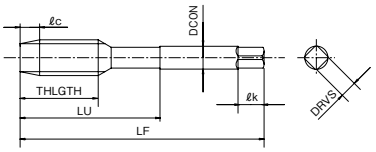
NI-POT

切削条件 Cutting Conditions | P.842

CPM

适用于航空工业、化学工业中经过时效处理的硬度为40 ~ 45HRC的镍基合金(Inconel 718)等加工。具有寿命长，效率高、稳定性好的特点。

This tap provides high performance when tapping heat resistant alloy steels which are used in the aerospace and chemical industries. These materials, such as nickel alloy (Inconel 718 etc.), have a hardness of 40 ~ 45 HRC after the process of age hardening by solution treatment.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
29010	M 3 ×0.5	STD	OH3	5P	46	18	19	4	3	Yes	●	5
29013	M 4 ×0.7				52	20	21	5		Yes	●	8
29016	M 5 ×0.8				60	22	29	5.5		Yes	●	11
29019	M 6 ×1				62	24	—	6		Yes	●	14
29022	M 8 ×1.25				70	22	39.5	7		Yes	●	22
29024	M 8 ×1				70	22	39.5	7		Yes	●	22
29026	M10 ×1.5				75	24	41	8.5		—	●	35
29028	M10 ×1.25	STD	OH3	5P	75	24	41	8.5	3	—	●	35
29030	M10 ×1				75	24	41	8.5		—	●	36
29032	M12 ×1.75	STD	OH4		82	29	43	10.5		—	●	55
29034	M12 ×1.5	STD	OH3		82	29	43	10.5		—	●	56
29036	M12 ×1.25	STD	OH4		82	29	43	10.5		—	●	56
29038	M12 ×1	STD	OH3		82	29	43	10.5		—	●	57

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U,UNJ

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8317033	No. 6 - 32UNJC	STD	OH2	5P	48	18	26	4	3	Yes	●	5
8317036	No. 6 - 40UNJF				48	18	26	4		Yes	●	6
8317040	No. 8 - 32UNJC				52	20	21	5		Yes	●	8
8317042	No. 8 - 36UNJF				52	20	21	5		Yes	●	8
8317046	No.10 - 24UNJC				60	22	29	5.5		Yes	●	11
8317049	No.10 - 32UNJF				60	22	29	5.5		Yes	●	11
8317058	1/4 - 20UNJC	STD	OH3		62	24	—	6		Yes	●	13
8317061	1/4 - 28UNJF	STD	OH2		62	24	—	6		Yes	●	14
8317067	5/16 - 18UNJC	STD	OH3	5P	70	22	36	7	3	Yes	●	21
8317070	5/16 - 24UNJF				70	22	36	7		Yes	●	22
8317076	3/8 - 16UNJC				75	24	41	8.5		—	●	33
8317082	3/8 - 24UNJF				75	24	41	8.5		—	●	34
8317091	7/16 - 14UNJC				80	25	40	10.5		—	●	49
8317094	7/16 - 20UNJF				80	25	40	10.5		—	●	51
8317100	1/2 - 13UNJC	STD	OH4		85	29	45	10.5		—	●	61
8317106	1/2 - 20UNJF	STD	OH3		85	29	45	10.5		—	●	63

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
NI-POT						○																	◎			

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1057

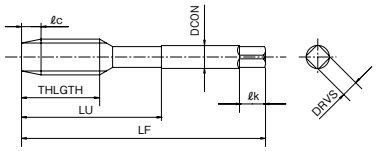
高速同步丝锥

SYNCHRO TAPS

HS-RFT

完全同步进给机械专用，用于高速 · 高精度通孔螺纹加工。另有长柄型和JIS 柄型。

Suitable for high speed / high precision, through hole tapping. This tap must be used with machines that have perfectly synchronized feed control (one pitch feed per revolution).



HSSE | TiN | 20° | 左螺旋 Reverse Flutes | SHANK h7

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20710	M 3 ×0.5	STD	OH3	6P	46	11	19	4	3	Yes	●	4
20714	M 4 ×0.7				52	13	21	6		Yes	●	9
20718	M 5 ×0.8				60	16	24	6		Yes	●	12
20722	M 6 ×1				62	19	29	6		Yes	●	12
20728	M 8 ×1.25	STD	OH4		70	22	37	8		—	●	22
20734	M10×1.5				75	24	41	8		—	●	30

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20736	M10×1.25	STD	OH4	6P	75	24	41	8	3	—	●	30
20739	M12×1.75				82	29	48	10		—	●	50
20742	M12×1.5				82	29	48	10		—	●	51
20745	M12×1.25				82	29	48	10		—	●	50
20749	M14×2	STD	OH5		88	30	48	12		—	●	77
20751	M14×1.5	STD	OH4		88	30	48	12		—	●	76

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

G-LIST No. | TH1120

高速同步丝锥 JIS柄型

SYNCHRO TAPS (JIS SHANK)

J-HS-RFT

HSSE | TiN | 20° | 左螺旋 Reverse Flutes | SHANK h7

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8305510	M 3 ×0.5	STD	OH3	5P	46	11	19	4	3	Yes	●	4
8305514	M 4 ×0.7				52	13	21	5		Yes	●	8
8305518	M 5 ×0.8				60	16	24	5.5		Yes	●	11
8305522	M 6 ×1				62	19	29	6		Yes	●	12
8305528	M 8 ×1.25	STD	OH4		70	22	37	6.2		—	●	17
8305534	M10 ×1.5				75	24	41	7		—	●	26

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8305536	M10 ×1.25	STD	OH4	5P	75	24	41	7	3	—	●	26
8305539	M12 ×1.75				82	29	48	8.5		—	●	42
8305542	M12 ×1.5				82	29	48	8.5		—	●	42
8305545	M12 ×1.25				82	29	48	8.5		—	●	43
8305549	M14 ×2	STD	OH5		88	30	48	10.5		—	●	67
8305551	M14 ×1.5	STD	OH4		88	30	48	10.5		—	●	68

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HS-RFT	◎	◎	○	○	○				○		○			○	○	○		○	◎		○				○
J-HS-RFT	◎	◎	○	○	○				○		○			○	○	○		○	◎		○				○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

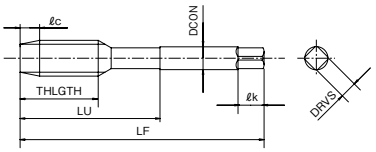
G-LIST No. | TH1090

高速同步进给丝锥 长柄型

SYNCHRO TAPS· LONG SHANK

HS-LT-RFT

HSSE | TiN | 20° 左螺旋 Reverse Flutes | SHANK h7



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8304010	M 3 ×0.5	STD	OH3	6P	100	11	19	4	3	Yes	●	11
8304011					120					Yes	●	12
8304013	M 4 ×0.7				100	13	21	6		Yes	●	20
8304015					150					Yes	●	31
8304016	M 5 ×0.8				100	16	24	6		Yes	●	21
8304018					150					Yes	●	32
8304019	M 6 ×1				100	19	29	6		Yes	●	23
8304021					150					Yes	●	33
8304023	M 8 ×1.25	STD	OH4		100	22	37	8		—	●	35
8304025					150					—	●	56
8304030	M10×1.5				100	24	41	8		—	●	40
8304032					150					—	●	61
8304034	M10×1.25				100	24	41	8		—	●	40
8304036					150					—	●	62
8304041	M12×1.75				100	29	48	10		—	●	62
8304043					150					—	●	92
8304045	M12×1.5				100	29	48	10		—	●	64

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8304047	M12×1.5	STD	OH4	6P	150	29	48	10	3	—	●	92
8304049	M12×1.25				100	29	48	10		—	●	63
8304051					150					—	●	93
8304058	M14×2	STD	OH5		150	30	48	12		—	●	125
8304062	M14×1.5	STD	OH4		150	30	48	12		—	●	127
8304065	M16×2	STD	OH5		150	32	60	16		—	●	193
8304069	M16×1.5	STD	OH4		150	32	60	16		—	●	191
8304072	M18×2.5	STD	OH5	5P	150	37	70	16	4	—	●	195
8304075	M18×1.5	STD	OH4		150	37	70	16		—	●	196
8304078	M20×2.5	STD	OH5		150	37	75	16		—	●	205
8304081	M20×1.5	STD	OH4		150	37	75	16		—	●	212
8304084	M22×2.5	STD	OH5		150	38	80	20		—	●	280
8304087	M22×1.5	STD	OH4		150	38	80	20		—	●	285
8304090	M24×3	STD	OH5		150	45	90	20		—	●	296
8304093	M24×1.5	STD	OH4		150	45	90	20		—	●	298
8304098	M27×3	STD	OH5		200	45	98	20		—	●	445
8304106	M30×3.5	STD	OH6		200	48	110	25		—	●	617

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HS-LT-RFT	◎	◎	○	○	○				○		○			○	○	○		○	◎		○				○

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1160

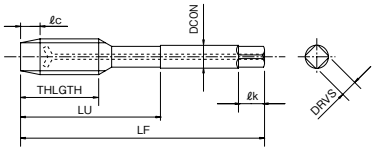
钢用内冷油孔高速同步丝锥

ULTRA SYNCHRO TAPS WITH INTERNAL COOLANT SUPPLY FOR STEELS

VPO-US-POT

对S45C可实现50m/min以上的高速攻丝加工。

The VPO-US-POT is capable of tapping above 50m/min on S45C.



CPM | V | SHANK h7

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8313111	M 6 ×1	STD	OH3	5P	62	10	29	6	3	Yes	▲	12
8313125	M 8 ×1.25	STD	OH4	5P	70	13	37	8	3	Yes	▲	23
8313139	M10 ×1.5	STD	OH4	5P	75	15	41	8	3	—	▲	29
8313143	M10 ×1.25	STD	OH4	5P	75	15	41	8	3	—	▲	30

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲= 该产品已停止生产，由 A-POT(P.657) 替代。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8313157	M12 ×1.75	STD	OH4	5P	82	18	48	10	3	—	▲	49
8313161	M12 ×1.5	STD	OH4	5P	82	18	48	10	3	—	▲	50
8313165	M12 ×1.25	STD	OH4	5P	82	18	48	10	3	—	▲	50

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-POT(p.657).

※SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
VPO-US-POT	◎	◎	○	○																						

库存记号 Inventory symbols

●= 标准库存品 Standard stock item

○= 准标准库存品(请确认库存。) Limited standard stock item

▲= 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△= 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1085

铝用高速同步进给丝锥

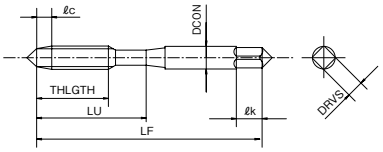
SYNCHRO TAPS· FOR ALUMINIUM

HS-AL-RFT

HSSE | 20° 左螺旋 Reverse Flutes | SHANK h7

完全同步进给机械专用，用于铝、铝合金。高速、高精度的螺纹加工。

For high speed / high precision tapping of aluminum and aluminum alloys. This tap must be used with machines that have perfectly synchronizes feed control (one pitch feed per revolution).



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胀长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8305002	M2 ×0.4	STD	OH2	6P	40	12	—	3	2	Yes	●	3
8305008	M2.6 ×0.45				44	14	—	3		Yes	●	4
8305010	M3 ×0.5	STD	OH3		46	11	19	4		Yes	●	4
8305014	M4 ×0.7				52	13	21	6		Yes	●	9
8305018	M5 ×0.8	STD	OH3	6P	60	16	24	6	2	Yes	●	11
8305022	M6 ×1				62	19	29	6		Yes	●	12

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HS-AL-RFT														○				◎	◎		◎				

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1126

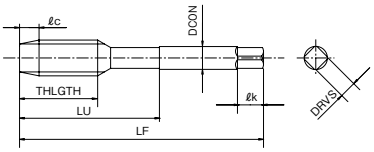
ULTRA同步丝锥

ULTRA SYNCHRO TAPS

US-AL-RFT

同步进给设备专用丝锥。由于使用了耐磨损性，耐溶着性高的V涂层，可进行铝、铝合金等的超高速攻丝加工。

Capable of high speed processing of materials such as aluminum and aluminum alloys, thanks to the superior abrasion and wear resistance of V Coating. For use with machines that have perfectly synchronized feed control.



HSSE | V | or | N | 20° 左螺旋 Reverse Flutes | SHANK h7

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8311269	M 3×0.5	STD	OH3	6P	46	11	19	4	2	Yes	▲	4
8311283	M 4×0.7				52	13	21	6		Yes	▲	9
8311297	M 5×0.8				60	16	24	6		Yes	▲	11
8311311	M 6×1				62	19	29	6		Yes	▲	12
8311325	M 8×1.25	STD	OH4		70	22	37	8		—	▲	22
8311339	M10×1.5				75	24	41	8		—	▲	30
8311343	M10×1.25				75	24	41	8		—	▲	30
8311357	M12×1.75				82	29	48	10		—	▲	47
8311361	M12×1.5				82	29	48	10		—	▲	47
8311365	M12×1.25				82	29	48	10		—	▲	49

■突顶尖长·柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. M16以下为V涂层，M16以上为氮化处理。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。
▲=该产品已停止生产，由A-POT(P.657)替代。

※高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8311379	M14×2	STD	OH5	6P	88	30	48	12	2	—	▲	73
8311383	M14×1.5	STD	OH4		88	30	48	12		—	△	76
8311397	M16×2	STD	OH5		95	32	52	16		—	△	115
8311401	M16×1.5	STD	OH4		95	32	52	16		—	△	116
8311415	M18×2.5	STD	OH5	5P	100	37	55	16		—	△	129
8311419	M18×1.5	STD	OH4		100	37	55	16		—	△	131
8311433	M20×2.5	STD	OH5		105	37	58	16		—	△	143
8311437	M20×1.5	STD	OH4		105	37	58	16		—	△	150
8311469	M24×3	STD	OH5		120	45	66	20		—	△	252

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Up to M16: with V coating, over M16: with Nitriding.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.
▲=The products have been stopped producing and replaced by A-POT(p.657).

※ULTRA SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
US-AL-RFT														○				○	◎		◎					

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

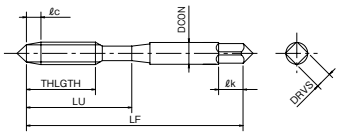
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1062

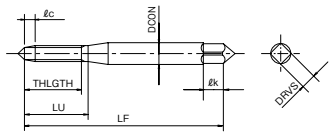
一般用
GENERAL APPLICATION

HT

HSS



新形状 New Dimension



旧形状 Old Dimension

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
61		9P													Yes	●	3
62	M 1 × 0.25	5P			30	5.5	–	3		30	8	8.5	3		Yes	●	3
63		1.5P													Yes	●	3
81		9P													Yes	●	3
82	M 1.2 × 0.25	5P			32	5.5	–	3		32	9	9.5	3		Yes	●	3
83		1.5P													Yes	●	3
101		9P													Yes	●	3
102	M 1.4 × 0.3	5P			34	7	–	3		34	11	11.5	3		Yes	●	3
103		1.5P													Yes	●	3
131		9P													Yes	●	3
132	M 1.6 × 0.35	5P			36	8	–	3		36	13	13.5	3		Yes	●	3
133		1.5P													Yes	●	3
161		9P													Yes	●	3
162	M 1.7 × 0.35	5P			36	8	–	3		36	13	13.5	3		Yes	●	3
163		1.5P													Yes	●	3
211		9P													Yes	●	3
212	M 1.8 × 0.35	5P			36	8	–	3		36	13	13.5	3		Yes	●	3
213		1.5P													Yes	●	3
231		9P													Yes	●	3
232	M 2 × 0.4	5P			40	8	–	3		40	15	16	3		Yes	●	3
233		1.5P													Yes	●	3
234		S													Yes	●	14
251		9P													Yes	●	3
252	M 2 × 0.25	5P			40	8	–	3		40	8	9	3		Yes	●	3
253		1.5P													Yes	●	3
271		9P													Yes	●	3
272	M 2.2 × 0.45	5P			42	9.5	–	3		42	15	16	3		Yes	●	3
273		1.5P													Yes	●	3
281		9P													Yes	●	3
282	M 2.2 × 0.25	5P			42	8	–	3		42	8	9	3		Yes	●	3
283		1.5P													Yes	●	3
291		9P													Yes	●	3
292	M 2.3 × 0.4	5P			42	9.5	–	3		42	15	20	3		Yes	●	3
293		1.5P													Yes	●	3
294		S													Yes	●	14
321		9P													Yes	●	3
322	M 2.5 × 0.45	5P			44	9.5	–	3		44	16	21	3		Yes	●	3
323		1.5P													Yes	●	3
324		S													Yes	●	14
351		9P													Yes	●	3
352	M 2.6 × 0.45	5P			44	9.5	–	3		44	16	21	3		Yes	●	3
353		1.5P													Yes	●	3
354		S													Yes	●	15
361		9P													Yes	●	3
362	M 2.6 × 0.35	5P			44	9.5	–	3		44	10	15	3		Yes	●	3
363		1.5P													Yes	●	3
381		9P													Yes	●	4
382	M 3 × 0.6	5P			46	11	19	4		46	18	20	4		Yes	●	4
383		1.5P													Yes	●	4
391		9P													Yes	●	5
392	M 3 × 0.5	5P			46	11	19	4		46	18	20	4		Yes	●	4
393		1.5P													Yes	●	5
394		S													Yes	●	18
401		9P													Yes	●	4
402	M 3 × 0.35	5P			46	10	19	4		46	10	12	4		Yes	●	4
403		1.5P													Yes	●	4

			STD	OH1					JIS2					3			

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尺寸 Size M3.5 ~ M5.5 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M1 ~ M3

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
411	M 3.5 × 0.6	9P	STD	OH1	48	13	20	4	JIS2	48	18	23	4	3	Yes	●	5
412		5P													Yes	●	5
413		1.5P													Yes	●	5
414		S													Yes	●	19
421	M 3.5 × 0.5	9P	STD	OH1	48	13	20	4		48	18	23	4		Yes	●	5
422		5P													Yes	●	5
423		1.5P													Yes	●	5
431	M 3.5 × 0.35	9P			48	10	20	4		48	10	15	4		Yes	●	5
432		5P													Yes	●	5
433		1.5P													Yes	●	5
441	M 4 × 0.75	9P	STD	OH2	52	13	21	5		52	20	22	5		Yes	●	7
442		5P													Yes	●	7
443		1.5P													Yes	●	7
451	M 4 × 0.7	9P			52	13	21	5		52	20	22	5		Yes	●	7
452		5P													Yes	●	7
453		1.5P													Yes	●	7
454		S													Yes	●	25
461	M 4 × 0.5	9P	STD	OH1	52	13	21	5		52	15	17	5		Yes	●	7
462		5P													Yes	●	7
463		1.5P													Yes	●	7
481	M 4.5 × 0.75	9P	STD	OH2	55	13	21	5		55	20	25	5		Yes	●	8
482		5P													Yes	●	8
483		1.5P													Yes	●	8
491	M 4.5 × 0.5	9P	STD	OH1	55	13	21	5		52	15	20	5		Yes	●	8
492		5P													Yes	●	8
493		1.5P													Yes	●	8
501	M 5 × 0.9	9P	STD	OH2	60	16	24	5.5		60	22	27	5.5		Yes	●	10
502		5P													Yes	●	10
503		1.5P													Yes	●	10
511	M 5 × 0.8	9P			60	16	24	5.5		60	22	27	5.5		Yes	●	10
512		5P													Yes	●	10
513		1.5P													Yes	●	10
514		S													Yes	●	33
521	M 5 × 0.75	9P			60	16	24	5.5		60	22	27	5.5		Yes	●	10
522		5P													Yes	●	10
523		1.5P													Yes	●	10
531	M 5 × 0.5	9P	STD	OH1	60	15	24	5.5		52	15	20	5.5		Yes	●	10
532		5P													Yes	●	10
533		1.5P													Yes	●	10
551	M 5.5 × 0.9	9P	STD	OH2	60	17	25	5.5		60	22	22	5.5		Yes	●	10
552		5P													Yes	●	10
553		1.5P													Yes	●	10
561	M 5.5 × 0.75	9P			60	17	25	5.5		60	22	22	5.5		Yes	●	10
562		5P													Yes	●	10
563		1.5P													Yes	●	10
571	M 5.5 × 0.5	9P	STD	OH1	60	15	25	5.5		52	15	15	5.5		Yes	●	10
572		5P													Yes	●	10
573		1.5P													Yes	●	10

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 切削锥长的 S 是表示 9P, 5P, 1.5P 三支一套。
2. 旧形状随库存减少,逐渐由新形状来替代。
3. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. "S" in "ℓc" column means 3pcs in a set (9p,5p,1.5p).
2. Conventional dimension is replaced with new one accordingly.
3. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

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尺寸 Size M6 ~ M10 NEXT

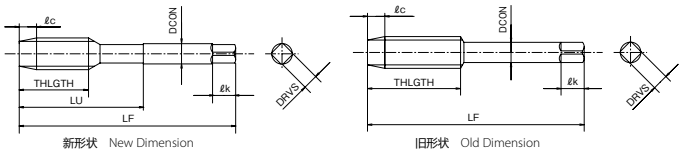
库存记号 Inventory symbols

●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT



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FROM 尺寸 Size M3.5 ~ M5.5

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
581	M 6 × 1	9P	STD	OH2	62	19	29	6	JIS2	62	24	24	6	3	Yes	●	12
582		5P													Yes	●	12
583		1.5P													Yes	●	12
584		S													Yes	●	40
591	M 6 × 0.75	9P			62	19	29	6		62	20	20	6		Yes	●	12
592		5P													Yes	●	12
593		1.5P													Yes	●	12
594		S													Yes	●	39
601	M 6 × 0.5	9P			62	15	29	6		55	15	15	6		Yes	●	12
602		5P	STD	OH1											Yes	●	12
603		1.5P													Yes	●	12
611	M 7 × 1	9P			65	19	33	6.2		65	26	–	6.2		–	●	15
612		5P													–	●	15
613		1.5P													–	●	15
614		S													–	●	55
621	M 7 × 0.75	9P			65	19	33	6.2		62	20	–	6.2		–	●	15
622		5P													–	●	15
623		1.5P													–	●	15
631	M 7 × 0.5	9P			65	15	29	6.2		55	15	–	6.2		–	●	15
632		5P	STD	OH1											–	●	15
633		1.5P													–	●	15
641	M 8 × 1.25	9P			70	22	37	6.2		70	30	–	6.2		–	●	17
642		5P													–	●	17
643		1.5P													–	●	17
644		S													–	●	62
651	M 8 × 1	9P			70	22	37	6.2		70	30	–	6.2		–	●	17
652		5P													–	●	17
653		1.5P													–	●	17
654		S													–	●	62
661	M 8 × 0.75	9P			70	20	35	6.2		62	20	–	6.2		–	●	17
662		5P	STD	OH2											–	●	17
663		1.5P													–	●	17
671	M 8 × 0.5	9P			70	15	30	6.2		55	15	–	6.2	4	–	●	17
672		5P	STD	OH1											–	●	18
673		1.5P													–	●	18
691	M 9 × 1.25	9P			72	22	38	7		72	30	–	7		–	●	23
692		5P													–	●	23
693		1.5P													–	●	23
701	M 9 × 1	9P			72	22	38	7		70	30	–	7		–	●	23
702		5P	STD	OH2											–	●	23
703		1.5P													–	●	23
711	M 9 × 0.75	9P			72	20	36	7		62	20	–	7		–	●	23
712		5P													–	●	23
713		1.5P													–	●	23
721	M 9 × 0.5	9P			70	15	31	7		55	15	–	7		–	●	20
722		5P	STD	OH1											–	●	23
723		1.5P													–	●	23
731	M 10 × 1.5	9P			75	24	41	7		75	32	–	7		–	●	25
732		5P													–	●	25
733		1.5P													–	●	25
734		S	STD	OH2											–	●	82
741	M 10 × 1.25	9P			75	24	41	7		75	32	–	7		–	●	26
742		5P													–	●	26
743		1.5P													–	●	26
744		S													–	●	83

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尺寸 Size M10 ~ M12 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M6 ~ M10

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
751	M 10 × 1	9P	STD	OH2	75	24	41	7		70	30	—	7		—	●	26
752		5P													—	●	26
753		1.5P													—	●	26
754		S													—	●	83
761	M 10 × 0.75	9P			75	20	37	7		62	20	—	7		—	●	25
762		5P													—	●	26
763		1.5P													—	●	26
771	M 10 × 0.5	9P	STD	OH1	70	15	32	7		55	15	—	7		—	●	24
772		5P													—	●	26
773		1.5P													—	●	24
791	M 11 × 1.5	9P	STD	OH2	80	25	48	8		80	38	—	8		—	●	34
792		5P													—	●	34
793		1.5P													—	●	34
811	M 11 × 1.25	9P			80	25	48	8		80	38	—	8		—	●	34
812		5P													—	●	35
813		1.5P													—	●	34
821	M 11 × 1	9P			80	25	48	8		70	30	—	8		—	●	34
822		5P													—	●	35
823		1.5P													—	●	35
831	M 11 × 0.75	9P			80	20	39	8		62	20	—	8		—	●	34
832		5P													—	●	35
833		1.5P													—	●	35
841	M 11 × 0.5	9P	STD	OH1	70	15	34	8	JIS2	55	15	—	8	4	—	●	25
842		5P													—	●	31
843		1.5P													—	●	31
851	M 12 × 1.75	9P	STD	OH2	82	29	48	8.5		82	38	—	8.5		—	●	40
852		5P													—	●	40
853		1.5P													—	●	40
854		S													—	●	120
861	M 12 × 1.5	9P			82	29	48	8.5		82	38	—	8.5		—	●	40
862		5P													—	●	40
863		1.5P													—	●	40
864		S													—	●	120
871	M 12 × 1.25	9P			82	29	48	8.5		80	38	—	8.5		—	●	40
872		5P													—	●	41
873		1.5P													—	●	41
874		S													—	●	120
881	M 12 × 1	9P			82	29	48	8.5		70	30	—	8.5		—	●	41
882		5P													—	●	41
883		1.5P													—	●	41
884		S													—	●	122
891	M 12 × 0.75	9P			82	20	39	8.5		70	30	—	8.5		—	●	40
892		5P													—	●	40
893		1.5P													—	●	40
901	M 12 × 0.5	9P	STD	OH1	70	15	34	8.5		55	15	—	8.5		—	●	35
902		5P													—	●	35
903		1.5P													—	●	35

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 切削锥长的S是表示9P, 5P, 1.5P三支一套。
2. 旧形状随库存减少,逐渐由新形状来替代。
3. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. "S" in "ℓc" column means 3pcs in a set (9p,5p,1.5p).
2. Conventional dimension is replaced with new one accordingly.
3. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

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尺寸 Size M13 ~ M15 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

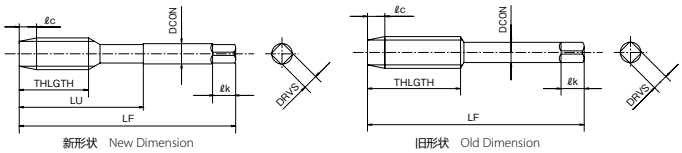
▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT



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FROM 尺寸 Size M10 ~ M12

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
921	M 13 × 1.75	9P			88	29	48	9.5		88	42	–	9.5		–	▲	56
922		5P													–	●	56
923		1.5P													–	●	56
931	M 13 × 1.5	9P			88	29	48	9.5		85	42	–	9.5		–	▲	56
932		5P													–	●	56
933		1.5P													–	●	58
941	M 13 × 1.25	9P	STD	OH2	88	29	48	9.5		80	38	–	9.5		–	▲	57
942		5P													–	●	57
943		1.5P													–	●	57
951	M 13 × 1	9P			88	29	48	9.5		70	30	–	9.5		–	▲	47
952		5P													–	●	57
953		1.5P													–	●	57
961	M 13 × 0.75	9P			88	29	48	9.5		70	30	–	9.5		–	▲	57
962		5P													–	●	57
963		1.5P													–	●	57
971	M 13 × 0.5	9P	STD	OH1	70	15	34	9.5		55	15	–	9.5		–	▲	45
972		5P													–	●	46
973		1.5P													–	●	45
981	M 14 × 2	9P	STD	OH2	88	30	48	10.5		88	42	–	10.5		–	▲	64
982		5P													–	●	64
983		1.5P													–	●	65
984		S													–	△	197
991	M 14 × 1.5	9P			88	30	48	10.5		88	42	–	10.5		–	▲	66
992		5P													–	●	66
993		1.5P													–	●	66
994		S													–	△	197
1001	M 14 × 1.25	9P			88	30	48	10.5	JIS2	88	42	–	10.5	4	–	▲	67
1002		5P													–	●	67
1003		1.5P													–	●	67
1004		S													–	△	199
1011	M 14 × 1	9P			88	30	48	10.5		70	30	–	10.5		–	▲	66
1012		5P													–	●	66
1013		1.5P													–	●	66
1014		S													–	△	203
1021	M 14 × 0.75	9P			88	30	48	10.5		70	30	–	10.5		–	▲	68
1022		5P													–	●	67
1023		1.5P													–	●	67
1031	M 14 × 0.5	9P	STD	OH1	70	15	34	10.5		58	15	–	10.5		–	▲	52
1032		5P													–	●	52
1033		1.5P													–	●	52
1051	M 15 × 2	9P	STD	OH2	95	30	52	10.5		90	42	–	10.5		–	▲	70
1052		5P													–	●	72
1053		1.5P													–	●	72
1061	M 15 × 1.5	9P			95	30	52	10.5		90	42	–	10.5		–	▲	73
1062		5P													–	●	72
1063		1.5P													–	●	73
1071	M 15 × 1.25	9P			95	30	52	10.5		90	42	–	10.5		–	▲	72
1072		5P													–	●	72
1073		1.5P													–	●	73
1081	M 15 × 1	9P			95	30	50	10.5		70	30	–	10.5		–	▲	73
1082		5P													–	●	73
1083		1.5P													–	●	74
1091	M 15 × 0.75	9P			95	30	50	10.5		70	30	–	10.5		–	▲	73
1092		5P													–	●	74
1093		1.5P													–	●	75

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尺寸 Size M15 ~ M18 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M13 ~ M15

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
1101	M 15 × 0.5	9P	STD	OH1	70	15	35	10.5	JIS2	58	15	–	10.5	4	–	▲	53
1102		5P													–	●	53
1103		1.5P													–	●	54
1111	M 16 × 2	9P	STD	OH2	95	32	52	12.5		95	45	–	12.5		–	▲	91
1112		5P													–	●	92
1113		1.5P													–	●	92
1114		S													–	△	276
1121	M 16 × 1.5	9P			95	32	52	12.5		95	45	–	12.5		–	▲	92
1122		5P													–	●	93
1123		1.5P													–	●	93
1124		S													–	△	282
1131	M 16 × 1.25	9P			95	32	52	12.5		95	45	–	12.5		–	▲	91
1132		5P													–	●	93
1133		1.5P													–	●	92
1141	M 16 × 1	9P			95	30	50	12.5		75	30	–	12.5		–	▲	92
1142		5P													–	●	92
1143		1.5P													–	●	94
1151	M 16 × 0.75	9P			95	30	50	12.5		75	30	–	12.5		–	▲	94
1152		5P													–	●	94
1153		1.5P													–	●	94
1161	M 16 × 0.5	9P	STD	OH1	75	15	35	12.5		60	15	–	12.5		–	▲	73
1162		5P													–	●	73
1163		1.5P													–	●	75
1191	M 17 × 2	9P	STD	OH2	100	32	52	13		95	45	–	13		–	▲	93
1192		5P													–	●	95
1193		1.5P													–	●	98
1201	M 17 × 1.5	9P			100	32	52	13		95	45	–	13		–	▲	99
1202		5P													–	●	99
1203		1.5P													–	●	100
1211	M 17 × 1.25	9P			100	32	52	13		95	45	–	13		–	▲	99
1212		5P													–	●	100
1213		1.5P													–	●	100
1221	M 17 × 1	9P			95	30	50	13		80	30	–	13		–	▲	94
1222		5P													–	●	96
1223		1.5P													–	●	96
1231	M 17 × 0.75	9P			95	30	50	13		80	30	–	13		–	▲	96
1232		5P													–	●	95
1233		1.5P													–	●	95
1241	M 17 × 0.5	9P			75	15	35	13		65	15	–	13		–	▲	73
1242		5P													–	●	73
1243		1.5P													–	●	74
1251	M 18 × 2.5	9P	STD	OH3	100	37	55	14		100	48	–	14		–	▲	111
1252		5P													–	●	112
1253		1.5P													–	●	113
1254		S													–	△	349

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 切削锥长的 S 是表示 9P, 5P, 1.5P 三支一套。
2. 旧形状随库存减少,逐渐由新形状来替代。
3. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产, 由 HT(切削锥 : 5P,1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. "S" in "ℓc" column means 3pcs in a set (9p,5p,1.5p).
2. Conventional dimension is replaced with new one accordingly.
3. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

▲ = The products have been stopped producing and replaced by HT (ℓc:5P,1.5P).

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尺寸 Size M18 ~ M20 NEXT

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

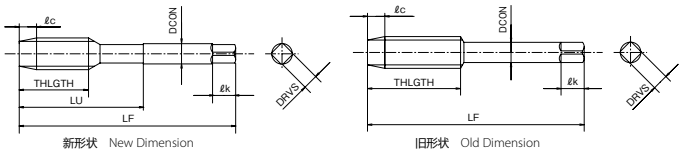
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT



HSS

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FROM 尺寸 Size M15 ~ M18

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
1261		9P													—	▲	114
1262	M 18 × 2	5P	STD	OH3	100	37	55	14		95	45	—	14		—	●	114
1263		1.5P													—	●	113
1271		9P													—	▲	114
1272	M 18 × 1.5	5P			100	37	55	14		95	45	—	14		—	●	114
1273		1.5P													—	●	114
1274		S													—	△	356
1281		9P													—	▲	116
1282	M 18 × 1.25	5P			100	37	55	14		95	45	—	14		—	●	114
1283		1.5P													—	●	114
1291		9P													—	▲	108
1292	M 18 × 1	5P	STD	OH2	95	30	50	14		80	30	—	14		—	●	108
1293		1.5P													—	●	108
1301		9P													—	▲	108
1302	M 18 × 0.75	5P			95	30	50	14		80	30	—	14		—	●	110
1303		1.5P													—	●	110
1311		9P													—	▲	93
1312	M 18 × 0.5	5P			80	15	35	14		65	15	—	13		—	●	93
1313		1.5P													—	●	93
1331		9P													—	▲	120
1332	M 19 × 2.5	5P			105	37	58	14		105	50	—	14		—	●	121
1333		1.5P													—	●	122
1341		9P													—	▲	113
1342	M 19 × 2	5P	STD	OH3	105	37	58	14		95	45	—	14		—	●	113
1343		1.5P													—	●	113
1351		9P													—	▲	114
1352	M 19 × 1.5	5P			105	37	58	14		95	45	—	14		—	●	124
1353		1.5P													—	●	124
1361		9P							JIS2					4	—	▲	114
1362	M 19 × 1	5P			95	30	50	14		80	30	—	14		—	●	114
1363		1.5P													—	●	114
1371		9P													—	▲	113
1372	M 19 × 0.75	5P	STD	OH2	95	30	50	14		80	30	—	14		—	●	114
1373		1.5P													—	●	114
1381		9P													—	▲	96
1382	M 19 × 0.5	5P			80	15	36	14		65	15	—	14		—	●	96
1383		1.5P													—	●	95
1391		9P													—	▲	136
1392	M 20 × 2.5	5P			105	37	58	15		105	50	—	15		—	●	138
1393		1.5P													—	●	138
1394		S													—	△	459
1401		9P													—	▲	140
1402	M 20 × 2	5P	STD	OH3	105	37	58	15		95	45	—	15		—	●	140
1403		1.5P													—	●	139
1411		9P													—	▲	140
1412	M 20 × 1.5	5P			105	37	58	15		95	45	—	15		—	●	142
1413		1.5P													—	●	142
1414		S													—	△	469
1421		9P													—	▲	140
1422	M 20 × 1.25	5P			105	37	58	15		95	45	—	15		—	●	140
1423		1.5P													—	●	141
1431		9P													—	▲	127
1432	M 20 × 1	5P	STD	OH2	95	30	51	15		80	30	—	15		—	●	128
1433		1.5P													—	●	128
1451		9P													—	▲	109
1452	M 20 × 0.5	5P			80	15	36	15		65	15	—	15		—	●	109
1453		1.5P													—	●	110

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尺寸 Size M21 ~ M24 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M18 ~ M20

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
1471	M 21 × 2.5	9P	STD	OH3	115	38	63	16	JIS2	115	55	—	16	4	—	▲	168
1472		5P													—	●	168
1473		1.5P													—	●	166
1481	M 21 × 1.5	9P			115	38	63	16		95	45	—	17		—	▲	172
1482		5P													—	●	172
1483		1.5P													—	●	172
1491	M 21 × 1	9P	STD	OH2	95	30	45	16		85	30	—	16		—	▲	145
1492		5P													—	●	146
1493		1.5P													—	●	146
1501	M 22 × 2.5	9P	STD	OH3	115	38	63	17		115	55	—	17		—	▲	187
1502		5P													—	●	187
1503		1.5P													—	●	187
1504		S													—	△	602
1511	M 22 × 2	9P			115	38	63	17		95	45	—	17		—	▲	187
1512		5P													—	●	185
1513		1.5P													—	●	187
1521	M 22 × 1.5	9P			115	38	63	17		95	45	—	17		—	▲	189
1522		5P													—	●	189
1523		1.5P													—	●	189
1524		S													—	△	610
1531	M 22 × 1	9P	STD	OH2	95	30	45	17		85	30	—	17		—	▲	161
1532		5P													—	●	161
1533		1.5P													—	●	161
1541	M 22 × 0.5	9P			85	15	30	17		68	15	—	17		—	▲	148
1542		5P													—	●	149
1543		1.5P													—	●	149
1561	M 23 × 2.5	9P	STD	OH3	120	38	63	18		120	58	—	18		—	▲	214
1562		5P													—	●	217
1563		1.5P													—	●	217
1571	M 23 × 2	9P			115	38	63	18		95	45	—	18		—	▲	168
1572		5P													—	●	170
1573		1.5P													—	●	172
1581	M 23 × 1.5	9P			120	38	63	18		95	45	—	18		—	▲	222
1582		5P													—	●	223
1583		1.5P													—	●	223
1591	M 23 × 1	9P	STD	OH2	95	30	45	18		90	30	—	18		—	▲	180
1592		5P													—	●	180
1593		1.5P													—	●	180
1601	M 24 × 3	9P	STD	OH3	120	45	66	19		120	58	—	19		—	▲	238
1602		5P													—	●	238
1603		1.5P													—	●	238
1604		S													—	△	763
1611	M 24 × 2.5	9P			120	45	66	19		120	58	—	19		—	▲	243
1612		5P													—	●	243
1613		1.5P													—	●	243
1621	M 24 × 2	9P			120	45	66	19		95	45	—	19		—	▲	240
1622		5P													—	●	240
1623		1.5P													—	●	245

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 切削锥长的 S 是表示9P, 5P, 1.5P三支一套。
2. 旧形状随库存减少,逐渐由新形状来替代。
3. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考 P.1004。

▲=该产品已停止生产, 由HT(切削锥 : 5P,1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. "S" in "ℓc" column means 3pcs in a set (9p,5p,1.5p).
2. Conventional dimension is replaced with new one accordingly.
3. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT (ℓc:5P,1.5P).

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尺寸 Size M24 ~ M28 NEXT

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

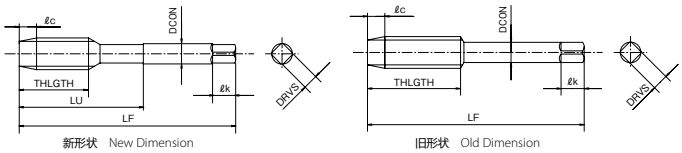
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT



HSS

上一页 FROM 尺寸 Size M21 ~ M24

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
1631	M 24 × 1.5	9P	STD	OH3	120	45	66	19	JIS2	95	45	–	19	4	–	▲	243
1632		5P													–	●	243
1633		1.5P													–	●	243
1634		S													–	△	766
1641	M 24 × 1.25	9P	STD	OH2	120	45	66	19		95	45	–	19		–	▲	242
1642		5P													–	●	243
1643		1.5P													–	●	249
1651	M 24 × 1	9P			95	30	45	19		90	30	–	19		–	▲	197
1652		5P													–	●	196
1653		1.5P													–	●	197
1671	M 25 × 3	9P	STD	OH3	130	45	71	19		130	62	–	19		–	▲	274
1672		5P													–	●	274
1673		1.5P													–	●	275
1681	M 25 × 2	9P			130	45	71	19		95	45	–	19		–	▲	276
1682		5P													–	●	276
1683		1.5P													–	●	277
1691	M 25 × 1.5	9P			130	45	71	19		95	45	–	19		–	▲	276
1692		5P													–	●	277
1693		1.5P													–	●	276
1701	M 25 × 1	9P	STD	OH2	95	30	45	19		95	30	–	19		–	▲	202
1702		5P													–	●	201
1703		1.5P													–	●	203
1711	M 26 × 3	9P	STD	OH3	130	45	71	20		130	62	–	20		–	▲	288
1712		5P													–	●	292
1713		1.5P													–	●	292
1721	M 26 × 2	9P			130	45	71	20		95	45	–	20		–	▲	302
1722		5P													–	●	297
1723		1.5P													–	●	297
1731	M 26 × 1.5	9P			130	45	71	20		95	45	–	20		–	▲	301
1732		5P													–	●	298
1733		1.5P													–	●	298
1741	M 26 × 1	9P	STD	OH2	95	30	45	20		95	30	–	20		–	▲	219
1742		5P													–	●	217
1743		1.5P													–	●	218
1751	M 27 × 3	9P	STD	OH3	130	45	71	20		130	62	–	20		–	▲	311
1752		5P													–	●	311
1753		1.5P													–	●	315
1761	M 27 × 2	9P			130	45	71	20		95	45	–	20		–	▲	317
1762		5P													–	●	315
1763		1.5P													–	●	316
1771	M 27 × 1.5	9P			130	45	71	20		95	45	–	20		–	▲	315
1772		5P													–	●	316
1773		1.5P													–	●	317
1781	M 27 × 1	9P	STD	OH2	95	30	45	20		95	30	–	20		–	▲	226
1782		5P													–	●	230
1783		1.5P													–	●	230
1801	M 28 × 3	9P	STD	OH3	135	48	74	21		135	65	–	21		–	▲	363
1802		5P													–	●	363
1803		1.5P													–	●	364
1811	M 28 × 2	9P			135	45	74	21		105	45	–	21		–	▲	356
1812		5P													–	●	354
1813		1.5P													–	●	356
1821	M 28 × 1.5	9P			130	45	60	21		105	45	–	21		–	▲	353
1822		5P													–	●	350
1823		1.5P													–	●	351

下一页 尺寸 Size M28 ~ M33 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M24 ~ M28

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
1831		9P													–	▲	280
1832	M 28 × 1	5P	STD	OH2	105	30	45	21		105	30	–	21		–	●	280
1833		1.5P													–	●	285
1841		9P													–	▲	401
1842	M 30 × 3.5	5P			135	51	74	23		135	65	–	23		–	●	401
1843		1.5P													–	●	401
1844		S													–	△	1,225
1851		9P													–	▲	402
1852	M 30 × 3	5P			135	48	74	23		135	65	–	23		–	●	406
1853		1.5P	STD	OH3											–	●	409
1861		9P													–	▲	409
1862	M 30 × 2	5P			135	45	74	23		105	45	–	23		–	●	404
1863		1.5P													–	●	407
1871		9P													–	▲	404
1872	M 30 × 1.5	5P			130	45	60	23		105	45	–	23		–	●	404
1873		1.5P													–	●	404
1874		S													–	△	1,222
1881		9P													–	▲	321
1882	M 30 × 1	5P	STD	OH2	105	30	45	23		105	30	–	23		–	●	322
1883		1.5P													–	●	328
1911		9P													–	▲	488
1912	M 32 × 3	5P			145	51	76	24		145	70	–	24		–	●	488
1913		1.5P													–	●	488
1921		9P													–	▲	351
1922	M 32 × 2	5P	STD	OH3	105	37	47	24	JIS2	105	45	–	24	4	–	●	352
1923		1.5P													–	●	352
1931		9P													–	▲	352
1932	M 32 × 1.5	5P			105	37	47	24		105	45	–	24		–	●	360
1933		1.5P													–	●	356
1941		9P													–	▲	356
1942	M 32 × 1	5P	STD	OH2	105	30	45	24		105	30	–	24		–	●	356
1943		1.5P													–	●	356
1951		9P													–	▲	517
1952	M 33 × 3.5	5P			145	51	76	25		145	70	–	25		–	●	513
1953		1.5P													–	●	518
1961		9P													–	▲	516
1962	M 33 × 3	5P			145	51	76	25		145	70	–	25		–	●	518
1963		1.5P													–	●	522
1971		9P													–	▲	395
1972	M 33 × 2	5P			110	37	47	25		110	45	–	25		–	●	395
1973		1.5P	STD	OH3											–	●	395
1981		9P													–	▲	391
1982	M 33 × 1.5	5P			110	37	47	25		110	45	–	25		–	●	393
1983		1.5P													–	●	396
1991		9P													–	▲	391
1992	M 33 × 1	5P	STD	OH2	110	30	45	25		110	30	–	25		–	●	396
1993		1.5P													–	●	396

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 切削锥长的 S 是表示 9P, 5P, 1.5P 三支一套。
2. 旧形状随库存减少,逐渐由新形状来替代。
3. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
4. 丝锥精度不能保证内螺纹的精度。
5. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产, 由 HT(切削锥 : 5P,1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. "S" in "ℓc" column means 3pcs in a set (9p,5p,1.5p).
2. Conventional dimension is replaced with new one accordingly.
3. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
4. TAP Limit does not guarantee thread limit for the internal thread after tapping.
5. Cutting fluid and Paste : Please refer to p.1004.

▲ = The products have been stopped producing and replaced by HT (ℓc:5P,1.5P).

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尺寸 Size M34 ~ M38 NEXT

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

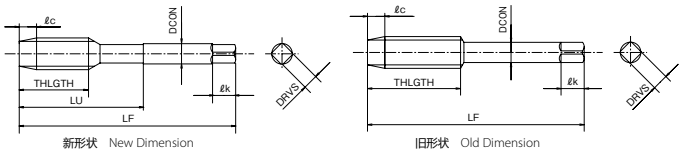
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT

HSS



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FROM 尺寸 Size M28 ~ M33

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
2011		9P													—	▲	592
2012	M 34 × 3	5P			155	57	77	26		155	75	—	26		—	●	592
2013		1.5P													—	●	598
2021		9P													—	▲	424
2022	M 34 × 2	5P	STD	OH3	110	37	47	26		110	45	—	26		—	●	425
2023		1.5P													—	●	432
2031		9P													—	▲	425
2032	M 34 × 1.5	5P			110	37	47	26		110	45	—	26		—	●	425
2033		1.5P													—	●	431
2041		9P													—	▲	433
2042	M 34 × 1	5P	STD	OH2	110	30	45	26		110	30	—	26		—	●	433
2043		1.5P													—	●	435
2061		9P													—	▲	607
2062	M 35 × 3	5P			155	57	77	26		155	75	—	26		—	●	629
2063		1.5P													—	●	621
2071		9P													—	▲	428
2072	M 35 × 2	5P	STD	OH3	110	37	47	26		110	45	—	26		—	●	431
2073		1.5P													—	●	439
2081		9P													—	▲	436
2082	M 35 × 1.5	5P			110	37	47	26		110	45	—	26		—	●	433
2083		1.5P													—	●	440
2091		9P													—	▲	440
2092	M 35 × 1	5P	STD	OH2	110	30	45	26		110	30	—	26		—	●	440
2093		1.5P													—	●	442
2111		9P													—	▲	691
2112	M 36 × 4	5P			155	57	77	28		155	75	—	28		—	●	682
2113		1.5P	STD	OH3											—	●	686
2121		9P													—	▲	697
2122	M 36 × 3	5P			155	57	77	28	JIS2	155	75	—	28	4	—	●	700
2123		1.5P													—	●	706
2131		9P													—	▲	477
2132	M 36 × 2	5P			110	37	47	28		110	45	—	28		—	●	478
2133		1.5P	STD	OH3											—	●	490
2141		9P													—	▲	488
2142	M 36 × 1.5	5P			110	37	47	28		110	45	—	28		—	●	484
2143		1.5P													—	●	483
2151		9P													—	▲	487
2152	M 36 × 1	5P	STD	OH2	110	30	45	28		110	30	—	28		—	●	487
2153		1.5P													—	●	487
2171		9P													—	▲	508
2172	M 37 × 1.5	5P	STD	OH3	115	37	47	28		115	45	—	28		—	●	508
2173		1.5P													—	●	517
2181		9P													—	▲	509
2182	M 37 × 1	5P	STD	OH2	115	30	45	28		115	30	—	28		—	●	520
2183		1.5P													—	●	522
2191		9P													—	▲	751
2192	M 38 × 4	5P			165	60	85	28		165	80	—	28		—	●	769
2193		1.5P													—	●	770
2201		9P													—	▲	721
2202	M 38 × 3	5P			165	60	85	28		165	80	—	28		—	●	721
2203		1.5P	STD	OH3											—	●	783
2211		9P													—	▲	524
2212	M 38 × 2	5P			115	37	47	28		115	45	—	28		—	●	524
2213		1.5P													—	●	524
2221		9P													—	▲	535
2222	M 38 × 1.5	5P			115	37	47	28		115	45	—	28		—	●	535
2223		1.5P													—	●	535

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尺寸 Size M38 ~ M42 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M34 ~ M38

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
2231		9P													–	▲	538
2232	M 38 × 1	5P	STD	OH2	115	30	45	28		115	30	–	28		–	●	538
2233		1.5P													–	●	538
2241		9P													–	▲	844
2242	M 39 × 4	5P			165	60	85	30		165	80	–	30		–	●	844
2243		1.5P													–	●	847
2251		9P													–	▲	864
2252	M 39 × 3	5P			165	60	85	30		165	80	–	30		–	●	848
2253		1.5P	STD	OH3											–	●	851
2261		9P													–	▲	586
2262	M 39 × 2	5P			115	37	47	30		115	45	–	30		–	●	593
2263		1.5P													–	●	584
2271		9P													–	▲	584
2272	M 39 × 1.5	5P			115	37	47	30		115	45	–	30		–	●	596
2273		1.5P													–	●	581
2281		9P													–	▲	585
2282	M 39 × 1	5P	STD	OH2	115	30	45	30		115	30	–	30		–	●	584
2283		1.5P													–	●	600
2311		9P													–	▲	874
2312	M 40 × 3	5P			165	60	85	30		165	80	–	30		–	●	882
2313		1.5P													–	●	866
2321		9P													–	▲	598
2322	M 40 × 2	5P	STD	OH3	115	37	47	30		115	45	–	30		–	●	594
2323		1.5P													–	●	592
2331		9P							JIS2					4	–	▲	595
2332	M 40 × 1.5	5P			115	37	47	30		115	45	–	30		–	●	600
2333		1.5P													–	●	594
2341		9P													–	▲	601
2342	M 40 × 1	5P	STD	OH2	115	30	45	30		115	30	–	30		–	●	602
2343		1.5P													–	●	608
2351		9P													–	▲	1,027
2352	M 42 × 4.5	5P			175	67	87	32		175	85	–	32		–	●	1,017
2353		1.5P													–	●	1,037
2361		9P													–	▲	1,022
2362	M 42 × 4	5P			175	60	85	32		175	80	–	32		–	●	1,032
2363		1.5P													–	●	1,044
2371		9P													–	▲	1,048
2372	M 42 × 3	5P	STD	OH3	175	60	85	32		175	80	–	32		–	●	1,033
2373		1.5P													–	●	1,036
2381		9P													–	▲	713
2382	M 42 × 2	5P			120	37	47	32		120	45	–	32		–	●	713
2383		1.5P													–	●	714
2391		9P													–	▲	711
2392	M 42 × 1.5	5P			120	37	47	32		120	45	–	32		–	●	713
2393		1.5P													–	●	722
2401		9P													–	▲	711
2402	M 42 × 1	5P	STD	OH2	120	30	45	32		120	30	–	32		–	●	727
2403		1.5P													–	●	730

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产, 由 HT(切削锥 : 5P,1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT (ℓc:5P,1.5P).

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尺寸 Size M45 ~ M50 NEXT

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

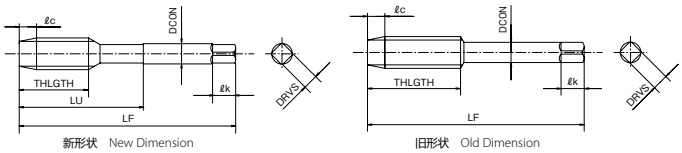
▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT



HSS

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FROM 尺寸 Size M38 ~ M42

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
2421		9P													—	▲	1,237
2422	M 45 × 4.5	5P			180	67	87	35		180	85	—	35		—	●	1,225
2423		1.5P													—	●	1,225
2431		9P													—	▲	1,225
2432	M 45 × 4	5P			180	67	87	35		180	80	—	35		—	●	1,229
2433		1.5P													—	●	1,255
2441		9P													—	▲	1,244
2442	M 45 × 3	5P	STD	OH3	180	67	82	35		180	80	—	35		—	●	1,248
2443		1.5P													—	●	1,244
2451		9P													—	▲	826
2452	M 45 × 2	5P			120	37	47	35		120	45	—	35		—	●	828
2453		1.5P													—	●	833
2461		9P													—	▲	838
2462	M 45 × 1.5	5P			120	37	47	35		120	45	—	35		—	●	825
2463		1.5P													—	●	832
2471		9P													—	▲	838
2472	M 45 × 1	5P	STD	OH2	120	30	45	35		120	30	—	35		—	●	831
2473		1.5P													—	●	848
2491		9P													—	▲	947
2492	M 46 × 1.5	5P	STD	OH3	125	37	47	35		125	45	—	35		—	●	868
2493		1.5P													—	●	878
2501		9P													—	▲	1,449
2502	M 48 × 5	5P	STD	OH4	185	70	90	38		185	90	—	38		—	●	1,456
2503		1.5P													—	●	1,464
2511		9P													—	▲	1,432
2512	M 48 × 4	5P			180	67	82	38		180	80	—	38		—	●	1,433
2513		1.5P													—	●	1,424
2521		9P													—	▲	1,456
2522	M 48 × 3	5P			180	67	82	38	JIS2	180	80	—	38	4	—	●	1,441
2523		1.5P	STD	OH3											—	●	1,438
2531		9P													—	▲	1,015
2532	M 48 × 2	5P			125	37	47	38		125	45	—	38		—	●	1,015
2533		1.5P													—	●	1,010
2541		9P													—	▲	993
2542	M 48 × 1.5	5P			125	37	47	38		125	45	—	38		—	●	996
2543		1.5P													—	●	1,012
2551		9P													—	▲	1,018
2552	M 48 × 1	5P	STD	OH2	125	30	45	38		125	30	—	38		—	●	1,007
2553		1.5P													—	●	1,010
2561		9P													—	▲	1,677
2562	M 50 × 5	5P			195	70	95	40		195	90	—	40		—	●	1,695
2563		1.5P	STD	OH4											—	●	1,695
2571		9P													—	▲	1,537
2572	M 50 × 4	5P			180	67	82	40		180	80	—	40		—	●	1,596
2573		1.5P													—	●	1,549
2581		9P													—	▲	1,579
2582	M 50 × 3	5P			180	67	82	40		180	80	—	40		—	●	1,604
2583		1.5P													—	●	1,582
2591		9P													—	▲	1,148
2592	M 50 × 2	5P	STD	OH3	130	45	60	40		130	45	—	40		—	●	1,135
2593		1.5P													—	●	1,151
2601		9P													—	▲	1,140
2602	M 50 × 1.5	5P			130	45	60	40		130	45	—	40		—	●	1,151
2603		1.5P													—	●	1,161
2611		9P													—	▲	1,136
2612	M 50 × 1	5P	STD	OH2	130	30	45	40		130	30	—	40		—	●	1,160
2613		1.5P													—	●	1,166

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尺寸 Size M52 ~ M58 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M45 ~ M50

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
2631		9P													–	▲	1,830
2632	M 52 × 5	5P			195	70	95	42		195	90	–	42		–	●	1,843
2633		1.5P	STD	OH4											–	●	1,843
2641		9P													–	▲	1,642
2642	M 52 × 4	5P			180	67	82	42		180	80	–	42		–	●	1,696
2643		1.5P													–	●	1,694
2651		9P													–	▲	1,703
2652	M 52 × 3	5P			180	67	82	42		180	80	–	42		–	●	1,730
2653		1.5P													–	●	1,702
2661		9P													–	▲	1,197
2662	M 52 × 2	5P	STD	OH3	130	45	60	42		130	50	–	42		–	●	1,241
2663		1.5P													–	●	1,219
2671		9P													–	▲	1,237
2672	M 52 × 1.5	5P			130	45	60	42		130	45	–	42		–	●	1,224
2673		1.5P													–	●	1,221
2681		9P													–	▲	1,810
2682	M 55 × 4	5P	STD	OH4	180	67	82	44		180	80	–	44		–	●	1,908
2683		1.5P													–	●	1,932
2691		9P													–	▲	1,919
2692	M 55 × 3	5P			180	67	82	44		180	80	–	44		–	●	1,916
2693		1.5P													–	●	1,919
2701		9P													–	▲	1,429
2702	M 55 × 2	5P	STD	OH3	135	45	60	44	JIS2	135	50	–	44	4	–	●	1,429
2703		1.5P													–	●	1,436
2711		9P													–	▲	1,437
2712	M 55 × 1.5	5P			135	45	60	44		135	45	–	44		–	●	1,442
2713		1.5P													–	●	1,445
2721		9P													–	▲	2,200
2722	M 56 × 5.5	5P			205	79	99	44		205	95	–	44		–	●	2,213
2723		1.5P	STD	OH4											–	●	2,230
2731		9P													–	▲	1,929
2732	M 56 × 4	5P			180	67	82	44		180	80	–	44		–	●	1,923
2733		1.5P													–	●	1,933
2741		9P													–	▲	1,939
2742	M 56 × 3	5P			180	67	82	44		180	80	–	44		–	●	1,939
2743		1.5P													–	●	1,938
2751		9P													–	▲	1,438
2752	M 56 × 2	5P	STD	OH3	135	45	60	44		135	50	–	44		–	●	1,457
2753		1.5P													–	●	1,460
2761		9P													–	▲	1,511
2762	M 56 × 1.5	5P			135	45	60	44		135	45	–	44		–	●	1,444
2763		1.5P													–	●	1,456
2781		9P													–	▲	2,100
2782	M 58 × 4	5P	STD	OH4	180	67	82	46		180	80	–	46		–	●	2,048
2783		1.5P													–	●	1,986

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产, 由 HT(切削锥 : 5P,1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT (ℓc:5P,1.5P).

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尺寸 Size M58 ~ M65 NEXT

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

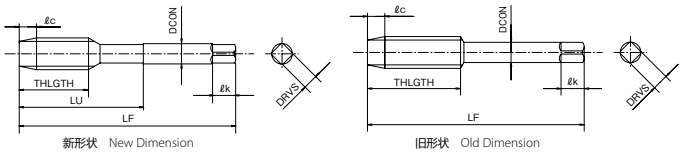
△ = 停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT

HSS



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FROM 尺寸 Size M52 ~ M58

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
2791		9P													–	▲	2,090
2792	M 58 × 3	5P			180	67	82	46		180	80	–	46		–	●	2,079
2793		1.5P													–	●	2,021
2801		9P													–	▲	1,543
2802	M 58 × 2	5P	STD	OH3	135	45	60	46		135	50	–	46		–	●	1,543
2803		1.5P													–	●	1,544
2811		9P													–	▲	1,562
2812	M 58 × 1.5	5P			135	45	60	46		135	45	–	46		–	●	1,545
2813		1.5P													–	●	1,565
2821		9P													–	▲	2,560
2822	M 60 × 5.5	5P			215	79	104	46		215	100	–	46		–	●	2,565
2823		1.5P	STD	OH4											–	●	2,565
2831		9P													–	▲	2,194
2832	M 60 × 4	5P			185	70	85	46		185	85	–	46		–	●	2,177
2833		1.5P													–	●	2,179
2841		9P													–	▲	2,189
2842	M 60 × 3	5P			185	70	85	46		185	85	–	46		–	●	2,197
2843		1.5P													–	●	2,191
2851		9P													–	▲	1,646
2852	M 60 × 2	5P	STD	OH3	140	45	60	46		140	55	–	46		–	●	1,639
2853		1.5P													–	●	1,659
2861		9P													–	▲	1,724
2862	M 60 × 1.5	5P			140	45	60	46		140	45	–	46		–	●	1,657
2863		1.5P													–	●	1,660
2891		9P													–	▲	2,318
2892	M 62 × 4	5P	STD	OH4	185	70	85	48		185	85	–	48		–	●	2,408
2893		1.5P													–	●	2,368
2901		9P													–	▲	2,328
2902	M 62 × 3	5P			185	70	85	48		185	85	–	48		–	●	2,377
2903		1.5P													–	●	2,372
2911		9P													–	▲	1,763
2912	M 62 × 2	5P	STD	OH3	140	45	60	48		140	55	–	48		–	●	1,781
2913		1.5P													–	●	1,790
2921		9P													–	▲	1,850
2922	M 62 × 1.5	5P			140	45	60	48		140	45	–	48		–	●	1,810
2923		1.5P													–	●	1,795
2931		9P													–	▲	2,960
2932	M 64 × 6	5P			225	86	106	48		225	105	–	48		–	●	2,978
2933		1.5P	STD	OH4											–	●	2,993
2941		9P													–	▲	2,458
2942	M 64 × 4	5P			185	70	85	48		185	85	–	48		–	●	2,428
2943		1.5P													–	●	2,450
2951		9P													–	▲	2,439
2952	M 64 × 3	5P			185	70	85	48		185	85	–	48		–	●	2,436
2953		1.5P													–	●	2,440
2961		9P													–	▲	1,809
2962	M 64 × 2	5P	STD	OH3	140	45	60	48		140	55	–	48		–	●	1,836
2963		1.5P													–	●	1,846
2971		9P													–	▲	1,855
2972	M 64 × 1.5	5P			140	45	60	48		140	45	–	48		–	●	1,862
2973		1.5P													–	●	1,872
2981		9P													–	▲	2,503
2982	M 65 × 4	5P	STD	OH4	185	70	85	50		185	85	–	50		–	●	2,537
2983		1.5P													–	●	2,498

JIS2

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尺寸 Size M65 ~ M75 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M58 ~ M65

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
2991		9P													–	▲	2,577
2992	M 65 × 3	5P			185	70	85	50		185	85	–	50		–	●	2,566
2993		1.5P													–	●	2,570
3001		9P													–	▲	1,950
3002	M 65 × 2	5P	STD	OH3	140	45	60	50		140	55	–	50		–	●	1,927
3003		1.5P													–	●	1,938
3011		9P													–	▲	1,999
3012	M 65 × 1.5	5P			140	45	60	50		140	45	–	50		–	●	1,935
3013		1.5P													–	●	1,900
3021		9P													–	▲	3,562
3022	M 68 × 6	5P			235	86	111	52		235	110	–	52		–	●	3,592
3023		1.5P	STD	OH4											–	●	3,605
3031		9P													–	▲	2,890
3032	M 68 × 4	5P			190	70	85	52		190	85	–	52		–	●	2,887
3033		1.5P													–	●	2,894
3041		9P													–	▲	2,882
3042	M 68 × 3	5P			190	70	85	52		190	85	–	52		–	●	2,908
3043		1.5P													–	●	2,901
3051		9P													–	▲	2,144
3052	M 68 × 2	5P	STD	OH3	140	45	60	52		140	55	–	52		–	●	2,130
3053		1.5P													–	●	2,131
3061		9P													–	▲	2,193
3062	M 68 × 1.5	5P			140	45	60	52		140	45	–	52		–	●	2,138
3063		1.5P													–	●	2,136
3081		9P							JIS2					4	–	▲	3,867
3082	M 70 × 6	5P			240	89	109	55		240	115	–	55		–	●	3,994
3083		1.5P	STD	OH4											–	●	4,066
3101		9P													–	▲	3,169
3102	M 70 × 4	5P			190	70	85	55		190	85	–	55		–	●	3,118
3103		1.5P													–	●	3,124
3111		9P													–	▲	2,312
3112	M 70 × 2	5P	STD	OH3	140	45	60	55		140	55	–	55		–	●	2,259
3113		1.5P													–	●	2,266
3131		9P													–	▲	4,052
3132	M 72 × 6	5P	STD	OH4	240	89	109	55		240	115	–	55		–	●	4,040
3133		1.5P													–	●	4,077
3151		9P													–	▲	2,312
3152	M 72 × 2	5P	STD	OH3	140	45	60	55		140	55	–	55		–	●	2,323
3153		1.5P													–	●	2,321
3161		9P													–	▲	3,136
3162	M 72 × 4	5P	STD	OH4	190	70	85	55		190	85	–	55		–	●	3,176
3163		1.5P													–	●	3,350
3171		9P													–	▲	3,199
3172	M 72 × 3	5P	STD	OH3	190	70	85	55		190	85	–	55		–	●	3,202
3173		1.5P													–	●	3,203
3181		9P													–	▲	3,551
3182	M 75 × 4	5P	STD	OH4	190	70	85	58		190	85	–	58		–	●	3,561
3183		1.5P													–	●	3,555

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产, 由 HT(切削锥 : 5P,1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT (ℓc:5P,1.5P).

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尺寸 Size M75 ~ M95 NEXT

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

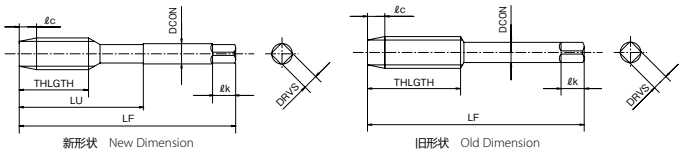
△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT

HSS



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FROM 尺寸 Size M65 ~ M75

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3201	M 75 × 2	9P	STD	OH3	145	48	63	58	JIS2	145	55	–	58	4	–	▲	2,689
3202		5P													–	●	2,719
3203		1.5P													–	●	2,724
3221	M 76 × 2	9P			145	48	63	58		145	55	–	58		–	▲	2,809
3222		5P													–	●	2,726
3223		1.5P													–	●	2,722
3291	M 80 × 6	9P	STD	OH4	245	89	114	58		245	115	–	58	6	–	▲	5,340
3292		5P													–	●	5,360
3293		1.5P													–	●	5,380
3301	M 80 × 4	9P			190	70	85	58		190	85	–	58		–	▲	4,454
3302		5P													–	●	4,150
3303		1.5P													–	●	4,166
3311	M 80 × 3	9P	STD	OH3	190	70	85	58		190	85	–	58		–	▲	4,215
3312		5P													–	●	4,160
3313		1.5P													–	●	4,181
3321	M 80 × 2	9P			145	48	63	58		145	55	–	58		–	▲	3,152
3322		5P													–	●	3,136
3323		1.5P													–	●	3,129
3341	M 85 × 6	9P	STD	OH4	245	89	114	60		245	115	–	60		–	▲	6,060
3342		5P													–	●	5,960
3343		1.5P													–	●	5,960
3351	M 85 × 4	9P			190	70	85	60		190	85	–	60		–	▲	4,880
3352		5P													–	●	4,900
3353		1.5P													–	●	4,906
3361	M 85 × 3	9P	STD	OH3	190	70	85	60		190	85	–	60		–	▲	4,818
3362		5P													–	●	4,733
3363		1.5P													–	●	4,700
3371	M 85 × 2	9P			150	48	63	60		150	55	–	60		–	▲	3,654
3372		5P													–	●	3,650
3373		1.5P													–	●	3,644
3391	M 90 × 6	9P	STD	OH4	250	89	114	60		250	120	–	60		–	▲	6,610
3392		5P													–	●	6,630
3393		1.5P													–	●	6,620
3401	M 90 × 4	9P			195	79	94	60		195	90	–	60		–	▲	5,400
3402		5P													–	●	5,140
3403		1.5P													–	●	5,140
3421	M 90 × 2	9P	STD	OH3	155	48	63	60		155	60	–	60		–	▲	3,955
3422		5P													–	●	4,150
3423		1.5P													–	●	4,205
3441	M 95 × 6	9P	STD	OH4	250	89	114	65		250	120	–	65		–	▲	7,240
3442		5P													–	●	7,590
3443		1.5P													–	●	7,600
3451	M 95 × 4	9P			200	79	94	65		200	90	–	65		–	▲	5,850
3452		5P													–	●	5,900
3453		1.5P													–	●	5,960
3471	M 95 × 2	9P	STD	OH3	155	48	63	65		155	60	–	65		–	▲	4,615
3472		5P													–	●	4,600
3473		1.5P													–	●	4,650

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尺寸 Size M100 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size **M75 ~ M95**

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3491		9P													–	▲	7,900
3492	**M 100 × 6**	5P			250	89	114	65		250	120	–	65		–	●	7,820
3493		1.5P	STD	OH4											–	●	7,720
3501		9P													–	▲	6,260
3502	**M 100 × 4**	5P			200	79	94	65	JIS2	200	90	–	65	6	–	●	6,480
3503		1.5P													–	●	6,240
3521		9P													–	▲	4,900
3522	**M 100 × 2**	5P	STD	OH3	155	48	63	65		155	60	–	65		–	●	4,800
3523		1.5P													–	●	4,820

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产, 由 HT(切削锥 : 5P,1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT (ℓc:5P,1.5P).

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

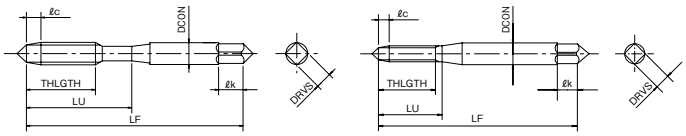
△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT

HSS



新形状 New Dimension　　旧形状 Old Dimension

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3811		9P													Yes	●	3
3812	No. 0 - 80 UNF	5P			36	8	—	3		36	13	13.5	3		Yes	●	3
3813		1.5P													Yes	●	3
3821		9P													Yes	●	3
3822	No. 1 - 64 UNC	5P			36	8	—	3		36	13	13.5	3		Yes	●	3
3823		1.5P													Yes	●	3
3831		9P													Yes	●	3
3832	No. 1 - 72 UNF	5P			36	8	—	3		36	13	13.5	3		Yes	●	3
3833		1.5P													Yes	●	3
3841		9P													Yes	●	4
3842	No. 2 - 56 UNC	5P			42	9.5	—	3		42	15	16	3		Yes	●	4
3843		1.5P													Yes	●	4
3851		9P													Yes	●	3
3852	No. 2 - 64 UNF	5P			42	9.5	—	3		42	15	16	3		Yes	●	3
3853		1.5P													Yes	●	3
3871		9P													Yes	●	3
3872	No. 3 - 48 UNC	5P	STD	OH1	44	9.5	—	3		44	16	21	3		Yes	●	3
3873		1.5P													Yes	●	3
3881		9P													Yes	●	3
3882	No. 3 - 56 UNF	5P			44	9.5	—	3		44	16	21	3		Yes	●	3
3883		1.5P													Yes	●	3
3891		9P													Yes	●	4
3892	No. 4 - 40 UNC	5P			44	11	—	3		44	16	21	3		Yes	●	4
3893		1.5P													Yes	●	4
3901		9P													Yes	●	3
3902	No. 4 - 48 UNF	5P			44	11	—	3		44	16	21	3		Yes	●	3
3903		1.5P													Yes	●	3
3911		9P							JIS2					3	Yes	●	4
3912	No. 5 - 40 UNC	5P			46	11	19	4		46	18	20	4		Yes	●	5
3913		1.5P													Yes	●	4
3921		9P													Yes	●	4
3922	No. 5 - 44 UNF	5P			46	11	19	4		46	18	20	4		Yes	●	4
3923		1.5P													Yes	●	4
3931		9P													Yes	●	5
3932	No. 6 - 32 UNC	5P	STD	OH2	48	13	21	4		48	18	23	4		Yes	●	5
3933		1.5P													Yes	●	5
3951		9P													Yes	●	4
3952	No. 6 - 40 UNF	5P	STD	OH1	48	13	21	4		48	18	23	4		Yes	●	4
3953		1.5P													Yes	●	4
3961		9P													Yes	●	8
3962	No. 8 - 32 UNC	5P			52	13	21	5		52	20	22	5		Yes	●	8
3963		1.5P													Yes	●	8
3971		9P													Yes	●	7
3972	No. 8 - 36 UNF	5P			52	13	21	5		52	20	22	5		Yes	●	7
3973		1.5P													Yes	●	7
3981		9P													Yes	●	9
3982	No.10 - 24 UNC	5P	STD	OH2	60	16	24	5.5		60	22	27	5.5		Yes	●	9
3983		1.5P													Yes	●	9
3991		9P													Yes	●	10
3992	No.10 - 32 UNF	5P			60	16	24	5.5		60	22	27	5.5		Yes	●	10
3993		1.5P													Yes	●	10
4021		9P													Yes	●	10
4022	No.12 - 24 UNC	5P			60	17	25	5.5		60	22	22	5.5		Yes	●	10
4023		1.5P													Yes	●	10

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尺寸 Size NO.12 ～ 5/16 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size NO.0 ~ NO.12

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
4031	No.12 - 28 UNF	9P	STD	OH2	60	17	25	5.5	JIS2	60	22	22	5.5	3	Yes	●	10
4032		5P													Yes	●	10
4033		1.5P													Yes	●	10
4051	1/4 - 20 UNC	9P			62	19	29	6		62	24	24	6		Yes	●	12
4052		5P													Yes	●	12
4053		1.5P													Yes	●	12
4061	1/4 - 28 UNF	9P			62	19	29	6		62	24	24	6		Yes	●	12
4062		5P													Yes	●	13
4063		1.5P													Yes	●	13
4071	1/4 - 32 UNEF	9P			62	19	29	6		58	24	24	6		Yes	●	10
4072		5P													Yes	●	12
4073		1.5P													Yes	●	12
4091	5/16 - 18 UNC	9P			70	22	37	6.1		70	30	–	6.1	4	–	●	16
4092		5P													–	●	17
4093		1.5P													–	●	18
4101	5/16 - 24 UNF	9P			70	22	37	6.1		70	30	–	6.1		–	●	17
4102		5P													–	●	17
4103		1.5P													–	●	18
4111	5/16 - 32 UNEF	9P			70	22	37	6.1		58	26	–	6.1		–	●	17
4112		5P													–	●	18
4113		1.5P													–	●	17
4121	3/8 - 16 UNC	9P			75	24	41	7		75	35	–	7		–	●	25
4122		5P													–	●	25
4123		1.5P													–	●	25
4131	3/8 - 20 UN	9P			75	24	41	7		75	35	–	7		–	●	24
4132		5P													–	●	24
4133		1.5P													–	●	24
4141	3/8 - 24 UNF	9P			75	24	41	7		75	32	–	7		–	●	25
4142		5P													–	●	25
4143		1.5P													–	●	25
4151	3/8 - 32 UNEF	9P			75	24	41	7		60	26	–	7		–	●	25
4152		5P													–	●	26
4153		1.5P													–	●	26
4171	7/16 - 14 UNC	9P			80	29	48	8		80	38	–	8		–	●	34
4172		5P													–	●	34
4173		1.5P													–	●	35
4181	7/16 - 20 UNF	9P			80	29	48	8		80	38	–	8		–	●	36
4182		5P													–	●	35
4183		1.5P													–	●	35
4221	1/2 - 13 UNC	9P			85	29	48	9		85	42	–	9		–	●	48
4222		5P													–	●	48
4223		1.5P													–	●	48
4251	1/2 - 20 UNF	9P			85	29	48	9		85	42	–	9		–	●	48
4252		5P													–	●	49
4253		1.5P													–	●	50
4301	9/16 - 12 UNC	9P			90	30	48	10.5		90	42	–	10.5		–	●	66
4302		5P													–	●	67
4303		1.5P													–	●	67

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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尺寸 Size 9/16 ~ 1 1/4 NEXT

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

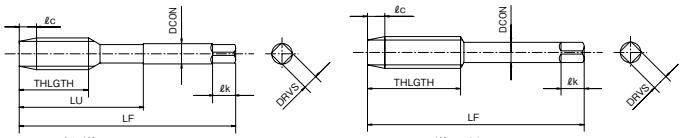
△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT

HSS



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FROM 尺寸 Size NO.12 ～ 9/16

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突肩尖 External Center	库存 Stock	重量 (g)
4321	9/16 - 18 UNF	9P	STD	OH2	90	30	48	10.5	JIS2	90	42	—	10.5	4	—	●	67
4322		5P													—	●	68
4323		1.5P													—	●	68
4371	5/8 - 11 UNC	9P	STD	OH3	95	37	52	12		95	45	—	12		—	●	87
4372		5P													—	●	88
4373		1.5P													—	●	88
4401	5/8 - 18 UNF	9P	STD	OH2	95	37	52	12		95	45	—	12		—	●	88
4402		5P													—	●	90
4403		1.5P													—	●	90
4421	5/8 - 24 UNEF	9P	STD	OH2	95	32	52	12		75	35	—	12		—	●	88
4422		5P													—	●	88
4423		1.5P													—	●	88
4451	3/4 - 10 UNC	9P	STD	OH3	105	37	58	14		105	50	—	14		—	●	122
4452		5P													—	●	123
4453		1.5P													—	●	123
4471	3/4 - 16 UNF	9P	STD	OH2	95	32	52	14		95	45	—	14		—	●	113
4472		5P													—	●	113
4473		1.5P													—	●	115
4481	3/4 - 20 UNEF	9P	STD	OH2	95	32	52	14		85	42	—	14		—	●	113
4482		5P													—	●	113
4483		1.5P													—	●	113
4591	7/8 - 9 UNC	9P	STD	OH3	115	45	63	17		115	55	—	17		—	●	186
4592		5P													—	●	188
4593		1.5P													—	●	187
4611	7/8 - 14 UNF	9P	STD	OH2	105	37	47	17		95	45	—	17		—	●	175
4612		5P													—	●	175
4613		1.5P													—	●	179
4631	7/8 - 20 UNEF	9P	STD	OH2	95	32	48	17		90	42	—	17		—	●	159
4632		5P													—	●	159
4633		1.5P													—	●	161
4711	1 - 8 UNC	9P	STD	OH3	125	45	68	20		125	60	—	20		—	●	276
4712		5P													—	●	279
4713		1.5P													—	●	278
4721	1 - 12 UNF	9P	STD	OH2	105	37	47	20		95	45	—	20		—	●	232
4722		5P													—	●	232
4723		1.5P													—	●	236
4731	1 - 14 UNS	9P	STD	OH2	105	37	47	20		95	45	—	20		—	●	237
4732		5P													—	●	233
4733		1.5P													—	●	233
4771	1 1/16 - 12 UN	9P	STD	OH2	105	37	47	22		95	45	—	22		—	●	280
4772		5P													—	●	282
4773		1.5P													—	●	285
4791	1 1/8 - 7 UNC	9P	STD	OH3	135	51	72	22		135	65	—	22		—	●	372
4792		5P													—	●	375
4793		1.5P													—	●	377
4801	1 1/8 - 12 UNF	9P	STD	OH2	105	37	47	22		105	45	—	22		—	●	290
4802		5P													—	●	290
4803		1.5P													—	●	298
4811	1 1/8 - 8 UN	9P	STD	OH3	135	51	72	22		135	65	—	22		—	●	371
4812		5P													—	●	373
4813		1.5P													—	●	378
4851	1 1/4 - 7 UNC	9P	STD	OH3	145	51	77	24		145	70	—	24		—	●	486
4852		5P													—	●	487
4853		1.5P													—	●	481

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尺寸 Size 1 1/4 ～ 2 NEXT

库存记号 Inventory symbols
- ● = 标准库存品 Standard stock item
- ○ = 准标准库存品(请确认库存。) Limited standard stock item
- ▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
- △ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size 9/16 ~ 1 1/4

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
4861		9P													–	●	350
4862	1 1/4 - 12 UNF	5P	STD	OH3	105	37	47	24		105	45	–	24		–	●	350
4863		1.5P													–	●	353
4871		9P													–	●	489
4872	1 1/4 - 8 UN	5P			145	51	77	24		145	70	–	24		–	●	485
4873		1.5P													–	●	493
4931		9P													–	●	401
4932	1 5/16 - 12 UN	5P	STD	OH2	105	37	47	26		105	45	–	26		–	●	402
4933		1.5P													–	●	401
4951		9P													–	●	604
4952	1 3/8 - 6 UNC	5P			155	60	82	26		155	75	–	26		–	●	610
4953		1.5P													–	●	614
4961		9P													–	●	618
4962	1 3/8 - 8 UN	5P			155	60	82	26		155	75	–	26		–	●	622
4963		1.5P													–	●	621
4971		9P													–	●	429
4972	1 3/8 - 12 UNF	5P			110	39	49	26		110	45	–	26		–	●	431
4973		1.5P													–	●	434
5001		9P	STD	OH3											–	●	791
5002	1 1/2 - 6 UNC	5P			160	60	85	30		160	78	–	30		–	●	794
5003		1.5P													–	●	809
5011		9P													–	●	814
5012	1 1/2 - 8 UN	5P			160	60	85	30		160	75	–	30		–	●	805
5013		1.5P													–	●	805
5021		9P							JIS2					4	–	●	572
5022	1 1/2 - 12 UNF	5P			115	39	49	30		115	45	–	30		–	●	572
5023		1.5P													–	●	570
5061		9P													–	●	1,019
5062	1 5/8 - 5 UNS	5P	STD	OH4	175	76	93	32		175	85	–	32		–	●	994
5063		1.5P													–	●	983
5081		9P													–	●	928
5082	1 5/8 - 8 UN	5P	STD	OH3	160	60	85	32		160	80	–	32		–	●	940
5083		1.5P													–	●	930
5091		9P													–	●	671
5092	1 5/8 - 12 UN	5P			115	39	49	32		115	45	–	32		–	●	672
5093		1.5P													–	●	672
5121		9P													–	●	1,148
5122	1 3/4 - 5 UNC	5P	STD	OH4	175	76	93	35		175	85	–	35		–	●	1,168
5123		1.5P													–	●	1,164
5131		9P													–	●	1,183
5132	1 3/4 - 8 UN	5P			175	67	93	35		175	85	–	35		–	●	1,184
5133		1.5P													–	●	1,189
5141		9P	STD	OH3											–	●	808
5142	1 3/4 - 12 UN	5P			120	39	49	35		120	45	–	35		–	●	808
5143		1.5P													–	●	811
5231		9P													–	●	1,702
5232	2 -4 1/2UNC	5P	STD	OH4	195	79	103	40		195	92	–	40		–	●	1,730
5233		1.5P													–	●	1,756

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2B 内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

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尺寸 Size 2 ~ 4 NEXT

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

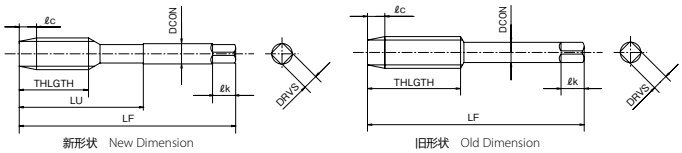
△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT

HSS



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FROM 尺寸 Size 1 ¼ ~ 2

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
5251	2 - 8 UN	9P	STD	OH3	185	67	93	40	JIS2	185	85	–	40	4	–	●	1,695
5252		5P													–	●	1,670
5253		1.5P													–	●	1,694
5261	2 - 12 UN	9P			130	39	49	40		130	45	–	40		–	●	1,161
5262		5P													–	●	1,166
5263		1.5P													–	●	1,172
5291	2 ¼ -4 ½UNC	9P	STD	OH4	205	79	108	44		205	95	–	44		–	●	2,243
5292		5P													–	●	2,272
5293		1.5P													–	●	2,251
5331	2 ½ - 4 UNC	9P			225	89	119	48		225	105	–	48		–	●	2,882
5332		5P													–	●	2,970
5333		1.5P													–	●	2,950
5341	2 ½ - 8 UN	9P	STD	OH3	200	76	103	48		200	85	–	48		–	●	2,627
5342		5P													–	●	2,642
5343		1.5P													–	●	2,633
5361	2 ¾ - 8 UN	9P			210	76	103	55		210	90	–	55		–	●	3,481
5362		5P													–	●	3,501
5363		1.5P													–	●	3,515
5371	3 - 4 UNC	9P	STD	OH4	245	89	130	58		245	115	–	58		–	●	4,568
5372		5P													–	●	4,586
5373		1.5P													–	●	4,607
5381	3 - 8 UN	9P	STD	OH3	220	76	103	58		220	90	–	58		–	●	4,140
5382		5P													–	●	4,277
5383		1.5P													–	●	4,260
5391	3 ½ - 4 UNC	9P	STD	OH4	265	89	140	60		265	120	–	60	6	–	●	6,820
5392		5P													–	●	6,840
5393		1.5P													–	●	6,860
5401	3 ½ - 8 UN	9P	STD	OH3	240	79	106	60		240	95	–	60		–	●	6,140
5402		5P													–	●	6,060
5403		1.5P													–	●	6,080
5421	4 - 4 UNC	9P	STD	OH4	275	89	146	65		275	120	–	65		–	●	9,000
5422		5P													–	●	8,800
5423		1.5P													–	●	8,580
5431	4 - 8 UN	9P	STD	OH3	255	79	106	65		255	115	–	65		–	●	8,460
5432		5P													–	●	8,000
5433		1.5P													–	●	8,180

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少，逐渐由新形状来替代。
2. 精度栏 [ ] 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

HSS

螺纹种类：W

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
5441	W 1/8 - 40	JIS2	9P	46	18	—	4	3	Yes	●	4
5442			5P						Yes	●	4
5443			1.5P						Yes	●	4
5451	W 5/32 - 32		9P	52	20	—	5		Yes	●	7
5452			5P						Yes	●	7
5453			1.5P						Yes	●	7
5461	W 3/16 - 24		9P	60	22	—	5.5		Yes	●	10
5462			5P						Yes	●	10
5463			1.5P						Yes	●	10
5471	W 1/4 - 20		9P	62	24	—	6		Yes	●	13
5472			5P						Yes	●	13
5473			1.5P						Yes	●	13
5481	W 5/16 - 18		9P	70	30	—	6.1	4	—	●	17
5482			5P						—	●	17
5483			1.5P						—	●	17
5491	W 3/8 - 16		9P	75	35	—	7		—	●	25
5492			5P						—	●	25
5493			1.5P						—	●	25
5501	W 7/16 - 14		9P	80	38	—	8		—	●	34
5502			5P						—	●	35
5503			1.5P						—	●	34
5511	W 1/2 - 12		9P	85	42	—	9		—	●	48
5512			5P						—	●	49
5513			1.5P						—	●	49
5521	W 9/16 - 12		9P	90	42	—	10.5		—	●	66
5522			5P						—	●	67
5523			1.5P						—	●	67
5531	W 5/8 - 11		9P	95	45	—	12		—	●	86
5532			5P						—	●	87
5533			1.5P						—	●	88
5541	W 3/4 - 10		9P	105	50	—	14		—	●	123
5542			5P						—	●	124
5543			1.5P						—	●	124
5551	W 7/8 - 9		9P	115	55	—	17		—	●	184
5552			5P						—	●	183
5553			1.5P						—	●	186
5561	W 1 - 8		9P	125	60	—	20		—	●	273
5562			5P						—	●	277
5563			1.5P						—	●	277
5571	W 1 1/8 - 7		9P	135	65	—	22		—	△	366
5572			5P						—	△	363
5573			1.5P						—	△	375

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
5581	W 1 1/4 - 7	JIS2	9P	145	70	—	24	4	—	△	484
5582			5P						—	△	484
5583			1.5P						—	△	484
5591	W 1 3/8 - 6		9P	155	75	—	26		—	△	596
5592			5P						—	△	596
5593			1.5P						—	△	597
5601	W 1 1/2 - 6		9P	160	78	—	30		—	△	776
5602			5P						—	△	777
5603			1.5P						—	△	779
5611	W 1 5/8 - 5		9P	170	82	—	32		—	△	980
5612			5P						—	△	951
5613			1.5P						—	△	974
5621	W 1 3/4 - 5		9P	175	85	—	35		—	△	1,165
5622			5P						—	△	1,167
5623			1.5P						—	△	1,157
5631	W 1 7/8 - 4 1/2		9P	185	90	—	38		—	△	1,403
5632			5P						—	△	1,397
5633			1.5P						—	△	1,420
5641	W 2 - 4 1/2		9P	195	92	—	40		—	△	1,700
5642			5P						—	△	1,726
5643			1.5P						—	△	1,719
5651	W 2 1/8 - 4		9P	210	100	—	44		—	△	2,134
5652			5P						—	△	2,165
5653			1.5P						—	△	2,142
5661	W 2 1/4 - 4		9P	210	100	—	44		—	△	2,326
5662			5P						—	△	2,308
5663			1.5P						—	△	2,277
5671	W 2 3/8 - 4		9P	225	105	—	46		—	△	2,696
5672			5P						—	△	2,607
5673			1.5P						—	△	2,657
5681	W 2 1/2 - 4		9P	225	105	—	48		—	△	2,908
5682			5P						—	△	2,925
5683			1.5P						—	△	2,933
5691	W 2 3/4 - 3 1/2		9P	235	110	—	55		—	△	3,867
5692			5P						—	△	3,772
5693			1.5P						—	△	3,894
5701	W 2 7/8 - 3 1/2		9P	250	115	—	56		—	△	4,442
5702			5P						—	△	4,489
5703			1.5P						—	△	4,437
5711	W 3 - 3 1/2		9P	250	115	—	58		—	△	4,967
5712			5P						—	△	4,712
5713			1.5P						—	△	4,635

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1062

一般用
GENERAL APPLICATION

HT

HSS

螺纹种类：SM

单位 :mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock		重量 (g)
8602	SM 3/32 - 56	STD	OH1	5P	42	15	—	3		Yes	D	●	3
8603				1.5P						Yes		●	3
8612	SM 1/8 - 40			5P	46	18	—	4		Yes		●	4
8613				1.5P						Yes		●	4
8622	SM 1/8 - 44			5P	46	18	—	4		Yes		●	4
8623				1.5P						Yes		●	6
8632	SM 9/64 - 40			5P	48	18	—	4		Yes		●	6
8633				1.5P						Yes		●	5
8642	SM 11/64 - 40		OH2	5P	55	20	—	5		Yes		●	9
8643				1.5P						Yes		●	8
8652	SM 3/16 - 24			5P	60	22	—	5.5		Yes		●	11
8653				1.5P						Yes		●	10
8662	SM 3/16 - 28			5P	60	22	—	5.5	3	Yes		●	10
8663				1.5P						Yes		●	10
8672	SM 3/16 - 32			5P	60	22	—	5.5		Yes		●	10
8673				1.5P						Yes		●	10
8682	SM 7/32 - 32			5P	60	22	—	5.5		Yes		●	11
8683				1.5P						Yes		●	11
8692	SM 15/64 - 28			5P	62	24	—	6		Yes		●	12
8693				1.5P						Yes		●	12
8702	SM 1/4 - 24			5P	62	24	—	6		Yes		●	12
8703				1.5P						Yes		●	12
8712	SM 1/4 - 28			5P	62	24	—	6		Yes		●	12
8713				1.5P						Yes		●	14
8722	SM 1/4 - 40			5P	62	24	—	6		Yes		●	13
8723				1.5P						Yes		●	13

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock		重量 (g)
8732	SM 9/32 - 20	STD	OH2	5P	65	26	—	6.5		—	D	●	18
8733				1.5P						—		●	15
8742	SM 9/32 - 28			5P	65	26	—	6.5		—		●	16
8743				1.5P						—		●	16
8752	SM 5/16 - 18			5P	70	30	—	6.1		—		●	16
8753				1.5P						—		●	16
8762	SM 5/16 - 24			5P	70	30	—	6.1		—		●	17
8763				1.5P						—		●	18
8772	SM 5/16 - 28			5P	70	30	—	6.1		—		●	17
8773				1.5P						—		●	19
8782	SM 11/32 - 28			5P	70	30	—	7		—		●	23
8783				1.5P						—		●	20
8792	SM 3/8 - 18			5P	75	35	—	7	4	—		●	25
8793				1.5P						—		●	24
8802	SM 3/8 - 28			5P	70	30	—	7		—		●	23
8803				1.5P						—		●	24
8812	SM 7/16 - 16			5P	80	38	—	8		—		●	34
8813				1.5P						—		●	34
8822	SM 7/16 - 28			5P	70	30	—	8		—		●	32
8823				1.5P						—		●	32
8832	SM 1/2 - 12		OH3	5P	85	42	—	9		—		●	48
8833				1.5P						—		●	52
8842	SM 1/2 - 20		OH2	5P	85	42	—	9		—		●	48
8843				1.5P						—		●	45
8852	SM 1/2 - 28			5P	70	30	—	9		—		●	40
8853				1.5P						—		●	38

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

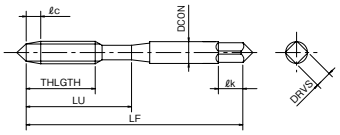
■记号说明请参考 P1页。 See p.1 for explanation of icons.

一般用(左螺纹)

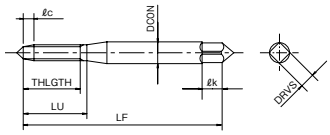
GENERAL APPLICATION (LH THREAD)

HT

HSS



新形状 New Dimension



旧形状 Old Dimension

螺纹种类：M(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
5881		9P													Yes	▲	3
5882	M 1.4× 0.3 -L	5P			34	7	—	3		34	11	11.5	3		Yes	●	3
5883		1.5P													Yes	●	3
6011		9P													Yes	▲	3
6012	M 1.7× 0.35 -L	5P			36	8	—	3		36	13	13.5	3		Yes	●	3
6013		1.5P													Yes	●	3
6041		9P													Yes	▲	3
6042	M 2 × 0.4 -L	5P			40	8	—	3		40	15	16	3		Yes	●	3
6043		1.5P													Yes	●	3
6061		9P													Yes	▲	3
6062	M 2 × 0.25 -L	5P			40	8	—	3		40	8	9	3		Yes	●	3
6063		1.5P													Yes	●	3
6091		9P													Yes	▲	3
6092	M 2.3× 0.4 -L	5P			42	9.5	—	3		42	15	20	3		Yes	●	3
6093		1.5P													Yes	●	3
6111		9P													Yes	▲	3
6112	M 2.3× 0.25 -L	5P	STD	OH1	42	8	—	3		42	8	9	3		Yes	●	3
6113		1.5P													Yes	●	3
6141		9P													Yes	▲	3
6142	M 2.6× 0.45 -L	5P			44	9.5	—	3		44	16	21	3		Yes	●	3
6143		1.5P													Yes	●	3
6161		9P													Yes	▲	5
6162	M 3 × 0.6 -L	5P			46	11	19	4	JIS2	46	18	20	4	3	Yes	●	4
6163		1.5P													Yes	●	4
6171		9P													Yes	▲	4
6172	M 3 × 0.5 -L	5P			46	11	19	4		46	18	20	4		Yes	●	5
6173		1.5P													Yes	●	4
6181		9P													Yes	▲	5
6182	M 3 × 0.35 -L	5P			46	10	19	4		46	10	12	4		Yes	●	4
6183		1.5P													Yes	●	4
6191		9P													Yes	▲	5
6192	M 3.5× 0.6 -L	5P			48	13	20	4		48	18	23	4		Yes	●	5
6193		1.5P													Yes	●	5
6211		9P													Yes	▲	6
6212	M 4 × 0.75 -L	5P			52	13	21	5		52	20	22	5		Yes	●	7
6213		1.5P	STD	OH2											Yes	●	7
6231		9P													Yes	▲	8
6232	M 4 × 0.7 -L	5P			52	13	21	5		52	20	22	5		Yes	●	8
6233		1.5P													Yes	●	8
6241		9P													Yes	▲	7
6242	M 4 × 0.5 -L	5P	STD	OH1	52	13	21	5		52	15	17	5		Yes	●	8
6243		1.5P													Yes	●	7
6251		9P													Yes	▲	8
6252	M 4.5× 0.75 -L	5P	STD	OH2	55	13	21	5		55	20	25	5		Yes	●	8
6253		1.5P													Yes	●	8

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产, 由HT 左螺纹(切削锥 : 5P、1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT LH THREAD (ℓc:5P,1.5P).

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尺寸 Size M5 ~ M10 NEXT

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

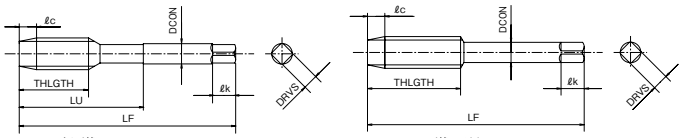
G-LIST No. | TH1062

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

HT

HSS



上一页
FROM 尺寸 Size M1.4 ~ M4.5

螺纹种类：M(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
6271		9P													Yes	▲	10
6272	M 5 × 0.9 -L	5P			60	16	24	5.5		60	22	27	5.5		Yes	●	10
6273		1.5P													Yes	●	10
6281		9P													Yes	▲	10
6282	M 5 × 0.8 -L	5P	STD	OH2	60	16	24	5.5		60	22	27	5.5		Yes	●	10
6283		1.5P													Yes	●	10
6291		9P													Yes	▲	10
6292	M 5 × 0.75 -L	5P			60	16	24	5.5		60	22	27	5.5		Yes	●	10
6293		1.5P													Yes	●	10
6301		9P													Yes	▲	10
6302	M 5 × 0.5 -L	5P	STD	OH1	60	15	24	5.5		52	15	20	5.5		Yes	●	10
6303		1.5P													Yes	●	10
6321		9P												3	Yes	▲	10
6322	M 5.5× 0.9 -L	5P			60	17	25	5.5		60	22	22	5.5		Yes	●	10
6323		1.5P													Yes	●	10
6351		9P													Yes	▲	12
6352	M 6 × 1 -L	5P	STD	OH2	62	19	29	6		62	24	24	6		Yes	●	12
6353		1.5P													Yes	●	12
6361		9P													Yes	▲	12
6362	M 6 × 0.75 -L	5P			62	19	29	6		62	20	20	6		Yes	●	12
6363		1.5P													Yes	●	12
6371		9P													Yes	▲	12
6372	M 6 × 0.5 -L	5P	STD	OH1	62	15	29	6		55	15	15	6		Yes	●	12
6373		1.5P													Yes	●	12
6381		9P													—	▲	15
6382	M 7 × 1 -L	5P			65	19	33	6.2		65	26	—	6.2		—	●	15
6383		1.5P													—	●	15
6411		9P													—	▲	17
6412	M 8 × 1.25 -L	5P			70	22	37	6.2		70	30	—	6.2		—	●	18
6413		1.5P	STD	OH2					JIS2						—	●	18
6421		9P													—	▲	17
6422	M 8 × 1 -L	5P			70	22	37	6.2		70	30	—	6.2		—	●	18
6423		1.5P													—	●	17
6431		9P													—	▲	17
6432	M 8 × 0.75 -L	5P			70	20	35	6.2		62	20	—	6.2		—	●	18
6433		1.5P													—	●	17
6441		9P													—	▲	17
6442	M 8 × 0.5 -L	5P	STD	OH1	70	15	30	6.2		55	15	—	6.2		—	●	17
6443		1.5P													—	●	17
6451		9P													—	▲	22
6452	M 9 × 1.25 -L	5P			72	22	38	7		72	30	—	7	4	—	●	22
6453		1.5P													—	●	22
6461		9P													—	▲	23
6462	M 9 × 1 -L	5P			72	22	38	7		70	30	—	7		—	●	23
6463		1.5P													—	●	23
6481		9P													—	▲	25
6482	M 10 × 1.5 -L	5P			75	24	41	7		75	32	—	7		—	●	26
6483		1.5P	STD	OH2											—	●	26
6491		9P													—	▲	26
6492	M 10 × 1.25 -L	5P			75	24	41	7		75	32	—	7		—	●	26
6493		1.5P													—	●	26
6501		9P													—	▲	25
6502	M 10 × 1 -L	5P			75	24	41	7		70	30	—	7		—	●	26
6503		1.5P													—	●	25
6511		9P													—	▲	22
6512	M 10 × 0.75 -L	5P			75	20	37	7		62	20	—	7		—	●	26
6513		1.5P													—	●	22

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尺寸 Size M11 ~ M16 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M5 ~ M10

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
6531		9P	STD	OH2	80	25	48	8	JIS2	80	38	—	8	4	—	▲	33
6532	M 11 × 1.5 -L	5P													—	●	35
6533		1.5P													—	●	34
6581		9P			82	29	48	8.5		82	38	—	8.5		—	▲	40
6582	M 12 × 1.75 -L	5P													—	●	40
6583		1.5P													—	●	40
6591		9P			82	29	48	8.5		82	38	—	8.5		—	▲	40
6592	M 12 × 1.5 -L	5P													—	●	41
6593		1.5P													—	●	40
6601		9P			82	29	48	8.5		80	38	—	8.5		—	▲	40
6602	M 12 × 1.25 -L	5P													—	●	41
6603		1.5P													—	●	41
6611		9P			82	29	48	8.5		70	30	—	8.5		—	▲	40
6612	M 12 × 1 -L	5P													—	●	41
6613		1.5P													—	●	40
6641		9P			88	29	48	9.5		88	42	—	9.5		—	▲	54
6642	M 13 × 1.75 -L	5P													—	●	54
6643		1.5P													—	●	56
6651		9P			88	29	48	9.5		85	42	—	9.5		—	▲	56
6652	M 13 × 1.5 -L	5P													—	●	55
6653		1.5P													—	●	51
6701		9P			88	30	48	10.5		88	42	—	10.5		—	▲	67
6702	M 14 × 2 -L	5P													—	●	67
6703		1.5P													—	●	64
6711		9P			88	30	48	10.5		88	42	—	10.5		—	▲	65
6712	M 14 × 1.5 -L	5P													—	●	67
6713		1.5P													—	●	67
6721		9P			88	30	48	10.5		88	42	—	10.5		—	▲	65
6722	M 14 × 1.25 -L	5P													—	●	66
6723		1.5P													—	●	65
6731		9P			88	30	48	10.5		70	30	—	10.5		—	▲	66
6732	M 14 × 1 -L	5P													—	●	67
6733		1.5P													—	●	66
6761		9P			95	30	48	10.5		90	42	—	10.5		—	▲	73
6762	M 15 × 2 -L	5P													—	●	72
6763		1.5P													—	●	74
6771		9P			95	30	52	10.5		90	42	—	10.5		—	▲	73
6772	M 15 × 1.5 -L	5P													—	●	72
6773		1.5P													—	●	70
6791		9P			95	30	50	10.5		70	30	—	10.5		—	▲	73
6792	M 15 × 1 -L	5P													—	●	73
6793		1.5P													—	●	73
6811		9P			95	32	52	12.5		95	45	—	12.5		—	▲	91
6812	M 16 × 2 -L	5P													—	●	92
6813		1.5P													—	●	94
6821		9P			95	32	52	12.5		95	45	—	12.5		—	▲	92
6822	M 16 × 1.5 -L	5P													—	●	94
6823		1.5P													—	●	94

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产, 由 HT 左螺纹(切削锥 : 5P、1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT LH THREAD (ℓc:5P,1.5P).

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尺寸 Size M16 ~ M22 NEXT

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

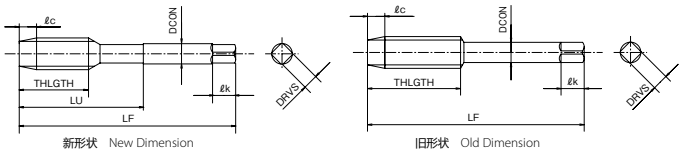
G-LIST No. | TH1062

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

HT

HSS



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FROM 尺寸 Size M11 ~ M16

螺纹种类：M(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
6831		9P													—	▲	86
6832	M 16 × 1.25 -L	5P			95	32	52	12.5		95	45	—	12.5		—	●	92
6833		1.5P													—	●	92
6841		9P													—	▲	94
6842	M 16 × 1 -L	5P			95	30	50	12.5		75	30	—	12.5		—	●	94
6843		1.5P													—	●	94
6881		9P													—	▲	110
6882	M 17 × 2 -L	5P	STD	OH2	100	32	52	13		95	45	—	13		—	●	97
6883		1.5P													—	●	94
6891		9P													—	▲	98
6892	M 17 × 1.5 -L	5P			100	32	52	13		95	45	—	13		—	●	99
6893		1.5P													—	●	100
6901		9P													—	▲	95
6902	M 17 × 1 -L	5P			95	30	50	13		80	30	—	13		—	●	95
6903		1.5P													—	●	95
6931		9P													—	▲	111
6932	M 18 × 2.5 -L	5P			100	37	55	14		100	48	—	14		—	●	111
6933		1.5P	STD	OH3											—	●	113
6941		9P													—	▲	113
6942	M 18 × 2 -L	5P			100	37	55	14		95	45	—	14		—	●	113
6943		1.5P													—	●	113
6951		9P													—	▲	106
6952	M 18 × 1.5 -L	5P			100	37	55	14		95	45	—	14		—	●	115
6953		1.5P													—	●	113
6961		9P													—	▲	99
6962	M 18 × 1.25 -L	5P	STD	OH2	100	37	55	14		95	45	—	14		—	●	115
6963		1.5P													—	●	115
6971		9P													—	▲	108
6972	M 18 × 1 -L	5P			95	30	50	14	JIS2	80	30	—	14	4	—	●	108
6973		1.5P													—	●	108
7001		9P													—	▲	119
7002	M 19 × 2.5 -L	5P			105	37	58	14		105	50	—	14		—	●	121
7003		1.5P													—	●	121
7011		9P													—	▲	110
7012	M 19 × 2 -L	5P			100	37	55	14		95	45	—	14		—	●	124
7013		1.5P													—	●	124
7031		9P													—	▲	122
7032	M 19 × 1.5 -L	5P			105	37	58	14		95	45	—	14		—	●	123
7033		1.5P													—	●	124
7041		9P	STD	OH3											—	▲	136
7042	M 20 × 2.5 -L	5P			105	37	58	15		105	50	—	15		—	●	138
7043		1.5P													—	●	139
7071		9P													—	▲	137
7072	M 20 × 2 -L	5P			105	37	58	15		95	45	—	15		—	●	140
7073		1.5P													—	●	140
7081		9P													—	▲	140
7082	M 20 × 1.5 -L	5P			105	37	58	15		95	45	—	15		—	●	142
7083		1.5P													—	●	142
7101		9P													—	▲	126
7102	M 20 × 1 -L	5P	STD	OH2	95	30	51	15		80	30	—	15		—	●	128
7103		1.5P													—	●	127
7161		9P													—	▲	184
7162	M 22 × 2.5 -L	5P			115	38	63	17		115	55	—	17		—	●	185
7163		1.5P	STD	OH3											—	●	186
7171		9P													—	▲	152
7172	M 22 × 2 -L	5P			115	38	63	17		95	45	—	17		—	●	188
7173		1.5P													—	●	186

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尺寸 Size M22 ~ M36 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size M16 ~ M22

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
7181		9P													–	▲	187
7182	M 22 × 1.5 -L	5P	STD	OH3	115	38	63	17		95	45	–	17		–	●	188
7183		1.5P													–	●	189
7191		9P													–	▲	165
7192	M 22 × 1 -L	5P	STD	OH2	95	30	45	17		85	30	–	17		–	●	159
7193		1.5P													–	●	159
7251		9P													–	▲	241
7252	M 24 × 3 -L	5P			120	45	66	19		120	58	–	19		–	●	236
7253		1.5P													–	●	237
7261		9P													–	▲	244
7262	M 24 × 2 -L	5P			120	45	66	19		95	45	–	19		–	●	247
7263		1.5P													–	●	240
7271		9P													–	▲	240
7272	M 24 × 1.5 -L	5P			120	45	66	19		95	45	–	19		–	●	242
7273		1.5P													–	●	244
7311		9P													–	▲	202
7312	M 25 × 1.5 -L	5P			130	45	71	19		95	45	–	19		–	●	280
7313		1.5P													–	●	277
7341		9P													–	▲	300
7342	M 26 × 1.5 -L	5P			130	45	71	20		95	45	–	20		–	●	298
7343		1.5P													–	●	299
7371		9P													–	▲	306
7372	M 27 × 3 -L	5P			130	45	71	20		130	62	–	20		–	●	307
7373		1.5P													–	●	315
7381		9P													–	▲	233
7382	M 27 × 2 -L	5P			130	45	71	20	JIS2	95	45	–	20	4	–	●	312
7383		1.5P													–	●	313
7391		9P													–	▲	236
7392	M 27 × 1.5 -L	5P	STD	OH3	130	45	71	20		95	45	–	20		–	●	216
7393		1.5P													–	●	314
7421		9P													–	▲	260
7422	M 28 × 1.5 -L	5P			130	45	60	21		105	45	–	21		–	●	354
7423		1.5P													–	●	355
7451		9P													–	▲	400
7452	M 30 × 3.5 -L	5P			135	51	74	23		135	65	–	23		–	●	400
7453		1.5P													–	●	408
7471		9P													–	▲	406
7472	M 30 × 2 -L	5P			135	45	74	23		105	45	–	23		–	●	409
7473		1.5P													–	●	411
7481		9P													–	▲	408
7482	M 30 × 1.5 -L	5P			130	45	60	23		105	45	–	23		–	●	409
7483		1.5P													–	●	409
7511		9P													–	▲	354
7512	M 32 × 1.5 -L	5P			105	37	47	24		105	45	–	24		–	●	358
7513		1.5P													–	●	354
7541		9P													–	▲	512
7542	M 33 × 3.5 -L	5P			145	51	76	25		145	70	–	25		–	●	510
7543		1.5P													–	●	521
7571		9P													–	▲	683
7572	M 36 × 4 -L	5P			155	57	77	28		155	75	–	28		–	●	681
7573		1.5P													–	●	688

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产, 由 HT 左螺纹(切削锥 : 5P、1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT LH THREAD (ℓc:5P,1.5P).

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

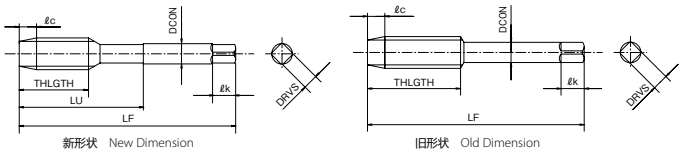
G-LIST No. | TH1062

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

HT

HSS



螺纹种类：U(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14211	1/4- 20UNC - L	9P	STD	OH2	62	19	29	6	JIS2	62	24	24	6	3	Yes	△	13
14212		5P													Yes	△	13
14213		1.5P													Yes	△	13
14221	1/4- 28UNF - L	9P			62	19	29	6		62	24	24	6		Yes	△	13
14222		5P													Yes	△	13
14223		1.5P													Yes	△	13
14251	5/16- 18UNC - L	9P			70	22	37	6.1		70	30	–	6.1	4	–	△	17
14252		5P													–	△	17
14253		1.5P													–	△	17
14261	5/16- 24UNF - L	9P			70	22	37	6.1		70	30	–	6.1		–	△	17
14262		5P													–	△	18
14263		1.5P													–	△	17
14281	3/8- 16UNC - L	9P			75	24	41	7		75	35	–	7		–	△	24
14282		5P													–	△	25
14283		1.5P													–	△	25
14301	3/8- 24UNF - L	9P			75	24	41	7		75	32	–	7		–	△	24
14302		5P													–	△	25
14303		1.5P													–	△	25
14341	1/2- 13UNC - L	9P			85	29	48	9		85	42	–	9		–	△	49
14342		5P													–	△	48
14343		1.5P													–	△	47
14361	1/2- 20UNF - L	9P			85	29	48	9		85	42	–	9		–	△	50
14362		5P													–	△	49
14363		1.5P													–	△	49
14391	5/8- 11UNC - L	9P	STD	OH3	95	37	52	12		95	45	–	12		–	△	84
14392		5P													–	△	86
14393		1.5P													–	△	87
14401	5/8- 18UNF - L	9P	STD	OH2	95	37	52	12		95	45	–	12		–	△	87
14402		5P													–	△	88
14403		1.5P													–	△	90
14421	3/4- 10UNC - L	9P	STD	OH3	105	37	58	14		105	50	–	14		–	△	119
14422		5P													–	△	122
14423		1.5P													–	△	123
14431	3/4- 16UNF - L	9P	STD	OH2	95	32	52	14		95	45	–	14		–	△	111
14432		5P													–	△	114
14433		1.5P													–	△	114
14451	7/8- 9UNC - L	9P	STD	OH3	115	45	63	17		115	55	–	17		–	△	174
14452		5P													–	△	189
14453		1.5P													–	△	185
14471	7/8- 14UNF - L	9P	STD	OH2	105	37	47	17		95	45	–	17		–	△	179
14472		5P													–	△	178
14473		1.5P													–	△	177

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尺寸 Size 1 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

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FROM 尺寸 Size 1/4 ~ 7/8

单位:mm Unit:mm

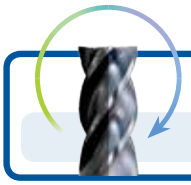
商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14501	1 - 8UNC - L	9P	STD	OH3	125	45	68	20	JIS2	125	60	—	20	4	—	△	271
14502		5P													—	△	280
14503		1.5P													—	△	276
14521	1 - 12UNF - L	9P	STD	OH2	105	37	47	20		95	45	—	20		—	△	233
14522		5P													—	△	234
14523		1.5P													—	△	205

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.



再研磨 · 再涂层

可一次性接受。实现和新品一样的性能。

※详情请参照▶P.9
See p.9 for details

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

△=停产产品(请确认库存。) Discontinued item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

G-LIST No. | TH1062

一般用(左螺纹)

GENERAL APPLICATION (LH THREAD)

HT

HSS

螺纹种类：W(L)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
7741	W 1/8 - 40 - L	JIS2	9P	46	18	—	4	3	Yes	△	4
7742			5P						Yes	△	4
7743			1.5P						Yes	△	4
7761	W 3/16 - 24 - L		9P	60	22	—	5.5		Yes	△	10
7762			5P						Yes	△	10
7763			1.5P						Yes	△	10
7771	W 1/4 - 20 - L		9P	62	24	—	6		Yes	△	12
7772			5P						Yes	△	12
7773			1.5P						Yes	△	12
7781	W 5/16 - 18 - L		9P	70	30	—	6.1		—	△	16
7782			5P						—	△	16
7783			1.5P						—	△	17
7791	W 3/8 - 16 - L		9P	75	35	—	7		—	△	24
7792			5P						—	△	24
7793			1.5P						—	△	25
7801	W 7/16 - 14 - L		9P	80	38	—	8	4	—	△	34
7802			5P						—	△	34
7803			1.5P						—	△	36
7811	W 1/2 - 12 - L		9P	85	42	—	9		—	△	48
7812			5P						—	△	48
7813			1.5P						—	△	48
7821	W 9/16 - 12 - L		9P	90	42	—	10.5		—	△	65
7822			5P						—	△	66
7823			1.5P						—	△	63

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
7831	W 5/8 - 11 - L	JIS2	9P	95	45	—	12	4	—	△	85
7832			5P						—	△	86
7833			1.5P						—	△	85
7841	W 3/4 - 10 - L		9P	105	50	—	14		—	△	120
7842			5P						—	△	122
7843			1.5P						—	△	121
7851	W 7/8 - 9 - L		9P	115	55	—	17		—	△	179
7852			5P						—	△	188
7853			1.5P						—	△	173
7861	W1 - 8 - L		9P	125	60	—	20		—	△	276
7862			5P						—	△	279
7863			1.5P						—	△	279
7871	W1 1/8 - 7 - L		9P	135	65	—	22		—	△	367
7872			5P						—	△	372
7873			1.5P						—	△	364
7881	W1 1/4 - 7 - L		9P	145	70	—	24		—	△	456
7882			5P						—	△	487
7883			1.5P						—	△	480
7891	W1 3/8 - 6 - L		9P	155	75	—	26		—	△	565
7892			5P						—	△	575
7893			1.5P						—	△	587
7901	W1 1/2 - 6 - L		9P	160	78	—	30		—	△	734
7902			5P						—	△	796
7903			1.5P						—	△	796

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT		○											○		○	○	○	○	○	○	○				

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

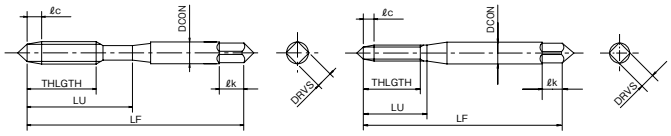
■记号说明请参考 P1页。 See p.1 for explanation of icons.

一般用4槽

GENERAL APPLICATION (4 FLUTES)

HT-4F

HSS



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	在库 Stock	重量 (g)
22711	M 4 × 0.7	5P	STD	OH2	52	13	21	5	JIS2	52	20	22	5	4	Yes	▲	8
22712		1.5P													Yes	▲	7
22717	M 5 × 0.8	5P			60	16	24	5.5		60	22	27	5.5		Yes	▲	10
22718		1.5P													Yes	▲	10
22721	M 6 × 1	5P			62	19	29	6		62	24	24	6		Yes	▲	12
22722		1.5P													Yes	▲	12

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由HT(P.701)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT(p.701).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HT-4F															○	○	○								

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

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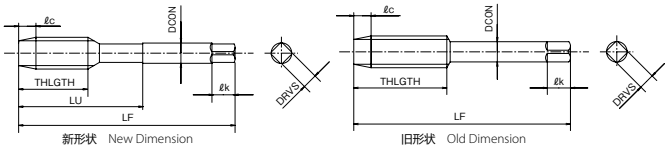
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1009

一般用3槽

GENERAL APPLICATION (3 FLUTES)

HT-3F



HSS

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22727	M 8 × 1.25	5P	STD	OH2	70	22	6.2	JIS2	70	30	6.2	3	—	▲	18
22728		1.5P											—	▲	18
22733	M 10 × 1.5	5P			75	24	7		75	32	7		—	▲	27
22734		1.5P											—	▲	27
22737	M 10 × 1.25	5P			75	24	7		75	32	7		—	▲	27
22738		1.5P											—	▲	27
22743	M 12 × 1.75	5P			82	29	8.5		82	38	8.5		—	▲	41
22744		1.5P											—	▲	40
22749	M 12 × 1.5	5P			82	29	8.5		82	38	8.5		—	▲	41
22750		1.5P											—	▲	41
22753	M 12 × 1.25	5P			82	29	8.5		80	38	8.5		—	▲	41
22754		1.5P											—	▲	34

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少,逐渐由新形状来替代。
2. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由 HT(P.701) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT(p.701).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
HT-3F													○					○	○	○	○					○

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

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Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | **TH1005**

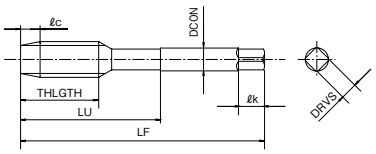
中径加大用

OVERSIZED

EX-OST

该直槽丝锥的中径加大，易于加工容易缩小的加工材料，以及能够加工JIS2级内螺纹并能使工具保持长寿命。

This oversize hand tap can cut JIS grade 2 threads and maintain a long tool life.



HSSE

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9150	M 3 ×0.5	STD+2	OH3	5P	46	11	19	4	3	Yes	●	4
9151		STD+2		1.5P						Yes	●	4
9153		STD+3	OH4	5P						Yes	●	4
9154		STD+3		1.5P						Yes	●	4
9170	M 4 ×0.7	STD+1	OH3	5P	52	13	21	5		Yes	●	7
9171		STD+1		1.5P						Yes	●	7
9173		STD+2	OH4	5P						Yes	●	8
9174		STD+2		1.5P						Yes	●	8
9190	M 5 ×0.8	STD+1	OH3	5P	60	16	24	5.5		Yes	●	10
9191		STD+1		1.5P						Yes	●	10
9193		STD+2	OH4	5P						Yes	●	10
9194		STD+2		1.5P						Yes	●	11
9200	M 6 ×1	STD+1	OH3	5P	62	19	29	6		Yes	●	12
9201		STD+1		1.5P						Yes	●	12
9203		STD+2	OH4	5P						Yes	●	12
9204		STD+2		1.5P						Yes	●	12
9210	M 8 ×1.25	STD+1	OH3	5P	70	22	37	6.2	4	—	●	17
9211		STD+1		1.5P						—	●	17
9213		STD+2	OH4	5P						—	●	18
9214		STD+2		1.5P						—	●	18
9220	M 8 ×1	STD+1	OH3	5P	70	22	37	6.2		—	●	17
9221		STD+1		1.5P						—	●	18
9433	M10×1.5	STD+2	OH4	5P	75	24	41	7		—	●	25
9434		STD+2		1.5P						—	●	25
9436		STD+3	OH5	5P						—	●	25
9437		STD+3		1.5P						—	●	25
9443	M10×1.25	STD+2	OH4	5P	75	24	41	7		—	●	25
9444		STD+2		1.5P						—	●	25
9446		STD+3	OH5	5P						—	●	25
9447		STD+3		1.5P						—	●	25
9450	M10×1	STD+1	OH3	5P	75	24	41	7		—	●	26
9451		STD+1		1.5P						—	●	26
9463	M12×1.75	STD+2	OH4	5P	82	29	48	8.5		—	●	40
9464		STD+2		1.5P						—	●	40
9466		STD+3	OH5	5P						—	●	40
9467		STD+3		1.5P						—	●	40
9473	M12×1.5	STD+2	OH4	5P	82	29	48	8.5		—	●	40
9474		STD+2		1.5P						—	●	40
9476		STD+3	OH5	5P						—	●	40

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9477	M12×1.5	STD+3	OH5	1.5P	82	29	48	8.5	4	—	●	40
9483	M12×1.25	STD+2	OH4	5P	82	29	48	8.5		—	●	40
9484		STD+2		1.5P						—	●	40
9486		STD+3	OH5	5P						—	●	40
9487		STD+3		1.5P						—	●	40
9490	M12×1	STD+1	OH3	5P	82	29	48	8.5		—	●	40
9491		STD+1		1.5P						—	●	41
9503	M14×2	STD+2	OH4	5P	88	30	48	10.5		—	●	64
9504		STD+2		1.5P						—	●	65
9506		STD+3	OH5	5P						—	●	65
9507		STD+3		1.5P						—	●	65
9513	M14×1.5	STD+2	OH4	5P	88	30	48	10.5		—	●	64
9514		STD+2		1.5P						—	●	65
9516		STD+3	OH5	5P						—	●	65
9517		STD+3		1.5P						—	●	66
9543	M16×2	STD+2	OH4	5P	95	32	52	12.5		—	●	91
9544		STD+2		1.5P						—	●	92
9546		STD+3	OH5	5P						—	●	92
9547		STD+3		1.5P						—	●	92
9553	M16×1.5	STD+2	OH4	5P	95	32	52	12.5	4	—	●	91
9554		STD+2		1.5P						—	●	89
9556		STD+3	OH5	5P						—	●	91
9557		STD+3		1.5P						—	●	89
9583	M18×2.5	STD+1	OH4	5P	100	37	55	14		—	△	110
9584		STD+1		1.5P						—	△	109
9586		STD+2	OH5	5P						—	△	112
9587		STD+2		1.5P						—	△	111
9603	M18×1.5	STD+2	OH4	5P	100	37	55	14		—	△	111
9604		STD+2		1.5P						—	△	111
9606		STD+3	OH5	5P						—	△	111
9607		STD+3		1.5P						—	△	110
9623	M20×2.5	STD+1	OH4	5P	105	37	58	15		—	△	136
9624		STD+1		1.5P						—	△	135
9636		STD+2	OH5	5P						—	△	136
9637		STD+2		1.5P						—	△	137
9653	M20×1.5	STD+1	OH4	5P	105	37	58	15		—	△	138
9654		STD+1		1.5P						—	△	138
9656		STD+2	OH5	5P						—	△	141
9657		STD+2		1.5P						—	△	140

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-OST		○		○						○	○		○		◎	◎	◎	○	○	◎	◎			○	

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

○ = 准标准库存品(请确认库存。)
Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。)
Discontinued item

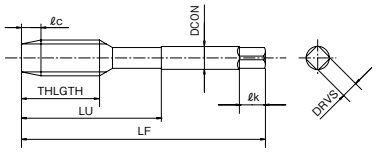
■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1042

一般用长柄型

LONG SHANK・GENERAL APPLICATION

EX-LT



HSSE

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	刃部长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
15040	M2 ×0.4	STD	OH1	5P	80	12	—	3	3	Yes	●	6
15041				1.5P						Yes	●	6
15042				5P	100					Yes	●	8
15043				1.5P						Yes	●	4
15048	M2.3 ×0.4			5P	80	13	—	3		Yes	●	6
15049				1.5P						Yes	●	6
15050				5P	100					Yes	●	8
15051				1.5P						Yes	●	7
15056	M2.5 ×0.45			5P	80	14	—	3		Yes	●	8
15057				1.5P						Yes	●	6
15058				5P	100					Yes	●	8
15059				1.5P						Yes	●	8
15064	M2.6 ×0.45			5P	80	14	—	3		Yes	●	6
15065				1.5P						Yes	●	6
15066				5P	100					Yes	●	8
15067				1.5P						Yes	●	8
11010	M3 ×0.5			5P	100	11	19	4		Yes	●	11
11011				1.5P						Yes	●	11
11012				5P	120					Yes	●	12
11013				1.5P						Yes	●	12
11014				5P	150					Yes	●	15
11015				1.5P						Yes	●	12
11021	M4 ×0.7			5P	100	13	21	5		Yes	●	16
11022				1.5P						Yes	●	16
11023				5P	120					Yes	●	18
11024				1.5P						Yes	●	18
11025				5P	150					Yes	●	23
11026				1.5P						Yes	●	23
11034	M5 ×0.8			5P	100	16	24	5.5		Yes	●	18
11035				1.5P						Yes	●	19
11036				5P	120					Yes	●	22
11037				1.5P						Yes	●	22
11038				5P	150					Yes	●	28
11039				1.5P						Yes	●	28
11046	M6 ×1		OH2	5P	100	19	29	6		Yes	●	23
11047				1.5P						Yes	●	23
11048				5P	120					Yes	●	26
11049				1.5P						Yes	●	27
11050				5P	150					Yes	●	33
11051				1.5P						Yes	●	33
11052				5P	200					Yes	●	44
11053				1.5P						Yes	●	46
11056				5P	300					Yes	●	69
11057				1.5P						Yes	●	69
11054	M6 ×0.75			5P	100	19	29	6		Yes	●	23
11055				1.5P						Yes	●	23
11058	M8 ×1.25			5P	100	22	37	6.2	4	—	●	26
11059				1.5P						—	●	26
11060				5P	120					—	●	30
11061				1.5P						—	●	31
11062				5P	150					—	●	38
11063				1.5P						—	●	38
11320				5P	200					—	●	50
11321				1.5P						—	●	50
11324				5P	300					—	●	76
11325				1.5P						—	●	77
11064	M8 ×1			5P	100	22	37	6.2		—	●	26
11065				1.5P						—	●	26

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	刃部长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11066	M8 ×1	STD	OH2	5P	120	22	37	6.2	4	—	●	31
11067				1.5P						—	●	31
11068				5P	150					—	●	38
11069				1.5P						—	●	37
11328	M8 ×0.75			5P	100	22	37	6.2		—	●	26
11329				1.5P						—	●	26
11070	M10 ×1.5			5P	100	24	41	7		—	●	34
11071				1.5P						—	●	33
11072				5P	120					—	●	41
11073				1.5P						—	●	41
11074				5P	150					—	●	49
11075				1.5P						—	●	50
11076				5P	200					—	●	64
11077				1.5P						—	●	65
11080				5P	300					—	●	98
11081				1.5P						—	●	98
11082	M10 ×1.25			5P	100	24	41	7		—	●	34
11083				1.5P						—	●	35
11084				5P	120					—	●	41
11085				1.5P						—	●	42
11086				5P	150					—	●	50
11087				1.5P						—	●	50
11088	M10 ×1			5P	100	24	41	7		—	●	34
11089				1.5P						—	●	34
11090				5P	120					—	●	41
11091				1.5P						—	●	41
11092				5P	150					—	●	50
11093				1.5P						—	●	49
11094	M12 ×1.75			5P	100	29	48	8.5		—	●	49
11095				1.5P						—	●	50
11096				5P	120					—	●	55
11097				1.5P						—	●	56
11098				5P	150					—	●	70
11099				1.5P						—	●	70
11100				5P	200					—	●	93
11101				1.5P						—	●	93
11104				5P	300					—	●	143
11105				1.5P						—	●	142
11106	M12 ×1.5			5P	100	29	48	8.5		—	●	49
11107				1.5P						—	●	50
11108				5P	120					—	●	54
11109				1.5P						—	●	56
11110				5P	150					—	●	70
11111				1.5P						—	●	71
11118	M12 ×1.25			5P	100	29	48	8.5		—	●	50
11119				1.5P						—	●	51
11120				5P	120					—	●	57
11121				1.5P						—	●	56
11122				5P	150					—	●	71
11123				1.5P						—	●	71
11124	M12 ×1			5P	100	29	48	8.5		—	●	49
11125				1.5P						—	●	51
11126				5P	120					—	●	55
11127				1.5P						—	●	55
11128				5P	150					—	●	72
11129				1.5P						—	●	73
11130	M14 ×2			5P	100	30	48	10.5		—	●	72
11131				1.5P						—	●	73

下一页
尺寸 Size M14～M30 NEXT

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45%~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-LT		○		○							○		○		○	○	○	○	○	○	○				

上一页 FROM 尺寸 Size M2 ~ M14

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11132	M14 ×2	STD	OH2	5P	120	30	48	10.5	4	—	●	75
11133				1.5P						—	●	79
11134				5P	150					—	●	101
11135				1.5P						—	●	102
11136				5P	200					—	●	137
11137				1.5P						—	●	136
11142	M14 ×1.5			5P	100					—	●	73
11143				1.5P						—	●	73
11144				5P	120					—	●	79
11145				1.5P						—	●	79
11146				5P	150					—	●	102
11147				1.5P						—	●	101
11152	M14 ×1			5P	150	30	48	10.5		—	●	102
11153				1.5P						—	●	103
11154	M16 ×2			5P	120	32	52	12.5		—	●	105
11155				1.5P						—	●	106
11156				5P	150					—	●	139
11157				1.5P						—	●	140
11158				5P	200					—	●	188
11159				1.5P						—	●	187
11160				5P	250					—	●	245
11161				1.5P						—	●	242
11166	M16 ×1.5			5P	120	32	52	12.5		—	●	107
11167				1.5P						—	●	106
11168				5P	150					—	●	138
11169				1.5P						—	●	139
11170				5P	200					—	●	187
11171				1.5P						—	●	188
11164	M16 ×1			5P	150	32	52	12.5		—	●	140
11165				1.5P						—	●	141
11178	M18 ×2.5	STD	OH3	5P	150	37	55	14		—	●	174
11179				1.5P						—	●	172
11180				5P	200					—	●	236
11181				1.5P						—	●	233
11182				5P	250					—	●	300
11183				1.5P						—	●	301
11184	M18 ×2			5P	150	37	55	14		—	●	175
11185				1.5P						—	●	172
11186	M18 ×1.5	STD	OH2	5P	150	37	55	14		—	●	173
11187				1.5P						—	●	173
11188				5P	200					—	●	235
11189				1.5P						—	●	237

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11194	M20 ×2.5	STD	OH3	5P	150	37	58	15	4	—	●	197
11195				1.5P						—	●	198
11196				5P	200					—	●	268
11197				1.5P						—	●	270
11198				5P	250					—	●	349
11199				1.5P						—	●	347
11200	M20 ×2			5P	150	37	58	15		—	●	203
11201				1.5P						—	●	203
11202	M20 ×1.5			5P	150	37	58	15		—	●	204
11203				1.5P						—	●	204
11204				5P	200					—	●	274
11205				1.5P						—	●	272
11210	M22 ×2.5			5P	150	38	63	17		—	●	247
11211				1.5P						—	●	247
11212				5P	200					—	●	337
11213				1.5P						—	●	334
11218	M22 ×1.5			5P	150	38	63	17		—	●	250
11219				1.5P						—	●	252
11220				5P	200					—	●	344
11221				1.5P						—	●	341
11226	M24 ×3			5P	150	45	66	19		—	●	307
11227				1.5P						—	●	307
11228				5P	200					—	●	421
11229				1.5P						—	●	422
11230				5P	250					—	●	541
11231				1.5P						—	●	543
11232	M24 ×2			5P	150	45	66	19		—	●	314
11233				1.5P						—	●	312
11234	M24 ×1.5			5P	150	45	66	19		—	●	312
11235				1.5P						—	●	313
11236				5P	200					—	●	433
11237				1.5P						—	●	414
11246	M27 ×3			5P	250	45	71	20		—	●	620
11247				1.5P						—	●	617
11250	M27 ×2			5P	250	45	71	20		—	●	621
11251				1.5P						—	●	623
11254	M27 ×1.5			5P	250	45	71	20		—	●	624
11255				1.5P						—	●	623
11257	M30 ×3.5			5P	250	48	74	23		—	●	785
11258				1.5P						—	●	789
11259				5P	300					—	●	954
11260				1.5P						—	●	953

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

下一页 尺寸 Size M30 ~ M48 NEXT

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

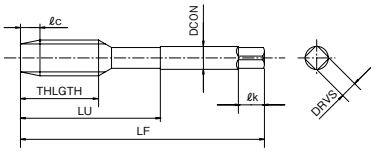
△=停产产品(请确认库存。) Discontinued item

G-LIST No. | TH1042

一般用长柄型

LONG SHANK · GENERAL APPLICATION

EX-LT



HSSE

上一页
FROM 尺寸 Size M14 ~ M30

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11261	M30 ×2	STD	OH3	5P	250	48	74	23	4	—	●	795
11262				1.5P						—	●	793
11265	M30 ×1.5			5P	250	48	74	23		—	●	798
11266				1.5P						—	●	798
11267	M33 ×3.5			5P	300	51	77	25		—	●	1,149
11268				1.5P						—	●	1,140

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11275	M36 ×4	STD	OH3	5P	300	57	82	28	4	—	●	1,401
11276				1.5P						—	●	1,401
11283	M42 ×4.5			5P	300	60	93	32		—	●	1,805
11284				1.5P						—	●	1,817
11299	M48 ×5			5P	300	67	98	38		—	●	2,460
11300				1.5P						—	●	2,500

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11951	1/4 - 20UNC	STD	OH2	5P	150	19	29	6	3	Yes	●	33
11952				1.5P						Yes	●	33
11953	1/4 - 28UNF			5P	150	19	29	6		Yes	●	33
11954				1.5P						Yes	●	33
11955	5/16 - 18UNC			5P	150	22	37	6.1	4	—	●	37
11956				1.5P						—	●	37
11957	5/16 - 24UNF			5P	150	22	37	6.1		—	●	37
11958				1.5P						—	●	37
11959	3/8 - 16UNC			5P	150	24	41	7		—	●	49
11960				1.5P						—	●	49
11961	3/8 - 24UNF			5P	150	24	41	7		—	●	49
11962				1.5P						—	●	49
11963	1/2 - 13UNC			5P	150	29	48	9		—	●	78
11964				1.5P						—	●	79
11965	1/2 - 20UNF			5P	150	29	48	9		—	●	81
11966				1.5P						—	●	80

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11967	5/8 - 11UNC	STD	OH3	5P	150	32	52	12	4	—	●	130
11968				1.5P						—	●	132
11969	5/8 - 18UNF	STD	OH2	5P	150	32	52	12		—	●	132
11970				1.5P						—	●	133
11971	3/4 - 10UNC	STD	OH3	5P	150	37	58	14		—	●	180
11972				1.5P						—	●	180
11973	3/4 - 16UNF	STD	OH2	5P	150	37	58	14		—	●	180
11974				1.5P						—	●	180
11975	7/8 - 9UNC	STD	OH3	5P	150	38	63	17		—	●	247
11976				1.5P						—	●	247
11977	7/8 - 14UNF	STD	OH2	5P	150	38	63	17		—	●	251
11978				1.5P						—	●	255
11979	1 - 8UNC	STD	OH3	5P	150	45	68	20		—	●	331
11980				1.5P						—	●	334
11981	1 - 12UNF			5P	150	45	68	20		—	●	335
11982				1.5P						—	●	336

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS 2B internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-LT		○		○							○		○		○	○	○	○	○	○	○				

HSSE

螺纹种类：W

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胜长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11901	W 1/4 - 20	STD	OH2	5P	150	19	29	6	3	Yes	●	33
11902				1.5P						Yes	●	33
11903	W 5/16 - 18			5P	150	22	37	6.1	4	—	●	37
11904				1.5P						—	●	37
11905	W 3/8 - 16			5P	150	24	41	7		—	●	49
11906				1.5P						—	●	49
11907	W 1/2 - 12			5P	150	29	48	9		—	●	78
11908				1.5P						—	●	79

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削胜长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11909	W 5/8 - 11	STD	OH2	5P	150	32	52	12	4	—	●	131
11910				1.5P						—	●	131
11911	W 3/4 - 10			5P	150	37	58	14		—	●	179
11912				1.5P						—	●	179
11913	W 1 - 8		OH3	5P	150	45	68	20		—	●	333
11914				1.5P						—	●	333

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1042

一般用长柄型（左螺旋）

LONG SHANK・GENERAL APPLICATION (LH THREAD)

EX-LT

HSSE

螺纹种类 :M(L)

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21010	M 3×0.5 -L	STD	OH1	5P	100	11	19	4	3	Yes	●	11
21011				1.5P						Yes	●	11
21021	M 4×0.7 -L		OH2	5P	100	13	21	5		Yes	●	16
21022				1.5P						Yes	●	16
21034	M 5×0.8 -L			5P	100	16	24	5.5		Yes	●	18
21035				1.5P						Yes	●	18
21046	M 6×1 -L			5P	100	19	29	6		Yes	●	13
21047				1.5P						Yes	●	20
21050				5P	150					Yes	●	33
21051				1.5P						Yes	●	32

■突顶尖长・柄部四方部尺寸ℓk，DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
21058	M 8×1.25 - L	STD	OH2	5P	100	22	37	6.2	4	—	●	26
21059				1.5P							●	25
21062				5P	150						●	37
21063				1.5P							●	37
21074	M10×1.5 -L			5P	150	24	41	7		—	●	49
21075				1.5P							●	49
21198	M12×1.75 - L			5P	150	29	48	8.5		—	●	71
21199				1.5P							●	70

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-LT		○		○							○		○		○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

中径加大用 长柄型

LONG SHANK · OVERSIZE

EX-LT-OST

HSSE

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14610	M 3 × 0.5	STD+2	OH3	5P	100	11	19	4	3	Yes	●	11
14611				1.5P						Yes	●	11
14614				5P	150					Yes	●	16
14615				1.5P						Yes	●	15
14618	M 4 × 0.7	STD+1		5P	100	13	21	5		Yes	●	16
14619				1.5P						Yes	●	16
14622				5P	150					Yes	●	23
14623				1.5P						Yes	●	23
14626	M 5 × 0.8			5P	100	16	24	5.5		Yes	●	19
14627				1.5P						Yes	●	19
14630				5P	150					Yes	●	28
14631				1.5P						Yes	●	28
14634	M 6 × 1			5P	100	19	29	6		Yes	●	23
14635				1.5P						Yes	●	23
14638				5P	150					Yes	●	32
14639				1.5P						Yes	●	32
14642	M 8 × 1.25			5P	100	22	37	6.2	4	—	●	26
14643				1.5P						—	●	25
14646				5P	150					—	●	38
14647				1.5P						—	●	38

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14658	M 10 × 1.5	STD+2	OH4	5P	100	24	41	7	4	—	●	34
14659				1.5P						—	●	33
14662				5P	150					—	●	50
14663				1.5P						—	●	50
14666	M 10 × 1.25			5P	100	24	41	7		—	●	34
14667				1.5P						—	●	34
14670				5P	150					—	●	50
14671				1.5P						—	●	50
14678	M 12 × 1.75			5P	150	29	48	8.5		—	●	72
14679				1.5P						—	●	70
14680				5P	200					—	●	92
14681				1.5P						—	●	94
14686	M 12 × 1.5			5P	150	29	48	8.5		—	●	70
14687				1.5P						—	●	71
14688				5P	200					—	●	93
14689				1.5P						—	●	93
14694	M 12 × 1.25			5P	150	29	48	8.5		—	●	71
14695				1.5P						—	●	71
14696				5P	200					—	●	94
14697				1.5P						—	●	94

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-LT-OST		○		○						○	○		○		◎	◎	◎	○	○	◎	◎			○	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

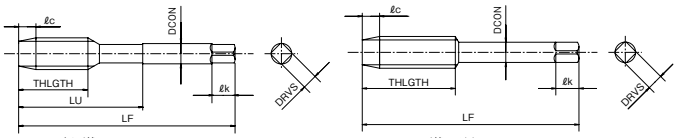
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1123

一般用氧化处理

GENERAL APPLICATION (WITH OX)

H-HT



HSS | H

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	精度标记 Grade	新形状 New Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	旧形状 Old Dimension 精度 TAP Limit	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22605	M 3 × 0.5	5P	STD	OH1	46	11	19	4	JIS2	46	18	20	4	3	Yes	●	5
22606		1.5P													Yes	●	5
22611	M 4 × 0.7	5P	STD	OH1	52	13	21	5		52	20	22	5		Yes	●	7
22612		1.5P													Yes	●	8
22617	M 5 × 0.8	5P	STD	OH1	60	16	24	5.5		60	22	27	5.5		Yes	●	10
22618		1.5P													Yes	●	10
22621	M 6 × 1	5P	STD	OH1	62	19	29	6		62	24	24	6		Yes	●	12
22622		1.5P													Yes	●	12
22627	M 8 × 1.25	5P	STD	OH1	70	22	37	6.2		70	30	–	6.2		–	●	17
22628		1.5P													–	●	17
22633	M 10 × 1.5	5P	STD	OH1	75	24	41	7		75	32	–	7		–	●	25
22634		1.5P													–	●	25
22637	M 10 × 1.25	5P	STD	OH1	75	24	41	7		75	32	–	7		–	●	25
22638		1.5P													–	●	27
22643	M 12 × 1.75	5P	STD	OH2	82	29	48	8.5		82	38	–	8.5		–	●	40
22644		1.5P													–	●	40
22649	M 12 × 1.5	5P	STD	OH2	82	29	48	8.5		82	38	–	8.5		–	●	40
22650		1.5P													–	●	40
22653	M 12 × 1.25	5P	STD	OH2	82	29	48	8.5		80	38	–	8.5		–	●	40
22654		1.5P													–	●	41
79201	M 14 × 2	5P	STD	OH2	88	30	48	10.5		88	42	–	10.5		–	●	65
79202		1.5P													–	●	66
79205	M 14 × 1.5	5P	STD	OH2	88	30	48	10.5		88	42	–	10.5		–	●	65
79206		1.5P													–	●	67
79209	M 16 × 2	5P	STD	OH2	95	32	52	12.5		95	45	–	12.5		–	●	92
79210		1.5P													–	●	92
79213	M 16 × 1.5	5P	STD	OH2	95	32	52	12.5		95	45	–	12.5		–	▲	92
79214		1.5P													–	▲	93
79217	M 18 × 2.5	5P	STD	OH3	100	37	55	14		100	48	–	14	4	–	●	108
79218		1.5P													–	●	108
79221	M 18 × 1.5	5P	STD	OH2	100	37	55	14		95	45	–	14		–	▲	114
79222		1.5P													–	▲	106
79225	M 20 × 2.5	5P	STD	OH3	105	37	58	15		105	50	–	15		–	●	137
79226		1.5P													–	●	138
79229	M 20 × 1.5	5P	STD	OH3	105	37	58	15		95	45	–	15		–	▲	141
79230		1.5P													–	▲	142
79233	M 22 × 2.5	5P	STD	OH3	115	38	63	17		115	55	–	17		–	●	187
79234		1.5P													–	●	183
79237	M 22 × 1.5	5P	STD	OH3	115	38	63	17		95	45	–	17		–	▲	189
79238		1.5P													–	▲	189
79241	M 24 × 3	5P	STD	OH3	120	45	66	19		120	58	–	19		–	●	238
79242		1.5P													–	●	239
79245	M 24 × 1.5	5P	STD	OH3	120	45	66	19		95	45	–	19		–	▲	246
79246		1.5P													–	▲	248
79249	M 27 × 3	5P	STD	OH3	130	45	71	20		130	62	–	20		–	●	310
79250		1.5P													–	●	310
79253	M 27 × 1.5	5P	STD	OH3	130	45	71	20		95	45	–	20		–	▲	317
79254		1.5P													–	▲	235
79257	M 30 × 3.5	5P	STD	OH3	135	51	74	23		135	65	–	23		–	●	400
79258		1.5P													–	●	403
79261	M 30 × 1.5	5P	STD	OH3	130	45	60	23		105	45	–	23		–	▲	405
79262		1.5P													–	▲	406

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 旧形状随库存减少，逐渐由新形状来替代。
2. 精度栏 [ ] 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产，由 TIN-HT(P.747)，HT(P.701) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Conventional dimension is replaced with new one accordingly.
2. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲ = The products have been stopped producing and replaced by TIN-HT (p.747) and HT (p.701).

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

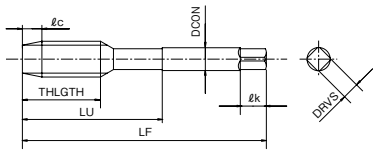
△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

一般用氧化处理 长柄型

LONG SHANK · GENERAL APPLICATION (WITH OX)

EX-H-LT



HSSE　H

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
79410	M 3 × 0.5	STD	OH1	5P	100	11	19	4	3	Yes	▲	11
79411				1.5P						Yes	▲	11
79416	M 4 × 0.7			5P	100	13	21	5		Yes	▲	16
79417				1.5P						Yes	▲	16
79422	M 5 × 0.8			5P	100	16	24	5.5		Yes	▲	19
79423				1.5P						Yes	▲	19
79428	M 6 × 1			5P	100	19	29	6		Yes	▲	20
79429				1.5P						Yes	▲	20
79432				5P	150					Yes	▲	33
79433				1.5P						Yes	▲	33
79436	M 8 × 1.25			5P	100	22	37	6.2	4	—	▲	26
79437				1.5P						—	▲	25
79440				5P	150					—	▲	39
79441				1.5P						—	▲	38
79452	M10 × 1.5			5P	150	24	41	7		—	▲	50
79453				1.5P						—	▲	50
79460	M10 × 1.25			5P	150	24	41	7		—	▲	49
79461				1.5P						—	▲	50
79474	M12 × 1.75			5P	150	29	48	8.5		—	▲	70
79475				1.5P						—	▲	71
79482	M12 × 1.5			5P	150	29	48	8.5		—	▲	71
79483				1.5P						—	▲	72
79490	M12 × 1.25			5P	150	29	48	8.5		—	▲	71
79491				1.5P						—	▲	71
79504	M14 × 2			5P	150	30	48	10.5		—	▲	102
79505				1.5P						—	▲	101
79512	M14 × 1.5			5P	150	30	48	10.5		—	▲	103
79513				1.5P						—	▲	102
79518	M16 × 2			5P	150	32	52	12.5		—	▲	138
79519				1.5P						—	▲	138
79522				5P	200					—	△	186
79523				1.5P						—	△	189
79526	M16 × 1.5			5P	150	32	52	12.5		—	▲	141

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏　　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲＝该产品已停止生产，由 TIN-LT(P.748)，EX-LT(P.737) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
79527	M16 × 1.5	STD	OH2	1.5P	150	32	52	12.5	4	—	▲	140
79530				5P	200					—	△	187
79531				1.5P						—	△	182
79534	M18 × 2.5	STD	OH3	5P	150	37	55	14		—	▲	172
79535				1.5P						—	▲	172
79538				5P	200					—	△	232
79539				1.5P						—	△	233
79544	M18 × 1.5	STD	OH2	5P	150	37	55	14		—	▲	174
79545				1.5P						—	▲	177
79550	M20 × 2.5	STD	OH3	5P	150	37	58	15		—	▲	202
79551				1.5P						—	▲	202
79554				5P	200					—	△	269
79555				1.5P						—	△	269
79560	M20 × 1.5			5P	150	37	58	15		—	▲	202
79561				1.5P						—	▲	200
79564				5P	200					—	△	263
79565				1.5P						—	△	265
79570	M22 × 2.5			5P	150	38	63	17		—	△	252
79571				1.5P						—	△	252
79574				5P	200					—	▲	336
79575				1.5P						—	▲	336
79580	M22 × 1.5			5P	150	38	63	17		—	△	244
79581				1.5P						—	△	248
79584				5P	200					—	▲	341
79585				1.5P						—	▲	341
79590	M24 × 3			5P	150	45	66	19		—	△	307
79591				1.5P						—	△	312
79594				5P	200					—	▲	426
79595				1.5P						—	▲	421
79600	M24 × 1.5			5P	150	45	66	19		—	△	309
79601				1.5P						—	△	317
79604				5P	200					—	▲	426
79605				1.5P						—	▲	422

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by TIN-LT (p.748) and EX-LT (p.737).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
H-HT	◎	○		○																					
EX-H-LT	◎	○		○							○														

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。　See p.1 for explanation of icons.

G-LIST No. | TH1034

深孔用(细柄型)

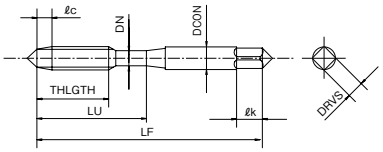
FOR DEEP HOLES (SLIM SHANK)

EX-SST

HSSE

可以在较深部位攻丝，此丝锥的颈部直径比螺纹小径还要小。

Because the neck diameter is narrower than the minor diameter, this tap can process an internal thread that is longer than the length of the tool's external thread.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	颈径 DN	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11852	M3 ×0.5	STD	OH1	5P	120	11	81	2.4	4	3	Yes	●	8
11853				1.5P							Yes	●	8
11860	M4 ×0.7	STD	OH2	5P	120	13	83	3.1	5		Yes	●	12
11861				1.5P							Yes	●	12
11868	M5 ×0.8			5P	120	16	86	4	5.5		Yes	●	17

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	颈径 DN	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
11869	M5 ×0.8	STD	OH2	1.5P	120	16	86	4	5.5	3	Yes	●	17
11876	M6 ×1			5P	120	19	89	4.7	6		Yes	●	21
11877				1.5P							Yes	●	21
11878				5P	150		109				Yes	●	26
11879				1.5P							Yes	●	26

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3 Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-SST		○		○							○		○		○	○	○	○	○		○					

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1145

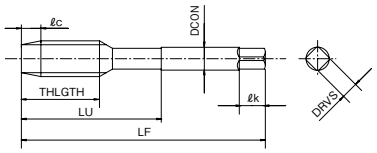
V涂层长柄型

V COATED・LONG SHANK

V-LT

刃尖强度优良，适合切屑为非连续状的高硬度材料。

Suitable for hardened material whose chips are not long, due to strong cutting edge.



HSSE　V

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8316030	M 3×0.5	STD	OH2	5P	100	11	19	4	3	Yes	▲	11
8316031				1.5P						Yes	▲	12
8316036	M 4×0.7			5P	100	13	21	5		Yes	▲	16
8316037				1.5P						Yes	▲	16
8316042	M 5×0.8			5P	100	16	24	5.5		Yes	▲	19
8316043				1.5P						Yes	▲	18
8316048	M 6×1			5P	100	19	29	6		Yes	▲	23
8316049				1.5P						Yes	▲	23
8316052				5P	150					Yes	▲	33
8316053				1.5P						Yes	▲	33
8316054	M 8×1.25			5P	100	22	37	6.2		—	▲	23
8316055				1.5P						—	▲	25
8316058				5P	150					—	▲	38
8316059				1.5P						—	▲	38
8316068	M 10×1.5	STD	OH3	5P	150	24	41	7	4	—	▲	49
8316069				1.5P						—	▲	50
8316074	M 10×1.25	STD	OH2	5P	150	24	41	7		—	▲	49
8316075				1.5P						—	▲	50
8316090	M 12×1.75	STD	OH3	5P	150	29	48	8.5		—	▲	71
8316091				1.5P						—	▲	72
8316096	M 12×1.5			5P	150	29	48	8.5		—	▲	76
8316097				1.5P						—	▲	76
8316102	M 12×1.25	STD	OH2	5P	150	29	48	8.5		—	▲	76
8316103				1.5P						—	▲	71

■突顶尖长・柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

▲＝该产品已停止生产，由TIN-LT(P.748)，EX-LT(P.737)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8316126	M 14×2	STD	OH3	5P	150	30	48	10.5	4	—	▲	104
8316127				1.5P						—	▲	104
8316134	M 14×1.5			5P	150	30	48	10.5		—	▲	105
8316135				1.5P						—	▲	102
8316140	M 16×2			5P	150	32	52	12.5		—	▲	141
8316141				1.5P						—	▲	141
8316148	M 16×1.5			5P	150	32	52	12.5		—	▲	136
8316149				1.5P						—	▲	141
8316154	M 18×2.5			5P	150	37	55	14		—	▲	172
8316155				1.5P						—	▲	173
8316160	M 18×1.5			5P	150	37	55	14		—	▲	171
8316161				1.5P						—	▲	175
8316166	M 20×2.5			5P	150	37	58	15		—	▲	202
8316167				1.5P						—	▲	194
8316172	M 20×1.5			5P	150	37	58	15		—	▲	196
8316173				1.5P						—	▲	202
8316180	M 22×2.5			5P	200	38	63	17		—	▲	337
8316181				1.5P						—	▲	338
8316186	M 22×1.5			5P	200	38	63	17		—	▲	353
8316187				1.5P						—	▲	342
8316192	M 24×3			5P	200	45	66	19		—	▲	411
8316193				1.5P						—	▲	416
8316198	M 24×1.5			5P	200	45	66	19		—	▲	417
8316199				1.5P						—	▲	419

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by TIN-LT (p.748) and EX-LT (p.737).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
V-LT	○	○	○	○	○					○	○				○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。　See p.1 for explanation of icons.

G-LIST No. | TH1060

TiN涂层

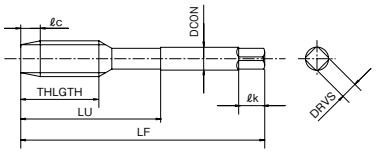
TiN COATED

TIN-HT

HSSE | TiN

刃尖强度优良，适合切屑为非连续状的高硬度材料。

Because of its superior cutting edges, this tap is suitable for tapping hardened materials that produce short and broken chips.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14700	M2 ×0.4	STD	OH1	5P	40	12	—	3	3	Yes	●	3
14701				1.5P						Yes	●	3
14702	M2.3×0.4			5P	42	13	—	3		Yes	●	4
14703				1.5P						Yes	●	4
14704	M2.5×0.45			5P	44	14	—	3		Yes	●	3
14705				1.5P						Yes	●	3
14706	M2.6×0.45			5P	44	14	—	3		Yes	●	4
14707				1.5P						Yes	●	3
14708	M3 ×0.5			5P	46	11	19	4		Yes	●	5
14709				1.5P						Yes	●	5
14774	M3.5×0.6			5P	48	13	20	4		Yes	●	5
14775				1.5P						Yes	●	5
14710	M4 ×0.7			5P	52	13	21	5		Yes	●	8
14711				1.5P						Yes	●	8
14712	M5 ×0.8			5P	60	16	24	5.5		Yes	●	11
14713				1.5P						Yes	●	11
14714	M6 ×1			5P	62	19	29	6		Yes	●	12
14715				1.5P						Yes	●	12
14718	M8 ×1.25			5P	70	22	37	6.2		—	●	17
14719				1.5P						—	●	18
14722	M10 ×1.5	STD	OH3	5P	75	24	41	7		—	●	25
14723				1.5P						—	●	25
14724	M10 ×1.25	STD	OH2	5P	75	24	41	7		—	●	25
14725				1.5P						—	●	25
14728	M12 ×1.75	STD	OH3	5P	82	29	48	8.5		—	●	40
14729				1.5P						—	●	40
14730	M12 ×1.5			5P	82	29	48	8.5		—	●	40
14731				1.5P						—	●	40
14732	M12 ×1.25	STD	OH2	5P	82	29	48	8.5	4	—	●	41
14733				1.5P						—	●	40
14736	M14 ×2	STD	OH3	5P	88	30	48	10.5		—	●	64
14737				1.5P						—	●	65
14738	M14 ×1.5			5P	88	30	48	10.5		—	●	66
14739				1.5P						—	●	65
14742	M16 ×2			5P	95	32	52	12.5		—	●	90
14743				1.5P						—	●	90
14744	M16 ×1.5			5P	95	32	52	12.5		—	●	90

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14745	M16 ×1.5	STD	OH3	1.5P	95	32	52	12.5	4	—	●	90
14748	M18 ×2.5			5P	100	37	55	14		—	●	110
14749				1.5P						—	●	110
14750	M18 ×1.5			5P	100	37	55	14		—	●	111
14751				1.5P						—	●	111
14754	M20 ×2.5			5P	105	37	58	15		—	●	134
14755				1.5P						—	●	135
14756	M20 ×1.5			5P	105	37	58	15		—	●	139
14757				1.5P						—	●	140
14760	M22 ×2.5			5P	115	38	63	17		—	●	181
14761				1.5P						—	●	182
14762	M22 ×1.5			5P	115	38	63	17		—	●	184
14763				1.5P						—	●	185
14766	M24 ×3			5P	120	45	66	19		—	●	235
14767				1.5P						—	●	236
14768	M24 ×1.5			5P	120	45	66	19		—	●	242
14769				1.5P						—	●	240
14780	M27 ×3			5P	130	45	71	20		—	▲	300
14781				1.5P						—	▲	300
14782	M27 ×1.5			5P	130	45	71	20		—	▲	311
14783				1.5P						—	▲	309
14784	M30 ×3.5			5P	135	48	74	23		—	▲	387
14785				1.5P						—	▲	397
14786	M30 ×1.5			5P	135	48	74	23		—	▲	398
14787				1.5P						—	▲	400
14788	M33 ×3.5			5P	145	51	77	25		—	▲	489
14789				1.5P						—	▲	506
14790	M33 ×1.5			5P	110	37	47	25		—	▲	383
14791				1.5P						—	▲	395
14792	M36 ×4	STD	OH4	5P	155	57	82	28		—	▲	673
14793				1.5P						—	▲	676
14794	M36 ×1.5	STD	OH3	5P	110	39	49	28		—	▲	470
14795				1.5P						—	▲	471
14796	M42 ×4.5	STD	OH4	5P	175	60	93	32		—	▲	985
14797				1.5P						—	▲	982
14798	M42 ×1.5	STD	OH3	5P	120	39	49	32		—	▲	704
14799				1.5P						—	▲	710

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产，由 HT(P.701)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT(p.701).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
TIN-HT	○	○	○	○	○					○	○				○	○	○	○	○	○	○					

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

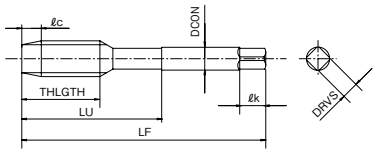
■记号说明请参考 P1页。 See p.1 for explanation of icons.

TiN涂层 长柄型

TiN COATED・LONG SHANK

TIN-LT

HSSE TiN



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14530	M 3×0.5	STD	OH2	5P	100	11	19	4	3	Yes	●	11
14531				1.5P						Yes	●	11
14536	M 4×0.7			5P	100	13	21	5		Yes	●	16
14537				1.5P						Yes	●	16
14542	M 5×0.8			5P	100	16	24	5.5		Yes	●	19
14543				1.5P						Yes	●	19
14548	M 6×1			5P	100	19	29	6		Yes	●	23
14549				1.5P						Yes	●	23
14552				5P	150					Yes	●	33
14553				1.5P						Yes	●	33
14554	M 8×1.25			5P	100	22	37	6.2		—	●	25
14555				1.5P						—	●	26
14558				5P	150					—	●	38
14559				1.5P						—	●	38
14568	M10×1.5	STD	OH3	5P	150	24	41	7		—	●	49
14569				1.5P						—	●	50
14574	M10×1.25	STD	OH2	5P	150	24	41	7	4	—	●	49
14575				1.5P						—	●	49
14590	M12×1.75	STD	OH3	5P	150	29	48	8.5		—	●	70
14591				1.5P						—	●	71
14596	M12×1.5			5P	150	29	48	8.5		—	●	71
14597				1.5P						—	●	72
14602	M12×1.25	STD	OH2	5P	150	29	48	8.5		—	●	71
14603				1.5P						—	●	72

■突顶尖长・柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

▲=该产品已停止生产，由EX-LT(P.737)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
17226	M14×2	STD	OH3	5P	150	30	48	10.5	4	—	▲	101
17227				1.5P						—	▲	101
17234	M14×1.5			5P	150	30	48	10.5		—	▲	102
17235				1.5P						—	▲	102
17240	M16×2			5P	150	32	52	12.5		—	▲	138
17241				1.5P						—	▲	137
17248	M16×1.5			5P	150	32	52	12.5		—	▲	140
17249				1.5P						—	▲	140
17254	M18×2.5			5P	150	37	55	14		—	▲	170
17255				1.5P						—	▲	174
17260	M18×1.5			5P	150	37	55	14		—	▲	173
17261				1.5P						—	▲	176
17266	M20×2.5			5P	150	37	58	15		—	▲	198
17267				1.5P						—	▲	198
17272	M20×1.5			5P	150	37	58	15		—	▲	202
17273				1.5P						—	▲	203
17280	M22×2.5			5P	200	38	63	17		—	▲	342
17281				1.5P						—	▲	337
17286	M22×1.5			5P	200	38	63	17		—	▲	341
17287				1.5P						—	▲	339
17292	M24×3			5P	200	45	66	19		—	▲	419
17293				1.5P						—	▲	409
17298	M24×1.5			5P	200	45	66	19		—	▲	414
17299				1.5P						—	▲	427

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by EX-LT(p.737).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
TIN-LT	○	○	○	○	○					○	○				○	○	○	○	○	○	○					

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

△=停产产品(请确认库存。)
Discontinued item

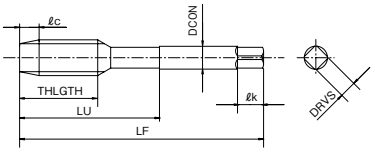
▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1058

难加工材料
FOR DIFFICULT TO MACHINE MATERIALS

CPM-HT



CPM

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22408	M 3 ×0.5	STD	OH2	5P	46	11	19	4	3	Yes	●	4
22409				2P						Yes	●	5
22410	M 4 ×0.7			5P	52	13	21	5		Yes	●	7
22411				2P						Yes	●	10
22412	M 5 ×0.8			5P	60	16	24	5.5		Yes	●	10
22413				2P						Yes	●	10
22414	M 6 ×1			5P	62	19	29	6		Yes	●	12
22415				2P						Yes	●	12
22418	M 8 ×1.25			5P	70	22	37	6.2	4	—	●	17
22419				2P						—	●	17
22422	M10 ×1.5	STD	OH3	5P	75	24	41	7		—	●	25
22423				2P						—	●	26
22424	M10 ×1.25	STD	OH2	5P	75	24	41	7		—	●	25
22425				2P						—	●	26
22428	M12 ×1.75	STD	OH3	5P	82	29	48	8.5		—	●	40
22429				2P						—	●	40
22430	M12 ×1.5			5P	82	29	48	8.5		—	●	40
22431				2P						—	●	40
22432	M12 ×1.25	STD	OH2	5P	82	29	48	8.5		—	●	40
22433				2P						—	●	41
22436	M14 ×2	STD	OH3	5P	88	30	48	10.5		—	●	66
22437				2P						—	●	67
22438	M14 ×1.5			5P	88	30	48	10.5		—	●	67
22439				2P						—	●	67
22442	M16 ×2			5P	95	32	52	12.5		—	●	93
22443				2P						—	●	93
22444	M16 ×1.5			5P	95	32	52	12.5		—	●	95
22445				2P						—	●	96
22448	M18 ×2.5			5P	100	37	55	14		—	●	112
22449				2P						—	●	114

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22450	M18 ×1.5	STD	OH3	5P	100	37	55	14	4	—	●	115
22451				2P						—	●	116
22454	M20 ×2.5			5P	105	37	58	15		—	●	141
22455				2P						—	●	142
22456	M20 ×1.5			5P	105	37	58	15		—	●	144
22457				2P						—	●	144
22460	M22 ×2.5			5P	115	38	63	17		—	●	191
22461				2P						—	●	191
22462	M22 ×1.5			5P	115	38	63	17		—	●	191
22463				2P						—	●	193
22466	M24 ×3			5P	120	45	66	19		—	●	242
22467				2P						—	●	245
22468	M24 ×1.5			5P	120	45	66	19		—	●	250
22469				2P						—	●	250
22472	M27 ×3			5P	130	45	71	20		—	●	318
22473				2P						—	●	318
22474	M27 ×1.5			5P	130	45	71	20		—	●	325
22475				2P						—	●	323
22478	M30 ×3.5			5P	135	48	74	23		—	●	412
22479				2P						—	●	411
22480	M30 ×1.5			5P	135	48	74	23		—	●	414
22481				2P						—	●	417
22484	M33 ×3.5	STD	OH4	5P	145	51	77	25		—	●	516
22485				2P						—	●	533
22488	M36 ×4			5P	155	57	82	28		—	●	696
22489				2P						—	●	699
22492	M42 ×4.5			5P	175	60	93	32		—	●	1,033
22493				2P						—	●	1,033
22496	M48 ×5			5P	185	67	98	38		—	●	1,465
22497				2P						—	●	1,484

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
CPM-HT			◎			○				○		◎	○						○			○	○			

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

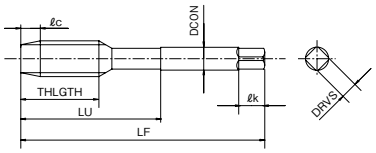
△=停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

难加工材料用 长柄型

LONG SHANK · FOR DIFFICULT TO MACHINE MATERIALS

CPM-LT



CPM

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78410	M 3×0.5	STD	OH3	5P	100	11	19	4	3	Yes	●	12
78411				2P						Yes	●	12
78416	M 4×0.7			5P	100	13	21	5		Yes	●	16
78417				2P						Yes	●	16
78422	M 5×0.8			5P	100	16	24	5.5		Yes	●	19
78423				2P						Yes	●	19
78428	M 6×1			5P	100	19	29	6		Yes	●	23
78429				2P						Yes	●	23
78432				5P	150					Yes	●	34
78433				2P						Yes	●	34
78436	M 8×1.25			5P	100	22	37	6.2		—	●	26
78437				2P						—	●	26
78440				5P	150					—	●	38
78441				2P						—	●	38
78452	M 10×1.5			5P	150	24	41	7		—	●	51
78453				2P						—	●	51
78460	M 10×1.25			5P	150	24	41	7	4	—	●	51
78461				2P						—	●	50
78474	M 12×1.75			5P	150	29	48	8.5		—	●	72
78475				2P						—	●	72
78482	M 12×1.5			5P	150	29	48	8.5		—	●	71
78483				2P						—	●	72
78490	M 12×1.25	STD	OH4	5P	150	29	48	8.5		—	●	73
78491				2P						—	●	72

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78504	M 14×2	STD	OH4	5P	150	30	48	10.5	4	—	●	105
78505				2P						—	●	104
78512	M 14×1.5	STD	OH3	5P	150	30	48	10.5		—	●	105
78513				2P						—	●	106
78518	M 16×2	STD	OH4	5P	150	32	52	12.5		—	●	144
78519				2P						—	●	144
78526	M 16×1.5	STD	OH3	5P	150	32	52	12.5		—	●	144
78527				2P						—	●	145
78532	M 18×2.5	STD	OH4	5P	150	37	55	14		—	●	178
78533				2P						—	●	179
78538	M 18×1.5			5P	150	37	55	14		—	●	179
78539				2P						—	●	178
78544	M 20×2.5			5P	150	37	58	15		—	●	207
78545				2P						—	●	207
78550	M 20×1.5			5P	150	37	58	15		—	●	210
78551				2P						—	●	210
78558	M 22×2.5			5P	200	38	63	17		—	●	354
78559				2P						—	●	354
78564	M 22×1.5			5P	200	38	63	17		—	●	354
78565				2P						—	●	356
78570	M 24×3			5P	200	45	66	19		—	●	435
78571				2P						—	●	436
78576	M 24×1.5			5P	200	45	66	19		—	●	441
78577				2P						—	●	452

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
CPM-LT			◎			○				○		◎	○						○			○	○		

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1022

内冷油孔型

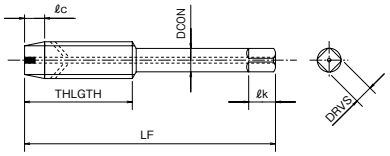
WITH INTERNAL COOLANT SUPPLY

OIL-HT

HSS | H

适用于卧式深孔加工，由于切削油通过油孔对刃尖起作用，能高速加工出高精度的螺纹。

Effective for horizontal deep hole tapping. Because cutting fluid is sufficiently supplied to the cutting edges, high speed/high precision tapping is possible.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
10110	M 6×1	STD	OH2	5P	80	19	—	6	3	—	▲	16
10111				1.5P						—	●	16
10112				5P	100					—	▲	22
10113				1.5P						—	●	22
10122	M 8×1.25			5P	80	22	—	6.2	4	—	▲	18
10123				1.5P						—	●	18
10124				5P	100					—	▲	23
10125				1.5P						—	●	24
10138	M10×1.5			5P	80	24	—	7		—	▲	26
10139				1.5P						—	●	26
10140				5P	100					—	▲	32
10141				1.5P						—	●	32
10152	M10×1.25			5P	120	24	—	7		—	▲	40
10153				1.5P						—	●	39
10168	M12×1.75			5P	100	29	—	8.5		—	▲	47
10169				1.5P						—	●	48
10170				5P	120					—	▲	53
10171				1.5P						—	●	52
10172				5P	150					—	▲	68
10173				1.5P						—	●	67
10178	M12×1.5			5P	120	29	—	8.5		—	▲	53
10179				1.5P						—	●	53
10186	M12×1.25			5P	120	29	—	8.5		—	▲	54
10187				1.5P						—	●	52
10200	M14×2			5P	100	30	—	10.5		—	▲	69
10201				1.5P						—	●	71
10202				5P	120					—	▲	75
10203				1.5P						—	●	77
10204				5P	150					—	▲	89
10205				1.5P						—	●	97
10220	M16×2			5P	100	32	45	12.5		—	▲	93
10221				1.5P						—	●	93
10222				5P	120					—	▲	105
10223				1.5P						—	●	105
10224				5P	150					—	▲	136
10225				1.5P						—	●	136
10240	M18×2.5	STD	OH3	5P	100	37	49	14		—	▲	106
10241	M18×2.5	STD	OH3	1.5P	100	37	49	14	4	—	●	106
10244				5P	150					—	▲	156
10245				1.5P						—	●	157
10258	M20×2.5			5P	120	37	50	15		—	▲	155
10259				1.5P						—	●	153
10260				5P	150					—	▲	200
10261				1.5P						—	●	197
10262				5P	200					—	△	249
10263				1.5P						—	△	263
10268	M20×1.5			5P	150	37	50	15		—	▲	201
10269				1.5P						—	●	199
10270				5P	200					—	△	268
10271				1.5P						—	△	263
10274	M22×2.5			5P	120	38	51	17		—	▲	186
10275				1.5P						—	●	187
10276				5P	150					—	▲	240
10277				1.5P						—	●	241
10278				5P	200					—	△	315
10279				1.5P						—	△	326
10290	M24×3			5P	120	45	59	19		—	▲	231
10291				1.5P						—	●	231
10292				5P	150					—	▲	295
10293				1.5P						—	●	296
10294				5P	200					—	△	402
10295				1.5P						—	△	403
10300	M24×1.5			5P	150	45	59	19		—	▲	304
10301				1.5P						—	●	305
10302				5P	200					—	△	397
10303				1.5P						—	△	399
10306	M27×3			5P	150	45	63	20		—	▲	349
10307				1.5P						—	●	344
10310				5P	250					—	▲	605
10311				1.5P						—	●	605
10318	M30×3.5			5P	150	48	67	23		—	▲	437
10319				1.5P						—	●	443
10322				5P	250					—	▲	769
10323				1.5P						—	●	780

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 每槽各有一个油孔。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由 OIL-HT(切削锥：1.5P) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Each flute has its own oil hole.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by OIL-HT (ℓc:1.5P).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OIL-HT	◎	○	○	○							○		○		○	○	○				○				

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

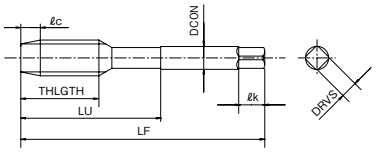
△=停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

不锈钢用
FOR STAINLESS STEELS

EX-SUS-HT

适用于不锈钢，耐热钢、碳素钢、合金钢等材料。
Suitable for tapping blind holes in materials such as stainless steels, copper and thermo plastic.



HSSE | H

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22002	M 2 ×0.4	STD	OH1	5P	40	12	—	3	3	Yes	●	3
22003				1.5P						Yes	●	3
22006	M 2.5 ×0.45	STD	OH2	5P	44	14	—	3		Yes	●	3
22007				1.5P						Yes	●	3
22008	M 2.6 ×0.45			5P	44	14	—	3		Yes	●	3
22009				1.5P						Yes	●	4
22010	M 3 ×0.5			5P	46	11	19	4		Yes	●	4
22011				1.5P						Yes	●	4
22090	M 3.5 ×0.6			5P	48	11	19	4		Yes	▲	5
22091				1.5P						Yes	▲	5
22012	M 4 ×0.7			5P	52	13	21	5		Yes	●	7
22013				1.5P						Yes	●	7
22014	M 5 ×0.8			5P	60	16	24	5.5		Yes	●	10
22015				1.5P						Yes	●	10
22016	M 6 ×1			5P	62	19	29	6		Yes	●	12
22017				1.5P						Yes	●	12
22018	M 8 ×1.25			5P	70	22	37	6.2		—	●	17
22019				1.5P						—	●	17
22020	M10 ×1.5	STD	OH3	5P	75	24	41	7		—	●	25
22021				1.5P						—	●	25
22022	M10 ×1.25	STD	OH2	5P	75	24	41	7		—	●	25
22023				1.5P						—	●	26
22024	M12 ×1.75	STD	OH3	5P	82	29	48	8.5		—	●	40
22025				1.5P						—	●	39
22026	M12 ×1.5			5P	82	29	48	8.5		—	●	40
22027				1.5P						—	●	40
22028	M12 ×1.25	STD	OH2	5P	82	29	48	8.5		—	●	41
22029				1.5P						—	●	41
22030	M14 ×2	STD	OH3	5P	88	30	48	10.5	4	—	●	64
22031				1.5P						—	●	65

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。
▲ = 该产品已停止生产，由 EX-SUS-SFT(P.631)、EX-SUS-POT (P.683) 、H-HT(P.743) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22032	M14 ×1.5	STD	OH3	5P	88	30	48	10.5	4	—	●	65
22033				1.5P						—	●	65
22034	M16 ×2			5P	95	32	52	12.5		—	●	91
22035				1.5P						—	●	90
22036	M16 ×1.5			5P	95	32	52	12.5		—	●	91
22037				1.5P						—	●	91
22038	M18 ×2.5			5P	100	37	55	14		—	▲	112
22039				1.5P						—	▲	112
22040	M18 ×1.5			5P	100	37	55	14		—	▲	114
22041				1.5P						—	▲	114
22042	M20 ×2.5			5P	105	37	58	15		—	▲	137
22043				1.5P						—	▲	135
22044	M20 ×1.5			5P	105	37	58	15		—	▲	139
22045				1.5P						—	▲	139
22046	M22 ×2.5			5P	115	38	63	17		—	▲	180
22047				1.5P						—	▲	185
22048	M22 ×1.5			5P	115	38	63	17		—	▲	185
22049				1.5P						—	▲	189
22050	M24 ×3			5P	120	45	66	19		—	▲	236
22051				1.5P						—	▲	234
22052	M24 ×1.5			5P	120	45	66	19		—	▲	236
22053				1.5P						—	▲	241
22054	M27 ×3			5P	130	45	71	20		—	▲	311
22055				1.5P						—	▲	307
22056	M27 ×1.5			5P	130	45	71	20		—	▲	315
22057				1.5P						—	▲	315
22058	M30 ×3.5			5P	135	48	74	23		—	▲	397
22059				1.5P						—	▲	404
22060	M30 ×1.5			5P	135	48	74	23		—	▲	409
22061				1.5P						—	▲	413

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
▲= The products have been stopped producing and replaced by EX-SUS-SFT (p.631) and EX-SUS-POT (p.683) and H-HT (p.743).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-SUS-HT									◎					○											○

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

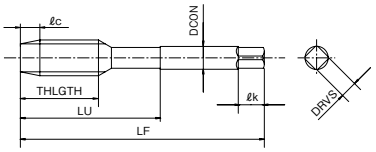
■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1114

铸铁用
FOR CAST IRON

EX-FC-HT

适用于灰口铸铁、球墨铸铁，可锻造铸铁等各种铸铁及黄铜铸件等。
Suitable for tapping grey cast iron, nodular cast iron, malleable cast iron, brass castings, and other similar materials.



HSSE | N

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24522	M 3 ×0.5	STD	OH3	3P	46	11	19	4	3	Yes	●	4
24523				1.5P						Yes	●	4
24526	M 3.5×0.6			3P	48	11	19	4		Yes	●	5
24527				1.5P						Yes	●	5
24530	M 4 ×0.7			3P	52	13	21	5		Yes	●	7
24531				1.5P						Yes	●	7
24536	M 5 ×0.8			3P	60	16	24	5.5		Yes	●	10
24537				1.5P						Yes	●	10
24540	M 6 ×1			3P	62	19	29	6		—	●	12
24541				1.5P						—	●	12
24548	M 8 ×1.25	STD	OH4	3P	70	22	37	6.2	4	—	●	17
24549				1.5P						—	●	17
24552	M 8 ×1	STD	OH3	3P	70	22	37	6.2		—	●	17
24553				1.5P						—	●	17
24556	M10 ×1.5	STD	OH4	3P	75	24	41	7		—	●	26
24557				1.5P						—	●	26
24560	M10 ×1.25			3P	75	24	41	7		—	●	26
24561				1.5P						—	●	26
24564	M10 ×1	STD	OH3	3P	75	24	41	7		—	●	26
24565				1.5P						—	●	26
24576	M12 ×1.75	STD	OH5	3P	82	29	48	8.5		—	●	40
24577				1.5P						—	●	40

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24580	M12 ×1.5	STD	OH4	3P	82	29	48	8.5	4	—	●	40
24581				1.5P						—	●	40
24584	M12 ×1.25			3P	82	29	48	8.5		—	●	40
24585				1.5P						—	●	40
24588	M12 ×1	STD	OH3	3P	82	29	48	8.5		—	●	39
24589				1.5P						—	●	40
24598	M14 ×2	STD	OH5	3P	88	30	48	10.5		—	●	65
24599				1.5P						—	●	65
24602	M14 ×1.5	STD	OH4	3P	88	30	48	10.5		—	●	66
24603				1.5P						—	●	66
24612	M16 ×2	STD	OH5	3P	95	32	52	12.5		—	●	93
24613				1.5P						—	●	93
24616	M16 ×1.5	STD	OH4	3P	95	32	52	12.5		—	●	93
24617				1.5P						—	●	94
24626	M18 ×2.5	STD	OH5	3P	100	37	55	14		—	●	113
24627				1.5P						—	●	111
24630	M18 ×1.5	STD	OH4	3P	100	37	55	14		—	●	113
24631				1.5P						—	●	113
24638	M20 ×2.5	STD	OH5	3P	105	37	58	15		—	●	139
24639				1.5P						—	●	139
24642	M20 ×1.5	STD	OH4	3P	105	37	58	15		—	●	143
24643				1.5P						—	●	141

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-FC-HT												◎	◎		○	○	○								

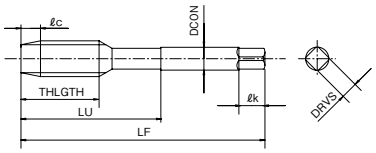
库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

铸铁用 长柄型

LONG SHANK · FOR CAST IRON

EX-FC-LT



HSSE　N

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78210	M 3×0.5	STD	OH3	3P	100	11	19	4	3	Yes	●	11
78211				1.5P						Yes	●	11
78216	M 4×0.7			3P	100	13	21	5		Yes	●	16
78217				1.5P						Yes	●	16
78222	M 5×0.8			3P	100	16	24	5.5		Yes	●	19
78223				1.5P						Yes	●	20
78228	M 6×1			3P	100	19	29	6		—	●	23
78229				1.5P						—	●	23
78232				3P	150					—	●	33
78233				1.5P						—	●	32
78236	M 8×1.25	STD	OH4	3P	100	22	37	6.2	4	—	●	25
78237				1.5P						—	●	26
78240				3P	150					—	●	38
78241				1.5P						—	●	38
78252	M10×1.5			3P	150	24	41	7		—	●	49
78253				1.5P						—	●	50
78260	M10×1.25			3P	150	24	41	7		—	●	50
78261				1.5P						—	●	51
78274	M12×1.75	STD	OH5	3P	150	29	48	8.5		—	●	70
78275				1.5P						—	●	71
78282	M12×1.5	STD	OH4	3P	150	29	48	8.5		—	●	70
78283				1.5P						—	●	71
78290	M12×1.25			3P	150	29	48	8.5		—	●	72
78291				1.5P						—	●	71

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
78304	M14×2	STD	OH5	3P	150	30	48	10.5	4	—	●	103
78305				1.5P						—	●	103
78312	M14×1.5	STD	OH4	3P	150	30	48	10.5		—	●	103
78313				1.5P						—	●	103
78318	M16×2	STD	OH5	3P	150	32	52	12.5		—	●	141
78319				1.5P						—	●	143
78326	M16×1.5	STD	OH4	3P	150	32	52	12.5		—	●	142
78327				1.5P						—	●	141
78332	M18×2.5	STD	OH5	3P	150	37	55	14		—	●	174
78333				1.5P						—	●	175
78338	M18×1.5	STD	OH4	3P	150	37	55	14		—	●	180
78339				1.5P						—	●	178
78344	M20×2.5	STD	OH5	3P	150	37	58	15		—	●	204
78345				1.5P						—	●	203
78350	M20×1.5	STD	OH4	3P	150	37	58	15		—	●	201
78351				1.5P						—	●	207
78358	M22×2.5	STD	OH5	3P	200	38	63	17		—	●	335
78359				1.5P						—	●	344
78364	M22×1.5	STD	OH4	3P	200	38	63	17		—	●	344
78365				1.5P						—	●	348
78370	M24×3	STD	OH5	3P	200	45	66	19		—	●	426
78371				1.5P						—	●	427
78376	M24×1.5	STD	OH4	3P	200	45	66	19		—	●	436
78377				1.5P						—	●	432

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-FC-LT												◎	◎		○	○	○									

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。　See p.1 for explanation of icons.

G-LIST No. | TW1000

硬质合金直槽丝锥

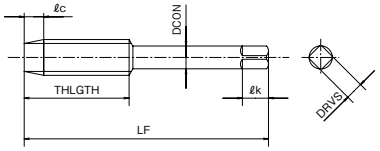
CARBIDE STRAIGHT FLUTED

OTT

CARBIDE

用于普通铸铁、强韧性铸铁、热硬化性树脂、黄铜铸件等，高精度，大批量加工。

Suitable for high production with high precision in automatic machines. It is ideal for tapping materials such as ordinary cast iron, ductile cast iron, thermosetting plastics and brass castings.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24000	M 1.4 ×0.3	STD	OH2	3P	34	9	3	3	Yes	●	4
22800				1.5P					Yes	●	4
24001	M 1.6 ×0.35	STD	OH3	3P	36	9	3		Yes	●	4
22801				1.5P					Yes	●	4
24002	M 1.7 ×0.35	STD	OH3	3P	36	11	3		Yes	●	4
22802				1.5P					Yes	●	4
24003	M 1.8 ×0.35	STD	OH3	3P	36	11	3		Yes	●	4
22803				1.5P					Yes	●	4
24004	M 2 ×0.4	STD	OH3	3P	40	12	3		Yes	●	5
22804				1.5P					Yes	●	4
24006	M 2.3 ×0.4	STD	OH3	3P	42	13	3		Yes	●	5
22806				1.5P					Yes	●	5
24007	M 2.5 ×0.45	STD	OH3	3P	44	14	3		Yes	●	5
22807				1.5P					Yes	●	5
24008	M 2.6 ×0.45	STD	OH3	3P	44	14	3		Yes	●	5
22808				1.5P					Yes	●	5
24010	M 3 ×0.5	STD	OH3	3P	46	11	4		Yes	●	7
22810				1.5P					Yes	●	7
24014	M 4 ×0.7	STD	OH3	3P	52	13	5		Yes	●	13
22814				1.5P					Yes	●	13
24017	M 5 ×0.8	STD	OH3	3P	60	16	5.5		Yes	●	18
22817				1.5P					Yes	●	18
24020	M 6 ×1	STD	OH3	3P	62	19	6		—	●	21
22820				1.5P					—	●	21
24030	M 8 ×1.25	STD	OH4	3P	70	22	6.2	4	—	●	30
22830				1.5P					—	●	30
24031	M 8 ×1	STD	OH3	3P	70	22	6.2		—	●	30
22831				1.5P					—	●	30
24033	M10 ×1.5	STD	OH4	3P	75	24	7		—	●	43
22833				1.5P					—	●	43
24034	M10 ×1.25	STD	OH4	3P	75	20	7		—	●	43
22834				1.5P					—	●	43
24035	M10 ×1	STD	OH3	3P	75	20	7		—	●	44

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22835	M10 ×1	STD	OH3	1.5P	75	20	7	4	—	●	44
24037	M12 ×1.75	STD	OH5	3P	82	29	8.5		—	●	68
22837				1.5P					—	●	69
24039	M12 ×1.5	STD	OH4	3P	82	29	8.5		—	●	69
22839				1.5P					—	●	69
24040	M12 ×1.25	STD	OH4	3P	80	24	8.5		—	●	67
22840				1.5P					—	●	67
24041	M12 ×1	STD	OH3	3P	80	24	8.5		—	●	68
22841				1.5P					—	●	68
◆24045	M14 ×2	STD	OH4	3P	88	29	10.5		—	●	72
◆24046				1.5P					—	●	72
◆24047	M14 ×1.5	STD	OH4	3P	88	22	10.5		—	●	70
◆24048				1.5P					—	●	70
◆24051	M16 ×2	STD	OH5	3P	95	29	12.5		—	●	99
◆24052				1.5P					—	●	101
◆24053	M16 ×1.5	STD	OH4	3P	95	29	12.5		—	●	102
◆24054				1.5P					—	●	101
◆24055	M18 ×2.5	STD	OH5	3P	100	35	14		—	●	121
◆24056				1.5P					—	●	121
◆24059	M18 ×1.5	STD	OH4	3P	95	29	14		—	●	116
◆24060				1.5P					—	●	116
◆24061	M20 ×2.5	STD	OH5	3P	105	35	15		—	●	149
◆24062				1.5P					—	●	150
◆24065	M20 ×1.5	STD	OH4	3P	95	29	15		—	●	137
◆24066				1.5P					—	●	137
◆24067	M22 ×2.5	STD	OH5	3P	115	35	17		—	△	200
◆24068				1.5P					—	△	201
◆24071	M22 ×1.5	STD	OH4	3P	95	29	17		—	△	169
◆24072				1.5P					—	△	169
◆24073	M24 ×3	STD	OH5	3P	120	35	19		—	△	259
◆24074				1.5P					—	△	260
◆24077	M24 ×1.5	STD	OH4	3P	95	29	19		—	△	210
◆24078				1.5P					—	△	206

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. ◆为焊接型。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. ◆/ symbol indicates carbide brazed type.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
OTT												◎	○		○	○	◎		○	○	○			◎		

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

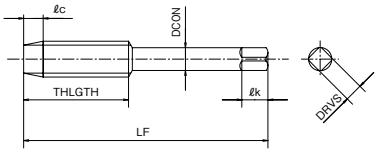
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TW1003

硬质合金直槽丝锥 长柄型

CARBIDE LONG SHANK · STRAIGHT FLUTED

LT-OTT



CARBIDE

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22916	M 3 ×0.5	STD	OH3	3P	100	18	4	3	Yes	●	17
22917				1.5P					Yes	●	17
22920	M 4 ×0.7			3P	100	20	5		Yes	●	25
22921				1.5P					Yes	●	26
22924	M 5 ×0.8			3P	100	22	5.5		Yes	●	31
22925				1.5P					Yes	●	32
22928	M 6 ×1			3P	100	24	6		—	●	37
22929				1.5P					—	●	38
22932	M 8 ×1.25	STD	OH4	3P	150	22	6.2	4	—	●	65
22933				1.5P					—	●	65
22936	M 8 ×1	STD	OH3	3P	150	22	6.2		—	●	65
22937				1.5P					—	●	66
22940	M10×1.5	STD	OH4	3P	150	24	7		—	●	85
22941				1.5P					—	●	85
22944	M10×1.25			3P	150	24	7		—	●	85
22945				1.5P					—	●	85
22948	M10×1	STD	OH3	3P	150	24	7		—	●	85
22949				1.5P					—	●	85
22952	M12×1.75	STD	OH4	3P	150	29	8.5		—	●	124
22953				1.5P					—	●	123
22956	M12×1.5			3P	150	29	8.5		—	●	124
22957				1.5P					—	●	124
22960	M12×1.25			3P	150	29	8.5		—	●	124
22961				1.5P					—	●	124
22964	M12×1	STD	OH3	3P	150	29	8.5		—	●	125

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. ◆为焊接型。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
22965	M12×1	STD	OH3	1.5P	150	29	8.5	4	—	●	126
◆22968	M14×2	STD	OH4	3P	150	29	10.5		—	●	109
◆22969				1.5P					—	●	109
◆22972	M14×1.5			3P	150	22	10.5		—	●	107
◆22973				1.5P					—	●	107
◆22976	M16×2	STD	OH5	3P	150	29	12.5		—	●	149
◆22977				1.5P					—	●	153
◆22980	M16×1.5	STD	OH4	3P	150	29	12.5		—	●	151
◆22981				1.5P					—	●	153
◆22984	M18×2.5	STD	OH5	3P	150	35	14		—	●	186
◆22985				1.5P					—	●	186
◆22988	M18×1.5	STD	OH4	3P	150	29	14		—	●	188
◆22989				1.5P					—	●	188
◆22992	M20×2.5	STD	OH5	3P	150	35	15		—	●	216
◆22993				1.5P					—	●	216
◆22996	M20×1.5	STD	OH4	3P	150	29	15		—	●	217
◆22997				1.5P					—	●	217
◆23000	M22×2.5	STD	OH5	3P	150	35	17		—	△	266
◆23001				1.5P					—	△	267
◆23004	M22×1.5	STD	OH4	3P	150	29	17		—	△	270
◆23005				1.5P					—	△	271
◆23008	M24×3	STD	OH5	3P	150	35	19		—	△	331
◆23009				1.5P					—	△	331
◆23012	M24×1.5	STD	OH4	3P	150	29	19		—	△	333
◆23013				1.5P					—	△	336

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. ◆/ symbol indicates carbide brazed type.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
LT-OTT												◎	○		○	○	◎		○	○	○			◎		

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

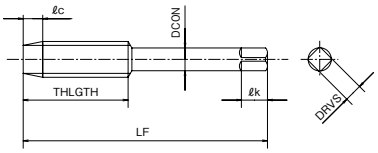
G-LIST No. | TH1000

铝合金用
FOR ALUMINUM

AL-HT

HSS

适用于铝合金、及其他轻金属延压材料。
Suitable for tapping aluminum and other light alloy rolled materials.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24714	M 3 ×0.5	STD	OH2	3P	46	18	4	3	Yes	▲	5
24715				1.5P					Yes	▲	5
24724	M 4 ×0.7			3P	52	20	5		Yes	▲	8
24725				1.5P					Yes	▲	7
24730	M 5 ×0.8			3P	60	22	5.5		Yes	▲	10
24731				1.5P					Yes	▲	10
24736	M 6 ×1			3P	62	24	6		—	▲	12
24737				1.5P					—	▲	12
24744	M 8 ×1.25			3P	70	30	6.2		—	▲	17
24745				1.5P					—	▲	16

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由 HT(P.701)、EX-DC-HT(P.758)、TIN-HT(P.747) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24752	M10×1.5	STD	OH2	3P	75	32	7	3	—	▲	24
24753				1.5P					—	▲	24
24754	M10×1.25			3P	75	32	7		—	▲	25
24755				1.5P					—	▲	24
24762	M12×1.75			3P	82	38	8.5	4	—	▲	39
24763				1.5P					—	▲	40
24764	M12×1.5			3P	82	38	8.5		—	▲	39
24765				1.5P					—	▲	39
24766	M12×1.25			3P	80	38	8.5		—	▲	38
24767				1.5P					—	▲	38

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by HT(p.701) and EX-DC-HT(p.758) and TIN-HT(p.747).

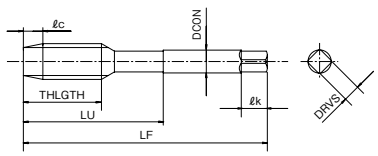
G-LIST No. | TH1118

树脂用
FOR PLASTIC/RESIN

EX-PLA-HT

HSS-Co | N

主要用于热硬化树脂的加工。
Suitable for tapping heat-hardened resins such as phenol (bakelite), epoxy, urea and melamin.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24410	M 2 ×0.4	STD	OH3	3P	40	12	—	3	3	Yes	●	3
24414	M 2.3×0.4				42	13	—	3		Yes	●	3
24416	M 2.5×0.45	STD	OH4		44	14	—	3		Yes	●	4
24418	M 2.6×0.45				44	14	—	3		Yes	●	3
24421	M 3 ×0.5				46	11	19	4	4	Yes	●	4
24423	M 3.5×0.6				48	13	20	4		Yes	●	5

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24426	M 4 ×0.7	STD	OH4	3P	52	13	21	5	4	Yes	●	7
24429	M 5 ×0.8				60	16	24	5.5		Yes	●	10
24431	M 6 ×1				62	19	29	6		Yes	●	12
24433	M 8 ×1.25				70	22	37	6.2	5	—	●	17
24437	M10 ×1.5				75	24	41	7		—	●	27
24442	M12 ×1.75	STD	OH5		82	29	48	8.5		—	●	42

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
AL-HT																		◎							
EX-PLA-HT																								◎	

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | **TH1113**

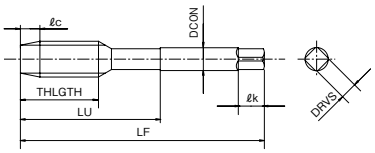
铸件用

FOR DIE CASTINGS

EX-DC-HT

适合用于铝合金铸件、锌合金铸件等。

Suitable for tapping materials such as aluminum alloy casting, aluminum alloy die casting and zinc alloy die casting.



HSSE | N

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24787	M1.4×0.3	STD	OH2	3P	34	9	—	3	3	Yes	●	3
24788				1.5P						Yes	●	3
24791	M1.7×0.35			3P	36	11	—	3		Yes	●	3
24792				1.5P						Yes	●	3
24794	M2 ×0.4			3P	40	12	—	3		Yes	●	3
24795				1.5P						Yes	●	3
24798	M2.3×0.4			3P	42	13	—	3		Yes	●	4
24799				1.5P						Yes	●	4
24802	M2.5×0.45			3P	44	14	—	3		Yes	●	4
24803				1.5P						Yes	●	3
24806	M2.6×0.45			3P	44	14	—	3		Yes	●	4
24807				1.5P						Yes	●	4
24810	M3 ×0.5		OH3	3P	46	11	19	4		Yes	●	4
24811				1.5P						Yes	●	5
24814	M3.5×0.6			3P	48	13	20	4		Yes	●	5
24815				1.5P						Yes	●	5
24818	M4 ×0.7			3P	52	13	21	5		Yes	●	7
24819				1.5P						Yes	●	7
24824	M5 ×0.8			3P	60	16	24	5.5		Yes	●	10
24825				1.5P						Yes	●	10
24830	M6 ×1			3P	62	19	29	6		—	●	11
24831				1.5P						—	●	11
24840	M8 ×1.25	STD	OH4	3P	70	22	37	6.2	4	—	●	17
24842				1.5P						—	●	17
24843	M8 ×1	STD	OH3	3P	70	22	37	6.2		—	●	18
24844				1.5P						—	●	17
24854	M10 ×1.5	STD	OH4	3P	75	24	41	7		—	●	26
24855				1.5P						—	●	26

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. M3以上为氮化处理。
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24858	M10 ×1.25	STD	OH4	3P	75	24	41	7	4	—	●	25
24859				1.5P						—	●	25
24860	M10 ×1	STD	OH3	3P	75	24	41	7		—	●	26
24861				1.5P						—	●	26
24872	M12 ×1.75	STD	OH4	3P	82	29	48	8.5		—	●	40
24873				1.5P						—	●	41
24874	M12 ×1.5			3P	82	29	48	8.5		—	●	41
24875				1.5P						—	●	41
24876	M12 ×1.25			3P	82	29	48	8.5		—	●	41
24877				1.5P						—	●	41
24878	M12 ×1	STD	OH3	3P	82	29	48	8.5		—	●	41
24879				1.5P						—	●	41
24888	M14 ×2	STD	OH4	3P	88	30	48	10.5		—	●	65
24889				1.5P						—	●	65
24890	M14 ×1.5			3P	88	30	48	10.5		—	●	66
24891				1.5P						—	●	66
24900	M16 ×2			3P	95	32	52	12.5		—	●	94
24901				1.5P						—	●	93
24902	M16 ×1.5			3P	95	32	52	12.5		—	●	94
24903				1.5P						—	●	93
24910	M18 ×2.5			3P	100	37	55	14		—	●	113
24911				1.5P						—	●	112
24914	M18 ×1.5			3P	100	37	55	14		—	●	113
24915				1.5P						—	●	113
24922	M20 ×2.5			3P	105	37	58	15		—	●	138
24923				1.5P						—	●	138
24926	M20 ×1.5			3P	105	37	58	15		—	●	141
24927				1.5P						—	●	144

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. ≦ M3: with nitriding.
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-DC-HT																		○	◎	◎	○					

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TW1032

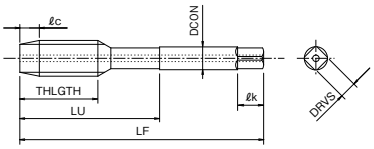
内冷油孔硬质合金直槽丝锥

CARBIDE STRAIGHT FLUTED TAP WITH INTERNAL COOLANT SUPPLY

A The A Brand

A-CHT

切削条件 Cutting Conditions | P.838



CARBIDE | FX | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330710	M 6 × 1	STD	OH3	1.5P	62	19	30	6	3	—	●	19
8330720	M 8 × 1.25	STD	OH4	1.5P	70	22	—	6.2	4	—	●	28
8330730	M 10 × 1.5	STD	OH4	1.5P	75	24	—	7	4	—	●	39
8330731	M 10 × 1.25	STD	OH4	1.5P	75	24	—	7	4	—	●	40
8330740	M 12 × 1.75	STD	OH4	1.5P	82	29	—	8.5	4	—	●	63
8330742	M 12 × 1.25	STD	OH4	1.5P	82	29	—	8.5	4	—	●	64

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 推荐底孔径是旧JIS2级内螺纹用。(除旧JIS 的规格中没有的内螺纹) JIS 规格中没有的内螺纹的底孔径仅供参考。

※ 高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS 2 B internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. The recommended tap limit corresponds to JIS class 2 internal thread standard. The recommended drill hole size that are not listed on JIS is as reference.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

G-LIST No. | TW1032

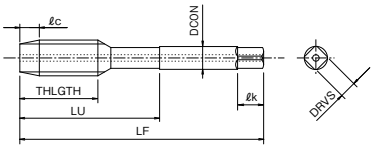
内冷油孔硬质合金直槽丝锥 (铣刀柄)

CARBIDE STRAIGHT FLUTED TAP WITH INTERNAL COOLANT SUPPLY (END MILL SHANK)

A The A Brand

A-CHT

切削条件 Cutting Conditions | P.838



CARBIDE | FX | SHANK h6

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330760	M 6 × 1 - 6	STD	OH3	1.5P	80	19	30	6	3	—	●	26
8330770	M 8 × 1.25 - 8	STD	OH4	1.5P	90	22	37	8	4	—	●	49
8330780	M 10 × 1.5 - 8	STD	OH4	1.5P	100	24	—	8	4	—	●	62
8330781	M 10 × 1.25 - 8	STD	OH4	1.5P	100	24	—	8	4	—	●	63
8330790	M 12 × 1.75 - 10	STD	OH4	1.5P	110	29	—	10	4	—	●	97
8330792	M 12 × 1.25 - 10	STD	OH4	1.5P	100	29	—	10	4	—	●	97

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2B内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 推荐底孔径是旧JIS2级内螺纹用。(除旧JIS 的规格中没有的内螺纹) JIS 规格中没有的内螺纹的底孔径仅供参考。

※ 高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap limit corresponds to JIS 2 B internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. The recommended tap limit corresponds to JIS class 2 internal thread standard. The recommended drill hole size that are not listed on JIS is as reference.

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
A-CHT												◎	◎		◎	◎	○		○	○	○			◎	○

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TW1018

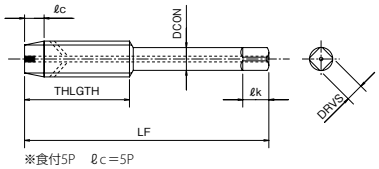
硬质合金内冷油孔高速同步直槽丝锥

SYNCHRO TUNGSTEN CARBIDE TAPS WITH INTERNAL COOLANT SUPPLY

HS-O-OTT

在铸铁和铝合金铸件的大量高速加工中发挥优良的性能。

Provides high performance and high speed tapping in cast iron and aluminum casting.



※食付5P　ℓc=5P

CARBIDE　FX　SHANK h6

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	镀标记 Grade	精度 TAP Limit	刃脱长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8315744	**M12×1.25**	STD	OH4	5P	100	29	—	10	4	—	▲	98

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。

▲=此产品已停止生产，由 A-CHT (P.759) 替代。

※ 高速同步丝锥是用于具有完全同步进给功能的设备的专用工具。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.

▲= The products have been stopped producing and replaced by A-CHT (p.759)

※ SYNCHRO TAPS are not recommended for use on machines without synchronized feed control.

再研磨 · 再涂层

可一次性接受。实现和新品一样的性能。

※详情请参照▶P.9
See p.9 for details

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	高碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸物 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HS-O-OTT												◎	○		○	○	○		◎	◎	◎				

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。　See p.1 for explanation of icons.

G-LIST No. | TW1009

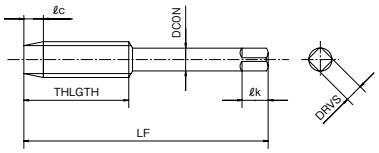
铸件用硬质合金直槽丝锥

CARBIDE STRAIGHT FLUTED · FOR DIE CASTINGS

OT-DC-HT

适合使用高精度自动机床大批量加工铝合金铸件。

Suitable for numerous operations with high precision, automatic machines. It is ideal for tapping materials such as aluminum alloy castings.



CARBIDE

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8315454	M 3 ×0.5	STD	OH3	3P	46	11	19	4	3	Yes	▲	7
8315455				1.5P						Yes	●	7
8315460	M 4 ×0.7			3P	52	13	21	5		Yes	▲	12
8315461				1.5P						Yes	●	13
8315466	M 5 ×0.8			3P	60	16	24	5.5		Yes	▲	17
8315467				1.5P						Yes	●	18
8315472	M 6 ×1			3P	62	19	29	6		—	▲	20
8315473				1.5P						—	●	20
8315484	M 8 ×1.25	STD	OH4	3P	70	22	—	6.2		—	▲	29
8315485				1.5P						—	●	29

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。
▲ = 该产品已停止生产，由 OTT (P.755) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8315496	M10×1.5	STD	OH4	3P	75	24	—	7	3	—	▲	43
8315497				1.5P						—	●	43
8315502	M10×1.25			3P	75	24	—	7		—	▲	42
8315503				1.5P						—	●	43
8315514	M12×1.75			3P	82	29	—	8.5		—	▲	66
8315515				1.5P						—	●	66
8315520	M12×1.5			3P	82	29	—	8.5		—	▲	67
8315521				1.5P						—	●	67
8315526	M12×1.25			3P	82	29	—	8.5		—	▲	67
8315527				1.5P						—	●	67

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
▲= The products have been stopped producing and replaced by OTT (p.755).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OT-DC-HT												○			◎	◎	○		◎	○	◎			○	◎

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

△ = 停产产品(请确认库存。) Discontinued item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1141

铸件用零前角丝锥

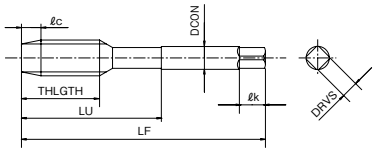
ZERO TAPS FOR DIE CASTINGS

VP-DC-HT

CPM　V

前角为0°，刃部强度大。在具有同步进给功能的设备上使用会对铝合金铸件加工产生更好的效果。

Ideal for aluminum casting alloy while using synchronized feed machine.



螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8312531	**M 6 ×1**	STD	OH3	1.5P	62	19	29	6	3	—	●	12
8312542	**M 8 ×1.25**	STD	OH4	1.5P	70	22	37	6.2	4	—	●	17
8312555	**M10 ×1.5**	STD	OH4	1.5P	75	24	41	7	4	—	●	25
8312559	**M10 ×1.25**	STD	OH4	1.5P	75	24	41	7	4	—	●	26

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8312573	**M12 ×1.75**	STD	OH4	1.5P	82	29	48	8.5	4	—	●	40
8312575	**M12 ×1.5**	STD	OH4	1.5P	82	29	48	8.5	4	—	●	42
8312577	**M12 ×1.25**	STD	OH4	1.5P	82	29	48	8.5	4	—	●	42

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

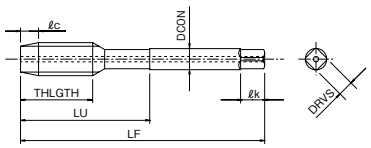
G-LIST No. | TH1161

内冷油孔铸件用零前角丝锥

ZERO TAPS WITH INTERNAL COOLANT SUPPLY FOR DIE CASTINGS

VO-DC-HT

HSSE　V



螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8313531	**M 6 ×1**	STD	OH3	1.5P	62	19	29	6	—	●	11
8313542	**M 8 ×1.25**	STD	OH4	1.5P	70	22	37	6.2	—	●	16
8313555	**M10 ×1.5**	STD	OH4	1.5P	75	24	41	7	—	●	22
8313559	**M10 ×1.25**	STD	OH4	1.5P	75	24	41	7	—	●	22

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8313573	**M12 ×1.75**	STD	OH4	1.5P	82	29	48	8.5	—	●	37
8313575	**M12 ×1.5**	STD	OH4	1.5P	82	29	48	8.5	—	●	37
8313577	**M12 ×1.25**	STD	OH4	1.5P	82	29	48	8.5	—	●	37

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
VP-DC-HT												◎	◎						◎	◎	◎					
VO-DC-HT												◎	◎					○	◎	◎	◎					

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。　See p.1 for explanation of icons.

G-LIST No. | TH1006

高硬度钢用

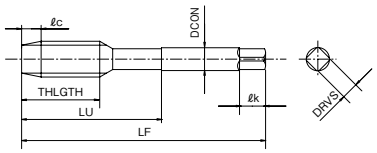
FOR HIGH STRENGTH STEELS

EX-SH-HT

HSSE

适用于热处理铬钢、锰钢、铬镍钢、工具钢等。

Suitable for tapping materials such as high strength heat treated chromium steels, nickel chromium steels, manganese steels and tool steels.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24320	M 6 ×1	STD	OH2	5P	62	19	29	6	4	Yes	▲	12
24321				2.5P						Yes	▲	12
24326	M 8 ×1.25			5P	70	22	37	6.2		—	▲	17
24327				2.5P						—	▲	17
24334	M10 ×1.5			5P	75	24	41	7		—	▲	25
24335				2.5P						—	▲	25
24336	M10 ×1.25			5P	75	24	41	7		—	▲	26
24337				2.5P						—	▲	26
24344	M12 ×1.75			5P	82	29	48	8.5		—	▲	33
24345				2.5P						—	▲	40
24346	M12 ×1.5			5P	82	29	48	8.5		—	▲	34
24347				2.5P						—	▲	40
24348	M12 ×1.25			5P	82	29	48	8.5		—	▲	40
24349				2.5P						—	▲	41
24356	M14 ×2			5P	88	30	48	10.5		—	▲	66

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

▲=该产品已停止生产，由CPM-HT(P.749)、TIN-HT(P.747)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
24357	M14 ×2	STD	OH2	2.5P	88	30	48	10.5	4	—	▲	66
24358	M14 ×1.5			5P	88	30	48	10.5		—	▲	53
24359				2.5P						—	▲	67
24364	M16 ×2			5P	95	32	52	12.5		—	▲	93
24365				2.5P						—	▲	92
24366	M16 ×1.5			5P	95	32	52	12.5		—	▲	91
24367				2.5P						—	▲	93
24370	M18 ×2.5	STD	OH3	5P	100	37	55	14		—	▲	108
24371				2.5P						—	▲	109
24374	M18 ×1.5	STD	OH2	5P	100	37	55	14		—	▲	115
24375				2.5P						—	▲	115
24380	M20 ×2.5	STD	OH3	5P	105	37	58	15		—	▲	137
24381				2.5P						—	▲	138
24384	M20 ×1.5	STD	OH2	5P	105	37	58	15		—	▲	124
24385				2.5P						—	▲	142

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by CPM-HT (p.749) and TIN-HT (p.747).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-SH-HT		○	○	○																					

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1128

V涂层粉末高速钢(高硬度钢用)

FOR HARDENED STEELS (42~52 HRC)

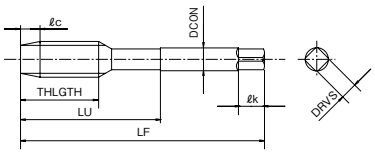
V-XPM-HT

切削条件 Cutting Conditions | P.843

最适合用于42 ~ 52HRC淬火钢(合金钢、模具钢、工具钢等)可最大限度的体现出母材的特性，V涂层更增加了耐磨性。

Suitable for tapping steels with hardness of 42~52 HRC, such as alloy steels, die steels, and tool steels. The high wear resistance of V coating allows this tap to perform exceptionally well under these conditions.

XPM　V



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330255	M 3×0.5	STD	OH3	5P	46	11	19	4	4	Yes	●	4
8330256				2.5P						Yes	●	5
8330261	M 4×0.7			5P	52	13	21	5		Yes	●	7
8330262				2.5P						Yes	●	7
8330267	M 5×0.8			5P	60	16	24	5.5		Yes	●	5
8330268				2.5P						Yes	●	10
8330273	M 6×1			5P	62	19	29	6		Yes	●	12
8330274				2.5P						Yes	●	12
8330285	M 8×1.25			5P	70	22	37	6.2	5	—	●	18
8330286				2.5P						—	●	17
8330291	M 8×1			5P	70	22	37	6.2		—	●	18
8330292				2.5P						—	●	17

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

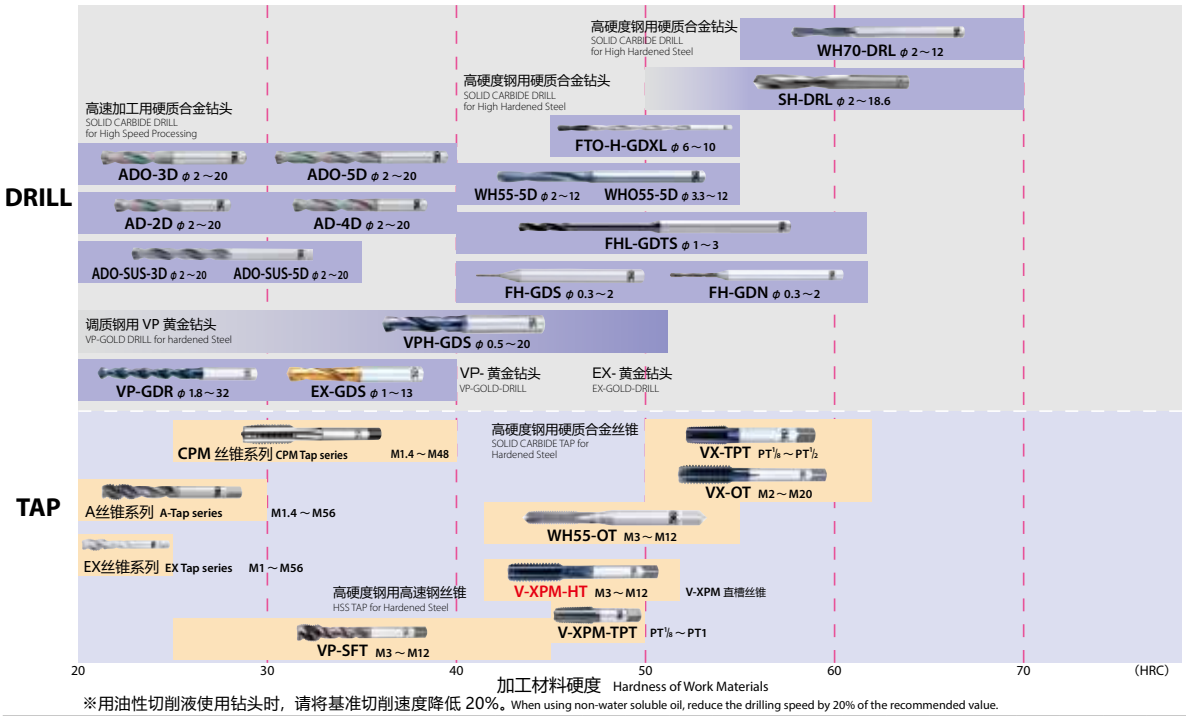
1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330297	M10×1.5	STD	OH3	5P	75	24	41	7	5	—	●	26
8330298				2.5P						—	●	26
8330303	M10×1.25			5P	75	24	41	7		—	●	26
8330304				2.5P						—	●	26
8330309	M10×1			5P	75	24	41	7		—	●	27
8330310				2.5P						—	●	26
8330315	M12×1.75			5P	82	29	48	8.5		—	●	40
8330316				2.5P						—	●	40
8330321	M12×1.5			5P	82	29	48	8.5		—	●	41
8330322				2.5P						—	●	42
8330327	M12×1.25	STD	OH4	5P	82	29	48	8.5		—	●	41
8330328				2.5P						—	●	40

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

■孔加工工具选择基准 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

加工材料 Work Material	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
V-XPM-HT						○※1	◎																			

※1 推荐40HRC以上　※1 We recommend 40HRC and over the tapping process by V-XPM-HT.

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TW1023

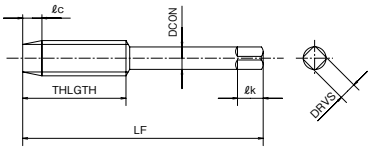
硬质合金高硬度钢用直槽丝锥 (∽55HRC)

CARBIDE STRAIGHT FLUTE · FOR HARDENED STEELS (~55HRC)

WH55-OT

切削条件 Cutting Conditions | P.842

最适合加工 55HRC 以下硬度的淬火钢。
Best for tapping heat treated material up to HRC55.



CARBIDE | V

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3901010	M 3 ×0.5	STD	OH3	5P	46	11	19	4	4	Yes	●	6
3901011				2.5P						Yes	●	6
3901014	M 4 ×0.7			5P	52	13	21	5		Yes	●	11
3901015				2.5P						Yes	●	12
3901018	M 5 ×0.8			5P	60	16	24	5.5		Yes	●	16
3901019				2.5P						Yes	●	17
3901022	M 6 ×1			5P	62	19	29	6		Yes	●	20
3901023				2.5P						Yes	●	20

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

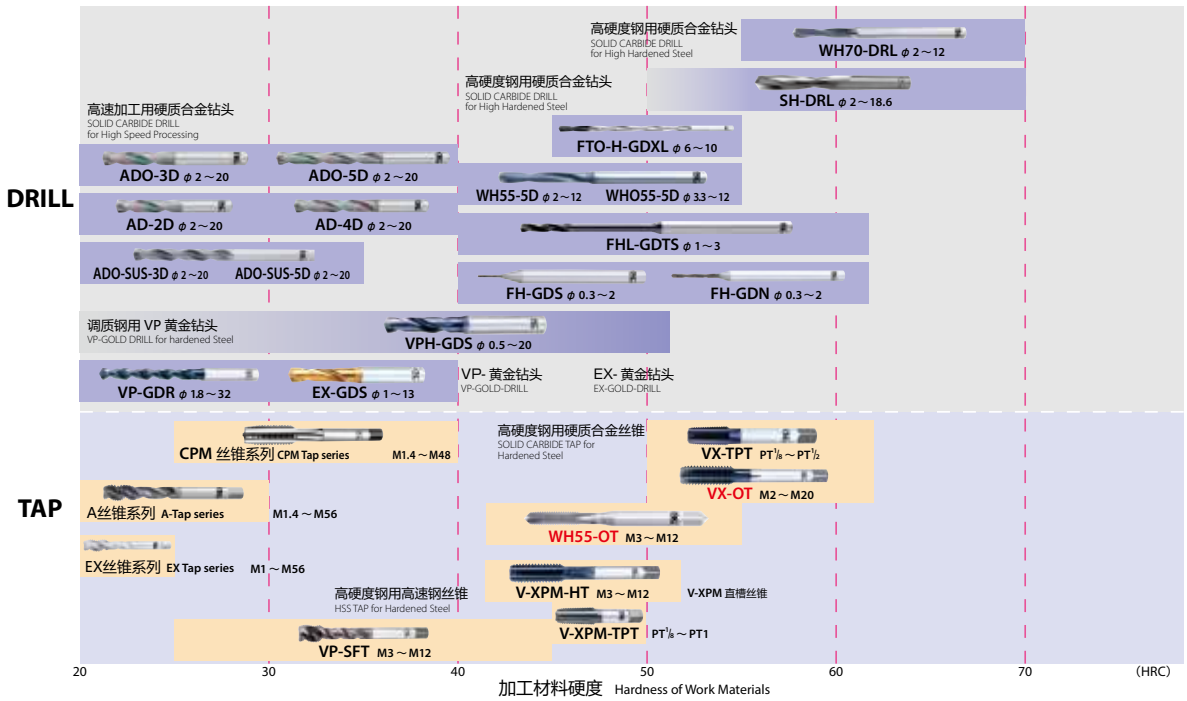
1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
3901026	M 8 ×1.25	STD	OH3	5P	70	22	—	6.2	5	—	●	29
3901027				2.5P						—	●	29
3901030	M10×1.5			5P	75	24	—	7		—	●	42
3901031				2.5P						—	●	43
3901034	M12×1.75			5P	82	29	—	8.5		—	●	69
3901035				2.5P						—	●	69

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.

■孔加工工具选择基准 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
WH55-OT						○※1	◎																		

※1 推荐40HRC以上 ※1 We recommend 40HRC and over the tapping process by WH55-OT.

库存记号 Inventory symbols

●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

硬质合金高硬度钢用直槽丝锥

CARBIDE STRAIGHT FLUTE · FOR HARDENED STEELS (50HRC~60HRC)

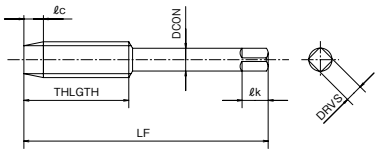
VX-OT

切削条件 Cutting Conditions | P.843

CARBIDE | V

用于50HRC以上(淬火钢、合金钢、高速钢、工具钢等)的攻丝。

This tap is especially designed for tapping hardened steels with hardness 50HRC or higher (alloy steels, die steels, tool steels, etc).



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330029	M 2 ×0.4	STD	OH3	3P	40	12	—	3	3	Yes	●	5
8330039	M 2.3×0.4				42	13	—	3	4	Yes	●	5
8330045	M 2.5×0.45				44	14	—	3		Yes	●	5
8330049	M 2.6×0.45				44	14	—	3		Yes	●	5
8330055	M 3 ×0.5				46	11	19	4		Yes	●	10
8330061	M 4 ×0.7				52	13	21	5		Yes	●	14
8330067	M 5 ×0.8				60	16	24	5.5		Yes	●	17
8330073	M 6 ×1				62	19	29	6	5	Yes	●	21
8330085	M 8 ×1.25				70	22	—	6.2		—	●	30
8330087	M 8 ×1				70	22	—	6.2		—	●	30
8330097	M10 ×1.5				75	24	—	7		—	●	46
8330099	M10 ×1.25				75	24	—	7		—	●	46
8330101	M10 ×1				75	24	—	7		—	●	47

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8330115	M12 ×1.75	STD	OH3	3P	82	29	—	8.5	5	—	●	75
8330117	M12 ×1.5				82	29	—	8.5		—	●	75
8330119	M12 ×1.25	STD	OH4		82	29	—	8.5		—	●	76
8330121	M12 ×1	STD	OH3		82	29	—	8.5		—	●	76
8330123	M14 ×2	STD	OH4		88	30	—	10.5	6	—	●	118
8330125	M14 ×1.5	STD	OH3		88	30	—	10.5		—	●	120
8330131	M16 ×2	STD	OH4		95	32	—	12.5		—	●	171
8330133	M16 ×1.5	STD	OH3		95	32	—	12.5		—	●	172
8330139	M18 ×2.5	STD	OH4		100	37	—	14		—	●	215
8330141	M18 ×1.5				100	37	—	14		—	●	216
8330147	M20 ×2.5				105	37	—	15		—	●	276
8330149	M20 ×1.5				105	37	—	15		—	●	281

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.

■推荐条件表 Recommended Conditions

切削速度 Cutting Speed	1～3m/min
使用机械 Machine	加工中心 Machining Center
切削油剂 Coolant	油性切削油剂 Non-water-Soluble

1.使用VX-OT时，一定要注意切削速度和切削油剂的选定。不宜使用攻丝油膏。
2.手动攻丝可能会引起切屑的卷入造成崩刀。不宜使用手动攻丝。

1.Make sure to select the correct cutting speed and cutting fluids. Tapping paste is not recommended.
2.The VX-OT is designed for machine use only. Tapping by hand will cause chips to get stuck between the tool and the work material, and result in chipping of the taps.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
VX-OT								◎																		

库存记号 Inventory symbols

●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1321

螺旋槽丝锥(锥管螺纹，长螺纹型)

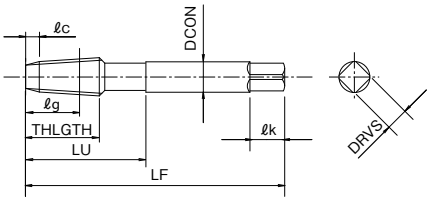
SPIRAL FLUTED TAP (TAPER PIPE THREAD)

A The A Brand

A-TPT

切削条件 Cutting Conditions | P.838

HSSE | V | 40°



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327651	PT 1/16 - 28	JIS2	2.5P	90	18	36	10.1	8	3	●	30
8327652	PT 1/8 - 28			90	19	37	13	8		●	36
8327653	PT 1/4 - 19			100	28	49	21	11		●	74
8327654	PT 3/8 - 19			100	28	50	21	14	4	●	115
8327655	PT 1/2 - 14			125	35	60	25	18		●	235
8327657	PT 3/4 - 14			140	35	74	25	23		●	424
8327659	PT 1 - 11			160	45	80	32	26		●	670

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

螺纹种类：Rc

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327721	Rc 1/16 - 28	—	2.5P	90	14	36	10.1	8	3	●	31
8327722	Rc 1/8 - 28	—		90	15	37	10.1	8		●	37
8327723	Rc 1/4 - 19	—		100	19	49	15	11		●	75
8327724	Rc 3/8 - 19	—		100	21	50	15.4	14	4	●	116
8327725	Rc 1/2 - 14	—		125	26	60	20.5	18		●	232
8327727	Rc 3/4 - 14	—		140	28	74	21.8	23		●	422
8327729	Rc 1 - 11	—		160	33	80	26	26		●	659

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

■管螺纹的尺寸一览表 Pipe Thread Size Chart

A	6	8	10	15	20	25	32	40	50
B	1/8	1/4	3/8	1/2	3/4	1	1 1/4	1 1/2	2

1. 如果螺纹尺寸是A，就加上A的符号，如果是基于B，就在每个数字后面加上B的符号。无论哪个都仅表示螺纹尺寸，在选择丝锥时，请务必检查螺纹标准。

1. If the thread size is A, add the sign of A, and if it is based on B, add the sign of B after each number. Both of them only indicate the size of thread. Please make sure to check the thread standard when selecting a tap.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
A-TPT	◎	◎	◎	◎	◎				○	○	○		○	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

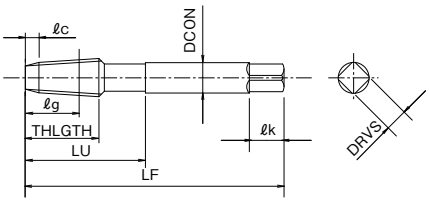
■记号说明请参考P1页。 See p.1 for explanation of icons.

螺旋槽丝锥 (锥管螺纹，短螺纹型)
SPIRAL FLUTED TAP (TAPER PIPE THREAD)

The A Brand

A-S-TPT

切削条件 Cutting Conditions | P.838



HSSE | V | 40°

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327661	PT 1/16 - 28	JIS2	2.5P	90	16.5	36	8.6	8	3	●	31
8327662	PT 1/8 - 28			90	16.5	37	10.5	8		●	36
8327663	PT 1/4 - 19			100	19.5	49	12.5	11		●	75
8327664	PT 3/8 - 19			100	21	50	14	14	4	●	115
8327665	PT 1/2 - 14			125	27	60	17	18		●	232
8327667	PT 3/4 - 14			140	29	74	19	23		●	421
8327669	PT 1 - 11			160	35	80	22	26		●	661

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-S-TPT	◎	◎	◎	◎	◎				○	○	○		○	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

1982年，由于ISO的导入，JIS管用螺纹规格得到了修改，螺纹的记号也得到了修改，但是由于螺纹的精度没有改变，因此我司丝锥的记号仍使用旧记号。

The JIS pipe thread standard was revised in 1982 to meet ISO standards. Although thread symbols changed, the limits were not changed. Therefore, it is still acceptable to use the older symbols.

(JIS B0203-1982)

种　类 Type	旧记号 Previous Symbol	新记号 New Symbol
密封用锥型内螺纹 Taper pipe threads for pressure-tight joints	**PT**	**Rc**

G-LIST No. | TH1147

一般用
GENERAL APPLICATION

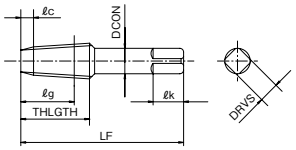
TPT

HSS

用于管材的锥形内螺纹加工。主要分长螺纹(TPT)和短螺纹(S—TPT)2种
PT：耐密用

This tap is used to process taper pipe internal threads. There are two types of these taps; Standard Thread Length (TPT) and Short Thread Length (S-TPT), which are used for processing short internal threads on joints.

PT : Taper pipe threads (for pressure-tight joints)



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23590	PT 1/16 - 28	JIS2	2.5P	55	18	10.1	8	4	●	19
23591	PT 1/8 - 28			55	19	13	8		●	22
23592	PT 1/4 - 19			62	28	21	11		●	47
23593	PT 3/8 - 19			65	28	21	14		●	68
23594	PT 1/2 - 14			80	35	25	18		●	133
23595	PT 5/8 - 14			82	35	25	19		●	159
23596	PT 3/4 - 14			85	35	25	23		●	233
23597	PT 7/8 - 14			90	40	28	24		●	292
23598	PT 1 - 11			95	45	32	26		●	347
23599	PT 1 1/8 - 11			100	45	32	28	6	●	495

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23600	PT 1 1/4 - 11	JIS2	2.5P	105	45	32	32	6	●	656
23601	PT 1 3/8 - 11			110	45	32	35		●	815
23602	PT 1 1/2 - 11			110	45	32	38		●	915
23603	PT 1 3/4 - 11			115	45	32	42		●	1,180
23604	PT 2 - 11			120	50	35	46		●	1,515
23606	PT 2 1/2 - 11			145	65	50	55	8	●	2,900
23607	PT 3 - 11			155	65	52	65		●	4,427
23608	PT 3 1/2 - 11			165	68	52	70	10	●	6,350
23609	PT 4 - 11			170	70	55	75		●	7,790

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：Rc 基准径位置符合ISO标准(JIS B 4446:1998) Standard diameter position is following ISO standard.

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8312700	Rc 1/16 - 28	2.5P	59	14	10.1	8	4	●	20
8312701	Rc 1/8 - 28		59	15	10.1	8		●	23
8312702	Rc 1/4 - 19		67	19	15	11		●	52
8312703	Rc 3/8 - 19		75	21	15.4	14		●	79

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 螺纹部精度相当于 JIS B0203。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8312704	Rc 1/2 - 14	2.5P	87	26	20.5	18	4	●	151
8312706	Rc 3/4 - 14		96	28	21.8	23		●	273
8312708	Rc 1 - 11		109	33	26	26		●	413

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Thread limit according to JIS B0203
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
TPT		○	○								○	○	○	○	○	○		○	○	○	○					

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1147

一般用(左螺纹)

GENERAL APPLICATION (LH)

TPT

HSS

螺纹种类：PT(Rc)

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23911	PT 1/8 - 28	JIS2	2.5P	55	19	13	8	4	●	23
23912	PT 1/4 - 19			62	28	21	11		●	47
23913	PT 3/8 - 19			65	28	21	14		●	68

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23914	PT 1/2 - 14	JIS2	2.5P	80	35	25	18	4	●	135
23916	PT 3/4 - 14			85	35	25	23		●	232
23918	PT 1 - 11			95	45	32	26		●	347

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

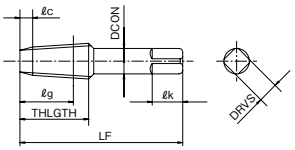
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1131

一般用短螺纹

GENERAL APPLICATION (SHORT THREAD)

S-TPT



HSS

螺纹种类：PT(Rc)

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23640	PT 1/16 - 28	JIS2	2.5P	55	16.5	8.6	8	4	●	19
23641	PT 1/8 - 28			55	16.5	10.5	8		●	23
23642	PT 1/4 - 19			62	19.5	12.5	11		●	50
23643	PT 3/8 - 19			65	21	14	14		●	72
23644	PT 1/2 - 14			80	27	17	18		●	142
23646	PT 3/4 - 14			85	29	19	23		●	242

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23648	PT 1 - 11	JIS2	2.5P	95	35	22	26	4	●	364
23650	PT 1 1/4 - 11			105	37.5	24.5	32	6	●	657
23652	PT 1 1/2 - 11			110	38.5	25.5	38		●	922
23654	PT 2 - 11			120	42.5	27.5	46		●	1,508
23655	PT 2 1/2 - 11			145	47	32	55	8	●	2,858
23656	PT 3 - 11			155	47	34	65		●	4,060

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
TPT		○	○								○	○	○	○	○	○		○	○	○	○				
S-TPT		○	○								○	○	○	○	○	○		○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

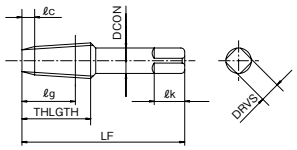
G-LIST No. | TH1112

一般用氧化处理

GENERAL APPLICATION (WITH OX)

H-TPT

HSS | H



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8307700	PT 1/16 - 28	JIS2	2.5P	55	18	10.1	8	4	●	18
8307701	PT 1/8 - 28			55	19	13	8		●	22
8307702	PT 1/4 - 19			62	28	21	11		●	47
8307703	PT 3/8 - 19			65	28	21	14		●	68
8307704	PT 1/2 - 14			80	35	25	18		●	135
8307705	PT 5/8 - 14			82	35	25	19		▲	160
8307706	PT 3/4 - 14			85	35	25	23		▲	232

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。
▲ = 该产品已停止生产，由 A-TPT(P.767)、TPT(P.769) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8307707	PT 7/8 - 14	JIS2	2.5P	90	40	28	24	4	▲	290
8307708	PT 1 - 11			95	45	32	26		▲	351
8307709	PT 1 1/8 - 11			100	45	32	28	6	▲	502
8307710	PT 1 1/4 - 11			105	45	32	32		▲	659
8307711	PT 1 3/8 - 11			110	45	32	35		▲	783
8307712	PT 1 1/2 - 11			110	45	32	38		▲	936

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.
▲= The products have been stopped producing and replaced by A-TPT (p.767) and TPT (p.769).

G-LIST No. | TH1111

一般用短螺纹氧化处理

GENERAL APPLICATION (WITH OX, SHORT THREAD)

H-S-TPT

HSS | H

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8307720	PT 1/16 - 28	JIS2	2.5P	55	16.5	8.6	8	4	●	19
8307721	PT 1/8 - 28			55	16.5	10.5	8		●	23
8307722	PT 1/4 - 19			62	19.5	12.5	11		●	49
8307723	PT 3/8 - 19			65	21	14	14		●	71
8307724	PT 1/2 - 14			80	27	17	18		●	141

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。
▲ = 该产品已停止生产，由 A-S-TPT(P.768)、S-TPT(P.770) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8307726	PT 3/4 - 14	JIS2	2.5P	85	29	19	23	4	▲	241
8307728	PT 1 - 11			95	35	22	26		▲	364
8307730	PT 1 1/4 - 11			105	37.5	24.5	32	6	▲	659
8307732	PT 1 1/2 - 11			110	38.5	25.5	38		▲	918

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.
▲= The products have been stopped producing and replaced by A-S-TPT (p.768) and S-TPT (p.770).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
H-TPT	◎	○		○					○		○			○											
H-S-TPT	◎	○		○					○		○			○											

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

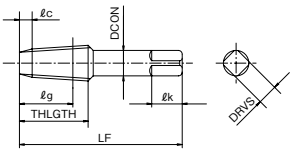
■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1071

一般用 长柄型

LONG SHANK・GENERAL APPLICATION

LT-TPT



HSS

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13559				100					●	42
13560	PT 1/8 - 28			120	19	13	8		●	51
13561		JIS2	2.5P	150				4	●	61
13564				100					●	79
13565	PT 1/4 - 19			120	28	21	11		●	87
13566				150					●	112

■突顶尖长・柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13569				100					●	114
13570	PT 3/8 - 19			120	28	21	14		●	138
13571		JIS2	2.5P	150				4	●	181
13575	PT 1/2 - 14			150	35	25	18		●	282
13583	PT 3/4 - 14			150	35	25	23		●	453
13591	PT 1 - 11			150	45	32	26		●	598

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1151

一般用短螺纹 长柄型

LONG SHANK・GENERAL APPLICATION (SHORT THREAD)

LT-S-TPT

HSS

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13610				100					●	41
13611	PT 1/8 - 28			120	16.5	10.5	8		●	50
13612		JIS2	2.5P	150				4	●	62
13615				100					●	81
13616	PT 1/4 - 19			120	19.5	12.5	11		●	90
13617				150					●	115

■突顶尖长・柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13620				100					●	116
13621	PT 3/8 - 19			120	21	14	14		●	142
13622		JIS2	2.5P	150				4	●	185
13625	PT 1/2 - 14			150	27	17	18		●	286
13635	PT 3/4 - 14			150	29	19	23		●	462
13645	PT 1 - 11			150	35	22	26		●	603

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
LT-TPT		○	○								○	○	○		○	○	○	○	○	○	○				
LT-S-TPT		○	○								○	○	○		○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1017

螺旋槽丝锥

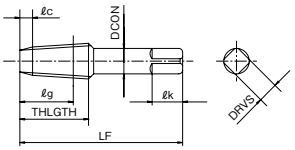
SPIRAL FLUTED

SFT-TPT

HSS | 30°

适用于盲孔加工或切屑易堵塞的材料的加工。

For taper pipe thread, suitable for blind hole where tends to have chip packing problem.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13750	PT 1/8 - 28	JIS2	2.5P	55	19	13	8	3	●	22
13751	PT 1/4 - 19			62	28	21	11		●	45
13752	PT 3/8 - 19			65	28	21	14	4	●	67
13753	PT 1/2 - 14			80	35	25	18		●	130
13755	PT 3/4 - 14			85	35	25	23		●	228
13757	PT 1 - 11			95	45	32	26		●	347
13758	PT 1 1/4 - 11			105	45	32	32		▲	632
13760	PT 1 1/2 - 11			110	45	32	38		▲	868

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由 TPT(P.769) 替代。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by TPT(p.769).

G-LIST No. | TH1016

螺旋槽丝锥短螺纹

SPIRAL FLUTED (SHORT THREAD)

SFT-S-TPT

HSS | 30°

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13771	PT 1/8 - 28	JIS2	2.5P	55	16.5	10.5	8	3	●	22
13772	PT 1/4 - 19			62	19.5	12.5	11	4	●	48
13773	PT 3/8 - 19			65	21	14	14		●	69
13774	PT 1/2 - 14			80	27	17	18		●	136
13776	PT 3/4 - 14			85	29	19	23		●	234
13778	PT 1 - 11			95	35	22	26		●	362

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC SUS	35~45 HRC SKD	45~50 HRC SC	50~60 HRC FC	不锈钢 Stainless Steel FCD	工具钢 Tool Steel Cu	铸钢 Cast Steel Bs	铸铁 Cast Iron BsC	球墨铸铁 Ductile Cast Iron PB	铜 Copper AL	黄铜 Brass AC,ADC	黄铜铸件 Brass Casting MC	青铜 Bronze ZDC	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
SFT-TPT		○		○							○									○						
SFT-S-TPT		○		○							○									○						

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

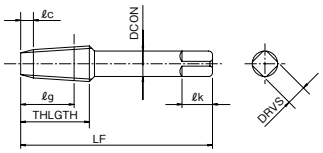
G-LIST No. | TH1158

螺旋槽丝锥 长柄型

LONG SHANK · SPIRAL FLUTED

LT-SFT-TPT

HSS　30°



螺纹种类：PT(Rc)

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309704				100					●	40
8309705	PT 1/8 -28			120	19	13	8	3	▲	51
8309706		JIS2	2.5P	150					●	62
8309708				100					●	76
8309709	PT 1/4 -19			120	28	21	11	4	▲	85
8309710				150					●	111

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309713				100					●	112
8309714	PT 3/8 -19			120	28	21	14		▲	136
8309715		JIS2	2.5P	150				4	●	177
8309719	PT 1/2 -14			150	35	25	18		●	273
8309727	PT 3/4 -14			150	35	25	23		▲	450
8309735	PT 1 -11			150	45	32	26		▲	600

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。
▲＝该产品已停止生产，由A-TPT(P.767)，LT-TPT(P.772)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.
▲＝The products have been stopped producing and replaced by A-TPT(p.767) and LT-TPT(p.772).

G-LIST No. | TH1157

螺旋槽丝锥 长柄短螺纹型

LONG SHANK · SPIRAL FLUTED (SHORT THREAD)

LT-SFT-S-TPT

HSS　30°

螺纹种类：PT(Rc)

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309754				100					●	40
8309755	PT 1/8 -28			120	16.5	10.5	8	3	▲	50
8309756		JIS2	2.5P	150					●	62
8309758				100					●	79
8309759	PT 1/4 -19			120	19.5	12.5	11	4	▲	89
8309760				150					●	113

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309763				100					●	116
8309764	PT 3/8 -19			120	21	14	14		▲	138
8309765		JIS2	2.5P	150				4	●	182
8309769	PT 1/2 -14			150	27	17	18		●	281
8309777	PT 3/4 -14			150	29	19	23		▲	456
8309785	PT 1 -11			150	35	22	26		▲	597

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。
▲＝该产品已停止生产，由A-S-TPT(P.768)，LT-S-TPT(P.772)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.
▲＝The products have been stopped producing and replaced by A-S-TPT(p.768) and LT-S-TPT(p.772).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
LT-SFT-TPT		○		○							○									○						
LT-SFT-S-TPT		○		○							○									○						

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。　See p.1 for explanation of icons.

G-LIST No. | TH1155

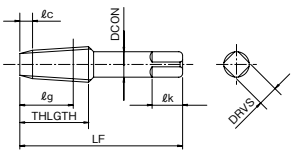
V涂层粉末高速钢 (高硬度钢用)

FOR HARDENED STEELS (42~52 HRC)

V-XPM-TPT

切削条件 Cutting Conditions | P.843

XPM V



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8313801	PT 1/8 - 28	JIS2	3P	59	19	13	8	5	●	24
8313802	PT 1/4 - 19			67	28	21	11		●	50
8313803	PT 3/8 - 19			75	28	21	14		●	79

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8313804	PT 1/2 - 14	JIS2	3P	87	35	25	18	5	●	150
8313806	PT 3/4 - 14			96	35	25	23		●	275
8313808	PT 1 - 11			109	45	32	26		●	418

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel			不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
V-XPM-TPT						○※1	◎																		

※1 推荐40HRC以上 ※1 We recommend 40HRC and over the tapping process by V-XPM-TPT.

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TW1012

V涂层硬质合金（高硬度钢用）

CARBIDE TAPER PIPE THREADS FOR HARDENED STEEL

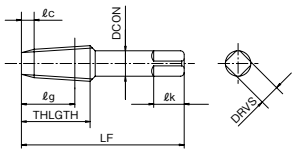
VX-TPT

切削条件 Cutting Conditions | P.843

最适合用于50HRC-60HRC以上的淬火钢(合金钢、高速钢、工具钢)

Most suitable for tapping hardened steels with hardness 50HRC~60HRC (alloy steels, die steels, tool steels, etc).

CARBIDE | V



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8330692	PT 1/8 - 28	JIS2	3P	59	19	13	8	5	●	42
8330693	PT 1/4 - 19			67	28	21	11		●	90

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。

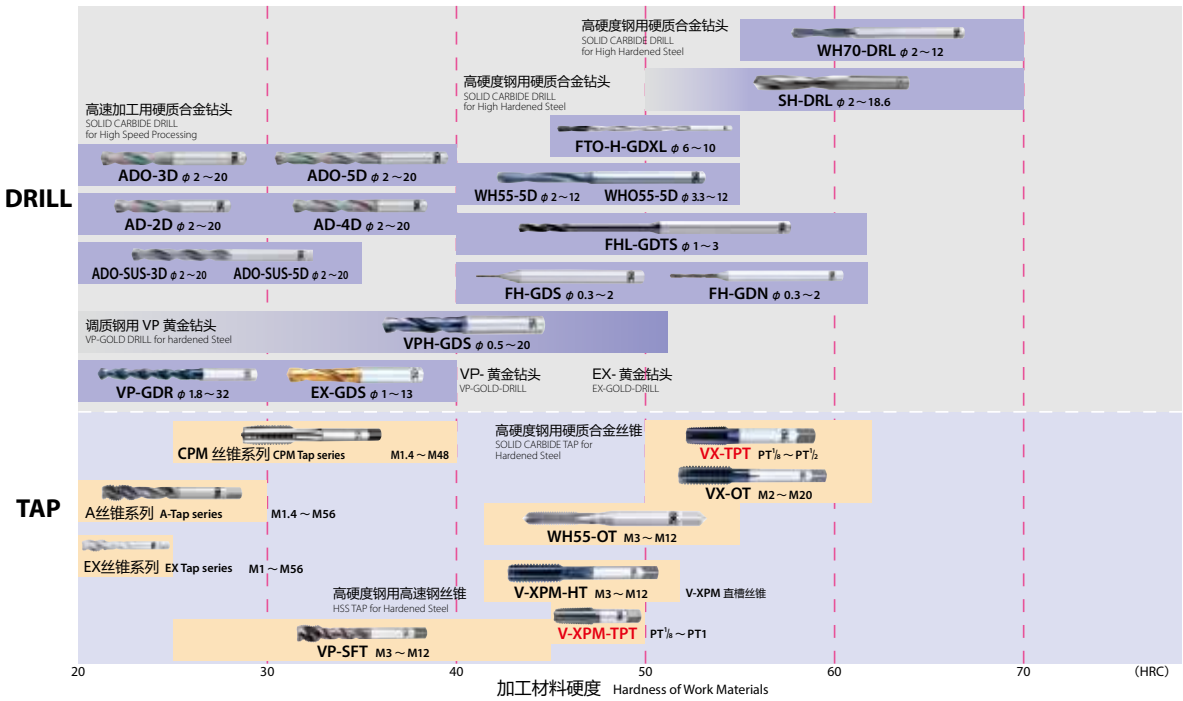
商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8330694	PT 3/8 - 19	JIS2	3P	75	28	21	14	6	●	150
8330695	PT 1/2 - 14			87	35	25	18		●	281

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.

1.使用VX-TPT时，一定要注意切削速度和切削油剂的选定。不宜使用攻丝油膏。
2.手动攻丝可能会引起切屑的卷入造成崩刀。不宜使用手动攻丝。
1.Make sure to select the correct cutting speed and cutting fluids. Tapping paste is not recommended.
2.The VX-TPT is designed for machine use only. Tapping by hand will cause chips to get stuck between the tool and the work material, and result in chipping of the taps.

■孔加工工具选择基准 Tool Guide for Hole Processing



※用油性切削液使用钻头时，请将基准切削速度降低 20%。When using non-water soluble oil, reduce the drilling speed by 20% of the recommended value.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
VX-TPT								◎																	

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

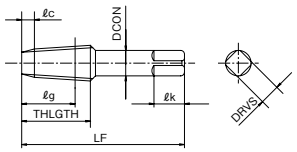
G-LIST No. | TH1077

TiN涂层
TiN COATED

TIN-TPT

HSSE | TiN

采用了耐溶着性，耐磨性良好的 TiN 涂层。
TiN coating provides superior welding and wear resistance.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23461	PT 1/8 -28	JIS2	2.5P	55	19	13	8	4	●	23
23462	PT 1/4 -19			62	28	21	11		●	47
23463	PT 3/8 -19			65	28	21	14		●	67
23464	PT 1/2 -14			80	35	25	18		●	133
23466	PT 3/4 -14			85	35	25	23		●	232
23468	PT 1 -11			95	45	32	26		●	357

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1076

TiN涂层短螺纹型
TiN COATED (SHORT THREAD)

TIN-S-TPT

HSSE | TiN

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23471	PT 1/8 - 28	JIS2	2.5P	55	16.5	10.5	8	4	●	23
23472	PT 1/4 - 19			62	19.5	12.5	11		●	50
23473	PT 3/8 - 19			65	21	14	14		●	72
23474	PT 1/2 - 14			80	27	17	18		●	140
23476	PT 3/4 - 14			85	29	19	23		●	239
23478	PT 1 - 11			95	35	22	26		●	367

■突顶尖长 · 柄部四方部尺寸 ℓk，DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
TIN-TPT	○	◎	◎	◎	○										○	○	○	○	○	○	○				
TIN-S-TPT	○	◎	◎	◎	○										○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

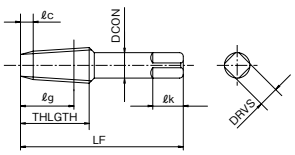
G-LIST No. | TH1107

TiN涂层长柄型

TiN COATED • LONG SHANK

TIN-LT-TPT

HSSE | TiN



螺纹种类：PT(Rc)

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309304	PT 1/8 - 28	JIS2	2.5P	100	19	13	8	4	●	41
8309305				120					●	50
8309306				150					●	62
8309308	PT 1/4 - 19			100	28	21	11		●	78
8309309				120					●	87
8309310				150					●	112

■突顶尖长·柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

▲=该产品已停止生产，由A-TPT(P.767)，LT-TPT(P.772)替代。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309313	PT 3/8 - 19	JIS2	2.5P	100	28	21	14	4	●	114
8309314				120					●	139
8309315				150					●	178
8309319	PT 1/2 - 14			150	35	25	18		●	276
8309327	PT 3/4 - 14			150	35	25	23		▲	454
8309335	PT 1 - 11			150	45	32	26		▲	590

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by A-TPT(p.767) and LT-TPT(p.772).

G-LIST No. | TH1104

TiN涂层短螺纹 长柄型

TiN COATED • LONG SHANK (SHORT THREAD)

TIN-LT-S-TPT

HSSE | TiN

螺纹种类：PT(Rc)

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309354	PT 1/8 - 28	JIS2	2.5P	100	16.5	10.5	8	4	●	41
8309355				120					●	50
8309358	PT 1/4 - 19			100	19.5	12.5	11		●	81
8309359				120					●	89
8309363	PT 3/8 - 19			100	21	14	14		●	117

■突顶尖长·柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

▲=该产品已停止生产，由A-S-TPT(P.768)，LT-S-TPT(P.772)替代。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309364	PT 3/8 - 19	JIS2	2.5P	120	21	14	14	4	●	140
8309369	PT 1/2 - 14			150	27	17	18		●	283
8309377	PT 3/4 - 14			150	29	19	23		▲	464
8309385	PT 1 - 11			150	35	22	26		▲	604

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by A-S-TPT(p.768) and LT-S-TPT(p.772).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
TIN-LT-TPT	○	◎	◎	◎	○										○	○	○	○	○	○	○				
TIN-LT-S-TPT	○	◎	◎	◎	○										○	○	○	○	○	○	○				

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

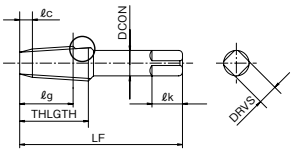
■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1092

难加工材料用
FOR DIFFICULT TO MACHINE MATERIALS

CPM-TPT

CPM



螺纹种类：PT(Rc)

单位:mm Unit:mm

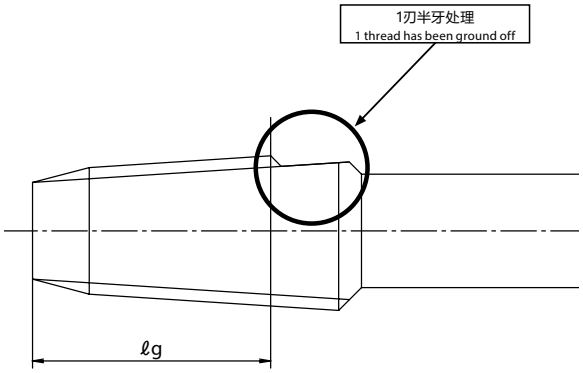
商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309102	**PT 1/8 - 28**	JIS2	2.5P	55	19	13	8	4	●	23
8309103	**PT 1/4 - 19**			62	28	21	11		●	48
8309104	**PT 3/8 - 19**			65	28	21	14		●	69
8309105	**PT 1/2 - 14**			80	35	25	18		●	136
8309106	**PT 3/4 - 14**			85	35	25	23		●	237
8309108	**PT 1 - 11**			95	45	32	26		●	356

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 基准径位置(ℓg)后1刃进行半牙处理。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Threads on one of cutting edges has been ground off from the ℓg.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.



加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
CPM-TPT			◎			○				○		◎	○						○			○	○			

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

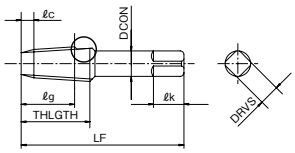
G-LIST No. | TH1170

难加工材料用短螺纹型

FOR DIFFICULT TO MACHINE MATERIALS (SHORT THREAD)

CPM-S-TPT

CPM



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309121	PT 1/8 - 28	JIS2	2.5P	55	16.5	10.5	8	4	●	23
8309122	PT 1/4 - 19			62	19.5	12.5	11		●	51
8309123	PT 3/8 - 19			65	21	14	14		●	71

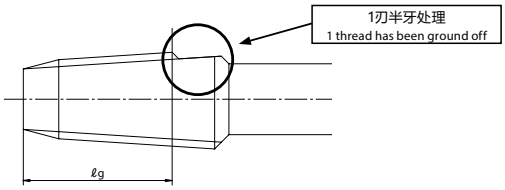
■突顶尖长·柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 基准径位置(ℓg)后1刃进行半牙处理
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309124	PT 1/2 - 14	JIS2	2.5P	80	27	17	18	4	●	143
8309126	PT 3/4 - 14			85	29	19	23		●	246
8309128	PT 1 - 11			95	35	22	26		●	370

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Threads on one of cutting edges has been ground off from the ℓg.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.



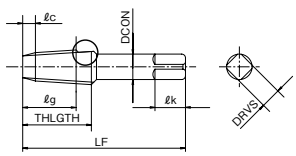
G-LIST No. | TH1171

难加工材料用短螺纹 长柄型

LONG SHANK · FOR DIFFICULT TO MACHINE MATERIALS (SHORT THREAD)

CPM-LT-S-TPT

CPM



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309455	PT 1/8 - 28	JIS2	2.5P	120	16.5	10.5	8	4	●	51
8309459	PT 1/4 - 19			120	19.5	12.5	11		●	92
8309464	PT 3/8 - 19			120	21	14	14		●	145

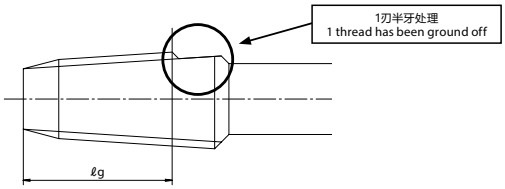
■突顶尖长·柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 基准径位置(ℓg)后1刃进行半牙处理
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309469	PT 1/2 - 14	JIS2	2.5P	150	27	17	18	4	●	290
8309477	PT 3/4 - 14			150	29	19	23		●	469
8309485	PT 1 - 11			150	35	22	26		●	618

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Threads on one of cutting edges has been ground off from the ℓg.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.



加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
CPM-S-TPT			◎			○				○		◎	○						○			○	○		
CPM-LT-S-TPT			◎			○				○		◎	○						○			○	○		

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

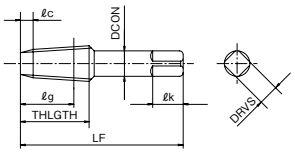
G-LIST No. | TH1018

软钢用
FOR MILD STEELS

STL-TPT

HSS | H

适用于低碳素钢、一般软钢等。
Suitable for low carbon steel, general soft steel, and the like.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23941	PT 1/8 -28	JIS2	2.5P	55	19	13	8	4	●	22
23942	PT 1/4 -19			62	28	21	11		●	48
23943	PT 3/8 -19			65	28	21	14		●	69
23944	PT 1/2 -14			80	35	25	18		●	135
23946	PT 3/4 -14			85	35	25	23		●	231
23948	PT 1 -11			95	45	32	26		●	345

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1103

软钢用短螺纹型
FOR MILD STEELS (SHORT THREAD)

STL-S-TPT

HSS | H

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23981	PT 1/8 -28	JIS2	2.5P	55	16.5	10.5	8	4	●	23
23982	PT 1/4 -19			62	19.5	12.5	11		●	50
23983	PT 3/8 -19			65	21	14	14		●	73
23984	PT 1/2 -14			80	27	17	18		●	140
23986	PT 3/4 -14			85	29	19	23		●	234
23988	PT 1 -11			95	35	22	26		●	356

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
STL-TPT	◎	○		○																					○
STL-S-TPT	◎	○		○																					○

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1026

内冷油孔型

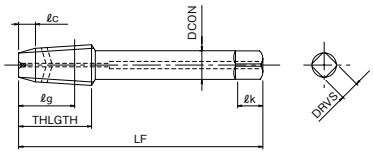
WITH INTERNAL COOLANT SUPPLY

OIL-TPT

HSS | H

使用于卧式深孔的螺纹加工，由于带有油孔可使切削油渗入丝锥头部，使高速，高精度螺纹切削变为可能。

Effective for tapping horizontal pipe thread and deep holes. High precision tapping is possible because cutting fluid is sufficiently supplied to the cutting area through coolant hole.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
10662	PT 1/8 -28	JIS2	2.5P	120	19	13	8	4	△	47
10663				150					△	59
10667	PT 1/4 -19			120	28	21	11		△	84
10668				150					△	109
10672	PT 3/8 -19			120	28	21	14		△	132
10673	PT 3/8 -19	JIS2	2.5P	150	28	21	14	4	△	171
10677	PT 1/2 -14			150	35	25	18		△	267
10681	PT 3/4 -14			150	35	25	23		△	433
10684	PT 1 -11			150	45	32	26		△	576

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 每槽各有一个油孔。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Each flute has its own oil hole.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1149

铝合金用

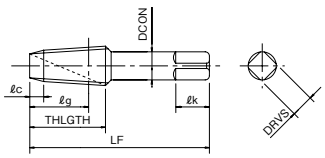
FOR ALUMINUM ALLOY

V-AL-TPT

HSSE | V | 15°

适用于易产生内螺纹烂牙的铝合金的锥管内螺纹加工。

It is the best for processing of the taper pipe thread of the aluminum.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8313701	PT 1/8 - 28	JIS2	2.5P	55	19	13	8	4	●	22
8313702	PT 1/4 - 19			62	28	21	11		●	46
8313703	PT 3/8 - 19			65	28	21	14		●	68
8313704	PT 1/2 - 14	JIS2	2.5P	80	35	25	18	4	●	134
8313706	PT 3/4 - 14			85	35	25	23		●	231
8313708	PT 1 - 11			95	45	32	26		●	349

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OIL-TPT	○	◎	○	◎						○	○	○	○	○	○	○	○				○				
V-AL-TPT														○				◎	◎						

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

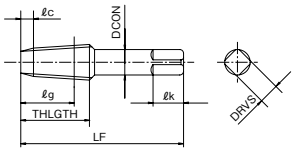
G-LIST No. | TH1003

铸铁用
FOR CAST IRON

EX-FC-TPT

HSSE | N

适用于各种铸铁的加工。
Suitable for tapping materials such as grey cast iron, nodular cast iron, malleable cast iron and brass castings.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23861	**PT 1/8 - 28**	JIS2	2.5P	55	19	13	8	4	●	23
23862	**PT 1/4 - 19**			62	28	21	11		●	48
23863	**PT 3/8 - 19**			65	28	21	14		●	69
23864	**PT 1/2 - 14**			80	35	25	18		●	135
23866	**PT 3/4 - 14**			85	35	25	23		▲	233
23868	**PT 1 - 11**			95	45	32	26		▲	354

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。
▲=该产品已停止生产，由TPT(P.769)，CPM-TPT(P.779)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.
▲= The products have been stopped producing and replaced by TPT(p.769) and CPM-TPT(p.779).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-FC-TPT												◎	◎		◎	◎	○		○	◎	○				○	

库存记号 Inventory symbols
●=标准库存品 Standard stock item
○=准标准库存品(请确认库存。) Limited standard stock item
▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

1982年，由于ISO的导入，JIS管用螺纹规格得到了修改，螺纹的记号也得到了修改，但是由于螺纹的精度没有改变，因此我司丝锥的记号仍使用旧记号。

The JIS pipe thread standard was revised in 1982 to meet ISO standards. Although thread symbols changed, the limits were not changed. Therefore, it is still acceptable to use the older symbols.

(JIS B0203-1982)

种　类 Type	旧记号 Previous Symbol	新记号 New Symbol
密封用锥型内螺纹 Taper pipe threads for pressure-tight joints	**PT**	**Rc**

G-LIST No. | TW1001

硬质合金锥管螺纹丝锥

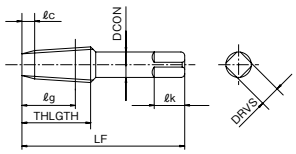
CARBIDE FOR TAPER PIPE THREADS

OT-TPT

CARBIDE

适用于普通铸铁、强韧铸铁、热硬化性树脂、黄铜铸铁、铝合金铸物的大批量高精度加工。

Suitable for high production with high precision in automatic machines. This tap is ideal for tapping materials such as ordinary cast iron, ductile cast iron, thermosetting plastics, brass castings and aluminum castings.



螺纹种类：PT(Rc)

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23402	**PT 1/8 - 28**	JIS2	2.5P	55	19	13	8	4	●	37
23403	**PT 1/4 - 19**			62	28	21	11		●	77
◆ 23404	**PT 3/8 - 19**			65	28	21	14		●	70
◆ 23405	**PT 1/2 - 14**			80	35	25	18		●	139
◆ 23407	**PT 3/4 - 14**			85	35	25	23		△	242
◆ 23409	**PT 1 - 11**			95	45	32	26		△	404

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. ◆为焊接型。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. ◆ / symbol indicates carbide brazed type.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TW1004

硬质合金锥管螺纹丝锥短螺纹型

CARBIDE FOR TAPER PIPE THREADS (SHORT THREAD)

OT-S-TPT

CARBIDE

螺纹种类：PT(Rc)

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23382	**PT 1/8 - 28**	JIS2	2.5P	55	16.5	10.5	8	4	●	38
23383	**PT 1/4 - 19**			62	19.5	12.5	11		●	81
◆ 23384	**PT 3/8 - 19**			65	21	14	14		●	73
◆ 23385	**PT 1/2 - 14**			80	27	17	18		●	144
◆ 23387	**PT 3/4 - 14**			85	29	19	23		△	246
◆ 23389	**PT 1 - 11**			95	35	22	26		△	379

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. ◆为焊接型。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. ◆ / symbol indicates carbide brazed type.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OT-TPT												◎	○		○	○	◎		◎	○	◎			◎	
OT-S-TPT												◎	○		○	○	◎		◎	○	◎			◎	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。　See p.1 for explanation of icons.

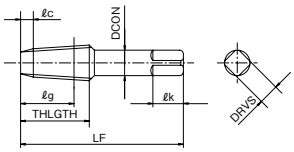
G-LIST No. | TW1007

硬质合金锥管螺纹丝锥 长柄型

CARBIDE LONG SHANK · FOR TAPER PIPE THREADS

OT-LT-TPT

CARBIDE



螺纹种类：PT(Rc)

单位:mm Unit:mm

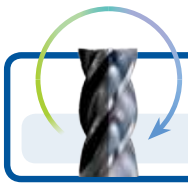
	商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
	22772	PT 1/8 - 28	JIS2	2.5P	100	19	13	8	4	●	70
	22774				150					●	105
	22775	PT 1/4 - 19			100	28	21	11		●	129
	22777				150					●	192
◆	22778	PT 3/8 - 19			100	28	21	14		●	115
◆	22780	PT 3/8 - 19	JIS2	2.5P	150	28	21	14	4	●	181
◆	22782	PT 1/2 - 14			150	35	25	18		●	282
◆	22788	PT 3/4 - 14			150	35	25	23		△	462
◆	22791	PT 1 - 11			150	45	32	26		△	628

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. ◆为焊接型。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. ◆ / symbol indicates carbide brazed type.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.



再研磨 · 再涂层

可一次性接受。实现和新品一样的性能。

※详情请参照 ▶P.9
See p.9 for details

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OT-LT-TPT												◎	○		○	○	◎		◎	○	◎			◎	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

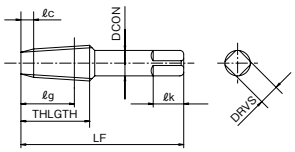
G-LIST No. | TH1008

不锈钢用
FOR STAINLESS STEELS

EX-SUS-TPT

HSSE | H | 15°

适用于不锈钢等难加工材料
Suitable for tapping stainless steels and difficult to machine materials.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23921	PT 1/8 -28	JIS2	2.5P	55	19	13	8	4	●	22
23922	PT 1/4 -19			62	28	21	11		●	46
23923	PT 3/8 -19			65	28	21	14		●	67
23924	PT 1/2 -14			80	35	25	18		●	134
23926	PT 3/4 -14			85	35	25	23	4	●	231
23928	PT 1 -11			95	45	32	26		●	356
23929	PT 1 1/4 -11			105	45	32	32	5	△	586
23931	PT 1 1/2 -11			110	45	32	38		△	835

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1050

不锈钢用短螺纹型
FOR STAINLESS STEELS (SHORT THREAD)

EX-SUS-S-TPT

HSSE | H | 15°

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23991	PT 1/8 - 28	JIS2	2.5P	55	16.5	10.5	8	4	●	23
23992	PT 1/4 - 19			62	19.5	12.5	11		●	50
23993	PT 3/8 - 19			65	21	14	14		●	71
23994	PT 1/2 - 14	JIS2	2.5P	80	27	17	18	4	●	139
23996	PT 3/4 - 14			85	29	19	23		●	237
23998	PT 1 - 11			95	35	22	26		●	364

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-SUS-TPT									◎					○											○
EX-SUS-S-TPT									◎					○											○

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

○ = 准标准库存品(请确认库存。)
Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

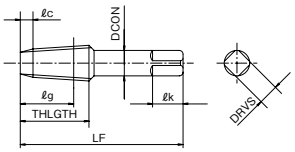
G-LIST No. | TH1099

不锈钢用 长柄型

LONG SHANK · FOR STAINLESS STEELS

LT-SUS-TPT

HSSE | H | 15°



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309204	PT 1/8 - 28	JIS2	2.5P	100	19	13	8	4	●	40
8309205				120					●	49
8309206				150					●	61
8309208	PT 1/4 - 19			100	28	21	11		●	78
8309209				120					●	86
8309210				150					●	111

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产，由 A-TPT(P.767) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309213	PT 3/8 - 19	JIS2	2.5P	100	28	21	14	4	●	112
8309214				120					●	137
8309215				150					●	179
8309219	PT 1/2 - 14			150	35	25	18		●	279
8309227	PT 3/4 - 14			150	35	25	23		▲	463
8309235	PT 1 - 11			150	45	32	26		▲	596

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-TPT (p.767).

G-LIST No. | TH1102

不锈钢用短螺纹 长柄型

LONG SHANK · FOR STAINLESS STEELS (SHORT THREAD)

LT-SUS-S-TPT

HSSE | H | 15°

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309254	PT 1/8 - 28	JIS2	2.5P	100	16.5	10.5	8	4	●	41
8309255				120					●	50
8309258	PT 1/4 - 19			100	19.5	12.5	11		●	79
8309259				120					●	88
8309263	PT 3/8 - 19			100	21	14	14		●	116

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产，由 A-S-TPT(P.768) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309264	PT 3/8 - 19	JIS2	2.5P	120	21	14	14	4	●	139
8309269	PT 1/2 - 14			150	27	17	18		●	286
8309277	PT 3/4 - 14			150	29	19	23		▲	464
8309285	PT 1 - 11			150	35	22	26		▲	604

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-S-TPT (p.768).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
LT-SUS-TPT									◎					○											△
LT-SUS-S-TPT									◎					○											△

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1117

不锈钢用螺旋槽丝锥

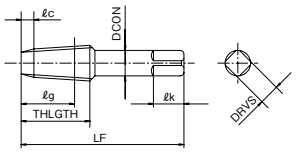
SPIRAL FLUTED · FOR STAINLESS STEELS

SUS-SFT-TPT

适用于不锈钢等难加工材料的盲孔加工。

Suitable for tapping stainless steels and difficult to machine materials.

HSSE | H | 30°



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309160	PT 1/16 - 28	JIS2	2.5P	55	18	10.1	8	3	●	18
8309161	PT 1/8 - 28			55	19	13	8		●	21
8309162	PT 1/4 - 19			62	28	21	11	4	●	45
8309163	PT 3/8 - 19			65	28	21	14		●	66

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产，由 A-TPT (P.767) 替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309164	PT 1/2 - 14	JIS2	2.5P	80	35	25	18	4	●	129
8309166	PT 3/4 - 14			85	35	25	23		▲	225
8309168	PT 1 - 11			95	45	32	26		▲	347

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲= The products have been stopped producing and replaced by A-TPT (p.767).

G-LIST No. | TH1116

不锈钢用螺旋槽丝锥短螺纹型

SPIRAL FLUTED · FOR STAINLESS STEELS (SHORT THREAD)

SUS-SFT-S-TPT

HSSE | H | 30°

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309180	PT 1/16 - 28	JIS2	2.5P	55	16.5	8.6	8	3	●	18
8309181	PT 1/8 - 28			55	16.5	10.5	8		●	22
8309182	PT 1/4 - 19			62	19.5	12.5	11	4	●	48
8309183	PT 3/8 - 19			65	21	14	14		●	70

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309184	PT 1/2 - 14	JIS2	2.5P	80	27	17	18	4	●	136
8309186	PT 3/4 - 14			85	29	19	23		●	235
8309188	PT 1 - 11			95	35	22	26		●	355

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
SUS-SFT-TPT									◎																
SUS-SFT-S-TPT									◎																

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

○ = 准标准库存品(请确认库存。)
Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1130

跳牙型
WITH INTERRUPTED THREADS

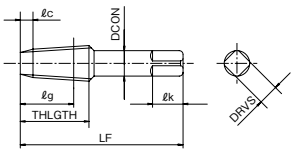
EX-IRT

HSSE | H | 8°

左螺旋
Reverse Flutes

适用于加工不锈钢、耐热合金这类易产生表面硬化层及易溶着的难加工材料。有长螺纹型(EX-IRT)和短螺纹型(EX-S-IRT) 2种类型。

Suitable for processing difficult to machine materials such as stainless steels and heat resistant alloy which has tendency to have workhardening and welding problem. There are two types of these taps; standard thread (EX-IRT) and short thread (EX-S-IRT).



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23711	PT 1/8 - 28	JIS2	2.5P	55	19	13	8	5	●	23
23712	PT 1/4 - 19			62	28	21	11		●	48
23713	PT 3/8 - 19			65	28	21	14		●	72
23714	PT 1/2 - 14			80	35	25	18		●	136
23715	PT 5/8 - 14			82	35	25	19		●	163
23716	PT 3/4 - 14			85	35	25	23		●	241
23717	PT 7/8 - 14			90	40	28	24		●	302
23718	PT 1 - 11			95	45	32	26	5	●	376
23720	PT 1 1/4 - 11			105	45	32	32		△	634
23722	PT 1 1/2 - 11			110	45	32	38	7	△	948
23724	PT 2 - 11			120	50	35	46		△	1,549
23725	PT 2 1/2 - 11			145	65	50	55		△	2,820
23726	PT 3 - 11			155	65	52	65		△	4,260

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1007

跳牙型短螺纹
WITH INTERRUPTED THREADS (SHORT THREAD)

EX-S-IRT

HSSE | H | 8°

左螺旋
Reverse Flutes

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23811	PT 1/8 -28	JIS2	2.5P	55	16.5	10.5	8	5	●	23
23812	PT 1/4 -19			62	19.5	12.5	11		●	51
23813	PT 3/8 -19			65	21	14	14		●	74
23814	PT 1/2 -14			80	27	17	18		●	143
23816	PT 3/4 -14			85	29	19	23		●	248
23818	PT 1 -11			95	35	22	26	5	●	382
23819	PT 1 1/4 -11			105	37.5	24.5	32		△	642
23821	PT 1 1/2 -11			110	38.5	25.5	38	7	△	928
23823	PT 2 -11			120	42.5	27.5	46		△	1,530

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
EX-IRT	○								◎			○													
EX-S-IRT	○								◎			○													

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1047

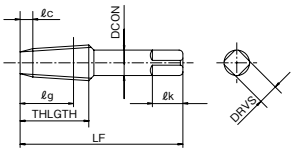
跳牙长柄型

LONG SHANK · WITH INTERRUPTED THREADS

EX-LT-IRT

HSSE | H | 8°

左螺旋
Reverse Flutes



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
15710	PT 1/8 - 28	JIS2	2.5P	120	19	13	8	5	●	51
15711				150					●	63
15715	PT 1/4 - 19			120	28	21	11		●	87
15716				150					●	113
15720	PT 3/8 - 19			120	28	21	14		●	140
15721	PT 3/8 - 19			150	28	21	14		●	181
15725	PT 1/2 - 14			150	35	25	18		●	280
15733	PT 3/4 - 14			150	35	25	23		●	460
15741	PT 1 - 11			150	45	32	26		●	613

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2 Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1048

跳牙短螺纹 长柄型

LONG SHANK · WITH INTERRUPTED THREADS (SHORT THREAD)

EX-LT-S-IRT

HSSE | H | 8°

左螺旋
Reverse Flutes

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
15760	PT 1/8 - 28	JIS2	2.5P	120	16.5	10.5	8	5	●	51
15761				150					●	63
15765	PT 1/4 - 19			120	19.5	12.5	11		●	89
15766				150					●	115
15770	PT 3/8 - 19			120	21	14	14		●	144
15771	PT 3/8 - 19			150	21	14	14		●	183
15775	PT 1/2 - 14			150	27	17	18		●	285
15783	PT 3/4 - 14			150	29	19	23		●	468
15791	PT 1 - 11			150	35	22	26		●	617

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-LT-IRT	○								◎			○													
EX-LT-S-IRT	○								◎			○													

库存记号 Inventory symbols

● = 标准库存品
Standard stock item

○ = 准标准库存品(请确认库存。)
Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1073

TiN涂层 跳牙型

TiN COATED · WITH INTERRUPTED THREADS

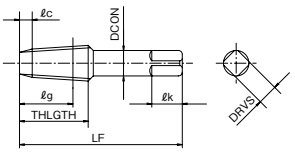
TIN-IRT

HSSE | TiN | 8°

左螺旋 Reverse Flutes

采用耐溶着性、耐磨损性优良的 TiN 涂层。

TiN coating provides superior welding and wear resistance.



螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23481	PT 1/8 - 28	JIS2	2.5P	55	19	13	8	5	●	23
23482	PT 1/4 - 19			62	28	21	11		●	49
23483	PT 3/8 - 19			65	28	21	14		●	72
23484	PT 1/2 - 14	JIS2	2.5P	80	35	25	18	5	●	137
23486	PT 3/4 - 14			85	35	25	23		●	241
23488	PT 1 - 11			95	45	32	26		●	374

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1075

TiN涂层 短螺纹跳牙型

TiN COATED · WITH INTERRUPTED THREADS (SHORT THREAD)

TIN-S-IRT

HSSE | TiN | 8°

左螺旋 Reverse Flutes

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23491	PT 1/8 - 28	JIS2	2.5P	55	16.5	10.5	8	5	●	24
23492	PT 1/4 - 19			62	19.5	12.5	11		●	51
23493	PT 3/8 - 19			65	21	14	14		●	73
23494	PT 1/2 - 14	JIS2	2.5P	80	27	17	18	5	●	144
23496	PT 3/4 - 14			85	29	19	23		●	248
23498	PT 1 - 11			95	35	22	26		●	386

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1106

TiN涂层 跳牙型短螺纹 长柄型

TiN COATED · LONG SHANK · WITH INTERRUPTED THREADS (SHORT THREAD)

TIN-LT-S-IRT

HSSE | TiN | 8°

左螺旋 Reverse Flutes

螺纹种类：PT(Rc)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309405	PT 1/8 -28	JIS2	2.5P	120	16.5	10.5	8	5	●	51
8309409	PT 1/4 -19			120	19.5	12.5	11		●	90
8309414	PT 3/8 -19			120	21	14	14		●	144
8309419	PT 1/2 -14	JIS2	2.5P	150	27	17	18	5	●	286
8309427	PT 3/4 -14			150	29	19	23		▲	470
8309435	PT 1 -11			150	35	22	26		▲	622

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。
▲ = 该产品已停止生产，由 A-S-TPT(P.768)，EX-LT-S-IRT(P.790)替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.
▲= The products have been stopped producing and replaced by A-S-TPT(p.768) and EX-LT-S-IRT(p.790).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
TIN-IRT	○	○			○				◎			○														
TIN-S-IRT	○	○			○				◎			○														
TIN-LT-S-IRT	○	○			○				◎			○														

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1325

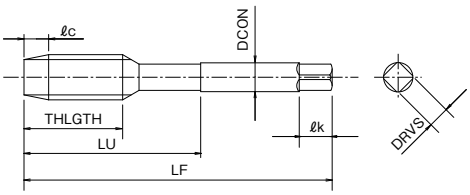
螺旋槽丝锥（平行管螺纹）

SPIRAL FLUTED TAP (PARALLEL PIPE THREAD)

The A Brand

A-SPT

切削条件 Cutting Conditions | P.838



HSSE | V | 45°

螺纹种类 :Rp　螺纹部精度符合ISO标准(JIS B 4446:1998) Thread tolerance is following ISO standard.　单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327701	Rp 1/16 - 28	2.5P	90	14	36	8	3	●	29
8327711		1.5P						●	29
8327702	Rp 1/8 - 28	2.5P	90	15	37	8		●	34
8327712		1.5P						●	34
8327703	Rp 1/4 - 19	2.5P	100	19	49	11		●	70
8327713		1.5P						●	71
8327704	Rp 3/8 - 19	2.5P	100	21	50	14	4	●	105
8327714		1.5P						●	105
8327705	Rp 1/2 - 14	2.5P	125	26	60	18		●	218
8327715		1.5P						●	215
8327707	Rp 3/4 - 14	2.5P	140	28	74	23		●	380
8327717		1.5P						●	380
8327709	Rp 1 - 11	2.5P	160	33	80	26		●	603
8327719		1.5P						●	593

・也可使用于旧记号的PS螺纹的加工。

■突顶尖长・柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

・Can also be used for machining threads with the old PS symbol.

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

■管螺纹的尺寸一览表 Pipe Thread Size Chart

A	6	8	10	15	20	25	32	40	50
B	1/8	1/4	3/8	1/2	3/4	1	1 1/4	1 1/2	2

1. 如果螺纹尺寸是A，就加上A的符号，如果是基于B，就在每个数字后面加上B的符号。无论哪个都仅表示螺纹尺寸，在选择丝锥时，请务必检查螺纹标准。

1. If the thread size is A, add the sign of A, and if it is based on B, add the sign of B after each number. Both of them only indicate the size of thread. Please make sure to check the thread standard when selecting a tap.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
A-SPT	◎	◎	◎	◎	◎				○	○	○		○	○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

1982年，由于ISO的导入，JIS管用螺纹规格得到了修改，螺纹的记号也得到了修改，但是由于螺纹的精度没有改变，因此我司丝锥的记号仍使用旧记号。

The JIS pipe thread standard was revised in 1982 to meet ISO standards. Although thread symbols changed, the limits were not changed. Therefore, it is still acceptable to use the older symbols.

(JIS B0203-1982)

种　类 Type	旧记号 Previous Symbol	新记号 New Symbol
密封用平行内螺纹 Parallel pipe threads for pressure-tight joints	**PS**	**Rp**

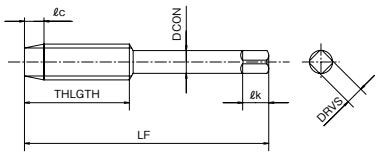
G-LIST No. | TH1146

一般用
GENERAL APPLICATION

SPT

用于加工锥管螺纹的平行内螺纹以及平行管螺纹的内螺纹。
PS：密封用

Used for tapping parallel pipe internal threads.
PS : Parallel pipe threads (for pressure-tight joints)



HSS

螺纹种类：PS(Rp)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23531	PS 1/8 - 28	JIS2	4P	55	19	8	4	●	23
23532	PS 1/4 - 19			62	28	11		●	48
23533	PS 3/8 - 19			65	28	14		●	69
23534	PS 1/2 - 14			80	35	18		●	135
23535	PS 5/8 - 14			82	35	19		●	162
23536	PS 3/4 - 14			85	35	23		●	232
23538	PS 1 - 11			95	45	26		●	357
23540	PS 1 1/4 - 11			105	45	32		●	606

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23542	PS 1 1/2 - 11	JIS2	4P	110	45	38	4	●	845
23543	PS 1 3/4 - 11			115	45	42	6	●	1,194
23544	PS 2 - 11			120	50	46		●	1,526
23546	PS 2 1/2 - 11			145	65	55		●	2,852
23547	PS 3 - 11			155	65	65		●	4,571
23548	PS 3 1/2 - 11			165	68	70	8	●	5,920
23549	PS 4 - 11			170	70	75		●	7,400

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：Rp　螺纹部精度符合ISO标准(JIS B 4446:1998)　Thread tolerance is following ISO standard.

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削推长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8312800	Rp 1/16 - 28	4P	59	14	8	4	●	20
8312801	Rp 1/8 - 28		59	15	8		●	24
8312802	Rp 1/4 - 19		67	19	11		●	52
8312803	Rp 3/8 - 19		75	21	14		●	84

・也可使用于旧记号的PS螺纹的加工。
■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 螺纹部精度相当于JIS B0203。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	切削推长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8312804	Rp 1/2 - 14	4P	87	26	18	4	●	154
8312806	Rp 3/4 - 14		96	28	23		●	275
8312808	Rp 1 - 11		109	33	26		●	412

・Can also be used for machining threads with the old PS symbol.
■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Thread limit according to JIS B0203
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
SPT		○									○	○	○		○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1146

一般用(左螺纹)

GENERAL APPLICATION (LH)

SPT

用于加工锥管螺纹的平行内螺纹以及平行管螺纹的内螺纹。
PS:密封用

Used for tapping parallel pipe internal threads.
PS : Parallel pipe threads (for pressure-tight joints)

HSS

螺纹种类：PS(Rp)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23881	PS 1/8 - 28	JIS2	4P	55	19	8	4	●	23
23882	PS 1/4 - 19			62	28	11		●	48
23883	PS 3/8 - 19			65	28	14		●	69
23884	PS 1/2 - 14			80	35	18		●	135
23886	PS 3/4 - 14			85	35	23		●	235
23888	PS 1 - 11			95	45	26		●	355

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

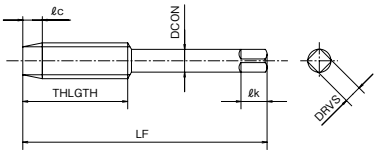
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1012

一般用 长柄型

LONG SHANK · GENERAL APPLICATION

LT-SPT



HSS

螺纹种类：PS(Rp)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13809	PS 1/8 - 28	JIS2	4P	120	19	8	4	●	51
13810				150				●	62
13814	PS 1/4 - 19			120	28	11		●	89
13815				150				●	115
13819	PS 3/8 - 19			120	28	14		●	140
13820	PS 3/8 - 19			150	28	14		●	180
13825	PS 1/2 - 14			150	35	18		●	281
13835	PS 3/4 - 14			150	35	23		●	460
13845	PS 1 - 11			150	45	26		●	598

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
SPT		○									○	○	○		○	○	○	○	○	○	○				
LT-SPT		○									○	○	○		○	○	○	○	○	○	○				

库存记号 Inventory symbols

●=标准库存品 Standard stock item

○=准标准库存品(请确认库存。) Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1015

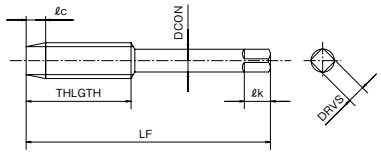
螺旋槽丝锥

SPIRAL FLUTED

SFT-SPT

根据工件形状，备有盲孔专用的螺旋槽型丝锥。
Use the spiral fluted version (SFT-SPT) for tapping blind holes.

HSS | 35°



螺纹种类：PS(Rp)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13731	PS 1/8 - 28	JIS2	2.5P	55	19	8	3	●	23
13732	PS 1/4 - 19			62	28	11		●	48
13733	PS 3/8 - 19			65	28	14		●	68
13734	PS 1/2 - 14			80	35	18	4	●	138
13736	PS 3/4 - 14			85	35	23	4	●	238
13738	PS 1 - 11			95	45	26		●	367
13739	PS 1 1/4 - 11			105	45	32		△	630
13741	PS 1 1/2 - 11			110	45	38		△	887

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1081

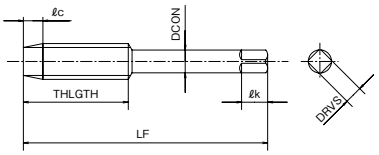
不锈钢用

FOR STAINLESS STEELS

EX-SUS-SPT

适用于不锈钢等难加工材料。
Suitable for tapping difficult to machine materials such as stainless steels.

HSSE | H



螺纹种类：PS(Rp)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23781	PS 1/8 - 28	JIS2	4P	55	19	8	4	●	23
23782	PS 1/4 - 19			62	28	11		●	80
23783	PS 3/8 - 19			65	28	14		●	69
23784	PS 1/2 - 14			80	35	18	4	●	134
23786	PS 3/4 - 14			85	35	23		●	232
23788	PS 1 - 11			95	45	26		●	370

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
SFT-SPT		◎		◎							◎		○	○	○	○	○	○	○	○	○				
EX-SUS-SPT									◎					○											○

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

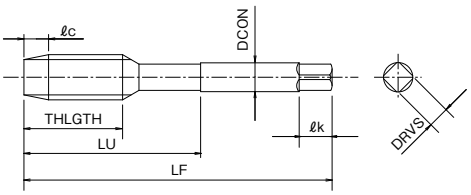
螺旋槽丝锥（平行管螺纹）

SPIRAL FLUTED TAP (PARALLEL PIPE THREAD)

The A Brand

A-SPT

切削条件 Cutting Conditions | P.837



HSSE | V | 45°

螺纹种类：G　螺纹部精度符合ISO标准(JIS B 4445:1998)　Thread tolerance is following ISO standard.

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327400	G 1/16 - 28	STD	OH3	2.5P	90	14	36	8	3	●	30
8327401	G 1/8 - 28				90	15	32	8		●	36
8327402	G 1/4 - 19				100	19	35	11		●	76
8327403	G 3/8 - 19				100	21	44	14	4	●	111
8327404	G 1/2 - 14		OH3.5		125	26	55	18		●	224
8327405	G 5/8 - 14				125	26	60	19		●	247
8327406	G 3/4 - 14				140	28	69	23		●	385
8327407	G 7/8 - 14				150	29	75	24		●	479
8327408	G 1 - 11		OH4		160	33	80	26		●	591

・也可使用于旧记号的PF螺纹的加工。

■突顶尖长・柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏　是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 不推荐再研磨。

・Can also be used for machining threads with the old PF symbol.

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. Tap limit does not guarantee thread limit for the internal thread after tapping.
3. Regrinding is not recommended.

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意

※ Stable feed control machines are recommended to avoid over size tapping.

■管螺纹的尺寸一览表 Pipe Thread Size Chart

A	6	8	10	15	20	25	32	40	50
B	1/8	1/4	3/8	1/2	3/4	1	1 1/4	1 1/2	2

1. 如果螺纹尺寸是A，就加上A的符号，如果是基于B，就在每个数字后面加上B的符号。无论哪个都仅表示螺纹尺寸，在选择丝锥时，请务必检查螺纹标准。

1. If the thread size is A, add the sign of A, and if it is based on B, add the sign of B after each number. Both of them only indicate the size of thread. Please make sure to check the thread standard when selecting a tap.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
A-SPT	◎	◎	◎	◎	◎				○	○	○		○	○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

1982年，由于ISO的导入，JIS管用螺纹规格得到了修改，螺纹的记号也得到了修改，但是由于螺纹的精度没有改变，因此我司丝锥的记号仍使用旧记号。

The JIS pipe thread standard was revised in 1982 to meet ISO standards. Although thread symbols changed, the limits were not changed. Therefore, it is still acceptable to use the older symbols.

(JIS B0202-1982)

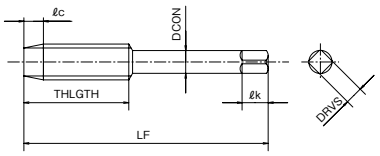
种　类 Type	旧记号 Previous Symbol	新记号 New Symbol
一般结合用平行内螺纹 Parallel pipe threads for mechanical joints	**PF**	**G**

G-LIST No. | TH1146

一般用
GENERAL APPLICATION

SPT

用于管用平行螺纹的内螺纹加工。
PF：一般结合用
Used for tapping parallel pipe internal threads.
PF : Parallel pipe threads (for mechanical joints)



HSS

螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23501	PF 1/8 -28	JIS2	4P	55	19	8	4	●	23
23951			1.5P					●	23
23502	PF 1/4 -19		4P	62	28	11		●	49
23952			1.5P					●	49
23503	PF 3/8 -19		4P	65	28	14		●	69
23953			1.5P					●	69
23504	PF 1/2 -14		4P	80	35	18		●	136
23954			1.5P					●	136
23505	PF 5/8 -14		4P	82	35	19		●	164
23506	PF 3/4 -14			85	35	23		●	233
23956			1.5P					●	235
23507	PF 7/8 -14		4P	90	40	24		●	290
23508	PF 1 -11			95	45	26		●	352

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23958	PF 1 -11	JIS2	1.5P	95	45	26	4	●	358
23509	PF 1 1/8 -11		4P	100	45	28		●	459
23510	PF 1 1/4 -11			105	45	32		●	612
23960			1.5P					●	608
23511	PF 1 3/8 -11		4P	110	45	35		●	697
23512	PF 1 1/2 -11			110	45	38		●	863
23962			1.5P					●	861
23513	PF 1 3/4 -11		4P	115	45	42	6	●	1,196
23514	PF 2 -11			120	50	46		●	1,530
23516	PF 2 1/2 -11			145	65	55		●	2,820
23517	PF 3 -11			155	65	65		●	4,300
23518	PF 3 1/2 -11			165	68	70	8	●	5,800
23519	PF 4 -11			170	70	75		●	7,400

■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：G　螺纹部精度符合ISO标准(JIS B 4445:1998) Thread tolerance is following ISO standard.

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8312850	G 1/16 - 28	4P	59	14	8	4	●	20
8312851	G 1/8 - 28		59	15	8		●	24
8312852	G 1/4 - 19		67	19	11		●	54
8312853	G 3/8 - 19		75	21	14		●	83
8312854	G 1/2 - 14		87	26	18		●	157

商品号 EDP No.	螺纹尺寸 Thread Size	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8312855	G 5/8 - 14	4P	91	26	19	4	●	183
8312856	G 3/4 - 14		96	28	23		●	276
8312857	G 7/8 - 14		102	29	24		●	326
8312858	G 1 - 11		109	33	26		●	420

・也可使用于旧记号的PF螺纹的加工。
■突顶尖长 · 柄部四方部尺寸ℓk，DRVS请参考P.1009。
1. 螺纹部精度相当于JIS B0202。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

・Can also be used for machining threads with the old PF symbol.
■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. Thread limit according to JIS B0202.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
SPT		○									○	○	○		○	○	○	○	○	○	○					

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1146

一般用(左螺纹)

GENERAL APPLICATION (LH)

SPT

HSS

螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23893	PF 1/8 - 28	JIS2	4P	55	19	8	4	●	23
23894	PF 1/4 - 19			62	28	11		●	81
23895	PF 3/8 - 19			65	28	14		●	70

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23896	PF 1/2 - 14	JIS2	4P	80	35	18	4	●	136
23898	PF 3/4 - 14			85	35	23		●	233
23900	PF 1 - 11			95	45	26		●	357

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1080

中径加大用

OVERSIZE

EX-SPT

HSSE

螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23771	PF 1/8 - 28	JIS2 + 0.04	4P	55	19	8	4	●	23
23772	PF 1/4 - 19			62	28	11		●	48
23773	PF 3/8 - 19			65	28	14		●	70

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23774	PF 1/2 - 14	JIS2 + 0.04	4P	80	35	18	4	●	136
23776	PF 3/4 - 14			85	35	23		△	239
23778	PF 1 - 11			95	45	26		△	360

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
SPT		○									○	○	○		○	○	○	○	○	○	○				
EX-SPT		○									○	○	○		○	○	○	○	○	○	○				

库存记号 Inventory symbols
● = 标准库存品 Standard stock item
○ = 准标准库存品(请确认库存。) Limited standard stock item
▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

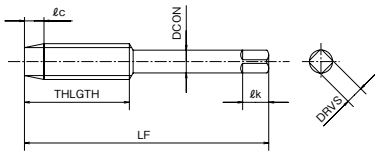
G-LIST No. | TH1012

一般用 长柄型

LONG SHANK · GENERAL APPLICATION

LT-SPT

HSS



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13509	PF 1/8 -28	JIS2	4P	120	19	8	4	●	51
13510				150				●	62
13514	PF 1/4 -19			120	28	11		●	88
13515				150				●	116
13519	PF 3/8 -19			120	28	14		●	139
13520	PF 3/8 -19	JIS2	4P	150	28	14	4	●	183
13525	PF 1/2 -14			150	35	18		●	281
13535	PF 3/4 -14			150	35	23		●	459
13545	PF 1 -11			150	45	26		●	597

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

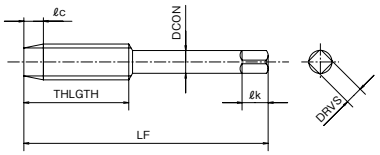
G-LIST No. | TH1110

一般用氧化处理

GENERAL APPLICATION (WITH OX)

H-SPT

HSS H



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8307741	PF 1/8 - 28	JIS2	4P	55	19	8	4	●	23
8307761			1.5P					●	22
8307742	PF 1/4 - 19		4P	62	28	11		●	48
8307762			1.5P					●	48
8307743	PF 3/8 - 19		4P	65	28	14		●	69
8307763			1.5P					●	69
8307744	PF 1/2 - 14		4P	80	35	18		●	136
8307764			1.5P					●	139
8307746	PF 5/8 - 14	JIS2	4P	82	35	19	4	▲	164
8307766			1.5P					▲	165
8307748	PF 3/4 - 14		4P	85	35	23		▲	234
8307768			1.5P					▲	236
8307750	PF 7/8 - 14		4P	90	40	24		▲	295
8307770			1.5P					▲	292
8307752	PF 1 - 11		4P	95	45	26		▲	358
8307772			1.5P					▲	365

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。
▲ = 该产品已停止生产，由 A-SPT(P.796) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.
▲ = The products have been stopped producing and replaced by A-SPT (p.796).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
LT-SPT		○									○	○	○		○	○	○	○	○	○	○				
H-SPT	◎	○		○							○			○											

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1078

TiN涂层

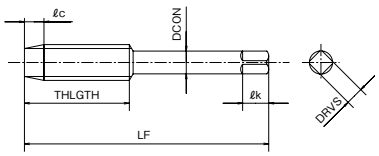
TiN COATED

TIN-SPT

采用耐溶着性、耐磨损性优良的 TiN 涂层。

TiN coating provides superior welding and wear resistance.

HSSE TiN



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23791	PF 1/8 - 28	JIS2	4P	55	19	8	4	●	23
23792	PF 1/4 - 19			62	28	11		●	49
23793	PF 3/8 - 19			65	28	14		●	70
23794	PF 1/2 - 14	JIS2	4P	80	35	18	4	●	137
23796	PF 3/4 - 14			85	35	23		●	237
23798	PF 1 - 11			95	45	26		●	357

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

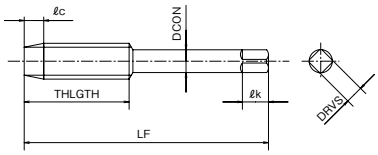
G-LIST No. | TH1091

难加工材料用

FOR DIFFICULT TO MACHINE MATERIALS

CPM-SPT

CPM



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309002	PF 1/8 - 28	JIS2	4P	55	19	8	4	●	23
8309003	PF 1/4 - 19			62	28	11		●	50
8309004	PF 3/8 - 19			65	28	14		●	71
8309005	PF 1/2 - 14	JIS2	4P	80	35	18	4	●	140
8309006	PF 3/4 - 14			85	35	23		△	244
8309008	PF 1 - 11			95	45	26		△	372

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
TIN-SPT	○	◎	○	◎	○										○	○	○	○	○	○	○				
CPM-SPT			◎			○				○		◎	○						○			○	○		

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

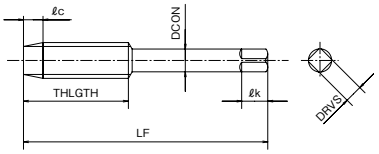
G-LIST No. | TH1081

不锈钢用
FOR STAINLESS STEELS

EX-SUS-SPT

适用于不锈钢等难加工材料的加工。特别准备有螺旋槽丝锥加工盲孔。
Suitable for tapping difficult to machine materials such as stainless steels. The spiral fluted model (SUS-SFT-SPT) is for tapping blind holes.

HSSE | H



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23971	PF 1/8 - 28	JIS2	4P	55	19	8	4	●	22
23972	PF 1/4 - 19			62	28	11		●	48
23973	PF 3/8 - 19			65	28	14		●	70
23974	PF 1/2 - 14			80	35	18		●	134
23976	PF 3/4 - 14			85	35	23		●	237
23978	PF 1 - 11			95	45	26		●	350

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

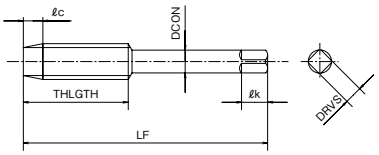
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1115

不锈钢用螺旋槽丝锥
SPIRAL FLUTED • FOR STAINLESS STEELS

SUS-SFT-SPT

HSSE | H | 45°



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309041	PF 1/8 - 28	JIS2	2.5P	55	19	8	3	●	22
8309042	PF 1/4 - 19			62	28	11		●	48
8309043	PF 3/8 - 19			65	28	14		●	69
8309044	PF 1/2 - 14	JIS2	2.5P	80	35	18	4	●	137
8309046	PF 3/4 - 14			85	35	23		●	236
8309048	PF 1 - 11			95	45	26		●	376

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
EX-SUS-SPT									◎					○											○
SUS-SFT-SPT									◎					○											

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1025

内冷油孔型

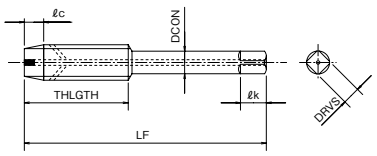
WITH INTERNAL COOLANT SUPPLY

OIL-SPT

HSS | H

适用于管用螺纹卧式、深孔加工。切削油剂直接作用于刃尖，可进行高速、高精度攻丝加工。

Effective for horizonal deep hole tapping. High speed / high precision tapping is possible because of the internal cutting fluid supply.



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP NO.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
10613	**PF 1/8 - 28**	JIS2	4P	150	19	8	4	△	59
10618	**PF 1/4 - 19**			150	28	11		△	111
10623	**PF 3/8 - 19**			150	28	14		△	173
10627	**PF 1/2 - 14**			150	35	18		△	274
10631	**PF 3/4 - 14**			150	35	23		△	440
10634	**PF 1 - 11**			150	45	26		△	573

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 油孔每槽各一个。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Each flute has its own oil hole.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

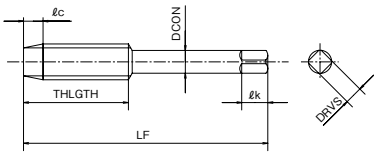
G-LIST No. | TH1052

Nu-Roll丝锥

FLUTELESS (NU-ROLL)

NRT-SPT

HSS | H



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	库存 Stock	重量 (g)
13691	**PF 1/8 - 28**	RH6	2.5P	55	11	8	●	26
13692	**PF 1/4 - 19**	RH7		62	17	11	●	58
13693	**PF 3/8 - 19**			65	17	14	●	85
13694	**PF 1/2 - 14**	RH8	2.5P	80	21	18	●	170
13696	**PF 3/4 - 14**			85	21	23	△	288
13698	**PF 1 - 11**	RH10		95	27	26	△	447

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥的推荐精度。(参照 P.836)
2. 切削锥长2.5P=B(盲孔用)
3. 丝锥精度不能保证内螺纹的精度。
4. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.836)
2. ℓc: 2.5P=B (for blind holes)
3. TAP Limit does not guarantee thread limit for the internal thread after tapping.
4. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OIL-SPT	◎	○	○	○						○	○	○	○		○	○	○				○				
NRT-SPT	◎	○	○	○					◎					○											

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

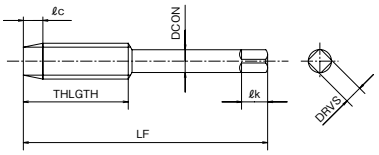
G-LIST No. | TW1002

硬质合金平行管螺纹丝锥

CARBIDE TAPS FOR PARALLEL PIPE THREADS

OT-SPT

CARBIDE



螺纹种类：PF(G)

单位:mm Unit:mm

	商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
	23422	PF 1/8 -28	JIS2	3P	55	19	8	4	●	37
	23423	PF 1/4 -19			62	28	11		●	77
◆	23424	PF 3/8 -19			65	28	14		●	72

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. ◆为焊接型。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

	商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
◆	23425	PF 1/2 -14	JIS2	3P	80	35	18	4	●	140
◆	23427	PF 3/4 -14			85	35	23		△	242
◆	23429	PF 1 -11			95	45	26		△	379

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. ◆ / symbol indicates carbide brazed type.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

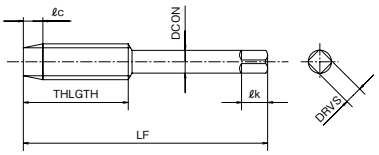
G-LIST No. | TW1008

硬质合金平行管螺纹丝锥 长柄型

CARBIDE TAPS FOR LONG SHANK・FOR PARALLEL PIPE THREADS

OT-LT-SPT

CARBIDE



螺纹种类：PF(G)

单位:mm Unit:mm

	商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
	22852	PF 1/8 - 28	JIS2	3P	100	19	8	4	●	70
	22854				150				●	105
	22855	PF 1/4 - 19			100	28	11		●	130
	22857				150				●	194
◆	22858	PF 3/8 - 19			100	28	14		●	117

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. ◆为焊接型。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

	商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
◆	22860	PF 3/8 - 19	JIS2	3P	150	28	14	4	●	181
◆	22862	PF 1/2 - 14			150	35	18		●	285
◆	22868	PF 3/4 - 14			150	35	23		△	463
◆	22871	PF 1 - 11			150	45	26		△	610

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. ◆ / symbol indicates carbide brazed type.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
OT-SPT												◎	○		○	○	◎		◎	○	◎			◎	
OT-LT-SPT												◎	○		○	○	◎		◎	○	◎			◎	

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

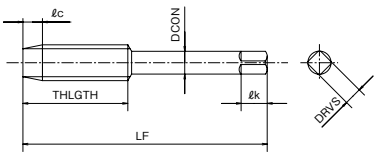
■记号说明请参考 P1页。 See p.1 for explanation of icons.

螺旋槽丝锥

SPIRAL FLUTED

SFT-SPT

HSS | 35°



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13710	PF 1/8 - 28	JIS2	2.5P	55	19	8	3	●	23
13712	PF 1/4 - 19			62	28	11		●	48
13713	PF 3/8 - 19			65	28	14		●	69
13714	PF 1/2 - 14			80	35	18	4	●	137
13716	PF 3/4 - 14			85	35	23	4	●	238
13718	PF 1 - 11			95	45	26		●	370
13719	PF 1 1/4 - 11			105	45	32		▲	633
13721	PF 1 1/2 - 11			110	45	38		▲	887

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

▲ = 该产品已停止生产，由 SPT(P.797) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲ = The products have been stopped producing and replaced by SPT (p.797).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
SFT-SPT		◎		◎							◎		○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

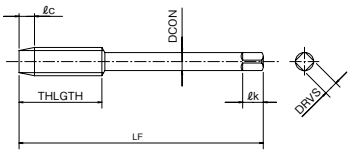
■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1156

螺旋槽丝锥 长柄型

LONG SHANK・SPIRAL FLUTED

LT-SFT-SPT



HSS　35°

螺纹种类：PF(G)

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309655	PF 1/8 - 28	JIS2	2.5P	120	19	8	3	▲	50
8309656				150				●	62
8309659	PF 1/4 - 19			120	28	11	3	▲	87
8309660				150				●	113
8309664	PF 3/8 - 19			120	28	14	3	▲	141

■突顶尖长・柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

▲=该产品已停止生产，由A-SPT(P.796)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309665	PF 3/8 - 19	JIS2	2.5P	150	28	14	3	●	182
8309669	PF 1/2 - 14			150	35	18	4	●	282
8309677	PF 3/4 - 14			150	35	23		▲	460
8309685	PF 1 - 11			150	45	26		▲	617

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

▲=The products have been stopped producing and replaced by A-SPT(p.796).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
LT-SFT-SPT		◎		◎							◎		○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。　See p.1 for explanation of icons.

G-LIST No. | **TH1049**

刃倾角丝锥

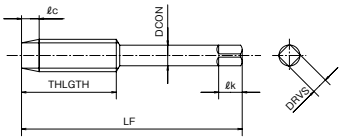
SPIRAL POINTED

EX-POT-SPT

HSSE

根据工件形状，有通孔用的刃倾角型、盲孔用的螺旋槽型。还有可加工低碳素钢、不锈钢等的NU-ROLL型。

The spiral point model (EX-POT-SPT) is for tapping through holes, while the spiral model (SFT-SPT) is for tapping blind holes. The forming tap (NRT-SPT) is available especially for low carbon steels and stainless steels.



螺纹种类：PF(G)

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13671	**PF 1/8 - 28**	OH2	4P	55	19	8	3	●	24
13672	**PF 1/4 - 19**	OH3		62	28	11		●	51
13673	**PF 3/8 - 19**			65	28	14		●	73
13674	**PF 1/2 - 14**	OH3	4P	80	35	18	3	●	144
13676	**PF 3/4 - 14**			85	35	23		▲	246
13678	**PF 1 - 11**	OH4		95	45	26	4	▲	391

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

▲＝该产品已停止生产，由 SPT(P.797) 替代。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

▲＝The products have been stopped producing and replaced by SPT(p.797).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-POT-SPT		◎		◎							◎		○	○	○	○	○	○	○	○	○				○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1321

螺旋槽丝锥 (锥管螺纹，长螺纹型)

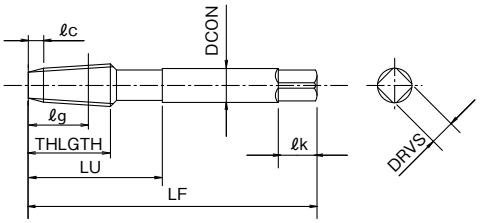
SPIRAL FLUTED TAP (TAPER PIPE THREAD)

The A Brand

A-TPT

切削条件 Cutting Conditions | P.838

HSSE | V | 40°



螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327671	1/16 - 27 NPT	ANSI G	2.5P	90	18	36	12	8	3	●	30
8327672	1/8 - 27 NPT			90	19	37	12.1	8		●	36
8327673	1/4 - 18 NPT			100	28	49	17.4	11		●	75
8327674	3/8 - 18 NPT			100	28	50	17.6	14	4	●	117
8327675	1/2 - 14 NPT			125	35	60	22.9	18		●	236
8327677	3/4 - 14 NPT			140	35	74	22.9	23		●	422
8327679	1 - 11 1/2 NPT			160	45	80	27.4	26		●	678

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-TPT	◎	◎	◎	◎	◎				○	○	○		○	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1327

螺旋槽丝锥 (锥管螺纹，短螺纹型)

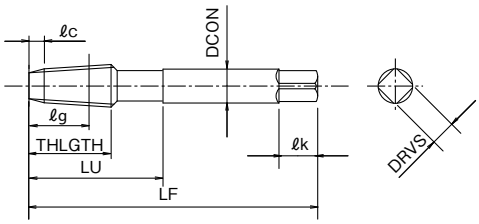
SPIRAL FLUTED TAP (TAPER PIPE THREAD)

The A Brand

A-S-TPT

切削条件 Cutting Conditions | P.838

HSSE | V | 40°



螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327681	1/16 - 27 NPT	ANSI G	2.5P	90	16	36	10	8	3	●	30
8327682	1/8 - 27 NPT			90	16.5	37	10.5	8		●	36
8327683	1/4 - 18 NPT			100	19.5	49	12.5	11		●	74
8327684	3/8 - 18 NPT			100	21	50	14	14	4	●	115
8327685	1/2 - 14 NPT			125	27	60	17	18		●	235
8327687	3/4 - 14 NPT			140	29	74	19	23		●	421
8327689	1 - 11 1/2 NPT			160	35	80	22	26		●	667

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
A-S-TPT	◎	◎	◎	◎	◎				○	○	○		○	○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1147

一般用 (NPT)

GENERAL APPLICATION (NPT)

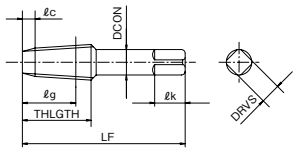
TPT

HSS

用于锥管内螺纹的加工主要分长螺纹(TPT) 和短螺纹(S-TPT)2 种。
NRT : 密封用。

Used to process taper pipe internal threads. OSG offers the standard thread length (TPT) and the short thread length (S-TPT), The S-TPT is used for processing short internal threads on joints.

NPT : American taper pipe threads (general purpose)



螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23671	1/16 - 27 NPT	ANSI G	2.5P	55	18	12	8	4	●	19
23672	1/8 - 27 NPT			55	19	12.1	8		●	23
23673	1/4 - 18 NPT			62	28	17.4	11		●	48
23674	3/8 - 18 NPT			65	28	17.6	14		●	69
23675	1/2 - 14 NPT			80	35	22.9	18		●	135
23676	3/4 - 14 NPT			85	35	22.9	23		●	234
23678	1 -11 1/2 NPT			95	45	27.4	26		●	354
23679	1 1/4-11 1/2 NPT	ANSI G	2.5P	105	45	28.1	32	4	●	598
23680	1 1/2-11 1/2 NPT			110	45	28.4	38	6	●	917
23681	2 -11 1/2 NPT			120	50	28	46		●	1,520
23682	2 1/2- 8 NPT			145	65	40.8	55	8	●	2,854
23683	3 - 8 NPT			155	65	43	65		●	4,724
23684	3 1/2- 8 NPT			165	68	44.7	70	10	●	5,760
23685	4 - 8 NPT			170	70	45.5	75		●	7,420

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1131

一般用 短螺纹 (NPT)

GENERAL APPLICATION (SHORT THREAD)

S-TPT

HSS

螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23621	1/16 - 27 NPT	ANSI G	2.5P	55	16	10	8	4	●	20
23622	1/8 - 27 NPT			55	16.5	10.5	8		●	23
23623	1/4 - 18 NPT			62	19.5	12.5	11		●	50
23624	3/8 - 18 NPT			65	21	14	14		●	71
23625	1/2 - 14 NPT	ANSI G	2.5P	80	27	17	18	4	●	142
23627	3/4 - 14 NPT			85	29	19	23		●	241
23629	1 -11 1/2NPT			95	35	22	26		●	361

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
TPT		○	○								○	○	○	○	○	○		○	○	○	○				
S-TPT		○	○								○	○	○	○	○	○		○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1147

一般用(NPTF)

GENERAL APPLICATION (NPTF)

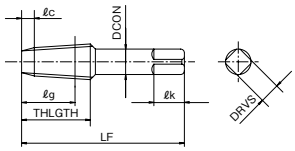
TPT

HSS

用于锥管内螺纹的加工主要分长螺纹(TPT)和短螺纹(S-TPT)2种。
NPTF: 密封用

Used to process taper pipe internal threads. OSG offers the standard thread length (TPT) and the short thread length (S-TPT), The S-TPT is used for processing short internal threads on joints.

NPTF : American taper pipe threads (dry seal)



螺纹种类：NPTF

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23691	1/16 -27 NPTF	ANSI G	2.5P	55	18	12	8	4	●	19
23692	1/8 -27 NPTF			55	19	12.1	8		●	23
23693	1/4 -18 NPTF			62	28	17.4	11		●	48
23694	3/8 -18 NPTF			65	28	17.6	14		●	69
23695	1/2 -14 NPTF			80	35	22.9	18		●	134
23697	3/4 -14 NPTF	ANSI G	2.5P	85	35	22.9	23	4	●	230
23699	1 -11 1/2 NPTF			95	45	27.4	26		●	346
23700	1 1/4 -11 1/2 NPTF			105	45	28.1	32		●	605
23701	1 1/2 -11 1/2 NPTF			110	45	28.4	38	6	●	928
23702	2 -11 1/2 NPTF			120	50	28	46		●	1,542

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1131

一般用短螺纹(NPTF)

GENERAL APPLICATION (SHORT THREAD)

S-TPT

HSS

螺纹种类：NPTF

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23661	1/16 - 27 NPTF	ANSI G	2.5P	55	16	10	8	4	●	20
23662	1/8 - 27 NPTF			55	16.5	10.5	8		●	23
23663	1/4 - 18 NPTF	ANSI G	2.5P	62	19.5	12.5	11	4	●	50
23664	3/8 - 18 NPTF			65	21	14	14		●	72

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
TPT		○	○								○	○	○	○	○	○		○	○	○	○				
S-TPT		○	○								○	○	○	○	○	○		○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1017

螺旋槽丝锥

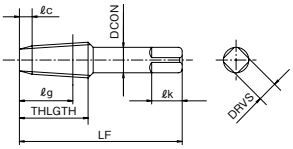
SPIRAL FLUTED

SFT-TPT

HSS | 30°

锥管内螺纹加工用，适合于盲孔及容易产生堵屑的螺纹加工。

Although it can be used to process taper pipe internal threads, this tap is best suited for tapping blind holes and for applications tend to have chip packing problem.



螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
13791	1/16 -27 NPT	ANSI G	2.5P	55	18	12	8	3	●	18
13792	1/8 -27 NPT			55	19	12.1	8		●	22
13793	1/4 -18 NPT			62	28	17.4	11	4	●	46
13794	3/8 -18 NPT			65	28	17.6	14		●	67
13795	1/2 -14 NPT			80	35	22.9	18		●	131
13797	3/4 -14 NPT			85	35	22.9	23	4	●	232
13799	1 -11½NPT			95	45	27.4	26		●	352

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

再研磨 · 再涂层

可一次性接受。实现和新品一样的性能。

※详情请参照▶P.9
See p.9 for details

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
SFT-TPT		○		○							○									○						

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1011

跳牙型

WITH INTERRUPTED THREADS

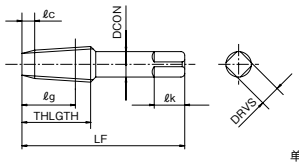
IRT

HSS | H | 8°

左螺旋 Revers Flutes

适用于不锈钢和耐热合金等表面加工硬化层及易溶着的难切削材料。

Suitable for processing difficult to machine materials such as stainless steels and heat resistant alloys that have hardened surfaces and/or a tendency for welding. TiN coated versions of this tap are also available.



螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23741	1/16 - 27 NPT	ANSI G	2.5P	55	18	12.1	8	5	●	19
23742	1/8 - 27 NPT			55	19	12.1	8		●	24
23743	1/4 - 18 NPT			62	28	17.5	11		●	49
23744	3/8 - 18 NPT			65	28	17.7	14		●	72
23745	1/2 - 14 NPT			80	35	22.9	18		●	137
23747	3/4 - 14 NPT	ANSI G	2.5P	85	35	22.9	23	5	●	241
23749	1 - 11½ NPT			95	45	27.4	26		●	374
23750	1¼ - 11½ NPT			105	45	28.1	32		●	639
23751	1½ - 11½ NPT			110	45	28.4	38	7	●	930
23752	2 - 11½ NPT			120	50	28	46		●	1,578

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1073

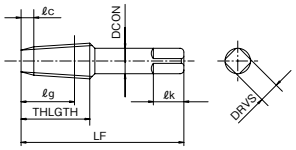
TiN涂层 跳牙型

TiN-COATED WITH INTERRUPTED THREADS

TIN-IRT

HSSE | TiN | 8°

左螺旋 Revers Flutes



螺纹种类：NPT

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8309142	1/8 - 27 NPT	ANSI G	2.5P	55	19	12.1	8	5	●	23
8309143	1/4 - 18 NPT			62	28	17.5	11		●	49
8309144	3/8 - 18 NPT			65	28	17.7	14		●	72
8309145	1/2 - 14 NPT	ANSI G	2.5P	80	35	22.9	18	5	●	137
8309147	3/4 - 14 NPT			85	35	23	23		●	242
8309149	1 - 11½ NPT			95	45	27.4	26		●	374

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1130

跳牙型(NPTF)

WITH INTERRUPTED THREADS

EX-IRT

HSSE | H | 8°

左螺旋 Revers Flutes

螺纹种类：NPTF

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	基准径位置 ℓg	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23761	1/16 - 27 NPTF	ANSI G	2.5P	55	18	12	8	3	●	19
23762	1/8 - 27 NPTF			55	19	12.05	8	5	●	24
23763	1/4 - 18 NPTF	ANSI G	2.5P	62	28	17.45	11	5	●	49
23764	3/8 - 18 NPTF			65	28	17.65	14		●	72

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel C ~0.25%	中碳素钢 Medium Carbon Steel C0.25% ~0.45%	高碳素钢 High Carbon Steel C 0.45% ~	合金钢 Alloy Steel SCM	调质钢 Hardened Steel 25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	不锈钢 Stainless Steel SUS	工具钢 Tool Steel SKD	铸钢 Cast Steel SC	铸铁 Cast Iron FC	球墨铸铁 Ductile Cast Iron FCD	铜 Copper Cu	黄铜 Brass Bs	黄铜铸件 Brass Casting BsC	青铜 Bronze PB	变形铝 Aluminum Rolled AL	铝合金铸件 Aluminum Alloy Casting AC,ADC	镁合金铸件 Magnesium Alloy Casting MC	锌合金铸件 Zinc Alloy Casting ZDC	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
IRT	○				○				◎			○													
TIN-IRT	○	○			○				◎			○													
EX-IRT	○								◎			○													

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1325

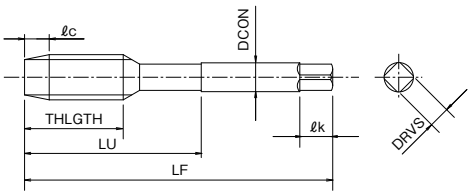
螺旋槽丝锥（平行管螺纹）

SPIRAL FLUTED TAP (PARALLEL PIPE THREAD)

The A Brand

A-SPT

切削条件 Cutting Conditions | P.838



HSSE | V | 45°

螺纹种类：NPS

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327691	1/16 - 27 NPS	ANSI G	2.5P	90	14	36	8	3	●	29
8327692	1/8 - 27 NPS			90	15	37	8		●	35
8327693	1/4 - 18 NPS			100	19	49	11		●	71
8327694	3/8 - 18 NPS			100	21	50	14	4	●	107
8327695	1/2 - 14 NPS			125	26	60	18		●	219
8327697	3/4 - 14 NPS			140	28	74	23		●	380
8327699	1 - 11 1/2 NPS			160	33	80	26		●	591

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-SPT	◎	◎	◎	◎	◎				○	○	○		○	○	○	○	○	○	○	○	○	○			

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1146

一般用 (NPS)

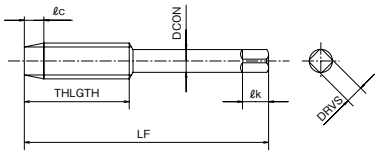
GENERAL APPLICATION (NPS)

SPT

HSS

用于锥管螺纹的平行内螺纹及管用平行内螺纹加工。
NPS: 密封用 (NPSC· NPSM) NPSF :干式

Used to process parallel pipe internal threads.
NPS : American straight pipe threads (for general purposes)
NPSC : American straight pipe threads (for pipe couplings)
NPSM : American straight pipe threads (for free fitting mechanical joints)
NPSF : American straight pipe threads (for dry seals)



螺纹种类：NPS

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23561	1/16 -27 NPS	ANSI G	4P	55	18	8	4	●	19
23562	1/8 -27 NPS			55	19	8		●	23
23563	1/4 -18 NPS			62	28	11		●	49
23564	3/8 -18 NPS			65	28	14		●	69
23565	1/2 -14 NPS			80	35	18		●	136
23567	3/4 -14 NPS			85	35	23		●	234
23569	1 -11 1/2 NPS			95	45	26		●	350

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23570	1 1/4 -11 1/2 NPS	ANSI G	4P	105	45	32	4	●	618
23571	1 1/2 -11 1/2 NPS			110	45	38	6	●	924
23572	2 -11 1/2 NPS			120	50	46		●	1,534
23573	2 1/2 - 8 NPS			145	65	55	8	●	2,699
23574	3 - 8 NPS			155	65	65		●	4,420
23575	3 1/2 - 8 NPS			165	68	70	10	●	5,860
23576	4 - 8 NPS			170	70	75		●	7,700

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1146

一般用 (NPSF)

GENERAL APPLICATION (NPSF)

SPT

HSS

螺纹种类：NPSF

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23801	1/16 -27 NPSF	ANSI G	4P	55	18	8	4	●	19
23802	1/8 -27 NPSF			55	19	8		●	23
23803	1/4 -18 NPSF			62	28	11		●	49
23804	3/8 -18 NPSF			65	28	14		●	69
23805	1/2 -14 NPSF			80	35	18		●	134

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
23807	3/4 -14 NPSF	ANSI G	4P	85	35	23	4	●	237
23809	1 -11 1/2 NPSF			95	45	26		●	352
23850	1 1/4 -11 1/2 NPSF			105	45	32		●	604
23852	1 1/2 -11 1/2 NPSF			110	45	38	6	●	906

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
SPT		○									○	○	○		○	○	○	○	○	○	○					

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1328

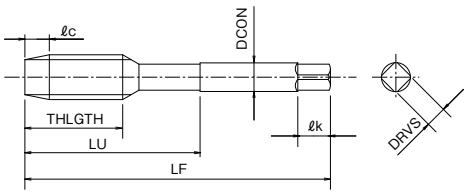
嵌套螺纹用螺旋槽丝锥

SPIRAL FLUTED TAP FOR HELICOIL / EG / STI

The A Brand

A-SFT HL

切削条件 Cutting Conditions | P.837



CPM | V | 45°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327751	M 2 × 0.4	OH1	2.5P	44	3.6	13	3	2	●	3
8327753	M 2.5 × 0.45	OH1.5		46	4	19	4	3	●	4
8327755	M 2.6 × 0.45			46	4	19	4		●	4
8327757	M 3 × 0.5			48	4.8	20	4		●	5
8327759			1.5P						●	5
8327761	M 4 × 0.7	OH2	2.5P	60	6.4	24	5.5		●	10
8327763			1.5P						●	10
8327765	M 5 × 0.8		2.5P	62	8	29	6		●	11
8327767			1.5P						●	11
8327769	M 6 × 1		2.5P	65	12	33	6.2		●	15
8327771			1.5P						●	15
8327773	M 8 × 1.25		2.5P	75	15	41	7		●	23
8327775			1.5P						●	23
8327777	M 10 × 1.5		2.5P	82	18	48	8.5		●	36
8327779			1.5P						●	37
8327781	M 12 × 1.75		2.5P	90	21	48	10.5		●	64

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

CPM | V | 45°

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327785	No. 10 – 32UNF	GH2	2.5P	62	8	29	6	3	●	11
8327787	¼ – 28UNF	GH2.5		70	11	37	6.2		●	16
8327789	5/16 – 24UNF	GH3		75	13	41	7		●	22
8327791	⅜ – 24UNF	GH3		80	13	48	8		●	31

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-SFT HL	○	◎	◎	○	◎				○	○	○		○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1329

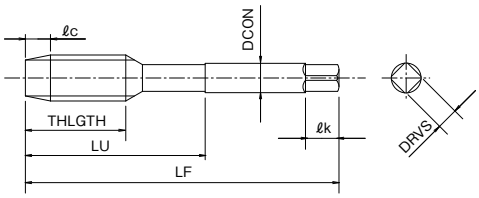
嵌套螺纹用螺旋槽丝锥 长柄型

SPIRAL FLUTED TAP WITH LONG SHANK FOR HELICOIL / EG / STI

The A Brand

A-LT-SFT HL

切削条件 Cutting Conditions | P.837



CPM | V | 45°

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	库存 Stock	重量 (g)
8327801	M 3 × 0.5 × 100	OH1.5	2.5P	100	4.8	20	4	3	●	11
8327803	M 4 × 0.7 × 100	OH2		100	6.4	24	5.5		●	20
8327805	M 5 × 0.8 × 100			100	8	29	6		●	23
8327807	M 6 × 1 × 100			100	12	33	6.2		●	24
8327809	M 8 × 1.25 × 100			100	15	41	7		●	32
8327811	M 10 × 1.5 × 100			100	18	48	8.5		●	46

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 不推荐再研磨。

※使用进给不稳定的机械，容易发生内螺纹扩大问题，需注意。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Tap limit does not guarantee thread limit for the internal thread after tapping.
2. Regrinding is not recommended.

※ Stable feed control machines are recommended to avoid over size tapping.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
A-LT-SFT HL	○	◎	◎	○	◎				○	○	○		○	○	○	○	○	○	○	○	○				

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

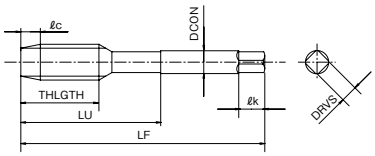
G-LIST No. | TH1053

螺旋槽丝锥

SPIRAL FLUTED

EX-HL-SFT

用于盲孔的嵌套螺纹。
Used for tapping blind holes that have a helical coil wire screw thread insert.



HSSE　35°

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14008	M 2 ×0.4	1b	2.5P	44	14	—	3	2	Yes	●	3
14078		1b+0.03							Yes	●	3
14010	M 2.5×0.45	1b		46	11	19	4	3	Yes	●	4
14080		1b+0.03							Yes	●	4
14012	M 2.6×0.45	1b		46	11	19	4		Yes	●	5
14082		1b+0.03							Yes	●	4
14014	M 3 ×0.5	1b		48	13	20	4		Yes	●	5
14084		1b+0.03							Yes	●	5
14016	M 4 ×0.7	1b		60	16	24	5.5		Yes	●	10
14086		1b+0.03							Yes	●	10
14018	M 5 ×0.8	1b		62	19	29	6		Yes	●	12

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
14088	M 5 ×0.8	1b+0.03	2.5P	62	19	29	6	3	Yes	●	12
14020	M 6 ×1	1b		65	19	33	6.2		—	●	15
14090		1b+0.03							—	●	15
14024	M 8 ×1.25	1b		75	24	41	7		—	●	25
14094		1b+0.03							—	●	25
14028	M10 ×1.5	1b		82	29	48	8.5		—	●	39
14098		1b+0.03							—	●	40
14030	M10 ×1.25	1b		82	29	48	8.5		—	●	38
14034	M12 ×1.75	1b		90	30	48	10.5		—	●	65
14100		1b+0.03							—	●	64

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

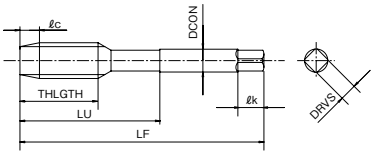
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1105

螺旋槽丝锥 长柄型

LONG SHANK · SPIRAL FLUTED

HL-LT-SFT



HSSE　35°

螺纹种类：M

单位:mm　Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8308012	M 3×0.5	1b	2.5P	100	13	20	4	3	Yes	●	11
8308015	M 4×0.7			100	16	24	5.5		Yes	●	15
8308018	M 5×0.8			100	19	29	6		Yes	●	23
8308021	M 6×1			100	19	33	6.2		—	●	24
8308023				150					—	●	37

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8308027	M 8×1.25	1b	2.5P	150	24	41	7	3	—	●	49
8308034	M10×1.5			150	29	48	8.5		—	●	70
8308038	M10×1.25			150	29	48	8.5		—	●	70
8308045	M12×1.75			150	30	48	10.5		—	●	102

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-HL-SFT																		◎	◎		◎				
HL-LT-SFT																		◎	◎		◎				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。　See p.1 for explanation of icons.

G-LIST No. | TH1101

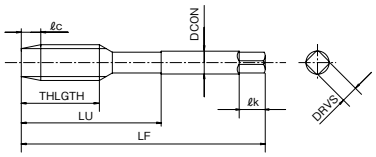
刃倾角丝锥

SPIRAL POINTED

EX-HL-POT

用于通孔的嵌套螺纹。

Used for tapping through holes that have a helical coil wire screw thread insert.



HSSE

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8307818	M 3 ×0.5	1b	5P	48	13	20	4	3	Yes	●	5
8307821	M 4 ×0.7			60	16	24	5.5		Yes	●	10
8307823	M 5 ×0.8			62	19	29	6		Yes	●	12
8307825	M 6 ×1			65	19	33	6.2		Yes	●	16

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8307827	M 8 ×1.25	1b	5P	75	24	41	7	3	—	●	27
8307829	M10×1.5			82	29	48	8.5		—	●	44
8307830	M10×1.25			82	29	48	8.5		—	●	43
8307832	M12×1.75			90	30	48	10.5		—	●	73

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

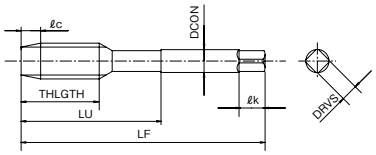
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1098

刃倾角丝锥 长柄型

LONG SHANK · SPIRAL POINTED

HL-LT-POT



HSSE

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8307912	M 3 ×0.5	1b	5P	100	13	20	4	3	Yes	●	11
8307915	M 4 ×0.7			100	16	24	5.5		Yes	●	19
8307918	M 5 ×0.8			100	19	29	6		Yes	●	23
8307921	M 6 ×1			100	19	33	6.2		Yes	●	27
8307923				150					Yes	●	38

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8307927	M 8 ×1.25	1b	5P	150	24	41	7	3	—	●	52
8307934	M10×1.5			150	29	48	8.5		—	●	75
8307938	M10×1.25			150	29	48	8.5		—	●	75
8307945	M12×1.75			150	30	48	10.5		—	●	110

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-HL-POT																		◎	◎		◎				
HL-LT-POT																		◎	◎		◎				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

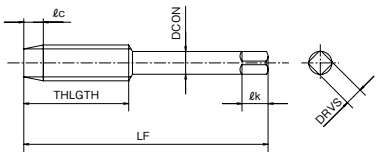
■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1163

直槽丝锥
STRAIGHT FLUTED

HL-HT

嵌套螺纹加工用。与相同尺寸的丝锥相比，螺距相同，但丝锥外径要大。
Used for tapping holes that have a helical coil wire screw thread insert. Compared to ordinary taps of the same nominal size, these taps have the same pitch but have an oversized outer diameter for insert.



HSS

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9693	M 2 ×0.4	1b	5P	44	16	3	3	Yes	●	3
9694			1.5P					Yes	●	3
9003		1b+0.03	5P					Yes	●	3
9004			1.5P					Yes	●	3
9697	M 2.5 ×0.45	1b	5P	46	18	4		Yes	●	5
9698			1.5P					Yes	●	5
9007		1b+0.03	5P					Yes	●	4
9008			1.5P					Yes	●	4
9701	M 2.6 ×0.45	1b	5P	46	18	4		Yes	●	5
9702			1.5P					Yes	●	5
9011		1b+0.03	5P					Yes	●	4
9012			1.5P					Yes	●	4
9704	M 3 ×0.5	1b	9P	48	18	4		Yes	●	5
9705			5P					Yes	●	5
9706			1.5P					Yes	●	5
9013		1b+0.03	9P					Yes	●	5
9014			5P					Yes	●	5
9015			1.5P					Yes	●	6
9710	M 4 ×0.7	1b	9P	60	22	5.5		Yes	●	11
9711			5P					Yes	●	11
9712			1.5P					Yes	●	11
9019		1b+0.03	9P					Yes	●	10
9020			5P					Yes	●	10
9021			1.5P					Yes	●	10
9716	M 5 ×0.8	1b	9P	62	24	6		Yes	●	12
9717			5P					Yes	●	13
9718			1.5P					Yes	●	13
9025		1b+0.03	9P					Yes	●	12
9026			5P					Yes	●	12
9027			1.5P					Yes	●	13
9722	M 6 ×1	1b	9P	65	26	6.2	4	—	●	16
9723			5P					—	●	16
9724			1.5P					—	●	16
9031		1b+0.03	9P					—	●	14
9032			5P					—	●	16
9033			1.5P					—	●	16
9728	M 8 ×1.25	1b	9P	75	32	7		—	●	25
9729			5P					—	●	25
9730			1.5P					—	●	25
9037		1b+0.03	9P					—	●	25
9038			5P					—	●	24
9039			1.5P					—	●	25

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9735	M10 ×1.5	1b	5P	82	38	8.5	4	—	●	41
9736			1.5P					—	●	42
9045		1b+0.03	5P					—	●	42
9046			1.5P					—	●	42
9739	M10 ×1.25	1b	5P	80	38	8.5		—	●	40
9740			1.5P					—	●	40
9049		1b+0.03	5P					—	●	39
9050			1.5P					—	●	40
9745	M12 ×1.75	1b	5P	90	42	10.5		—	●	70
9746			1.5P					—	●	70
9055		1b+0.03	5P					—	●	69
9056			1.5P					—	●	70
9749	M12 ×1.5	1b	5P	88	42	10.5		—	●	67
9750			1.5P					—	●	66
9059		1b+0.03	5P					—	●	65
9060			1.5P					—	●	66
9753	M12 ×1.25	1b	5P	88	42	10.5		—	●	67
9754			1.5P					—	●	66
9063		1b+0.03	5P					—	●	66
9064			1.5P					—	●	67
9757	M14 ×2	1b	5P	95	45	13		—	●	98
9758			1.5P					—	●	98
9761	M14 ×1.5		5P	95	45	12.5		—	●	93
9762			1.5P					—	●	93
9765	M16 ×2		5P	95	45	14		—	●	110
9766			1.5P					—	●	109
9769	M16 ×1.5		5P	95	45	14		—	●	109
9770			1.5P					—	●	108
9773	M18 ×2.5		5P	115	55	17		—	●	184
9774			1.5P					—	●	188
9777	M18 ×1.5		5P	95	45	15		—	●	129
9778			1.5P					—	●	132
9781	M20 ×2.5		5P	120	58	19		—	●	241
9782			1.5P					—	●	242
9785	M20 ×1.5		5P	95	45	17		—	●	158
9786			1.5P					—	●	159
9791	M22 ×2.5		5P	130	62	20		—	●	286
9792			1.5P					—	●	292
9794	M22 ×1.5		5P	95	45	19		—	●	193
9795			1.5P					—	●	194
9800	M24 ×3		5P	135	65	21		—	●	345
9801			1.5P					—	●	346

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

下一页
尺寸 Size M24 ~ M30 NEXT

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HL-HT																		○	○		◎				

上一页

FROM 尺寸 **Size** **M2 ~ M24**

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9941	**M24 ×1.5**	1b	5P	95	45	20	4	—	●	213
9942			1.5P					—	●	208
9950	**M27 ×3**		5P	145	70	23		—	●	439
9951			1.5P					—	●	436
9956	**M27 ×1.5**		5P	105	45	21		—	●	285

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考P.1004。

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削推长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9957	**M27 ×1.5**	1b	1.5P	105	45	21	4	—	●	285
9962	**M30 ×3.5**		5P	155	75	28		—	●	630
9963			1.5P					—	●	644
9968	**M30 ×1.5**		5P	105	45	24		—	●	351
9969			1.5P					—	●	356

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

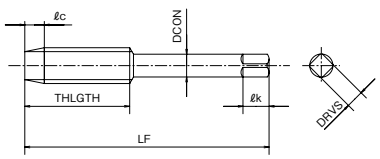
G-LIST No. | TH1163

直槽丝锥
STRAIGHT FLUTED

HL-HT

HSS

嵌套螺纹加工用。与相同尺寸的丝锥相比，螺距相同，但丝锥外径要大。
Used for tapping holes that have a helical coil wire screw thread insert. Compared to ordinary taps of the same nominal size, these taps have the same pitch but have an oversized outer diameter for insert.



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9803	No. 2 - 56UNC	1b	5P	44	16	3	3	Yes	●	4
9804			1.5P					Yes	●	3
9805	No. 4 - 40UNC		5P	48	18	4		Yes	●	5
9806			1.5P					Yes	●	5
9813	No. 5 - 40UNC		5P	52	20	5		Yes	●	7
9814			1.5P					Yes	●	7
9821	No. 6 - 32UNC		5P	55	20	5		Yes	●	9
9822			1.5P					Yes	●	8
9825	No. 6 - 40UNF		5P	55	20	5		Yes	●	8
9826			1.5P					Yes	●	8
9829	No. 8 - 32UNC		5P	60	22	5.5		Yes	●	11
9830			1.5P					Yes	●	10
9833	No. 8 - 36UNF		5P	60	22	5.5		Yes	●	10
9834			1.5P					Yes	●	10
9837	No.10 - 24UNC		5P	62	24	6		Yes	●	13
9838			1.5P					Yes	●	13
9841	No.10 - 32UNF		5P	62	24	6		Yes	●	13
9842			1.5P					Yes	●	13
9845	No.12 - 24UNC		5P	65	26	6.2	4	—	●	14
9846			1.5P					—	●	14
9849	No.12 - 28UNF		5P	65	26	6.2		—	●	14
9850			1.5P					—	●	14
9853	1/4 - 20UNC		5P	70	30	6.2		—	●	17
9854			1.5P					—	●	18
9857	1/4 - 28UNF		5P	70	30	6.2		—	●	17
9858			1.5P					—	●	17
9861	5/16 - 18UNC		5P	75	32	7		—	●	25
9862			1.5P					—	●	25
9865	5/16 - 24UNF		5P	75	32	7		—	●	25

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。
1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
9866	5/16 - 24UNF	1b	1.5P	75	32	7	4	—	●	25
9869	3/8 - 16UNC		5P	82	38	8.5		—	●	40
9870			1.5P					—	●	40
9873	3/8 - 24UNF		5P	80	38	8		—	●	36
9874			1.5P					—	●	35
9877	7/16 - 14UNC		5P	88	42	10.5		—	●	64
9878			1.5P					—	●	63
9881	7/16 - 20UNF		5P	85	42	9		—	●	53
9882			1.5P					—	●	53
9885	1/2 - 13UNC		5P	95	45	12		—	●	86
9886			1.5P					—	●	85
9889	1/2 - 20UNF		5P	90	42	10.5		—	●	71
9890			1.5P					—	●	70
9893	5/8 - 11UNC		5P	105	50	14		—	●	116
9894			1.5P					—	●	117
9895	5/8 - 18UNF		5P	95	45	14		—	●	108
9896			1.5P					—	●	107
9899	3/4 - 10UNC		5P	115	55	17		—	●	196
9900			1.5P					—	●	190
9901	3/4 - 16UNF		5P	95	45	17		—	●	155
9902			1.5P					—	●	155
9905	7/8 - 9UNC		5P	125	60	20		—	●	289
9906			1.5P					—	●	289
9907	7/8 - 14UNF		5P	95	45	19		—	●	190
9908			1.5P					—	●	192
9911	1 - 8UNC		5P	135	65	23		—	●	396
9912			1.5P					—	●	387
9913	1 - 12UNF		5P	105	45	21		—	●	259
9914			1.5P					—	●	259

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.
1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HL-HT																		○	○		◎				

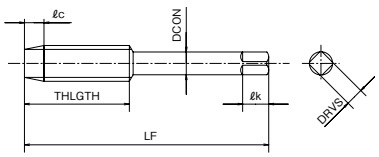
库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

直槽丝锥 长柄型

LONG SHANK · STRAIGHT FLUTED

HL-LT



HSS

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8308124	M 3 ×0.5	1b	5P	100	18	4	3	Yes	●	11
8308125			1.5P					Yes	●	11
8308130	M 4 ×0.7		5P	100	22	5.5		Yes	●	19
8308131			1.5P					Yes	●	19
8308136	M 5 ×0.8		5P	100	24	6		Yes	●	24
8308137			1.5P					Yes	●	25
8308142	M 6 ×1		5P	100	26	6.2	4	—	●	25
8308143			1.5P					—	●	25
8308146			5P	150				—	●	37
8308147			1.5P					—	●	37
8308154	M 8 ×1.25		5P	150	32	7		—	●	49

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8308155	M 8 ×1.25	1b	1.5P	150	32	7	4	—	●	50
8308168	M10×1.5		5P	150	38	8.5		—	●	74
8308169			1.5P					—	●	73
8308174	M10×1.25		5P	150	38	8.5		—	●	71
8308175			1.5P					—	●	72
8308190	M12×1.75		5P	150	42	10.5		—	●	105
8308191			1.5P					—	●	106
8308198	M12×1.5		5P	150	42	10.5		—	●	106
8308199			1.5P					—	●	105
8308206	M12×1.25		5P	150	42	10.5		—	●	107
8308207			1.5P					—	●	104

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8309502	No. 4 -40UNC	1b	5P	100	18	4	3	Yes	△	12
8309503			1.5P					Yes	△	12
8309508	No. 5 -40UNC		5P	100	20	5		Yes	△	16
8309509			1.5P					Yes	△	16
8309520	No. 6 -32UNC		5P	100	20	5		Yes	△	16
8309521			1.5P					Yes	△	16
8309526	No. 6 -40UNF		5P	100	20	5		Yes	△	16
8309527			1.5P					Yes	△	16
8309532	No. 8 -32UNC		5P	100	22	5.5		Yes	△	21
8309533			1.5P					Yes	△	21
8309538	No. 8 -36UNF		5P	100	22	5.5		Yes	△	21
8309539			1.5P					Yes	△	21
8309544	No.10-24UNC		5P	100	24	6		Yes	△	24
8309545			1.5P					Yes	△	22
8309550	No.10-32UNF		5P	100	24	6		Yes	△	24
8309551			1.5P					Yes	△	24
8309556	No.12-24UNC		5P	100	26	6.2	4	—	△	25
8309557			1.5P					—	△	25
8309564	No.12-28UNF		5P	100	26	6.2		—	△	25
8309565			1.5P					—	△	25
8309572	¼ -20UNC		5P	100	30	6.2		—	△	26
8309573			1.5P					—	△	26

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
8309576	¼ -20UNC	1b	5P	150	30	6.2	4	—	△	38
8309577			1.5P					—	△	38
8309580	¼ -28UNF		5P	100	30	6.2		—	△	25
8309581			1.5P					—	△	25
8309584	¼ -28UNF		5P	150	30	6.2		—	△	37
8309585			1.5P					—	△	37
8309592	5/16 -18UNC		5P	150	32	7		—	△	48
8309593			1.5P					—	△	50
8309600	5/16 -24UNF		5P	150	32	7		—	△	48
8309601			1.5P					—	△	49
8309608	3/8 -16UNC		5P	150	38	8.5		—	△	70
8309609			1.5P					—	△	70
8309616	3/8 -24UNF		5P	150	38	8		—	△	64
8309617			1.5P					—	△	63
8309624	7/16 -14UNC		5P	150	42	10.5		—	△	100
8309625			1.5P					—	△	100
8309632	7/16 -20UNF		5P	150	42	9		—	△	80
8309633			1.5P					—	△	79
8309640	½ -13UNC		5P	150	45	12		—	△	128
8309641			1.5P					—	△	130
8309648	½ -20UNF		5P	150	42	10.5		—	△	106
8309649			1.5P					—	△	106

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 软钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
HL-LT																		○	○		◎				

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1051

非铁合金用NRT挤压丝锥

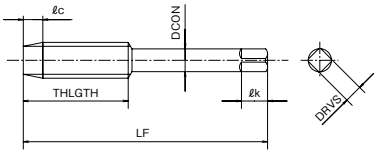
FLUTELESS (NU-ROLL) · FOR NON-FERROUS METALS

HL-B-NRT

HSS **N**

加工铝、(锻造、变形、铸造)及其他轻合金非常有效,不会出现切屑堵塞。

Suitable for tapping aluminum (casting, rolled, cast alloys) and other light alloys with chip waste countermeasures or longer tool life.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
14048	M 2 ×0.4	RH2	2P	44	14	—	3	—	●	3
14050	M 2.5 ×0.45			46	9	18	4	—	●	5
14052	M 2.6 ×0.45			46	9	18	4	—	●	5
14054	M 3 ×0.5	RH3		48	9	18	4	—	●	5
14056	M 4 ×0.7	RH4		60	11	22	5.5	—	●	11
14058	M 5 ×0.8			62	12	24	6	—	●	14

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
14060	M 6 ×1	RH4	2P	65	13	26	6.2	—	●	18
14064	M 8 ×1.25	RH5		75	19	—	7	—	●	30
14068	M 10 ×1.5			82	23	—	8.5	—	●	48
14070	M 10 ×1.25			82	23	—	8.5	—	●	46
14074	M 12 ×1.75			90	25	—	10.5	—	●	82

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

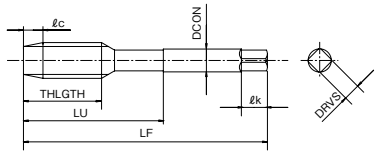
G-LIST No. | TH1100

非铁合金用NRT挤压丝锥 长柄型

LONG SHANK · FLUTELESS (NU-ROLL) · FOR NON-FERROUS METALS

HL-LT-B-NRT

HSS **N**



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307612	M 3 ×0.5	RH3	2P	100	9	18	4	—	●	12
8307615	M 4 ×0.7	RH4		100	11	22	5.5	—	●	20
8307618	M 5 ×0.8			100	12	24	6	—	●	25
8307621	M 6 ×1			100	13	26	6.2	—	●	27
8307623				150				—	●	40

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
8307627	M 8 ×1.25	RH5	2P	150	19	41	7	—	●	54
8307634	M10 ×1.5			150	23	48	8.5	—	●	80
8307638	M10 ×1.25			150	23	48	8.5	—	●	78
8307645	M12 ×1.75			150	25	48	10.5	—	●	114

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
HL-B-NRT																		◎	◎		◎					
HL-LT-B-NRT																		◎	◎		◎					

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1013

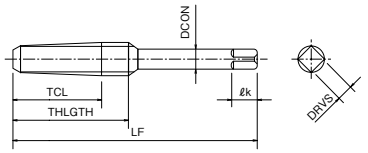
螺母丝锥

NUT TAPS (TAPPER TAPS)

NT

主要用于螺母的螺纹加工，从螺母的加工性考虑，螺纹部分的长度，柄部需要加长以适应连续加工。

These taps are used for producing nuts. The length of thread and long shank are used to accumulate the nuts, thereby increasing efficiency.



HSS

螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	全长 LF	螺纹长 THLGTH	切削锥长 TCL	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20013	M 2 × 0.4	2b	80	14	10.5	1.4	3	Yes	△	4
20018	M 2.3 × 0.4		80	14	10.5	1.6		Yes	△	4
20021	M 2.5 × 0.45		85	15	11	2		Yes	△	5
20023	M 2.6 × 0.45		85	15	11	2		Yes	△	5
20026	M 3 × 0.6		90	20	15	2.1		Yes	△	5
20027	M 3 × 0.5		90	20	15	2.1		Yes	●	5
20030	M 3.5 × 0.6		95	20	15	2.6		Yes	△	7
20033	M 4 × 0.75		100	25	18	2.8		Yes	△	8
20034	M 4 × 0.7		100	25	18	2.8		Yes	●	7
20035	M 4 × 0.5		100	18	14	2.8		Yes	△	8
20037	M 4.5 × 0.75		105	25	18	3.3		Yes	△	9
20039	M 5 × 0.9		110	30	23	3.6		Yes	△	8
20040	M 5 × 0.8		110	30	23	3.6		Yes	●	12
20042	M 5 × 0.5		110	20	15	3.6		Yes	△	13
20046	M 6 × 1		120	35	26	4.5		Yes	●	16
20047	M 6 × 0.75		120	28	21	4.5		Yes	△	17
20048	M 6 × 0.5		120	28	21	4.5		Yes	△	17
20049	M 7 × 1		130	35	26	5.5		—	△	25
20052	M 8 × 1.25		140	40	30	6.2		—	●	34
20053	M 8 × 1		140	38	28	6.2		—	△	34
20054	M 8 × 0.75		120	30	23	6.2		—	△	30
20056	M 9 × 1.25		150	45	34	7.2		—	△	42
20060	M 10 × 1.5		160	50	38	7.8		—	●	58
20061	M 10 × 1.25		160	48	36	7.8		—	△	59
20062	M 10 × 1		140	38	28	7.8		—	△	52
20065	M 11 × 1.5		165	55	41	8.8		—	△	73
20071	M 12 × 1.75		170	60	45	9		—	●	81
20072	M 12 × 1.5		170	58	43	9		—	△	81
20073	M 12 × 1.25		170	48	36	9		—	△	83
20074	M 12 × 1	2b	140	40	30	9	3	—	△	69
20078	M 13 × 1.5		190	58	43	10		—	△	103
20083	M 14 × 2		190	65	49	11		—	△	133
20084	M 14 × 1.5		190	58	43	11		—	△	132
20086	M 14 × 1		150	40	30	11		—	△	105
20095	M 16 × 2		200	70	53	13		—	△	189
20096	M 16 × 1.5		200	58	43	13		—	△	193
20098	M 16 × 1		160	42	32	13		—	△	153
20108	M 18 × 2.5		220	80	60	14		—	△	243
20109	M 18 × 2		220	75	56	14		—	△	229
20110	M 18 × 1.5		220	60	45	14		—	△	256
20119	M 20 × 2.5		230	85	64	16		—	△	325
20120	M 20 × 2		230	78	58	16		—	△	322
20121	M 20 × 1.5		230	60	45	16		—	△	315
20128	M 22 × 2.5		250	90	68	18		—	△	435
20129	M 22 × 2		250	78	58	18		—	△	445
20130	M 22 × 1.5		250	60	46	18		—	△	465
20136	M 24 × 3		260	100	75	19		—	△	517
20137	M 24 × 2		260	78	58	19		—	△	540
20138	M 24 × 1.5		260	60	46	19		—	△	516
20146	M 27 × 3		280	110	83	22		—	△	738
20148	M 27 × 1.5		280	65	49	22		—	△	784
20152	M 30 × 3.5		300	120	90	24		—	△	962
20155	M 30 × 1.5		300	65	49	24		—	△	1,024
20160	M 33 × 3.5		310	130	98	27	4	—	△	1,188
20163	M 33 × 1.5		310	68	51	27.5		—	△	1,361
20169	M 36 × 4		330	140	105	29		—	△	1,481
20172	M 36 × 1.5		330	68	51	29		—	△	1,628
20179	M 39 × 4		340	145	109	32		—	△	2,056

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. M4以下没有四方部。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Up to M4: without square on shank.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹种类：W

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	全长 LF	螺纹长 THLGTH	切削锥长 TCL	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20323	W 1/4 - 20	2b	125	42	32	4.5	3	Yes	△	17
20324	W 5/16 - 18		140	50	38	5.9		—	△	30
20325	W 3/8 - 16		155	55	41	7.3		—	△	49
20327	W 1/2 - 12		180	65	49	9.5		—	△	93
20329	W 5/8 - 11	2b	200	75	56	12.5	3	—	△	170
20330	W 3/4 - 10		230	85	64	15		—	△	285
20331	W 7/8 - 9		250	95	71	18		—	△	427
20332	W 1 - 8		270	105	79	20.5		—	△	606

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 丝锥精度不能保证内螺纹的精度。
2. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. TAP Limit does not guarantee thread limit for the internal thread after tapping.
2. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
NT		○										○	○	○	◎	○	○	○	◎	◎	◎				

库存记号 Inventory symbols

● = 标准库存品 Standard stock item

○ = 准标准库存品(请确认库存。) Limited standard stock item

▲ = 由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△ = 停产产品(请确认库存。) Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1013

螺母丝锥

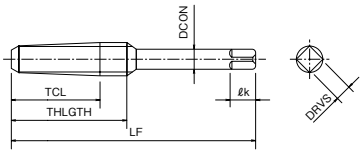
NUT TAPS (TAPPER TAPS)

NT

HSS

主要用于螺母的螺纹加工，从螺母的加工性考虑，螺纹部分的长度，柄部需要加长以适应连续加工。

These taps are used for producing nuts. The length of thread and long shank are used to accumulate the nuts, thereby increasing efficiency.



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	全长 LF	螺纹长 THLGTH	切削锥长 TCL	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20237	No. 6 - 32UNC	2b	95	28	21	2.2	3	Yes	△	6
20238	No. 6 - 40UNF		95	25	18	2.2		Yes	△	6
20240	No. 8 - 32UNC		105	28	21	2.9		Yes	△	7
20241	No. 8 - 36UNF		105	25	18	2.9		Yes	△	7
20243	No.10 - 24UNC		110	35	26	3.3		Yes	△	9
20244	No.10 - 32UNF		110	28	23.1	3.3		Yes	△	9
20251	1/4 - 20UNC		125	42	32	4.5		Yes	△	18
20252	1/4 - 28UNF		125	35	28.9	4.5		Yes	△	17
20254	5/16 - 18UNC		140	50	38	5.9		—	△	31
20255	5/16 - 24UNF		140	40	30	5.9		—	△	31
20257	3/8 - 16UNC		155	55	41	7.3		—	△	49
20259	3/8 - 24UNF		155	40	30	7.3		—	△	51

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. NO.8以下没有四方部。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	全长 LF	螺纹长 THLGTH	切削锥长 TCL	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20261	7/16 - 14UNC	2b	165	60	45	8.5	3	—	△	70
20262	7/16 - 20UNF		165	48	36	8.5		—	△	70
20264	1/2 - 13UNC		180	65	49	9.5		—	△	96
20267	1/2 - 20UNF		180	48	36	9.5		—	△	99
20274	5/8 - 11UNC		200	75	56	12.5		—	△	174
20275	5/8 - 18UNF		200	55	41	12.5		—	△	176
20277	3/4 - 10UNC		230	85	64	15		—	△	287
20278	3/4 - 16UNF		230	62	46	15		—	△	301
20280	7/8 - 9UNC		250	95	71	18		—	△	441
20281	7/8 - 14UNF		250	72	54	18		—	△	460
20283	1 - 8UNC		270	105	79	20.5		—	△	608
20284	1 - 12UNF		270	72	54	20.5		—	△	627

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Up to No.8: without square on shank.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

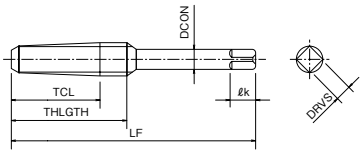
G-LIST No. | TH1014

螺母丝锥 中径加大用

NUT TAPS (TAPPER TAPS) • OVERSIZE

O-NT

HSS



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	全长 LF	螺纹长 THLGTH	切削锥长 TCL	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20351	M 3 × 0.5	OH3	90	20	15	2.1	3	Yes	△	5
20354	M 4 × 0.7		100	25	18	2.8		Yes	△	8
20357	M 5 × 0.8		110	30	23	3.6		Yes	△	10
20359	M 6 × 1		120	35	26	4.5		Yes	△	16
20361	M 8 × 1.25		140	40	30	6.2		—	△	33

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. M4以下没有四方部。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	全长 LF	螺纹长 THLGTH	切削锥长 TCL	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20369	M10 × 1.5	OH4	160	50	38	7.8	3	—	△	57
20372	M10 × 1.25	OH3	160	48	36	7.8		—	△	58
20380	M12 × 1.75	OH4	170	60	45	9		—	△	82
20382	M12 × 1.5		170	58	43	9		—	△	81

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Up to M4: without square on shank.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
NT		○										○	○	○	◎	○	○	○	◎	◎	◎					
O-NT		○										○	○	○	◎	○	○	○	◎	◎	◎					

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1037

加工中心用 长柄型

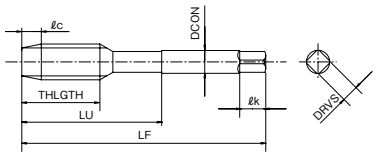
MACHINING CENTER TAPS (LONG SHANK)

EX-MCT

HSSE | H | 8° 左螺旋 Revers Flutes

用于加工中心，加工稳定。

The design of this tap helps eliminate flute clogging of horizontal machining centers, and provides stable and efficient operation.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20515	M 6 ×1	STD	OH2	3P	120	19	29	6	2	—	●	26
20523	M 8 ×1.25	STD	OH2		120	22	37	6.2		—	●	31
20532	M10 ×1.5	STD	OH3		150	24	41	7		—	●	49
20540	M10 ×1.25	STD	OH2		150	24	41	7		—	●	50
20548	M12 ×1.75	STD	OH3		150	29	48	8.5	3	—	●	70
20556	M12 ×1.5				150	29	48	8.5		—	●	70
20564	M12 ×1.25				150	29	48	8.5		—	●	71
20572	M14 ×2				150	30	48	10.5		—	●	101
20580	M14 ×1.5				150	30	48	10.5		—	●	102
20588	M16 ×2				150	32	52	12.5		—	●	141

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。
4. 盲孔的情况下，请务必留足够的底孔余量。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20596	M16 ×1.5	STD	OH3	3P	150	32	52	12.5	3	—	●	142
20604	M18 ×2.5	STD	OH4		200	37	55	14		—	●	236
20612	M18 ×1.5	STD	OH3		200	37	55	14		—	●	241
20620	M20 ×2.5	STD	OH4		200	37	58	15		—	●	272
20628	M20 ×1.5	STD	OH3		200	37	58	15	4	—	●	277
20636	M22 ×2.5	STD	OH4		200	38	63	17		—	●	338
20644	M22 ×1.5	STD	OH3		200	38	63	17		—	●	341
20652	M24 ×3	STD	OH4		200	45	66	19		—	●	426
20660	M24 ×1.5	STD	OH3		200	45	66	19		—	●	425

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
4. In the case of blind holes, make it as deep as possible.

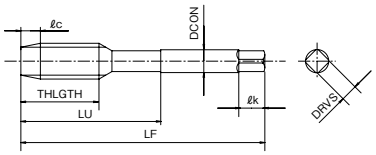
G-LIST No. | TH1063

加工中心用 短刃型

MACHINING CENTER TAPS (NORMAL LENGTH)

EX-S-MCT

HSSE | H | 8° 左螺旋 Revers Flutes



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20422	M 6 ×1	STD	OH2	3P	62	19	29	6	2	—	●	12
20428	M 8 ×1.25	STD	OH2		70	22	37	6.2		—	●	17
20434	M10 ×1.5	STD	OH3		75	24	41	7		—	●	25
20436	M10 ×1.25	STD	OH2		75	24	41	7		—	●	25
20439	M12 ×1.75	STD	OH3		82	29	48	8.5	3	—	●	39
20442	M12 ×1.5				82	29	48	8.5		—	●	39
20445	M12 ×1.25				82	29	48	8.5		—	●	40
20449	M14 ×2				88	30	48	10.5		—	●	64
20451	M14 ×1.5				88	30	48	10.5		—	●	64
20455	M16 ×2				95	32	52	12.5		—	●	91

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照 P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考 P.1004。
4. 盲孔的情况下，请务必留足够的底孔余量。

▲=该产品已停止生产，由 HXL-SFT(P.624)，LW-SFT(P.643)替代。

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	槽数 NOF	突顶尖 External Center	库存 Stock	重量 (g)
20457	M16 ×1.5	STD	OH3	3P	95	32	52	12.5	3	—	●	93
20461	M18 ×2.5	STD	OH4		100	37	55	14		—	▲	110
20463	M18 ×1.5	STD	OH3		100	37	55	14		—	▲	110
20467	M20 ×2.5	STD	OH4		105	37	58	15		—	▲	135
20469	M20 ×1.5	STD	OH3		105	37	58	15	4	—	▲	136
20473	M22 ×2.5	STD	OH4		115	38	63	17		—	▲	182
20475	M22 ×1.5	STD	OH3		115	38	63	17		—	▲	187
20479	M24 ×3	STD	OH4		120	45	66	19		—	▲	234
20481	M24 ×1.5	STD	OH3		120	45	66	19		—	▲	240

■Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.
4. In the case of blind holes, make it as deep as possible.

▲=The products have been stopped producing and replaced by HXL-SFT(p.624) and LW-SFT(p.643).

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
EX-MCT	◎	◎	○	○							◎	○	○						○		○				
EX-S-MCT	◎	◎	○	○							◎	○	○						○		○				

库存记号 Inventory symbols

●=标准库存品
Standard stock item

○=准标准库存品(请确认库存。)
Limited standard stock item

▲=由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△=停产产品(请确认库存。)
Discontinued item

■记号说明请参考 P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1001

钻攻一体式丝锥

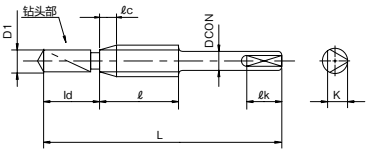
DRILL TAPS

DRT

HSS | 25° 仅钻头

通孔专用。
DRT are available for only through holes.

先端的钻头可进行攻丝前底孔加工，提高加工效率。
These taps have a drill point that allow you to make the hole and thread in one step. Combining these operations greatly improves productivity.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 L	钻头部长 ld	螺纹长 ℓ	钻头直径 D1	柄径 DCON	三角部长 ℓk	三角部宽 K	槽数 Flutes	库存 Stock	重量 (g)
22510	M 3 × 0.6	JIS3	5P	62	12	15	2.4	4	—	—	3	△	6
22511	M 3 × 0.5			62	12	15	2.5	4	—	—		●	6
22514	M 4 × 0.75			71	16	20	3.25	5	—	—		△	10
22515	M 4 × 0.7			71	16	20	3.3	5	—	—		●	9
22518	M 5 × 0.9			80	20	22	4.1	5.5	—	—		△	13
22519	M 5 × 0.8			80	20	22	4.2	5.5	—	—		●	13
22522	M 6 × 1			86	24	24	5	6	—	—		●	16
22525	M 8 × 1.25			102	32	30	6.75	6.2	24	5.9		●	25
22529	M 10 × 1.5			115	40	32	8.5	7.8	25	7.5		●	41
22530	M 10 × 1.25			115	40	32	8.75	7.8	25	7.5		△	42
22534	M 12 × 1.75			130	48	38	10.3	9	26	8.6		●	61
22535	M 12 × 1.5			130	48	38	10.3	9	26	8.6		△	60
22539	M 14 × 2			144	56	42	12	11	28	10.6		△	93
22540	M 14 × 1.5			144	56	42	12	11	28	10.6		△	95
22543	M 16 × 2			159	64	45	14	13	30	12.5		△	136
22544	M 16 × 1.5			159	64	45	14	13	30	12.5		△	135

1. W螺纹也有库存。
2. 切削油剂请参考P.1004。

1. Taps for Whitworth threads are available from stock.
2. Cutting fluid and Paste : Please refer to p.1004.

G-LIST No. | TH1132

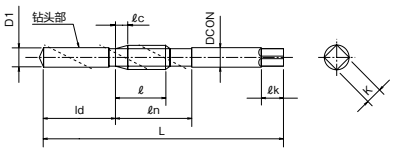
钻攻一体式螺旋槽丝锥

SPIRAL FLUTED TAP COMBINED WITH DRILL

V-DR-SFT

HSSE | V | 45° 丝锥 Taps | 45° 钻头 Drills

通孔专用。
DRT are available for only through holes.



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度标记 Grade	精度 TAP Limit	切削锥长 ℓc	全长 L	钻头部长 ld	螺纹长 ℓ	颈长 ℓn	钻头直径 D1	柄径 DCON	槽数 Flutes	库存 Stock	重量 (g)
22581	M 3 × 0.5	STD	OH3	2.5P	57	11	3.5	19	2.5	4	2	●	5
22583	M 4 × 0.7				65	13	4.9	21	3.35	5		●	8
22585	M 5 × 0.8				76	16	5.6	24	4.25	5.5		●	11
22587	M 6 × 1				81	19	7	29	5.05	6		●	17
22589	M 8 × 1.25				92	22	8.5	37	6.8	6.2		●	21
22591	M 10 × 1.5				99	24	10.5	41	8.55	7		●	30
22593	M 12 × 1.75				111	29	12	48	10.3	8.5		●	46

■突顶尖长 · 柄部四方部尺寸ℓk, DRVS请参考P.1009。

1. 精度栏 是适合加工2级内螺纹的丝锥推荐精度。(参照P.835)
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width K.

1. The recommended TAP Limit corresponds to JIS class 2 internal thread standard. (see p.835)
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
商品记号 Abbreviation	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25~35 HRC	35~45 HRC	45~50 HRC	50~60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC					
DRT												◎	○		◎	○	○		◎	◎	◎					
V-DR-SFT	◎										○			○				◎								

库存记号 Inventory symbols

●＝标准库存品
Standard stock item

○＝准标准库存品(请确认库存。)
Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。)
Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。)
Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

G-LIST No. | TH1162

内螺纹修补用

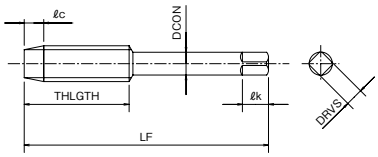
SPATTER REMOVE HAND TAP

SR-HT

适用于内螺纹溶屑及切屑的清除。

Suitable for removing spatters and chips from internal thread.

HSSE



螺纹种类：M

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	槽数 NOF	库存 Stock	重量 (g)
28730	M 5 ×0.8			60	22	5.5	—		●	8
28731	M 6 ×1	–0.06	5P	62	24	6	—	3	●	13
28732	M 8 ×1.25			70	30	6.2	—		●	20
28733	M10×1.25			75	32	7	—		●	30
28734	M12×1.25	–0.06	5P	80	38	8.5	—	4	●	46
28735	M14×1.5			88	42	10.5	—		●	75

螺纹种类：U

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削长 ℓc	全长 LF	螺纹长 THLGTH	柄径 DCON	突顶尖 External Center	槽数 NOF	库存 Stock	重量 (g)
28740	7/16 - 20UNF	–0.06	5P	80	38	8	—	3	●	40

■突顶尖长・柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 切削油剂请参考 P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. Cutting fluid and Paste : Please refer to p.1004.

■零件 Accessories

丝锥尺寸 Tap Size	螺母 Nut 商品号 EDP No.	螺母 Nut 尺寸 Type	螺母 Nut 库存 Stock		夹管 Tube 商品号 EDP No.	夹管 Tube 尺寸 Type	夹管 Tube 库存 Stock	
M 5	79801	M5	●		79901	M5	●	
M 6	79802	M6	●		79902	M6	●	
M 8	79803	M8	●		79903	M8	●	
M10	79804	M10	●		79904	M10	●	
M12	79805	M12	●		79905	M12	●	
M14	79806	M14	●		79906	M14	●	
7/16 UNF	79807	7/16U	●		79907	7/16U	●	

溶屑粘着 (GP:NG)
Spatter

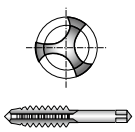
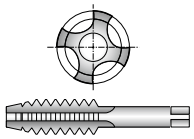
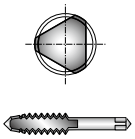
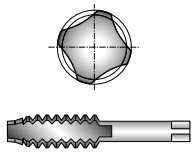
SR-HT 使用
After using

溶屑去除 (GP:OK)
Spatter

特点 Features

①可以简单地修补内螺纹 Easy to repair internal threads

切削功能及导向功能具备 From cutting function to guiding function

	～M8	M10～
HT		
SR-HT		

■无切削刃 No lip
■心厚大 Wide web
■螺纹扩大 Wide threads

内螺纹无损 no galling of internal threads
防止折损 prevents breakage
重视导向 for proper guiding

②可使用气动工具

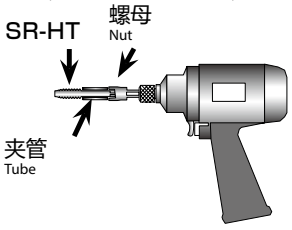
Can also be used with air tools

使用螺母可装夹气动工具，对应高转速。

无切削刃设计可进行稳定地进牙。

Can be attached to an air tool by using a nut.

Supports high-speed operations!
Because they do not have lips, they can pitch feed reliably.



使用夹管固定，防止振动及接触等危险产生。
By holding on to the tube, the operator can protect himself from the danger of a runout and a free hand.

实现安全、稳定、迅速、简单地作业!
Operates safely, reliably, efficiently, and simply!

库存记号 Inventory symbols

●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

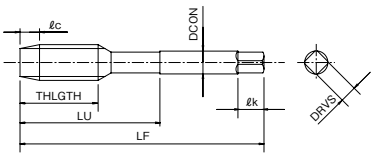
G-LIST No. | TH1166

照相机三角架螺纹用

TAPS FOR SCREW THREADS FOR CAMERA TRIPOD CONNECTIONS

TRP-SFT

HSSE



螺纹种类：U

单位:mm Unit:mm

商品号 EDP No.	螺纹尺寸 Thread Size	精度 TAP Limit	切削锥长 ℓc	全长 LF	螺纹长 THLGTH	颈长 LU	柄径 DCON	突顶尖 External Center	库存 Stock	重量 (g)
29102	1/4 - 20	OH9	1.5P	62	19	29	6	—	●	12
29103	3/8 - 16	OH12	1.5P	75	24	—	7	—	●	24

■突顶尖长 · 柄部四方部尺寸 ℓk, DRVS 请参考 P.1009。

1. 精度栏 是根据JISB7103三脚架部规定的内螺纹精度所对应的丝锥推荐精度。
2. 丝锥精度不能保证内螺纹的精度。
3. 切削油剂请参考P.1004。

■ Please see p.1009 for length of external center and shank square length ℓk and width DRVS.

1. The recommended tap tolerance list is based on JIS B7103 standard for Tripod screw for camera.
2. TAP Limit does not guarantee thread limit for the internal thread after tapping.
3. Cutting fluid and Paste : Please refer to p.1004.

螺纹尺寸	底孔径 最小 ～ 最大
1/4-20	4.975 ～ 5.267
3/8-16	7.806 ～ 8.163

加工材料 Work Material / 商品记号 Abbreviation	低碳素钢 Low Carbon Steel Mild Steel	中碳素钢 Medium Carbon Steel	高碳素钢 High Carbon Steel	合金钢 Alloy Steel	调质钢 Hardened Steel				不锈钢 Stainless Steel	工具钢 Tool Steel	铸钢 Cast Steel	铸铁 Cast Iron	球墨铸铁 Ductile Cast Iron	铜 Copper	黄铜 Brass	黄铜铸件 Brass Casting	青铜 Bronze	变形铝 Aluminum Rolled	铝合金铸件 Aluminum Alloy Casting	镁合金铸件 Magnesium Alloy Casting	锌合金铸件 Zinc Alloy Casting	钛合金 Titanium Alloy	镍基合金 Nickel Alloy	热硬化性塑料 Thermo Setting Plastic	热可塑性塑料 Thermo Plastic
	C ~0.25%	C0.25% ~0.45%	C 0.45% ~	SCM	25～35 HRC	35～45 HRC	45～50 HRC	50～60 HRC	SUS	SKD	SC	FC	FCD	Cu	Bs	BsC	PB	AL	AC,ADC	MC	ZDC				
TRP-SFT		○		○									○	○	○	○	○	○	○	○	○				○

库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

■记号说明请参考P1页。 See p.1 for explanation of icons.

用途
用于螺母的自动连续生产。

Applications
The bent shank tap is used with automatic tapping machines that eject nuts via the shank. This enables continuous tapping operation without reversing or stopping the machine.

曲柄丝锥
BENT-SHANK TAP

用途
2 支丝锥结合在一起的复合式丝锥。有增径式和异径式两大类。

Applications
This tap is capable of slightly increasing the size of already-cut, large thread, or it can be used to cut thread of different sizes in the same hole (but same pitch) .

异径阶梯丝锥
TANDEM TAP

用途
用于直径比较大的螺纹加工。螺纹部分为中空必须配上柄部才可使用。

Applications
This tap is attached to an arbor for larger thread cutting operations.

中空丝锥
SHELL TAP

用途
医疗专用丝锥。用于骨科及牙科等场合材质为不锈钢。

Applications
These taps are designed specifically for medical purposes, usually in bones of the human body. For example, these taps are used to make a hole in the jaw for the insertion of an artificial root for a tooth.

医疗用丝锥
MEDICAL TAPS

用途
先端具有导向部。底孔和内螺纹的同轴度好。在螺距较大的梯形螺纹加工中可发挥出较好效果。

Applications
The pilot at the head is used to achieve same-axis precision between the drill hole and the internal thread, and between the drill hole and the tap. It is especially effective for tapping trapezoidal screw threads with a coarse pitch.

先端导向式丝锥
TAP WITH PILOT GUIDE

用途
滚珠螺纹的螺母加工丝锥牙型为滚珠。

Applications
This tap is for processing nuts for ball screws. The round shape of the thread profile is used for the feed screw of machine tools and power steering systems for automobiles.

滚珠螺纹用丝锥
TAP FOR BALL SCREW

用途
前端有铰刀，铰加工和攻丝加工同时进行的丝锥。

Applications
This tap can simultaneously ream and cut thread. The tool can be used either to finish a drill hole diameter or to make holes that are not for tapping.

铰攻一体式丝锥
TAP WITH REAMER

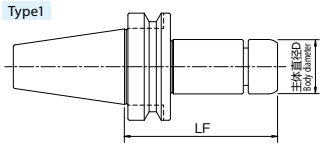
G-LIST No. | SS1022 NEW SIZES

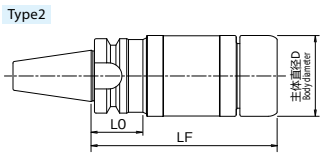
攻丝刀柄
TAP HOLDER

SynchroMaster

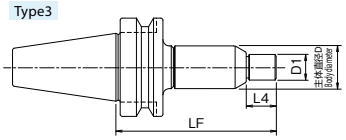
售价请咨询我司销售人员
Contact your local OSG sales representative for information regarding pricing

BT主轴刀柄 BT Shank Holder





WBT-AHO · A主轴刀柄 WBT-AHO · A Shank Holder



BT主轴刀柄 BT Shank Holder

单位:mm Unit:mm

商品号 EDP No.	品名 Designation	LF	形状 Type	L0	L4	主体直径D Body diameter	螺母直径D1 Nut diameter	重量 (kg)	刀柄尺寸 Holder Size	适用夹套 Applicable Collet	丝锥尺寸 Tap Size
※ 76900	BT30-SMH8-75	75	3	—	14	20	12	0.5	SMH8	ER8GH ER8GHC	M1～M3.5
※ 76901	BT40-SMH8-80	80	3	—				1.1			
79910	BT30-SMH16-90	90	1	—	—	32	—	0.7	SMH16	ER16GH ER16GHC	M3～M12 PT 1/16、PT 1/8
※ 79962	BT30-SMH16-120	120	1	—				0.9			
79911	BT40-SMH16-90	90	1	—				1.2			
※ 79963	BT40-SMH16-120	120	1	—				1.4			
※ 79927	BT50-SMH16-105	105	1	—				3.8			
※ 79964	BT50-SMH16-150	150	1	—				4.1			
※ 79966	BT30-SMH32-120	120	2	37	—	50	—	1.4	SMH32	ER32GH ER32GHC	M10～M20 注1 Note1 PT 1/16～PT 3/8
※ 79967	BT40-SMH32-120	120	1	—				1.9			
※ 79968	BT50-SMH32-125	125	1	—				4.4			

注1：切削丝锥通用加工时推荐M10~M20。高硬度材料或成型丝锥时推荐M10~M16。
Note 1: M10 to M20 is recommended for general-purpose cutting taps. M10 to M16 is recommended for high hardness materials and forming taps.

※= NEW SIZES

请与带同步进给功能的设备配合使用。Please use a machine with synchronous feed capability.

WBT-AHO（双面拘束主轴）主轴刀柄 WBT-AHO·A (Dual-Contact BT) Shank Holder

单位:mm Unit:mm

商品号 EDP No.	品名 Designation	LF	形状 Type	L4	主体直径D Body diameter	螺母直径D1 Nut diameter	重量 (kg)	刀柄尺寸 Holder Size	适用夹套 Applicable Collet	丝锥尺寸 Tap Size
※ 76902	WBT-AHO30A-SMH8-75	75	3	14	20	12	0.4	SMH8	ER8GH ER8GHC	M1～M3.5
※ 79937	WBT-AHO30A-SMH16-90	90	1	—	32	—	0.6	SMH16	ER16GH ER16GHC	M3～M12 PT 1/16、PT 1/8
※ 79938	WBT-AHO40A-SMH16-90	90					1.1			

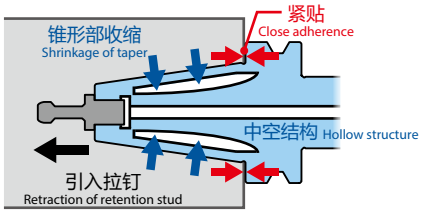
1. WBT-AHO · A主轴刀柄请使用与BT主轴刀柄相同的牵引螺栓。
当使用中心内冷时，需要使用中心内冷专用的牵引螺栓。
2. 使用旧AHO主轴刀柄（WBT-AHO30-SMH8-75、WBT-AHO30-SMH16-90、WBT-AHO40-SMH16-90）专用带冷却管道的牵引螺栓时，请取下冷却管道后使用。

※= NEW SIZES

1. Please use the BT shank retention stud for the WBT-AHO·A shank. When using center-through coolant, a retention stud compatible with center-through coolant is required.
2. Remove the coolant pipe before use for retention studs with a coolant pipe that are dedicated to the old AHO shank (WBT-AHO30-SMH8-75, WBT-AHO30-SMH16-90, WBT-AHO40-SMH16-90).

请与带同步进给功能的设备配合使用。Please use a machine with synchronous feed capability.

■AHO·A的特点 Features of AHO·A (AHO·A：Accurate Hollow)



·通过中空结构实现轻量化
Lightweight with hollow structure

·由于牵引螺栓的引入使锥形部收缩，端面紧贴
Taper shrinkage occurs by the retraction of the retention stud, causing the end surfaces to adhere tightly

※高速同步加工丝锥在使用时推荐带有同步进给功能的设备与刚性攻丝刀柄
*Synchro Tap is recommended to be used in combination with a solid holder and machine with synchronous feed mechanism

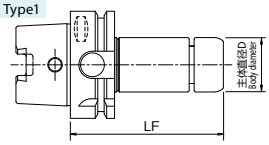
机械 Machine	刀柄 Holder	丝锥（例） Tap (example)	推荐 Recommendation
带同步进给功能的设备 Machine with synchronous feed mechanism	SynchroMaster	A-TAP (A-SFT、A-POT) A-tap 挤压丝锥 (XPF) Forming tap	◎
		通用丝锥 General purpose tap (EX-SFT、TIN-POT)	○
		同步进给丝锥 Synchro tap (HS-SFT、US-AL-RFT)	—※

◎: best ○: good

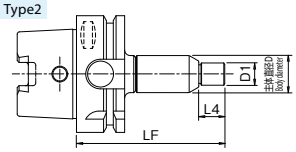
■ 弹簧夹套与扳手需另行购买。The collet and spanner are sold separately.
■ 对应丝锥尺寸请参照p.833 ~ 834的“对应丝锥尺寸”一栏。For corresponding tap size, please refer to the "corresponding tap size" column on p.833~834.

HSK 主轴刀柄 HSK Shank Holder

Type1

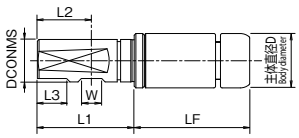


Type2

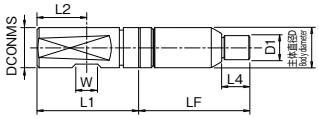


ST 主轴刀柄 ST Shank Holder

Type1



Type2



HSK 主轴刀柄 HSK Shank Holder

单位:mm Unit:mm

商品号 EDP No.	品名 Designation	LF	形状 Type	L4	主体直径D Body diameter	螺母直径 D1 Nut diameter	重量 (kg)	刀柄尺寸 Holder Size	适用夹套 Applicable Collet	丝锥尺寸 Tap Size
※ 76903	HSK63A-SMH8-80	80	2	14	20	12	0.8	SMH8	ER8GH ER8GHC	M1～M3.5
79912 注2 Note2	HSK40A-SMH16-85	85	1	—	32	—	0.5	SMH16	ER16GH ER16GHC	M3～M12 PT 1/16、PT 1/8
79913	HSK63A-SMH16-90	90					0.9			
※ 79965	HSK63A-SMH16-120	120					1.1			
※ 79969	HSK63A-SMH32-108	108	1	—	50	—	1.5	SMH32	ER32GH ER32GHC	M10～M20 注3 Note3 PT 1/16～PT 3/8

1．附带冷却管道。 1. Coolant hose is included. ※= NEW SIZES

注2：HSK40A 无手动夹持孔。 Note 2: The HSK40A does not have manual clamp holes.

注3：切削丝锥通用加工时推荐 M10~M20。高硬度材料或成型丝锥时推荐 M10~M16。

Note 3: M10 to M20 is recommended for general-purpose cutting taps. M10 to M16 is recommended for high hardness materials and forming taps.

请与带同步进给功能的设备配合使用。Please use a machine with synchronous feed capability.

ST 主轴刀柄 (DIN1835B＋E) ST Shank Holder

单位:mm Unit:mm

商品号 EDP No.	品名 Designation	LF	形状 Type	L1	L2	L3	L4	柄径 DCONMS	W	主体直径D Body diameter	螺母直径D1 Nut diameter	重量 (kg)	刀柄尺寸 Holder Size	适用夹套 Applicable Collet	丝锥尺寸 Tap Size
※ 76904 注4 Note4	ST20D-SMH8-55	55	2	51	25	—	14	20	11	20	12	0.2	SMH8	ER8GH ER8GHC	M1～M3.5
※ 79924 注4 Note4	ST20D-SMH16-68	68	1	51	25	—	—	20	11	32	—	0.4	SMH16	ER16GH ER16GHC	M3～M12 PT 1/16、PT 1/8
※ 79925	ST25D-SMH16-68	68		57	32	17	—	25	12		—	0.5			

注4：ST20D 无 L3 平面部。 Note 4: The ST20D does not include the L3 flat section. ※= NEW SIZES

请与带同步进给功能的设备配合使用。Please use a machine with synchronous feed capability.

附件 Accessories

卡帽 Nut	商品号 EDP No.	品名 Designation	适用刀柄尺寸 Applicable Holder Size
	76909	ERP-8T	SMH8
	79922	ERP-16T	SMH16
	79992	ERP-32T	SMH32

扳手 Spanner	商品号 EDP No.	品名 Designation	适用刀柄尺寸 Applicable Holder Size
	76910	S-8E	SMH8
	79923	FKT-32L	SMH16
	79993	FKT-50L	SMH32

· 另有扭矩扳手(可订购)。详情请咨询我司销售人员。

The wrench is sold separately. Please contact your sales representative for details.

SynchroMaster (刀柄＋卡帽 Holder + Nut) 弹簧夹套(另售) Collet (sold separately) 扳手(另售) Spanner (sold separately)

■ 弹簧夹套与扳手需另行购买。TThe collet and spanner are sold separately.

■ 对应丝锥尺寸请参照 p.833 ~ 834的 “对应丝锥尺寸” 一栏。For corresponding tap size, please refer to the "corresponding tap size" column on p.833~834.

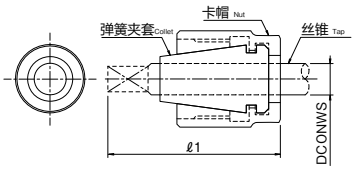
G-LIST No. | SS1022 NEW SIZES

攻丝刀柄
TAP HOLDER

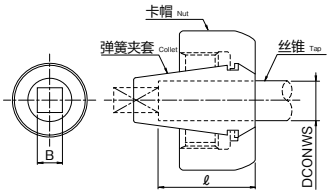
SynchroMaster Collet 专用弹簧夹套

售价请咨询我司销售人员
Contact your local OSG sales representative for information regarding pricing

SMH8



SMH16、SMH32



SMH8用 For SMH8

单位:mm Unit:mm

		商品号 EDP No.	品名 Designation	丝锥柄径 DCONWS	ℓ1	对应丝锥尺寸 Corresponding Tap Size 旧 JIS Old JIS	对应丝锥尺寸 立铣刀柄 End Mill Shank	标准紧固扭矩 Standard Tightening Torque
ER8GH 外部供油用 for external coolant supply		※76905	ER8GH-3	3	23	M1～M2.6	–	5～7N·m
		※76907	ER8GH-4	4	23	M3、M3.5	M3	
ER8GHC 内冷弹簧夹套用 for collet-through		※76906	ER8GHC-3	3	23	M1～M2.6	–	5～7N·m
		※76908	ER8GHC-4	4	23	M3、M3.5	M3	

※= NEW SIZES

1. SMH8仅支持内冷弹簧夹套，不支持中心内冷。
2. 请正确确认所使用丝锥的各部分尺寸，选择正确的丝锥夹套。
3. 紧固扭矩请使用扭矩扳手进行确认。
4. 请将丝锥的柄部插入超出夹套内径的长度 (图1)。
5. 请不要用夹套夹住丝锥的柄部四方角。
   由于ER8弹簧夹套无角孔，这是导致弹簧夹套破损、握持力低、精度低的原因 (图1)。
6. 请不要用夹套夹住丝锥的切削刀部。这样会导致精度降低 (图1)。
7. 当使用内冷弹簧夹套时，请勿将丝锥插入刀柄最里面。这将堵住冷却液流出路径，使冷却液无法正常流出 (图2)。
8. 请使用冷却液压力在7MPa以下。

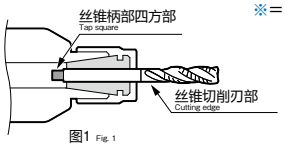


图1 Fig. 1

1. SMH8 only supports collet-through, not center-through.
2. Select the appropriate collet after confirming the dimensions of the tap to be used.
3. Please confirm the tightening torque with a torque spanner or similar tool.
4. Insert the shank of the tap beyond the collet's inner diameter length (Fig. 1).
5. Do not chuck the tap shank square with the collet.
   The ER8 collet does not have a square hole, which can cause damage to the collet, reduce chucking force, and reduce accuracy (Fig. 1).
6. Do not chuck the cutting edge of flute to the tap. This may decrease the accuracy (Fig. 1).
7. When using the collet-through coolant, do not insert the tap to the end of the holder bore. It will block the coolant path and coolant will not be dispensed properly (Fig. 2).
8. Use coolant pressure under 7MPa.

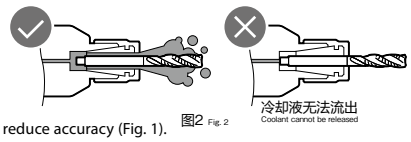
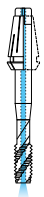


图2 Fig. 2

SMH16用 For SMH16

单位:mm Unit:mm

		商品号 EDP No.	品名 Designation	丝锥柄径 DCONWS	四方部 B	ℓ	对应丝锥尺寸 Corresponding Tap Size 旧 JIS Old JIS	对应丝锥尺寸 立铣刀柄 End Mill Shank	标准紧固扭矩 Standard Tightening Torque
ER16GH 中心内冷及外部供油用 for center-through and external coolant supply		79914	ER16GH -4 -3.2	4	3.2	15	M3	M3	30～35N·m
		79915	ER16GH -5 -4	5	4	18	M4	–	
		79916	ER16GH -5.5- 4.5	5.5	4.5	18	M5	–	
		79917	ER16GH -6 -4.5	6	4.5	18	M6	M4、M5、M6	
		79918	ER16GH -6.2- 5	6.2	5	18	M8	–	
		79919	ER16GH -7 -5.5	7	5.5	18	M10	–	45～50N·m
		79920	ER16GH -8 -6	8	6	22	PT 1/16、PT 1/8	M8、M10	
		79921	ER16GH -8.5- 6.5	8.5	6.5	22	M12	–	
ER16GHC 内冷弹簧夹套用 for collet-through		※79929	ER16GHC- 4 -3.2	4	3.2	15	M3	M3	30～35N·m
		※79930	ER16GHC- 5 -4	5	4	18	M4	–	
		※79931	ER16GHC- 5.5- 4.5	5.5	4.5	18	M5	–	
		※79932	ER16GHC- 6 -4.5	6	4.5	18	M6	M4、M5、M6	
		※79933	ER16GHC- 6.2- 5	6.2	5	18	M8	–	
		※79934	ER16GHC- 7 -5.5	7	5.5	18	M10	–	45～50N·m
		※79935	ER16GHC- 8 -6	8	6	22	PT 1/16、PT 1/8	M8、M10	
		※79936	ER16GHC- 8.5- 6.5	8.5	6.5	22	M12	–	

使用注意请参见p.834。 See p.834 for precaution for use.

※= NEW SIZES

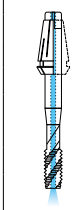
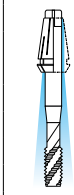
■弹簧夹套选择表 Collet Selection Table

机械 Machine	丝锥油孔 Tap Oil Hole	夹套 Collet
内部供油（中心内冷） Internal coolant supply (center-through)	有 Yes	GH型※ GH Type
内部供油（内冷弹簧夹套） Internal coolant supply (collet-through)	无 None	GHC型 GHC Type
外部供油 External coolant supply	无 None	GH型 GH Type

※ER8GH不支持中心内冷
ER8GH does not support center-through

SMH32用 For SMH32

单位:mm Unit:mm

		商品号 EDP No.	品名 Designation	丝锥柄径 DCONWS	四方部 B	ℓ	对应丝锥尺寸 Corresponding Tap Size 旧JIS Old JIS	对应丝锥尺寸 Corresponding Tap Size 立铣刀柄 End Mill Shank	标准紧固扭矩 Standard Tightening Torque
ER32GH 中心内冷及外部供油用 for center-through and external coolant supply		※ 79970	ER32GH - 7 - 5.5	7	5.5	18	M10	—	100～105N·m
		※ 79971	ER32GH - 8 - 6	8	6	22	PT 1/16、PT 1/8	M8、M10	
		※ 79972	ER32GH - 8.5 - 6.5	8.5	6.5	22	M12	—	
		※ 79973	ER32GH - 10 - 8	10	8	25	—	M12	
		※ 79974	ER32GH - 10.5 - 8	10.5	8	25	M14	—	
		※ 79975	ER32GH - 11 - 9	11	9	25	PT 1/4	—	
		※ 79976	ER32GH - 12 - 9	12	9	25	—	M14	
		※ 79977	ER32GH - 12.5 - 10	12.5	10	25	M16	—	
		※ 79978	ER32GH - 14 - 11.2	14	11.2	25	M18、PT 3/8	—	
		※ 79979	ER32GH - 15 - 12	15	12	25	M20	—	
		※ 79980	ER32GH - 16 - 12	16	12	25	—	M16、M20	
ER32GHC 内冷弹簧夹套用 for collet-through		※ 79981	ER32GHC - 7 - 5.5	7	5.5	18	M10	—	100～105N·m
		※ 79982	ER32GHC - 8 - 6	8	6	22	PT 1/16、PT 1/8	M8、M10	
		※ 79983	ER32GHC - 8.5 - 6.5	8.5	6.5	22	M12	—	
		※ 79984	ER32GHC - 10 - 8	10	8	25	—	M12	
		※ 79985	ER32GHC - 10.5 - 8	10.5	8	25	M14	—	
		※ 79986	ER32GHC - 11 - 9	11	9	25	PT 1/4	—	
		※ 79987	ER32GHC - 12 - 9	12	9	25	—	M14	
		※ 79988	ER32GHC - 12.5 - 10	12.5	10	25	M16	—	
		※ 79989	ER32GHC - 14 - 11.2	14	11.2	25	M18、PT 3/8	—	
		※ 79990	ER32GHC - 15 - 12	15	12	25	M20	—	
		※ 79991	ER32GHC - 16 - 12	16	12	25	—	M16、M20	

※＝NEW SIZES

1. 使用中心内冷或内冷弹簧夹套时务必将丝锥插入弹簧夹套底部。刀具插入长度过短时会发生冷却液的泄露。
2. 请正确确认所使用丝锥的各部分尺寸，选择正确的丝锥夹套。
3. 紧固扭矩请使用扭矩扳手进行确认。
4. 如果需使用管用丝锥时，请使用A丝锥或长柄型丝锥的平行管螺纹型。
5. 切削丝锥通用加工时推荐M10~M20。高硬度材料或成型丝锥时推荐M10~M16。
6. 使用SMH16的GHC型夹套时，请将预置螺钉拧到刀柄最里面的状态下使用（图3）。
7. 请使用冷却液压力在7MPa以下。

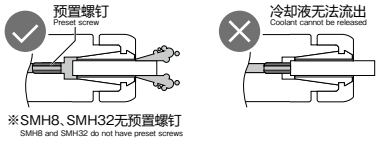


图3 Fig. 3

1. For center-through and collet-through coolant systems, please insert the tool all the way to the back of the collet. Coolant leakage may occur if the tool insertion length is too short.
2. Select the appropriate collet after confirming the dimensions of the tap to be used.
3. Please confirm the tightening torque with a torque spanner or similar tool.
4. When using pipe taps, please use A-Taps or long shank taps.
5. M10 to M20 is recommended for general-purpose cutting taps. M10 to M16 is recommended for high hardness materials and forming taps.
6. When using the SMH16 GHC type collet, make sure that the preset screw is screwed all the way into the holder (Fig. 3).
7. Use coolant pressure under 7MPa.

OH精度 OH LIMIT

OSG的专用丝锥，在满足螺纹精度的前提下，为了使操作者能够根据不同加工条件而选择丝锥精度，采用了独特的阶梯精度方式，即OH精度。

OSG applies a unique system of tap pitch diameter limits. We call it the OH Limit System. Using the step method, you can select the best tap pitch diameter limits to match your work conditions.

OH 精度 OH LIMIT

几乎所有研磨丝锥都适应此精度。该精度具有JIS2级等同或同等以上的精度，根据螺距将丝锥中径按下划分。
Most of OSG'S ground finished taps use this limit system. The limits are calculated as follows.

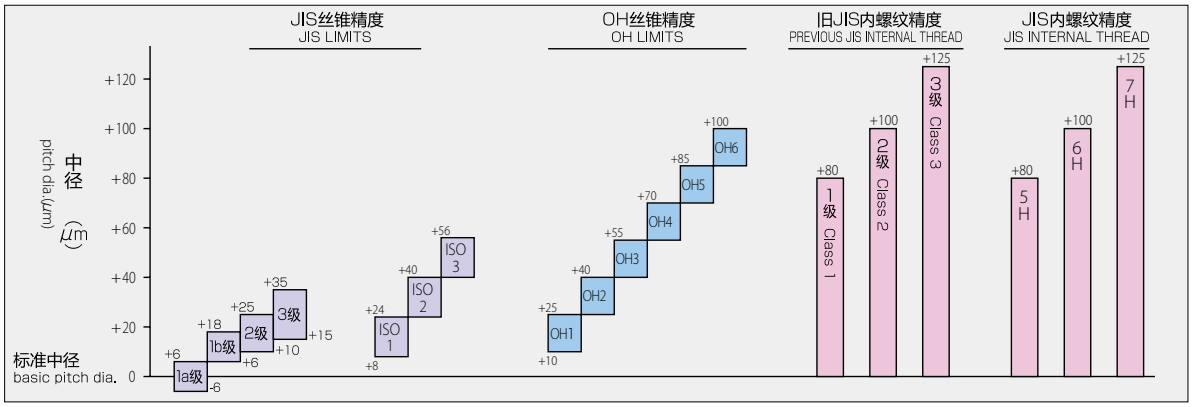
1. P≦0.6(40牙以上) P≦0.6(T.P.I.≧40)

上公差：0.010+0.015×n upper limit : 0.010+0.015×n
下公差：上公差−0.015 lower limit : (upper limit) −0.015
单位： mm Unit : mm (n=OH号) (n=OH number)

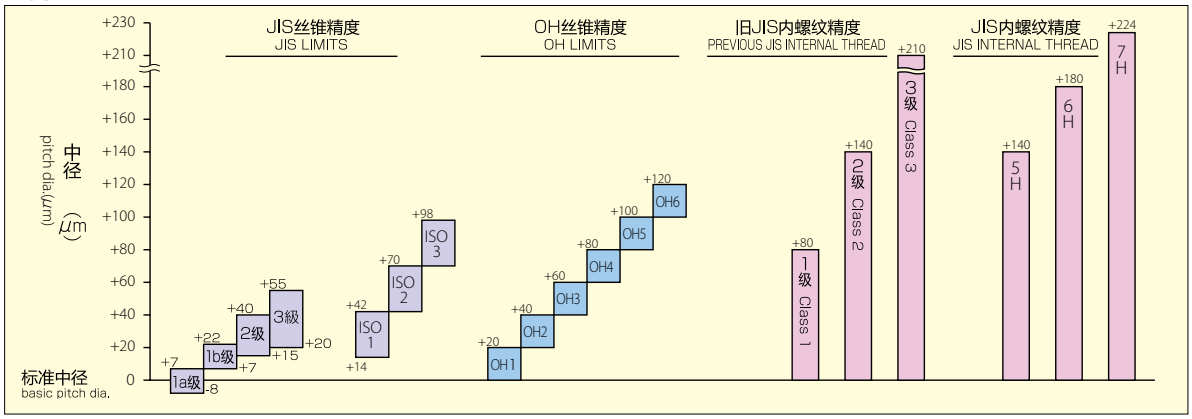
2. P≧0.7(36牙以下) P≧0.7(T.P.I.≦36)

上公差：0.020×n upper limit : 0.020×n
下公差：上公差−0.020 lower limit : (upper limit) −0.020
单位：mm Unit : mm (n=OH号) (n=OH number)

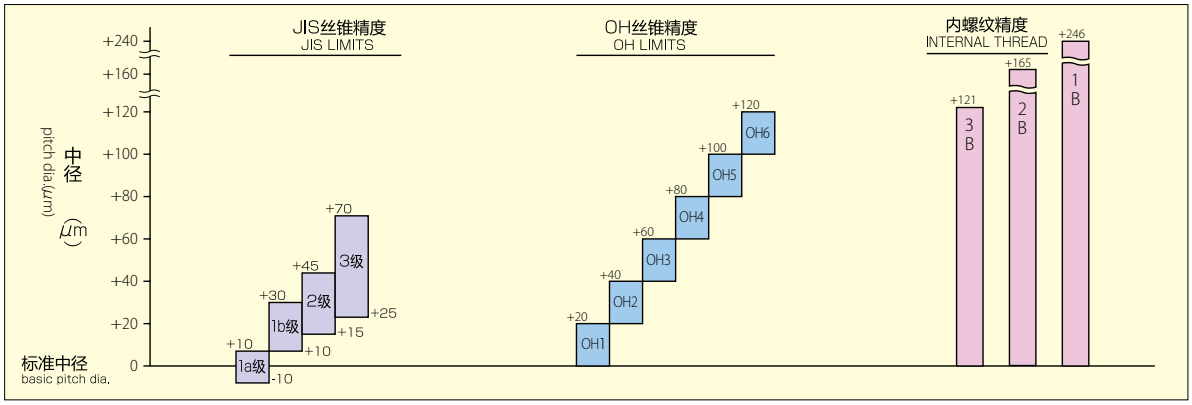
■例 M3×0.5 Example M3×0.5



■例 M10×1.5 Example M10×1.5



■例 ½-13UNC Example ½-13UNC



RH精度 RH LIMIT

OSG的挤压丝锥(NRT丝锥，HRT丝锥)利用塑性变形原理来加工内螺纹，其底孔管理较切削丝锥更为严格，因而丝锥精度也要求更为严格。OSG公司采用了公差为12.7μM。

OSG's fluteless taps(NRT, HRT)are described by the RH Limit system. The limits are established in increments of 12.7μm.

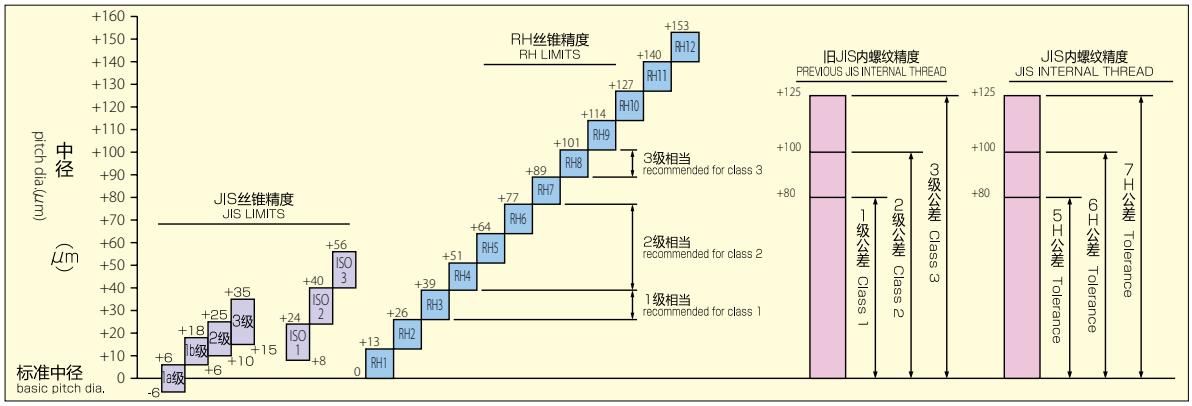
RH 精度 RH LIMIT

上公差：0.0127 × n upper limit : 0.0127 × n

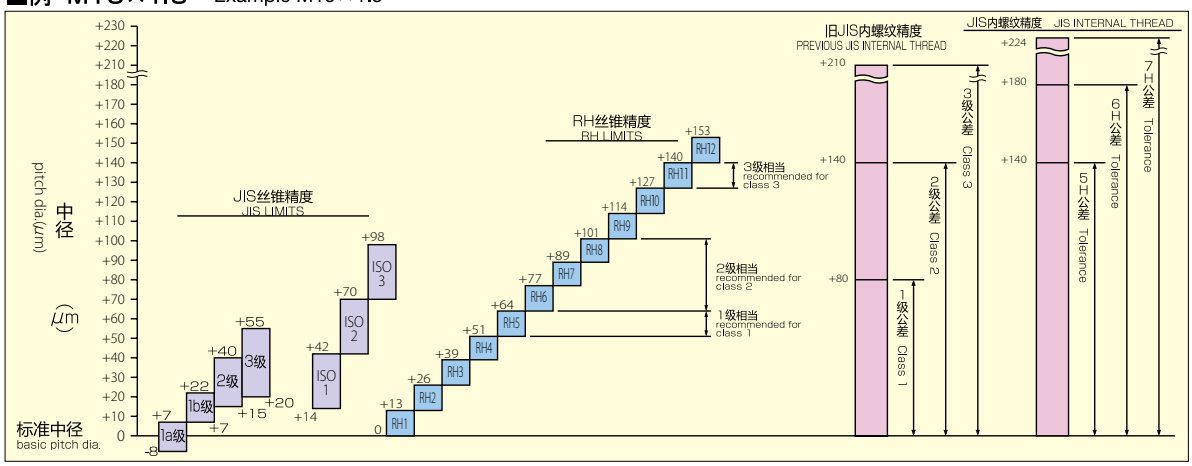
下公差：上公差－ 0.0127 lower limit : 0.0127 × n － 0.0127

单位：mm Unit : mm (n=RH 号) (n=RH number)

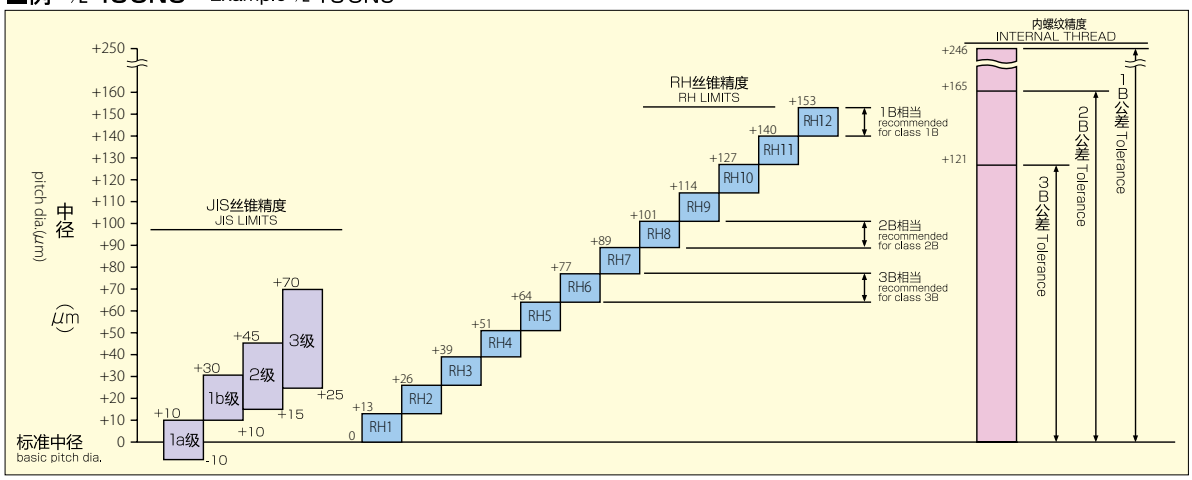
■例 M3×0.5 Example M3×0.5



■例 M10×1.5 Example M10×1.5



■例 ½-13UNC Example ½-13UNC



形状尺寸表 SPECIFICATION CHARTS A-SFT ▶ P.583
形状尺寸表 SPECIFICATION CHARTS A-LT-SFT ▶ P.591
形状尺寸表 SPECIFICATION CHARTS A-SPT ▶ P.796
形状尺寸表 SPECIFICATION CHARTS A-SFT HL ▶ P.815
形状尺寸表 SPECIFICATION CHARTS A-LT-SFT HL ▶ P.816

切削条件基准表 CUTTING CONDITIONS

■ A-SFT・A-LT-SFT (～ M24、2.5P)

		切削速度 (m/min) Cutting Speed 0 5 10 15 20 30 40 50 60 70 75
中・高碳素钢 Medium Carbon Steel High Carbon Steel	S45C	5—15 / 15—50 / 50—75
合金钢 Alloy Steel	SCM	5—10 / 10—15 / 15—30
一般构造用钢 Mild Steel	SS400	5—20 (*)
不锈钢 Stainless Steel	SUS304 SUS420	5—10 / 10—15
铝 Aluminum	AC ADC	5—50
球墨铸铁 Ductile Cast iron	FCD	5—50

■ A-SFT (～ M24、短切削锥1.5P・1P Short Chamfer)・A-SFT HL・A-LT-SFT HL

		切削速度 (m/min) Cutting Speed 0 5 10 15 20 30 40 50 60 70 75
中・高碳素钢 Medium Carbon Steel High Carbon Steel	S45C	3—15 / 15—30
合金钢 Alloy Steel	SCM	3—8 (*)
一般构造用钢 Mild Steel	SS400	3—20 (*)
不锈钢 Stainless Steel	SUS304 SUS420	3—8 (*)
铝 Aluminum	AC ADC	3—30 (*)
球墨铸铁 Ductile Cast iron	FCD	3—15

■ A-SFT (M27 ～、2.5P)・A-SFT(U)・A-SPT(G)

		切削速度 (m/min) Cutting Speed 0 5 10 15 20 30 40 50 60 70 75
中・高碳素钢 Medium Carbon Steel High Carbon Steel	S45C	3—8 / 8—15
合金钢 Alloy Steel	SCM	3—8 / 8—15
一般构造用钢 Mild Steel	SS400	3—15 (*)
不锈钢 Stainless Steel	SUS304 SUS420	3—8
铝 Aluminum	AC ADC	3—20
球墨铸铁 Ductile Cast iron	FCD	3—15

■ A-SFT・A-LT-SFT (铣刀柄 End Mill Shank)

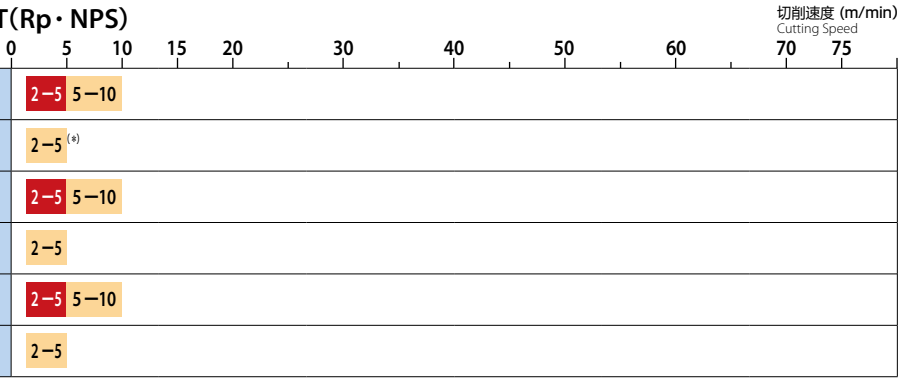
		切削速度 (m/min) Cutting Speed 0 5 10 15 20 30 40 50 60 70 75
中・高碳素钢 Medium Carbon Steel High Carbon Steel	S45C	5—15 / 15—50 / 50—75
合金钢 Alloy Steel	SCM	5—10 / 10—15 / 15—30
一般构造用钢 Mild Steel	SS400	5—20 (*)
不锈钢 Stainless Steel	SUS304 SUS420	5—10 / 10—15
铝 Aluminum	AC ADC	5—50
球墨铸铁 Ductile Cast iron	FCD	5—75

推荐加工领域 Advisable
可以加工领域 Possible

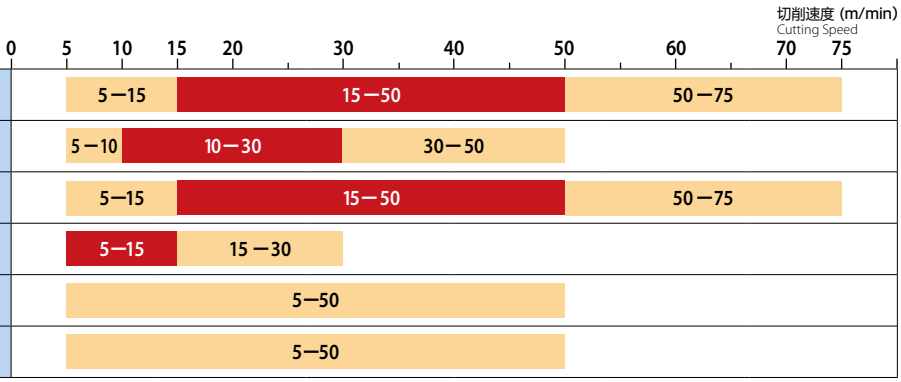
形状尺寸表 SPECIFICATION CHARTS A-TPT ▶ P.767,P.807 | 形状尺寸表 SPECIFICATION CHARTS A-S-TPT ▶ P.768,P.808 | 形状尺寸表 SPECIFICATION CHARTS A-SPT ▶ P.792,P.813 | 形状尺寸表 SPECIFICATION CHARTS A-POT ▶ P.657 | 形状尺寸表 SPECIFICATION CHARTS A-LT-POT ▶ P.662 | 形状尺寸表 SPECIFICATION CHARTS A-CSF ▶ P.647 | 形状尺寸表 SPECIFICATION CHARTS A-CHT ▶ P.759

切削条件基准表 CUTTING CONDITIONS

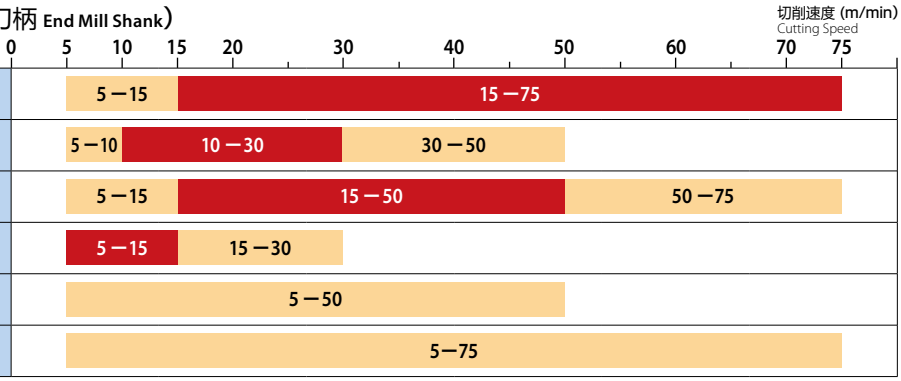
■ A-TPT・A-S-TPT・A-SPT(Rp・NPS)



■ A-POT・A-LT-POT



■ A-POT・A-LT-POT (铣刀柄 End Mill Shank)



推荐加工领域 Advisable　可以加工领域 Possible

1. 切削速度需要根据实际的加工情况而定。
2. 此切削条件适用于水溶性切削油剂。
3. 根据切削油剂的情况，可能不能充分发挥性能。
4. 虽然立铣刀柄丝锥可以应对弹簧刀柄、铣刀柄等，但请使用止动块。
(*) 请注意加工领域

1. Cutting speed should be adjusted according to the machining conditions.
2. The indicated speeds and feeds are for tapping with water-soluble oil.
3. Depending on the coolant condition, it may not show a good results.
4. Although taps with end mill shank are compatible with a collet holder, milling holder and etc., use a holder with a detent.
(*) Please set cutting speed carefully.

■ A-CSF・A-CHT

加工材料 Work Material	铸铁、球墨铸铁、铝 (AC, ADC) Cast Iron, Ductile Cast Iron, Aluminum	
供油方式 Type of Lubricant Supply	外部供油 External	内部供油 Internal
切削速度 Cutting Speed	5～15m/min	10～100m/min
切削油剂 Coolant	水溶性切削油剂 Water-Soluble	
使用机械 Machine	同步加工中心 Synchronized Machining Center	

切削条件基准表 CUTTING CONDITIONS

P.543			A-XPF						
加工材料 Work Material			切削速度 Cutting Speed (m/min)	A-XPF	螺纹底孔加工用钻头 Drill for pilot holes				
					P.201	P.195	P.153	P.137	P.253
					MRS-GDL	WX-MS-GDS	ADO-5D	AD-2D	VPH-GDS
软钢・低碳素钢・中碳素钢 Mild Steel Low Carbon Steel Medium Carbon Steel		C0.4%以下 ≦ C0.4%	10～50	◎	—	◎	◎	◎	○
高碳素钢 High Carbon Steel		C0.45%以上 ≧ C0.45%	10～40	◎	—	○	◎	◎	○
合金钢 Alloy Steel		SCM	10～35	◎	—	○	◎	○	○
调质钢 Hardened Steel		25～35HRC	5～30	◎	—	—	◎	○	◎
铸钢 Cast Steel		SC	10～40	○	—	—	◎	○	◎
※	不锈钢 Stainless Steel	SUS304 SUS420	5～15	◎*1	◎	○	◎	—	—
※	銅 Copper	Cu	10～30	◎	—	◎	○	○	—
※	黄铜・黄铜铸件 Brass / Brass Casting	Bs・BsC	10～30	◎	—	◎	◎	◎	◎
※	变形铝 Aluminum Rolled Steel	AL	20～50	◎	—	◎	○	—	—
※	铝合金铸件 Aluminum Alloy Casting	AC・ADC	20～50	◎	—	○	○	○	—
※	锌合金铸件 Zinc Alloy Casting	ZDC	10～30	◎	—	—	○	○	—

最适◎ Ideal ◎ 适用○ Good ○

注 ：此切削条件基准表使用的是无氯水溶性切削油剂。
※ ：关于不锈钢以下的加工材料请使用 EX-SUS 系列及 NEXUS 系列 。
＊1 加工不锈钢请使用油性切削油剂或润滑性良好的水溶性切削油剂。

Note : The indicated speeds and feeds are for tapping with chlorine-free water-soluble coolant.
※ : For Stainless Steel to Zinc Alloy Casting on the above, use EX-SUS and NEXUS drill series.
＊1 We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

切削速度和切削油剂 RECOMMENDED CUTTING SPEEDS AND LUBRICANTS

切削速度和切削油剂
RECOMMENDED CUTTING SPEEDS AND LUBRICANTS

选定切削速度时必须考虑丝锥的材质，种类、牙数、底孔形状，加工材质及切削油剂等加工条件，另外切削油剂、具有润滑，冷却，抗溶着 3 种作用，攻丝加工是一种复杂加工，必须选择适当的切削油剂。

This chart shows the recommended cutting speeds and cutting fluids. Tap material, type of tap, chamfer length, dimension of drill hole, work materials and cutting fluids are important factors for determining suitable cutting speed. Lubrication, cooling, capability and adhesion resistance are the three important factors effecting cutting fluid.

■标准切削速度与适用切削油剂 ■ RECOMMENDED STANDARD CUTTING SPEEDS AND APPLICATION OF CUTTING FLUIDS

加工材料 Work Material		切削速度 Cutting Speed (m/min)							切削油剂 Cutting Fluids			
		※直槽丝锥 ※ Straight Fluted Tap	螺旋槽丝锥 Spiral Fluted Tap	※刃倾角丝锥 ※ Spiral Pointed Tap	※硬质合金丝锥 ※ Tungsten Carbide Tap	※挤压丝锥 ※ Fluteless Tap	高速同步丝锥 High Speed Synchro Tap	管用丝锥 Pipe Thread Tap	油性 Non-Water-Soluble	水溶性(乳化液) Water-Soluble	半干式 Semi-Dry	干式 Dry
软钢・低碳素钢 Mild Steel Low Carbon Steel	C0.25%以下 ≦ C0.25%	8～13	8～13	15～25	—	8～13	27～32	3～6	◎	○	—	—
中碳素钢 Medium Carbon Steel	C0.25～0.45%	7～12	7～12	10～15	—	7～10	27～32	3～6	◎	○	—	—
高碳素钢 Hign Carbon Steel	C0.45%以上 ≧ C0.45%	6～9	6～9	8～13	—	5～8	22～27	2～5	◎	○	—	—
合金钢 Alloy Steel	SCM	7～12	7～12	10～15	—	5～8	22～27	2～5	◎	△	—	—
调质钢 Hardened Steel	25～45HRC	3～5 (4～8)	3～5 (4～8)	4～6 (6～10)	—	—	—	2～5	◎	△	—	—
不锈钢 Stainless Steel	SUS	4～7	5～8	8～13	—	5～10	—	3～6	◎	○	—	—
析出硬化体不锈钢 Precipitation Hardended Stainless Steel	SUS630 SUS631	3～5	3～5	4～6	—	—	—	2～5	◎	—	—	—
工具钢 Tool Steel	SKD	6～9	6～9	7～10	—	—	—	2～5	◎	—	—	—
铸钢 Cast Steel	SC	6～11	6～11	10～15	—	—	17～22	2～5	◎	○	—	—
铸铁 Cast Iron	FC	10～15	—	—	10～20	—	—	2～5	◎	○	○	○
球墨铸铁 Ductile Cast Iron	FCD	7～12	7～12	10～20	10～20	—	—	4～8	◎	○	○	—
铜 Copper	Cu	6～9	6～11	7～12	10～20	7～12	27～32	2～5	○	○	—	—
黄铜・黄铜铸件 Brass Brass Casting	Bs・BsC	10～15	10～20	15～25	15～25	7～12	27～32	5～10	○	○	○	○
青铜・青铜铸件 Bronze Bronze Casting	PB・PBC	6～11	6～11	10～20	10～20	7～12	—	6～11	○	○	—	—
变形铝 Aluminum Rolled Steel	AL	10～20	10～20	15～25	—	7～12	100～300	5～10	◎	○	—	—
铝合金铸件 Aluminum Alloy Casting	AC・ADC	10～15	10～15	15～20	10～20	12～20	80～300	10～15	◎	○	—	—
镁合金铸件 Magnesium Alloy Casting	MC	7～12	7～12	10～15	10～20	—	—	10～15	◎	○	—	—
锌合金铸件 Zinc Alloy Casting	ZDC	7～12	7～12	10～15	10～20	7～12	27～100	10～15	◎	○	—	—
热硬化性塑料 Thermo Setting Plastic	酚醛塑料 环氧塑料 Bakelite Phenol・Epoxy	10～20	—	—	15～25	—	—	5～10	—	○	○	○
热可塑性塑料 Thermo Plastic	氯乙烯尼龙共聚甲醛 Vinyl Chloride Nylon	10～20	10～15	10～20	10～20	—	27～32	5～10	—	○	—	—

◎ 最适 ◎ Ideal ○ 适用 ○ Good △ 可使用 △ Applicable — 不可使用 — Not Applicable

1. 此表为一般性的选定基准，请根据使用条件进行变更。
2. 选择丝锥时，请参照不同用途丝锥选型基准表。
3. 调质钢一栏的（）内为 CPM 丝锥系列的切削速度。
※涂层系列的参数请按照表中数值 +30%～+50% 的标准设定。
但不包括氧化处理和氮化处理。

1.These are general recommendations which depending upon conditions, may be altered.
2.To select the best taps, please see TAP selection chart.
3.（ ）=recommendation for CPM taps.
※Please apply +30～+50% higher speed for coated tap
(Exclude Steam Oxide and Nitride Treatment)

切削条件基准表 CUTTING CONDITIONS

P.544・P.546・P.547		S-XPF・LT-S-XPF・OIL-S-XPF							
加工材料 Work Material		切削速度 Cutting Speed (m/min) 10 20 30	P.547 OIL-S-XPF	螺纹底孔加工用钻头 Drill for pilot holes					
			P.544・P.546 S-XPF・LT-S-XPF	P.201 MRS-GDL	P.195 WX-MS-GDS	P.153 ADO-SD	P.137 AD-2D	P.253 VPH-GDS
软钢・低碳素钢・中碳素钢 Mild Steel Low Carbon Steel Medium Carbon Steel	C≦0.4%	15～40	◎	—	◎	◎	◎	○
高碳素钢 High Carbon Steel	C≧0.45%	15～30	◎	—	○	◎	◎	○
合金钢 Alloy Steel	SCM	15～30	◎	—	○	◎	○	○
调质钢 Hardened Steel	25～35HRC	5～20	◎	—	—	◎	○	◎
铸钢 Cast Steel	SC	15～40	○	—	—	◎	○	◎
※ 不锈钢 Stainless Steel	SUS304 SUS420	5～15	◎*1	◎	○	◎	—	—
※ 铜 Copper	Cu	10～30	◎	—	◎	○	○	—
※ 黄铜・黄铜铸件 Brass / Brass Casting	Bs・BsC	10～30	◎	—	◎	◎	◎	◎
※ 变形铝 Aluminum Rolled Steel	AL	20～50	◎	—	◎	○	—	—
※ 铝合金铸件 Aluminum Alloy Casting	AC・ADC	20～40	◎	—	○	○	○	—
※ 锌合金铸件 Zinc Alloy Casting	ZDC	10～30	◎	—	—	○	○	—

最适◎ Ideal ◎ 适用○ Good ○

注：此切削条件基准表使用的是无氯水溶性切削油剂。
：M24以上的尺寸，推荐使用上述切削条件基准表的７０％以下进行加工。
※：关于不锈钢以下的加工材料请使用EX-SUS系列及NEXUS系列。
＊加工不锈钢请使用油性切削油剂或润滑性良好的水溶性切削油剂。

Note : The indicated speeds and feeds are for tapping with chlorine-free water-soluble coolant.
: Cutting speed is recommended to be reduced by at least 30% in case of M24 and up.
※ : For Stainless Steel to Zinc Alloy Casting on the above, use EX-SUS and NEXUS drill series.
＊1We recommend using the non-water-soluble fluid or highly lubricated water-soluble fluid for the stainless steels.

P.630		CC-SUS-SFT			
加工材料 Work Material		M2～M6(2槽) M2～M6 (2 FLUTES)		M6(3槽)～M24 M6 (3 FLUTES)～M24	
		切削速度 Cutting Speed (m/min)	最适◎ Ideal ◎ 适用○ Good ○	切削速度 Cutting Speed (m/min)	最适◎ Ideal ◎ 适用○ Good ○
不锈钢(奥氏体、铁素体) Stainless Steel (Austenitic・Ferritic)	SUS304・SUS420	6 ～ 10	◎	6 ～ 10	◎
中碳素钢 Medium Carbon Steel	S45C	25 ～ 35	○	15 ～ 25	○
合金钢 Alloy Steel	SCM (30HRC)	15 ～ 30	◎	—	—
软钢 Mild Steel	SS400	30 ～ 40	○	—	—

・加工钢材请使用同步进给。

・When machining steels, please do cynclonised feeding.

切削条件基准表 CUTTING CONDITIONS

P.651・P.652・P.694・P.695		WHR-NI-SFT・NI-SFT・WHR-NI-POT・NI-POT										
加工材料 Work Material		切削速度 Cutting Speed（m/min）							切削油剂 Cutting Fluids			
		直槽丝锥 Straight Fluted Tap	螺旋槽丝锥 Spiral Fluted Tap	刃倾角丝锥 Spiral Pointed Tap	硬质合金丝锥 Tungsten Carbide Tap	挤压丝锥 Fluteless Tap	高速同步丝锥 High Speed Synchro Tap	管用丝锥 Pipe Thread Tap	油性 Non-Water-Soluble	水溶性 Water-Soluble	半干式 Semi-Dry	干式 Dry
镍基合金 Nickel Alloy	Inconel Inconel	—	1～3	2～4	—	—	—	—	◎	—	—	—

·加工3B级内螺纹时，请使用同步进给和铣刀夹头避免内螺纹扩大。

· To machine 3B class internal threads, use synchronized feeding and a milling chuck as measures against the problem of enlarged internal threads.

P.650・P.693	V-TI-SFT・V-TI-POT										
加工材料 Work Material	切削速度 Cutting Speed（m/min）							切削油剂 Cutting Fluids			
	直槽丝锥 Straight Fluted Tap	螺旋槽丝锥 Spiral Fluted Tap	刃倾角丝锥 Spiral Pointed Tap	硬质合金丝锥 Tungsten Carbide Tap	挤压丝锥 Fluteless Tap	高速同步丝锥 High Speed Synchro Tap	管用丝锥 Pipe Thread Tap	油性 Non-Water-Soluble	水溶性 Water-Soluble	半干式 Semi-Dry	干式 Dry
钛合金 Titanium Alloy	—	3～5	4～6	—	—	—	—	◎	○	—	—

P.765		WH55-OT		
加工材料 Work Material		切削速度 Cutting Speed（m/min）	切削油剂 Cutting Fluids	使用机械 Machine
高硬度钢 High Hardened Steel	40～50HRC	2～4	水溶性切削油剂、Water-Soluble, 油性切削油剂 Non-Water-Soluble	加工中心 Machining Center
高硬度钢 High Hardened Steel	50～55HRC	1～3	水溶性切削油剂、Water-Soluble, 油性切削油剂 Non-Water-Soluble	加工中心 Machining Center

1. 请注意 WH55-OT 的切削速度和切削油剂的选定，不推荐使用攻牙油膏。
2. 使用水溶性切削油剂时，请使用润滑性优良的水溶性切削油剂。
3. 手动攻丝的情况下容易产生切屑的缠绕，可以预见丝锥的崩损发生，请尽量避免手动操作。

1.Make sure to select the correct cutting speed and cutting fluids. Tapping paste is not recommended.
2.When you use water-soluble coolant, please select a coolant with better lubrication character.
3.The WH55-OT is designed for machine use only. Tapping by hand will cause chips to get stuck between the tool and the work material, and result in chipping of the taps.

切削条件基准表 CUTTING CONDITIONS

P.764		V-XPM-HT		
加工材料 Work Material		切削速度 Cutting Speed (m/min)	切削油剂 Cutting Fluids	使用机械 Machine
高硬度钢 High Hardened Steel	42～52HRC	1～3	油性切削油剂 Non-Water-Soluble	加工中心 Machining Center

P.775		V-XPM-TPT		
加工材料 Work Material		切削速度 Cutting Speed (m/min)	切削油剂 Cutting Fluids	使用机械 Machine
高硬度钢 High Hardened Steel	45～50HRC	1～3	油性切削油剂 Non-Water-Soluble	加工中心 Machining Center

P.766・P.776		VX-OT・VX-TPT		
加工材料 Work Material		切削速度 Cutting Speed (m/min)	切削油剂 Cutting Fluids	使用机械 Machine
高硬度钢 High Hardened Steel	50～62HRC	1～3	油性切削油剂 Non-Water-Soluble	加工中心 Machining Center

1. 请注意切削速度和切削油剂的选定。不宜使用攻丝油膏。
2. 手动攻丝可能会引起切屑的卷入造成崩刀。不宜使用手动攻丝。

1. Make sure to select the correct cutting speed and cutting fluids. Tapping paste is not recommended.
2. The VX-OT and VX-TPT are designed for machine use only. Tapping by hand would cause chips to get stucked between the tool and the work material, and result in chipping of the taps.

P.522	ED-PNT					
加工材料 Work Material	氧化物陶瓷 Oxide			非氧化物陶瓷 Non-Oxide		
	氧化铝・氧化锆 $Al_2O_3 \cdot ZrO_2$			氮化硅・碳化硅 $Si_3N_4 \cdot SiC$		
磨削速度 Grinding Speed	25～50			25～50		
尺寸 Thread Size (mm)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/min)	切入量 Step Feed (mm/rev)	转速 Speed (min^{-1})	进给量 Feed Rate (mm/min)	切入量 Step Feed (mm/rev)
2.2 × 7.5	4,500	10	0.01	4,000	5	0.005
3 × 9.8	3,500	10	0.01	3,250	5	0.005
3.7 × 12	3,000	20	0.02	2,500	10	0.01
4.5 × 15	3,000	30	0.02	2,500	15	0.01
6 × 20	2,500	40	0.02	2,000	20	0.01
7.5 × 24	2,000	50	0.02	1,500	20	0.01
9 × 29.8	1,500	60	0.02	1,500	30	0.01
10 × 34	1,250	60	0.02	1,250	30	0.01

1. 陶瓷用螺纹铣刀是研磨加工中心用工具。
2. 为防止切屑阻塞降低刀具寿命，请使用充分的冷却剂。
3. 陶瓷有多种类型，相同种类的陶瓷由于烧结方法的不同，刀具寿命也会有较大变化。
4. 陶瓷用螺纹铣刀是为陶瓷加工用研发的，也可对应硬质合金。但是在孔加工时，氧化铝陶瓷寿命低。

1. ED-PNT should be used with a grinding center. Even when used in a machining center with helical interpolation, chips need to be kept away from the sleeves to enable removal.
2. High pressure and sufficient coolant is required to prevent short tool life due to chips lodged in flutes.
3. There are several types of ceramic. Though the names of ceramics are same, the performance of tool is different depending on the method of sintering ceramics.
4. ED-PNT can be applied to tungsten carbide as well, though its tool life in drilling operation decreases more dramatically than Al_2O_3.

切削条件基准表 CUTTING CONDITIONS

加工材料 Work Material		P.503～P.505 AT-1 切削速度 Cutting Speed (m/min)	进给量 Feed Rate (mm/t)
软钢・低碳素钢 Mild Steel・Low Carbon Steel	～C0.25%	80 ～ 160	0.01 ～ 0.05
中碳素钢 Medium Carbon Steel	C0.25%～0.45%	80 ～ 160	0.01 ～ 0.05
高碳素钢 High Carbon Steel	C0.45%～	80 ～ 160	0.01 ～ 0.05
合金钢 Alloy Steel	SCM	60 ～ 120	0.01 ～ 0.05
调质钢 Hardened Steel	25～45HRC	80 ～ 200	0.01 ～ 0.05
	45～50HRC	—	—
	50～60HRC	—	—
不锈钢 Stainless Steel	SUS304 SUS420	60 ～ 120	0.01 ～ 0.05
工具钢 Tool Steel	SKD	—	—
铸钢 Cast Steel	SC	60 ～ 120	0.01 ～ 0.05
铸铁 Cast Iron	FC	80 ～ 160	0.01 ～ 0.05
球墨铸铁 Ductile Cast Iron	FCD	60 ～ 120	0.01 ～ 0.05
铜 Copper	Cu	80 ～ 160	0.03 ～ 0.1
黄铜 Brass	Bs	80 ～ 160	0.03 ～ 0.1
黄铜铸件 Brass Casting	BsC	80 ～ 160	0.03 ～ 0.1
青铜 Bronze	PB	80 ～ 160	0.03 ～ 0.1
变形铝 Aluminum Rolled Stell	AL	80 ～ 160	0.03 ～ 0.1
铝合金铸件 Aluminum Alloy Casting	AC,ADC	100 ～ 300	0.05 ～ 0.2
镁合金铸件 Magnesium Alloy Casting	MC	100 ～ 300	0.05 ～ 0.2
锌合金铸件 Zinc Alloy Casting	ZDC	100 ～ 300	0.05 ～ 0.2
钛合金 Titanium Alloy	Ti-6Al-4V	—	—
镍基合金 Nickel Alloy	镍合金® Inconel	—	—
热硬化性塑料 Thermo Setting Plastic	—	80 ～ 160	0.03 ～ 0.1
热可塑性塑料 Thermo Plastic	—	80 ～ 160	0.03 ～ 0.1

1. 此切削条件基准表适用于水溶性切削油剂。
2. 加工镁合金时不可使用水溶性切削油剂。
3. 请根据工件的刚性，机械、夹具的刚性适当变更切削条件。
4. 攻丝长度较长、螺距较大的情况时，请使用较小的进给量，分多次进行加工。
5. 如果加工平行内螺纹发生倾斜，通规无法通过时，请追加zero cut（精加工）。
6. 当HY-PRO P经常出现刃尖欠损，紧固螺纹破损时，请将半径方向切深量减少至螺纹高度的50%以下。
7. AT-1加工平行内螺纹也会发生倾斜、通规无法通过的情况。此时，请第一次加工75%，第二次进行精加工。

1. The indicated speeds and feeds are for water soluble oil.
2. Water-soluble oil is not suitable for tapping magnesium alloy.
3. Please adjust the cutting conditions depending on the rigidity of machine, tool holders, and workpiece clamping.
4. If the tapping length is long, or when machining a large-pitch thread, select a smaller feed and separate the machining process into a few segments.
5. If a machined parallel internal thread is tapered and prevents the go-gauge from going through, add a zero cut (finish machining).
6. When frequent chipping or breakage occurs of the HY-PRO P cutting edges, it is recommended to reduce the radial depth of cut by 50%.
7. Even with the AT-1, it is possible that the go-gauge may have trouble passing through the tapered parallel internal thread. In that case, please process the 1st pass at 75% and finish the thread with the 2nd pass.

切削条件基准表 CUTTING CONDITIONS

P.506～P.508			AT-2								
加工材料 Work Material			软钢・低碳素钢 Mild Steel・Low Carbon Steel ～C0.25%			中碳素钢・高碳素钢 Medium Carbon Steel・High Carbon Steel C0.25%～			合金钢 Alloy Steel SCM		
推荐切削油剂 Recommended Coolant			水溶性切削油剂 Water-Soluble			水溶性切削油剂 Water-Soluble			水溶性切削油剂 Water-Soluble		
切削速度 Cutting Speed (m/min)			35～55			80～160			60～120		
螺纹分类 Thread	加工径 Thread Size	DC	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)
M	M 3×0.5	2.4	5,968	48	0.01	10,610	85	0.01	7,958	64	0.01
	M 4×0.7	3.1	4,621	62	0.015	8,214	111	0.015	6,161	83	0.015
	M 5×0.8	4	3,581	49	0.017	6,366	87	0.017	4,775	65	0.017
	M 6×1	4.6	3,114	58	0.02	5,536	103	0.02	4,152	78	0.02
	M 8×1.25	6.2	2,310	62	0.03	4,107	111	0.03	3,080	83	0.03
	M10×1.5	7.5	1,910	67	0.035	3,395	119	0.035	2,546	89	0.035
	M12×1.75	9	1,592	72	0.045	2,829	127	0.045	2,122	95	0.045
	M16×2	11.7	1,224	72	0.055	2,176	129	0.055	1,632	96	0.055
	M18×2.5	14	1,023	55	0.06	1,819	97	0.06	1,364	73	0.06
	M20×2.5	15.7	912	51	0.065	1,622	91	0.065	1,216	68	0.065
U	No.8 -32UNC	3.1	4,621	47	0.01	8,214	84	0.01	6,161	63	0.01
	No.10 -24UNC	3.7	3,871	54	0.015	6,882	96	0.015	5,162	72	0.015
	1/4 -20UNC	4.55	3,148	89	0.025	5,597	159	0.025	4,197	119	0.025
	1/4 -28UNF	4.55	3,148	89	0.025	5,597	159	0.025	4,197	119	0.025
	5/16 -18UNC	5.7	2,513	85	0.03	4,468	151	0.03	3,351	113	0.03
	3/8 -16UNC	6.7	2,138	89	0.035	3,801	158	0.035	2,851	118	0.035
	7/16 -14UNC	7.7	1,860	91	0.04	3,307	162	0.04	2,480	122	0.04
	1/2 -13UNC	9.2	1,557	77	0.045	2,768	137	0.045	2,076	103	0.045
Rc (PT)	1/16 - 28	4.86	2,982	※1	0.025	5,302	※1	0.025	3,976	※1	0.025
	1/8 - 28	5.76	2,512	※1	0.03	4,465	※1	0.03	3,349	※1	0.03
	1/4 - 19	7.98	1,814	※1	0.04	3,225	※1	0.04	2,419	※1	0.04
	3/8 - 19	9.68	1,493	※1	0.045	2,654	※1	0.045	1,990	※1	0.045
	1/2 - 14	11.61	1,246	※1	0.055	2,215	※1	0.055	1,661	※1	0.055
	1 - 11	15.54	930	※1	0.065	1,654	※1	0.065	1,240	※1	0.065
NPT	1/16 - 27	4.86	2,984	※1	0.025	5,304	※1	0.025	3,978	※1	0.025
	1/8 - 27	5.76	2,513	※1	0.03	4,467	※1	0.03	3,350	※1	0.03
	1/4 - 18	7.98	1,815	※1	0.04	3,227	※1	0.04	2,420	※1	0.04
	3/8 - 18	9.68	1,493	※1	0.045	2,655	※1	0.045	1,991	※1	0.045
	1/2 - 14	11.61	1,246	※1	0.055	2,215	※1	0.055	1,661	※1	0.055
	1 - 11 1/2	15.54	930	※1	0.065	1,653	※1	0.065	1,240	※1	0.065

※1.取决于所要加工的孔深。

1. 此切削条件基准表为标准值。加工时推荐使用NC编程软件ThreadPro创建的程序。
2. 请根据工件的刚性，机械、夹具的刚性适当变更切削条件。
3. 请将刀具振动精度控制在最小限度时使用。
4. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
5. 因为是左刃，所以请主轴逆转使用。

※1. Values vary depending on the depth of hole to be machined.

1. This cutting condition table shows standard values. When machining, it is recommended to use the program created by the NC code generator software ThreadPro.
2. Please adjust the cutting conditions depending on the rigidity of machine, tool holders, and workpiece clamping.
3. Tool vibrations should be kept at a minimum level for maximum accuracy.
4. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
5. Spindle rotation must be counterclockwise due to the left-hand cut configuration.

切削条件基准表 CUTTING CONDITIONS

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P.506～P.508			AT-2								
加工材料 Work Material			调质钢 Hardened Steel								
			25～45HRC			45～50HRC			50～65HRC		
推荐切削油剂 Recommended Coolant			气冷式 Air Blow								
切削速度 Cutting Speed (m/min)			35～75			35～65			35～55		
螺纹分类 Thread	加工径 Thread Size	DC	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)
M	M 3×0.5	2.4	5,968	48	0.01	5,968	48	0.01	5,968	48	0.01
	M 4×0.7	3.1	4,621	62	0.015	4,621	62	0.015	4,621	62	0.015
	M 5×0.8	4	3,581	49	0.017	3,581	49	0.017	3,581	49	0.017
	M 6×1	4.6	3,114	58	0.02	3,114	58	0.02	3,114	58	0.02
	M 8×1.25	6.2	2,310	62	0.03	2,310	62	0.03	2,310	62	0.03
	M10×1.5	7.5	1,910	67	0.035	1,910	67	0.035	1,910	67	0.035
	M12×1.75	9	1,592	72	0.045	1,592	72	0.045	1,592	72	0.045
	M16×2	11.7	1,224	72	0.055	1,224	72	0.055	1,224	72	0.055
	M18×2.5	14	1,023	55	0.06	1,023	55	0.06	1,023	55	0.06
	M20×2.5	15.7	912	51	0.065	912	51	0.065	912	51	0.065
U	No.8 -32UNC	3.1	4,621	47	0.01	4,621	47	0.01	4,621	47	0.01
	No.10 -24UNC	3.7	3,871	54	0.015	3,871	54	0.015	3,871	54	0.015
	1/4 -20UNC	4.55	3,148	89	0.025	3,148	89	0.025	3,148	89	0.025
	1/4 -28UNF	4.55	3,148	89	0.025	3,148	89	0.025	3,148	89	0.025
	5/16 -18UNC	5.7	2,513	85	0.03	2,513	85	0.03	2,513	85	0.03
	3/8 -16UNC	6.7	2,138	89	0.035	2,138	89	0.035	2,138	89	0.035
	7/16 -14UNC	7.7	1,860	91	0.04	1,860	91	0.04	1,860	91	0.04
	1/2 -13UNC	9.2	1,557	77	0.045	1,557	77	0.045	1,557	77	0.045
Rc (PT)	1/16 - 28	4.86	2,982	※1	0.025	2,982	※1	0.025	2,982	※1	0.025
	1/8 - 28	5.76	2,512	※1	0.03	2,512	※1	0.03	2,512	※1	0.03
	1/4 - 19	7.98	1,814	※1	0.04	1,814	※1	0.04	1,814	※1	0.04
	3/8 - 19	9.68	1,493	※1	0.045	1,493	※1	0.045	1,493	※1	0.045
	1/2 - 14	11.61	1,246	※1	0.055	1,246	※1	0.055	1,246	※1	0.055
	1 - 11	15.54	930	※1	0.065	930	※1	0.065	930	※1	0.065
NPT	1/16 - 27	4.86	2,984	※1	0.025	2,984	※1	0.025	2,984	※1	0.025
	1/8 - 27	5.76	2,513	※1	0.03	2,513	※1	0.03	2,513	※1	0.03
	1/4 - 18	7.98	1,815	※1	0.04	1,815	※1	0.04	1,815	※1	0.04
	3/8 - 18	9.68	1,493	※1	0.045	1,493	※1	0.045	1,493	※1	0.045
	1/2 - 14	11.61	1,246	※1	0.055	1,246	※1	0.055	1,246	※1	0.055
	1 - 11 1/2	15.54	930	※1	0.065	930	※1	0.065	930	※1	0.065

※1. 取决于所要加工的孔深。

1. 此切削条件基准表为标准值。加工时推荐使用NC编程软件ThreadPro创建的程序。
2. 请根据工件的刚性，机械、夹具的刚性适当变更切削条件。
3. 请将刀具振动精度控制在最小限度时使用。
4. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
5. 因为是左刃，所以请主轴逆转使用。

※1. Values vary depending on the depth of hole to be machined.

1. This cutting condition table shows standard values. When machining, it is recommended to use the program created by the NC code generator software ThreadPro.
2. Please adjust the cutting conditions depending on the rigidity of machine, tool holders, and workpiece clamping.
3. Tool vibrations should be kept at a minimum level for maximum accuracy.
4. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
5. Spindle rotation must be counterclockwise due to the left-hand cut configuration.

切削条件基准表 CUTTING CONDITIONS

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P.506～P.508			AT-2											
加工材料 Work Material			不锈钢・工具钢 Stainless Steel・Tool Steel SUS304・SKD			铸钢・铸铁・球墨铸铁 Cast Steel・Cast Iron・Ductile Cast Iron SC・FC・FCD			铜・黄铜・黄铜铸件・青銅 Copper・Brass・Brass Casting・Bronze Cu・Bs・BsC・PB ～20HRC			20HRC～		
推荐切削油剂 Recommended Coolant			水溶性切削油剂 Water-Soluble			气冷式 Air Blow			水溶性切削油剂 Water-Soluble					
切削速度 Cutting Speed (m/min)			35～100			35～100			35～100			35～75		
螺纹分类 Thread	加工径 Thread Size	DC	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)
M	M 3×0.5	2.4	5,968	48	0.01	7,958	64	0.01	7,958	64	0.01	5,968	48	0.01
	M 4×0.7	3.1	4,621	62	0.015	6,161	83	0.015	6,161	83	0.015	4,621	62	0.015
	M 5×0.8	4	3,581	49	0.017	4,775	65	0.017	4,775	65	0.017	3,581	49	0.017
	M 6×1	4.6	3,114	58	0.02	4,152	78	0.02	4,152	78	0.02	3,114	58	0.02
	M 8×1.25	6.2	2,310	62	0.03	3,080	83	0.03	3,080	83	0.03	2,310	62	0.03
	M10×1.5	7.5	1,910	67	0.035	2,546	89	0.035	2,546	89	0.035	1,910	67	0.035
	M12×1.75	9	1,592	72	0.045	2,122	95	0.045	2,122	95	0.045	1,592	72	0.045
	M16×2	11.7	1,224	72	0.055	1,632	96	0.055	1,632	96	0.055	1,224	72	0.055
	M18×2.5	14	1,023	55	0.06	1,364	73	0.06	1,364	73	0.06	1,023	55	0.06
	M20×2.5	15.7	912	51	0.065	1,216	68	0.065	1,216	68	0.065	912	51	0.065
U	No.8 -32UNC	3.1	4,621	47	0.01	6,161	63	0.01	6,161	63	0.01	4,621	47	0.01
	No.10 -24UNC	3.7	3,871	54	0.015	5,162	72	0.015	5,162	72	0.015	3,871	54	0.015
	1/4 -20UNC	4.55	3,148	89	0.025	4,197	119	0.025	4,197	119	0.025	3,148	89	0.025
	1/4 -28UNF	4.55	3,148	89	0.025	4,197	119	0.025	4,197	119	0.025	3,148	89	0.025
	5/16 -18UNC	5.7	2,513	85	0.03	3,351	113	0.03	3,351	113	0.03	2,513	85	0.03
	3/8 -16UNC	6.7	2,138	89	0.035	2,851	118	0.035	2,851	118	0.035	2,138	89	0.035
	7/16 -14UNC	7.7	1,860	91	0.04	2,480	122	0.04	2,480	122	0.04	1,860	91	0.04
	1/2 -13UNC	9.2	1,557	77	0.045	2,076	103	0.045	2,076	103	0.045	1,557	77	0.045
Rc (PT)	1/16 - 28	4.86	2,982	※1	0.025	3,976	※1	0.025	3,976	※1	0.025	2,982	※1	0.025
	1/8 - 28	5.76	2,512	※1	0.03	3,349	※1	0.03	3,349	※1	0.03	2,512	※1	0.03
	1/4 - 19	7.98	1,814	※1	0.04	2,419	※1	0.04	2,419	※1	0.04	1,814	※1	0.04
	3/8 - 19	9.68	1,493	※1	0.045	1,990	※1	0.045	1,990	※1	0.045	1,493	※1	0.045
	1/2 - 14	11.61	1,246	※1	0.055	1,661	※1	0.055	1,661	※1	0.055	1,246	※1	0.055
	1 - 11	15.54	930	※1	0.065	1,240	※1	0.065	1,240	※1	0.065	930	※1	0.065
NPT	1/16 - 27	4.86	2,984	※1	0.025	3,978	※1	0.025	3,978	※1	0.025	2,984	※1	0.025
	1/8 - 27	5.76	2,513	※1	0.03	3,350	※1	0.03	3,350	※1	0.03	2,513	※1	0.03
	1/4 - 18	7.98	1,815	※1	0.04	2,420	※1	0.04	2,420	※1	0.04	1,815	※1	0.04
	3/8 - 18	9.68	1,493	※1	0.045	1,991	※1	0.045	1,991	※1	0.045	1,493	※1	0.045
	1/2 - 14	11.61	1,246	※1	0.055	1,661	※1	0.055	1,661	※1	0.055	1,246	※1	0.055
	1 - 11 1/2	15.54	930	※1	0.065	1,240	※1	0.065	1,240	※1	0.065	930	※1	0.065

※1.取决于所要加工的孔深。

1. 此切削条件基准表为标准值。加工时推荐使用NC编程软件ThreadPro创建的程序。
2. 请根据工件的刚性，机械、夹具的刚性适当变更切削条件。
3. 请将刀具振动精度控制在最小限度时使用。
4. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
5. 因为是左刃，所以请主轴逆转使用。

※1. Values vary depending on the depth of hole to be machined.

1. This cutting condition table shows standard values. When machining, it is recommended to use the program created by the NC code generator software ThreadPro.
2. Please adjust the cutting conditions depending on the rigidity of machine, tool holders, and workpiece clamping.
3. Tool vibrations should be kept at a minimum level for maximum accuracy.
4. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
5. Spindle rotation must be counterclockwise due to the left-hand cut configuration.

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切削条件基准表 CUTTING CONDITIONS

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P.506～P.508			AT-2								
加工材料 Work Material			变形铝・铝合金铸件 Aluminum Rolled Steel・Aluminum Alloy Casting AL・AC・ADC			镁合金铸件・锌合金铸件 Magnesium Alloy Casting・Zinc Alloy Casting MC・ZDC			钛合金※ Titanium Alloy Ti-6Al-4V		
推荐切削油剂 Recommended Coolant			水溶性切削油剂 Water-Soluble			水溶性切削油剂 Water-Soluble			水溶性切削油剂 Water-Soluble		
切削速度 Cutting Speed (m/min)			35～100			35～100			35～55		
螺纹分类 Thread	加工径 Thread Size	DC	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)
M	M 3×0.5	2.4	10,610	85	0.01	7,958	64	0.01	5,968	48	0.01
	M 4×0.7	3.1	8,214	111	0.015	6,161	83	0.015	4,621	62	0.015
	M 5×0.8	4	6,366	87	0.017	4,775	65	0.017	3,581	49	0.017
	M 6×1	4.6	5,536	103	0.02	4,152	78	0.02	3,114	58	0.02
	M 8×1.25	6.2	4,107	111	0.03	3,080	83	0.03	2,310	62	0.03
	M10×1.5	7.5	3,395	119	0.035	2,546	89	0.035	1,910	67	0.035
	M12×1.75	9	2,829	127	0.045	2,122	95	0.045	1,592	72	0.045
	M16×2	11.7	2,176	129	0.055	1,632	96	0.055	1,224	72	0.055
	M18×2.5	14	1,819	97	0.06	1,364	73	0.06	1,023	55	0.06
	M20×2.5	15.7	1,622	91	0.065	1,216	68	0.065	912	51	0.065
U	No.8 -32UNC	3.1	8,214	84	0.01	6,161	63	0.01	4,621	47	0.01
	No.10 -24UNC	3.7	6,882	96	0.015	5,162	72	0.015	3,871	54	0.015
	1/4 -20UNC	4.55	5,597	159	0.025	4,197	119	0.025	3,148	89	0.025
	1/4 -28UNF	4.55	5,597	159	0.025	4,197	119	0.025	3,148	89	0.025
	5/16 -18UNC	5.7	4,468	151	0.03	3,351	113	0.03	2,513	85	0.03
	3/8 -16UNC	6.7	3,801	158	0.035	2,851	118	0.035	2,138	89	0.035
	7/16 -14UNC	7.7	3,307	162	0.04	2,480	122	0.04	1,860	91	0.04
	1/2 -13UNC	9.2	2,768	137	0.045	2,076	103	0.045	1,557	77	0.045
Rc (PT)	1/16 - 28	4.86	5,302	※1	0.025	3,976	※1	0.025	2,982	※1	0.025
	1/8 - 28	5.76	4,465	※1	0.03	3,349	※1	0.03	2,512	※1	0.03
	1/4 - 19	7.98	3,225	※1	0.04	2,419	※1	0.04	1,814	※1	0.04
	3/8 - 19	9.68	2,654	※1	0.045	1,990	※1	0.045	1,493	※1	0.045
	1/2 - 14	11.61	2,215	※1	0.055	1,661	※1	0.055	1,246	※1	0.055
	1 - 11	15.54	1,654	※1	0.065	1,240	※1	0.065	930	※1	0.065
NPT	1/16 - 27	4.86	5,304	※1	0.025	3,978	※1	0.025	2,984	※1	0.025
	1/8 - 27	5.76	4,467	※1	0.03	3,350	※1	0.03	2,513	※1	0.03
	1/4 - 18	7.98	3,227	※1	0.04	2,420	※1	0.04	1,815	※1	0.04
	3/8 - 18	9.68	2,655	※1	0.045	1,991	※1	0.045	1,493	※1	0.045
	1/2 - 14	11.61	2,215	※1	0.055	1,661	※1	0.055	1,246	※1	0.055
	1 - 11 1/2	15.54	1,653	※1	0.065	1,240	※1	0.065	930	※1	0.065

※1. 取决于所要加工的孔深。

1. 此切削条件基准表为标准值。加工时推荐使用NC编程软件ThreadPro创建的程序。
2. 请根据工件的刚性，机械、夹具的刚性适当变更切削条件。
3. 请将刀具振动精度控制在最小限度时使用。
4. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
5. 因为是左刃，所以请主轴逆转使用。

※关于钛合金・镍基合金，上述条件表仅适用于使用水溶性切削油剂，且螺纹长度1D左右或 适应油孔尺寸 (油孔栏：印 ○)

※1. Values vary depending on the depth of hole to be machined.

1. This cutting condition table shows standard values. When machining, it is recommended to use the program created by the NC code generator software ThreadPro.
2. Please adjust the cutting conditions depending on the rigidity of machine, tool holders, and workpiece clamping.
3. Tool vibrations should be kept at a minimum level for maximum accuracy.
4. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
5. Spindle rotation must be counterclockwise due to the left-hand cut configuration.

※ For titanium alloys and Ni-based alloys, the above condition table applies only when using a water-soluble cutting fluid and processing with a thread length of approximately 1xD or an oil hole compatible size (oil hole column: ○ mark).

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切削条件基准表 CUTTING CONDITIONS

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AT-2								
加工材料 Work Material			镍基合金※ Ni-based Alloy Inconel			塑料 Plastic —		
推荐切削油剂 Recommended Coolant			水溶性切削油剂 Water-Soluble			水溶性切削油剂 Water-Soluble		
切削速度 Cutting Speed (m/min)			35～55			35～100		
螺纹分类 Thread	加工径 Thread Size	DC	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)
M	M 3×0.5	2.4	4,642	37	0.01	7,958	64	0.01
	M 4×0.7	3.1	3,594	49	0.015	6,161	83	0.015
	M 5×0.8	4	2,785	38	0.017	4,775	65	0.017
	M 6×1	4.6	2,422	45	0.02	4,152	78	0.02
	M 8×1.25	6.2	1,797	49	0.03	3,080	83	0.03
	M 10×1.5	7.5	1,485	52	0.035	2,546	89	0.035
	M 12×1.75	9	1,238	56	0.045	2,122	95	0.045
	M 16×2	11.7	952	56	0.055	1,632	96	0.055
	M 18×2.5	14	796	42	0.06	1,364	73	0.06
	M 20×2.5	15.7	710	40	0.065	1,216	68	0.065
U	No.8 -32UNC	3.1	3,594	37	0.01	6,161	63	0.01
	No.10 -24UNC	3.7	3,011	42	0.015	5,162	72	0.015
	1/4 -20UNC	4.55	2,449	69	0.025	4,197	119	0.025
	1/4 -28UNF	4.55	2,449	69	0.025	4,197	119	0.025
	5/16 -18UNC	5.7	1,955	66	0.03	3,351	113	0.03
	3/8 -16UNC	6.7	1,663	69	0.035	2,851	118	0.035
	7/16 -14UNC	7.7	1,447	71	0.04	2,480	122	0.04
	1/2 -13UNC	9.2	1,211	60	0.045	2,076	103	0.045
Rc (PT)	1/16 - 28	4.86	2,320	※1	0.025	3,976	※1	0.025
	1/8 - 28	5.76	1,954	※1	0.03	3,349	※1	0.03
	1/4 - 19	7.98	1,411	※1	0.04	2,419	※1	0.04
	3/8 - 19	9.68	1,161	※1	0.045	1,990	※1	0.045
	1/2 - 14	11.61	969	※1	0.055	1,661	※1	0.055
	1 - 11	15.54	724	※1	0.065	1,240	※1	0.065
NPT	1/16 - 27	4.86	2,321	※1	0.025	3,978	※1	0.025
	1/8 - 27	5.76	1,954	※1	0.03	3,350	※1	0.03
	1/4 - 18	7.98	1,412	※1	0.04	2,420	※1	0.04
	3/8 - 18	9.68	1,161	※1	0.045	1,991	※1	0.045
	1/2 - 14	11.61	969	※1	0.055	1,661	※1	0.055
	1 - 11 1/2	15.54	723	※1	0.065	1,240	※1	0.065

※1.取决于所要加工的孔深。

1. 此切削条件基准表为标准值。加工时推荐使用NC编程软件ThreadPro创建的程序。
2. 请根据工件的刚性，机械、夹具的刚性适当变更切削条件。
3. 请将刀具振动精度控制在最小限度时使用。
4. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
5. 因为是左刃，所以请主轴逆转使用。

※关于钛合金・镍基合金，上述条件表仅适用于使用水溶性切削油剂，且螺纹长度1D左右或 适应油孔尺寸 (油孔栏：印 ○)

※1. Values vary depending on the depth of hole to be machined.

1. This cutting condition table shows standard values. When machining, it is recommended to use the program created by the NC code generator software ThreadPro.
2. Please adjust the cutting conditions depending on the rigidity of machine, tool holders, and workpiece clamping.
3. Tool vibrations should be kept at a minimum level for maximum accuracy.
4. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
5. Spindle rotation must be counterclockwise due to the left-hand cut configuration.

※ For titanium alloys and Ni-based alloys, the above condition table applies only when using a water-soluble cutting fluid and processing with a thread length of approximately 1xD or an oil hole compatible size (oil hole column: ○ mark).

切削条件基准表 CUTTING CONDITIONS

P.509	AT-2 R-SPEC																	
加工材料 Work Material	铝合金铸件 Aluminum Alloy Casting AC4C・ADC						铝合金・镁合金 Aluminum・Magnesium Alloy A5052・A7075・AZ91・AZ80A						铜合金 Copper Alloy C1100					
推荐切削油剂 Recommended Coolant	水溶性切削油剂 Water-Soluble						水溶性切削油剂 Water-Soluble						水溶性切削油剂 Water-Soluble					
切削速度 Cutting Speed (m/min)	100～300						100～300						100～300					
加工径 Thread Size	DC	2D型 2 x D Type			2.5D型 2.5 x D Type			2D型 2 x D Type			2.5D型 2.5 x D Type			2D型 2 x D Type			2.5D型 2.5 x D Type		
		转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)	转速 Speed (min^{-1})	进给速度 Feed (mm/min)	每刃进给量 Feed per Tooth (mm/t)
M 3×0.5	2.4	13,263	1,592	0.3	13,263	1,592	0.3	13,263	159	0.03	13,263	159	0.03	13,263	159	0.03	13,263	159	0.03
M 4×0.7	3.1	14,375	1,941	0.3	14,375	1,941	0.3	14,375	194	0.03	14,375	194	0.03	14,375	194	0.03	14,375	194	0.03
M 5×0.8	4	15,915	1,910	0.3	12,732	1,528	0.3	15,915	255	0.04	12,732	204	0.04	15,915	255	0.04	12,732	204	0.04
M 6×1	4.6	15,224	2,842	0.4	11,072	2,067	0.4	15,224	284	0.04	11,072	207	0.04	15,224	284	0.04	11,072	207	0.04
M 8×1.25	6.2	12,322	2,218	0.4	8,214	1,479	0.4	12,322	277	0.05	8,214	185	0.05	12,322	277	0.05	8,214	185	0.05
M 10×1.5	7.5	10,186	2,037	0.4	6,791	1,358	0.4	10,186	255	0.05	6,791	170	0.05	10,186	255	0.05	6,791	170	0.05
M 12×1.75	9	8,488	1,698	0.4	5,659	1,132	0.4	8,488	212	0.05	5,659	141	0.05	8,488	212	0.05	5,659	141	0.05

1. 此为ThreadPro早期显示的切削条件参考值。使用时，请以此切削条件基准表为基础，根据工件的刚性，机械、夹具的刚性适当调整切削条件。
2. 请将刀具振动精度控制在最小限度时使用。
3. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
4. 因为是左刃，所以请主轴逆转使用。

1. Before use, please adjust the cutting conditions according to the recommended cutting condition table as well as the actual machining environment, such as the rigidity of machine, tool holder and workpiece clamping.
2. Tool vibrations should be kept at a minimum level for maximum accuracy.
3. When machining magnesium alloy materials, please use the coolant oil recommended by the coolant oil manufacturer. Please also properly dispose the cutting chips to prevent fire hazards.
4. Spindle rotation must be counterclockwise due to the left-hand cut configuration.

切削条件基准表 CUTTING CONDITIONS

加工材料 Work Material		P.511 WH-VM-PNC S1～1.4, M1～1.8 ※2 切削速度 Cutting Speed (m/min)	进给量 Feed Rate (mm/t) DC=φ0.72	DC=φ0.92 DC=φ1.05	DC=φ1.2 DC=φ1.3	P.511 WH-VM-PNC M2～5, No.8 切削速度 Cutting Speed (m/min)	进给量 Feed Rate (mm/t)	P.512・P.514 WX-ST-PNC・WXO-ST-PNC 切削速度 Cutting Speed (m/min)	进给量 Feed Rate (mm/t)	P.515 WX-PNC 切削速度 Cutting Speed (m/min)	进给量 Feed Rate (mm/t)	P.517 OT-SFT-PNGT 切削速度 Cutting Speed (m/min)	进给量 Feed Rate (mm/t)
软钢・低碳素钢 Mild Steel・Low Carbon Steel	～C0.25%	60 ～ 90	0.02	0.03	0.05	60 ～ 90	0.02～0.08	80 ～ 120	0.04 ～ 0.1	50 ～ 75	0.01 ～ 0.11	50 ～ 75	0.01 ～ 0.11
中碳素钢 Medium Carbon Steel	C0.25%～0.45%	60 ～ 90	0.02	0.03	0.05	60 ～ 90	0.02～0.08	80 ～ 120	0.04 ～ 0.1	—	—	40 ～ 70	0.01 ～ 0.11
高碳素钢 High Carbon Steel	C0.45%～	60 ～ 90	0.02	0.03	0.05	60 ～ 90	0.02～0.08	80 ～ 120	0.04 ～ 0.1	—	—	40 ～ 70	0.01 ～ 0.11
合金钢 Alloy Steel	SCM	—	—	—	—	30 ～ 60	0.01～0.03	80 ～ 120	0.02 ～ 0.08	—	—	15 ～ 30	0.01 ～ 0.03
调质钢 Hardened Steel	25～45HRC	—	—	—	—	30 ～ 60	0.01～0.03	60 ～ 100	0.02 ～ 0.08	—	—	—	—
	45～50HRC	—	—	—	—	30 ～ 60	0.01～0.03	—	—	—	—	—	—
	50～60HRC	—	—	—	—	30 ～ 60 ※1	0.01～0.02	—	—	—	—	—	—
不锈钢 Stainless Steel	SUS304 SUS420	60 ～ 90	0.02	0.03	0.05	60 ～ 90	0.02～0.08	40 ～ 80	0.02 ～ 0.06	—	—	20 ～ 40	0.01 ～ 0.06
工具钢 Tool Steel	SKD	—	—	—	—	—	—	—	—	—	—	—	—
铸钢 Cast Steel	SC	40 ～ 60	0.02	0.03	0.05	40 ～ 60	0.02～0.09	40 ～ 65	0.02 ～ 0.09	40 ～ 65	0.02 ～ 0.09	40 ～ 65	0.02 ～ 0.09
铸铁 Cast Iron	FC	40 ～ 60	0.02	0.03	0.05	50 ～ 100	0.03～0.1	50 ～ 100	0.03 ～ 0.1	50 ～ 100	0.03 ～ 0.1	50 ～ 100	0.03 ～ 0.1
球墨铸铁 Ductile Cast Iron	FCD	40 ～ 60	0.02	0.03	0.05	50 ～ 70	0.03～0.1	50 ～ 65	0.03 ～ 0.1	50 ～ 65	0.03 ～ 0.1	50 ～ 65	0.03 ～ 0.1
铜 Copper	Cu	—	—	—	—	—	—	—	—	65 ～ 130	0.03 ～ 0.1	65 ～ 130	0.03 ～ 0.1
黄铜 Brass	Bs	—	—	—	—	—	—	—	—	65 ～ 130	0.03 ～ 0.1	65 ～ 130	0.03 ～ 0.1
黄铜铸件 Brass Casting	BsC	60 ～ 100	0.04	0.06	0.08	50 ～ 100	0.02～0.06	—	—	65 ～ 130	0.03 ～ 0.1	65 ～ 130	0.03 ～ 0.1
青铜 Bronze	PB	—	—	—	—	50 ～ 100	0.02～0.06	—	—	65 ～ 130	0.03 ～ 0.1	65 ～ 130	0.03 ～ 0.1
变形铝 Aluminum Rolled Stell	AL	70 ～ 100	0.04	0.06	0.08	50 ～ 100	0.02～0.06	—	—	50 ～ 70	0.03 ～ 0.1	50 ～ 70	0.03 ～ 0.1
铝合金铸件 Aluminum Alloy Casting	AC,ADC	70 ～ 100	0.04	0.06	0.08	50 ～ 100	0.02～0.06	—	—	65 ～ 130	0.03 ～ 0.1	65 ～ 130	0.03 ～ 0.1
镁合金铸件 Magnesium Alloy Casting	MC	70 ～ 100	0.04	0.06	0.08	50 ～ 100	0.02～0.06	—	—	65 ～ 130	0.03 ～ 0.1	65 ～ 130	0.03 ～ 0.1
锌合金铸件 Zinc Alloy Casting	ZDC	70 ～ 100	0.04	0.06	0.08	50 ～ 100	0.02～0.06	—	—	65 ～ 130	0.03 ～ 0.1	65 ～ 130	0.03 ～ 0.1
钛合金 Titanium Alloy	Ti-6Al-4V	20 ～ 40	0.01	0.02	0.03	20 ～ 60	0.01～0.03	—	—	20 ～ 60	0.02 ～ 0.06	—	—
镍基合金 Nickel Alloy	镍合金® Inconel	—	—	—	—	20 ～ 60	0.01～0.03	—	—	20 ～ 60	0.01 ～ 0.03	—	—
热硬化性塑料 Thermo Setting Plastic	—	50 ～ 100	0.04	0.06	0.08	50 ～ 100	0.02～0.06	65 ～ 130	0.03 ～ 0.13	65 ～ 130	0.03 ～ 0.13	65 ～ 130	0.03 ～ 0.13
热可塑性塑料 Thermo Plastic	—	50 ～ 100	0.04	0.06	0.08	50 ～ 100	0.02～0.06	65 ～ 130	0.03 ～ 0.13	65 ～ 130	0.03 ～ 0.13	65 ～ 130	0.03 ～ 0.13

1. 此切削条件基准是在选用水溶性切削油剂的场合。
2. 镁合金加工时，不可用水溶性切削油剂。
3. 根据工件的刚性，机械和夹套等刚性调整切削条件。
4. 攻丝长度较长、螺距较大的情况时，请使用较小的进给量，分多次进行加工。
5. 如果加工平行内螺纹发生倾斜，通规无法通过时，请追加zero cut（精加工）。
6. 当HY-PRO P经常出现刃尖欠损，紧固螺纹破损时，请将半径方向切深量减少至螺纹高度的50%以下。
7. 平行内螺纹也会发生倾斜、通规无法通过的情况。此时，请第一次加工75%，第二次进行精加工。

※1 请充分考虑切削深度等加工程序。
※2 径向请分2次以上加工。

1. The indicated speeds and feeds are for water soluble oil.
2. Water-soluble oil is not suitable for tapping magnesium alloy.
3. Please adjust the cutting conditions depending on the rigidity of machine, tool holders, and workpiece clamping.
4. If the tapping length is long, or when machining a large-pitch thread, select a smaller feed and separate the machining process into a few segments.
5. If a machined parallel internal thread is tapered and prevents the go-gauge from going through, add a zero cut (finish machining).
6. When frequent chipping or breakage occurs of the HY-PRO P cutting edges, it is recommended to reduce the radial depth of cut by 50%.
7. It is possible that the go-gauge may have trouble passing through the tapered parallel internal thread. In that case, please process the 1st pass at 75% and finish the thread with the 2nd pass.

※1 Pay attention to conditions including the depth of cut in the machine program.
※2 Please use at least two passes in order to avoid tool breakage or excessive wear.

切削条件基准表 CUTTING CONDITIONS

加工材料 Work Material		P.518 OT-PNGT 切削速度 Cutting Speed (m/min)	P.518 OT-PNGT 进给量 Feed Rate (mm/t)	P.519 PNGT 切削速度 Cutting Speed (m/min)	P.519 PNGT 进给量 Feed Rate (mm/t)	P.533 HY-PRO P 多牙型 Multi Point 切削速度 Cutting Speed (m/min)	P.533 HY-PRO P 多牙型 Multi Point 进给量 Feed Rate (mm/t)	P.531 HY-PRO P 单牙型 Single Point 切削速度 Cutting Speed (m/min)	P.531 HY-PRO P 单牙型 Single Point 进给量 Feed Rate (mm/t)
软钢・低碳素钢 Mild Steel・Low Carbon Steel	~C0.25%	40 ~ 60	0.01 ~ 0.09	20 ~ 30	0.01 ~ 0.05	100 ~ 210	0.05 ~0.3	100 ~ 210	0.24 ~ 0.36
中碳素钢 Medium Carbon Steel	C0.25%~0.45%	30 ~ 50	0.01 ~ 0.04	10 ~ 20	0.01 ~ 0.05	100 ~ 180	0.05 ~0.25	100 ~ 180	0.24 ~ 0.36
高碳素钢 High Carbon Steel	C0.45%~	30 ~ 50	0.01 ~ 0.04	8 ~ 12	0.01 ~ 0.05	100 ~ 170	0.05 ~0.2	100 ~ 170	0.22 ~ 0.33
合金钢 Alloy Steel	SCM	15 ~ 30	0.01 ~ 0.03	10 ~ 15	0.01 ~ 0.05	60 ~ 130	0.05 ~0.2	60 ~ 130	0.18 ~ 0.27
调质钢 Hardened Steel	25~45HRC	15 ~ 30	0.01 ~ 0.03	10 ~ 15	0.01 ~ 0.05	—	—	70 ~ 110	0.16 ~ 0.24
	45~50HRC	—	—	—	—	—	—	—	—
	50~60HRC	—	—	—	—	—	—	—	—
不锈钢 Stainless Steel	SUS304 SUS420	20 ~ 40	0.01 ~ 0.06	10 ~ 15	0.01 ~ 0.05	70 ~ 140	0.05 ~0.15	70 ~ 140	0.16 ~ 0.24
工具钢 Tool Steel	SKD	—	—	—	—	—	—	70 ~ 110	0.16 ~ 0.24
铸钢 Cast Steel	SC	30 ~ 50	0.02 ~ 0.07	10 ~ 20	0.02 ~ 0.1	100 ~ 170	0.05 ~0.1	70 ~ 120	0.14 ~ 0.21
铸铁 Cast Iron	FC	40 ~ 75	0.02 ~ 0.08	20 ~ 50	0.02 ~ 0.1	60 ~ 130	0.05 ~0.15	60 ~ 120	0.16 ~ 0.24
球墨铸铁 Ductile Cast Iron	FCD	40 ~ 50	0.02 ~ 0.08	20 ~ 30	0.02 ~ 0.1	60 ~ 130	0.02 ~0.08	60 ~ 100	0.16 ~ 0.24
铜 Copper	Cu	50 ~ 100	0.02 ~ 0.08	50 ~ 80	0.02 ~ 0.05	120 ~ 210	0.1 ~0.3	120 ~ 210	0.5 ~ 0.75
黄铜 Brass	Bs	50 ~ 100	0.02 ~ 0.08	50 ~ 100	0.02 ~ 0.05	120 ~ 210	0.1 ~0.3	120 ~ 210	0.6 ~ 0.9
黄铜铸件 Brass Casting	BsC	50 ~ 100	0.02 ~ 0.08	50 ~ 100	0.02 ~ 0.05	120 ~ 210	0.1 ~0.3	120 ~ 210	0.6 ~ 0.9
青铜 Bronze	PB	50 ~ 100	0.02 ~ 0.08	30 ~ 60	0.02 ~ 0.05	120 ~ 210	0.05 ~0.25	120 ~ 210	0.5 ~ 0.75
变形铝 Aluminum Rolled Stell	AL	40 ~ 55	0.02 ~ 0.08	40 ~ 55	0.02 ~ 0.08	100 ~ 250	0.1 ~0.4	100 ~ 180	0.5 ~ 0.75
铝合金铸件 Aluminum Alloy Casting	AC,ADC	50 ~ 100	0.02 ~ 0.08	50 ~ 80	0.02 ~ 0.1	150 ~ 400	0.01 ~0.3	150 ~ 280	0.4 ~ 0.6
镁合金铸件 Magnesium Alloy Casting	MC	50 ~ 100	0.02 ~ 0.08	50 ~ 80	0.02 ~ 0.1	150 ~ 400	0.01 ~0.3	150 ~ 280	0.4 ~ 0.6
锌合金铸件 Zinc Alloy Casting	ZDC	50 ~ 100	0.02 ~ 0.08	50 ~ 80	0.02 ~ 0.1	150 ~ 400	0.01 ~0.3	150 ~ 280	0.4 ~ 0.6
钛合金 Titanium Alloy	Ti-6Al-4V	—	—	—	—	—	—	—	—
镍基合金 Nickel Alloy	镍合金® Inconel	—	—	—	—	—	—	—	—
热硬化性塑料 Thermo Setting Plastic	—	50 ~ 100	0.02 ~ 0.1	50 ~ 80	0.02 ~ 0.1	150 ~ 400	0.05 ~0.3	150 ~ 280	0.4 ~ 0.6
热可塑性塑料 Thermo Plastic	—	50 ~ 100	0.02 ~ 0.1	50 ~ 80	0.02 ~ 0.1	150 ~ 400	0.05 ~0.3	150 ~ 280	0.4 ~ 0.6

P.521・P.522 DR-PNAC・DR-O-PNAC 加工材料 Work Material		内螺纹 Internal Threads 切削速度 Cutting Speed (m/min)	内螺纹 Internal Threads 进给量 Feed Rate (mm/t)	钻头 Drills 进给量 Feed Rate (mm/rev)
铸铁 Cast Iron	FC	50 ~ 120	0.02 ~ 0.04	0.1 ~0.2
球墨铸铁 Ductile Cast Iron	FCD	50 ~ 100	0.02 ~ 0.04	0.1 ~0.2
铝合金※ Aluminum Alloy®	A****	80 ~ 200	0.02 ~ 0.05	0.1 ~0.2
铝合金铸件 压铸用铝合金 Aluminum Alloy Casting・Aluminum Alloy Casting for Die Casting	<Si13%	80 ~ 200	0.02 ~ 0.05	0.1 ~0.2
	≧Si13%	80 ~ 200	0.02 ~ 0.04	0.05 ~0.1

P.521・P.522 DR-PNAC・DR-O-PNAC 加工材料 Work Material		内螺纹 Internal Threads 切削速度 Cutting Speed (m/min)	内螺纹 Internal Threads 进给量 Feed Rate (mm/t)	钻头 Drills 进给量 Feed Rate (mm/rev)
镁合金铸件 Magnesium Alloy Casting	MC	80 ~ 200	0.02 ~ 0.05	0.1 ~0.2
锌合金铸件 Zinc Alloy Casting	ZDC	80 ~ 200	0.02 ~ 0.05	0.1 ~0.2
热可塑性塑料 Thermo Plastic		80 ~ 200	0.02 ~ 0.05	0.1 ~0.2

※推荐用DR-O-PNAC加工铝合金。
※ For aluminum alloy we recomend DR-O-PNAC.

丝锥加工问题解答 TROUBLE SHOOTING

问题 Problem		丝锥 Tap			使用条件 Operating Conditions	
内容	要因 Specific Problem	选定 Selection	设计式样 Designed Spec.	再研磨 Regrinding	使用机械 Machine Used	夹具 Tooling
内螺纹中径扩大 Oversize Pitch Diameter	丝锥选定不当 Incorrect tap selection	①选用适当精度的丝锥 ②加长切削锥长度 ③选择同心圆铲背丝锥 ① Select tap of appropriate limit. ② Increase chamfer length. ③ Select con-eccentric relief tap.	①减少前角 ②加大螺纹部刃带宽 ③调整切削锥长的铲背角 ① Reduce rake angle. ② Increase margin width of thread. ③ Correct relief angle of chamfer section.			
	切屑堵塞 Chip packing	①选用POT,SFT,NRT,HRT丝锥 ②选用内冷式丝锥 ① Select POT/SFT/XPF/NRT/HRT. ② Select tap with oil hole.	①减少槽数扩大容屑槽 ① Reduce number of flutes to provide extra chip room.			
	使用条件不当 Incorrect operating conditions				调整机械的功率 Adjust machine capacity (drive force) to appropriate level.	①使用柔性攻丝夹具 ②防止轴心振动 ① Use floating type tap holder. ② Avoid runout of spindle.
	溶着 Welding	①选择表面处理(氧化处理涂层)的丝锥 ②选择内冷式丝锥 ① Select surface-treatment (steam oxide or coating). ② Select tap with oil hole.	①实行氧化处理 ②根据材料选择适当的前角 ③缩短螺纹部长度 ① Apply steam oxide treatment. ② Adjust rake angle to suit tapped material. ③ Shorten thread length of tap.			
	丝锥再研磨不当 Incorrect tap regrinding			①正确分割排屑槽角度 ②仰制切削锥部的径向跳动 ③不要把丝锥前角切削锥角磨得太大 ④避免刀刃厚度过小 ⑤除掉刃磨时的毛刺 ① The land must be accurately indexed. ② Reduce run-out of chamfer section. ③ Make sure that rake angle and primary relief angle are not too large. ④ Make sure that land width is not excessively thin. ⑤ Remove burrs.		
内螺纹中径缩小 Undersize Pitch Diameter	丝锥选型不当 Incorrect tap selection	选用精度大的丝锥 A. 铜合金、铝合金、铸铁等切扩量小的被切削材料。 B. 被切削材料的形状为反弹量较大的管状，薄板等时。 Select oversize tap. (a)Tapping material: Materials with low over size margin, such as copper alloy, aluminum alloy and cast iron (b)Shape of tapping material: Hollow materials and mild sheet steels with punched holes which have ""a spring back"" action after tapping	①选择正确的切削锥角 ②加大前角 ③槽数增加 ① Adjust primary relief angle to appropriate level. ② Increase rake angle. ③ Increase number of flutes	缩短再研磨周期 Shorten regrinding intervals.		
	内螺纹划伤 Damaged internal thread					

丝锥加工问题解答 TROUBLE SHOOTING

使用条件 Operating Conditions		加工材料 Work Material			其他 Other
切削条件 Tapping Conditions	切削油剂 Cutting Lubricant	硬度 Hardness	形状 Dimension	螺纹底孔 Drill Hole	
	改变切削油剂的种类和供油方法 Change lubricant type and lubricating method.			①尽可能加大底孔直径 ②盲孔的场合，尽可能加深底孔 ① Make drill hole diameter as large as possible. ② In the case of blind holes, make it as deep as possible.	
①使用正确的切削速度 ②采用合适的进给量，防止出现过切而使内螺纹牙型瘦小 ③采用强制进给(导向进给)方式 ① Adjust tapping speed to appropriate level. ② Adjust feed speed to appropriate level to prevent torn or rough thread. ③ Use forced feed (lead feed) tapper.				①防止底孔的偏心 ②底孔入口处施以倒角 ① Prevent misalignment with drill hole. ② Chamfer entrance of the drilled hole.	
①切削速度下降 ① Reduce tapping speed.	使用抗溶着性良好的切削油 Replace lubricant with one that has higher anti-galling properties.				
			使用尺寸加大型丝锥 A. 铜合金、铝合金、铸铁等切扩量小的被切削材料 B. 被切削材料的形状为反弹量较大的管状，薄板等时。 Select oversize tap. (a)Tapping material: Materials with low over size margin, such as copper alloy, aluminum alloy and cast iron (b)Shape of tapping material: Hollow materials and mild sheet steels with punched holes which have a "spring back" action after tapping.		
回转时，采用适当的切削速度以保证内螺纹出口处不产生划伤 Adjust reverse speed to an appropriate level, to avoid damage at entrance of tapped thread on the way out of the hole.					

丝锥加工问题解答 TROUBLE SHOOTING

问题 Problem		丝锥 Tap			使用条件 Operating Conditions	
内容	要因 Specific Problem	选定 Selection	设计式样 Designed Spec.	再研磨 Regrinding	使用机械 Machine Used	夹具 Tooling
内螺纹中径缩小 Undersize Pitch Diameter	内螺纹中有切屑残留 Left-over chips		提高丝锥的锋利度，防止出现须状的切屑 Improve sharpness of cutting edges to prevent spare chips.			
表面不光滑，有划伤波纹 Torn or rough Thread	丝锥选型不当 Incorrect tap selection	适量增加切削锥的长度 Select tap with long chamfer length.	①根据被切削材选择适当的前角 ②减少刃带宽 ③缩短有效螺纹长度 ① Adjust rake angle to suit tapped material. ② Reduce margin width. ③ Shorten effective thread length.			
	溶着 Welding	①使用带后角的丝锥 ②选择表面处理(氧化处理涂层)的丝锥 ③选用内冷式丝锥 ① Select tap with thread relief. ② Select surface-treatment (steam oxide or coating). ③ Select tap with oil hole.	①减小刀刃厚度 ②缩短有效螺纹长度 ① Reduce land width. ② Shorten effective thread length.	①正确分割排屑槽角度 ②减小前角的不稳定 ③注意刃尖研磨产生的过热，发黑迹象。 ① The flutes must be accurately indexed. ② Reduce runout of rake angle. ③ Pay special attention to heat build up on the cutting edge.		
	切屑堵塞 Chip packing	选用POT,SFT,NRT,HRT,XPF丝锥 Select spiral pointed or spiral fluted taps.				
	使用条件不当 Incorrect operating conditions				螺距进给 Switch to pitch feed mode.	①防止轴心的振动 ②使用柔性攻丝夹具 ① Avoid runout of spindle. ② Use a floating type tap holder.
	丝锥再研磨不当 Incorrect tap regrinding			①正确分割排屑槽角度 ②抑制切削锥部的径向跳动 ③磨损部全部清除 ④缩短再研磨周期 ① The land must be accurately indexed. ② Reduce run-out of chamfer section. ③ Make sure these are no wom-out areas. ④ Shorten regrinding intervals.		
振动 Jagged Thread	丝锥选型不当 Incorrect tap selection		①减小前角 ②减小铲背 ① Reduce rake angle. ② Reduce amount of thread relief.	①避免刀刃厚度过小 ②不再进行槽再研磨 ① Make sure that land width is not excessively thin. ② Do not regrind flutes.		①防止轴心的振动 ②使用柔性攻丝夹具 ① Use a floating type tap holder. ② Avoid runout of spindle.
丝锥折损 Breakage	切屑堵塞 Chip packing	使用POT,SFT,XPF,NRT,HRT丝锥 Use spiral pointed, spiral fluted or forming taps	①加大容屑槽 ②适当增加切削锥的长度 ① Enlarge chip room ② Increase chamfer length.			
	溶着 Welding	表面处理(氧化处理、涂层处理)的丝锥 Select surface-treatment (steam oxide or coating).		磨损部全部清除 Make sure there are no worn-out areas.		

丝锥加工问题解答 TROUBLE SHOOTING

使用条件 Operating Conditions		加工材料 Work Material			其他 Other
切削条件 Tapping Conditions	切削油剂 Cutting Lubricant	硬度 Hardness	形状 Dimension	螺纹底孔 Drill Hole	
					在完全清除掉残留的切屑后，再使用螺纹塞规检查内螺纹 Before gauge check, be sure to remove chips completely.
降低切削速度 Reduce tapping speed.	①调整切屑油剂的种类和供油方式 ②更换、补充切削油的时间要适当 ③防止混入其他油类 ④过滤切削液 ① Review lubricant type and lubricating supply method. ② Correct lubricant change/ replenishment intervals. ③ Prevent entry of other oils such as operating oil. ④ Filtrate oil stored in tank.			尽量可能加大底孔直径 Make drill hole diameter as large as possible.	除去前工序的残留切屑 Remove chips generated in previous process.
尽量可能加大底孔直径 Make drill hole as large as possible.	调整切削油剂的种类和供油方式 Review lubricant type and lubricating method.			尽量可能加大底孔直径 Make drill hole diameter as large as possible.	
	调整切削油剂种类及供给方法 Review lubricant type and lubricating method.	调查加工材料的硬度及组织结构的均一性 Pay special attention to changes and variations in tapping material, hardness and structure.		①防止底孔偏心和倾斜 ②防止底孔加工时的加工硬化 ① Avoid misalignment and inclination from drilled hole. ② Avoid work hardening of the hole after tapping.	
降低切削速度 Reduce tapping speed.	调整切削油剂种类和供油方式 Review lubricant type and lubricating method.		①加固工件的夹持具 ②注意工件的厚度 ① Hold work material more securely. ② Pay special attention to thickness of work material.		
				①尽可能加深盲孔的底孔深度 ②修正底孔倾斜 ① Make hole for blind hole as deep as possible. ② Correct inclination of drilled hole.	①清除底孔及加工工件周围的切屑 ②确保清除切屑空间 ① Remove chips collected in drilled hole and around tapping areas in previous process. ② Keep space for removal of chips.

丝锥加工问题解答 TROUBLE SHOOTING

问题 Problem		丝锥 Tap			使用条件 Operating Conditions	
内容	要因 Specific Problem	选定 Selection	设计式样 Designed Spec.	再研磨 Regrinding	使用机械 Machine Used	夹具 Tooling
丝锥折损 Breakage	切削扭矩过大 Excessive tapping torque	适当增加切削锥的长度 Select tap with long chamfer length.	①为了提高丝锥的锋利度，加大前角 ②为了减小扭矩扩大铲背减小刀刃厚度 ① Increase rake angle to improve cutting sharpness. ② Increase amount of thread relief and reduce land width to reduce friction torque.	①磨损部全部清除 ②缩短复磨周期 ① Make sure there are no worn-out areas. ② Shorten regrinding intervals.		
	使用条件不当 Incorrect operating conditions				保持稳定进给 Avoid inconsistent feed rate	①使用带有扭矩调整功能的装置 ②保持浮动攻丝 ① Use a tap holder that has torque adjustment function. ② Use a floating type tap holder.
刀刃损伤 Chipping	丝锥选型不当 Incorrect tap selection	防止切屑堵塞 Prevent chip clogging	①缩短螺纹长度 ②更换刀具材料 ③降低硬度 ④加长切削锥的长度 ① Reduce thread length. ② Change tool material. ③ Reduce hardness of the tap. ④ Increase chamfer length.	①磨损部全部清除 ②避免刀刃厚度过小 ① Make sure there are no worn-out areas. ② Make sure that land width is not excessively thin.		
	使用条件不当 Incorrect operating conditions				保持稳定进给 Avoid inconsistent feed rate	①盲孔时回转不宜过快 ②使用柔性攻丝夹具 ① When tapping hole, do not reverse rotation suddenly. ② Use floating type tap holder.
磨损 Excessive Wear	丝锥选型不当 Incorrect tap selection	①选择经过表面处理（氧化处理、涂层处理）的丝锥 ②选用EX型丝锥或粉末高速钢丝锥 ① Select surface-treatment (steam oxide or coating). ② Select High-Speed Steel tap that contains high vanadium or powder metal tap.	切削材料硬度高的情况下刀具要进行表面处理 If tapping material is hard, improve tool material or apply surface treatment.	①防止前角过大 ②防止研磨时的发热过高 ① Make sure that rake angle is not too large. ② Avoid tapping burn.		
	使用条件不当 Incorrect operating conditions					
粘结 Galling	摩擦热过高 Excessive frictional heat		①适当加工铲背 ②减小刀刃厚度 ① Increase amount of thread relief. ② Reduce land width.			

丝锥加工问题解答 TROUBLE SHOOTING

使用条件 Operating Conditions		加工材料 Work Material			其他 Other
切削条件 Tapping Conditions	切削油剂 Cutting Lubricant	硬度 Hardness	形状 Dimension	螺纹底孔 Drill Hole	
①降低切削速度 ②防止丝锥与底孔的偏心和底孔的倾斜 ③防止碰到底孔底部 ① Reduce tapping speed. ② Avoid misalignment between tap and drilled hole as well as inclination of drilled hole. ③ Avoid hitting bottom of the drilled hole with tap.		注意加工材料的硬度及组织结构的均一性 Pay special attention to changes and variations in tapping material, hardness and structure.		①防止底孔的偏心和倾斜 ②防止底孔的加工硬化 ③去除前一工序产生的切屑 ① Avoid misalignment and inclination from drilled hole. ② Avoid work hardening of the hole after tapping. ③ Remove chips generated in previous process.	
①降低切削速度 ②防止底孔偏心和倾斜 ① Reduce tapping speed. ② Avoid misalignment between tap and drilled hole as well as inclination of drilled hole.	选用溶着性好的切削油剂 Use lubricant that has higher anti-galling properies.	注意加工材料的硬度及组织结构的均一性 Pay special attention to changes and variations in tapping material, hardness and structure.		①防止底孔的偏心和倾斜 ②防止底孔加工时的加工硬化 ① Avoid misalignment and inclination from drilled hole. ② Avoid work hardening of the hole after tapping.	
①降低切削速度 ②防止底孔加工时的加工硬化 ① Reduce tapping speed. ② Avoid work hardening of the hole after tapping.	调整切削油剂种类及供油方法 Review lubricant type and lubricating method.	注意加工材料的硬度及组织结构的均一性 Pay special attention to changes and variations in tapping material, hardness and structure.		①尽可能加大底孔径 ②加工盲孔时，底孔尽可能深 ③防止产生底孔的加工硬化 ① Make hole as large as possible. ② In the case of a blind hole, make it as deep as possible. ③ Avoid work hardening of the hole after tapping.	
降低切削速度 Reduce tapping speed.	①调整切削油剂种类及供油方法 ②调整切削油剂的更换周期及补充周期 ③防止其他油剂(如润滑油)混入 ④过滤切削油 ① Review lubricant type and lubricating method. ② Correct lubricant change/replenishment intervals. ③ Prevent entry of other oils such as operating oil. ④ Filtrate oil stored in tank.				

关于螺纹底孔 DRILL HOLE

底孔径 DRILL HOLE SIZE

底孔径是影响攻丝加工的重要因素之一。
外螺纹和内螺纹的有效嵌合高度与标准牙形高的比称为嵌合率。

The Drill Hole diameter (or Thread Overlap Ratio) substantially affects tapping operations.
cf. Thread Overlap Ratio = percentage of thread overlap (a) to basic overlap (h)

嵌合率 ★ Formula ★

$$\text{嵌合率 Percentage of thread engagement} = \frac{\text{（外螺纹大径的基准尺寸）－（底孔径）}\ \text{(basic major dia. of external thread)−(drill hole dia.)}}{\text{2×（标准牙形高度）}\ \text{2×(basic height of thread engagement)}} \times 100$$

在加工内螺纹底孔之前必须考虑到这个嵌合率。
内螺纹小径和底孔直径相等。如果定下了螺距 P、外螺纹大径 d、嵌合率，那么底孔径 (公制螺纹、美制统一螺纹) 可由外螺纹标准牙高 0.541266P。

Because the minor dia. of the internal thread is equal to the Drill Hole diameter, the Drill diameter is calculated using the following formula (Metric and Unified Threads:)

底孔径 (公制螺纹、美制螺纹) ★ Formula ★

$$\text{底孔径 Drill Hole diameter} = d - 2 \times (0.541266P) \times \left(\frac{\text{嵌合率 (Percentage of thread engagement)}}{100} \right)$$

求出。

d: 外螺纹大径　d:Major diameter of External thread (mm)
P: 螺距　P:Pitch (mm)

图1　嵌合率
当外螺纹呈标准牙形时

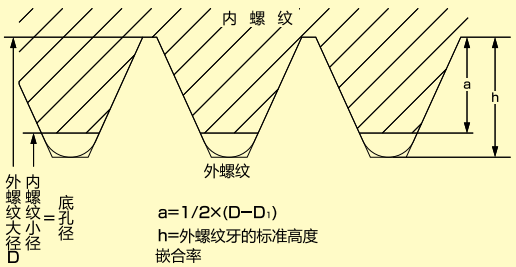
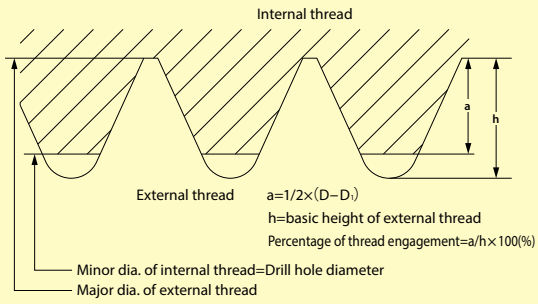


FIGURE 1. Percentage of thread engagement
When external thread profile is equal to basic profile



螺纹底孔径表 RECOMMENDED DRILL HOLE SIZE

嵌套螺纹用请参考 P869。For screw thread insert : Please refer to p.869

公制螺纹 Metric screw threads

JIS B 0209-1: 2007(单位：mm)
JIS B 8031- 2007(Unit : mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.			
		各精度通用	旧JIS级用	4H用	5H用	6H用
M 1 × 0.25	0.75	0.73	0.78	0.77	0.78	0.8
※ 1 × 0.2	0.8	0.79	—	0.82	0.83	0.84
1.1 × 0.25	0.85	0.83	0.88	0.87	0.88	0.9
※ 1.1 × 0.2	0.9	0.89	—	0.92	0.93	0.94
1.2 × 0.25	0.95	0.93	0.98	0.97	0.98	1
※ 1.2 × 0.2	1	0.99	—	1.02	1.03	1.04
1.4 × 0.3	1.1	1.08	1.14	1.12	1.14	1.16
※ 1.4 × 0.2	1.2	1.19	—	1.22	1.23	1.24
1.6 × 0.35	1.25	1.23	1.32	1.28	1.3	1.32
※ 1.6 × 0.2	1.4	1.39	—	1.42	1.43	1.44
※ 1.7 × 0.35	1.35	—	—	1.38	1.4	1.42
※ 1.7 × 0.3	1.4	—	—	1.42	1.44	1.46
※ 1.7 × 0.25	1.45	—	—	1.47	1.48	1.5
※ 1.7 × 0.2	1.5	—	—	1.52	1.53	1.54
1.8 × 0.35	1.45	1.43	1.52	1.48	1.5	1.52
※ 1.8 × 0.2	1.6	1.59	—	1.62	1.63	1.64
2 × 0.4	1.6	1.57	1.67	1.63	1.65	1.67
※ 2 × 0.25	1.75	1.73	—	1.77	1.78	1.8
2.2 × 0.45	1.75	1.72	1.83	1.79	1.81	1.83
※ 2.2 × 0.25	1.95	1.93	—	1.97	1.98	2
※ 2.3 × 0.4	1.9	—	—	1.93	1.95	1.97
※ 2.3 × 0.35	1.95	—	—	1.98	2	2.02
※ 2.3 × 0.25	2.05	—	—	2.07	2.08	2.1
2.5 × 0.45	2.05	2.02	2.13	2.09	2.11	2.13
2.5 × 0.35	2.15	2.13	2.22	2.18	2.2	2.22
※ 2.6 × 0.45	2.15	—	—	2.19	2.22	2.23
※ 2.6 × 0.35	2.25	—	—	2.28	2.3	2.32
※ 3 × 0.6	2.4	2.35	2.42	2.45	2.47	2.51
3 × 0.5	2.5	2.46	2.59	2.54	2.57	2.59
3 × 0.35	2.65	2.63	2.72	2.68	2.7	2.72
3.5 × 0.6	2.9	2.85	3.01	2.95	2.97	3.01
※ 3.5 × 0.5	3	2.96	—	3.04	3.07	3.09
3.5 × 0.35	3.15	3.13	3.22	3.18	3.2	3.22
4 × 0.75	3.25	3.19	3.32	3.3	3.33	3.37
4 × 0.7	3.3	3.25	3.42	3.35	3.38	3.42
4 × 0.5	3.5	3.46	3.59	3.54	3.57	3.59
4.5 × 0.75	3.75	3.69	3.87	3.8	3.83	3.87
4.5 × 0.5	4	3.96	4.09	4.04	4.07	4.09
※ 5 × 0.9	4.1	—	—	4.15	4.19	4.23
5 × 0.8	4.2	4.14	4.33	4.25	4.29	4.33
※ 5 × 0.75	4.25	4.19	—	4.3	4.33	4.37
5 × 0.5	4.5	4.46	4.59	4.54	4.57	4.59
※ 5.5 × 0.9	4.6	—	—	4.65	4.69	4.73
※ 5.5 × 0.75	4.75	—	—	4.8	4.83	4.87
5.5 × 0.5	5	4.96	5.09	5.04	5.07	5.09
6 × 1	5	4.92	5.15	5.06	5.1	5.15
6 × 0.75	5.25	5.19	5.37	5.3	5.33	5.37
※ 6 × 0.5	5.5	—	—	5.54	5.57	5.59
7 × 1	6	5.92	6.15	6.06	6.1	6.15
7 × 0.75	6.25	6.19	6.37	6.3	6.33	6.37

红字＝JIS粗牙螺纹
Red character = JIS coarse pitch thread

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.			
		各精度通用	旧JIS级用	4H用	5H用	6H用
※ 7 × 0.5	6.5	—	—	6.54	6.57	6.59
8 × 1.25	6.75	6.65	6.91	6.81	6.85	6.91
8 × 1	7	6.92	7.15	7.06	7.1	7.15
8 × 0.75	7.25	7.19	7.37	7.3	7.33	7.37
※ 8 × 0.5	7.5	—	—	7.54	7.57	7.59
9 × 1.25	7.75	7.65	7.91	7.81	7.85	7.91
9 × 1	8	7.92	8.15	8.06	8.1	8.15
9 × 0.75	8.25	8.19	8.37	8.3	8.33	8.37
※ 9 × 0.5	8.5	—	—	8.54	8.57	8.59
10 × 1.5	8.5	8.38	8.67	8.52	8.61	8.67
10 × 1.25	8.75	8.65	8.91	8.81	8.85	8.91
10 × 1	9	8.92	9.15	9.06	9.1	9.15
10 × 0.75	9.25	9.19	9.37	9.3	9.33	9.37
※ 10 × 0.5	9.5	—	—	9.54	9.57	9.59
11 × 1.5	9.5	9.38	9.67	9.52	9.61	9.67
11 × 1.25	9.75	9.65	9.8	9.81	9.85	9.91
11 × 1	10	9.92	10.15	10.06	10.1	10.15
11 × 0.75	10.25	10.19	10.37	10.3	10.33	10.37
※ 11 × 0.5	10.5	—	—	10.54	10.57	10.59
12 × 1.75	10.25	10.11	10.44	10.31	10.37	10.44
12 × 1.5	10.5	10.38	10.67	10.56	10.61	10.67
12 × 1.25	10.75	10.65	10.91	10.81	10.85	10.91
12 × 1	11	10.92	11.15	11.06	11.1	11.15
※ 12 × 0.75	11.25	—	—	11.3	11.33	11.37
※ 12 × 0.5	11.5	—	—	11.54	11.57	11.59
※ 13 × 1.75	11.25	—	—	11.31	11.37	11.44
※ 13 × 1.5	11.5	—	—	11.56	11.61	11.67
※ 13 × 1.25	11.75	—	—	11.81	11.85	11.91
※ 13 × 1	12	—	—	12.06	12.1	12.15
※ 13 × 0.75	12.3	—	—	12.3	12.33	12.37
※ 13 × 0.5	12.5	—	—	12.54	12.57	12.59
14 × 2	12	11.84	12.21	12.07	12.13	12.21
14 × 1.5	12.5	12.38	12.67	12.56	12.61	12.67
14 × 1.25	12.75	12.65	—	—	—	12.91
14 × 1	13	12.92	13.15	13.06	13.1	13.15
※ 14 × 0.75	13.3	—	—	13.3	13.33	13.37
※ 14 × 0.5	13.5	—	—	13.54	13.57	13.59
※ 15 × 2	13	—	—	13.07	13.13	13.21
15 × 1.5	13.5	13.4	13.6	13.56	13.61	13.67
15 × 1.25	13.8	13.7	13.9	13.81	13.85	13.91
15 × 1	14	13.95	14.15	14.06	14.1	14.15
※ 15 × 0.75	14.3	—	—	14.3	14.33	14.37
※ 15 × 0.5	14.5	—	—	14.54	14.57	14.59
16 × 2	14	13.9	14.2	14.07	14.13	14.21
16 × 1.5	14.5	14.4	14.6	14.56	14.61	14.67
※ 16 × 1.25	14.75	14.65	—	14.81	14.85	14.91
16 × 1	15	14.95	15.15	15.06	15.1	15.15
※ 16 × 0.75	15.25	15.19	—	15.3	15.33	15.37
16 × 0.5	15.5	15.46	15.52	15.54	15.57	15.59
※ 17 × 2	15	—	—	15.07	15.13	15.21

※ 推荐底孔径为旧 JIS2 级内螺纹用。
※ JIS 规格中没有的内螺纹底孔径为参考值。

The recommended tap limit corresponds to the old JIS class 2 internal thread standard.
※ Recommended drill hole diameters that are not listed in JIS are reference values.

螺纹底孔径表 RECOMMENDED DRILL HOLE SIZE

嵌套螺纹用请参考 P869。For screw thread insert : Please refer to p.869

公制螺纹 Metric screw threads

JIS B 0209-1: 2007(单位：mm)
JIS B 8031- 2007(Unit : mm)

红字＝JIS 粗牙螺纹
Red character = JIS coarse pitch thread

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.			
		各精度通用	旧JIS级用	4H用	5H用	6H用
17 X 1.5	15.5	15.4	15.68	15.56	15.61	15.67
※ 17 X 1.25	15.8	—	—	15.81	15.85	15.91
17 X 1	16	15.95	16.15	16.06	16.1	16.15
※ 17 X 0.75	16.3	—	—	16.3	16.33	16.37
※ 17 X 0.5	16.5	—	—	16.54	16.57	16.59
18 X 2.5	15.5	15.3	15.7	15.57	15.64	15.74
18 X 2	16	15.9	16.2	16.07	16.13	16.21
18 X 1.5	16.5	16.4	16.6	16.56	16.61	16.67
※ 18 X 1.25	16.75	16.65	—	16.81	16.85	16.91
18 X 1	17	16.95	17.15	17.06	17.1	17.15
※ 18 X 0.75	17.25	17.19	—	17.3	17.33	17.37
18 X 0.5	17.5	17.46	17.52	17.54	17.57	17.59
※ 19 X 2.5	16.5	—	—	16.57	16.64	16.74
※ 19 X 2	17	—	—	17.07	17.13	17.21
※ 19 X 1.5	17.5	—	—	17.56	17.61	17.67
※ 19 X 1.25	17.8	—	—	17.81	17.85	17.91
※ 19 X 1	18	—	—	18.06	18.1	18.15
※ 19 X 0.75	18.3	—	—	18.3	18.33	18.37
※ 19 X 0.5	18.5	—	—	18.54	18.57	18.59
20 X 2.5	17.5	17.3	17.7	17.57	17.64	17.74
20 X 2	18	17.9	18.2	18.07	18.13	18.21
20 X 1.5	18.5	18.4	18.6	18.56	18.61	18.67
※ 20 X 1.25	18.75	18.65	—	18.81	18.85	18.91
20 X 1	19	18.95	19.15	19.06	19.1	19.15
20 X 0.5	19.5	19.46	19.52	19.54	19.57	19.59
※ 21 X 2.5	18.5	—	—	18.57	18.64	18.74
※ 21 X 1.5	19.5	—	—	19.56	19.61	19.67
※ 21 X 1	20	—	—	20.06	20.1	20.15
22 X 2.5	19.5	19.3	19.7	19.57	19.64	19.74
22 X 2	20	19.9	20.2	20.07	20.13	20.21
22 X 1.5	20.5	20.4	20.6	20.56	20.61	20.67
22 X 1	21	20.95	21.15	21.06	21.1	21.15
22 X 0.5	21.5	21.46	21.52	21.54	21.57	21.59
※ 23 X 2.5	20.5	—	—	20.57	20.64	20.74
※ 23 X 2	21	—	—	21.07	21.13	21.21
※ 23 X 1.5	21.5	—	—	21.56	21.61	21.67
※ 23 X 1	22	—	—	22.06	22.1	22.15
24 X 3	21	20.8	21.2	21.06	21.15	21.25
※ 24 X 2.5	21.5	21.29	—	21.57	21.64	21.74
24 X 2	22	21.9	22.2	22.07	22.13	22.21
24 X 1.5	22.5	22.4	22.6	22.56	22.61	22.67
※ 24 X 1.25	22.75	22.65	—	22.81	22.85	22.91
24 X 1	23	22.95	23.15	23.06	23.1	23.15
※ 25 X 3	22	—	—	22.06	22.15	22.25
25 X 2	23	22.9	23.2	23.07	23.13	23.21
25 X 1.5	23.5	23.4	23.6	23.56	23.61	23.67
25 X 1	24	23.95	24.15	24.06	24.1	24.15
※ 26 X 3	23	—	—	23.06	23.15	23.25
※ 26 X 2	24	—	—	24.07	24.13	24.21
26 X 1.5	24.5	24.4	24.6	24.56	24.61	24.67

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.			
		各精度通用	旧JIS级用	4H用	5H用	6H用
26 X 1	25	24.95	25.15	25.06	25.1	25.15
27 X 3	24	23.8	24.2	24.06	24.15	24.25
※ 27 X 2.5	24.5	—	—	24.57	24.64	24.74
27 X 2	25	24.9	25.2	25.07	25.13	25.21
27 X 1.5	25.5	25.4	25.6	25.56	25.61	25.67
27 X 1	26	25.95	26.15	26.06	26.1	26.15
※ 28 X 3	25	—	—	25.06	25.15	25.25
28 X 2	26	25.9	26.2	26.07	26.13	26.21
28 X 1.5	26.5	26.4	26.6	26.56	26.61	26.67
28 X 1	27	26.95	27.15	27.06	27.1	27.15
30 X 3.5	26.5	26.3	26.7	26.56	26.66	26.77
30 X 3	27	26.8	27.2	27.06	27.15	27.25
30 X 2	28	27.9	28.2	28.07	28.13	28.21
30 X 1.5	28.5	28.4	28.6	28.56	28.61	28.67
30 X 1	29	28.95	29.15	29.06	29.1	29.15
※ 32 X 3	29	—	—	29.06	29.15	29.25
32 X 2	30	29.9	30.2	30.07	30.13	30.21
32 X 1.5	30.5	30.4	30.6	30.56	30.61	30.67
32 X 1	31	30.95	31.15	31.06	31.1	—
33 X 3.5	29.5	29.3	29.7	29.56	29.66	29.77
33 X 3	30	29.8	30.2	30.06	30.15	30.25
33 X 2	31	30.9	31.2	31.07	31.13	31.21
33 X 1.5	31.5	31.4	31.6	31.56	31.61	31.67
※ 33 X 1	32	—	—	32.06	32.1	32.15
※ 34 X 3	31	—	—	31.06	31.15	31.25
※ 34 X 2	32	—	—	32.07	32.13	32.21
※ 34 X 1.5	32.5	—	—	32.56	32.61	32.67
※ 34 X 1	33	—	—	33.06	33.1	33.15
※ 35 X 3	32	—	—	32.06	32.15	32.25
※ 35 X 2	33	—	—	33.07	33.13	33.2
35 X 1.5	33.5	33.4	33.6	33.56	33.61	33.67
※ 35 X 1	34	—	—	34.06	34.1	34.15
36 X 4	32	31.7	32.2	32.04	32.14	32.27
36 X 3	33	32.8	33.2	33.06	33.15	33.25
36 X 2	34	33.9	34.2	34.07	34.13	34.21
36 X 1.5	34.5	34.4	34.6	34.56	34.61	34.67
※ 36 X 1	35	—	—	35.06	35.1	35.15
※ 37 X 1.5	35.5	—	—	35.56	35.61	35.67
※ 37 X 1	36	—	—	36.06	36.1	36.15
※ 38 X 4	34	—	—	34.04	34.14	34.27
※ 38 X 3	35	—	—	35.06	35.15	35.25
※ 38 X 2	36	—	—	36.07	36.13	36.21
38 X 1.5	36.5	36.4	36.6	36.56	36.61	36.67
38 X 1	37	36.95	37.15	37.06	37.1	37.15
39 X 4	35	34.7	35.2	35.04	35.14	35.27
39 X 3	36	35.8	36.2	36.06	36.15	36.25
39 X 2	37	36.9	37.2	37.07	37.13	37.21
39 X 1.5	37.5	37.4	37.6	37.56	37.61	37.67
※ 39 X 1	38	—	—	38.06	38.1	38.15
※ 40 X 4	36	—	—	36.04	36.14	36.27

※ 推荐底孔径为旧 JIS2 级内螺纹用。
※ JIS 规格中没有的内螺纹底孔径为参考值。

The recommended tap limit corresponds to the old JIS class 2 internal thread standard.
※ Recommended drill hole diameters that are not listed in JIS are reference values.

螺纹底孔径表 RECOMMENDED DRILL HOLE SIZE

嵌套螺纹用请参考 P869。For screw thread insert : Please refer to p.869

公制螺纹 Metric screw threads

JIS B 0209-1: 2007(单位：mm)
JIS B 8031- 2007(Unit：mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.			
		各精度通用	旧JIS级用	4H用	5H用	6H用
40 X 3	37	36.8	37.2	37.06	37.15	37.25
40 X 2	38	37.9	38.2	38.07	38.13	38.21
40 X 1.5	38.5	38.4	38.6	38.56	38.61	38.67
※ 40 X 1	39	—	—	39.06	39.1	39.15
42 X 4.5	37.5	37.2	37.7	37.55	37.65	37.79
42 X 4	38	37.7	38.2	38.04	38.14	38.27
42 X 3	39	38.8	39.2	39.06	39.15	39.25
42 X 2	40	39.9	40.2	40.07	40.13	40.21
42 X 1.5	40.5	40.4	40.6	40.56	40.61	40.67
42 X 1	41	40.95	41.03	41.06	41.1	41.15
45 X 4.5	40.5	40.2	40.7	40.55	40.65	40.79
45 X 4	41	40.7	41.2	41.04	41.14	41.27
45 X 3	42	41.8	42.2	42.06	42.15	42.25
45 X 2	43	42.9	43.2	43.07	43.13	43.21
45 X 1.5	43.5	43.4	43.6	43.56	43.61	43.67
※ 45 X 1	44	—	—	44.06	44.1	44.15
※ 46 X 1.5	44.5	—	—	44.56	44.61	44.67
48 X 5	43	42.6	43.2	43.03	43.14	43.29
48 X 4	44	43.7	44.2	44.04	44.14	44.27
48 X 3	45	44.8	45.2	45.06	45.15	45.25
48 X 2	46	45.9	46.2	46.07	46.13	46.21
48 X 1.5	46.5	46.4	46.6	46.56	46.61	46.67
※ 48 X 1	47	—	—	47.06	47.1	47.15
※ 50 X 5	45	—	—	45.03	45.14	45.29
※ 50 X 4	46	45.7	—	46	46.1	46.2
50 X 3	47	46.8	47.2	47.06	47.15	47.25
50 X 2	48	47.9	48.2	48.07	48.13	48.21
50 X 1.5	48.5	48.4	48.6	48.56	48.61	48.67
※ 50 X 1	49	—	—	49.1	49.1	49.15
52 X 5	47	46.6	47.2	47	47.1	47.2
52 X 4	48	47.7	48.2	48	48.1	48.2
52 X 3	49	48.8	49.2	49	49.1	49.2
52 X 2	50	49.9	50.2	50	50.1	50.2
52 X 1.5	50.5	50.4	50.6	50.5	50.6	50.6
55 X 4	51	50.7	51.2	51	51.1	51.2
55 X 3	52	51.8	52.2	52	52.1	52.2
55 X 2	53	52.9	53.2	53	53.1	53.2
55 X 1.5	53.5	53.4	53.6	53.5	53.6	53.6
56 X 5.5	50.5	50.1	50.7	50.5	50.6	50.7
56 X 4	52	51.7	52.2	52	52.1	52.2
56 X 3	53	52.8	53.2	53	53.1	53.2
56 X 2	54	53.9	54.2	54	54.1	54.2
56 X 1.5	54.5	54.4	54.6	54.5	54.6	54.6
58 X 4	54	53.7	54.2	54	54.1	54.2
58 X 3	55	54.8	55.2	55	55.1	55.2
58 X 2	56	55.9	56.2	56	56.1	56.2
58 X 1.5	56.5	56.4	56.6	56.5	56.6	56.6
60 X 5.5	54.5	54.1	54.7	54.5	54.6	54.7
60 X 4	56	55.7	56.2	56	56.1	56.2
60 X 3	57	56.8	57.2	57	57.1	57.2

※ 推荐底孔径为旧 JIS2 级内螺纹用。
※ JIS 规格中没有的内螺纹底孔径为参考值。

红字＝JIS粗牙螺纹
Red character = JIS coarse pitch thread

(单位：mm)
(Unit：mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.			
		各精度通用	旧JIS级用	4H用	5H用	6H用
60 X 2	58	57.9	58.2	58	58.1	58.2
60 X 1.5	58.5	58.4	58.6	58.5	58.6	58.6
62 X 4	58	57.7	58.2	58	58.1	58.2
62 X 3	59	58.8	59.2	59	59.1	59.2
62 X 2	60	59.9	60.2	60	60.1	60.2
62 X 1.5	60.5	60.4	60.6	60.5	60.6	60.6
64 X 6	58	57.6	58.3	58	58.1	58.2
64 X 4	60	59.7	60.2	60	60.1	60.2
64 X 3	61	60.8	61.2	61	61.1	61.2
64 X 2	62	61.9	62.2	62	62.1	62.2
64 X 1.5	62.5	62.4	62.6	62.5	62.6	62.6
65 X 4	61	60.7	61.2	61	61.1	61.2
65 X 3	62	61.8	62.2	62	62.1	62.2
65 X 2	63	62.9	63.2	63	63.1	63.2
65 X 1.5	63.5	63.4	63.6	63.5	63.6	63.6
68 X 6	62	61.6	62.3	62	62.1	62.2
68 X 4	64	63.7	64.2	64	64.1	64.2
68 X 3	65	64.8	65.2	65	65.1	65.2
68 X 2	66	65.9	66.2	66	66.1	66.2
68 X 1.5	66.5	66.4	66.6	66.5	66.6	66.6
70 X 6	64	63.6	64.3	64	64.1	64.3
70 X 4	66	65.7	66.2	66	66.1	66.2
70 X 3	67	66.8	67.2	67	67.1	67.2
70 X 2	68	67.9	68.2	68	68.1	68.2
72 X 6	66	65.6	66.3	66	66.1	66.3
72 X 4	68	67.7	68.2	68	68.1	68.2
72 X 3	69	68.8	69.2	69	69.1	69.2
72 X 2	70	69.9	70.2	70	70.1	70.2
75 X 4	71	70.7	71.2	71	71.1	71.2
75 X 3	72	71.8	72.2	72	72.1	72.2
75 X 2	73	72.9	73.2	73	73.1	73.2
76 X 2	74	73.9	74.2	74	74.1	74.2
80 X 6	74	73.6	74.3	74	74.1	74.3
80 X 4	76	75.7	76.2	76	76.1	76.2
80 X 3	77	76.8	77.2	77	77.1	77.2
80 X 2	78	77.9	78.2	78	78.1	78.2
85 X 6	79	78.6	79.3	79	79.1	79.3
85 X 4	81	80.7	81.2	81	81.1	81.2
85 X 3	82	81.8	82.2	82	82.1	82.2
85 X 2	83	82.9	83.2	83	83.1	83.2
90 X 6	84	83.6	84.3	84	84.1	84.3
90 X 4	86	85.7	86.2	86	86.1	86.2
90 X 2	88	87.9	88.2	88	88.1	88.2
95 X 6	89	88.6	89.3	89	89.1	89.3
95 X 4	91	90.7	91.2	91	91.1	91.2
95 X 2	93	92.9	93.2	93	93.1	93.2
100 X 6	94	93.6	94.3	94	94.1	94.3
100 X 4	96	95.7	96.2	96	96.1	96.2
100 X 2	98	97.9	98.2	98	98.1	98.2

The recommended tap limit corresponds to the old JIS class 2 internal thread standard.
※ Recommended drill hole diameters that are not listed in JIS are reference values.

螺纹底孔径表 RECOMMENDED DRILL HOLE SIZE

嵌套螺纹用请参考 P869。For screw thread insert : Please refer to p.869

美制螺纹 Unified screw threads

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	JIS2B级用 JIS class 2B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
No. 0 - 80UNF	1.25	1.19	1.3
1 - 64UNC	1.5	1.43	1.57
1 - 72UNF	1.55	1.48	1.61
2 - 56UNC	1.79	1.7	1.87
2 - 64UNF	1.84	1.76	1.91
3 - 48UNC	2.05	1.95	2.14
3 - 56UNF	2.11	2.03	2.19
4 - 40UNC	2.27	2.16	2.38
4 - 48UNF	2.37	2.28	2.45
5 - 40UNC	2.59	2.49	2.69
5 - 44UNF	2.65	2.56	2.74
6 - 32UNC	2.77	2.65	2.89
6 - 40UNF	2.92	2.82	3.02
8 - 32UNC	3.42	3.31	3.53
8 - 36UNF	3.51	3.41	3.6
10 - 24UNC	3.81	3.69	3.93
10 - 32UNF	4.07	3.97	4.16
12 - 24UNC	4.47	4.35	4.59
12 - 28UNF	4.61	4.5	4.72
1/4 - 20UNC	5.12	4.98	5.25
1/4 - 28UNF	5.47	5.36	5.58
※ 1/4 - 32UNEF	5.59	5.49	5.68
5/16 - 18UNC	6.57	6.41	6.73
5/16 - 24UNF	6.91	6.79	7.03
※ 5/16 - 32UNEF	7.18	7.09	7.26
3/8 - 16UNC	7.98	7.8	8.15
※ 3/8 - 20UN	8.3	8.16	8.43
3/8 - 24UNF	8.51	8.39	8.63
※ 3/8 - 32UNEF	8.77	8.67	8.86
7/16 - 14UNC	9.35	9.15	9.55
7/16 - 20UNF	9.88	9.73	10.03
1/2 - 13UNC	10.81	10.6	11.02
1/2 - 20UNF	11.47	11.33	11.6
9/16 - 12UNC	12.2	12	12.4
9/16 - 18UNF	12.9	12.8	13
5/8 - 11UNC	13.6	13.4	13.8
5/8 - 18UNF	14.5	14.4	14.6
※ 5/8 - 24UNEF	14.9	14.8	14.9
3/4 - 10UNC	16.6	16.4	16.8
3/4 - 16UNF	17.5	17.4	17.6
※ 3/4 - 20UNEF	17.8	17.7	17.9
7/8 - 9UNC	19.5	19.2	19.7
7/8 - 14UNF	20.5	20.3	20.6
※ 7/8 - 20UNEF	21	20.9	21.1
1 - 8UNC	22.3	22	22.6
1 - 12UNF	23.4	23.2	23.5
※ 1 - 14UNS	23.7	23.5	23.8
※ 1 1/16 - 12UN	24.9	24.7	25.1
1 1/8 - 7UNC	25	24.7	25.3
※ 1 1/8 - 8UN	25.5	25.2	25.7
1 1/8 - 12UNF	26.5	26.3	26.7
1 1/4 - 7UNC	28.2	27.9	28.5
※ 1 1/4 - 8UN	28.7	28.4	28.9
1 1/4 - 12UNF	29.7	29.5	29.9

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	JIS2B级用 JIS class 2B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
※ 1 5/16 - 12UN	31.3	31.1	31.4
1 3/8 - 6UNC	30.8	30.4	31.1
※ 1 3/8 - 8UN	31.8	31.5	32.1
1 3/8 - 12UNF	32.9	32.7	33
1 1/2 - 6UNC	33.9	33.6	34.2
※ 1 1/2 - 8UN	35	34.7	35.3
1 1/2 - 12UNF	36.1	35.9	36.2
※ 1 5/8 - 5UNS	36.2	35.8	36.6
※ 1 5/8 - 8UN	38.2	37.9	38.4
※ 1 5/8 - 12UN	39.2	39	39.4
1 3/4 - 5UNC	39.4	39	39.8
※ 1 3/4 - 8UN	41.4	41.1	41.6
※ 1 3/4 - 12UN	42.4	42.2	42.6
※ 1 7/8 - 8UN	44.5	44.2	44.8
2 - 4.5UNC	45.1	44.7	45.5
※ 2 - 8UN	47.7	47.4	48
※ 2 - 12UN	48.8	48.6	48.9
2 1/4 - 4.5UNC	51.5	51.1	51.9
2 1/2 - 4UNC	57.1	56.7	57.5
※ 2 1/2 - 8UN	60.4	60.1	60.7
2 3/4 - 4UNC	63.5	63	63.9
※ 2 3/4 - 8UN	66.8	66.5	67
3 - 4UNC	69.8	69.4	70.2
※ 3 - 8UN	73.1	72.8	73.4
3 1/4 - 4UNC	76.2	75.7	76.6
3 1/2 - 4UNC	82.5	82.1	82.9
※ 3 1/2 - 8UN	85.8	85.5	86.1
3 3/4 - 4UNC	88.9	88.4	89.3
4 - 4UNC	95.2	94.8	95.6
※ 4 - 8UN	98.5	98.2	98.8
※ 4 1/4 - 4UN	101.6	101.1	102
※ 4 1/4 - 6UN	103.8	103.4	104.1
※ 4 1/4 - 8UN	104.9	104.6	105.1
※ 4 1/2 - 4UN	107.9	107.5	108.3
※ 4 1/2 - 6UN	110.1	109.8	110.4
※ 4 1/2 - 8UN	111.2	110.9	111.5
※ 4 3/4 - 4UN	126.3	137.8	114.7
※ 4 3/4 - 6UN	116.5	116.1	116.8
※ 4 3/4 - 8UN	117.6	117.3	117.8
※ 5 - 4UN	120.6	120.2	121
※ 5 - 6UN	122.8	122.5	123.1
※ 5 - 8UN	123.9	123.6	124.2
※ 5 1/4 - 4UN	127	126.5	127.4
※ 5 1/4 - 6UN	129.2	128.8	129.5
※ 5 1/4 - 8UN	130.3	130	130.5
※ 5 1/2 - 4UN	133.3	132.9	133.7
※ 5 1/2 - 6UN	134.5	135.2	133.8
※ 5 1/2 - 8UN	136.6	136.3	136.9
※ 5 3/4 - 4UN	139.7	139.2	140.1
※ 5 3/4 - 6UN	141.9	141.5	142.2
※ 5 3/4 - 8UN	143	142.7	143.2
※ 6 - 4UN	146	145.6	146.4
※ 6 - 6UN	148.2	147.9	148.5
※ 6 - 8UN	149.3	149	149.6

※ JIS 规格内没有的内螺纹的底孔径为参考值。
根据 JIS B 1004-1975。
基准牙形与各数值与公制螺纹相同。

※ Recommended drill hole diameters that are not listed in JIS are reference values.
In accordance to JIS B 1004-1975.
Thread value are the same as metric standard.

螺纹底孔径表 RECOMMENDED DRILL HOLE SIZE

航天航空用UNJ螺纹规格 UNJ thread for aircraft and aerospace industry

根据ISO 3161 Third edition 1999-12-01。(单位：mm)
根据MIL-S-8879C 25 July 1991。(Unit：mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	3B级用 3B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
No. 6 - 32UNJC	2.84	2.74	2.93
6 - 40UNJF	2.97	2.89	3.05
8 - 32UNJC	3.5	3.4	3.59
8 - 36UNJF	3.57	3.48	3.66
10 - 24UNJC	3.93	3.8	4.06
10 - 32UNJF	4.16	4.06	4.25
1/4 - 20UNJC	5.25	5.12	5.38
1/4 - 28UNJF	5.57	5.47	5.66

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	3B级用 3B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
5/16 - 18UNJC	6.7	6.57	6.83
5/16 - 24UNJF	7.01	6.91	7.1
3/8 - 16UNJC	8.12	7.98	8.25
3/8 - 24UNJF	8.59	8.5	8.67
7/16 - 14UNJC	9.49	9.35	9.63
7/16 - 20UNJF	9.98	9.88	10.08
1/2 - 13UNJC	10.95	10.8	11.09
1/2 - 20UNJF	11.57	11.47	11.66

缝纫机螺纹 Screw threads for sewing machines

(单位：mm)
(Unit：mm)

螺纹尺寸 Thread size	钻头直径 Drill dia.	2级螺纹及底孔径 JIS class 2 drill hole dia.	2级内螺纹小径 JIS class 2B Internal thread minor dia.	
			最小尺寸 Min.	最大尺寸 Max.
SM 1/16 - 80	1.25	1.28(75%)	1.211	1.281
5/64 - 64	1.55	1.57(80%)	1.513	1.593
3/32 - 100	2.1	2.15(70%)	2.081	2.156
3/32 - 56	1.85	1.91(80%)	1.841	1.936
1/8 - 44	2.5	2.58(80%)	2.485	2.605
1/8 - 40	2.45	2.52(80%)	2.421	2.551
9/64 - 40	2.85	2.91(80%)	2.818	2.948
11/64 - 40	3.65	3.71(80%)	3.612	3.742
3/16 - 32	3.9	3.94(80%)	3.82	3.98
3/16 - 28	3.7	3.82(80%)	3.684	3.844
3/16 - 24	3.55	3.59(85%)	3.498	3.658
7/32 - 32	4.7	4.73(80%)	4.614	4.774
15/64 - 28	4.9	5.01(80%)	4.875	5.055
1/4 - 40	5.6	5.69(80%)	5.596	5.726
1/4 - 28	5.3	5.41(80%)	5.272	5.452

(单位：mm)
(Unit：mm)

螺纹尺寸 Thread size	钻头直径 Drill dia.	2级螺纹及底孔径 JIS class 2 drill hole dia.	2级内螺纹小径 JIS class 2B Internal thread minor dia.	
			最小尺寸 Min.	最大尺寸 Max.
SM 1/4 - 24	5.1	5.25(80%)	5.086	5.266
9/32 - 28	6.1	6.2 (80%)	6.066	6.256
9/32 - 20	5.7	5.82(80%)	5.634	5.824
5/16 - 28	6.9	6 (80%)	6.86	7.05
5/16 - 24	6.7	6.84(80%)	6.674	6.864
5/16 - 18	6.3	6.38(85%)	6.254	6.444
11/32 - 28	7.6	7.79(80%)	7.653	7.843
3/8 - 28	8.5	8.58(80%)	8.447	8.637
3/8 - 18	7.9	7.97(85%)	7.843	8.053
7/16 - 28	10.1	10.17(80%)	10.034	10.224
7/16 - 16	9.3	9.36(85%)	9.22	9.44
1/2 - 28	11.7	11.76(80%)	11.622	11.812
1/2 - 20	11.3	11.38(80%)	11.19	11.41
1/2 - 12	10.3	10.36(85%)	10.18	10.42

惠氏粗牙螺纹 Whitworth Coarse screw threads

(单位：mm)
(Unit：mm)

螺纹尺寸 Thread size	牙数 Number of thread	内螺纹最小径 Internal thread min.minor dia.	内螺纹最大径 Internal thread max.minor dia.
W 1/8	40	2.452	2.602
5/32	32	3.073	3.253
3/16	24	3.567	3.807
1/4	20	4.914	5.204
5/16	18	6.34	6.67
3/8	16	7.733	8.113
7/16	14	9.048	9.508
1/2	12	10.31	10.83
9/16	12	11.898	12.418
5/8	11	13.257	13.817
3/4	10	16.178	16.778
7/8	9	19.031	19.691
1	8	21.814	22.514
1 1/8	7	24.469	25.229

螺纹尺寸 Thread size	牙数 Number of thread	内螺纹最小径 Internal thread min.minor dia.	内螺纹最大径 Internal thread max.minor dia.
1 1/4	7	27.644	28.404
1 3/8	6	30.123	30.923
1 1/2	6	33.298	34.098
1 5/8	5	35.529	36.409
1 3/4	5	38.704	39.584
1 7/8	4 1/2	41.237	42.227
2	4 1/2	44.412	45.402
2 1/8	4	46.783	47.893
2 1/4	4	49.958	51.068
2 3/8	4	53.133	54.243
2 1/2	4	56.308	57.418
2 3/4	3 1/2	61.636	62.816
2 7/8	3 1/2	64.81	65.99
3	3 1/2	67.986	69.166

螺纹底孔径表 RECOMMENDED DRILL HOLE SIZE

锥管螺纹 (英式)
Taper pipe threads

(单位 : mm)
(Unit : mm)

螺纹 Thread		JIS B 0203				JIS B 2301	
		锥管内螺纹 Rc(PT) Taper internal threads(PT)		平行内螺纹 Rp(PS) Parallel internal threads(PS)		锥管内螺纹 Taper internal threads	
尺寸 Thread size	外径 Major dia.	计算值 calculated value	底孔径 Drill hole dia.	计算值 calculated value	底孔径 Drill hole dia.	计算值 calculated value	底孔径 Drill hole dia.
1/16	7.723	6.23	6.2	6.49	6.5	—	—
1/8	9.728	8.235	8.2	8.495	8.5	8.191	8.2
1/4	13.157	10.941	10.9	11.341	11.4	10.945	10.9
3/8	16.662	14.428	14.4	14.846	14.9	14.388	14.4
1/2	20.955	17.95	18	18.489	18.5	17.943	18
3/4	26.441	23.349	23	23.975	24	23.305	23
1	33.249	29.423	29	30.111	30	29.353	29
1 1/4	41.91	37.94	38	38.772	39	37.89	38
1 1/2	47.803	43.833	44	44.565	45	43.72	43
2	59.614	55.412	55	56.476	56	55.406	55
2 1/2	75.184	70.701	71	72.009	72	70.788	70
3	87.884	83.201	83	84.709	85	83.364	83
3 1/2	100.33	95.547	96	97.155	97	95.747	95
4	113.03	107.834	108	109.855	110	108.322	108
5	138.43	133.11	133	135.255	135	133.597	133
6	163.83	158.51	159	160.655	161	158.81	158
7	189.23	183.36	183	185.954	186	—	—
8	214.63	208.56	209	211.354	212	—	—
9	240.03	233.96	234	236.754	237	—	—
10	265.43	259.166	259	262.154	262	—	—
12	316.23	309.747	310	312.875	313	—	—

1982年由于ISO的导入，JIS管用螺纹规格有所修改。螺纹记号得到变更，但螺纹精度没有改变。因此丝锥的新旧记号可以通用。

The JIS pipe thread standard was revised in 1982 to meet ISO standards. Although thread symbols changed, the limits were not changed. Therefore, it is still acceptable to use taps with both new and old symbols.
(JIS B 0202-1982 / JIS B 0203-1982)

种类 Type	旧记号 Previous Symbol	新记号 New Symbol
密封用锥管内螺纹 Taper pipe threads for pressure-tight joints	PT	Rc
密封用平行管螺纹 Parallel pipe threads for pressure-tight joints	PS	Rp
一般结合用平行内螺纹 Parallel pipe threads for mechanical joints	PF	G

1. JIS B 0203锥管内螺纹的计算值为，当基准值位于连接部端面时，允许有效螺纹的小端径处存在不完全山形的直孔孔径。
2. JIS B 2301锥管内螺纹的计算值为，当基准值位于连接部端面时，不允许在小端径处存在不完全牙形的直孔孔径。
3. PT、PS的⅛遵循JIS B 0203-1982Rc、Rp的螺纹规格。

1. Calculated value of JIS B 0203 taper thread refers to the diameter of the straight hole in case that the last one thread at the small diameter position in useful threads is allowed to be incomplete when the reference is on the end surface of the joint.
2. Calculated value of JIS B 2301 taper thread refers to the diameter of the straight hole in case that the last thread at the small diameter position needs to be complete when the reference is on the end surface of the joint.
3. The values for 1/16 of OT and PS conform to those of Rc and Rp threads under JIS B 0203-1982.

平行管螺纹(英式)
Parallel pipe threads

(单位 : mm)
(Unit : mm)

螺纹 Thread		最小底孔径(嵌合率%) Drill hole dia min.	最大底孔径(嵌合率%) Drill hole dia max.
尺寸 Thread size	外径 d Major dia.		
G 1/16	7.723	6.561 (100)	6.843 (80)
G(PF) 1/8	9.728	8.566 〃	8.848 〃
1/4	13.157	11.445 〃	11.89 (75)
3/8	16.662	14.95 〃	15.395 〃
1/2	20.955	18.631 〃	19.172 (80)
5/8	22.911	20.587 〃	21.128 〃
3/4	26.441	24.117 〃	24.658 〃
7/8	30.201	27.877 〃	28.418 〃
1	33.249	30.291 〃	30.931 〃
1 1/8	37.897	34.939 〃	35.579 〃
1 1/4	41.91	38.952 〃	39.592 (85)
1 3/8	44.323	41.365 〃	42.005 (80)
1 1/2	47.803	44.845 〃	45.485 〃
1 3/4	53.746	50.788 〃	51.428 〃
2	59.614	56.656 〃	57.296 〃
2 1/2	75.184	72.226 〃	72.866 〃
3	87.884	84.926 〃	85.566 〃
3 1/2	100.33	97.372 〃	98.012 〃
4	113.03	110.072 〃	110.712 〃

平行管螺纹(PF) NRT丝锥 (英式)
Parallel pipe threads (Nu-Roll tap)

(单位 : mm)
(Unit : mm)

尺寸 Thread		RH 精度 RH Limits	最小～最大 (嵌合率%) Min. ～ Max. (Thread Overlap Ratio:%)
尺寸 Thread size	外径 d Major dia.		
PF1/8	9.728	6	9.24 ～ 9.35 (100 ～80)
1/4	13.157	7	12.41 ～12.62 (100 ～75)
3/8	16.662	7	15.92 ～16.12 (100 ～75)
1/2	20.955	8	19.93 ～20.15 (100 ～80)
3/4	26.441	8	25.41 ～25.64 (100 ～80)
1	33.249	10	31.919 ～32.205 (100 ～80)

螺纹底孔径表 RECOMMENDED DRILL HOLE SIZE

美标管用螺纹 (NPT•NPSC)
American pipe threads

(单位：mm( )=inch)
(Unit：mm( )=inch)

螺纹 Thread		锥管螺纹 (NPT) Taper threads (NPT)				平行螺纹 (NPSC) Parallel threads (NPSC)	
		钻头直径 Drill dia.				钻头直径 Drill dia.	
尺寸 Thread size	外径 Major dia.	使用铰刀时 Where Reamer is used		不使用铰刀时 Where Reamer is not used			
1/16	7.77	—	5.94 (0.234)	—	6.15 (0.242)	1/4	6.35 (0.25)
1/8	10.117	21/64	8.33 (0.328)	—	8.43 (0.332)	11/32	8.74 (0.344)
1/4	13.426	27/64	10.72 (0.422)	7/16	11.13 (0.438)	7/16	11.13 (0.438)
3/8	16.866	9/16	14.27 (0.562)	9/16	14.27 (0.562)	37/64	14.68 (0.578)
1/2	20.98	11/16	17.48 (0.688)	45/64	17.86 (0.703)	23/32	18.26 (0.719)
3/4	26.325	57/64	22.63 (0.891)	29/32	23.01 (0.906)	59/64	23.42 (0.922)
1	32.934	1 1/8	28.58 (1.125)	1 9/64	28.98 (1.141)	1 5/32	29.36 (1.156)
1 1/4	41.689	1 15/32	37.31 (1.469)	1 31/64	37.69 (1.484)	1 1/2	38.1 (1.5)
1 1/2	47.76	1 45/64	43.26 (1.703)	1 23/32	43.66 (1.719)	1 3/4	44.45 (1.75)
2	59.797	2 11/64	55.17 (2.172)	2 3/16	55.58 (2.188)	2 7/32	56.36 (2.219)
2 1/2	72.273	2 37/64	65.48 (2.578)	2 39/64	66.27 (2.609)	2 21/32	67.46 (2.656)

上述钻头直径取自美式管用螺纹 ANSI/ASME B1.20.1-1983 Pipe Threads,General Purpose (Inch)附录推荐的钻头直径。
The drill sizes are quoted from ANSI/ASME B1.20.1-1983 Pipe Threads,General Purpose (Inch) Appendix.

美标干圈管用螺纹(NPTF•NPSF)
American dryseal pipe threads

(单位：mm( )=inch)
(Unit：mm( )=inch)

螺纹 Thread		锥管螺纹 (NPTF) Taper threads (NPTF)				平行螺纹 (NPSF) Parallel threads (NPSF)	
		钻头直径 Drill dia.				钻头直径 Drill dia.	
尺寸 Thread size	外径 Major dia.	使用铰刀时 Where Reamer is used		不使用铰刀时 Where Reamer is not used			
1/16	7.77	—	5.94 (0.234)	—	6.15 (0.242)	—	6.25 (0.246)
1/8	10.117	21/64	8.33 (0.328)	—	8.43 (0.332)	—	8.61 (0.339)
1/4	13.426	27/64	10.72 (0.422)	7/16	11.13 (0.438)	7/16	11.13 (0.438)
3/8	16.866	9/16	14.3 (0.563)	9/16	14.27 (0.562)	37/64	14.68 (0.578)
1/2	20.98	11/16	17.48 (0.688)	45/64	17.86 (0.703)	45/64	17.86 (0.703)
3/4	26.325	57/64	22.63 (0.891)	29/32	23.01 (0.906)	59/64	23.42 (0.922)
1	32.934	1 1/8	28.58 (1.125)	1 9/64	28.98 (1.141)	1 5/32	29.36 (1.156)
1 1/4	41.689	1 15/32	37.31 (1.469)	1 31/64	37.69 (1.484)	—	—
1 1/2	47.76	1 45/64	43.26 (1.703)	1 23/32	43.66 (1.719)	—	—
2	59.797	2 11/64	55.17 (2.172)	2 3/16	55.58 (2.188)	—	—
2 1/2	72.273	2 37/64	65.48 (2.578)	2 39/64	66.27 (2.609)	—	—

上述钻头直径取自 ANSI B1.20.3-1976 Dryseal Pipe Threads, (Inch)。
The drill sizes are quoted from ANSI B1.20.3-1976 Dryseal Pipe Threads (Inch) Appendix.

美制粗牙螺纹(NRT丝锥)
Unified Coarse screw threads (Nu-Roll tap)

(单位：mm)
(Unit：mm)

螺纹尺寸 Thread size	2B级螺纹用底孔径 for JIS class 2B drill hole dia.		3B级螺纹用底孔径 for JIS class 3B drill hole dia.	
	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio:%)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio:%)
No. 1 - 64UNC	3	1.66 ～ 1.7 (100～65)	2	1.65 ～ 1.69 (100～65)
No. 2 - 56	4	1.96 ～ 2.02 (100～65)	3	1.95 ～ 2.01 (100～65)
No. 3 - 48	4	2.25 ～ 2.32 (100～65)	3	2.23 ～ 2.31 (100～65)
No. 4 - 40	5	2.52 ～ 2.6 (100～70)	3	2.5 ～ 2.58 (100～70)
No. 5 - 40	5	2.86 ～ 2.93 (100～70)	3	2.83 ～ 2.91 (100～70)
No. 6 - 32	5	3.09 ～ 3.17 (100～75)	3	3.06 ～ 3.14 (100～75)
No. 8 - 32	5	3.75 ～ 3.83 (100～75)	4	3.74 ～ 3.82 (100～75)
No.10 - 24	6	4.26 ～ 4.35 (100～80)	4	4.24 ～ 4.32 (100～80)
No.12 - 24	6	4.92 ～ 5.01 (100～80)	4	4.9 ～ 4.96 (100～85)
1/4 - 20	6	5.66 ～ 5.76 (100～80)	4	5.64 ～ 5.74 (100～80)
5/16 - 18	7	7.18 ～ 7.29 (100～80)	5	7.15 ～ 7.24 (100～85)
3/8 - 16	7	8.66 ～ 8.78 (100～80)	5	8.63 ～ 8.73 (100～85)
7/16 - 14	7	10.11 ～10.25 (100～80)	5	10.08 ～10.19 (100～85)
1/2 - 13	8	11.62 ～11.78 (100～80)	6	11.6 ～11.68 (100～90)
9/16 - 12	10	13.14 ～13.27 (100～85)	8	13.11 ～13.24 (100～85)
5/8 - 11	11	14.62 ～14.76 (100～85)	8	14.58 ～14.67 (100～90)
3/4 - 10	12	17.67 ～17.88 (100～80)	9	17.63 ～17.74 (100～90)
7/8 - 9	12	20.68 ～20.85 (100～85)	9	20.64 ～20.75 (100～90)
1 - 8	13	23.65 ～23.84 (100～85)	10	23.61 ～23.74 (100～90)

1. 上表的底孔径会因工件材质不同而变化，仅供参考。
2. 底孔径会因材质，硬度，形状尺寸等要素而变化，请事先进行试加工。
3. 底孔稍大会有利于延长寿命，请根据加工目的合理选择。
4. 底孔的变形，错位会导致加工问题，请注意。

1. The proper drill hole size may change due to material variety. Use the recommended drill hole size as a benchmark.
2. As the hole diameter may vary by behavior of plasticity depending on the material, hardness and shapes of workpiece, the hole diameter should be determined through trial tapping prior to final machining.
3. A larger drill hole size is better for extending tool life. Select a drill hole size based on your particular application.
4. To avoid tapping trouble, correct hole must be maintained free from warp, deformation, stagger and the like.

美制细牙螺纹(NRT丝锥)
Unified Fine screw threads (Nu-Roll tap)

(单位：mm)
(Unit：mm)

螺纹尺寸 Thread size	2B 级螺纹用底孔径 for JIS class 2B drill hole dia.		3B级螺纹用底孔径 for JIS class 3B drill hole dia.	
	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio:%)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio:%)
No. 0 - 80UNF	3	1.38 ～ 1.41 (100～65)	2	1.36 ～ 1.4 (100～65)
No. 1 - 72	3	1.68 ～ 1.72 (100～65)	2	1.67 ～ 1.71 (100～65)
No. 2 - 64	3	1.98 ～ 2.04 (100～65)	2	1.97 ～ 2.03 (100～65)
No. 3 - 56	4	2.29 ～ 2.35 (100～65)	3	2.28 ～ 2.34 (100～65)
No. 4 - 48	4	2.57 ～ 2.64 (100～70)	3	2.56 ～ 2.63 (100～70)
No. 5 - 44	5	2.89 ～ 2.96 (100～70)	3	2.87 ～ 2.94 (100～70)
No. 6 - 40	5	3.19 ～ 3.26 (100～70)	3	3.16 ～ 3.22 (100～75)
No. 8 - 36	5	3.8 ～ 3.88 (100～75)	4	3.79 ～ 3.86 (100～75)
No.10 - 32	5	4.41 ～ 4.48 (100～80)	4	4.4 ～ 4.46 (100～80)
No.12 - 28	5	5 ～ 5.08 (100～80)	4	4.99 ～ 5.06 (100～80)
1/4 - 28	5	5.86 ～ 5.93 (100～80)	4	5.85 ～ 5.92 (100～80)
5/16 - 24	6	7.38 ～ 7.46 (100～80)	5	7.36 ～ 7.43 (100～85)
3/8 - 24	6	8.96 ～ 9.05 (100～80)	5	8.95 ～ 9.02 (100～85)
7/16 - 20	7	10.44 ～10.54 (100～80)	5	10.41 ～10.49 (100～85)
1/2 - 20	7	12.02 ～12.12 (100～80)	5	12 ～12.05 (100～90)
9/16 - 18	9	13.55 ～13.66 (100～80)	7	13.53 ～13.58 (100～90)
5/8 - 18	9	15.14 ～15.25 (100～80)	7	15.11 ～15.17 (100～90)
3/4 - 16	10	18.22 ～18.32 (100～85)	7	18.18 ～18.25 (100～90)
7/8 - 14	11	21.27 ～21.38 (100～85)	8	21.23 ～21.27 (100～95)
1 - 12	12	24.28 ～24.41 (100～85)	9	24.24 ～24.32 (100～90)

螺纹底孔径表(挤压丝锥用) RECOMMENDED DRILL HOLE SIZE (FOR FLUTELSS TAPS)

公制螺纹 (NRT 丝锥) Metric screw threads (Nu-Roll tap)

红字＝JIS粗牙螺纹
Red character = JIS coarse pitch thread

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread size	旧 JIS 1 级螺纹 for JIS class 1 drill hole dia.		旧 JIS 2 级螺纹 for JIS class 2 drill hole dia.		4H		5H		6H	
	RH 精度 RH Limits	最小～最大(嵌合率%) Min.～Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.～Max.(Thread Overlap Ratio)
M 1 × 0.25	2	0.87 ～ 0.89 (100%～85%)	4	0.90 ～ 0.92 (100%～80%)	2	0.875 ～ 0.889 (100%～85%)	4	0.901 ～ 0.920 (100%～80%)	—	—
1.1 × 0.25	2	0.97 ～ 0.99 〃	4	1.00 ～ 1.02 〃	2	0.975 ～ 0.989 〃	4	1.001 ～ 1.020 〃	—	—
1.2 × 0.25	2	1.07 ～ 1.09 〃	4	1.10 ～ 1.12 〃	2	1.075 ～ 1.089 〃	4	1.101 ～ 1.120 〃	—	—
1.4 × 0.3	2	1.244 ～ 1.263 〃	4	1.270 ～ 1.294 〃	2	1.245 ～ 1.262 〃	4	1.270 ～ 1.294 〃	4	1.270 ～ 1.291 (100%～82%)
1.6 × 0.35	2	1.41 ～ 1.44 (100%～80%)	4	1.44 ～ 1.48 (100%～75%)	2	1.415 ～ 1.442 (100%～80%)	4	1.440 ～ 1.466 (100%～81%)	4	1.440 ～ 1.475 (100%～75%)
※ 1.6 × 0.2	—	—	—	—	—	—	—	—	4	1.530 ～ 1.550 (100%～75%)
※ 1.7 × 0.35	—	—	4	＊1.54 ～ 1.58 〃	—	—	—	—	—	—
1.8 × 0.35	2	1.61 ～ 1.64 (100%～80%)	4	1.64 ～ 1.68 〃	2	1.615 ～ 1.634 (100%～86%)	4	1.640 ～ 1.666 (100%～81%)	4	1.640 ～ 1.675 (100%～75%)
2 × 0.4	2	1.78 ～ 1.82 〃	4	1.81 ～ 1.85 〃	2	1.785 ～ 1.806 〃	4	1.810 ～ 1.840 〃	4	1.810 ～ 1.849 〃
2 × 0.25	2	1.88 ～ 1.89 〃	—	—	2	1.875 ～ 1.888 (100%～87%)	4	1.901 ～ 1.918 (99%～82%)	—	—
2.2 × 0.45	2	1.95 ～ 1.99 〃	4	1.98 ～ 2.03 (100%～75%)	2	1.955 ～ 1.979 (100%～86%)	4	1.980 ～ 2.012 (100%～82%)	4	1.980 ～ 2.024 (100%～75%)
※ 2.3 × 0.4	—	—	4	＊2.11 ～ 2.15 〃	—	—	—	—	—	—
2.5 × 0.45	2	2.25 ～ 2.29 (100%～80%)	4	2.28 ～ 2.33 〃	2	2.255 ～ 2.279 (100%～86%)	4	2.280 ～ 2.312 (100%～82%)	4	2.280 ～ 2.324 (100%～75%)
※ 2.6 × 0.45	—	—	4	＊2.38 ～ 2.43 〃	—	—	—	—	—	—
※ 3 × 0.6	3	2.68 ～ 2.70 (100%～90%)	5	2.70 ～ 2.73 (100%～90%)	—	—	—	—	—	—
3 × 0.5	3	2.74 ～ 2.78 (100%～80%)	5	2.76 ～ 2.81 (100%～75%)	3	2.737 ～ 2.764 (100%～86%)	5	2.762 ～ 2.798 (100%～82%)	5	2.762 ～ 2.812 (100%～75%)
3.5 × 0.6	3	3.18 ～ 3.21 (100%～85%)	5	3.20 ～ 3.26 〃	3	3.177 ～ 3.210 〃	5	3.202 ～ 3.242 (100%～83%)	5	3.202 ～ 3.250 (100%～80%)
※ 4 × 0.75	4	3.60 ～ 3.64 〃	6	3.62 ～ 3.67 (100%～85%)	—	—	—	—	—	—
4 × 0.7	4	3.63 ～ 3.67 〃	6	3.65 ～ 3.70 〃	4	3.63 ～ 3.66 (100%～88%)	4	3.63 ～ 3.67 (100%～85%)	6	3.66 ～ 3.69 (100%～85%)
4.5 × 0.75	4	4.10 ～ 4.14 〃	6	4.12 ～ 4.18 (100%～80%)	4	4.10 ～ 4.13 〃	4	4.10 ～ 4.14 〃	6	4.13 ～ 4.18 (100%～80%)
※ 5 × 0.9	4	4.51 ～ 4.56 〃	6	4.53 ～ 4.59 (100%～85%)	—	—	—	—	—	—
5 × 0.8	4	4.57 ～ 4.62 〃	6	4.59 ～ 4.66 (100%～80%)	4	4.57 ～ 4.60 (100%～88%)	4	4.57 ～ 4.61 (100%～85%)	6	4.60 ～ 4.65 (100%～80%)
6 × 1	4	5.45 ～ 5.51 〃	7	5.48 ～ 5.57 〃	4	5.45 ～ 5.49 〃	4	5.45 ～ 5.50 〃	7	5.49 ～ 5.56 〃
7 × 1	4	6.45 ～ 6.51 〃	7	6.48 ～ 6.57 〃	4	6.45 ～ 6.49 (100%～89%)	4	6.45 ～ 6.50 〃	7	6.49 ～ 6.56 〃
8 × 1.25	5	7.31 ～ 7.38 〃	7	7.34 ～ 7.41 (100%～85%)	5	7.31 ～ 7.36 (100%～90%)	7	7.34 ～ 7.40 (100%～87%)	7	7.34 ～ 7.41 (100%～85%)
8 × 1	4	7.45 ～ 7.51 〃	7	7.48 ～ 7.57 (100%～80%)	4	7.45 ～ 7.48 (100%～91%)	4	7.45 ～ 7.50 (100%～85%)	7	7.49 ～ 7.56 (100%～80%)
10 × 1.5	5	9.16 ～ 9.22 (100%～90%)	7	9.18 ～ 9.28 (100%～85%)	5	9.16 ～ 9.21 〃	7	9.19 ～ 9.24 (100%～90%)	7	9.19 ～ 9.27 (100%～85%)
10 × 1.25	5	9.31 ～ 9.38 (100%～85%)	7	9.34 ～ 9.41 〃	5	9.31 ～ 9.36 (100%～90%)	7	9.34 ～ 9.40 (100%～87%)	7	9.34 ～ 9.41 〃
10 × 1	5	9.46 ～ 9.52 〃	7	9.48 ～ 9.57 (100%～80%)	5	9.47 ～ 9.50 〃	5	9.47 ～ 9.52 (100%～85%)	7	9.49 ～ 9.56 (100%～80%)
12 × 1.75	5	11.01 ～ 11.08 (100%～90%)	8	11.05 ～ 11.15 (100%～85%)	5	11.01 ～ 11.07 (100%～91%)	8	11.05 ～ 11.11 (100%～90%)	8	11.05 ～ 11.15 (100%～85%)
12 × 1.5	5	11.16 ～ 11.22 〃	7	11.18 ～ 11.28 〃	5	11.16 ～ 11.21 〃	7	11.19 ～ 11.24 〃	7	11.19 ～ 11.27 〃
12 × 1.25	5	11.31 ～ 11.38 (100%～85%)	7	11.34 ～ 11.41 〃	5	11.31 ～ 11.36 (100%～90%)	7	11.34 ～ 11.40 (100%～87%)	7	11.34 ～ 11.41 〃
12 × 1	5	11.46 ～ 11.52 〃	7	11.48 ～ 11.57 (100%～80%)	5	11.47 ～ 11.50 〃	5	11.47 ～ 11.52 (100%～85%)	7	11.49 ～ 11.56 (100%～80%)
14 × 2	6	12.83 ～ 12.95 (100%～90%)	10	12.92 ～ 13.04 (100%～85%)	6	12.88 ～ 12.93 (100%～92%)	10	12.93 ～ 13.00 (100%～90%)	10	12.93 ～ 13.04 (100%～85%)
14 × 1.5	5	13.16 ～ 13.22 〃	9	13.21 ～ 13.30 〃	5	13.16 ～ 13.21 (100%～91%)	9	13.21 ～ 13.27 〃	9	13.21 ～ 13.30 〃
16 × 2	6	14.87 ～ 14.95 〃	10	14.92 ～ 15.04 〃	6	14.88 ～ 14.93 (100%～92%)	6	14.88 ～ 14.95 〃	10	14.93 ～ 15.04 〃
16 × 1.5	5	15.16 ～ 15.22 〃	9	15.21 ～ 15.30 (100%～80%)	5	15.16 ～ 15.21 (100%～91%)	9	15.21 ～ 15.27 〃	9	15.21 ～ 15.30 〃
18 × 2.5	6	16.57 ～ 16.67 〃	11	16.63 ～ 16.78 (100%～85%)	6	16.57 ～ 16.64 (100%～92%)	11	16.64 ～ 16.73 〃	11	16.64 ～ 16.78 〃
18 × 1.5	6	17.17 ～ 17.23 〃	10	17.22 ～ 17.31 〃	6	17.18 ～ 17.22 (100%～91%)	6	17.18 ～ 17.23 〃	10	17.23 ～ 17.31 〃
20 × 2.5	6	18.57 ～ 18.67 〃	11	18.63 ～ 18.78 〃	6	18.57 ～ 18.64 (100%～92%)	11	18.64 ～ 18.73 〃	11	18.64 ～ 18.78 〃
20 × 1.5	6	19.17 ～ 19.23 〃	10	19.22 ～ 19.31 〃	6	19.18 ～ 19.22 (100%～91%)	6	19.18 ～ 19.23 〃	10	19.23 ～ 19.31 〃
22 × 2.5	—	—	11	20.63 ～ 20.78 (100%～85%)	—	—	—	—	11	20.63 ～ 20.78 (100%～85%)
22 × 1.5	—	—	10	21.22 ～ 21.31 〃	—	—	—	—	10	21.22 ～ 21.31 〃
24 × 3	—	—	13	22.36 ～ 22.53 〃	—	—	—	—	13	22.36 ～ 22.53 〃
24 × 1.5	—	—	10	23.22 ～ 23.31 〃	—	—	—	—	10	23.22 ～ 23.31 〃
27 × 3	—	—	13	25.36 ～ 25.53 〃	—	—	—	—	13	25.36 ～ 25.53 〃
30 × 3.5	—	—	14	28.07 ～ 28.25 〃	—	—	—	—	14	28.07 ～ 28.25 〃
33 × 3.5	—	—	14	31.07 ～ 31.25 〃	—	—	—	—	14	31.07 ～ 31.25 〃
36 × 4	—	—	15	33.78 ～ 33.99 〃	—	—	—	—	15	33.78 ～ 33.99 〃
42 × 4.5	—	—	16	39.49 ～ 39.71 〃	—	—	—	—	16	39.49 ～ 39.71 〃
45 × 4.5	—	—	16	42.49 ～ 42.71 〃	—	—	—	—	16	42.49 ～ 42.71 〃

4H～6H 根据 JIS B 0209-2001。
粗牙尺寸根据 JIS B 0209-1982 附属书 1。
细牙尺寸根据 JIS B 0209-1982 附属书。
印＊是根据 JIS B0209-1982 附属书 2。
印※是 JIS 已经废番的尺寸。

4H - 6H corresponds to JIS B 0209-2001.
Coarse thread sizes correspond to the appendix 1 of JIS B 0209-1982.
Fine pitch thread sizes correspond to the appendix of JIS B 0211-1982.
＊Corresponds to the appendix 2 of JIS B 0209-1982.
※Size abolished by JIS.

1. 上表的底孔径会因工件材质不同而变化，仅供参考。
2. 底孔径会因材质，硬度，形状尺寸等要素而变化，请事先进行试加工。
3. 底孔稍大会有利于延长寿命，请根据加工目的合理选择。
4. 底孔的变形，错位会导致加工问题，请注意。

1. The proper drill hole size may change due to material variety. Use the recommended drill hole size as a benchmark.
2. As the hole diameter may vary by behavior of plasticity depending on the material, hardness and shapes of workpiece, the hole diameter should be determined through trial tapping prior to final machining.
3. A larger drill hole size is better for extending tool life. Select a drill hole size based on your particular application.
4. To avoid tapping trouble, correct hole must be maintained free from warp, deformation, stagger and the like.

螺纹底孔径表(挤压丝锥用) RECOMMENDED DRILL HOLE SIZE (FOR FLUTELSS TAPS)

公制螺纹 (HRT 丝锥)Metric screw threads (Hi-Roll tap)

红字＝JIS粗牙螺纹
Red character = JIS coarse pitch thread

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread size	旧 JIS 1 级螺纹 for JIS class 1 drill hole dia.		旧 JIS 2 级螺纹 for JIS class 2 drill hole dia.		4H		5H		6H	
	RH 精度 RH Limits	最小～最大(嵌合率%) Min. ~ Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min. ~ Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min. ~ Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min. ~ Max.(Thread Overlap Ratio)	RH 精度 RH Limits	最小～最大 (嵌合率%) Min. ~ Max.(Thread Overlap Ratio)
M 1 × 0.25	2	0.858～0.879 (100%～85%)	4	0.858～0.887 (100%～80%)	2	0.860～0.879 (100%～85%)	4	0.858～0.886 (100%～80%)	—	—
1.2 × 0.25	2	1.058～1.079 〃	4	1.058～1.087 〃	2	1.060～1.079 〃	4	1.058～1.086 〃	—	—
1.4 × 0.3	2	1.23～1.26 〃	4	1.23～1.26 〃	2	1.230～1.255 〃	4	1.230～1.263 〃	4	1.230～1.263 (100%～80%)
1.6 × 0.35	2	1.40～1.44 (100%～80%)	4	1.40～1.45 (100%～75%)	2	1.410～1.431 〃	4	1.402～1.441 〃	4	1.402～1.451 (100%～75%)
※ 1.7 × 0.35	—	—	4	＊1.50～1.55 〃	—	—	—	—	—	—
1.8 × 0.35	2	1.60～1.64 (100%～80%)	4	1.60～1.65 〃	2	1.610～1.631 (100%～85%)	4	1.602～1.641 (100%～80%)	4	1.602～1.651 (100%～75%)
2 × 0.4	2	1.77～1.82 〃	4	1.77～1.82 (100%～80%)	2	1.78～1.80 (100%～86%)	4	1.78～1.81 〃	4	1.78～1.81 (100%～80%)
2 × 0.25	2	1.858～1.887 〃	—	—	—	—	4	1.858～1.886 〃	—	—
※ 2.3 × 0.4	—	—	4	＊2.07～2.13 (100%～75%)	—	—	—	—	—	—
2.5 × 0.45	3	2.24～2.30 (100%～80%)	5	2.24～2.31 〃	3	2.25～2.28 (100%～86%)	3	2.25～2.30 (100%～75%)	5	2.25～2.30 (100%～75%)
※ 2.6 × 0.45	—	—	5	＊2.34～2.41 〃	—	—	—	—	—	—
※ 3 × 0.6	3	2.72～2.73 (100%～90%)	5	2.66～2.73 (100%～90%)	—	—	—	—	—	—
3 × 0.5	5	2.72～2.77 (100%～80%)	6	2.72～2.78 (100%～75%)	3	2.72～2.75 (100%～85%)	5	2.72～2.77 (100%～80%)	6	2.72～2.78 (100%～75%)
3 × 0.35	3	2.80～2.84 〃	5	2.80～2.85 〃	3	2.81～2.83 〃	3	2.81～2.84 〃	5	2.81～2.85 〃
3.5 × 0.6	3	3.16～3.21 (100%～85%)	5	3.16～3.25 〃	3	3.16～3.21 〃	5	3.16～3.21 (100%～85%)	5	3.16～3.24 〃
※ 4 × 0.75	3	3.57～3.64 〃	6	3.57～3.64 (100%～85%)	—	—	—	—	—	—
4 × 0.7	6	3.60～3.66 〃	7	3.60～3.66 〃	4	3.61～3.65 (100%～87%)	6	3.61～3.66 (100%～85%)	7	3.61～3.66 (100%～85%)
4 × 0.5	3	3.71～3.77 (100%～80%)	6	3.71～3.79 (100%～75%)	3	3.72～3.75 (100%～85%)	5	3.72～3.77 (100%～80%)	6	3.72～3.78 (100%～75%)
※ 5 × 0.9	3	4.49～4.59 (100%～85%)	7	4.49～4.59 (100%～85%)	—	—	—	—	—	—
5 × 0.8	3	4.55～4.62 〃	8	4.55～4.64 (100%～80%)	5	4.55～4.60 (100%～88%)	6	4.55～4.61 (100%～85%)	8	4.55～4.63 (100%～80%)
5 × 0.5	3	4.72～4.77 (100%～80%)	6	4.72～4.79 (100%～75%)	3	4.72～4.75 (100%～85%)	5	4.72～4.77 (100%～80%)	6	4.72～4.78 (100%～75%)
6 × 1	4	5.43～5.52 (100%～85%)	7	5.43～5.55 (100%～80%)	4	5.44～5.50 (100%～88%)	7	5.44～5.51 (100%～85%)	7	5.44～5.54 (100%～80%)
6 × 0.75	3	5.57～5.64 〃	7	5.57～5.66 〃	5	5.58～5.63 (100%～87%)	7	5.58～5.63 〃	7	5.58～5.65 〃

4H~6H 根据 JIS B 0209-2001。
粗牙尺寸根据 JIS B 0209-1982 附属书 1。
细牙尺寸根据 JIS B 0211-1982 附属书。
印＊是根据 JIS B0209-1982 附属书 2。
印※是 JIS 已经废番的尺寸。

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2. 底孔径会因材质，硬度，形状尺寸等要素而变化，请事先进行试加工。
3. 底孔稍大会有利于延长寿命，请根据加工目的合理选择。
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4H - 6H corresponds to JIS B 0209-2001.
Coarse thread sizes correspond to the appendix 1 of JIS B 0209-1982.
Fine pitch thread sizes correspond to the appendix of JIS B 0211-1982.
＊Corresponds to the appendix 2 of JIS B 0209-1982.
※Size abolished by JIS.

1. The proper drill hole size may change due to material variety. Use the recommended drill hole size as a benchmark.
2. As the hole diameter may vary by behavior of plasticity depending on the material, hardness and shapes of workpiece, the hole diameter should be determined through trial tapping prior to final machining.
3. A larger drill hole size is better for extending tool life. Select a drill hole size based on your particular application.
4. To avoid tapping trouble, correct hole must be maintained free from warp, deformation, stagger and the like.

螺纹底孔径表(嵌套螺纹用) RECOMMENDED DRILL HOLE SIZE (FOR SCREW THREAD INSERT)

一般螺纹用请参考 P860。For general screw thread : Please refer to p.860

公制粗牙螺纹 Metric Coarse screw threads

(单位：mm) (Unit : mm)

螺纹尺寸 Thread size	丝锥底孔径 Drill hole dia. 最小尺寸 Min.	丝锥底孔径 Drill hole dia. 最大尺寸 Max.	适用钻头直径 Suitable Drill dia.
M 2 × 0.4 (2.520)	2.09	2.18	2.15
2.5 × 0.45 (3.085)	2.6	2.69	2.65
2.6 × 0.45 (3.185)	2.7	2.79	2.75
3 × 0.5 (3.650)	3.11	3.2	3.15
4 × 0.7 (4.909)	4.16	4.29	4.25
5 × 0.8 (6.039)	5.18	5.33	5.25
6 × 1 (7.300)	6.22	6.4	6.3
8 × 1.25 (9.624)	8.28	8.48	8.4
10 × 1.5 (11.948)	10.33	10.56	10.45
12 × 1.75 (14.274)	12.38	12.64	12.5
14 × 2 (16.598)	14.44	14.73	14.6
16 × 2 (18.598)	16.44	16.73	16.6
18 × 2.5 (21.248)	18.55	18.89	18.7
20 × 2.5 (23.248)	20.55	20.89	20.7
22 × 2.5 (25.248)	22.55	22.89	22.7
24 × 3 (27.898)	24.65	25.05	24.8
27 × 3 (30.898)	27.65	28.05	27.8
30 × 3.5 (34.547)	30.76	31.2	31

公制细牙螺纹 Metric Fine screw threads

(单位：mm) (Unit : mm)

螺纹尺寸 Thread size	丝锥底孔径 Drill hole dia. 最小尺寸 Min.	丝锥底孔径 Drill hole dia. 最大尺寸 Max.	适用钻头直径 Suitable Drill dia.
M 10 × 1 (11.300)	10.22	10.4	10.3
10 × 1.25 (11.624)	10.28	10.48	10.4
12 × 1.25 (13.624)	12.28	12.48	12.4
12 × 1.5 (13.948)	12.33	12.56	12.5
14 × 1.5 (15.948)	14.33	14.56	14.5
16 × 1.5 (17.948)	16.33	16.56	16.5
18 × 1.5 (19.948)	18.33	18.56	18.5
20 × 1.5 (21.948)	20.33	20.56	20.5
20 × 2 (22.598)	20.44	20.73	20.6
22 × 1.5 (23.948)	22.33	22.56	22.5
24 × 1.5 (25.948)	24.33	24.56	24.5
24 × 2 (26.598)	24.44	24.73	24.6
27 × 1.5 (28.948)	27.33	27.56	27.4
30 × 1.5 (31.948)	30.33	30.56	30.5

美制粗牙螺纹 Unified Coarse screw threads

(单位：mm) (Unit : mm)

螺纹尺寸 Thread size	丝锥底孔径 Drill hole dia. 最小尺寸 Min.	丝锥底孔径 Drill hole dia. 最大尺寸 Max.	适用钻头直径 Suitable Drill dia.
No. 2 - 56UNC (2.773)	2.28	2.44	2.35
No. 3 - 48 (3.202)	2.63	2.83	2.75
No. 4 - 40 (3.670)	2.99	3.18	3.1
No. 5 - 40 (4.000)	3.31	3.52	3.4
No. 6 - 32 (4.536)	3.68	3.87	3.75
No. 8 - 32 (5.197)	4.33	4.52	4.45
No. 10 - 24 (6.201)	5.06	5.28	5.2
No. 12 - 24 (6.861)	5.72	5.92	5.8
1/4 - 20 (8.000)	6.63	6.86	6.75
5/16 - 18 (9.771)	8.25	8.48	8.4
3/8 - 16 (11.587)	9.87	10.12	10
7/16 - 14 (13.469)	11.51	11.78	11.65
1/2 - 13 (15.238)	13.13	13.39	13.3
9/16 - 12 (17.038)	14.74	15.05	14.9
5/8 - 11 (18.875)	16.38	16.67	16.5
3/4 - 10 (22.350)	19.6	19.9	19.8
7/8 - 9 (25.891)	22.84	23.16	23
1 - 8 (29.524)	26.09	26.46	26.3

美制细牙螺纹 Unified Fine screw threads

(单位：mm) (Unit : mm)

螺纹尺寸 Thread size	丝锥底孔径 Drill hole dia. 最小尺寸 Min.	丝锥底孔径 Drill hole dia. 最大尺寸 Max.	适用钻头直径 Suitable Drill dia.
No. 4 - 48UNF (3.532)	2.96	3.15	3.05
No. 6 - 40 (4.330)	3.65	3.81	3.75
No. 8 - 36 (5.083)	4.33	4.49	4.4
No. 10 - 32 (5.857)	5	5.18	5.1
No. 12 - 28 (6.665)	5.67	5.89	5.8
1/4 - 28 (7.528)	6.55	6.72	6.65
5/16 - 24 (9.313)	8.17	8.35	8.25
3/8 - 24 (10.900)	9.76	9.93	9.85
7/16 - 20 (12.762)	11.39	11.58	11.5
1/2 - 20 (14.350)	12.98	13.17	13.1
9/16 - 18 (16.121)	14.58	14.8	14.7
5/8 - 18 (17.708)	16.18	16.38	16.3
3/4 - 16 (21.112)	19.4	19.6	19.5
7/8 - 14 (24.582)	22.62	22.84	22.7
1 - 12 (28.150)	25.86	26.11	26

公制螺纹 (NRT 丝锥) Metric screw threads (Nu-Roll taps)

(单位：mm) (Unit : mm)

螺纹尺寸 Thread size	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.-Max.(Threads Overlap Ratio:%)
M 2 × 0.4 (2.520)	2	2.31 ～ 2.33 (100 ～80)
2.5 × 0.45 (3.085)	2	2.84 ～ 2.87 (100 ～80)
2.6 × 0.45 (3.185)	2	2.94 ～ 2.97 (100 ～80)
3 × 0.5 (3.650)	3	3.39 ～ 3.43 (100 ～80)
4 × 0.7 (4.909)	4	4.54 ～ 4.58 (100 ～85)
5 × 0.8 (6.039)	4	5.61 ～ 5.66 (100 ～85)
6 × 1 (7.300)	4	6.75 ～ 6.81 (100 ～85)

螺纹尺寸 Thread size	RH 精度 RH Limits	最小～最大 (嵌合率%) Min.-Max.(Threads Overlap Ratio:%)
8 × 1.25 (9.624)	5	8.93 ～ 9.01 (100 ～85)
10 × 1.5 (11.948)	5	11.11 ～ 11.17 (100 ～90)
10 × 1.25 (11.624)	5	10.93 ～ 11.01 (100 ～85)
12 × 1.75 (14.274)	5	13.28 ～ 13.35 (100 ～90)
12 × 1.5 (13.948)	5	13.11 ～ 13.17 (100 ～90)
12 × 1.25 (13.624)	5	12.93 ～ 13.01 (100 ～85)

量规
GAUGES

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量规材料中含钴。
There are some gauges which include cobalt.

●本样本登载的产品，虽标有库存，但由于新材料、新产品的开发，更改废番的情况也有。
●式样，形状，表内数值也可能会有变动。

●The inventory status is indicated for respective products on this catalogue. However, the products may be improved or discontinued due to development of new materials and products, etc.
●Specifications, shapes, values in the tables, etc. are subject to change without prior notice.

量规选择表 GAUGE SELECTION CHART

待测定螺纹 Screw thread to be gauged				量规 Gauges			
测定螺纹的种类 Classification of screw thread			外螺纹or内螺纹 External thread or Internal thread	量规记号 Gauges symbol	种类 Gauges type	精度 Class	页码 Page
公制螺纹 Metric screw threads	JIS（ISO等级） JIS (ISO)	M	外螺纹 External thread	LG	GR, NR	4h	P.919
						6h, 6g	P.909
						6h, 6g（左）(Left)	P.917
			内螺纹 Internal thread	LG	GPNP	5H	P.919
						6H, 5H	P.909
						6H, 5H（左）(Left)	P.917
				TIN-LG	GPNP（TiN涂层） TiN Coating	6H	P.936
				DLC-LG	GPNP（DLC涂层） DLC Coating	6H	P.939
	旧JIS Previous JIS	M	外螺纹 External thread	LG	GR, IR, WR	1	P.905
						2	P.885
						3	P.908
						2（左）(Left)	P.903
					GR（材质： 粉末高速钢） Powder HSS(XPM)	2	P.966
			内螺纹 Internal thread	LG	GPIP, GPWP	1	P.905
						2	P.885
						3	P.908
						2（左）(Left)	P.903
					GP（材质： 粉末高速钢） Powder HSS(XPM)	2	P.966
					GP（材质：硬质合金） Carbide	2	P.966
				TIN-LG	GPIP, GPWP（TiN涂层） TiN Coating	2	P.935
				DLC-LG	GPIP, GPWP（DLC涂层） DLC Coating	2	P.938
镀前公制螺纹 Metric screw threads before plating	JIS（ISO等级） JIS (ISO)	M	内螺纹 Internal thread	LG	GPNP	6H＋0.03	P.924
	旧JIS Previous JIS	M	外螺纹 External thread	LG	GR, IR, WR	2－0.03	P.922
			内螺纹 Internal thread	LG	GPIP, GPWP	2＋0.03	P.922
小径用公制螺纹 Metric screw threads for minor diameter	JIS（ISO等级） JIS (ISO)	M	内螺纹 Internal thread	LG	PP	6H	P.945
	旧JIS Previous JIS	M	内螺纹 Internal thread	LG	IM, WM	2	P.944
美制螺纹 Unified inch screw threads	JIS	UNC UNF	外螺纹 External thread	LG	GR, IR, WR※1	3A	P.929
						2A	P.925
	ANSI/ASME	UNEF UN UNS	内螺纹 Internal thread	LG	GPIP, GPWP※1	3B	P.929
						2B	P.925

※1：UNEF, UNS, UN, UNJC, UNJF适用于"ANSI/ASME B1.2"。

※1：UNEF, UNS, UN, UNJC, UNJF are manufactured in correspondence to " ANSI / ASME B1.2 " .

量规选择表 GAUGE SELECTION CHART

待测定螺纹 Screw thread to be gauged				量规 Gauges			
测定螺纹的种类 Classification of screw thread			外螺纹or内螺纹 External thread or Internal thread	量规记号 Gauges symbol	种类 Gauges type	精度 Class	页码 Page
美制螺纹(UNJ) Unified inch screw threads (UNJ Thread form)	ANSI/ASME	UNJC UNJF	外螺纹 External thread	LG	GR, IR, WR※1	3A	P.931
			内螺纹 Internal thread	TIN-LG	GPIP, GPWP※1 (TiN涂层) TiN Coating	3B	P.937
惠氏螺纹 Whitworth screw threads	旧JIS Previous JIS	W	外螺纹 External thread	LG	GR, IR, WR	2	P.932
						2(左) (Left)	P.933
			内螺纹 Internal thread	LG	GPIP, GPWP	2	P.932
						2(左) (Left)	P.933
缝纫机用螺纹 Screw threads for sewing machines	旧JIS Previous JIS	SM	外螺纹 External thread	LG	GR, IR, WR	2	P.934
			内螺纹 Internal thread	LG	GPIP, GPWP	2	P.934
公制嵌套螺纹 Metric Insert screw threads	—	M	内螺纹 Internal thread	HL-LG	GPWP	2	P.948
美制嵌套螺纹 Unified Insert screw threads	—	UNC UNF	内螺纹 Internal thread	HL-LG	GPWP	2B	P.949
		UNJC UNJF		TIN-HL-LG	GPWP (TiN涂层) TiN Coating	3B	P.950
锥管螺纹 Taper pipe threads	JIS (ISO等级) JIS (ISO)	R	外螺纹 External thread	TG	R	—	P.958
		Rc	内螺纹 Internal thread	TG	R	—	P.958
	旧JIS※2 Previous JIS	PT	外螺纹 External thread	TG	PT	—	P.957
			内螺纹 Internal thread	TG	PT	—	P.957
平行管螺纹 Parallel pipe threads	JIS (ISO等级) JIS (ISO)	G	外螺纹 External thread	LG	GR, NR	A/B※4, A	P.943
			内螺纹 Internal thread	LG	GPNP	—	P.943
		Rp	内螺纹 Internal thread	TG	R	—	P.958
	旧JIS※2 Previous JIS	PS	外螺纹 External thread	LG	GR, IR, WR	—	P.940
			内螺纹 Internal thread	LG	GPIP, GPWP	—	P.940
				TG	PT	—	P.957
		PF	外螺纹 External thread	LG	GR, IR, WR	A/B※5, A	P.941
						A/B※5, B	P.942
			内螺纹 Internal thread	LG	GPIP, GPWP	A/B※5, A	P.941
						A/B※5, B	P.942
锥管螺纹 (ANSI) ※3 Taper pipe threads	ANSI/ASME	NPT	外螺纹 External thread	TG	NPT	—	P.959
			内螺纹 Internal thread	TG	NPT	—	P.959
	ANSI	NPTF	外螺纹 External thread	TG	NPTF	L1	P.960
			内螺纹 Internal thread	TG	NPTF	L1	P.960

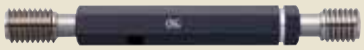
※1：UNEF, UNS, UN, UNJC, UNJF适用于"ANSI/ASME B1.2"。
※2：旧英式标准。
※3：旧美式标准。
※4：通规（GR）为A级B级共用。
※5：通规（GP,GR）为A级B级共用。

※1：UNEF, UNS, UN, UNJC, UNJF are manufactured in correspondence to " ANSI / ASME B1.2 " .
※2：Old UK standard.
※3：ANSI standard.
※4：GO gauges (GR) can be used by both class A and class B.
※5：GO gauges (GP, GR) can be used by both class A and class B.

螺纹量规系列 GAUGES

极限螺纹量规
Limit gauges for screw threads **LG**

内螺纹用
for Internal thread



通规 GO side　　止规 NO GO side

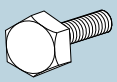
外螺纹用
for External thread

止规 NO GO side　　通规 GO side

极限螺纹量规和螺纹相同，也有等级精度标准。利用通规和止规检查螺纹的2个极限。以往的JIS规格，按照使用目的又将止规分为检查用和工作用两类，而ISQ规格则无此区分。通规必须能轻松顺畅地通过被检测螺纹的有效螺纹长度，止规必须在旋转2周之内(ANSI规格为3周之内)停住，才能判断被测螺纹为合格。

Limit gauges for screw threads are graded in the same manner as screws. Screw threads are inspected according to two limits defined by GO and NO GO gauges. The Previous JIS gauge system provides two categories of NO GO gauges depending on the purpose of usage: machining and inspection. This classification is not used in the ISO system. Screw threads pass the inspection if the GO gauge, when screwed by hand without using excess force on the thread under test for the specified engagement length, goes over the entire thread length, and if the NO GO gauge, when screwed by hand without using excess force, enter on both sides by not more than two turns of thread (not more than three turns of thread in ANSI).

■极限螺纹量规的种类和记号 Symbols of Limit Gauges for Screw Threads

被检查的螺纹 Screw thread to be inspected		导入 ISO 后的 JIS 规格量规 ISO 种类 Gauge type	记号 Symbol	以往的 JIS 规格量规 JIS 种类 Gauge type	记号 Symbol
外螺纹 External thread 	中径 Pitch diameter	环规通规 GO screw ring gauge	GR	环规通规（工、检） GO screw ring gauge	GR
				工作用环规止规 NO GO screw ring gauge for machine work	WR
		环规止规 NO GO screw ring gauge	NR	检查用环规止规 NO GO screw ring gauge for inspection	IR
	大径 Major diameter	大径用环规通规 Plain GO ring gauge for major diameter	PR 通 PR go	——	——
		大径用环规止规 Plain NO GO ring gauge for major diameter	PR 止 PR not-go	——	——
				工作用极限夹钳量规 Limit snap gauge for machine work	WS
		大径用夹钳量规 Plain calliper gauge for major diameter	PC	检查用极限夹钳量规 Limit snap gauge for inspection	IS
内螺纹 Internal thread	中径 Pitch diameter	塞规通规 GO screw plug gauge	GP	塞规通规（工、检） GO screw plug gauge	GP
				工作用塞规止规 NO GO screw plug gauge for machine work	WP
		塞规止规 NO GO screw plug gauge	NP	检查用塞规止规 NO GO screw plug gauge for inspection	IP
	小径 Minor diameter	小径用塞规 Plain plug gauge for minor diameter	PP	工作用极限塞规 Limit plug gauge for machine work	WM
				检查用极限塞规 Limit plug gauge for inspection	IM

■点检用量规的种类和记号 Symbols of Gauges for Check

被检查的螺纹根限量规 Limit gauges for screw threads to be inspected	导入 ISO 标准的 JIS 规格量规 ISO		以往的 JIS 规格量规 JIS	
	种类 Gauge type	记号 Symbol	种类 Gauge type	记号 Symbol
环规通规 GO screw ring gauge	点检用塞规通规 GO check plug for GO screw ring gauge	GRGF	——	——
	点检用塞规止规 NO GO check plug for GO screw ring gauge	GRNF	——	——
	——	——	嵌合点检用塞规通规 Screw plug gauge for checking fit of GO side	GF
	磨耗点检用塞规 Wear check plug for GO screw ring gauge	GW	磨耗点检用塞规通规 Screw plug gauge for checking wear of GO side	GW
环规止规 NO GO screw ring gauge	点检用塞规通规 GO check plug for NO GO screw ring gauge	NRGF	——	——
	点检用塞规通规 NO GO check plug for NO GO screw ring gauge	NRNF	——	——
	——	——	工作用止规嵌合点检塞规 Screw plug gauge for checking fit of NO GO side for machine work	WF
	——	——	检查用止规嵌合点检塞规 Screw plug gauge for checking fit of NO GO side for inspection	IF
	磨耗点检用塞规 Wear check plug for NO GO screw ring gauge	NW	——	

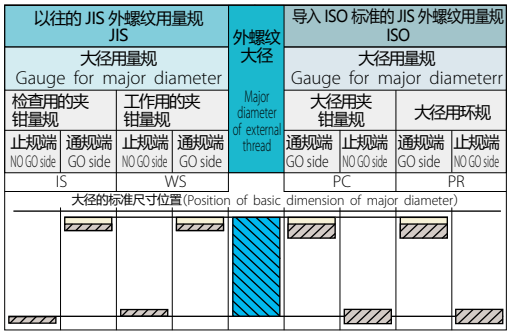
螺纹量规系列 GAUGES

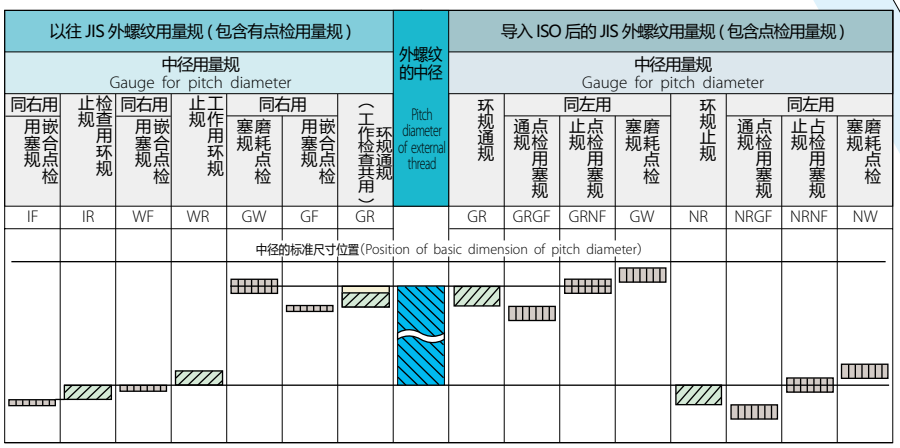
■外螺纹、外螺纹用极限量规及点检用量规的公差位置示意图

Mutually related positions of external screw thread, limit gauge for external screw thread and gauge for checking explanation figure.

以导入ISO标准的JIS规格外螺纹6g,8g为例　Example for ISO 6g, 8g

以旧JIS规格外螺纹2、3级螺纹为例　Example for previous JIS class 2, 3 external thread





外螺纹基本牙形
basic profile of external screw thread

图中所表示公差区域及磨损量，各自有以下说明。
The illustrations for the tolerance zone of wear margin in the above figures show the following:

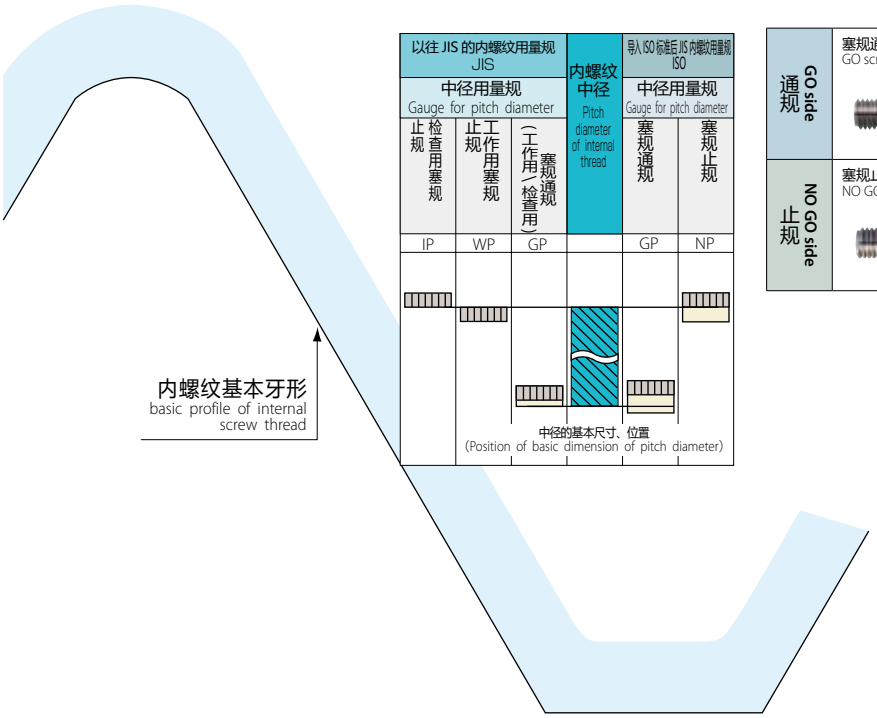
- 外螺纹中径或是大径公差 Tolerance on pitch diameter or major diameter of external thread
- 最小磨损 Minimum margin for wear
- 螺纹环规、夹规及环规的公差 Tolerance on screw ring gauge, snap gauge or ring gauge
- 螺纹塞规或塞规的公差 Tolerance on screw plug or plug gauge

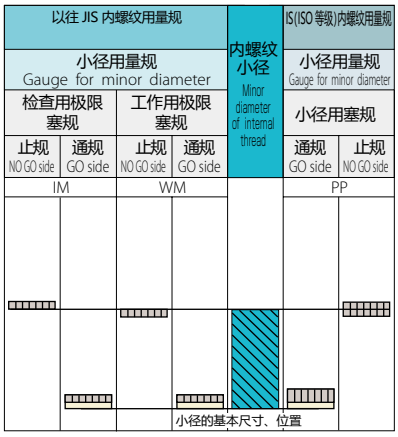
ISO 量规方式引用公制螺纹 ISO 等级的螺纹。
ISO system for gauge applies only to Metric thread ISO class.

通规 GO side	GR	点检用 Check plug gauge for GO screw ring gauge	JIS(ISO等级) GRGF 〃 GRNF 旧 JIS GF
		磨耗点检用 Wear check plug for GO screw ring gauge	GW
止规 NO GO side	ISO 标准 JIS NR，旧JIS WR或IR JIS(ISO): NR, previous JIS: WR or IR	点检用 Check plug gauge for NO GO screw ring gauge	JIS(ISO等级) NRGF 〃 NRNF 旧 JIS WF 〃 IF
		磨耗点检用 Wear check plug for NO GO screw ring gauge	JIS(ISO等级) NW

■内螺纹、内螺纹用极限量规、点检用量规的公差位置示意图
Mutually related positions of internal screw thread, limit gauge for internal screw thread and gauge for checking explanation figure.

以导入ISO标准后的JIS规格内螺纹5H、6H、7H为例 Example for ISO 5H, 6H, 7H
以旧JIS规格内螺纹2、3级螺纹为例 Example for previous JIS class 2, 3 internal thread





Position of basic dimension of minor diameter

JIS(ISO等级) PP
旧JIS WM或IM
JIS(ISO): PP
Previous JIS: WM or IM

图中所表示公差区域及磨损量有以下说明。
The illustrations for the tolerance zone of wear margin in the above figures show the following:

- 内螺纹小径公差 Tolerance on pitch diameter or minor diameter of internal thread
- 螺纹塞规或塞规的公差 Tolerance on screw plug or plug gauge
- 最小磨损量 Minimum margin for wear

ISO 量规方式仅适用公制螺纹 ISO 等级的螺纹。
ISO system for gauge applies only to Metric thread ISO class.

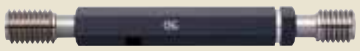
标准螺纹量规
Standard screw thread gauges **SG**

标准螺纹量规是严格按照标准牙形及标准尺寸制作的一套标准螺纹量规由塞规和环规组成，并且两者之间有着良好的配合度。有些标准螺纹量规由塞规代替内螺纹定位孔，此类的塞规适合环规的内径。标准螺纹量规能同时应对内螺纹、外螺纹以及标准规的测试。他们也经常被用作通规使用。然而，在使用等级2或3的标准螺纹量规时，由于会消除基本尺寸的公差，因此可能会得到错误的测量。因此，标准螺纹量规适用于高精度、小批量的螺纹测量。

Standard screw thread gauges are constructed correctly to the basic thread and dimensions. One set of standard screw thread gauges comprises a screw thread plug gauge and a screw thread ring gauge that fit each other without using excess force and play. Some standard screw thread gauges include a plug gauge intended for internal thread pilot holes. This plug gauge fits the internal diameter of the ring gauge. Standard screw thread gauges can be directly fitted to external and internal threads for inspection, as well as for use as a master gauge in comparative measurement. They are commonly used as a substitute for a GO gauge. However, use of a standard screw thread gauge with class 2 or 3 metric screw threads, which have clearance allowances with respect to the basic dimensions, produces inaccurate measurements. Consequently, standard screw thread gauges are suitable for the inspection of high-precision threads in small quantities.

平行管螺纹量规
Limit gauges for parallel pipe threads
LG(G • PF • PS)

内螺纹用
for Internal thread



通规 GO side　　止规 NO GO side

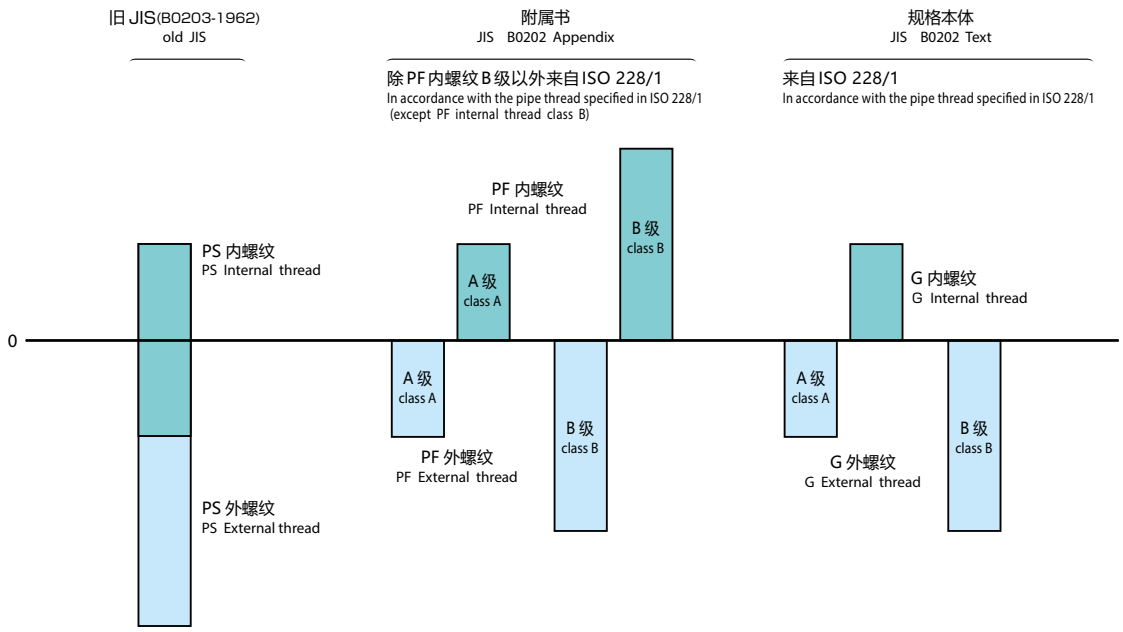
外螺纹用
for External thread

止规 NO GO side　　通规 GO side

自1966年9月平行管螺纹JIS修订以来，除了原有的密封用JIS B0203以外，又新增加了一般结合用JIS B0202，之后螺纹规的规格进行了大幅的改动，锥度螺纹分类JIS B0253(AS)主要为密封用，锥度外螺纹与平行内螺纹组合后，螺纹规只有塞规，没有环规。另外制定了一种机械结合用为目的的JIS B0254(PF)。之后在1982年，JIS B0202(平行管螺纹)被修订，ISO 228/1的规格用记号"G"代替了旧JIS标准中使用的"PF"。与此同时，ISO 7/1的规格用记号"R"、"Rc"和"Rp"来代替旧JIS标准中的"PT"和"PS"。

In September 1966, the JIS standard for parallel pipe threads was revised to incorporate ISO standards. As a result, JIS B 0202 (principally addressing mechanical joints) was added to the existing JIS B 0203 (principally addressing sealability). The revision involved radical amendments to the specifications for screw thread gauges. The JIS B 0253 (PS) for taper threads focused on sealability as a principal purpose. Since sealability is concerned with the combination of an external taper thread and a parallel internal thread, screw thread plug gauges survived while screw thread ring gauges were discontinued. Meanwhile, JIS B 2054 (PF) was established principally for mechanical joints. Subsequently, JIS B 0202 (Parallel pipe threads) was revised in 1982. Its main text sets out the content of ISO 228/1, using the thread symbol "G," while "PF" used in the previous JIS edition is specified in the Appendix. Furthermore, the main text of JIS B 0203 (Taper pipe threads) also sets out the content of ISO 7/1, using thread symbols "R," "Rc" and "Rp." Symbols "PT" and "PS" used in the previous JIS edition are specified in the Appendix to the standard.

■有关平行管螺纹的尺寸位置关系图 Related positions of Parallel Pipe threads



在检查新 JIS 管用螺纹时，请使用标有新螺纹记号的量规。
Where pressure-tight joints are made on the threads, the pipe threads will comply with JIS B 0203.
When checking new JIS Pipe threads, use the new thread symbol.

■区别 Difference

	附 属 书 JIS0202 Appendix	规 格 本 体 JIS0202 Text
螺 纹 记 号 Screw thread Symbol	PF	G
尺 寸 范 围 Range of thread size	PF1/8 ～ PF12"	G1/16 ～ G6"
等 级 Classes	外螺纹、内螺纹都有 A 级、B 级之分 Both external & internal thread are divided into classes A & B	外螺纹有 A 级、B 级之分，内螺纹无等级之分 Only the external thread is divided into classes A & B
	"1/8 - 6" 的外螺纹 (A 级、B 级) 和内螺纹 (A 级) 是在规定以外的事项，它们的公差与规格本体中规定的没有改变 The tolerances of the external and internal threads of PF1/8 ～6" differ from the specifications in the Appendix, but they are the same as those specified in the Text.	

螺纹量规系列 GAUGES

锥管螺纹量规※1
Gauges for taper pipe threads
TG (R • PT)

锥管螺纹量规用于检测锥管螺纹以及检测锥管螺纹相嵌合之管用平行内螺纹。检测锥管内螺纹丝锥管外螺纹制造公差时，锥管内螺纹的端面必须进入锥管塞规大径侧端面上的切口，锥管外螺纹端面必须进入锥管纹环规小径侧面的切口，才能判断被测螺纹是否合格。在1982年，JIS标准的锥管螺纹量规被重新修订。ISO 7/1的规格用记号"R"、"Rc"和"Rp"来代替旧JIS标准中的"PT"和"PS"。在使用新的JIS标准时，需要使用新的记号。

Gauges for taper pipe threads are used to inspect taper pipe threads and parallel pipe internal threads that fit taper threads. A taper thread plug gauge and a taper thread ring gauge form a pair of gauges for taper pipe threads. To inspect the manufacturing tolerance for an internal taper thread or external taper thread, the notch in the large end of a taper thread plug gauge or the small end of a taper thread ring gauge is referred to. When a taper thread plug or ring gauge is screwed up into or on an internal or external taper thread by hand, the pipe or pipe fitting passes the inspection if its end is within the range defined by the notch. The JIS standard for taper pipe threads was revised in 1982. Its main text sets out the content of ISO 7/1, using thread symbols "R," "Rc" and "Rp." Symbols "PT" and "PS" used in the previous JIS edition are specified in the Appendix to the standard. To inspect pipe threads specified in the revised JIS, gauges that bear the new thread symbols should be used.

※1：旧英式规格。　※1：Old UK standard.

JIS B0203-1982

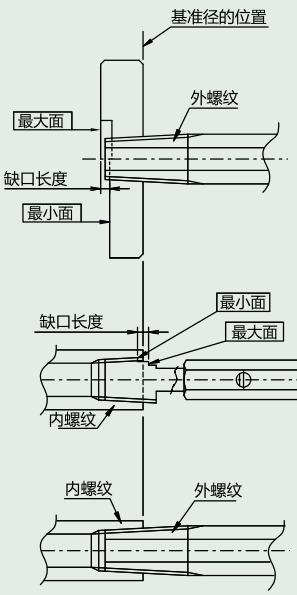
规格本体的螺纹	锥管外螺纹 锥管内螺纹 平行内螺纹	：R ：Rc ：Rp	Symbol specified in Text	External taper thread Internal taper thread Internal parallel thread	:R :Rc :Rp
附属书的螺纹	锥管外螺纹 锥管内螺纹 平行内螺纹	：PT ：PT ：PS	Symbol specified in Appendix	External taper thread Internal taper thread Internal parallel thread	:PT :PT :PS

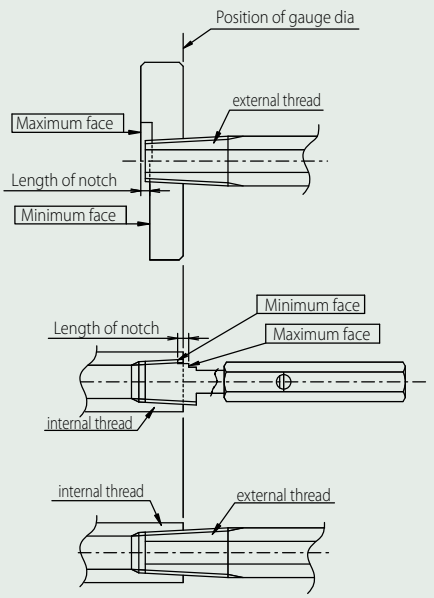
螺纹与锥管螺纹量规的关系示意图（R）　Relationship of Taper threads and Gauges(R)

●外螺纹判定
Inspection of external thread

●内螺纹判定
Inspection of internal thread

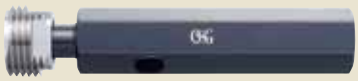
●外螺纹和内螺纹的组合
External and internal thread combined





锥管螺纹量规※2
Gauges for ANSI taper pipe threads

TG (NPT)



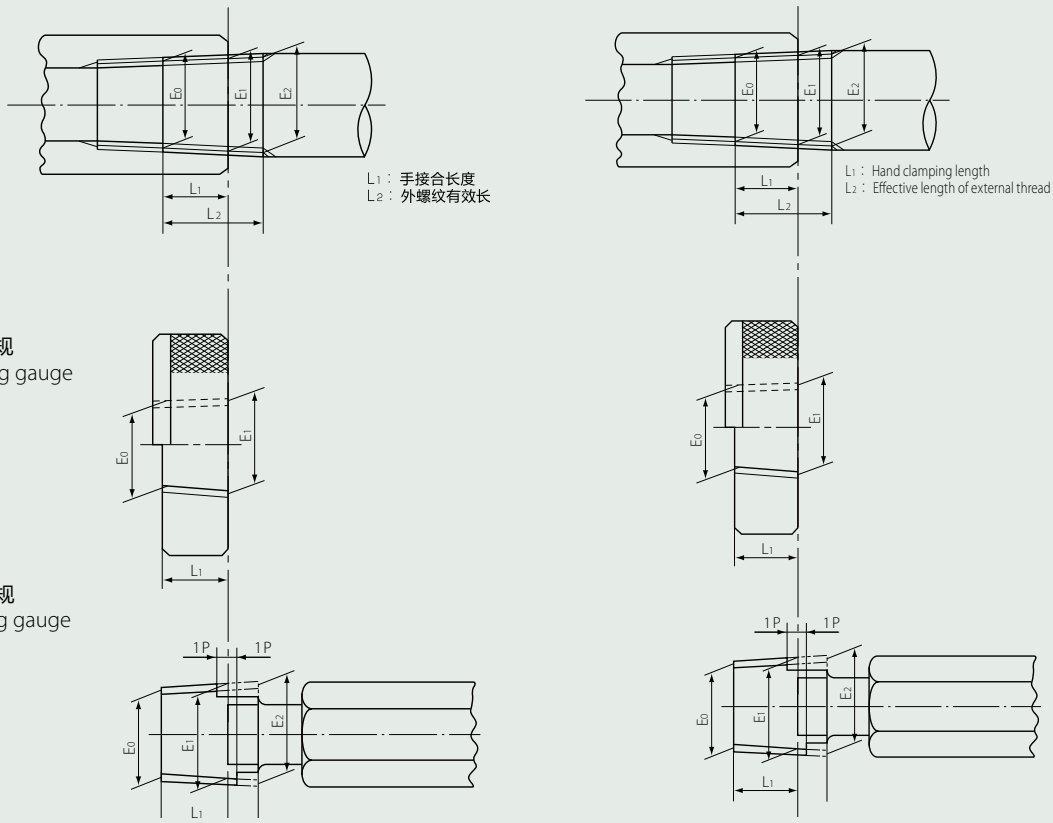
根据美国ANSI规格的规定，美式锥管螺纹量规是用于检测密封用锥管螺纹的量规。在NPT量规中，有各种各样的规格，包括带切口的和不带切口的。带有3层切口的式样（L1）为常用。如果测试的螺纹符合标准，外螺纹和内螺纹管端将会停在端面螺纹规的中央位置，其他两个端面将分别表示最大和最小容许公差。

Gauges for ANSI taper pipe threads (NPT) are used to inspect taper pipe threads (NPT) in general sealable parts. Various gauge specifications are in use for NPT gauges, some of which have notches, while others do not. Commonly used thread plug and ring gauges are provided with three-step notches (L1). If the inspected taper thread conforms to the standard dimensions, the pipe end stops at the BASIC position, which is the middle notch on the gauge. The other two notches indicate the maximum and minimum allowed dimensions.

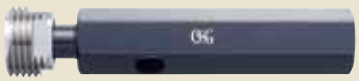
※2：旧美式规格。※2：Old ANSI standard.

■螺纹和锥管螺纹量规的关系示意图 Relationship of Taper threads and Gauges

●内螺纹和外螺纹的组合
External and Internal thread combined



锥管螺纹量规※2
Gauges for ANSI taper pipe threads
TG (NPTF)



美式锥管螺纹量规适用于检测船舶、汽车、航空航天的燃料管等对密封性要求极高的锥管螺纹的量规，它可以在不适用密封材料的情况下，依旧保证无油密封。规格为L1的塞规和环规适用于检测手结合部分的外螺纹和内螺纹。L3的塞规和L2的环规适用于检测扳手结合部分的外螺纹和内螺纹。
※L1的量规为标准品，L2和L3量规接受非标定制。

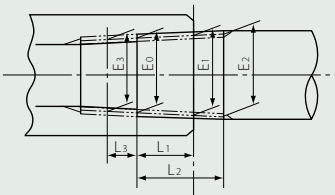
Gauges for ANSI taper pipe threads (NPTF) are intended for threads used to join fuel or oil pipes in ships, automobiles, aircraft and etc. These threads are designed to achieve dry seal joints without using a sealing material. L1 plug and L1 ring are used to inspect the hand-tight length (L1) of external and internal threads. L3 plug and L2 ring are used to check the wrench-tight length (L3 and L2-L1) of external and internal threads. When the positional relationship of the notches of two gauges, L1 and L3 plugs, or L1 and L2 rings, is not more than a half turn, the degree of taper of the product is guaranteed.
※ We offer L1 gauges as standard stocked items. L2 and L3 gauges are made to order.

※2：旧美式规格。※2：Old ANSI standard.

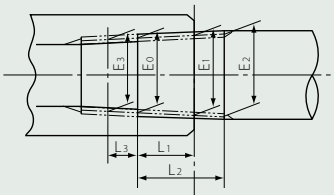
NPTF 量规	检测手接合部分	L1 螺纹塞规
		L1 螺纹环规
	检测扳手接合部分	L3 螺纹塞规
		L2 螺纹环规

NPTF gauge	inspection of handclamping length	L_1 Plug gauge
		L_1 Ring gauge
	inspection of wrench clamping length	L_3 Plug gauge
		L_2 Ring gauge

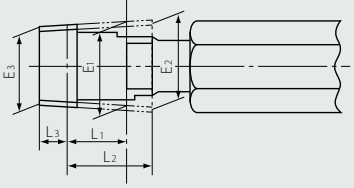
● L_1 塞规
L_1 Plug gauge



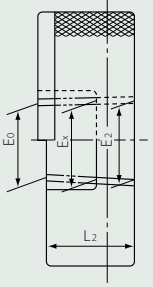
● L_1 环规
L_1 Ring gauge



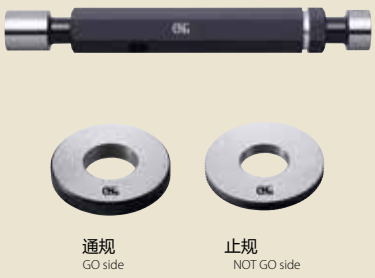
● L_3 塞规
L_3 Plug gauge



● L_2 环规
L_2 Ring gauge



极限圆柱量规
Plain limit gauges **PG**

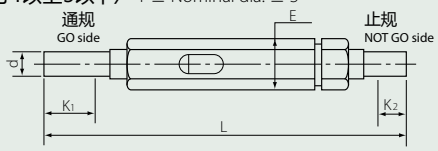


极限圆柱量规是检测孔和轴尺寸用的量规，常见的有塞规、环规和夹钳量规。塞规常用于检测标准直径为1mm到120mm的孔。对于那些标准直径为1mm到50mm的孔，经常使用通规和止规。无论通规还是止规都能用于检测和制造。
※环规为非标品。

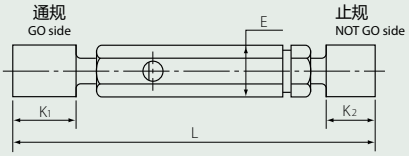
Plain limit gauges are used to inspect hole or shaft dimensions. Plug, ring and caliper gauges are commonly used. Plug gauges are usually used with holes 1 mm to 120 mm in nominal diameter. For holes 1 mm to 50 mm in nominal diameter, gauges with a GO end and a NO GO end attached to a handle (double-head type) are used. For holes exceeding 50 mm in nominal diameter, separate GO and NO GO gauges (single-head type) are used. NO GO gauges are provided with an identifying groove. A bleeder hole could be bored in these gauges upon veguests.
※Ring gauges: special order item

■极限圆柱量规的形状
Shapes and Dimensions of Limit Plug Gauges

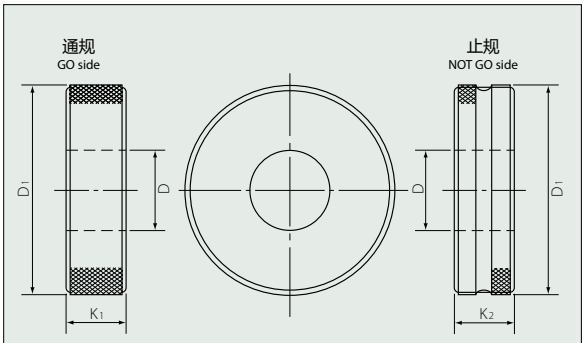
〈尺寸1以上3以下〉 1 ≦ Nominal dia. ≦ 3



〈尺寸3以上50以下〉 3 < Nominal dia. ≦ 50



■极限圆柱量规的形状
Shapes and Dimensions of Limit Ring Gauges



标准量规
Standard gauges
(Master gauges) **PG-M** **RG-M**

标准量规
Master ring gauges

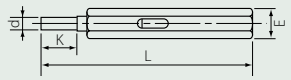
标准塞规
Master plug gauges

标准量规是按照测定器的尺寸而设定的，或用于基本尺寸的点检管理，标准量规包括塞规和环规，并不直接用于检测产品。
※PG-M为非标品。

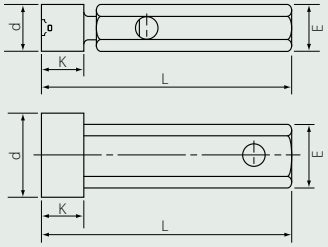
Standard gauges are used as a reference for dimensioning and maintenance of other gauges and comparators (cylinder gauges, microindicators, air micrometers, and dial gauge-based measuring instruments). Standard gauges include master plug and master ring gauges. These gauges are not to be directly used with products (parts).
※PG-M: special order item

■标准塞规形状
Shapes and Dimensions of Master Plug Gauges

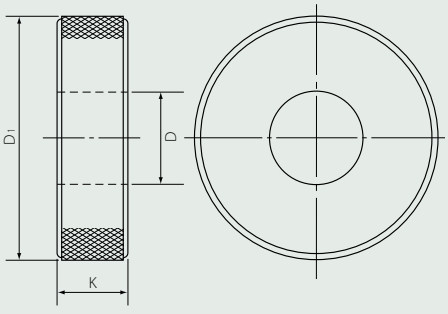
锥套型
Taper lock type



嵌套型
Trilock type



■标准塞环规形状
Shapes and Dimensions of Master Ring Gauges



螺纹规格表 SCREW THREAD STANDARDS

平行螺纹 Parallel (Straight) thread

螺纹种类 Type	记号 Abbreviation	规格 Standard	牙形角 Thread angle	尺寸范围 Size range	精度等级 Tolerance class	量规规格 Standard for screw thread gauge
公制螺纹 Metric screw threads	M	JIS B 0205 JIS B 0209 JIS B 0207 ※1 JIS B 0211 ※1		1 ～ 355	4H, 5H, 6H, 7H 4h, 6h, 6g, 8g	JIS B 0251
极小径螺纹 Miniature screw thread	S	JIS B 0201		0.3 ～ 1.4	3G5, 3G6, 4H5 4H6, 5h3	—
美制螺纹（粗牙） Unified coarse screw threads	UNC	JIS B 0206 JIS B 0210		No.1 ～ 4"	3B, 2B, 1B 3A, 2A, 1A	JIS B 0255
美制螺纹（细牙） Unified fine screw threads	UNF	JIS B 0208 JIS B 0212		No.0 ～ 1½		
美制螺纹（ANSI 规格） Unified thread (ANSI standard)	UNC/UNRC	ANSI/ASME B1.1	60°	No.1 ～ 4"		ANSI B1.2
	UNF/UNRF			No.0 ～ 1½		
	UNEF/UNREF			No.12 ～ 1 11/16		
	UNS/UNRS			No.10 ～ 6"		—
	4, 6, 8, 12, 16, 20, 28, 32UN/UNR			5/16 ～ 6		ANSI/ASME B1.2
美制螺纹 Unified thread	UNJC	SAE AS 8879D ISO 3161 ASME B1.15		0.073 ～ 4	3B, 3A 2B, 2A	NBS HAND BOOK H28
	UNJF			0.060 ～ 1.5		
	UNJEF			0.216 ～ 1.6875		
	8UNJ			1.0625 ～ 4		
	12UNJ			0.625 ～ 6		
	16UNJ			0.4375 ～ 6		
惠氏螺纹 (粗牙) Whitworth coarse screw thread	W	JIS B 0206 ※2	55°	¼ ～ 6	2级，3级，4级 Class2, Class3, Class4	JIS B 0257 ※1
惠氏螺纹 (细牙) Whitworth fine screw thread		JIS B 0208 ※2		9.5 ～ 150		JIS B 0258 ※1
平行管螺纹 Parallel pipe threads	G	JIS B 0202		1/16 ～ 6	外螺纹 -A 级，B 级 External thread-Class A, Class B	JIS B 0254
	PF	JIS B 0202 附属书 Appendix		1/8 ～12	A 级，B 级 Class A, Class B	JIS B 0254 附属书 Appendix
厚钢电源管螺纹 Screw threads for thick steel conduits	CTG	JIS C 8305 附属书 Appendix		16 ～ 104	—	—
薄钢电源管螺纹 Screw threads for thin steel conduits	CTC		80°	19 ～ 75		
平行管螺纹（美式） Straight pipe thread (USA)	NPSC	ANSI/ASME B1.20.1	60°	1/8 ～ 4		ANSI/ASME B1.20.1
	NPSM			1/8 ～ 6	2B, 2A	
	NPSL			1/8 ～12	—	
	NPSH	ANSI/ASME B1.20.7		½ ～ 4		
干密封圈平行管螺纹（美式） Parallel pipe threads (USA) (Dryseal)	NPSF	ANSI B1.20.3.1.20.4		1/16 ～ 1		ANSI B1.20.5
	NPSI					
平行管螺纹 (英式) Pipe threads (UK)	G	BS 2779	55°	1/16 ～ 6	外螺纹 -A 级，B 级 External thread-Class A, Class B	—
公制梯形螺纹 Metric trapezoidal screw threads	Tr	JIS B 0216 B 0217 B 0218 ※1	30°	8 ～ 300	7H, 8H, 7e, 8c	
30 度梯形螺纹 Trapezoidal screw thread (30°)	TM	JIS B 0216 : 1980 附属书 Appendix		10 ～ 300	—	
29 度梯形螺纹 Trapezoidal screw thread (29°)	TW	JIS B 0222 ※1	29°	10 ～ 100		
美式 ACME 螺纹 ACME threads (USA)	ACME	ANSI/ASME B1.5		1/4 ～ 5	4G, 3G, 2G 4C, 3C, 2C	ANSI B1.5
美式 STUB ACME 螺纹 Stub ACME threads, short (USA)	STUB ACME	ANSI/ASME B1.8			—	ANSI B1.8
美式 Buttress 螺纹 Buttress screw threads (USA)	BUTT	ANSI B1.9	7°×45°	½ ～ 24	Class3, Class2	ANSI B1.9
自行车螺纹 (一般用) Bicycle threads (General purpose)	BC	JIS B 0225	60°	5/16 ～ 1 9/16	—	JMAS 4002
自行车螺纹 (气门用) Bicycle threads (for spokes)				1.8 ～ 4		
缝纫机用螺纹 Screw threads for sewing machines	SM	JIS B 0226 ※1		1/16 ～ 1 3/16	1级，2级，3级 Class1, Class2, Class3	—
照相机三脚架用螺纹 Screw threads for Tripod Connections for Cameras	U	JIS B 7103		1/4, 3/8	—	
照相机镜头附属用品用螺纹 Screw threads for Engagement of Accessories to Lens Front	M	JIS B 7111		13.5 ～ 95		
内燃机火花塞螺纹 Screw threads for Spark Plugs for Internal Combustion Engines	M	JIS B 8031		10S, 12S, 14S		

螺纹规格表 SCREW THREAD STANDARDS

平行螺纹 Parallel (Straight) thread

螺纹种类 Type	记号 Abbreviation	规格 Standard	牙形角 Thread angle	尺寸范围 Size range	精度等级 Tolerance class	量规规格 Standard for screw thread gauge
植入式螺栓用 Stud Bolts	STUD	JIS B 1173	60°	4 ～ 20	—	—
汽车轮胎用气门螺纹 Tire valve threads for automobiles	V	JIS D 4207 附属书 Appendix		5 ～ 20		
汽车用轮胎气门系统螺纹 Tire valve threads for automobiles	TV	JIS D 4208※1		5 ～ 12		
自行车轮胎用气门螺纹 Tire valve threads for bicycles	CTV	JIS D 9422 附属书 Appendix		5 ～ 8		JMAS 4002
电灯用 Screw threads for electric lamps	E	JIS C 7709	—	5 ～ 40		—
水龙头用 Screw threads for Faucets and Ball Taps	—	JIS B 2061	55°	13, 20, 25		
钢线用 Plugs and flanges for steel drums	G	JIS Z 1604 附属书 Appendix		3/4, 2		JIS Z 1604 附属书 Appendix

锥管螺纹 Taper thread

螺纹种类 Type	记号 Abbreviation	规格 Standard	牙形角 Thread angle	尺寸范围 Size range	精度等级 Tolerance class	量规规格 Standard for screw thread gauge
锥管螺纹 Taper pipe external threads	R, RC（锥管内螺纹） Rp（平行内螺纹）	JIS B 0203	55°	1/16 ～ 6	1/16	JIS B 0253
	PT, PS（平行内螺纹）	JIS B 0203 附属书 Appendix		1/8 ～12		JIS B 0253 附属书 Appendix
锥管螺纹 (ISO) Taper pipe threads (ISO)	R	ISO7-1		1/16 ～ 6		ISO7-2
锥管螺纹（英式） Taper pipe threads (UK)	R, RC（锥管内螺纹） Rp（平行内螺纹）	BS 21				BS 21
锥管螺纹（美式） Taper pipe threads (USA)	NPT	ANSI/ASME B1.20.1	60°	1/16 ～ 24OD		ANSI/ASME B1.20.1
	NPTR			1/2 ～ 4		
锥管螺纹（美式）（干圈） Taper pipe threads (USA) (Dryseal)	NPTF	ANSI B1.20.3, 1.20.4		1/16 ～ 3		ANSI B1.20.5
	PTF-SAE SHORT					
锥管螺纹（航空用） Aeronautical National Form taper pipe threads	ANPT	SAE AS71051B				SAE AS71051B
三脚架用 for Shutter Cable Release Tips and Sockets for Cameras	—	JIS B 7104		3.4	28°	—
黑铅电极用 Screw threads for artificial graphite electrodes		JIS R 7201		3T ～ 24T	1/3	JIS R 7202
高压阀用 Screw threads for Seamless Steel Gas Cylinders		JIS B 8241	55°	V1, V2, V3	3/26	—
溶解容器阀用 Screw threads for Valves for Dissolved Acetylene Cylinders		JIS B 8244 附属书 Appendix		39		JIS B 8244～6 解说 Explanation
液化石油气容器阀用 Screw threads for Valves for Liquefied Petroleum Gas Cylinders		JIS B 8245 附属书 Appendix		V1, V2		
高压容器阀用 Screw threads for Valves for High Pressure Gas Cylinders		JIS B 8246		V1, V2, V3		
煤气容器用（英式） Screw threads for Transportable gas container valves (UK)		BS 341:Part1, 2		0.6 ～1.25	1/5.625, 1/8	BS 341:Part1, 2
油井用钢管用（美式） API Casing, Tubing, Line Pipe Threads (USA)	LP	API Std 5B	60°	1/8 ～ 20D	1/16	API Std 5B
	CSG			4 1/2 ～ 20		
	TBG			1.050 ～ 4 1/2		
	UP TBG					
	Buttress CSG		3°×10°	4 1/2 ～ 13 3/8	1/16	
				16 ～ 20	1/12	
	Ex. Li. CSG		6°× 6°	5 ～ 7 5/8	1/8	
				8 5/8 ～ 10 3/4	1/9.6	
API TOOL JOINT 螺纹（美式） API Rotary Shouldered Connection Threads (USA)	NC	API Spec 7	60°	23 ～ 77	1/4, 1/6	API Spec 7
	REG			2 3/8 ～ 8 5/8		
	IF			2 3/8 ～ 5 1/2	1/6	
	FH			3 1/2 ～ 6 5/8	1/4, 1/6	

※1:已经废番规格
※2:在本规格中，只有和其相当的规格被废番。

※1：A standard that has been abolished.
※2：In this standard, only the standard corresponding to the screw thread has been abolished.

螺纹极限量规(LG)
Limit gauges for screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1 × 0.25	2	30050	2	30051	2	30052	2	30053	2	30054	2	30057	2	30058	2	30059
M 1 × 0.2	2	30060	2	30061	2	30062	2	30063	2	30064	2	30067	2	30068	2	30069
M 1.1 × 0.25	2	30080	2	30081	2	30082	2	30083	2	30084	2	30087	2	30088	2	30089
M 1.1 × 0.2	2	30090	2	30091	2	30092	2	30093	2	30094	2	30097	2	30098	2	30099
M 1.2 × 0.25	2	30110	2	30111	2	30112	2	30113	2	30114	2	30117	2	30118	2	30119
M 1.2 × 0.2	2	30120	2	30121	2	30122	2	30123	2	30124	2	30127	2	30128	2	30129
M 1.4 × 0.3	2	30130	2	30131	2	30132	2	30133	2	30134	2	30137	2	30138	2	30139
M 1.4 × 0.2	2	30140	2	30141	2	30142	2	30143	2	30144	2	30147	2	30148	2	30149
M 1.6 × 0.35	2	30150	2	30151	2	30152	2	30153	2	30154	2	30157	2	30158	2	30159
M 1.6 × 0.2	2	30160	2	30161	2	30162	2	30163	2	30164	2	30167	2	30168	2	30169
M 1.7 × 0.35	2	30170	2	30171	2	30172	2	30173	2	30174	2	30177	2	30178	2	30179
M 1.7 × 0.2	2	30180	2	30181	2	30182	2	30183	2	30184	2	30187	2	30188	2	30189
M 1.8 × 0.35	2	30200	2	30201	2	30202	2	30203	2	30204	2	30207	2	30208	2	30209
M 1.8 × 0.2	2	30210	2	30211	2	30212	2	30213	2	30214	2	30217	2	30218	2	30219
M 2 × 0.4	2	30220	2	30221	2	30222	2	30223	2	30224	2	30227	2	30228	2	30229
M 2 × 0.25	2	30240	2	30241	2	30242	2	30243	2	30244	2	30247	2	30248	2	30249
M 2.2 × 0.45	2	30250	2	30251	2	30252	2	30253	2	30254	2	30257	2	30258	2	30259
M 2.2 × 0.25	2	30260	2	30261	2	30262	2	30263	2	30264	2	30267	2	30268	2	30269

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※2:长颈型请参考P.902。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.
※2：Refer to p. 902 for the head type.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

上一页
FROM 尺寸 Size M1 ~ M2.2

公制螺纹(M) Metric screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2.3 × 0.4	2	30280	2	30281	2	30282	2	30283	2	30284	2	30287	2	30288	2	30289
M 2.3 × 0.25	2	30300	2	30301	2	30302	2	30303	2	30304	2	30307	2	30308	2	30309
M 2.5 × 0.45	2	30310	2	30311	2	30312	2	30313	2	30314	2	30317	2	30318	2	30319
M 2.5 × 0.35	2	30320	2	30321	2	30322	2	30323	2	30324	2	30327	2	30328	2	30329
M 2.6 × 0.45	2	30330	2	30331	2	30332	2	30333	2	30334	2	30337	2	30338	2	30339
M 2.6 × 0.35	2	30340	2	30341	2	30342	2	30343	2	30344	2	30347	2	30348	2	30349
M 3 × 0.6	2	30350	2	30351	2	30352	2	30353	2	30354	2	30357	2	30358	2	30359
M 3 × 0.5	2	30360	2	30361	2	30362	2	30363	2	30364	2	30367	2	30368	2	30369
M 3 × 0.35	2	30370	2	30371	2	30372	2	30373	2	30374	2	30377	2	30378	2	30379
M 3.5 × 0.6	2	30390	2	30391	2	30392	2	30393	2	30394	2	30397	2	30398	2	30399
M 3.5 × 0.35	2	30400	2	30401	2	30402	2	30403	2	30404	2	30407	2	30408	2	30409
M 4 × 0.75	2	30410	2	30411	2	30412	2	30413	2	30414	2	30417	2	30418	2	30419
M 4 × 0.7	2	30420	2	30421	2	30422	2	30423	2	30424	2	30427	2	30428	2	30429
M 4 × 0.5	2	30430	2	30431	2	30432	2	30433	2	30434	2	30437	2	30438	2	30439
M 4.5 × 0.75	2	30440	2	30441	2	30442	2	30443	2	30444	2	30447	2	30448	2	30449
M 4.5 × 0.5	2	30450	2	30451	2	30452	2	30453	2	30454	2	30457	2	30458	2	30459
M 5 × 0.9	2	30460	2	30461	2	30462	2	30463	2	30464	2	30467	2	30468	2	30469
M 5 × 0.8	2	30470	2	30471	2	30472	2	30473	2	30474	2	30477	2	30478	2	30479

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※2:长颈型请参考P.902。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.
※2：Refer to p. 902 for the head type.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M5 ~ M9 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M2.3 ~ M5

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 5 × 0.75	2	30480	2	30481	2	30482	2	30483	2	30484	2	30487	2	30488	2	30489
M 5 × 0.5	2	30490	2	30491	2	30492	2	30493	2	30494	2	30497	2	30498	2	30499
M 5.5 × 0.9	2	30510	2	30511	2	30512	2	30513	2	30514	2	30517	2	30518	2	30519
M 5.5 × 0.75	2	30520	2	30521	2	30522	2	30523	2	30524	2	30527	2	30528	2	30529
M 5.5 × 0.5	2	30530	2	30531	2	30532	2	30533	2	30534	2	30537	2	30538	2	30539
M 6 × 1	2	30540	2	30541	2	30542	2	30543	2	30544	2	30547	2	30548	2	30549
M 6 × 0.75	2	30550	2	30551	2	30552	2	30553	2	30554	2	30557	2	30558	2	30559
M 6 × 0.5	2	30560	2	30561	2	30562	2	30563	2	30564	2	30567	2	30568	2	30569
M 7 × 1	2	30570	2	30571	2	30572	2	30573	2	30574	2	30577	2	30578	2	30579
M 7 × 0.75	2	30580	2	30581	2	30582	2	30583	2	30584	2	30587	2	30588	2	30589
M 7 × 0.5	2	30590	2	30591	2	30592	2	30593	2	30594	2	30597	2	30598	2	30599
M 8 × 1.25	2	30610	2	30611	2	30612	2	30613	2	30614	2	30617	2	30618	2	30619
M 8 × 1	2	30620	2	30621	2	30622	2	30623	2	30624	2	30627	2	30628	2	30629
M 8 × 0.75	2	30630	2	30631	2	30632	2	30633	2	30634	2	30637	2	30638	2	30639
M 8 × 0.5	2	30640	2	30641	2	30642	2	30643	2	30644	2	30647	2	30648	2	30649
M 9 × 1.25	2	30650	2	30651	2	30652	2	30653	2	30654	2	30657	2	30658	2	30659
M 9 × 1	2	30660	2	30661	2	30662	2	30663	2	30664	2	30667	2	30668	2	30669
M 9 × 0.75	2	30670	2	30671	2	30672	2	30673	2	30674	2	30677	2	30678	2	30679

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※2:长颈型请参考P.902。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.
※2：Refer to p. 902 for the head type.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M9 ~ M13 NEXT

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FROM 尺寸 Size M5 ~ M9

公制螺纹(M) Metric screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 9 × 0.5	2	30680	2	30681	2	30682	2	30683	2	30684	2	30687	2	30688	2	30689
M10 × 1.5	2	30700	2	30701	2	30702	2	30703	2	30704	2	30707	2	30708	2	30709
M10 × 1.25	2	30710	2	30711	2	30712	2	30713	2	30714	2	30717	2	30718	2	30719
M10 × 1	2	30720	2	30721	2	30722	2	30723	2	30724	2	30727	2	30728	2	30729
M10 × 0.75	2	30730	2	30731	2	30732	2	30733	2	30734	2	30737	2	30738	2	30739
M10 × 0.5	2	30740	2	30741	2	30742	2	30743	2	30744	2	30747	2	30748	2	30749
M11 × 1.5	2	30750	2	30751	2	30752	2	30753	2	30754	2	30757	2	30758	2	30759
M11 × 1.25	2	30760	2	30761	2	30762	2	30763	2	30764	2	30767	2	30768	2	30769
M11 × 1	2	30770	2	30771	2	30772	2	30773	2	30774	2	30777	2	30778	2	30779
M11 × 0.75	2	30780	2	30781	2	30782	2	30783	2	30784	2	30787	2	30788	2	30789
M11 × 0.5	2	30790	2	30791	2	30792	2	30793	2	30794	2	30797	2	30798	2	30799
M12 × 1.75	2	30800	2	30801	2	30802	2	30803	2	30804	2	30807	2	30808	2	30809
M12 × 1.5	2	30810	2	30811	2	30812	2	30813	2	30814	2	30817	2	30818	2	30819
M12 × 1.25	2	30820	2	30821	2	30822	2	30823	2	30824	2	30827	2	30828	2	30829
M12 × 1	2	30830	2	30831	2	30832	2	30833	2	30834	2	30837	2	30838	2	30839
M12 × 0.75	2	30840	2	30841	2	30842	2	30843	2	30844	2	30847	2	30848	2	30849
M12 × 0.5	2	30850	2	30851	2	30852	2	30853	2	30854	2	30857	2	30858	2	30859
M13 × 1.75	2	30870	2	30871	2	30872	2	30873	2	30874	2	30877	2	30878	2	30879

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※2:长颈型请参考P.902。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.
※2：Refer to p. 902 for the head type.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M13 ~ M16 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M9 ~ M13

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M13 × 1.5	2	30880	2	30881	2	30882	2	30883	2	30884	2	30887	2	30888	2	30889
M13 × 1.25	2	30890	2	30891	2	30892	2	30893	2	30894	2	30897	2	30898	2	30899
M13 × 1	2	30900	2	30901	2	30902	2	30903	2	30904	2	30907	2	30908	2	30909
M13 × 0.75	2	30910	2	30911	2	30912	2	30913	2	30914	2	30917	2	30918	2	30919
M13 × 0.5	2	30920	2	30921	2	30922	2	30923	2	30924	2	30927	2	30928	2	30929
M14 × 2	2	30930	2	30931	2	30932	2	30933	2	30934	2	30937	2	30938	2	30939
M14 × 1.5	2	30940	2	30941	2	30942	2	30943	2	30944	2	30947	2	30948	2	30949
M14 × 1.25	2	30950	2	30951	2	30952	2	30953	2	30954	2	30957	2	30958	2	30959
M14 × 1	2	30960	2	30961	2	30962	2	30963	2	30964	2	30967	2	30968	2	30969
M14 × 0.75	2	30970	2	30971	2	30972	2	30973	2	30974	2	30977	2	30978	2	30979
M14 × 0.5	2	30980	2	30981	2	30982	2	30983	2	30984	2	30987	2	30988	2	30989
M15 × 2	2	31000	2	31001	2	31002	2	31003	2	31004	2	31007	2	31008	2	31009
M15 × 1.5	2	31010	2	31011	2	31012	2	31013	2	31014	2	31017	2	31018	2	31019
M15 × 1	2	31030	2	31031	2	31032	2	31033	2	31034	2	31037	2	31038	2	31039
M15 × 0.75	2	31040	2	31041	2	31042	2	31043	2	31044	2	31047	2	31048	2	31049
M15 × 0.5	2	31050	2	31051	2	31052	2	31053	2	31054	2	31057	2	31058	2	31059
M16 × 2	2	31060	2	31061	2	31062	2	31063	2	31064	2	31067	2	31068	2	31069
M16 × 1.5	2	31070	2	31071	2	31072	2	31073	2	31074	2	31077	2	31078	2	31079

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M16 ~ M20 NEXT

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FROM 尺寸 Size M13 ~ M16

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M16 × 1.25	2	31080	2	31081	2	31082	2	31083	2	31084	2	31087	2	31088	2	31089
M16 × 1	2	31090	2	31091	2	31092	2	31093	2	31094	2	31097	2	31098	2	31099
M16 × 0.75	2	31100	2	31101	2	31102	2	31103	2	31104	2	31107	2	31108	2	31109
M16 × 0.5	2	31110	2	31111	2	31112	2	31113	2	31114	2	31117	2	31118	2	31119
M17 × 1.5	2	31140	2	31141	2	31142	2	31143	2	31144	2	31147	2	31148	2	31149
M17 × 1	2	31160	2	31161	2	31162	2	31163	2	31164	2	31167	2	31168	2	31169
M17 × 0.75	2	31170	2	31171	2	31172	2	31173	2	31174	2	31177	2	31178	2	31179
M18 × 2.5	2	31180	2	31181	2	31182	2	31183	2	31184	2	31187	2	31188	2	31189
M18 × 2	2	31190	2	31191	2	31192	2	31193	2	31194	2	31197	2	31198	2	31199
M18 × 1.5	2	31200	2	31201	2	31202	2	31203	2	31204	2	31207	2	31208	2	31209
M18 × 1	2	31220	2	31221	2	31222	2	31223	2	31224	2	31227	2	31228	2	31229
M18 × 0.75	2	31210	2	31211	2	31212	2	31213	2	31214	2	31217	2	31218	2	31219
M18 × 0.5	2	31230	2	31231	2	31232	2	31233	2	31234	2	31237	2	31238	2	31239
M19 × 2.5	2	31240	2	31241	2	31242	2	31243	2	31244	2	31247	2	31248	2	31249
M19 × 1.5	2	31260	2	31261	2	31262	2	31263	2	31264	2	31267	2	31268	2	31269
M19 × 1	2	31270	2	31271	2	31272	2	31273	2	31274	2	31277	2	31278	2	31279
M20 × 2.5	2	31290	2	31291	2	31292	2	31293	2	31294	2	31297	2	31298	2	31299
M20 × 2	2	31300	2	31301	2	31302	2	31303	2	31304	2	31307	2	31308	2	31309

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M20 ~ M25 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M16 ~ M20

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M20 × 1.5	2	31310	2	31311	2	31312	2	31313	2	31314	2	31317	2	31318	2	31319
M20 × 1.25	2	31320	2	31321	2	31322	2	31323	2	31324	2	31327	2	31328	2	31329
M20 × 1	2	31330	2	31331	2	31332	2	31333	2	31334	2	31337	2	31338	2	31339
M20 × 0.5	2	31350	2	31351	2	31352	2	31353	2	31354	2	31357	2	31358	2	31359
M22 × 2.5	2	31380	2	31381	2	31382	2	31383	2	31384	2	31387	2	31388	2	31389
M22 × 2	2	31390	2	31391	2	31392	2	31393	2	31394	2	31397	2	31398	2	31399
M22 × 1.5	2	31400	2	31401	2	31402	2	31403	2	31404	2	31407	2	31408	2	31409
M22 × 1	2	31410	2	31411	2	31412	2	31413	2	31414	2	31417	2	31418	2	31419
M22 × 0.5	2	31420	2	31421	2	31422	2	31423	2	31424	2	31427	2	31428	2	31429
M24 × 3	2	31460	2	31461	2	31462	2	31463	2	31464	2	31467	2	31468	2	31469
M24 × 2	2	31470	2	31471	2	31472	2	31473	2	31474	2	31477	2	31478	2	31479
M24 × 1.5	2	31480	2	31481	2	31482	2	31483	2	31484	2	31487	2	31488	2	31489
M24 × 1	2	31490	2	31491	2	31492	2	31493	2	31494	2	31497	2	31498	2	31499
M24 × 0.5	2	31500	2	31501	2	31502	2	31503	2	31504	2	31507	2	31508	2	31509
M25 × 2	2	31530	2	31531	2	31532	2	31533	2	31534	2	31537	2	31538	2	31539
M25 × 1.5	2	31540	2	31541	2	31542	2	31543	2	31544	2	31547	2	31548	2	31549
M25 × 1	2	31550	2	31551	2	31552	2	31553	2	31554	2	31557	2	31558	2	31559
M25 × 0.5	2	31560	2	31561	2	31562	2	31563	2	31564	2	31567	2	31568	2	31569

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M26 ~ M30 NEXT

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FROM 尺寸 Size M20 ~ M25

公制螺纹(M) Metric screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M26 × 3	2	31570	2	31571	2	31572	2	31573	2	31574	2	31577	2	31578	2	31579
M26 × 2	2	31580	2	31581	2	31582	2	31583	2	31584	2	31587	2	31588	2	31589
M26 × 1.5	2	31590	2	31591	2	31592	2	31593	2	31594	2	31597	2	31598	2	31599
M26 × 1	2	31600	2	31601	2	31602	2	31603	2	31604	2	31607	2	31608	2	31609
M26 × 0.5	2	31610	2	31611	2	31612	2	31613	2	31614	2	31617	2	31618	2	31619
M27 × 3	2	31620	2	31621	2	31622	2	31623	2	31624	2	31627	2	31628	2	31629
M27 × 2	2	31630	2	31631	2	31632	2	31633	2	31634	2	31637	2	31638	2	31639
M27 × 1.5	2	31640	2	31641	2	31642	2	31643	2	31644	2	31647	2	31648	2	31649
M27 × 1	2	31650	2	31651	2	31652	2	31653	2	31654	2	31657	2	31658	2	31659
M28 × 3	2	31660	2	31661	2	31662	2	31663	2	31664	2	31667	2	31668	2	31669
M28 × 2	2	31670	2	31671	2	31672	2	31673	2	31674	2	31677	2	31678	2	31679
M28 × 1.5	2	31680	2	31681	2	31682	2	31683	2	31684	2	31687	2	31688	2	31689
M28 × 1.25	2	31710	2	31711	2	31712	2	31713	2	31714	2	31717	2	31718	2	31719
M28 × 1	2	31690	2	31691	2	31692	2	31693	2	31694	2	31697	2	31698	2	31699
M28 × 0.5	2	31700	2	31701	2	31702	2	31703	2	31704	2	31707	2	31708	2	31709
M30 × 3.5	2	31720	2	31721	2	31722	2	31723	2	31724	2	31727	2	31728	2	31729
M30 × 3	2	31730	2	31731	2	31732	2	31733	2	31734	2	31737	2	31738	2	31739
M30 × 2	2	31740	2	31741	2	31742	2	31743	2	31744	2	31747	2	31748	2	31749

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M30 ~ M35 NEXT

螺纹极限量规(LG)

Limit gauges for screw threads

上一页
FROM 尺寸 Size M26 ~ M30

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M30 × 1.5	2	31750	2	31751	2	31752	2	31753	2	31754	2	31757	2	31758	2	31759
M30 × 1	2	31760	2	31761	2	31762	2	31763	2	31764	2	31767	2	31768	2	31769
M30 × 0.5	2	31770	2	31771	2	31772	2	31773	2	31774	2	31777	2	31778	2	31779
M32 × 3	2	31780	2	31781	2	31782	2	31783	2	31784	2	31787	2	31788	2	31789
M32 × 2	2	31790	2	31791	2	31792	2	31793	2	31794	2	31797	2	31798	2	31799
M32 × 1.5	2	31800	2	31801	2	31802	2	31803	2	31804	2	31807	2	31808	2	31809
M32 × 1	2	31810	2	31811	2	31812	2	31813	2	31814	2	31817	2	31818	2	31819
M32 × 0.5	2	31820	2	31821	2	31822	2	31823	2	31824	2	31827	2	31828	2	31829
M33 × 3.5	2	31830	2	31831	2	31832	2	31833	2	31834	2	31837	2	31838	2	31839
M33 × 3	2	31840	2	31841	2	31842	2	31843	2	31844	2	31847	2	31848	2	31849
M33 × 2	2	31850	2	31851	2	31852	2	31853	2	31854	2	31857	2	31858	2	31859
M33 × 1.5	2	31860	2	31861	2	31862	2	31863	2	31864	2	31867	2	31868	2	31869
M34 × 2	2	31900	2	31901	2	31902	2	31903	2	31904	2	31907	2	31908	2	31909
M34 × 1.5	2	31910	2	31911	2	31912	2	31913	2	31914	2	31917	2	31918	2	31919
M34 × 1	2	31920	2	31921	2	31922	2	31923	2	31924	2	31927	2	31928	2	31929
M34 × 0.5	2	31930	2	31931	2	31932	2	31933	2	31934	2	31937	2	31938	2	31939
M35 × 3	2	31940	2	31941	2	31942	2	31943	2	31944	2	31947	2	31948	2	31949
M35 × 1.5	2	31960	2	31961	2	31962	2	31963	2	31964	2	31967	2	31968	2	31969

库存分类全部为● (标准库存品)。

Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M36 ~ M40 NEXT

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FROM 尺寸 Size M30 ~ M35

公制螺纹(M) Metric screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M36 × 4	2	31980	2	31981	2	31982	2	31983	2	31984	2	31987	2	31988	2	31989
M36 × 3	2	31990	2	31991	2	31992	2	31993	2	31994	2	31997	2	31998	2	31999
M36 × 2	2	32000	2	32001	2	32002	2	32003	2	32004	2	32007	2	32008	2	32009
M36 × 1.5	2	32010	2	32011	2	32012	2	32013	2	32014	2	32017	2	32018	2	32019
M36 × 1	2	32020	2	32021	2	32022	2	32023	2	32024	2	32027	2	32028	2	32029
M36 × 0.5	2	32030	2	32031	2	32032	2	32033	2	32034	2	32037	2	32038	2	32039
M38 × 3	2	32050	2	32051	2	32052	2	32053	2	32054	2	32057	2	32058	2	32059
M38 × 2	2	32060	2	32061	2	32062	2	32063	2	32064	2	32067	2	32068	2	32069
M38 × 1.5	2	32070	2	32071	2	32072	2	32073	2	32074	2	32077	2	32078	2	32079
M38 × 1	2	32080	2	32081	2	32082	2	32083	2	32084	2	32087	2	32088	2	32089
M38 × 0.5	2	32090	2	32091	2	32092	2	32093	2	32094	2	32097	2	32098	2	32099
M39 × 4	2	32100	2	32101	2	32102	2	32103	2	32104	2	32107	2	32108	2	32109
M39 × 3	2	32110	2	32111	2	32112	2	32113	2	32114	2	32117	2	32118	2	32119
M39 × 2	2	32120	2	32121	2	32122	2	32123	2	32124	2	32127	2	32128	2	32129
M39 × 1.5	2	32130	2	32131	2	32132	2	32133	2	32134	2	32137	2	32138	2	32139
M40 × 3	2	32160	2	32161	2	32162	2	32163	2	32164	2	32167	2	32168	2	32169
M40 × 2	2	32170	2	32171	2	32172	2	32173	2	32174	2	32177	2	32178	2	32179
M40 × 1.5	2	32180	2	32181	2	32182	2	32183	2	32184	2	32187	2	32188	2	32189

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M40 ~ M48 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M36 ~ M40

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M40 × 1	2	32190	2	32191	2	32192	2	32193	2	32194	2	32197	2	32198	2	32199
M42 × 4.5	2	32200	2	32201	2	32202	2	32203	2	32204	2	32207	2	32208	2	32209
M42 × 4	2	32210	2	32211	2	32212	2	32213	2	32214	2	32217	2	32218	2	32219
M42 × 3	2	32220	2	32221	2	32222	2	32223	2	32224	2	32227	2	32228	2	32229
M42 × 2	2	32230	2	32231	2	32232	2	32233	2	32234	2	32237	2	32238	2	32239
M42 × 1.5	2	32240	2	32241	2	32242	2	32243	2	32244	2	32247	2	32248	2	32249
M42 × 1	2	32250	2	32251	2	32252	2	32253	2	32254	2	32257	2	32258	2	32259
M45 × 4.5	2	32270	2	32271	2	32272	2	32273	2	32274	2	32277	2	32278	2	32279
M45 × 4	2	32280	2	32281	2	32282	2	32283	2	32284	2	32287	2	32288	2	32289
M45 × 3	2	32290	2	32291	2	32292	2	32293	2	32294	2	32297	2	32298	2	32299
M45 × 2	2	32300	2	32301	2	32302	2	32303	2	32304	2	32307	2	32308	2	32309
M45 × 1.5	2	32310	2	32311	2	32312	2	32313	2	32314	2	32317	2	32318	2	32319
M45 × 1	2	32320	2	32321	2	32322	2	32323	2	32324	2	32327	2	32328	2	32329
M46 × 1.5	2	32340	2	32341	2	32342	2	32343	2	32344	2	32347	2	32348	2	32349
M48 × 5	2	32360	2	32361	2	32362	2	32363	2	32364	2	32367	2	32368	2	32369
M48 × 4	2	32370	2	32371	2	32372	2	32373	2	32374	2	32377	2	32378	2	32379
M48 × 3	2	32380	2	32381	2	32382	2	32383	2	32384	2	32387	2	32388	2	32389
M48 × 2	2	32390	2	32391	2	32392	2	32393	2	32394	2	32397	2	32398	2	32399

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M48 ~ M56 NEXT

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FROM 尺寸 Size M40 ~ M48

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M48 × 1.5	2	32400	2	32401	2	32402	2	32403	2	32404	2	32407	2	32408	2	32409
M48 × 1	2	32410	2	32411	2	32412	2	32413	2	32414	2	32417	2	32418	2	32419
M50 × 3	2	32430	2	32431	2	32432	2	32433	2	32434	2	32437	2	32438	2	32439
M50 × 2	2	32440	2	32441	2	32442	2	32443	2	32444	2	32447	2	32448	2	32449
M50 × 1.5	2	32450	2	32451	2	32452	2	32453	2	32454	2	32457	2	32458	2	32459
M50 × 1	2	32460	2	32461	2	32462	2	32463	2	32464	2	32467	2	32468	2	32469
M52 × 5	—	—	—	—	2	32482	2	32483	2	32484	2	32487	2	32488	2	32489
M52 × 4	—	—	—	—	2	32492	2	32493	2	32494	2	32497	2	32498	2	32499
M52 × 3	—	—	—	—	2	32502	2	32503	2	32504	2	32507	2	32508	2	32509
M52 × 2	—	—	—	—	2	32512	2	32513	2	32514	2	32517	2	32518	2	32519
M52 × 1.5	—	—	—	—	2	32522	2	32523	2	32524	2	32527	2	32528	2	32529
M54 × 4	—	—	—	—	2	32532	2	32533	2	32534	2	32537	2	32538	2	32539
M55 × 4	—	—	—	—	2	32552	2	32553	2	32554	2	32557	2	32558	2	32559
M55 × 3	—	—	—	—	2	32562	2	32563	2	32564	2	32567	2	32568	2	32569
M55 × 2	—	—	—	—	2	32572	2	32573	2	32574	2	32577	2	32578	2	32579
M55 × 1.5	—	—	—	—	2	32582	2	32583	2	32584	2	32587	2	32588	2	32589
M56 × 5.5	—	—	—	—	2	32592	2	32593	2	32594	2	32597	2	32598	2	32599
M56 × 4	—	—	—	—	2	32602	2	32603	2	32604	2	32607	2	32608	2	32609

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M56 ~ M64 NEXT

螺纹极限量规(LG)

Limit gauges for screw threads

上一页
FROM 尺寸 Size M48 ~ M56

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M56 × 3	—	—	—	—	2	32612	2	32613	2	32614	2	32617	2	32618	2	32619
M56 × 2	—	—	—	—	2	32622	2	32623	2	32624	2	32627	2	32628	2	32629
M56 × 1.5	—	—	—	—	2	32632	2	32633	2	32634	2	32637	2	32638	2	32639
M58 × 4	—	—	—	—	2	32652	2	32653	2	32654	2	32657	2	32658	2	32659
M58 × 3	—	—	—	—	2	32662	2	32663	2	32664	2	32667	2	32668	2	32669
M58 × 2	—	—	—	—	2	32672	2	32673	2	32674	2	32677	2	32678	2	32679
M58 × 1.5	—	—	—	—	2	32682	2	32683	2	32684	2	32687	2	32688	2	32689
M60 × 5.5	—	—	—	—	2	32702	2	32703	2	32704	2	32707	2	32708	2	32709
M60 × 4	—	—	—	—	2	32712	2	32713	2	32714	2	32717	2	32718	2	32719
M60 × 3	—	—	—	—	2	32722	2	32723	2	32724	2	32727	2	32728	2	32729
M60 × 2	—	—	—	—	2	32732	2	32733	2	32734	2	32737	2	32738	2	32739
M60 × 1.5	—	—	—	—	2	32742	2	32743	2	32744	2	32747	2	32748	2	32749
M62 × 4	—	—	—	—	2	32762	2	32763	2	32764	2	32767	2	32768	2	32769
M62 × 3	—	—	—	—	2	32772	2	32773	2	32774	2	32777	2	32778	2	32779
M62 × 2	—	—	—	—	2	32782	2	32783	2	32784	2	32787	2	32788	2	32789
M62 × 1.5	—	—	—	—	2	32792	2	32793	2	32794	2	32797	2	32798	2	32799
M64 × 6	—	—	—	—	2	32812	2	32813	2	32814	2	32817	2	32818	2	32819
M64 × 4	—	—	—	—	2	32822	2	32823	2	32824	2	32827	2	32828	2	32829

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M64 ~ M72 NEXT

上一页
FROM 尺寸 Size M56 ~ M64

公制螺纹(M) Metric screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M64 × 3	—	—	—	—	2	32832	2	32833	2	32834	2	32837	2	32838	2	32839
M64 × 2	—	—	—	—	2	32842	2	32843	2	32844	2	32847	2	32848	2	32849
M64 × 1.5	—	—	—	—	2	32852	2	32853	2	32854	2	32857	2	32858	2	32859
M65 × 4	—	—	—	—	2	32872	2	32873	2	32874	2	32877	2	32878	2	32879
M65 × 3	—	—	—	—	2	32882	2	32883	2	32884	2	32887	2	32888	2	32889
M65 × 2	—	—	—	—	2	32892	2	32893	2	32894	2	32897	2	32898	2	32899
M65 × 1.5	—	—	—	—	2	32902	2	32903	2	32904	2	32907	2	32908	2	32909
M68 × 6	—	—	—	—	2	32922	2	32923	2	32924	2	32927	2	32928	2	32929
M68 × 4	—	—	—	—	2	32932	2	32933	2	32934	2	32937	2	32938	2	32939
M68 × 3	—	—	—	—	2	32942	2	32943	2	32944	2	32947	2	32948	2	32949
M68 × 2	—	—	—	—	2	32952	2	32953	2	32954	2	32957	2	32958	2	32959
M68 × 1.5	—	—	—	—	2	32962	2	32963	2	32964	2	32967	2	32968	2	32969
M70 × 6	—	—	—	—	2	9314402	2	9314403	2	9314404	2	9314407	2	9314408	2	9314409
M70 × 4	—	—	—	—	2	9314442	2	9314443	2	9314444	2	9314447	2	9314448	2	9314449
M70 × 3	—	—	—	—	2	9314482	2	9314483	2	9314484	2	9314487	2	9314488	2	9314489
M70 × 2	—	—	—	—	2	9314522	2	9314523	2	9314524	2	9314527	2	9314528	2	9314529
M70 × 1.5	—	—	—	—	2	9314562	2	9314563	2	9314564	2	9314567	2	9314568	2	9314569
M72 × 6	—	—	—	—	2	9314572	2	9314573	2	9314574	2	9314577	2	9314578	2	9314579

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M72 ~ M80 NEXT

螺纹极限量规(LG)

Limit gauges for screw threads

上一页
FROM 尺寸 Size M64 ~ M72

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M72 × 4	—	—	—	—	2	9314582	2	9314583	2	9314584	2	9314587	2	9314588	2	9314589
M72 × 3	—	—	—	—	2	9314602	2	9314603	2	9314604	2	9314607	2	9314608	2	9314609
M72 × 2	—	—	—	—	2	9314642	2	9314643	2	9314644	2	9314647	2	9314648	2	9314649
M72 × 1.5	—	—	—	—	2	9314682	2	9314683	2	9314684	2	9314687	2	9314688	2	9314689
M75 × 4	—	—	—	—	2	9314702	2	9314703	2	9314704	2	9314707	2	9314708	2	9314709
M75 × 3	—	—	—	—	2	9314722	2	9314723	2	9314724	2	9314727	2	9314728	2	9314729
M75 × 2	—	—	—	—	2	9314762	2	9314763	2	9314764	2	9314767	2	9314768	2	9314769
M75 × 1.5	—	—	—	—	2	9314802	2	9314803	2	9314804	2	9314807	2	9314808	2	9314809
M76 × 6	—	—	—	—	2	9314812	2	9314813	2	9314814	2	9314817	2	9314818	2	9314819
M76 × 4	—	—	—	—	2	9314822	2	9314823	2	9314824	2	9314827	2	9314828	2	9314829
M76 × 3	—	—	—	—	2	9314842	2	9314843	2	9314844	2	9314847	2	9314848	2	9314849
M76 × 2	—	—	—	—	2	9314882	2	9314883	2	9314884	2	9314887	2	9314888	2	9314889
M76 × 1.5	—	—	—	—	2	9314892	2	9314893	2	9314894	2	9314897	2	9314898	2	9314899
M78 × 2	—	—	—	—	2	9314912	2	9314913	2	9314914	2	9314917	2	9314918	2	9314919
M80 × 6	—	—	—	—	2	9314922	2	9314923	2	9314924	2	9314927	2	9314928	2	9314929
M80 × 3	—	—	—	—	2	9314962	2	9314963	2	9314964	2	9314967	2	9314968	2	9314969
M80 × 2	—	—	—	—	2	9315002	2	9315003	2	9315004	2	9315007	2	9315008	2	9315009
M80 × 1.5	—	—	—	—	2	9315042	2	9315043	2	9315044	2	9315047	2	9315048	2	9315049

库存分类全部为● (标准库存品)。

Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M82 ~ M100 NEXT

上一页
FROM 尺寸 Size M72 ~ M80

公制螺纹(M) Metric screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M82 × 2	—	—	—	—	2	9315062	2	9315063	2	9315064	2	9315067	2	9315068	2	9315069
M85 × 4	—	—	—	—	2	9315082	2	9315083	2	9315084	2	9315087	2	9315088	2	9315089
M85 × 3	—	—	—	—	2	9315122	2	9315123	2	9315124	2	9315127	2	9315128	2	9315129
M85 × 2	—	—	—	—	2	9315162	2	9315163	2	9315164	2	9315167	2	9315168	2	9315169
M85 × 1.5	—	—	—	—	2	9315202	2	9315203	2	9315204	2	9315207	2	9315208	2	9315209
M90 × 6	—	—	—	—	2	9315242	2	9315243	2	9315244	2	9315247	2	9315248	2	9315249
M90 × 4	—	—	—	—	2	9315282	2	9315283	2	9315284	2	9315287	2	9315288	2	9315289
M90 × 3	—	—	—	—	2	9315322	2	9315323	2	9315324	2	9315327	2	9315328	2	9315329
M90 × 2	—	—	—	—	2	9315362	2	9315363	2	9315364	2	9315367	2	9315368	2	9315369
M90 × 1.5	—	—	—	—	2	9315402	2	9315403	2	9315404	2	9315407	2	9315408	2	9315409
M95 × 6	—	—	—	—	2	9315412	2	9315413	2	9315414	2	9315417	2	9315418	2	9315419
M95 × 4	—	—	—	—	2	9315432	2	9315433	2	9315434	2	9315437	2	9315438	2	9315439
M95 × 3	—	—	—	—	2	9315452	2	9315453	2	9315454	2	9315457	2	9315458	2	9315459
M95 × 2	—	—	—	—	2	9315492	2	9315493	2	9315494	2	9315497	2	9315498	2	9315499
M95 × 1.5	—	—	—	—	2	9315532	2	9315533	2	9315534	2	9315537	2	9315538	2	9315539
M100 × 6	—	—	—	—	2	9315572	2	9315573	2	9315574	2	9315577	2	9315578	2	9315579
M100 × 4	—	—	—	—	2	9315612	2	9315613	2	9315614	2	9315617	2	9315618	2	9315619
M100 × 3	—	—	—	—	2	9315652	2	9315653	2	9315654	2	9315657	2	9315658	2	9315659

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M100 ~ M130 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M82 ~ M100

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M100 × 2	—	—	—	—	2	9315692	2	9315693	2	9315694	2	9315697	2	9315698	2	9315699
M100 × 1.5	—	—	—	—	2	9315732	2	9315733	2	9315734	2	9315737	2	9315738	2	9315739
M105 × 6	—	—	—	—	2	9315752	2	9315753	2	9315754	2	9315757	2	9315758	2	9315759
M105 × 2	—	—	—	—	2	9315792	2	9315793	2	9315794	2	9315797	2	9315798	2	9315799
M110 × 3	—	—	—	—	2	9315842	2	9315843	2	9315844	2	9315847	2	9315848	2	9315849
M110 × 2	—	—	—	—	2	9315862	2	9315863	2	9315864	2	9315867	2	9315868	2	9315869
M115 × 4	—	—	—	—	2	9315912	2	9315913	2	9315914	2	9315917	2	9315918	2	9315919
M115 × 2	—	—	—	—	2	9315932	2	9315933	2	9315934	2	9315937	2	9315938	2	9315939
M120 × 3	—	—	—	—	2	9315982	2	9315983	2	9315984	2	9315987	2	9315988	2	9315989
M120 × 2	—	—	—	—	2	9316002	2	9316003	2	9316004	2	9316007	2	9316008	2	9316009
M125 × 4	—	—	—	—	2	9316032	2	9316033	2	9316034	2	9316037	2	9316038	2	9316039
M125 × 2	—	—	—	—	2	9316052	2	9316053	2	9316054	2	9316057	2	9316058	2	9316059
M130 × 6	—	—	—	—	2	9316072	2	9316073	2	9316074	2	9316077	2	9316078	2	9316079
M130 × 3	—	—	—	—	2	9316092	2	9316093	2	9316094	2	9316097	2	9316098	2	9316099
M130 × 2	—	—	—	—	2	9316112	2	9316113	2	9316114	2	9316117	2	9316118	2	9316119

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹用极限量规 长颈型(LG)

Thread Limit Gauge (long neck type)

是仅加长了螺纹用极限塞规颈部的螺纹塞规。

※ 无法用于有效螺纹长度的判定。如需讨论有效螺纹长度的判定，请咨询我司销售人员。

Thread plug gauge with only the neck of the thread limit plug gauge lengthened.
*Cannot be used to determine the effective thread length. Please consult with your nearest OSG sales office if required.

2级 (旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size 螺纹尺寸×螺距×ℓ Pitch	六角形柄长 Handle Length	塞规 Plug					
		GPIP		GPWP		GP	
		精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4 × 30	40	2	9344000	2	9344001	2	9344002
M 2.5 × 0.45 × 30	40	2	9344010	2	9344011	2	9344012
M 2.6 × 0.45 × 30	40	2	9344020	2	9344021	2	9344022
M 3 × 0.5 × 30	40	2	9344030	2	9344031	2	9344032
M 4 × 0.7 × 40	50	2	9344040	2	9344041	2	9344042
M 5 × 0.8 × 40	50	2	9344050	2	9344051	2	9344052
M 6 × 1 × 40	70	2	9344060	2	9344061	2	9344062
M 8 × 1.25 × 40	70	2	9344070	2	9344071	2	9344072
M 10 × 1.5 × 50	75	2	9344080	2	9344081	2	9344082
M 10 × 1.25 × 50	75	2	9344090	2	9344091	2	9344092
M 12 × 1.75 × 50	75	2	9344100	2	9344101	2	9344102
M 12 × 1.25 × 50	75	2	9344110	2	9344111	2	9344112

库存分类全部为● (标准库存品)。

Stock are categolized in section ● (Standard stock item).

※1:由于塞规和六角形柄为压入结构,所以尺寸存在偏差(±1.5mm左右)。
※2:请在确认和工件的干涉有2mm以上的余量后使用。
※3:无法进行有效螺纹长度的测定。

※1:The dimensions of the plug gauge and handle vary due to press-fitting (± 1.5 mm).
※2:Please confirm that there is at least 2 mm between the handle and the workpiece with no interference before purchasing.
※3:The effective thread length cannot be measured.

螺纹极限量规(LG)
Limit gauges for screw threads

公制螺纹(M) Metric screw threads
■左螺纹 LH Thread

2级(旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1.4 × 0.3 -L	2	39420	2	39421	2	39422	2	39423	2	39424	2	39427	2	39428	2	39429
M 1.7 × 0.35 -L	2	39460	2	39461	2	39462	2	39463	2	39464	2	39467	2	39468	2	39469
M 2 × 0.4 -L	2	39500	2	39501	2	39502	2	39503	2	39504	2	39507	2	39508	2	39509
M 2.5 × 0.45 -L	2	39560	2	39561	2	39562	2	39563	2	39564	2	39567	2	39568	2	39569
M 2.6 × 0.45 -L	2	39580	2	39581	2	39582	2	39583	2	39584	2	39587	2	39588	2	39589
M 3 × 0.6 -L	2	39600	2	39601	2	39602	2	39603	2	39604	2	39607	2	39608	2	39609
M 3 × 0.5 -L	2	39610	2	39611	2	39612	2	39613	2	39614	2	39617	2	39618	2	39619
M 4 × 0.75 -L	2	39630	2	39631	2	39632	2	39633	2	39634	2	39637	2	39638	2	39639
M 4 × 0.7 -L	2	39640	2	39641	2	39642	2	39643	2	39644	2	39647	2	39648	2	39649
M 5 × 0.9 -L	2	39660	2	39661	2	39662	2	39663	2	39664	2	39667	2	39668	2	39669
M 5 × 0.8 -L	2	39670	2	39671	2	39672	2	39673	2	39674	2	39677	2	39678	2	39679
M 6 × 1 -L	2	39680	2	39681	2	39682	2	39683	2	39684	2	39687	2	39688	2	39689
M 7 × 1 -L	2	39700	2	39701	2	39702	2	39703	2	39704	2	39707	2	39708	2	39709
M 8 × 1.25 -L	2	39710	2	39711	2	39712	2	39713	2	39714	2	39717	2	39718	2	39719
M 9 × 1.25 -L	2	39730	2	39731	2	39732	2	39733	2	39734	2	39737	2	39738	2	39739
M10 × 1.5 -L	2	39750	2	39751	2	39752	2	39753	2	39754	2	39757	2	39758	2	39759
M10 × 1.25 -L	2	39760	2	39761	2	39762	2	39763	2	39764	2	39767	2	39768	2	39769
M11 × 1.5 -L	2	39780	2	39781	2	39782	2	39783	2	39784	2	39787	2	39788	2	39789
M12 × 1.75 -L	2	39800	2	39801	2	39802	2	39803	2	39804	2	39807	2	39808	2	39809
M12 × 1.5 -L	2	39810	2	39811	2	39812	2	39813	2	39814	2	39817	2	39818	2	39819

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为●（标准库存品）。
Stock are categolized in section ● (Standard stock item).

上一页
FROM 尺寸 Size M1.4 ~ M12

公制螺纹(M) Metric screw threads

■左螺纹 LH Thread

2级 (旧JIS)
Class 2 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M12 × 1.25 -L	2	39820	2	39821	2	39822	2	39823	2	39824	2	39827	2	39828	2	39829
M14 × 2 -L	2	39840	2	39841	2	39842	2	39843	2	39844	2	39847	2	39848	2	39849
M14 × 1.5 -L	2	39850	2	39851	2	39852	2	39853	2	39854	2	39857	2	39858	2	39859
M14 × 1.25 -L	2	39860	2	39861	2	39862	2	39863	2	39864	2	39867	2	39868	2	39869
M16 × 2 -L	2	39870	2	39871	2	39872	2	39873	2	39874	2	39877	2	39878	2	39879
M16 × 1.5 -L	2	39880	2	39881	2	39882	2	39883	2	39884	2	39887	2	39888	2	39889
M18 × 2.5 -L	2	9320630	2	9320631	2	9320632	2	9320633	2	9320634	2	9320637	2	9320638	2	9320639
M18 × 1.5 -L	2	9320650	2	9320651	2	9320652	2	9320653	2	9320654	2	9320657	2	9320658	2	9320659
M20 × 2.5 -L	2	9320720	2	9320721	2	9320722	2	9320723	2	9320724	2	9320727	2	9320728	2	9320729
M20 × 1.5 -L	2	9320740	2	9320741	2	9320742	2	9320743	2	9320744	2	9320747	2	9320748	2	9320749
M22 × 2.5 -L	2	9320790	2	9320791	2	9320792	2	9320793	2	9320794	2	9320797	2	9320798	2	9320799
M22 × 1.5 -L	2	9320810	2	9320811	2	9320812	2	9320813	2	9320814	2	9320817	2	9320818	2	9320819
M24 × 3 -L	2	9320850	2	9320851	2	9320852	2	9320853	2	9320854	2	9320857	2	9320858	2	9320859
M24 × 1.5 -L	2	9320870	2	9320871	2	9320872	2	9320873	2	9320874	2	9320877	2	9320878	2	9320879
M26 × 1.5 -L	2	9320910	2	9320911	2	9320912	2	9320913	2	9320914	2	9320917	2	9320918	2	9320919
M27 × 3 -L	2	9320930	2	9320931	2	9320932	2	9320933	2	9320934	2	9320937	2	9320938	2	9320939
M27 × 1.5 -L	2	9320950	2	9320951	2	9320952	2	9320953	2	9320954	2	9320957	2	9320958	2	9320959
M28 × 1.5 -L	2	9320960	2	9320961	2	9320962	2	9320963	2	9320964	2	9320967	2	9320968	2	9320969
M30 × 3.5 -L	2	9321000	2	9321001	2	9321002	2	9321003	2	9321004	2	9321007	2	9321008	2	9321009
M30 × 1.5 -L	2	9321020	2	9321021	2	9321022	2	9321023	2	9321024	2	9321027	2	9321028	2	9321029

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

1级 (旧JIS)
Class 1 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	1	9322160	1	9322161	1	9322162	1	9322163	1	9322164	1	9322167	1	9322168	1	9322169
M 2.6 × 0.45	1	9322260	1	9322261	1	9322262	1	9322263	1	9322264	1	9322267	1	9322268	1	9322269
M 3 × 0.6	1	9322290	1	9322291	1	9322292	1	9322293	1	9322294	1	9322297	1	9322298	1	9322299
M 3 × 0.5	1	9322300	1	9322301	1	9322302	1	9322303	1	9322304	1	9322307	1	9322308	1	9322309
M 3.5 × 0.6	1	9322320	1	9322321	1	9322322	1	9322323	1	9322324	1	9322327	1	9322328	1	9322329
M 4 × 0.75	1	9322350	1	9322351	1	9322352	1	9322353	1	9322354	1	9322357	1	9322358	1	9322359
M 4 × 0.7	1	9322360	1	9322361	1	9322362	1	9322363	1	9322364	1	9322367	1	9322368	1	9322369
M 5 × 0.9	1	9322400	1	9322401	1	9322402	1	9322403	1	9322404	1	9322407	1	9322408	1	9322409
M 5 × 0.8	1	9322410	1	9322411	1	9322412	1	9322413	1	9322414	1	9322417	1	9322418	1	9322419
M 6 × 1	1	9322470	1	9322471	1	9322472	1	9322473	1	9322474	1	9322477	1	9322478	1	9322479
M 8 × 1.25	1	9322530	1	9322531	1	9322532	1	9322533	1	9322534	1	9322537	1	9322538	1	9322539
M 8 × 1	1	9322540	1	9322541	1	9322542	1	9322543	1	9322544	1	9322547	1	9322548	1	9322549
M 10 × 1.5	1	9322610	1	9322611	1	9322612	1	9322613	1	9322614	1	9322617	1	9322618	1	9322619
M 10 × 1.25	1	9322620	1	9322621	1	9322622	1	9322623	1	9322624	1	9322627	1	9322628	1	9322629
M 10 × 1	1	9322630	1	9322631	1	9322632	1	9322633	1	9322634	1	9322637	1	9322638	1	9322639
M 12 × 1.75	1	9322710	1	9322711	1	9322712	1	9322713	1	9322714	1	9322717	1	9322718	1	9322719
M 12 × 1.5	1	9322720	1	9322721	1	9322722	1	9322723	1	9322724	1	9322727	1	9322728	1	9322729
M 12 × 1.25	1	9322730	1	9322731	1	9322732	1	9322733	1	9322734	1	9322737	1	9322738	1	9322739

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M12 ~ M24 NEXT

上一页
FROM 尺寸 Size M2 ~ M12

1级 (旧JIS)
Class 1 (Previous JIS)

公制螺纹 (M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 12 × 1	1	9322740	1	9322741	1	9322742	1	9322743	1	9322744	1	9322747	1	9322748	1	9322749
M 14 × 2	1	9322830	1	9322831	1	9322832	1	9322833	1	9322834	1	9322837	1	9322838	1	9322839
M 14 × 1.5	1	9322840	1	9322841	1	9322842	1	9322843	1	9322844	1	9322847	1	9322848	1	9322849
M 14 × 1	1	9322860	1	9322861	1	9322862	1	9322863	1	9322864	1	9322867	1	9322868	1	9322869
M 16 × 2	1	9322950	1	9322951	1	9322952	1	9322953	1	9322954	1	9322957	1	9322958	1	9322959
M 16 × 1.5	1	9322960	1	9322961	1	9322962	1	9322963	1	9322964	1	9322967	1	9322968	1	9322969
M 16 × 1	1	9322980	1	9322981	1	9322982	1	9322983	1	9322984	1	9322987	1	9322988	1	9322989
M 18 × 2.5	1	9323070	1	9323071	1	9323072	1	9323073	1	9323074	1	9323077	1	9323078	1	9323079
M 18 × 1.5	1	9323090	1	9323091	1	9323092	1	9323093	1	9323094	1	9323097	1	9323098	1	9323099
M 20 × 2.5	1	9323210	1	9323211	1	9323212	1	9323213	1	9323214	1	9323217	1	9323218	1	9323219
M 20 × 2	1	9323220	1	9323221	1	9323222	1	9323223	1	9323224	1	9323227	1	9323228	1	9323229
M 20 × 1.5	1	9323230	1	9323231	1	9323232	1	9323233	1	9323234	1	9323237	1	9323238	1	9323239
M 22 × 2.5	1	9323300	1	9323301	1	9323302	1	9323303	1	9323304	1	9323307	1	9323308	1	9323309
M 22 × 2	1	9323310	1	9323311	1	9323312	1	9323313	1	9323314	1	9323317	1	9323318	1	9323319
M 22 × 1.5	1	9323320	1	9323321	1	9323322	1	9323323	1	9323324	1	9323327	1	9323328	1	9323329
M 24 × 3	1	9323390	1	9323391	1	9323392	1	9323393	1	9323394	1	9323397	1	9323398	1	9323399
M 24 × 2	1	9323410	1	9323411	1	9323412	1	9323413	1	9323414	1	9323417	1	9323418	1	9323419
M 24 × 1.5	1	9323420	1	9323421	1	9323422	1	9323423	1	9323424	1	9323427	1	9323428	1	9323429

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M27 ~ M36 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页

FROM 尺寸 Size M12 ~ M24

1级(旧JIS)
Class 1 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 27 × 3	1	9323530	1	9323531	1	9323532	1	9323533	1	9323534	1	9323537	1	9323538	1	9323539
M 27 × 2	1	9323550	1	9323551	1	9323552	1	9323553	1	9323554	1	9323557	1	9323558	1	9323559
M 27 × 1.5	1	9323580	1	9323581	1	9323582	1	9323583	1	9323584	1	9323587	1	9323588	1	9323589
M 30 × 3.5	1	9323640	1	9323641	1	9323642	1	9323643	1	9323644	1	9323647	1	9323648	1	9323649
M 30 × 2	1	9323660	1	9323661	1	9323662	1	9323663	1	9323664	1	9323667	1	9323668	1	9323669
M 30 × 1.5	1	9323670	1	9323671	1	9323672	1	9323673	1	9323674	1	9323677	1	9323678	1	9323679
M 32 × 1.5	1	9323710	1	9323711	1	9323712	1	9323713	1	9323714	1	9323717	1	9323718	1	9323719
M 33 × 3.5	1	9323730	1	9323731	1	9323732	1	9323733	1	9323734	1	9323737	1	9323738	1	9323739
M 33 × 2	1	9323750	1	9323751	1	9323752	1	9323753	1	9323754	1	9323757	1	9323758	1	9323759
M 33 × 1.5	1	9323760	1	9323761	1	9323762	1	9323763	1	9323764	1	9323767	1	9323768	1	9323769
M 36 × 4	1	9323860	1	9323861	1	9323862	1	9323863	1	9323864	1	9323867	1	9323868	1	9323869
M 36 × 3	1	9323870	1	9323871	1	9323872	1	9323873	1	9323874	1	9323877	1	9323878	1	9323879
M 36 × 2	1	9323880	1	9323881	1	9323882	1	9323883	1	9323884	1	9323887	1	9323888	1	9323889
M 36 × 1.5	1	9323890	1	9323891	1	9323892	1	9323893	1	9323894	1	9323897	1	9323898	1	9323899

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

3级 (旧JIS)
Class 3 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	3	36460	3	36461	3	36462	3	36463	3	36464	3	36467	3	36468	3	36469
M 3 × 0.6	3	36510	3	36511	3	36512	3	36513	3	36514	3	36517	3	36518	3	36519
M 3 × 0.5	3	36520	3	36521	3	36522	3	36523	3	36524	3	36527	3	36528	3	36529
M 4 × 0.75	3	36540	3	36541	3	36542	3	36543	3	36544	3	36547	3	36548	3	36549
M 4 × 0.7	3	36550	3	36551	3	36552	3	36553	3	36554	3	36557	3	36558	3	36559
M 5 × 0.9	3	36570	3	36571	3	36572	3	36573	3	36574	3	36577	3	36578	3	36579
M 5 × 0.8	3	36580	3	36581	3	36582	3	36583	3	36584	3	36587	3	36588	3	36589
M 6 × 1	3	36600	3	36601	3	36602	3	36603	3	36604	3	36607	3	36608	3	36609
M 8 × 1.25	3	36650	3	36651	3	36652	3	36653	3	36654	3	36657	3	36658	3	36659
M 8 × 1	3	36660	3	36661	3	36662	3	36663	3	36664	3	36667	3	36668	3	36669
M10 × 1.5	3	36700	3	36701	3	36702	3	36703	3	36704	3	36707	3	36708	3	36709
M10 × 1.25	3	36710	3	36711	3	36712	3	36713	3	36714	3	36717	3	36718	3	36719
M12 × 1.75	3	36760	3	36761	3	36762	3	36763	3	36764	3	36767	3	36768	3	36769
M12 × 1.5	3	36770	3	36771	3	36772	3	36773	3	36774	3	36777	3	36778	3	36779
M12 × 1.25	3	36780	3	36781	3	36782	3	36783	3	36784	3	36787	3	36788	3	36789
M12 × 1	3	36790	3	36791	3	36792	3	36793	3	36794	3	36797	3	36798	3	36799
M14 × 2	3	36810	3	36811	3	36812	3	36813	3	36814	3	36817	3	36818	3	36819
M14 × 1.5	3	36820	3	36821	3	36822	3	36823	3	36824	3	36827	3	36828	3	36829
M16 × 2	3	36860	3	36861	3	36862	3	36863	3	36864	3	36867	3	36868	3	36869
M16 × 1.5	3	36870	3	36871	3	36872	3	36873	3	36874	3	36877	3	36878	3	36879

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads
■ JIS (ISO)【嵌合度：中】(Fitting quality:Medium)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1 × 0.25	5H	9326980	5H	9326982	5H	9326983	6h	9326987	6h	9326988
M 1 × 0.2	6H※	9326990	6H※	9326992	6H※	9326993	6h	9326997	6h	9326998
M 1.1 × 0.25	5H	9327010	5H	9327012	5H	9327013	6h	9327017	6h	9327018
M 1.1 × 0.2	6H※	9327020	6H※	9327022	6H※	9327023	6h	9327027	6h	9327028
M 1.2 × 0.25	5H	9327040	5H	9327042	5H	9327043	6h	9327047	6h	9327048
M 1.2 × 0.2	6H※	9327050	6H※	9327052	6H※	9327053	6h	9327057	6h	9327058
M 1.4 × 0.3	5H	9327060	5H	9327062	5H	9327063	6h	9327067	6h	9327068
M 1.4 × 0.2	6H※	9327070	6H※	9327072	6H※	9327073	6h	9327077	6h	9327078
M 1.6 × 0.35	6H	9327080	6H	9327082	6H	9327083	6g	9327087	6g	9327088
M 1.6 × 0.2	6H※	9327090	6H※	9327092	6H※	9327093	6g	9327097	6g	9327098
M 1.8 × 0.35	6H	9327130	6H	9327132	6H	9327133	6g	9327137	6g	9327138
M 1.8 × 0.2	6H※	9327140	6H※	9327142	6H	9327143	6g	9327147	6g	9327148
M 2 × 0.4	6H	9327150	6H	9327152	6H	9327153	6g	9327157	6g	9327158
M 2 × 0.25	6H※	9327170	6H※	9327172	6H※	9327173	6g	9327177	6g	9327178
M 2.2 × 0.45	6H	9327180	6H	9327182	6H	9327183	6g	9327187	6g	9327188
M 2.2 × 0.25	6H※	9327190	6H※	9327192	6H※	9327193	6g	9327197	6g	9327198
M 2.5 × 0.45	6H	9327240	6H	9327242	6H	9327243	6g	9327247	6g	9327248
M 2.5 × 0.35	6H	9327250	6H	9327252	6H	9327253	6g	9327257	6g	9327258
M 3 × 0.5	6H	9327280	6H	9327282	6H	9327283	6g	9327287	6g	9327288

印※表示JIS规格以外的，不用"嵌合区分：中"规定。
※ indicates items outside of the JIS standard and are not stipulated by the "normal fit" thread tolerance class.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※2:长颈型请参考P.916。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.
※2 : Refer to p. 916 for the head type.

上一页
FROM 尺寸 Size M1 ~ M3

公制螺纹(M) Metric screw threads

■ JIS (ISO) [嵌合度：中] (Fitting quality:Medium)

JIS(ISO等级)
JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 3 × 0.35	6H	9327290	6H	9327292	6H	9327293	6g	9327297	6g	9327298
M 3.5 × 0.6	6H	9327300	6H	9327302	6H	9327303	6g	9327307	6g	9327308
M 3.5 × 0.35	6H	9327310	6H	9327312	6H	9327313	6g	9327317	6g	9327318
M 4 × 0.7	6H	9327350	6H	9327352	6H	9327353	6g	9327357	6g	9327358
M 4 × 0.5	6H	9327360	6H	9327362	6H	9327363	6g	9327367	6g	9327368
M 4.5 × 0.75	6H	9327370	6H	9327372	6H	9327373	6g	9327377	6g	9327378
M 4.5 × 0.5	6H	9327380	6H	9327382	6H	9327383	6g	9327387	6g	9327388
M 5 × 0.8	6H	9327400	6H	9327402	6H	9327403	6g	9327407	6g	9327408
M 5 × 0.5	6H	9327420	6H	9327422	6H	9327423	6g	9327427	6g	9327428
M 5.5 × 0.5	6H	9327450	6H	9327452	6H	9327453	6g	9327457	6g	9327458
M 6 × 1	6H	9327460	6H	9327462	6H	9327463	6g	9327467	6g	9327468
M 6 × 0.75	6H	9327470	6H	9327472	6H	9327473	6g	9327477	6g	9327478
M 7 × 1	6H	9327490	6H	9327492	6H	9327493	6g	9327497	6g	9327498
M 7 × 0.75	6H	9327500	6H	9327502	6H	9327503	6g	9327507	6g	9327508
M 8 × 1.25	6H	9327520	6H	9327522	6H	9327523	6g	9327527	6g	9327528
M 8 × 1	6H	9327530	6H	9327532	6H	9327533	6g	9327537	6g	9327538
M 8 × 0.75	6H	9327540	6H	9327542	6H	9327543	6g	9327547	6g	9327548
M 9 × 1.25	6H	9327560	6H	9327562	6H	9327563	6g	9327567	6g	9327568
M 9 × 1	6H	9327570	6H	9327572	6H	9327573	6g	9327577	6g	9327578

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※2:长颈型请参考P.916。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.
※2 : Refer to p. 916 for the head type.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M9 ~ M16 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M3 ~ M9

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads
■ JIS (ISO) [嵌合度：中] (Fitting quality:Medium)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 9 × 0.75	6H	9327580	6H	9327582	6H	9327583	6g	9327587	6g	9327588
M 10 × 1.5	6H	9327600	6H	9327602	6H	9327603	6g	9327607	6g	9327608
M 10 × 1.25	6H	9327610	6H	9327612	6H	9327613	6g	9327617	6g	9327618
M 10 × 1	6H	9327620	6H	9327622	6H	9327623	6g	9327627	6g	9327628
M 10 × 0.75	6H	9327630	6H	9327632	6H	9327633	6g	9327637	6g	9327638
M 11 × 1.5	6H	9327650	6H	9327652	6H	9327653	6g	9327657	6g	9327658
M 11 × 1	6H	9327670	6H	9327672	6H	9327673	6g	9327677	6g	9327678
M 11 × 0.75	6H	9327680	6H	9327682	6H	9327683	6g	9327687	6g	9327688
M 12 × 1.75	6H	9327700	6H	9327702	6H	9327703	6g	9327707	6g	9327708
M 12 × 1.5	6H	9327710	6H	9327712	6H	9327713	6g	9327717	6g	9327718
M 12 × 1.25	6H	9327720	6H	9327722	6H	9327723	6g	9327727	6g	9327728
M 12 × 1	6H	9327730	6H	9327732	6H	9327733	6g	9327737	6g	9327738
M 14 × 2	6H	9327820	6H	9327822	6H	9327823	6g	9327827	6g	9327828
M 14 × 1.5	6H	9327830	6H	9327832	6H	9327833	6g	9327837	6g	9327838
M 14 × 1.25	6H	9327840	6H	9327842	6H	9327843	6g	9327847	6g	9327848
M 14 × 1	6H	9327850	6H	9327852	6H	9327853	6g	9327857	6g	9327858
M 15 × 1.5	6H	9327870	6H	9327872	6H	9327873	6g	9327877	6g	9327878
M 15 × 1	6H	9327880	6H	9327882	6H	9327883	6g	9327887	6g	9327888
M 16 × 2	6H	9327940	6H	9327942	6H	9327943	6g	9327947	6g	9327948

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※2:长颈型请参考P.916。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.
※2：Refer to p. 916 for the head type.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M16 ~ M24 NEXT

上一页
FROM 尺寸 Size M9 ～ M16

公制螺纹(M) Metric screw threads

■ JIS (ISO) [嵌合度：中] (Fitting quality:Medium)

JIS(ISO等级)
JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 16 × 1.5	6H	9327950	6H	9327952	6H	9327953	6g	9327957	6g	9327958
M 16 × 1	6H	9327960	6H	9327962	6H	9327963	6g	9327967	6g	9327968
M 17 × 1.5	6H	9327970	6H	9327972	6H	9327973	6g	9327977	6g	9327978
M 17 × 1	6H	9327980	6H	9327982	6H	9327983	6g	9327987	6g	9327988
M 18 × 2.5	6H	9328060	6H	9328062	6H	9328063	6g	9328067	6g	9328068
M 18 × 2	6H	9328070	6H	9328072	6H	9328073	6g	9328077	6g	9328078
M 18 × 1.5	6H	9328080	6H	9328082	6H	9328083	6g	9328087	6g	9328088
M 18 × 1	6H	9328090	6H	9328092	6H	9328093	6g	9328097	6g	9328098
M 20 × 2.5	6H	9328200	6H	9328202	6H	9328203	6g	9328207	6g	9328208
M 20 × 2	6H	9328210	6H	9328212	6H	9328213	6g	9328217	6g	9328218
M 20 × 1.5	6H	9328220	6H	9328222	6H	9328223	6g	9328227	6g	9328228
M 20 × 1	6H	9328230	6H	9328232	6H	9328233	6g	9328237	6g	9328238
M 22 × 2.5	6H	9328290	6H	9328292	6H	9328293	6g	9328297	6g	9328298
M 22 × 2	6H	9328300	6H	9328302	6H	9328303	6g	9328307	6g	9328308
M 22 × 1.5	6H	9328310	6H	9328312	6H	9328313	6g	9328317	6g	9328318
M 22 × 1	6H	9328320	6H	9328322	6H	9328323	6g	9328327	6g	9328328
M 24 × 3	6H	9328380	6H	9328382	6H	9328383	6g	9328387	6g	9328388
M 24 × 2	6H	9328390	6H	9328392	6H	9328393	6g	9328397	6g	9328398
M 24 × 1.5	6H	9328410	6H	9328412	6H	9328413	6g	9328417	6g	9328418

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M24 ～ M32 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M16 ~ M24

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads
■ JIS (ISO) [嵌合度：中] (Fitting quality:Medium)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 24 × 1	6H	9328420	6H	9328422	6H	9328423	6g	9328427	6g	9328428
M 25 × 2	6H	9328430	6H	9328432	6H	9328433	6g	9328437	6g	9328438
M 25 × 1.5	6H	9328440	6H	9328442	6H	9328443	6g	9328447	6g	9328448
M 25 × 1	6H	9328450	6H	9328452	6H	9328453	6g	9328457	6g	9328458
M 26 × 1.5	6H	9328470	6H	9328472	6H	9328473	6g	9328477	6g	9328478
M 27 × 3	6H	9328520	6H	9328522	6H	9328523	6g	9328527	6g	9328528
M 27 × 2	6H	9328530	6H	9328532	6H	9328533	6g	9328537	6g	9328538
M 27 × 1.5	6H	9328550	6H	9328552	6H	9328553	6g	9328557	6g	9328558
M 27 × 1	6H	9328560	6H	9328562	6H	9328563	6g	9328567	6g	9328568
M 28 × 2	6H	9328570	6H	9328572	6H	9328573	6g	9328577	6g	9328578
M 28 × 1.5	6H	9328580	6H	9328582	6H	9328583	6g	9328587	6g	9328588
M 28 × 1	6H	9328590	6H	9328592	6H	9328593	6g	9328597	6g	9328598
M 30 × 3.5	6H	9328610	6H	9328612	6H	9328613	6g	9328617	6g	9328618
M 30 × 3	6H	9328620	6H	9328622	6H	9328623	6g	9328627	6g	9328628
M 30 × 2	6H	9328630	6H	9328632	6H	9328633	6g	9328637	6g	9328638
M 30 × 1.5	6H	9328640	6H	9328642	6H	9328643	6g	9328647	6g	9328648
M 30 × 1	6H	9328650	6H	9328652	6H	9328653	6g	9328657	6g	9328658
M 32 × 2	6H	9328660	6H	9328662	6H	9328663	6g	9328667	6g	9328668
M 32 × 1.5	6H	9328670	6H	9328672	6H	9328673	6g	9328677	6g	9328678

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M33 ~ M42 NEXT

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FROM 尺寸 Size M24 ~ M32

公制螺纹(M) Metric screw threads

■ JIS (ISO) [嵌合度：中] (Fitting quality:Medium)

JIS(ISO等级)
JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 33 × 3.5	6H	9328680	6H	9328682	6H	9328683	6g	9328687	6g	9328688
M 33 × 3	6H	9328690	6H	9328692	6H	9328693	6g	9328697	6g	9328698
M 33 × 2	6H	9328700	6H	9328702	6H	9328703	6g	9328707	6g	9328708
M 33 × 1.5	6H	9328710	6H	9328712	6H	9328713	6g	9328717	6g	9328718
M 35 × 1.5	6H	9328720	6H	9328722	6H	9328723	6g	9328727	6g	9328728
M 36 × 4	6H	9328730	6H	9328732	6H	9328733	6g	9328737	6g	9328738
M 36 × 3	6H	9328740	6H	9328742	6H	9328743	6g	9328747	6g	9328748
M 36 × 2	6H	9328750	6H	9328752	6H	9328753	6g	9328757	6g	9328758
M 36 × 1.5	6H	9328760	6H	9328762	6H	9328763	6g	9328767	6g	9328768
M 38 × 1.5	6H	9328770	6H	9328772	6H	9328773	6g	9328777	6g	9328778
M 39 × 4	6H	9328780	6H	9328782	6H	9328783	6g	9328787	6g	9328788
M 39 × 3	6H	9328790	6H	9328792	6H	9328793	6g	9328797	6g	9328798
M 39 × 2	6H	9328800	6H	9328802	6H	9328803	6g	9328807	6g	9328808
M 39 × 1.5	6H	9328810	6H	9328812	6H	9328813	6g	9328817	6g	9328818
M 40 × 3	6H	9328820	6H	9328822	6H	9328823	6g	9328827	6g	9328828
M 40 × 2	6H	9328830	6H	9328832	6H	9328833	6g	9328837	6g	9328838
M 40 × 1.5	6H	9328840	6H	9328842	6H	9328843	6g	9328847	6g	9328848
M 42 × 4.5	6H	9328850	6H	9328852	6H	9328853	6g	9328857	6g	9328858
M 42 × 4	6H	9328860	6H	9328862	6H	9328863	6g	9328867	6g	9328868

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M42 ~ M50 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页
FROM 尺寸 Size M33 ~ M42

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads
■ JIS (ISO) [嵌合度：中] (Fitting quality:Medium)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 42 × 3	6H	9328870	6H	9328872	6H	9328873	6g	9328877	6g	9328878
M 42 × 2	6H	9328880	6H	9328882	6H	9328883	6g	9328887	6g	9328888
M 42 × 1.5	6H	9328890	6H	9328892	6H	9328893	6g	9328897	6g	9328898
M 45 × 4.5	6H	9328900	6H	9328902	6H	9328903	6g	9328907	6g	9328908
M 45 × 4	6H	9328910	6H	9328912	6H	9328913	6g	9328917	6g	9328918
M 45 × 3	6H	9328920	6H	9328922	6H	9328923	6g	9328927	6g	9328928
M 45 × 2	6H	9328930	6H	9328932	6H	9328933	6g	9328937	6g	9328938
M 45 × 1.5	6H	9328940	6H	9328942	6H	9328943	6g	9328947	6g	9328948
M 48 × 5	6H	9328950	6H	9328952	6H	9328953	6g	9328957	6g	9328958
M 48 × 4	6H	9328960	6H	9328962	6H	9328963	6g	9328967	6g	9328968
M 48 × 3	6H	9328970	6H	9328972	6H	9328973	6g	9328977	6g	9328978
M 48 × 2	6H	9328980	6H	9328982	6H	9328983	6g	9328987	6g	9328988
M 48 × 1.5	6H	9328990	6H	9328992	6H	9328993	6g	9328997	6g	9328998
M 50 × 3	6H	9325020	6H	9325022	6H	9325023	6g	9325027	6g	9325028
M 50 × 2	6H	9325030	6H	9325032	6H	9325033	6g	9325037	6g	9325038
M 50 × 1.5	6H	9325040	6H	9325042	6H	9325043	6g	9325047	6g	9325048

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹用极限量规 长颈型(LG)

Thread Limit Gauge (long neck type)

是仅加长了螺纹用极限塞规颈部的螺纹塞规。

※ 无法用于有效螺纹长度的判定。如需讨论有效螺纹长度的判定，请咨询我司销售人员。

Thread plug gauge with only the neck of the thread limit plug gauge lengthened.

*Cannot be used to determine the effective thread length. Please consult with your nearest OSG sales office if required.

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size 螺纹尺寸×螺距×ℓ Pitch	六角形柄长 Handle Length	塞规 Plug			
		GPNP		GP	
		精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4 × 30	40	6H	9344120	6H	9344122
M 2.5 × 0.45 × 30	40	6H	9344130	6H	9344132
M 2.6 × 0.45 × 30	40	6H	9344140	6H	9344142
M 3 × 0.5 × 30	40	6H	9344150	6H	9344152
M 4 × 0.7 × 40	48	6H	9344160	6H	9344162
M 5 × 0.8 × 40	48	6H	9344170	6H	9344172
M 6 × 1 × 40	48	6H	9344180	6H	9344182
M 8 × 1.25 × 40	56	6H	9344190	6H	9344192
M 10 × 1.5 × 50	56	6H	9344200	6H	9344202
M 10 × 1.25 × 50	56	6H	9344210	6H	9344212
M 12 × 1.75 × 50	63	6H	9344220	6H	9344222
M 12 × 1.25 × 50	63	6H	9344230	6H	9344232

库存分类全部为● (标准库存品)。

Stock are categolized in section ● (Standard stock item).

※1:由于塞规和六角形柄为压入结构,所以尺寸存在偏差(±1.5mm左右)。
※2:请在确认和工件的干涉有2mm以上的余量后使用。
※3:无法进行有效螺纹长度的测定。

※1:The dimensions of the plug gauge and handle vary due to press-fitting (± 1.5 mm).
※2:Please confirm that there is at least 2 mm between the handle and the workpiece with no interference before purchasing.
※3:The effective thread length cannot be measured.

螺纹极限量规(LG)
Limit gauges for screw threads

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads
■JIS (ISO) 左螺纹 [嵌合度：中] LH Thread (Fitting quality:Medium)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1.4 × 0.3 - L	5H	9318060	5H	9318062	5H	9318063	6h	9318067	6h	9318068
M 2 × 0.4 - L	6H	9318150	6H	9318152	6H	9318153	6g	9318157	6g	9318158
M 2.5 × 0.45 - L	6H	9318240	6H	9318242	6H	9318243	6g	9318247	6g	9318248
M 3 × 0.5 - L	6H	9318280	6H	9318282	6H	9318283	6g	9318287	6g	9318288
M 4 × 0.7 - L	6H	9318350	6H	9318352	6H	9318353	6g	9318357	6g	9318358
M 5 × 0.8 - L	6H	9318400	6H	9318402	6H	9318403	6g	9318407	6g	9318408
M 6 × 1 - L	6H	9318460	6H	9318462	6H	9318463	6g	9318467	6g	9318468
M 7 × 1 - L	6H	9318490	6H	9318492	6H	9318493	6g	9318497	6g	9318498
M 8 × 1.25 - L	6H	9318520	6H	9318522	6H	9318523	6g	9318527	6g	9318528
M 10 × 1.5 - L	6H	9318600	6H	9318602	6H	9318603	6g	9318607	6g	9318608
M 10 × 1.25 - L	6H	9318610	6H	9318612	6H	9318613	6g	9318617	6g	9318618
M 12 × 1.75 - L	6H	9318700	6H	9318702	6H	9318703	6g	9318707	6g	9318708
M 12 × 1.5 - L	6H	9318710	6H	9318712	6H	9318713	6g	9318717	6g	9318718
M 12 × 1.25 - L	6H	9318720	6H	9318722	6H	9318723	6g	9318727	6g	9318728
M 14 × 2 - L	6H	9318820	6H	9318822	6H	9318823	6g	9318827	6g	9318828

※1：颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

上一页
FROM 尺寸 Size M1.4 ～ M14

公制螺纹(M) Metric screw threads

■ JIS (ISO) 左螺纹 [嵌合度：中] LH Thread (Fitting quality:Medium)

JIS(ISO等级)
JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 14 × 1.5 - L	6H	9318830	6H	9318832	6H	9318833	6g	9318837	6g	9318838
M 16 × 2 - L	6H	9318940	6H	9318942	6H	9318943	6g	9318947	6g	9318948
M 16 × 1.5 - L	6H	9318950	6H	9318952	6H	9318953	6g	9318957	6g	9318958
M 18 × 2.5 - L	6H	9319060	6H	9319062	6H	9319063	6g	9319067	6g	9319068
M 18 × 1.5 - L	6H	9319080	6H	9319082	6H	9319083	6g	9319087	6g	9319088
M 20 × 2.5 - L	6H	9319200	6H	9319202	6H	9319203	6g	9319207	6g	9319208
M 20 × 1.5 - L	6H	9319220	6H	9319222	6H	9319223	6g	9319227	6g	9319228
M 22 × 2.5 - L	6H	9319290	6H	9319292	6H	9319293	6g	9319297	6g	9319298
M 22 × 1.5 - L	6H	9319310	6H	9319312	6H	9319313	6g	9319317	6g	9319318
M 24 × 3 - L	6H	9319380	6H	9319382	6H	9319383	6g	9319387	6g	9319388
M 24 × 1.5 - L	6H	9319410	6H	9319412	6H	9319413	6g	9319417	6g	9319418
M 27 × 3 - L	6H	9319520	6H	9319522	6H	9319523	6g	9319527	6g	9319528
M 27 × 1.5 - L	6H	9319550	6H	9319552	6H	9319553	6g	9319557	6g	9319558
M 30 × 3.5 - L	6H	9319610	6H	9319612	6H	9319613	6g	9319617	6g	9319618
M 30 × 1.5 - L	6H	9319640	6H	9319642	6H	9319643	6g	9319647	6g	9319648

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为●（标准库存品）。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads
■ JIS (ISO) [嵌合度：精] (Fitting quality:Fine)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	5H	9310150	5H	9310152	5H	9310153	4h	9310157	4h	9310158
M 3 × 0.5	5H	9310280	5H	9310282	5H	9310283	4h	9310287	4h	9310288
M 3.5 × 0.6	5H	9310300	5H	9310302	5H	9310303	4h	9310307	4h	9310308
M 4 × 0.7	5H	9310350	5H	9310352	5H	9310353	4h	9310357	4h	9310358
M 5 × 0.8	5H	9310400	5H	9310402	5H	9310403	4h	9310407	4h	9310408
M 6 × 1	5H	9310460	5H	9310462	5H	9310463	4h	9310467	4h	9310468
M 8 × 1.25	5H	9310520	5H	9310522	5H	9310523	4h	9310527	4h	9310528
M 8 × 1	5H	9310530	5H	9310532	5H	9310533	4h	9310537	4h	9310538
M 10 × 1.5	5H	9310600	5H	9310602	5H	9310603	4h	9310607	4h	9310608
M 10 × 1.25	5H	9310610	5H	9310612	5H	9310613	4h	9310617	4h	9310618
M 12 × 1.75	5H	9310700	5H	9310702	5H	9310703	4h	9310707	4h	9310708
M 12 × 1.5	5H	9310710	5H	9310712	5H	9310713	4h	9310717	4h	9310718
M 12 × 1.25	5H	9310720	5H	9310722	5H	9310723	4h	9310727	4h	9310728
M 12 × 1	5H	9310730	5H	9310732	5H	9310733	4h	9310737	4h	9310738
M 14 × 2	5H	9310820	5H	9310822	5H	9310823	4h	9310827	4h	9310828
M 14 × 1.5	5H	9310830	5H	9310832	5H	9310833	4h	9310837	4h	9310838
M 14 × 1	5H	9310850	5H	9310852	5H	9310853	4h	9310857	4h	9310858
M 16 × 2	5H	9310940	5H	9310942	5H	9310943	4h	9310947	4h	9310948
M 16 × 1.5	5H	9310950	5H	9310952	5H	9310953	4h	9310957	4h	9310958

※1：颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M16 ~ M36 NEXT

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FROM 尺寸 Size M2 ~ M16

公制螺纹(M) Metric screw threads

■JIS (ISO) [嵌合度：精] (Fitting quality:Fine)

JIS(ISO等级)
JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 16 × 1	5H	9310960	5H	9310962	5H	9310963	4h	9310967	4h	9310968
M 18 × 2.5	5H	9311060	5H	9311062	5H	9311063	4h	9311067	4h	9311068
M 18 × 1.5	5H	9311080	5H	9311082	5H	9311083	4h	9311087	4h	9311088
M 20 × 2.5	5H	9311200	5H	9311202	5H	9311203	4h	9311207	4h	9311208
M 20 × 1.5	5H	9311220	5H	9311222	5H	9311223	4h	9311227	4h	9311228
M 22 × 2.5	5H	9311290	5H	9311292	5H	9311293	4h	9311297	4h	9311298
M 22 × 1.5	5H	9311310	5H	9311312	5H	9311313	4h	9311317	4h	9311318
M 24 × 3	5H	9311380	5H	9311382	5H	9311383	4h	9311387	4h	9311388
M 24 × 1.5	5H	9311410	5H	9311412	5H	9311413	4h	9311417	4h	9311418
M 27 × 3	5H	9311520	5H	9311522	5H	9311523	4h	9311527	4h	9311528
M 27 × 1.5	5H	9311550	5H	9311552	5H	9311553	4h	9311557	4h	9311558
M 30 × 3.5	5H	9311610	5H	9311612	5H	9311613	4h	9311617	4h	9311618
M 30 × 1.5	5H	9311640	5H	9311642	5H	9311643	4h	9311647	4h	9311648
M 33 × 3.5	5H	9311710	5H	9311712	5H	9311713	4h	9311717	4h	9311718
M 33 × 1.5	5H	9311740	5H	9311742	5H	9311743	4h	9311747	4h	9311748
M 36 × 4	5H	9311800	5H	9311802	5H	9311803	4h	9311807	4h	9311808
M 36 × 3	5H	9311810	5H	9311812	5H	9311813	4h	9311817	4h	9311818
M 36 × 2	5H	9311820	5H	9311822	5H	9311823	4h	9311827	4h	9311828
M 36 × 1.5	5H	9311830	5H	9311832	5H	9311833	4h	9311837	4h	9311838

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

植入式螺栓(JIS B 1173:2010)用的螺纹环规。
Thread ring gauge for studs (JIS B 1173:2010)

植入式螺栓用(STUD)
Stud Bolt

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	环规 Ring					
	GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 6 × 1	STUD	9346787	STUD	9346788	STUD	9346789
M 8 × 1.25	STUD	9346797	STUD	9346798	STUD	9346799
M 10 × 1.5	STUD	9346807	STUD	9346808	STUD	9346809
M 10 × 1.25	STUD	9346817	STUD	9346818	STUD	9346819
M 12 × 1.75	STUD	9346827	STUD	9346828	STUD	9346829
M 12 × 1.25	STUD	9346837	STUD	9346838	STUD	9346839
M 14 × 2	STUD	9346847	STUD	9346848	STUD	9346849
M 16 × 1.5	STUD	9346857	STUD	9346858	STUD	9346859

※JIS B 1173 : 2010

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

2级±0.03(旧JIS)
Class 2±0.03 (Previous JIS)

公制螺纹(M) Metric screw threads
■镀前用 Before plating

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	2 +0.03	36060	2 +0.03	36061	2 +0.03	36062	2 +0.03	36063	2 +0.03	36064	2 −0.03	36067	2 −0.03	36068	2 −0.03	36069
M 2.3 × 0.4	2 +0.03	36080	2 +0.03	36081	2 +0.03	36082	2 +0.03	36083	2 +0.03	36084	2 −0.03	36087	2 −0.03	36088	2 −0.03	36089
M 2.6 × 0.45	2 +0.03	36100	2 +0.03	36101	2 +0.03	36102	2 +0.03	36103	2 +0.03	36104	2 −0.03	36107	2 −0.03	36108	2 −0.03	36109
M 3 × 0.6	2 +0.03	36110	2 +0.03	36111	2 +0.03	36112	2 +0.03	36113	2 +0.03	36114	2 −0.03	36117	2 −0.03	36118	2 −0.03	36119
M 3 × 0.5	2 +0.03	36120	2 +0.03	36121	2 +0.03	36122	2 +0.03	36123	2 +0.03	36124	2 −0.03	36127	2 −0.03	36128	2 −0.03	36129
M 3.5 × 0.6	2 +0.03	36130	2 +0.03	36131	2 +0.03	36132	2 +0.03	36133	2 +0.03	36134	2 −0.03	36137	2 −0.03	36138	2 −0.03	36139
M 4 × 0.75	2 +0.03	36140	2 +0.03	36141	2 +0.03	36142	2 +0.03	36143	2 +0.03	36144	2 −0.03	36147	2 −0.03	36148	2 −0.03	36149
M 4 × 0.7	2 +0.03	36150	2 +0.03	36151	2 +0.03	36152	2 +0.03	36153	2 +0.03	36154	2 −0.03	36157	2 −0.03	36158	2 −0.03	36159
M 5 × 0.9	2 +0.03	36170	2 +0.03	36171	2 +0.03	36172	2 +0.03	36173	2 +0.03	36174	2 −0.03	36177	2 −0.03	36178	2 −0.03	36179
M 5 × 0.8	2 +0.03	36180	2 +0.03	36181	2 +0.03	36182	2 +0.03	36183	2 +0.03	36184	2 −0.03	36187	2 −0.03	36188	2 −0.03	36189
M 6 × 1	2 +0.03	36200	2 +0.03	36201	2 +0.03	36202	2 +0.03	36203	2 +0.03	36204	2 −0.03	36207	2 −0.03	36208	2 −0.03	36209
M 8 × 1.25	2 +0.03	36220	2 +0.03	36221	2 +0.03	36222	2 +0.03	36223	2 +0.03	36224	2 −0.03	36227	2 −0.03	36228	2 −0.03	36229
M10 × 1.5	2 +0.03	36240	2 +0.03	36241	2 +0.03	36242	2 +0.03	36243	2 +0.03	36244	2 −0.03	36247	2 −0.03	36248	2 −0.03	36249
M10 × 1.25	2 +0.03	36250	2 +0.03	36251	2 +0.03	36252	2 +0.03	36253	2 +0.03	36254	2 −0.03	36257	2 −0.03	36258	2 −0.03	36259
M12 × 1.75	2 +0.03	36270	2 +0.03	36271	2 +0.03	36272	2 +0.03	36273	2 +0.03	36274	2 −0.03	36277	2 −0.03	36278	2 −0.03	36279

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M12 ~ M20 NEXT

螺纹极限量规(LG)
Limit gauges for screw threads

上一页

FROM 尺寸 Size M2 ~ M12

公制螺纹(M) Metric screw threads

■镀前用 Before plating

2级±0.03(旧JIS)
Class 2±0.03 (Previous JIS)

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M12 × 1.5	2 +0.03	36280	2 +0.03	36281	2 +0.03	36282	2 +0.03	36283	2 +0.03	36284	2 −0.03	36287	2 −0.03	36288	2 −0.03	36289
M12 × 1.25	2 +0.03	36290	2 +0.03	36291	2 +0.03	36292	2 +0.03	36293	2 +0.03	36294	2 −0.03	36297	2 −0.03	36298	2 −0.03	36299
M14 × 2	2 +0.03	9325690	—	—	2 +0.03	9325692	2 +0.03	9325693	—	—	2 −0.03	9325697	2 −0.03	9325698	—	—
M14 × 1.5	2 +0.03	9325700	—	—	2 +0.03	9325702	2 +0.03	9325703	—	—	2 −0.03	9325707	2 −0.03	9325708	—	—
M16 × 2	2 +0.03	9325810	—	—	2 +0.03	9325812	2 +0.03	9325813	—	—	2 −0.03	9325817	2 −0.03	9325818	—	—
M16 × 1.5	2 +0.03	9325820	—	—	2 +0.03	9325822	2 +0.03	9325823	—	—	2 −0.03	9325827	2 −0.03	9325828	—	—
M18 × 2.5	2 +0.03	9325930	—	—	2 +0.03	9325932	2 +0.03	9325933	—	—	2 −0.03	9325937	2 −0.03	9325938	—	—
M18 × 1.5	2 +0.03	9325950	—	—	2 +0.03	9325952	2 +0.03	9325953	—	—	2 −0.03	9325957	2 −0.03	9325958	—	—
M20 × 2.5	2 +0.03	9326070	—	—	2 +0.03	9326072	2 +0.03	9326073	—	—	2 −0.03	9326077	2 −0.03	9326078	—	—
M20 × 1.5	2 +0.03	9326090	—	—	2 +0.03	9326092	2 +0.03	9326093	—	—	2 −0.03	9326097	2 −0.03	9326098	—	—

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

公制螺纹(M) Metric screw threads
■ JIS (ISO) 镀前用【嵌合度：中】Before plating (Fitting quality:Medium)

6H级+0.03 JIS (ISO等级)
Class 6H+0.03 JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug					
	GPNP		GP		NP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	6H+0.03	9312150	6H+0.03	9312152	6H+0.03	9312153
M 3 × 0.5	6H+0.03	9312280	6H+0.03	9312282	6H+0.03	9312283
M 3.5 × 0.6	6H+0.03	9312300	6H+0.03	9312302	6H+0.03	9312303
M 4 × 0.7	6H+0.03	9312350	6H+0.03	9312352	6H+0.03	9312353
M 5 × 0.8	6H+0.03	9312400	6H+0.03	9312402	6H+0.03	9312403
M 6 × 1	6H+0.03	9312460	6H+0.03	9312462	6H+0.03	9312463
M 8 × 1.25	6H+0.03	9312520	6H+0.03	9312522	6H+0.03	9312523
M 10 × 1.5	6H+0.03	9312600	6H+0.03	9312602	6H+0.03	9312603
M 10 × 1.25	6H+0.03	9312610	6H+0.03	9312612	6H+0.03	9312613
M 12 × 1.75	6H+0.03	9312700	6H+0.03	9312702	6H+0.03	9312703
M 12 × 1.5	6H+0.03	9312710	6H+0.03	9312712	6H+0.03	9312713
M 12 × 1.25	6H+0.03	9312720	6H+0.03	9312722	6H+0.03	9312723
M 14 × 2	6H+0.03	9312820	6H+0.03	9312822	6H+0.03	9312823
M 14 × 1.5	6H+0.03	9312830	6H+0.03	9312832	6H+0.03	9312833
M 16 × 2	6H+0.03	9312940	6H+0.03	9312942	6H+0.03	9312943
M 16 × 1.5	6H+0.03	9312950	6H+0.03	9312952	6H+0.03	9312953
M 18 × 2.5	6H+0.03	9313060	6H+0.03	9313062	6H+0.03	9313063
M 18 × 1.5	6H+0.03	9313080	6H+0.03	9313082	6H+0.03	9313083
M 20 × 2.5	6H+0.03	9313200	6H+0.03	9313202	6H+0.03	9313203
M 20 × 1.5	6H+0.03	9313220	6H+0.03	9313222	6H+0.03	9313223

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)

Limit gauges for screw threads

2B级•2A级 JIS(UNC,UNF)※
Class 2B•2A JIS(UNC,UNF)※

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
No.0 - 80 UNF	2B	34010	2B	34011	2B	34012	2B	34013	2B	34014	2A	34017	2A	34018	2A	34019
No.1 - 64 UNC	2B	34020	2B	34021	2B	34022	2B	34023	2B	34024	2A	34027	2A	34028	2A	34029
No.1 - 72 UNF	2B	34030	2B	34031	2B	34032	2B	34033	2B	34034	2A	34037	2A	34038	2A	34039
No.2 - 56 UNC	2B	34040	2B	34041	2B	34042	2B	34043	2B	34044	2A	34047	2A	34048	2A	34049
No.2 - 64 UNF	2B	34050	2B	34051	2B	34052	2B	34053	2B	34054	2A	34057	2A	34058	2A	34059
No.3 - 48 UNC	2B	34060	2B	34061	2B	34062	2B	34063	2B	34064	2A	34067	2A	34068	2A	34069
No.3 - 56 UNF	2B	34070	2B	34071	2B	34072	2B	34073	2B	34074	2A	34077	2A	34078	2A	34079
No.4 - 40 UNC	2B	34080	2B	34081	2B	34082	2B	34083	2B	34084	2A	34087	2A	34088	2A	34089
No.4 - 48 UNF	2B	34090	2B	34091	2B	34092	2B	34093	2B	34094	2A	34097	2A	34098	2A	34099
No.5 - 40 UNC	2B	34110	2B	34111	2B	34112	2B	34113	2B	34114	2A	34117	2A	34118	2A	34119
No.5 - 44 UNF	2B	34120	2B	34121	2B	34122	2B	34123	2B	34124	2A	34127	2A	34128	2A	34129
No.6 - 32 UNC	2B	34130	2B	34131	2B	34132	2B	34133	2B	34134	2A	34137	2A	34138	2A	34139
No.6 - 40 UNF	2B	34140	2B	34141	2B	34142	2B	34143	2B	34144	2A	34147	2A	34148	2A	34149
No.8 - 32 UNC	2B	34150	2B	34151	2B	34152	2B	34153	2B	34154	2A	34157	2A	34158	2A	34159
No.8 - 36 UNF	2B	34160	2B	34161	2B	34162	2B	34163	2B	34164	2A	34167	2A	34168	2A	34169
No.10- 24 UNC	2B	34170	2B	34171	2B	34172	2B	34173	2B	34174	2A	34177	2A	34178	2A	34179
No.10- 32 UNF	2B	34180	2B	34181	2B	34182	2B	34183	2B	34184	2A	34187	2A	34188	2A	34189
No.12- 24 UNC	2B	34190	2B	34191	2B	34192	2B	34193	2B	34194	2A	34197	2A	34198	2A	34199
No.12- 28 UNF	2B	34200	2B	34201	2B	34202	2B	34203	2B	34204	2A	34207	2A	34208	2A	34209

※UNEF,UNS,UN适用于"ANSI/ASME B1.2"。
※UNEF, UNS, UN are manufactured in correspondence to " ANSI / ASME B1.2 ".

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

钻头 DRILLS
丝锥 TAPS
量规 GAUGES
GAUGES STOCK LIST 库存一览表
板牙 ROUND DIES
滚造工具 ROLLING DIES
各种产品 OTHER PRODUCTS
索引 INDEX
LIMIT GAUGES FOR SCREW THREADS 螺纹极限量规
PARALLEL PIPE THREADS 管用平行螺纹
LIMIT PLUG GAUGE FOR MINOR DIAMETER 内径塞规
LIMIT GAUGES FOR INSERT SCREW THREADS 螺纹极限量规
STANDARD SCREW THREAD GAUGES 标准螺纹量规
GAUGES FOR TAPER PIPE THREADS 锥管螺纹量规
PLAIN LIMIT GAUGES 极限圆柱量规
MASTER RING GAUGES 标准量规
WEAR CHECK PLUG FOR GO SCREW RING GAUGES 磨耗点螺纹检螺纹塞规
POWDERHSS LIMIT GAUGES FOR SCREW THREADS 粉末高速钢螺纹极限量规
CARBIDE LIMIT GAUGES FOR SCREW THREADS 硬质合金螺纹极限量规

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FROM 尺寸 Size No.0 ~ No.12

2B级•2A级 JIS(UNC,UNF)※
Class 2B•2A JIS(UNC,UNF)※

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
1/4 -20 UNC	2B	34220	2B	34221	2B	34222	2B	34223	2B	34224	2A	34227	2A	34228	2A	34229
1/4 -28 UNF	2B	34230	2B	34231	2B	34232	2B	34233	2B	34234	2A	34237	2A	34238	2A	34239
1/4 -32 UNEF	2B	34240	2B	34241	2B	34242	2B	34243	2B	34244	2A	34247	2A	34248	2A	34249
5/16 -18 UNC	2B	34250	2B	34251	2B	34252	2B	34253	2B	34254	2A	34257	2A	34258	2A	34259
5/16 -24 UNF	2B	34260	2B	34261	2B	34262	2B	34263	2B	34264	2A	34267	2A	34268	2A	34269
5/16 -32 UNEF	2B	34270	2B	34271	2B	34272	2B	34273	2B	34274	2A	34277	2A	34278	2A	34279
3/8 -16 UNC	2B	34280	2B	34281	2B	34282	2B	34283	2B	34284	2A	34287	2A	34288	2A	34289
3/8 -24 UNF	2B	34290	2B	34291	2B	34292	2B	34293	2B	34294	2A	34297	2A	34298	2A	34299
3/8 -32 UNEF	2B	34300	2B	34301	2B	34302	2B	34303	2B	34304	2A	34307	2A	34308	2A	34309
7/16 -14 UNC	2B	34310	2B	34311	2B	34312	2B	34313	2B	34314	2A	34317	2A	34318	2A	34319
7/16 -20 UNF	2B	34320	2B	34321	2B	34322	2B	34323	2B	34324	2A	34327	2A	34328	2A	34329
1/2 -13 UNC	2B	34340	2B	34341	2B	34342	2B	34343	2B	34344	2A	34347	2A	34348	2A	34349
1/2 -20 UNF	2B	34360	2B	34361	2B	34362	2B	34363	2B	34364	2A	34367	2A	34368	2A	34369
1/2 -32 UN	2B	9330600	2B	9330601	2B	9330602	2B	9330603	2B	9330604	2A	9330607	2A	9330608	2A	9330609
9/16 -12 UNC	2B	34390	2B	34391	2B	34392	2B	34393	2B	34394	2A	34397	2A	34398	2A	34399
9/16 -18 UNF	2B	34400	2B	34401	2B	34402	2B	34403	2B	34404	2A	34407	2A	34408	2A	34409
5/8 -11 UNC	2B	34420	2B	34421	2B	34422	2B	34423	2B	34424	2A	34427	2A	34428	2A	34429
5/8 -18 UNF	2B	34430	2B	34431	2B	34432	2B	34433	2B	34434	2A	34437	2A	34438	2A	34439
5/8 -24 UNEF	2B	34440	2B	34441	2B	34442	2B	34443	2B	34444	2A	34447	2A	34448	2A	34449

※UNEF,UNS,UN适用于"ANSI/ASME B1.2"。
※UNEF, UNS, UN are manufactured in correspondence to " ANSI / ASME B1.2 ".

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size 3/4 ~ 1 3/8 NEXT

螺纹极限量规(LG)

Limit gauges for screw threads

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FROM 尺寸 Size 1/4 ～ 5/8

2B级•2A级 JIS(UNC,UNF)※
Class 2B•2A JIS(UNC,UNF)※

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
3/4 -10 UNC	2B	34450	2B	34451	2B	34452	2B	34453	2B	34454	2A	34457	2A	34458	2A	34459
3/4 -16 UNF	2B	34460	2B	34461	2B	34462	2B	34463	2B	34464	2A	34467	2A	34468	2A	34469
7/8 - 9 UNC	2B	34480	2B	34481	2B	34482	2B	34483	2B	34484	2A	34487	2A	34488	2A	34489
7/8 -14 UNF	2B	34490	2B	34491	2B	34492	2B	34493	2B	34494	2A	34497	2A	34498	2A	34499
1 - 8 UNC	2B	34510	2B	34511	2B	34512	2B	34513	2B	34514	2A	34517	2A	34518	2A	34519
1 -12 UNF	2B	34520	2B	34521	2B	34522	2B	34523	2B	34524	2A	34527	2A	34528	2A	34529
1 -14 UNS	2B	34530	2B	34531	2B	34532	2B	34533	2B	34534	2A	34537	2A	34538	2A	34539
1 1/16-12 UN	2B	9330660	2B	9330661	2B	9330662	2B	9330663	2B	9330664	2A	9330667	2A	9330668	2A	9330669
1 1/8 - 7 UNC	2B	34550	2B	34551	2B	34552	2B	34553	2B	34554	2A	34557	2A	34558	2A	34559
1 1/8 - 8 UN	2B	9330680	2B	9330681	2B	9330682	2B	9330683	2B	9330684	2A	9330687	2A	9330688	2A	9330689
1 1/8 -12 UNF	2B	34560	2B	34561	2B	34562	2B	34563	2B	34564	2A	34567	2A	34568	2A	34569
1 3/16-12 UN	2B	9330700	2B	9330701	2B	9330702	2B	9330703	2B	9330704	2A	9330707	2A	9330708	2A	9330709
1 1/4 - 7 UNC	2B	34580	2B	34581	2B	34582	2B	34583	2B	34584	2A	34587	2A	34588	2A	34589
1 1/4 - 8 UN	2B	9330710	2B	9330711	2B	9330712	2B	9330713	2B	9330714	2A	9330717	2A	9330718	2A	9330719
1 1/4 -12 UNF	2B	34590	2B	34591	2B	34592	2B	34593	2B	34594	2A	34597	2A	34598	2A	34599
1 5/16-12 UN	2B	9330720	2B	9330721	2B	9330722	2B	9330723	2B	9330724	2A	9330727	2A	9330728	2A	9330729
1 3/8 - 6 UNC	2B	34620	2B	34621	2B	34622	2B	34623	2B	34624	2A	34627	2A	34628	2A	34629
1 3/8 - 8 UN	2B	9330730	2B	9330731	2B	9330732	2B	9330733	2B	9330734	2A	9330737	2A	9330738	2A	9330739
1 3/8 -12 UNF	2B	34630	2B	34631	2B	34632	2B	34633	2B	34634	2A	34637	2A	34638	2A	34639

※UNEF,UNS,UN适用于"ANSI/ASME B1.2"。
※UNEF, UNS, UN are manufactured in correspondence to " ANSI / ASME B1.2 ".

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size 1½ ～4¾ NEXT

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FROM 尺寸 Size ¾ ～ 1⅜

2B级•2A级 JIS(UNC,UNF)※
Class 2B•2A JIS(UNC,UNF)※

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
1½ - 6 UNC	2B	34650	2B	34651	2B	34652	2B	34653	2B	34654	2A	34657	2A	34658	2A	34659
1½ - 8 UN	2B	9330750	2B	9330751	2B	9330752	2B	9330753	2B	9330754	2A	9330757	2A	9330758	2A	9330759
1½ -12 UNF	2B	34660	2B	34661	2B	34662	2B	34663	2B	34664	2A	34667	2A	34668	2A	34669
1⅝ - 8 UN	2B	9330770	2B	9330771	2B	9330772	2B	9330773	2B	9330774	2A	9330777	2A	9330778	2A	9330779
1⅞ - 8 UN	2B	9330790	2B	9330791	2B	9330792	2B	9330793	2B	9330794	2A	9330797	2A	9330798	2A	9330799
1¾ - 5 UNC	2B	34690	2B	34691	2B	34692	2B	34693	2B	34694	2A	34697	2A	34698	2A	34699
1¾ - 8 UN	2B	9330780	2B	9330781	2B	9330782	2B	9330783	2B	9330784	2A	9330787	2A	9330788	2A	9330789
2 -4 -½ UNC	2B	34730	2B	34731	2B	34732	2B	34733	2B	34734	2A	34737	2A	34738	2A	34739
2 - 8 UN	2B	9330800	2B	9330801	2B	9330802	2B	9330803	2B	9330804	2A	9330807	2A	9330808	2A	9330809
2½ - 8 UN	—	—	—	—	2B	9330902	2B	9330903	2B	9330904	2A	9330907	2A	9330908	2A	9330909
3 - 8 UN	—	—	—	—	2B	9330952	2B	9330953	2B	9330954	2A	9330957	2A	9330958	2A	9330959
3½ - 8 UN	—	—	—	—	2B	9331052	2B	9331053	2B	9331054	2A	9331057	2A	9331058	2A	9331059
4 - 8 UN	—	—	—	—	2B	9331102	2B	9331103	2B	9331104	2A	9331107	2A	9331108	2A	9331109
4½ - 8 UN	—	—	—	—	2B	9331202	2B	9331203	2B	9331204	2A	9331207	2A	9331208	2A	9331209
4¾ - 8 UN	—	—	—	—	2B	9331232	2B	9331233	2B	9331234	2A	9331237	2A	9331238	2A	9331239

※UNEF,UNS,UN适用于"ANSI/ASME B1.2"。
※UNEF, UNS, UN are manufactured in correspondence to " ANSI / ASME B1.2 ".

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)

Limit gauges for screw threads

3B级•3A级(JIS)
Class 3B•3A(JIS)

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
No. 2 - 56 UNC	3B	9334350	3B	9334351	3B	9334352	3B	9334353	3B	9334354	3A	9334357	3A	9334358	3A	9334359
No. 3 - 48 UNC	3B	9334370	3B	9334371	3B	9334372	3B	9334373	3B	9334374	3A	9334377	3A	9334378	3A	9334379
No. 4 - 40 UNC	3B	9334390	3B	9334391	3B	9334392	3B	9334393	3B	9334394	3A	9334397	3A	9334398	3A	9334399
No. 5 - 40 UNC	3B	9334410	3B	9334411	3B	9334412	3B	9334413	3B	9334414	3A	9334417	3A	9334418	3A	9334419
No. 6 - 32 UNC	3B	34810	3B	34811	3B	34812	3B	34813	3B	34814	3A	34817	3A	34818	3A	34819
No. 6 - 40 UNF	3B	34820	3B	34821	3B	34822	3B	34823	3B	34824	3A	34827	3A	34828	3A	34829
No. 8 - 32 UNC	3B	34830	3B	34831	3B	34832	3B	34833	3B	34834	3A	34837	3A	34838	3A	34839
No. 8 - 36 UNF	3B	34840	3B	34841	3B	34842	3B	34843	3B	34844	3A	34847	3A	34848	3A	34849
No.10 - 24 UNC	3B	34850	3B	34851	3B	34852	3B	34853	3B	34854	3A	34857	3A	34858	3A	34859
No.10 - 32 UNF	3B	34860	3B	34861	3B	34862	3B	34863	3B	34864	3A	34867	3A	34868	3A	34869
No.12 - 24 UNC	3B	34870	3B	34871	3B	34872	3B	34873	3B	34874	3A	34877	3A	34878	3A	34879
No.12 - 28 UNF	3B	34880	3B	34881	3B	34882	3B	34883	3B	34884	3A	34887	3A	34888	3A	34889
1/4 - 20 UNC	3B	34900	3B	34901	3B	34902	3B	34903	3B	34904	3A	34907	3A	34908	3A	34909
1/4 - 28 UNF	3B	34910	3B	34911	3B	34912	3B	34913	3B	34914	3A	34917	3A	34918	3A	34919
5/16 - 18 UNC	3B	34930	3B	34931	3B	34932	3B	34933	3B	34934	3A	34937	3A	34938	3A	34939
5/16 - 24 UNF	3B	34940	3B	34941	3B	34942	3B	34943	3B	34944	3A	34947	3A	34948	3A	34949
3/8 - 16 UNC	3B	34960	3B	34961	3B	34962	3B	34963	3B	34964	3A	34967	3A	34968	3A	34969
3/8 - 24 UNF	3B	34980	3B	34981	3B	34982	3B	34983	3B	34984	3A	34987	3A	34988	3A	34989

库存分类全部为● (标准库存品)。

Stock are categolized in section ● (Standard stock item).

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FROM 尺寸 Size No.2 ~ 3/8

3B级·3A级 (JIS)
Class 3B·3A(JIS)

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
7/16 - 14 UNC	3B	35000	3B	35001	3B	35002	3B	35003	3B	35004	3A	35007	3A	35008	3A	35009
7/16 - 20 UNF	3B	35010	3B	35011	3B	35012	3B	35013	3B	35014	3A	35017	3A	35018	3A	35019
1/2 - 13 UNC	3B	35030	3B	35031	3B	35032	3B	35033	3B	35034	3A	35037	3A	35038	3A	35039
1/2 - 20 UNF	3B	35050	3B	35051	3B	35052	3B	35053	3B	35054	3A	35057	3A	35058	3A	35059
9/16 - 12 UNC	3B	35080	3B	35081	3B	35082	3B	35083	3B	35084	3A	35087	3A	35088	3A	35089
9/16 - 18 UNF	3B	35090	3B	35091	3B	35092	3B	35093	3B	35094	3A	35097	3A	35098	3A	35099
5/8 - 11 UNC	3B	35110	3B	35111	3B	35112	3B	35113	3B	35114	3A	35117	3A	35118	3A	35119
5/8 - 18 UNF	3B	35120	3B	35121	3B	35122	3B	35123	3B	35124	3A	35127	3A	35128	3A	35129
3/4 - 10 UNC	3B	35140	3B	35141	3B	35142	3B	35143	3B	35144	3A	35147	3A	35148	3A	35149
3/4 - 16 UNF	3B	35150	3B	35151	3B	35152	3B	35153	3B	35154	3A	35157	3A	35158	3A	35159
7/8 - 9 UNC	3B	35170	3B	35171	3B	35172	3B	35173	3B	35174	3A	35177	3A	35178	3A	35179
7/8 - 14 UNF	3B	35180	3B	35181	3B	35182	3B	35183	3B	35184	3A	35187	3A	35188	3A	35189
1 - 8 UNC	3B	35200	3B	35201	3B	35202	3B	35203	3B	35204	3A	35207	3A	35208	3A	35209
1 - 12 UNF	3B	35210	3B	35211	3B	35212	3B	35213	3B	35214	3A	35217	3A	35218	3A	35219

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

符合ANSI/ASME B 1.2标准的UNJ外螺纹的环规。
量规方式不是ANSI标准的调整式量规方式，而是符合JIS标准的固定式量规方式。
UNJ thread ring gauge in compliant with ANSI/ASME B1.2.
The gauge system is not the adjustable gauge system of the ANSI standard, but the fixed gauge system of the JIS standard.

3A级
Class 3A

美制螺纹(UNJ) Unified inch screw threads (UNJ Thread form)

螺纹尺寸 Thread Size	环规 Ring					
	GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
0.1380 - 32 UNJC	3A	9345057	3A	9345058	3A	9345059
0.1640 - 32 UNJC	3A	9345067	3A	9345068	3A	9345069
0.1900 - 32 UNJF	3A	9345077	3A	9345078	3A	9345079
0.2160 - 28 UNJF	3A	9345087	3A	9345088	3A	9345089
0.2500 - 28 UNJF	3A	9345097	3A	9345098	3A	9345099
0.3125 - 18 UNJC	3A	9345107	3A	9345108	3A	9345109
0.3125 - 24 UNJF	3A	9345117	3A	9345118	3A	9345119
0.3750 - 24 UNJF	3A	9345127	3A	9345128	3A	9345129
0.4375 - 20 UNJF	3A	9345137	3A	9345138	3A	9345139
0.5000 - 20 UNJF	3A	9345147	3A	9345148	3A	9345149
0.5625 - 18 UNJF	3A	9345157	3A	9345158	3A	9345159
0.6250 - 18 UNJF	3A	9345167	3A	9345168	3A	9345169
0.7500 - 16 UNJF	3A	9345177	3A	9345178	3A	9345179

※UNJ适用于"ANSI/ASME B1.2"。
※ UNJ is manufactured in correspondence to " ANSI / ASME B1.2 " .

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

量规方式有符合 JIS 标准的检查用和工作用。并非ANSI标准的量规方式。
There are two types of gauges in compliance with JIS standards, one for inspection and one for working. Not ANSI standard gauge system.

螺纹极限量规(LG)
Limit gauges for screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

惠氏螺纹(W) Whitworth screw threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
W 1/16 -60	2	35410	2	35411	2	35412	2	35413	2	35414	2	35417	2	35418	2	35419
W 1/8 -40	2	35420	2	35421	2	35422	2	35423	2	35424	2	35427	2	35428	2	35429
W 3/16 -24	2	35430	2	35431	2	35432	2	35433	2	35434	2	35437	2	35438	2	35439
W 1/4 -20	2	35440	2	35441	2	35442	2	35443	2	35444	2	35447	2	35448	2	35449
W 5/16 -18	2	35450	2	35451	2	35452	2	35453	2	35454	2	35457	2	35458	2	35459
W 3/8 -16	2	35460	2	35461	2	35462	2	35463	2	35464	2	35467	2	35468	2	35469
W 7/16 -14	2	35470	2	35471	2	35472	2	35473	2	35474	2	35477	2	35478	2	35479
W 1/2 -12	2	35480	2	35481	2	35482	2	35483	2	35484	2	35487	2	35488	2	35489
W 9/16 -12	2	35490	2	35491	2	35492	2	35493	2	35494	2	35497	2	35498	2	35499
W 5/8 -11	2	35500	2	35501	2	35502	2	35503	2	35504	2	35507	2	35508	2	35509
W 3/4 -10	2	35510	2	35511	2	35512	2	35513	2	35514	2	35517	2	35518	2	35519
W 7/8 - 9	2	35520	2	35521	2	35522	2	35523	2	35524	2	35527	2	35528	2	35529
W1 - 8	2	35530	2	35531	2	35532	2	35533	2	35534	2	35537	2	35538	2	35539
W1 1/8 - 7	2	35540	2	35541	2	35542	2	35543	2	35544	2	35547	2	35548	2	35549
W1 1/4 - 7	2	35550	2	35551	2	35552	2	35553	2	35554	2	35557	2	35558	2	35559
W1 3/8 - 6	2	35560	2	35561	2	35562	2	35563	2	35564	2	35567	2	35568	2	35569
W1 1/2 - 6	2	35570	2	35571	2	35572	2	35573	2	35574	2	35577	2	35578	2	35579
W1 5/8 - 5	2	35580	2	35581	2	35582	2	35583	2	35584	2	35587	2	35588	2	35589
W1 3/4 - 5	2	35590	2	35591	2	35592	2	35593	2	35594	2	35597	2	35598	2	35599
W1 7/8 - 4-1/2	2	35600	2	35601	2	35602	2	35603	2	35604	2	35607	2	35608	2	35609
W2 - 4-1/2	2	35610	2	35611	2	35612	2	35613	2	35614	2	35617	2	35618	2	35619

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

2级 (旧JIS)
Class 2 (Previous JIS)

惠氏螺纹(W) Whitworth screw threads
■左螺纹 LH Threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
W1/4 - 20 - L	2	9330050	2	9330051	2	9330052	2	9330053	2	9330054	2	9330057	2	9330058	2	9330059
W5/16 - 18 - L	2	9330060	2	9330061	2	9330062	2	9330063	2	9330064	2	9330067	2	9330068	2	9330069
W3/8 - 16 - L	2	9330070	2	9330071	2	9330072	2	9330073	2	9330074	2	9330077	2	9330078	2	9330079
W1/2 - 12 - L	2	9330090	2	9330091	2	9330092	2	9330093	2	9330094	2	9330097	2	9330098	2	9330099
W5/8 - 11 - L	2	9330110	2	9330111	2	9330112	2	9330113	2	9330114	2	9330117	2	9330118	2	9330119
W3/4 - 10 - L	2	9330120	2	9330121	2	9330122	2	9330123	2	9330124	2	9330127	2	9330128	2	9330129
W7/8 - 9 - L	2	9330130	2	9330131	2	9330132	2	9330133	2	9330134	2	9330137	2	9330138	2	9330139
W1 - 8 - L	2	9330140	2	9330141	2	9330142	2	9330143	2	9330144	2	9330147	2	9330148	2	9330149

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹极限量规(LG)
Limit gauges for screw threads

2级(旧JIS)
Class 2 (Previous JIS)

缝纫机用(SM)螺纹 Screw threads for Sewing machines

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
SM 3/32 - 56	2	38920	2	38921	2	38922	2	38923	2	38924	2	38927	2	38928	2	38929
SM 1/8 - 40	2	38940	2	38941	2	38942	2	38943	2	38944	2	38947	2	38948	2	38949
SM 1/8 - 44	2	38950	2	38951	2	38952	2	38953	2	38954	2	38957	2	38958	2	38959
SM 9/64 - 40	2	38970	2	38971	2	38972	2	38973	2	38974	2	38977	2	38978	2	38979
SM11/64 - 40	2	38990	2	38991	2	38992	2	38993	2	38994	2	38997	2	38998	2	38999
SM 3/16 - 28	2	39010	2	39011	2	39012	2	39013	2	39014	2	39017	2	39018	2	39019
SM 3/16 - 32	2	39020	2	39021	2	39022	2	39023	2	39024	2	39027	2	39028	2	39029
SM15/64 - 28	2	39060	2	39061	2	39062	2	39063	2	39064	2	39067	2	39068	2	39069
SM 1/4 - 40	2	39090	2	39091	2	39092	2	39093	2	39094	2	39097	2	39098	2	39099

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

TiN涂层螺纹极限量规(TIN-LG)

TiN Coated Thread Limit Gauge

螺纹部表面采用TiN涂层(金色)，可根据涂层的附着情况，目视判断磨损程度(标准)。
另外，由于高硬度的TiN涂层，螺纹量规可以实现更长寿命。

The thread surface is coated with TiN (gold color), and wear on the gauge can be visually determined based on the adhesion of the coating.
In addition, long tool life of the thread gauge is achieved by the high hardness TiN coating.

注：仅在易磨损的通规端采用TiN涂层。

TiN coating is applied only to the go side of the gauge as wear tends to progress.

2级(旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug					
	GPIP		GPWP		GP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	2	9344240	2	9344241	2	9344242
M 2.5 × 0.45	2	9344250	2	9344251	2	9344252
M 2.6 × 0.45	2	9344260	2	9344261	2	9344262
M 3 × 0.5	2	9344270	2	9344271	2	9344272
M 4 × 0.7	2	9344280	2	9344281	2	9344282
M 5 × 0.8	2	9344290	2	9344291	2	9344292
M 6 × 1	2	9344300	2	9344301	2	9344302
M 8 × 1.25	2	9344310	2	9344311	2	9344312
M 10 × 1.5	2	9344320	2	9344321	2	9344322
M 10 × 1.25	2	9344330	2	9344331	2	9344332
M 12 × 1.75	2	9344340	2	9344341	2	9344342

※1：颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

TiN涂层螺纹极限量规(TIN-LG)
TiN Coated Thread Limit Gauge

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug			
	GPNP		GP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	6H	9344350	6H	9344352
M 2.5 × 0.45	6H	9344360	6H	9344362
M 2.6 × 0.45	6H	9344370	6H	9344372
M 3 × 0.5	6H	9344380	6H	9344382
M 4 × 0.7	6H	9344390	6H	9344392
M 5 × 0.8	6H	9344400	6H	9344402
M 6 × 1	6H	9344410	6H	9344412
M 8 × 1.25	6H	9344420	6H	9344422
M 10 × 1.5	6H	9344430	6H	9344432
M 10 × 1.25	6H	9344440	6H	9344442
M 12 × 1.75	6H	9344450	6H	9344452

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

TiN涂层螺纹极限量规(TIN-LG)

TiN Coated Thread Limit Gauge

螺纹部表面采用TiN涂层(金色),可根据涂层的附着情况,目视判断磨损程度(标准)。
另外,由于高硬度的TiN涂层,螺纹量规可以实现更长寿命。
符合ANSI/ASME B 1.2标准的飞机用UNJ螺纹用的量规。

The thread surface is coated with TiN (gold color), and wear on the gauge can be visually determined based on the adhesion of the coating. In addition, long tool life of the thread gauge is achieved by the high hardness TiN coating.
UNJ thread gauge in compliant with ANSI/ASME B1.2 for aircraft.

注:仅在易磨损的通规端采用TiN涂层。
TiN coating is applied only to the go side of the gauge as wear tends to progress.

3B级
Class 3B

美制螺纹(UNJ) Unified inch screw threads (UNJ Thread form)

螺纹尺寸 Thread Size	塞规 Plug					
	GPIP		GPWP		GP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
0.1380 - 32 UNJC	3B	9344930	3B	9344931	3B	9344932
0.1640 - 32 UNJC	3B	9344940	3B	9344941	3B	9344942
0.1900 - 32 UNJF	3B	9344950	3B	9344951	3B	9344952
0.2160 - 28 UNJF	3B	9344960	3B	9344961	3B	9344962
0.2500 - 28 UNJF	3B	9344970	3B	9344971	3B	9344972
0.3125 - 18 UNJC	3B	9344980	3B	9344981	3B	9344982
0.3125 - 24 UNJF	3B	9344990	3B	9344991	3B	9344992
0.3750 - 24 UNJF	3B	9345000	3B	9345001	3B	9345002
0.4375 - 20 UNJF	3B	9345010	3B	9345011	3B	9345012
0.5000 - 20 UNJF	3B	9345020	3B	9345021	3B	9345022
0.5625 - 18 UNJF	3B	9345030	3B	9345031	3B	9345032
0.6250 - 18 UNJF	3B	9345040	3B	9345041	3B	9345042
0.7500 - 16 UNJF	3B	9345050	3B	9345051	3B	9345052

※UNJ适用于"ANSI/ASME B1.2"。
※UNJ is manufactured in correspondence to " ANSI / ASME B1.2 " .

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

量规方式有符合 JIS 标准的检查用和工作用。并非ANSI 标准的量规方式。
There are two types of gauges in compliance with JIS standards, one for inspection and one for working. Not ANSI standard gauge system.

DLC涂层螺纹极限量规(DLC-LG)

DLC Coated Thread Limit Gauge

螺纹部表面采用润滑性优良的DLC涂层，有效防止溶着。
另外，由于高硬度的DLC涂层，螺纹量规可以实现更长寿命。对非铁金属(铝、铜、树脂等)的材料特别有效。

DLC coating with excellent lubricity is applied to the thread surface, which is effective in preventing welding. In addition, the long life of the thread gauge is achieved by the high hardness DLC coating. It is especially effective for non-ferrous metals (aluminum, copper, resin, etc.).

注：仅在易溶着的通规端采用DLC涂层。

DLC coating is applied only to the go side of the gauge, which is easy to weld.

2级(旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug					
	GPIP		GPWP		GP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	2	9344460	2	9344461	2	9344462
M 2.5 × 0.45	2	9344470	2	9344471	2	9344472
M 2.6 × 0.45	2	9344480	2	9344481	2	9344482
M 3 × 0.5	2	9344490	2	9344491	2	9344492
M 4 × 0.7	2	9344500	2	9344501	2	9344502
M 5 × 0.8	2	9344510	2	9344511	2	9344512
M 6 × 1	2	9344520	2	9344521	2	9344522
M 8 × 1.25	2	9344530	2	9344531	2	9344532
M 10 × 1.5	2	9344540	2	9344541	2	9344542
M 10 × 1.25	2	9344550	2	9344551	2	9344552
M 12 × 1.75	2	9344560	2	9344561	2	9344562

※1：颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

DLC涂层螺纹极限量规(DLC-LG)

DLC Coated Thread Limit Gauge

螺纹部表面采用润滑性优良的DLC涂层，有效防止溶着。
另外，由于高硬度的DLC涂层，螺纹量规可以实现更长寿命。对非铁金属(铝、铜、树脂等)的材料特别有效。

DLC coating with excellent lubricity is applied to the thread surface, which is effective in preventing welding. In addition, the long life of the thread gauge is achieved by the high hardness DLC coating. It is especially effective for non-ferrous metals (aluminum, copper, resin, etc.).

注：仅在易溶着的通规端采用DLC涂层。

DLC coating is applied only to the go side of the gauge, which is easy to weld.

JIS(ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug			
	GPNP		GP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2 × 0.4	6H	9344570	6H	9344572
M 2.5 × 0.45	6H	9344580	6H	9344582
M 2.6 × 0.45	6H	9344590	6H	9344592
M 3 × 0.5	6H	9344600	6H	9344602
M 4 × 0.7	6H	9344610	6H	9344612
M 5 × 0.8	6H	9344620	6H	9344622
M 6 × 1	6H	9344630	6H	9344632
M 8 × 1.25	6H	9344640	6H	9344642
M 10 × 1.5	6H	9344650	6H	9344652
M 10 × 1.25	6H	9344660	6H	9344662
M 12 × 1.75	6H	9344670	6H	9344672

※1：颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1 : Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

平行管螺纹量规(LG)
Parallel pipe threads

PS内螺纹合格与否的判定在P.916锥管螺纹量规(TG PT)可见(JIS B 0253).
使用螺纹用极限量规(LG)时,仅限在外螺纹为PS的情况下。
At the inspection of PS internal thread, Taper Pipe Thread Gage (TG, PT) to be used (JIS B 0253)

— (旧JIS)(Previous JIS)

平行管螺纹(PS) Parallel pipe threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
PS 1/8 - 28	—	35910	—	35911	—	35912	—	35913	—	35914	—	35917	—	35918	—	35919
PS 1/4 - 19	—	35920	—	35921	—	35922	—	35923	—	35924	—	35927	—	35928	—	35929
PS 3/8 - 19	—	35930	—	35931	—	35932	—	35933	—	35934	—	35937	—	35938	—	35939
PS 1/2 - 14	—	35940	—	35941	—	35942	—	35943	—	35944	—	35947	—	35948	—	35949
PS 5/8 - 14	—	35950	—	35951	—	35952	—	35953	—	35954	—	35957	—	35958	—	35959
PS 3/4 - 14	—	35960	—	35961	—	35962	—	35963	—	35964	—	35967	—	35968	—	35969
PS 7/8 - 14	—	35970	—	35971	—	35972	—	35973	—	35974	—	35977	—	35978	—	35979
PS 1 - 11	—	35980	—	35981	—	35982	—	35983	—	35984	—	35987	—	35988	—	35989
PS 1 1/8 - 11	—	35990	—	35991	—	35992	—	35993	—	35994	—	35997	—	35998	—	35999
PS 1 1/4 - 11	—	36000	—	36001	—	36002	—	36003	—	36004	—	36007	—	36008	—	36009
PS 1 1/2 - 11	—	36010	—	36011	—	36012	—	36013	—	36014	—	36017	—	36018	—	36019
PS 1 3/4 - 11	—	36020	—	36021	—	36022	—	36023	—	36024	—	36027	—	36028	—	36029
PS 2 - 11	—	—	—	—	—	36032	—	36033	—	36034	—	36037	—	36038	—	36039
PS 2 1/4 - 11	—	—	—	—	—	9333012	—	9333013	—	9333014	—	9333017	—	9333018	—	9333019
PS 2 1/2 - 11	—	—	—	—	—	9333032	—	9333033	—	9333034	—	9333037	—	9333038	—	9333039
PS 3 - 11	—	—	—	—	—	9333072	—	9333073	—	9333074	—	9333077	—	9333078	—	9333079

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

平行管螺纹量规(LG)
Parallel pipe threads

A级(旧JIS)
Class A (Previous JIS)

平行管螺纹(PF) Parallel pipe threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
PF 1/8 - 28	A	35710	A	35711	A/B	35712	A	35713	A	35714	A/B	35717	A	35718	A	35719
PF 1/4 - 19	A	35720	A	35721	A/B	35722	A	35723	A	35724	A/B	35727	A	35728	A	35729
PF 3/8 - 19	A	35730	A	35731	A/B	35732	A	35733	A	35734	A/B	35737	A	35738	A	35739
PF 1/2 - 14	A	35740	A	35741	A/B	35742	A	35743	A	35744	A/B	35747	A	35748	A	35749
PF 5/8 - 14	A	35750	A	35751	A/B	35752	A	35753	A	35754	A/B	35757	A	35758	A	35759
PF 3/4 - 14	A	35760	A	35761	A/B	35762	A	35763	A	35764	A/B	35767	A	35768	A	35769
PF 7/8 - 14	A	35770	A	35771	A/B	35772	A	35773	A	35774	A/B	35777	A	35778	A	35779
PF 1 - 11	A	35780	A	35781	A/B	35782	A	35783	A	35784	A/B	35787	A	35788	A	35789
PF 1 1/8 - 11	A	35790	A	35791	A/B	35792	A	35793	A	35794	A/B	35797	A	35798	A	35799
PF 1 1/4 - 11	A	35800	A	35801	A/B	35802	A	35803	A	35804	A/B	35807	A	35808	A	35809
PF 1 1/2 - 11	A	35810	A	35811	A/B	35812	A	35813	A	35814	A/B	35817	A	35818	A	35819
PF 1 3/4 - 11	A	35820	A	35821	A/B	35822	A	35823	A	35824	A/B	35827	A	35828	A	35829
PF 2 - 11	—	—	—	—	A/B	35832	A	35833	A	35834	A/B	35837	A	35838	A	35839
PF 2 1/4 - 11	—	—	—	—	A/B	9332512	A	9332513	A	9332514	A/B	9332517	A	9332518	A	9332519
PF 2 1/2 - 11	—	—	—	—	A/B	9332532	A	9332533	A	9332534	A/B	9332537	A	9332538	A	9332539
PF 3 - 11	—	—	—	—	A/B	9332572	A	9332573	A	9332574	A/B	9332577	A	9332578	A	9332579
PF 3 1/2 - 11	—	—	—	—	A/B	9332592	A	9332593	A	9332594	A/B	9332597	A	9332598	A	9332599
PF 4 - 11	—	—	—	—	A/B	9332612	A	9332613	A	9332614	A/B	9332617	A	9332618	A	9332619

※1：通规 (GP,GR) 为A级B级共用。
※1：GO gauges (GP, GR) can be used by both class A and class B.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

平行管螺纹量规(LG)
Parallel pipe threads

B级(旧JIS)
Class B (Previous JIS)

平行管螺纹(PF) Parallel pipe threads

螺纹尺寸 Thread Size	塞规 Plug										环规 Ring					
	GPIP		GPWP		GP		IP		WP		GR		IR		WR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
PF 1/8 - 28	B	9332700	B	9332701	A/B	35712	B	9332703	B	9332704	A/B	35717	B	9332708	B	9332709
PF 1/4 - 19	B	9332720	B	9332721	A/B	35722	B	9332723	B	9332724	A/B	35727	B	9332728	B	9332729
PF 3/8 - 19	B	9332740	B	9332741	A/B	35732	B	9332743	B	9332744	A/B	35737	B	9332748	B	9332749
PF 1/2 - 14	B	9332760	B	9332761	A/B	35742	B	9332763	B	9332764	A/B	35747	B	9332768	B	9332769
PF 3/4 - 14	B	9332800	B	9332801	A/B	35762	B	9332803	B	9332804	A/B	35767	B	9332808	B	9332809
PF 1 - 11	B	9332840	B	9332841	A/B	35782	B	9332843	B	9332844	A/B	35787	B	9332848	B	9332849
PF 1 1/4 - 11	B	9332880	B	9332881	A/B	35802	B	9332883	B	9332884	A/B	35807	B	9332888	B	9332889
PF 1 1/2 - 11	B	9332900	B	9332901	A/B	35812	B	9332903	B	9332904	A/B	35817	B	9332908	B	9332909

※1：通规 (GP,GR) 为A级B级共用。
※1：GO gauges (GP, GR) can be used by both class A and class B.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

平行管螺纹量规(LG)
Parallel pipe threads

A级 JIS (ISO等级)
Class A JIS (ISO)

平行管螺纹(G) Parallel pipe threads
■ JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug						环规 Ring			
	GPNP		GP		NP		GR		NR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
G 1/16 - 28	—	36340	—	36342	—	36343	A/B	36347	A	36348
G 1/8 - 28	—	36350	—	36352	—	36353	A/B	36357	A	36358
G 1/4 - 19	—	36360	—	36362	—	36363	A/B	36367	A	36368
G 3/8 - 19	—	36370	—	36372	—	36373	A/B	36377	A	36378
G 1/2 - 14	—	36380	—	36382	—	36383	A/B	36387	A	36388
G 5/8 - 14	—	36390	—	36392	—	36393	A/B	36397	A	36398
G 3/4 - 14	—	36400	—	36402	—	36403	A/B	36407	A	36408
G 7/8 - 14	—	36410	—	36412	—	36413	A/B	36417	A	36418
G 1 - 11	—	36420	—	36422	—	36423	A/B	36427	A	36428
G 1 1/4 - 11	—	9331800	—	9331802	—	9331803	A/B	9331807	A	9331808
G 1 1/2 - 11	—	9331810	—	9331812	—	9331813	A/B	9331817	A	9331818
G 2 - 11	—	—	—	9331832	—	9331833	A/B	9331837	A	9331838

※1：通规 (GR) 为A级B级共用。
※1：GO gauges (GR) can be used by both class A and class B.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

小径塞规(LG)
Limit plug gauge for minor diameter

2级(旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	检查用 Inspection IM		工作用 Working WM	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1.4 × 0.3	2	9329020	2	9329021
M 1.6 × 0.35	2	9329035	2	9329036
M 1.7 × 0.35	2	9329045	2	9329046
M 2 × 0.4	2	9329075	2	9329076
M 2.3 × 0.4	2	9329100	2	9329101
M 2.5 × 0.45	2	9329115	2	9329116
M 2.6 × 0.45	2	9329125	2	9329126
M 3 × 0.5	2	9329145	2	9329146
M 4 × 0.7	2	9329175	2	9329176
M 5 × 0.8	2	9329200	2	9329201
M 6 × 1	2	9329230	2	9329231
M 8 × 1.25	2	9329260	2	9329261
M 8 × 1	2	9329265	2	9329266
M 10 × 1.5	2	9329300	2	9329301
M 10 × 1.25	2	9329305	2	9329306
M 10 × 1	2	9329310	2	9329311

螺纹尺寸 Thread Size	检查用 Inspection IM		工作用 Working WM	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 12 × 1.75	2	9329350	2	9329351
M 12 × 1.5	2	9329355	2	9329356
M 12 × 1.25	2	9329360	2	9329361
M 12 × 1	2	9329365	2	9329366
M 14 × 2	2	9329410	2	9329411
M 14 × 1.5	2	9329415	2	9329416
M 16 × 2	2	9329470	2	9329471
M 16 × 1.5	2	9329475	2	9329476
M 18 × 2.5	2	9329530	2	9329531
M 18 × 1.5	2	9329540	2	9329541
M 20 × 2.5	2	9329600	2	9329601
M 20 × 1.5	2	9329605	2	9329606
M 22 × 2.5	2	9329645	2	9329646
M 22 × 1.5	2	9329655	2	9329656
M 24 × 3	2	9329690	2	9329691
M 24 × 1.5	2	9329705	2	9329706

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

小径用塞规(LG)
Plain plug gauges for minor diameter

JIS (ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads

■JIS (ISO) [嵌合度 ：中] (Fitting quality:Medium)

螺纹尺寸 Thread Size	塞规 Plug PP 精度 Class	塞规 Plug PP 商品号 EDP No.
M 1.4 × 0.3	6H※	9345304
M 1.6 × 0.35	6H	9345314
M 1.7 × 0.35	6H	9345324
M 2 × 0.4	6H	9345334
M 2.3 × 0.4	6H	9345344
M 2.5 × 0.45	6H	9345354
M 2.6 × 0.45	6H	9345364
M 3 × 0.5	6H	9345374
M 4 × 0.7	6H	9345384
M 5 × 0.8	6H	9345394
M 6 × 1	6H	9345404
M 8 × 1.25	6H	9345414
M 8 × 1	6H	9345424
M 10 × 1.5	6H	9345434
M 10 × 1.25	6H	9345444
M 10 × 1	6H	9345454

螺纹尺寸 Thread Size	塞规 Plug PP 精度 Class	塞规 Plug PP 商品号 EDP No.
M 12 × 1.75	6H	9345464
M 12 × 1.5	6H	9345474
M 12 × 1.25	6H	9345484
M 12 × 1	6H	9345494
M 14 × 2	6H	9345504
M 14 × 1.5	6H	9345514
M 16 × 2	6H	9345524
M 16 × 1.5	6H	9345534
M 18 × 2.5	6H	9345544
M 18 × 1.5	6H	9345554
M 20 × 2.5	6H	9345564
M 20 × 1.5	6H	9345574
M 22 × 2.5	6H	9345584
M 22 × 1.5	6H	9345594
M 24 × 3	6H	9345604
M 24 × 1.5	6H	9345614

※表示JIS规格以外的，不规定为"嵌合区分：中"。
※ indicates items outside of the JIS standard and are not stipulated by the "normal fit" thread tolerance class.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

锥管螺纹用小径塞规(TPG-P)

Taper Pipe Thread Plug Gauge for Minor Diameter

是用于检查锥管螺纹的内螺纹小径的量规。
锥管螺纹量规(TG)无法检查内螺纹小径，请使用锥管螺纹用小径塞规(TPG)。

Gauge for inspecting the minor diameter of female threads of taper pipe threads. For the taper pipe thread gauge (TG), the minor diameter of the internal thread cannot be inspected, so please use the taper pipe thread plug gauge for minor diameter (TPG).

— (旧JIS) (Previous JIS)

锥管螺纹(PT) Taper pipe threads

螺纹尺寸 Thread Size	塞规Plug TPG-P 精度 Class	塞规Plug TPG-P 商品号 EDP No.
PT 1/16 - 28	—	9344701
PT 1/8 - 28	—	9344711
PT 1/4 - 19	—	9344721
PT 3/8 - 19	—	9344731
PT 1/2 - 14	—	9344741
PT 5/8 - 14	—	9344751
PT 3/4 - 14	—	9344761

螺纹尺寸 Thread Size	塞规Plug TPG-P 精度 Class	塞规Plug TPG-P 商品号 EDP No.
PT 7/8 - 14	—	9344771
PT1 - 11	—	9344781
PT1 1/4 - 11	—	9344791
PT1 1/2 - 11	—	9344801
PT1 3/4 - 11	—	9344811
PT2 - 11	—	9344821

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

锥管螺纹用小径塞规(TPG-P)

Taper Pipe Thread Plug Gauge for Minor Diameter

是用于检查锥管螺纹的内螺纹小径的量规。
锥管螺纹量规(TG)无法检查内螺纹小径,请使用锥管螺纹用小径塞规(TPG)

Gauge for inspecting the minor diameter of female threads of taper pipe threads. For the taper pipe thread gauge (TG), the minor diameter of the internal thread cannot be inspected, so please use the taper pipe thread plug gauge for minor diameter (TPG).

—
JIS(ISO等级) JIS (ISO)

锥管螺纹(R) Taper pipe threads

■ JIS (ISO)

螺纹尺寸 Thread Size	塞规 Plug TPG-P 精度 Class	塞规 Plug TPG-P 商品号 EDP No.
R 1/16 - 28	—	9344831
R 1/8 - 28	—	9344841
R 1/4 - 19	—	9344851
R 3/8 - 19	—	9344861
R 1/2 - 14	—	9344871
R 3/4 - 14	—	9344881
R1 - 11	—	9344891
R1 1/4 - 11	—	9344901
R1 1/2 - 11	—	9344911
R2 - 11	—	9344921

嵌套螺纹用极限塞规（HL-LG）
Limit gauges for Insert screw threads

2级 Class 2

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug					
	GPWP		GP		WP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 2.6 × 0.45	2	9333121	2	9333122	2	9333124
M 3 × 0.5	2	9333141	2	9333142	2	9333144
M 4 × 0.7	2	9333161	2	9333162	2	9333164
M 5 × 0.8	2	9333181	2	9333182	2	9333184
M 6 × 1	2	9333201	2	9333202	2	9333204
M 8 × 1.25	2	9333221	2	9333222	2	9333224
M 10 × 1.5	2	9333241	2	9333242	2	9333244
M 10 × 1.25	2	9333261	2	9333262	2	9333264
M 12 × 1.75	2	9333281	2	9333282	2	9333284
M 12 × 1.5	2	9333301	2	9333302	2	9333304
M 12 × 1.25	2	9333321	2	9333322	2	9333324
M 14 × 2	2	9333341	2	9333342	2	9333344
M 14 × 1.5	2	9333361	2	9333362	2	9333364
M 16 × 2	2	9333381	2	9333382	2	9333384
M 16 × 1.5	2	9333401	2	9333402	2	9333404
M 18 × 2.5	2	9333421	2	9333422	2	9333424
M 18 × 1.5	2	9333441	2	9333442	2	9333444
M 20 × 2.5	2	9333461	2	9333462	2	9333464
M 20 × 1.5	2	9333481	2	9333482	2	9333484

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

嵌套螺纹用极限螺纹量规（HL-LG）
Limit gauges for Insert screw threads

2B级
Class 2B

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug					
	GPWP		GP		WP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
No. 4 - 40 UNC	2B	9333691	2B	9333692	2B	9333694
No. 5 - 40 UNC	2B	9333711	2B	9333712	2B	9333714
No. 6 - 32 UNC	2B	9333731	2B	9333732	2B	9333734
No. 6 - 40 UNF	2B	9333741	2B	9333742	2B	9333744
No. 8 - 32 UNC	2B	9333751	2B	9333752	2B	9333754
No. 8 - 36 UNF	2B	9333761	2B	9333762	2B	9333764
No. 10 - 24 UNC	2B	9333771	2B	9333772	2B	9333774
No. 10 - 32 UNF	2B	9333781	2B	9333782	2B	9333784
No. 12 - 24 UNC	2B	9333791	2B	9333792	2B	9333794
No. 12 - 28 UNF	2B	9333801	2B	9333802	2B	9333804
1/4 - 20 UNC	2B	9333831	2B	9333832	2B	9333834
1/4 - 28 UNF	2B	9333841	2B	9333842	2B	9333844
5/16 - 18 UNC	2B	9333881	2B	9333882	2B	9333884
5/16 - 24 UNF	2B	9333891	2B	9333892	2B	9333894
3/8 - 16 UNC	2B	9333921	2B	9333922	2B	9333924
3/8 - 24 UNF	2B	9333931	2B	9333932	2B	9333934
7/16 - 14 UNC	2B	9333961	2B	9333962	2B	9333964
7/16 - 20 UNF	2B	9333971	2B	9333972	2B	9333974
1/2 - 13 UNC	2B	9334001	2B	9334002	2B	9334004
1/2 - 20 UNF	2B	9334011	2B	9334012	2B	9334014
5/8 - 11 UNC	2B	9334061	2B	9334062	2B	9334064
5/8 - 18 UNF	2B	9334071	2B	9334072	2B	9334074
3/4 - 10 UNC	2B	9334101	2B	9334102	2B	9334104
3/4 - 16 UNF	2B	9334111	2B	9334112	2B	9334114
1 - 8 UNC	2B	9334151	2B	9334152	2B	9334154
1 - 12 UNF	2B	9334161	2B	9334162	2B	9334164

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

TiN 涂层 嵌套螺纹用极限塞规（TIN-HL-LG）

TiN Coated Insert Thread Limit Plug Gauge

螺纹部表面采用TiN涂层(金色)，可根据涂层的附着情况，目视判断磨损程度(标准)。
另外，由于高硬度的TiN涂层，螺纹量规可以实现更长寿命。
The thread surface is coated with TiN (gold color), and wear on the gauge can be visually determined based on the adhesion of the coating. In addition, long tool life of the thread gauge is achieved by the high hardness TiN coating.

注：仅在易磨损的通规端采用TiN涂层。
TiN coating is applied only to the go side of the gauge as wear tends to progress.

3B级
Class 3B

美制螺纹(U) Unified inch screw threads

螺纹尺寸 Thread Size	塞规 Plug			
	GPWP		GP	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
0.1380 - 32 UNJC	3B	9345181	3B	9345182
0.1640 - 32 UNJC	3B	9345191	3B	9345192
0.1900 - 32 UNJF	3B	9345201	3B	9345202
0.2160 - 28 UNJF	3B	9345211	3B	9345212
0.2500 - 28 UNJF	3B	9345221	3B	9345222
0.3125 - 18 UNJC	3B	9345231	3B	9345232
0.3125 - 24 UNJF	3B	9345241	3B	9345242
0.3750 - 24 UNJF	3B	9345251	3B	9345252
0.4375 - 20 UNJF	3B	9345261	3B	9345262
0.5000 - 20 UNJF	3B	9345271	3B	9345272
0.5625 - 18 UNJF	3B	9345281	3B	9345282
0.6250 - 18 UNJF	3B	9345291	3B	9345292
0.7500 - 16 UNJF	3B	9345301	3B	9345302

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

在日本使用OSG独有的式样，J表示螺纹记号，通规处印GP，止规处印WP。
虽然不是ANSI规格定义的量规记号，但可用于NASM33537（MS33537E）中规定的嵌套螺纹3B的尺寸检测。
Assuming use in Japan, it is OSG's original specification with J on the thread symbol, GP printed on the go side, and WP printed on the no-go side. Although it is not a gauge symbol specified by the ANSI standard, it can be used for inspection of the insert thread 3B specified in NASM33537 (MS33537E).

标准螺纹量规(SG)
Standard screw thread gauges

量规精度J级表示符合日本精密测定机器工业会规格JMAS 4001:1991。
Gauge class J indicates that it complies with the Japan Precision Measuring Instruments Manufacturers Association Standard JMAS 4001:1991.

J级 Class J

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1.4 × 0.3	J	37010	J	37011	J	37012
M 1.7 × 0.35	J	37040	J	37041	J	37042
M 2 × 0.4	J	37070	J	37071	J	37072
M 2.3 × 0.4	J	37100	J	37101	J	37102
M 2.6 × 0.45	J	37130	J	37131	J	37132
M 3 × 0.6	J	37150	J	37151	J	37152
M 3 × 0.5	J	37160	J	37161	J	37162
M 3.5 × 0.6	J	37180	J	37181	J	37182
M 4 × 0.75	J	37200	J	37201	J	37202
M 4 × 0.7	J	37210	J	37211	J	37212
M 5 × 0.9	J	37230	J	37231	J	37232
M 5 × 0.8	J	37240	J	37241	J	37242
M 6 × 1	J	37260	J	37261	J	37262
M 7 × 1	J	37270	J	37271	J	37272
M 8 × 1.25	J	37280	J	37281	J	37282
M 8 × 1	J	37290	J	37291	J	37292
M 9 × 1.25	J	37310	J	37311	J	37312
M 10 × 1.5	J	37330	J	37331	J	37332
M 10 × 1.25	J	37340	J	37341	J	37342
M 10 × 1	J	37350	J	37351	J	37352
M 12 × 1.75	J	37370	J	37371	J	37372
M 12 × 1.5	J	37380	J	37381	J	37382
M 12 × 1.25	J	37390	J	37391	J	37392

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M12 ~ M24 NEXT

上一页
FROM 尺寸 Size M1.4 ~ M12

J级
Class J

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 12 × 1	J	37400	J	37401	J	37402
M 14 × 2	J	37440	J	37441	J	37442
M 14 × 1.5	J	37450	J	37451	J	37452
M 14 × 1.25	J	37460	J	37461	J	37462
M 14 × 1	J	37470	J	37471	J	37472
M 16 × 2	J	37510	J	37511	J	37512
M 16 × 1.5	J	37520	J	37521	J	37522
M 16 × 1	J	37530	J	37531	J	37532
M 18 × 2.5	J	37550	J	37551	J	37552
M 18 × 2	J	37560	J	37561	J	37562
M 18 × 1.5	J	37570	J	37571	J	37572
M 18 × 1	J	37580	J	37581	J	37582
M 20 × 2.5	J	37610	J	37611	J	37612
M 20 × 2	J	37620	J	37621	J	37622
M 20 × 1.5	J	37630	J	37631	J	37632
M 20 × 1	J	37640	J	37641	J	37642
M 22 × 2.5	J	37670	J	37671	J	37672
M 22 × 2	J	37680	J	37681	J	37682
M 22 × 1.5	J	37690	J	37691	J	37692
M 22 × 1	J	37700	J	37701	J	37702
M 24 × 3	J	37730	J	37731	J	37732
M 24 × 2	J	37740	J	37741	J	37742
M 24 × 1.5	J	37750	J	37751	J	37752

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

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尺寸 Size M24 ~ M40 NEXT

标准螺纹量规(SG)
Standard screw thread gauges

量规精度J级表示符合日本精密测定机器工业会规格JMAS 4001:1991。
Gauge class J indicates that it complies with the Japan Precision Measuring Instruments Manufacturers Association Standard JMAS 4001:1991.

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FROM 尺寸 Size M12 ~ M24

J级 Class J

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 24 × 1	J	37760	J	37761	J	37762
M 25 × 1.5	J	9337000	J	9337001	J	9337002
M 26 × 1.5	J	9337030	J	9337031	J	9337032
M 27 × 3	J	9337060	J	9337061	J	9337062
M 27 × 2	J	9337070	J	9337071	J	9337072
M 27 × 1.5	J	9337080	J	9337081	J	9337082
M 28 × 2	J	9337110	J	9337111	J	9337112
M 28 × 1.5	J	9337120	J	9337121	J	9337122
M 30 × 3.5	J	9337150	J	9337151	J	9337152
M 30 × 2	J	9337160	J	9337161	J	9337162
M 30 × 1.5	J	9337170	J	9337171	J	9337172
M 33 × 3.5	J	9337220	J	9337221	J	9337222
M 33 × 2	J	9337230	J	9337231	J	9337232
M 33 × 1.5	J	9337240	J	9337241	J	9337242
M 36 × 4	J	9337290	J	9337291	J	9337292
M 36 × 3	J	9337300	J	9337301	J	9337302
M 36 × 2	J	9337310	J	9337311	J	9337312
M 36 × 1.5	J	9337320	J	9337321	J	9337322
M 39 × 4	J	9337370	J	9337371	J	9337372
M 39 × 3	J	9337380	J	9337381	J	9337382
M 39 × 2	J	9337390	J	9337391	J	9337392
M 39 × 1.5	J	9337400	J	9337401	J	9337402
M 40 × 2	J	9337430	J	9337431	J	9337432

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M40 ~ M60 NEXT

上一页
FROM 尺寸 Size M24 ~ M40

J级
Class J

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 40 × 1.5	J	9337440	J	9337441	J	9337442
M 42 × 4.5	J	9337480	J	9337481	J	9337482
M 42 × 3	J	9337490	J	9337491	J	9337492
M 42 × 2	J	9337500	J	9337501	J	9337502
M 42 × 1.5	J	9337510	J	9337511	J	9337512
M 48 × 5	J	9337600	J	9337601	J	9337602
M 48 × 3	J	9337610	J	9337611	J	9337612
M 48 × 2	J	9337620	J	9337621	J	9337622
M 48 × 1.5	J	9337630	J	9337631	J	9337632
M 52 × 5	J	9337680	J	9337681	J	9337682
M 52 × 3	J	9337690	J	9337691	J	9337692
M 52 × 2	J	9337700	J	9337701	J	9337702
M 52 × 1.5	J	9337710	J	9337711	J	9337712
M 55 × 2	J	9337760	J	9337761	J	9337762
M 55 × 1.5	J	9337770	J	9337771	J	9337772
M 56 × 5.5	J	9337800	J	9337801	J	9337802
M 56 × 3	J	9337810	J	9337811	J	9337812
M 56 × 2	J	9337820	J	9337821	J	9337822
M 56 × 1.5	J	9337830	J	9337831	J	9337832
M 60 × 5.5	J	9337880	J	9337881	J	9337882
M 60 × 3	J	9337890	J	9337891	J	9337892
M 60 × 2	J	9337900	J	9337901	J	9337902
M 60 × 1.5	J	9337910	J	9337911	J	9337912

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

标准螺纹量规(SG)
Standard screw thread gauges

J级
Class J

惠氏螺纹(W) Whitworth screw threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
W 1/8 - 40	J	38010	J	38011	J	38012
W 3/16 - 24	J	38020	J	38021	J	38022
W 1/4 - 20	J	38030	J	38031	J	38032
W 5/16 - 18	J	38040	J	38041	J	38042
W 3/8 - 16	J	38050	J	38051	J	38052
W 7/16 - 14	J	38060	J	38061	J	38062
W 1/2 - 12	J	38070	J	38071	J	38072
W 5/8 - 11	J	38080	J	38081	J	38082
W 3/4 - 10	J	38090	J	38091	J	38092
W 7/8 - 9	J	38110	J	38111	J	38112
W 1 - 8	J	38120	J	38121	J	38122

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

标准螺纹量规(SG)
Standard screw thread gauges

量规精度J级表示符合日本精密测定机器工业会规格JMAS 4001:1991。
Gauge class J indicates that it complies with the Japan Precision Measuring Instruments Manufacturers Association Standard JMAS 4001:1991.

J级 Class J

平行管螺纹 (PS) Parallel pipe internal threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
PS 1/8 - 28	J	38360	J	38361	J	38362
PS 1/4 - 19	J	38370	J	38371	J	38372
PS 3/8 - 19	J	38380	J	38381	J	38382
PS 1/2 - 14	J	38390	J	38391	J	38392
PS 5/8 - 14	J	38400	J	38401	J	38402
PS 3/4 - 14	J	38410	J	38411	J	38412
PS 7/8 - 14	J	38420	J	38421	J	38422
PS 1 - 11	J	38430	J	38431	J	38432

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

平行管螺纹 (PF) Parallel pipe threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
PF 1/8 - 28	J	38210	J	38211	J	38212
PF 1/4 - 19	J	38220	J	38221	J	38222
PF 3/8 - 19	J	38230	J	38231	J	38232
PF 1/2 - 14	J	38240	J	38241	J	38242
PF 5/8 - 14	J	38250	J	38251	J	38252
PF 3/4 - 14	J	38260	J	38261	J	38262
PF 7/8 - 14	J	38270	J	38271	J	38272
PF 1 - 11	J	38280	J	38281	J	38282

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

锥管螺纹量规(TG)
Gauges for taper pipe threads

— (旧JIS) (Previous JIS)

锥管螺纹 (PT) Taper pipe threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
PT 1/16 - 28	—	38500	—	38501	—	38502
PT 1/8 - 28	—	38510	—	38511	—	38512
PT 1/4 - 19	—	38520	—	38521	—	38522
PT 3/8 - 19	—	38530	—	38531	—	38532
PT 1/2 - 14	—	38540	—	38541	—	38542
PT 5/8 - 14	—	38550	—	38551	—	38552
PT 3/4 - 14	—	38560	—	38561	—	38562
PT 7/8 - 14	—	38570	—	38571	—	38572
PT1 - 11	—	38580	—	38581	—	38582
PT1 1/4 - 11	—	38590	—	38591	—	38592
PT1 1/2 - 11	—	38600	—	38601	—	38602
PT1 3/4 - 11	—	38610	—	38611	—	38612
PT2 - 11	—	38620	—	38621	—	38622
PT2 1/2 - 11	—	9335640	—	9335641	—	9335642
PT3 - 11	—	9335680	—	9335681	—	9335682
PT3 1/2 - 11	—	9335710	—	9335711	—	9335712
PT4 - 11	—	9335750	—	9335751	—	9335752
PT5 - 11	—	9335800	—	9335801	—	9335802

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

锥管螺纹量规(TG)

Gauges for taper pipe threads

锥管螺纹（R） Taper pipe threads

■ JIS(ISO)

— JIS(ISO等级) JIS (ISO)

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
R 1/16 - 28	—	9335000	—	9335001	—	9335002
R 1/8 - 28	—	9335020	—	9335021	—	9335022
R 1/4 - 19	—	9335040	—	9335041	—	9335042
R 3/8 - 19	—	9335060	—	9335061	—	9335062
R 1/2 - 14	—	9335080	—	9335081	—	9335082
R 3/4 - 14	—	9335100	—	9335101	—	9335102
R1 - 11	—	9335120	—	9335121	—	9335122
R1 1/4 - 11	—	9335140	—	9335141	—	9335142
R1 1/2 - 11	—	9335160	—	9335161	—	9335162
R2 - 11	—	9335180	—	9335181	—	9335182

库存分类全部为● (标准库存品)。

Stock are categolized in section ● (Standard stock item).

锥管螺纹量规(TG)
Gauges for taper pipe threads

— ANSI / ASME

美式锥管螺纹 (NPT) ANSI taper pipe threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
1/16 - 27 NPT	—	38700	—	38701	—	38702
1/8 - 27 NPT	—	38710	—	38711	—	38712
1/4 - 18 NPT	—	38720	—	38721	—	38722
3/8 - 18 NPT	—	38730	—	38731	—	38732
1/2 - 14 NPT	—	38740	—	38741	—	38742
3/4 - 14 NPT	—	38750	—	38751	—	38752
1 - 11 - 1/2 NPT	—	38760	—	38761	—	38762
1 1/4 - 11 - 1/2 NPT	—	9336110	—	9336111	—	9336112
1 1/2 - 11 - 1/2 NPT	—	9336130	—	9336131	—	9336132
2 - 11 - 1/2 NPT	—	9336180	—	9336181	—	9336182
2 1/2 - 8 NPT	—	9336200	—	9336201	—	9336202
3 - 8 NPT	—	9336270	—	9336271	—	9336272
3 1/2 - 8 NPT	—	9336300	—	9336301	—	9336302
4 - 8 NPT	—	9336330	—	9336331	—	9336332

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

锥管螺纹量规(TG)
Gauges for taper pipe threads

L1 (ANSI)

美式锥管螺纹 (NPTF) ANSI taper pipe threads

螺纹尺寸 Thread Size	S(套) Set		P(塞规) Plug		R(环规) Ring	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
1/16 - 27 NPTF	L1	38800	L1	38801	L1	38802
1/8 - 27 NPTF	L1	38810	L1	38811	L1	38812
1/4 - 18 NPTF	L1	38820	L1	38821	L1	38822
3/8 - 18 NPTF	L1	38830	L1	38831	L1	38832
1/2 - 14 NPTF	L1	38840	L1	38841	L1	38842
3/4 - 14 NPTF	L1	38850	L1	38851	L1	38852
1 - 11 - 1/2 NPTF	L1	38860	L1	38861	L1	38862
1 1/4 - 11 - 1/2 NPTF	L1	9336600	L1	9336601	L1	9336602
1 1/2 - 11 - 1/2 NPTF	L1	9336640	L1	9336641	L1	9336642
2 - 11 - 1/2 NPTF	L1	9336680	L1	9336681	L1	9336682

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

极限圆柱量规(PG)

Plain limit gauges

H7
(JIS B 7420)

公制 通止 Metric GO NOT GO

螺纹尺寸 Size	通止 (套) GO NOT GO	
	精度 Class	商品号 EDP No.
1	H7	9343001
2	H7	9343002
3	H7	9343003
4	H7	9343004
5	H7	9343005
6	H7	9343006
7	H7	9343007
8	H7	9343008
9	H7	9343009
10	H7	9343010
11	H7	9343011
12	H7	9343012
13	H7	9343013
14	H7	9343014
15	H7	9343015
16	H7	9343016
17	H7	9343017
18	H7	9343018
19	H7	9343019
20	H7	9343020
21	H7	9343021
22	H7	9343022
23	H7	9343023
24	H7	9343024
25	H7	9343025
26	H7	9343026

螺纹尺寸 Size	通止 (套) GO NOT GO	
	精度 Class	商品号 EDP No.
27	H7	9343027
28	H7	9343028
29	H7	9343029
30	H7	9343030
31	H7	9343031
32	H7	9343032
33	H7	9343033
34	H7	9343034
35	H7	9343035
36	H7	9343036
37	H7	9343037
38	H7	9343038
39	H7	9343039
40	H7	9343040
41	H7	9343041
42	H7	9343042
43	H7	9343043
44	H7	9343044
45	H7	9343045
46	H7	9343046
47	H7	9343047
48	H7	9343048
49	H7	9343049
50	H7	9343050
55	H7	9343051
60	H7	9343052

符合JIS B 7420，相当于JIS B 7421(工作用)。
Conforms to JIS B 7420, equivalent to JIS B 7421 (working gauge).

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

标准环规(RG-M)

Master ring gauges

标准环规上刻有尺寸和实际测量值。
The standard (master) ring gauge is engraved with the nominal dimensions and measured values.

±0.001

公制 Metric

螺纹尺寸 Size	环规 Ring RG-M 精度 Class	环规 Ring RG-M 商品号 EDP No.
2	±0.001	9339004
2.5	±0.001	9339005
3	±0.001	9339006
3.5	±0.001	9339007
4	±0.001	9339008
4.5	±0.001	9339009
5	±0.001	9339010
5.5	±0.001	9339011
6	±0.001	9339012
6.5	±0.001	9339013
7	±0.001	9339014
7.5	±0.001	9339015
8	±0.001	9339016
8.5	±0.001	9339017
9	±0.001	9339018
9.5	±0.001	9339019
10	±0.001	9339020
11	±0.001	9339022
12	±0.001	9339024
13	±0.001	9339026
14	±0.001	9339028
15	±0.001	9339030
16	±0.001	9339032
17	±0.001	9339034
18	±0.001	9339036
19	±0.001	9339038
20	±0.001	9339040
21	±0.001	9339042
22	±0.001	9339044

螺纹尺寸 Size	环规 Ring RG-M 精度 Class	环规 Ring RG-M 商品号 EDP No.
23	±0.001	9339046
24	±0.001	9339048
25	±0.001	9339050
26	±0.001	9339052
27	±0.001	9339054
28	±0.001	9339056
29	±0.001	9339058
30	±0.001	9339060
31	±0.001	9339062
32	±0.001	9339064
33	±0.001	9339066
34	±0.001	9339068
35	±0.001	9339070
36	±0.001	9339072
37	±0.001	9339074
38	±0.001	9339076
39	±0.001	9339078
40	±0.001	9339080
41	±0.001	9339082
42	±0.001	9339084
43	±0.001	9339086
44	±0.001	9339088
45	±0.001	9339090
46	±0.001	9339092
47	±0.001	9339094
48	±0.001	9339096
49	±0.001	9339098
50	±0.001	9339100

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

磨耗点检螺纹量规（LCG）
Wear Check Thread Gauge

用于检查通规端螺纹用极限量规(GP,GR)磨损情况的量规。
旧JIS 2级用GP,GR无法通过,ISO等级6H的GP,GR不超过1圈旋入,由此判断为磨损范围内。
※ 磨耗点检环规(GPW)是JIS中没有规定的量规,是OSG独有设定的。使用时请充分考虑。

This gauge is used to check the wear of the GO thread limit gauge (GP, GR). Conventionally, for JIS Class 2 grades, the GP and GR do not pass through, and for ISO grade 6H, the GP and GR do not exceed 1 revolution, so it is judged that they are within the wear limit.
*The wear check ring gauge (GPW) is not specified in JIS and is set by OSG. Please give due consideration before use.

2级(旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug GW		环规 Ring GPW	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1.4 × 0.3	2	9338104	—	—
M 1.6 × 0.35	2	9338107	—	—
M 1.7 × 0.35	2	9338109	—	—
M 2 × 0.4	2	9338115	※ 2	9338219
M 2.3 × 0.4	2	9338120	—	—
M 2.5 × 0.45	2	9338123	※ 2	9338239
M 2.6 × 0.45	2	9338125	※ 2	9338249
M 3 × 0.5	2	9338129	※ 2	9338259
M 4 × 0.7	2	9338135	※ 2	9338269
M 5 × 0.8	2	9338140	※ 2	9338279
M 6 × 1	2	9338146	※ 2	9338289
M 8 × 1.25	2	9338152	※ 2	9338299
M 8 × 1	2	9338153	—	—
M 10 × 1.5	2	9338160	※ 2	9338309
M 10 × 1.25	2	9338161	※ 2	9338319
M 12 × 1.75	2	9338170	※ 2	9338329
M 12 × 1.5	2	9338171	—	—

螺纹尺寸 Thread Size	塞规 Plug GW		环规 Ring GPW	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 12 × 1.25	2	9338172	—	—
M 14 × 2	2	9338182	—	—
M 14 × 1.5	2	9338183	—	—
M 16 × 2	2	9338194	—	—
M 16 × 1.5	2	9338195	—	—
M 18 × 2.5	2	9338206	—	—
M 18 × 1.5	2	9338208	—	—
M 20 × 2.5	2	9338220	—	—
M 20 × 1.5	2	9338222	—	—
M 22 × 2.5	2	9338229	—	—
M 22 × 1.5	2	9338231	—	—
M 24 × 3	2	9338238	—	—
M 24 × 1.5	2	9338241	—	—
M 27 × 3	2	9338252	—	—
M 27 × 1.5	2	9338255	—	—
M 30 × 3.5	2	9338261	—	—
M 30 × 1.5	2	9338264	—	—

※ = NEW SIZES

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

磨耗点检螺纹量规（LCG）
Wear Check Thread Gauge

用于检查通规端螺纹用极限量规(GP,GR)磨损情况的量规。
旧JIS 2级用GP,GR无法通过,ISO等级6H的GP,GR不超过1圈旋入,由此判断为磨损范围内。
※ 磨耗点检环规(GPW)是JIS中没有规定的量规,是OSG独有设定的。使用时请充分考虑。

This gauge is used to check the wear of the GO thread limit gauge (GP, GR). Conventionally, for JIS Class 2 grades, the GP and GR do not pass through, and for ISO grade 6H, the GP and GR do not exceed 1 revolution, so it is judged that they are within the wear limit.
*The wear check ring gauge (GPW) is not specified in JIS and is set by OSG. Please give due consideration before use.

JIS (ISO等级)
JIS (ISO)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug				环规 Ring	
	GW		NW		GPW	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 1.4 × 0.3	6h	9345617	6h	9345618	—	—
M 1.6 × 0.35	6g	9345637	6g	9345638	—	—
M 1.7 × 0.35	6g	9345657	6g	9345658	—	—
M 2 × 0.4	6g	9345677	6g	9345678	6H	9345679
M 2.3 × 0.4	6g	9345697	6g	9345698	—	—
M 2.5 × 0.45	6g	9345717	6g	9345718	6H	9345719
M 2.6 × 0.45	6g	9345737	6g	9345738	6H	9345739
M 3 × 0.5	6g	9345757	6g	9345758	6H	9345759
M 4 × 0.7	6g	9345777	6g	9345778	6H	9345779
M 5 × 0.8	6g	9345797	6g	9345798	6H	9345799
M 5.5 × 0.5	6g	9345817	6g	9345818	—	—
M 6 × 1	6g	9345837	6g	9345838	6H	9345839
M 6 × 0.75	6g	9345857	6g	9345858	—	—
M 8 × 1.25	6g	9345877	6g	9345878	6H	9345879
M 8 × 1	6g	9345897	6g	9345898	—	—
M 10 × 1.5	6g	9345917	6g	9345918	6H	9345919
M 10 × 1.25	6g	9345937	6g	9345938	6H	9345939
M 10 × 1	6g	9345957	6g	9345958	—	—
M 12 × 1.75	6g	9345977	6g	9345978	6H	9345979
M 12 × 1.5	6g	9345997	6g	9345998	—	—
M 12 × 1.25	6g	9346017	6g	9346018	—	—
M 12 × 1	6g	9346037	6g	9346038	—	—
M 14 × 2	6g	9346057	6g	9346058	—	—
M 14 × 1.5	6g	9346077	6g	9346078	—	—

磨耗点检环规(GPW)是JIS 中没有规定的量规，是OSG独有设定的。使用时请充分考虑。
The wear check ring gauge (GPW) is not specified in JIS and is set by OSG.
Please give due consideration before use.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

下一页
尺寸 Size M14 ~ M36 NEXT

磨耗点检螺纹量规 (LCG)
Wear Check Thread Gauge

用于检查通规端螺纹用极限量规(GP, GR)磨损情况的量规。
旧JIS 2级用GP, GR无法通过, ISO等级6H的GP, GR不超过1圈旋入, 由此判断为磨损范围内。
※磨耗点检环规(GPW)是JIS中没有规定的量规, 是OSG独有设定的。使用时请充分考虑。

This gauge is used to check the wear of the GO thread limit gauge (GP, GR). Conventionally, for JIS Class 2 grades, the GP and GR do not pass through, and for ISO grade 6H, the GP and GR do not exceed 1 revolution, so it is judged that they are within the wear limit.
*The wear check ring gauge (GPW) is not specified in JIS and is set by OSG. Please give due consideration before use.

JIS (ISO等级)
JIS (ISO)

上一页
FROM 尺寸 Size M1.4 ~ M14

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug				环规 Ring	
	GW		NW		GPW	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 14 × 1.25	6g	9346097	6g	9346098	—	—
M 14 × 1	6g	9346117	6g	9346118	—	—
M 16 × 2	6g	9346137	6g	9346138	—	—
M 16 × 1.5	6g	9346157	6g	9346158	—	—
M 16 × 1	6g	9346177	6g	9346178	—	—
M 18 × 2.5	6g	9346197	6g	9346198	—	—
M 18 × 1.5	6g	9346217	6g	9346218	—	—
M 18 × 1	6g	9346237	6g	9346238	—	—
M 20 × 2.5	6g	9346257	6g	9346258	—	—
M 20 × 1.5	6g	9346277	6g	9346278	—	—
M 22 × 2.5	6g	9346297	6g	9346298	—	—
M 22 × 1.5	6g	9346317	6g	9346318	—	—
M 24 × 3	6g	9346337	6g	9346338	—	—
M 24 × 1.5	6g	9346357	6g	9346358	—	—
M 25 × 1.5	6g	9346377	6g	9346378	—	—
M 26 × 1.5	6g	9346397	6g	9346398	—	—
M 27 × 3	6g	9346417	6g	9346418	—	—
M 27 × 1.5	6g	9346437	6g	9346438	—	—
M 27 × 1	6g	9346457	6g	9346458	—	—
M 28 × 1.5	6g	9346477	6g	9346478	—	—
M 30 × 3.5	6g	9346497	6g	9346498	—	—
M 30 × 1.5	6g	9346517	6g	9346518	—	—
M 33 × 1.5	6g	9346537	6g	9346538	—	—
M 36 × 1.5	6g	9346557	6g	9346558	—	—

XPM 粉末高速钢螺纹极限量规（LG）

Powder HSS(XPM) limit gauges for screw threads

2级(旧JIS)
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

螺纹尺寸 Thread Size	塞规 Plug GP		环规 Ring GR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 3 × 0.5	2	9340362	2	9340367
M 4 × 0.7	2	9340422	2	9340427
M 5 × 0.8	2	9340472	2	9340477
M 6 × 1	2	9340542	2	9340547
M 8 × 1.25	2	9340612	2	9340617
M 8 × 1	2	9340622	2	9340627

螺纹尺寸 Thread Size	塞规 Plug GP		环规 Ring GR	
	精度 Class	商品号 EDP No.	精度 Class	商品号 EDP No.
M 10 × 1.5	2	9340702	2	9340707
M 10 × 1.25	2	9340712	2	9340717
M 12 × 1.75	2	9340802	2	9340807
M 12 × 1.5	2	9340812	2	9340817
M 12 × 1.25	2	9340822	2	9340827

库存分类全部为●（标准库存品）。
Stock are categolized in section ● (Standard stock item).

※1:颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

硬质合金螺纹极限量规（LG）
Carbide limit gauges for screw threads

2级（旧JIS）
Class 2 (Previous JIS)

公制螺纹(M) Metric screw threads

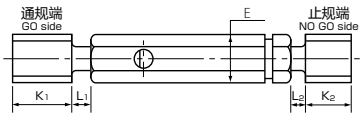
螺纹尺寸 Thread Size	塞规 Plug GP 精度 Class	塞规 Plug GP 商品号 EDP No.
M 1.4 × 0.3	2	9341132
M 1.6 × 0.35	2	9341152
M 1.7 × 0.35	2	9341172
M 1.8 × 0.35	2	9341202
M 2 × 0.4	2	9341222
M 2.5 × 0.45	2	9341312
M 2.6 × 0.45	2	9341332
M 3 × 0.5	2	9341362
M 4 × 0.7	2	9341422

螺纹尺寸 Thread Size	塞规 Plug GP 精度 Class	塞规 Plug GP 商品号 EDP No.
M 5 × 0.8	2	9341472
M 6 × 1	2	9341542
M 8 × 1.25	2	9341612
M 8 × 1	2	9341622
M 10 × 1.5	2	9341702
M 10 × 1.25	2	9341712
M 12 × 1.75	2	9341802
M 12 × 1.5	2	9341812
M 12 × 1.25	2	9341822

※1：颈长·六角形柄形状尺寸请参考P.968 · P.969。
※1：Refer to pp. 968 and 969 for the neck length and handle shape dimensions.

库存分类全部为● (标准库存品)。
Stock are categolized in section ● (Standard stock item).

螺纹用极限量规的颈长/六角形柄形状尺寸 Handle Shape Dimensions



■新JIS(6H、5H)

公制粗牙螺纹：尺寸 M1 ∽ M24 **Metric Coarse screw threads**

(单位：mm) (Unit：mm)

螺纹尺寸 Thread Size	通端 GO		止端 NO GO		六角形柄对角线尺寸 Handle Diagonal Dimension	六角形柄长 Handle Length
	K_1	L_1	K_2	L_2	E	
M 1 ～M 1.8	3.5	4.5	3.5	4.5	5.8	40
M 2 ～M 3	4.5		4.5			
M 3.5 ～M 4.5	6	6	6	6	8.1	48
M 5・M 6	8					
M 7	10	7	6	7	10.4	56
M 8 ～M 10	12		10			
M 11・M 12	16	8	10	8	12.7	63
M 14			12			
M 16	16	10	12	10	16.2	70
M 18	20		16			
M 20	20	12	16	12	19.6	80
M 22	24		16			
M 24	24		20			

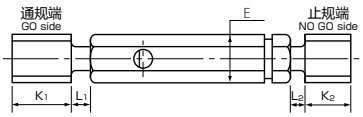
公制细牙螺纹：尺寸 M1 ∽ M24 **Metric Fine screw threads**

(单位：mm) (Unit：mm)

螺纹尺寸 Thread Size	螺距 Pitch	通端 GO		止端 NO GO		六角形柄对角线尺寸 Handle Diagonal Dimension	六角形柄长 Handle Length
		K_1	L_1	K_2	L_2	E	
M1 ～ M3	0.4	3.5	4.5	3.5	4.5	5.8	40
	0.35	3.5		3.5			
	0.25	3.5		3.5			
M3.5	0.35	3.5	6	3.5	6	8.1	48
M4 ～ M5.5	0.5	6		6			
M 6	0.75	6		6			
M 7	0.75	7	7	6	7	10.4	56
M 8・M 9	1	10		6			
	0.75	7		6			
M 10	1.25	12		10			
	1	10		6			
	0.75	7		6			
M 11	1	10	8	6	8	12.7	63
	0.75	8		6			
M 12・M 14	1.5	16		10			
	1.25	12		10			
	1	10		6			
M 15 ～M 17	1.5	16	10	10	10	16.2	70
	1	10		8			
M 18	2	16		12			
	1.5	16		10			
	1	10		8			
M 20	2	16	12	12	12	19.6	80
	1.5	16		12			
	1	12		8			
M 22 ～M 24	2	16		14			
	1.5	16		12			
	1	12		8			

※参考值：根据制造过程的不同，数值可能会略有不同。 Reference Value：Values may vary slightly depending on the manufacturing process.

螺纹用极限量规的颈长/六角形柄形状尺寸 Handle Shape Dimensions



■旧JIS(1、2、3级)

公制粗牙螺纹：尺寸 M1 ∽ M24 **Metric Coarse screw threads**

(单位：mm) (Unit：mm)

螺纹尺寸 Thread Size	通端 GO		止端 NO GO		六角形柄对角线尺寸 Handle Diagonal Dimension	六角形柄长 Handle Length
	K_1	L_1	K_2	L_2	E	
M 1 ～M 2.6	3.5	3	3.5	3	6.9	40
M 3・M 3.5	5		3.5			
M 4 ～M 5	7	6	5	6	9.2	50
M 6 ～M 9	10		7		10.4	70
M 10・M 11	13		10		13.9	75
M 12	17		13			
M 14・M 16	17		13		19.6	80
M 18 ～M 22	25		17			
M 24	32	8	25	8	24.2	90

公制细牙螺纹：尺寸 M1 ∽ M24 **Metric Fine screw threads**

(单位：mm) (Unit：mm)

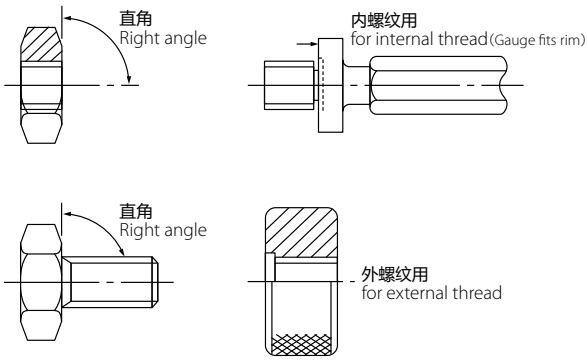
螺纹尺寸 Thread Size	螺距 Pitch	通端 GO		止端 NO GO		六角形柄对角线尺寸 Handle Diagonal Dimension	六角形柄长 Handle Length
		K_1	L_1	K_2	L_2	E	
M1 ～M 3.5	0.35	3.5	3	3.5	3	6.9	40
	0.25	3.5		3.5			
	0.2	3.5		3.5			
M4 ～M 5.5	0.5	5	6	5	6	9.2	50
M 6・M 7	0.75	7		5		10.4	70
M 8・M 9	1	10		7			
	0.75	7		5			
M 10・M 11	1.25	10		7		13.9	75
	1	10		7			
	0.75	7		5			
M 12	1.5	13		10			
	1.25	13		10			
	1	13		10			
M 14 ～M 16	1.5	13		10		19.6	80
	1	13		10			
M 17	1.5	13		13			
	1	13		13			
M 18 ～M 22	2	25		17			
	1.5	17		13			
	1	13		13			
M 24	2	25	8	17	8	24.2	90
	1.5	17		13			
	1	13		13			

※参考值：根据制造过程的不同，数值可能会略有不同。 Reference Value：Values may vary slightly depending on the manufacturing process.

直角用量规
Gauge for right angle

〈被测定工件〉
Workpiece

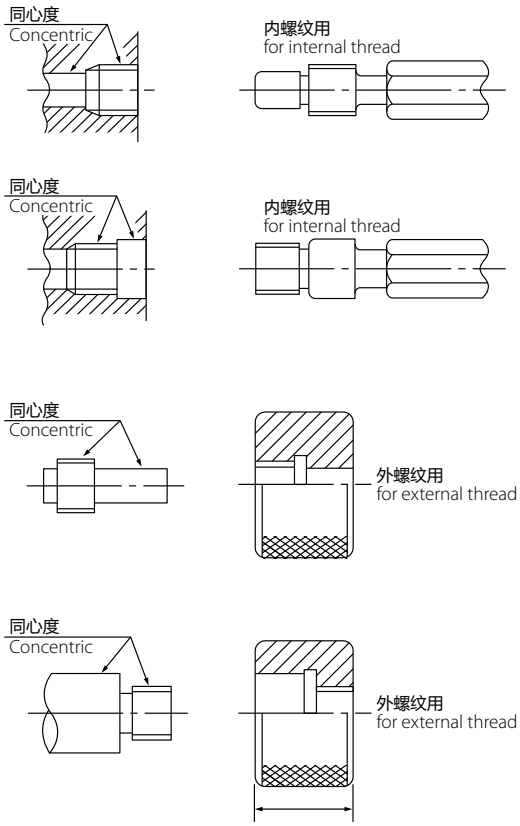
〈使用量规〉
Applied gauge



同心度量规
Gauge for concentricity

〈被测定工件〉
Workpiece

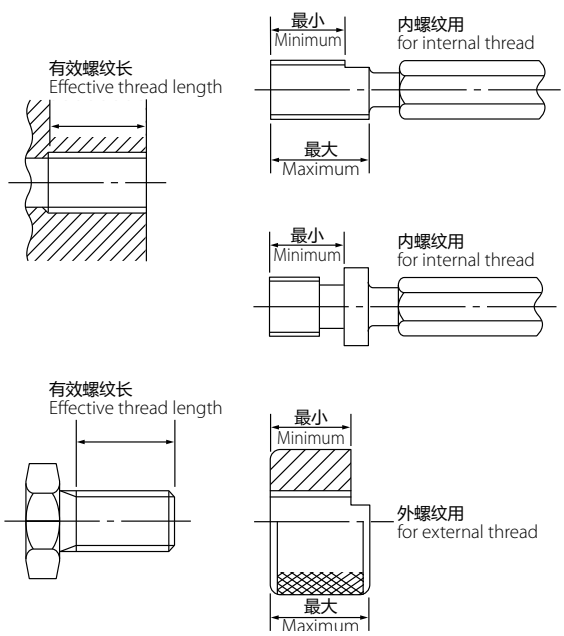
〈使用量规〉
Applied gauge



有效螺纹长测定用量规
Gauge for effective thread length

〈被测定工件〉
Workpiece

〈使用量规〉
Applied gauge



■检查表 Inspection results

量规检查WEB系统

Gauge Inspection Sheet Download

https://www.osg.co.jp/products/gauge/inspection/Gauge_Select.php

ゲージNo.を入力し、検索ボタンをクリックしてください。
请输入量规号，按搜索键
Please input your gauge # and click Search.

ゲージNo. (Gauge#)

言語 (a language) ◉**日本語のみ** (Japanese) ○ **英語のみ** (English) ○ **両方** (Japanese and English)

検索 (Search)

我们可在网上出具检测结果。
We issue inspection results on our website.

■校正证明和可追溯证明 OSG Gauge Calibration Services

OSG提供从螺纹加工到螺纹检测综合的服务。

作为丝锥厂家的优秀的研磨技术，可以实施 "螺纹量规" "极限量规" 的有偿校正服务。

可提供检查结果表 (无偿)、校正证书 (有偿)、可追溯证明 (有偿)。

OSG offers optional "thread gauges" and "plain gauges" calibration services at a fee to provide our clients with a total tooling solution – from making the perfect thread to ensuring that proper tolerances are met.

Inspection report (free), calibration certificate (surcharge), traceability certificate (surcharge) can also be issued.

如有需要，请咨询我司营业人员。

板牙工具

ROUND DIES

PAGE

RD 可调式板牙
ROUND DIES: ADJUSTABLE TYPE FOR GENERAL USE
- (M) 公制螺纹 METRIC — 975～977
- (M) 公制左螺纹 METRIC LH — 978, 979
- (W) 惠式螺纹 WHITWORTH — 979
- (U) 美制螺纹 UNIFY — 980

SPD 平行管螺纹用
ROUND DIES: ADJUSTABLE TYPE FOR PARALLEL PIPE THREADS
- (PS) 平行管螺纹（英式） PS: PREVIOUS JIS — 981
- (PF) 平行管螺纹（英式） PF: PREVIOUS JIS — 981
- (NPS) 平行管螺纹（美式） NPS: ANSI — 981

TPD 锥管螺纹用
ROUND DIES: SOLID TYPE FOR TAPER PIPE THREADS
- (NPT) 锥管螺纹(美式) NPT: ANSI — 981
- (PT) 锥管螺纹(英式) PT: PREVIOUS JIS — 982
- (NPTF) 锥管螺纹耐密用（美式） NPTF: ANSI — 982

A-TPD 可调式锥管螺纹用
ROUND DIES: ADJUSTABLE TYPE FOR TAPER PIPE THREADS
- (PT) 锥管螺纹 （英式） PT: PREVIOUS JIS — 982
- (NPT) 锥管螺纹（美式） NPT: ANSI — 982

高速钢RD，可调式板牙
HSS ROUND DIES: ADJUSTABLE TYPE FOR GENERAL USE
- (M) 公制螺纹 METRIC — 983
- (M) 公制左螺纹 METRIC LH — 984
- (W) 惠式螺纹 WHITWORTH — 984

高速钢SPD，可调式平行管螺纹用
HSS ROUND DIES: ADJUSTABLE TYPE FOR PARALLEL PIPE THREADS
- (PF) 平行管螺纹（英式） PF: PREVIOUS JIS — 984

高速钢TPD，管用锥管螺纹用
HSS ROUND DIES: SOLID TYPE FOR TAPER PIPE THREADS
- (PT) 锥管螺纹（英式） PT: PREVIOUS JIS — 985
- (NPT) 锥管螺纹（美式） NPT: ANSI — 985

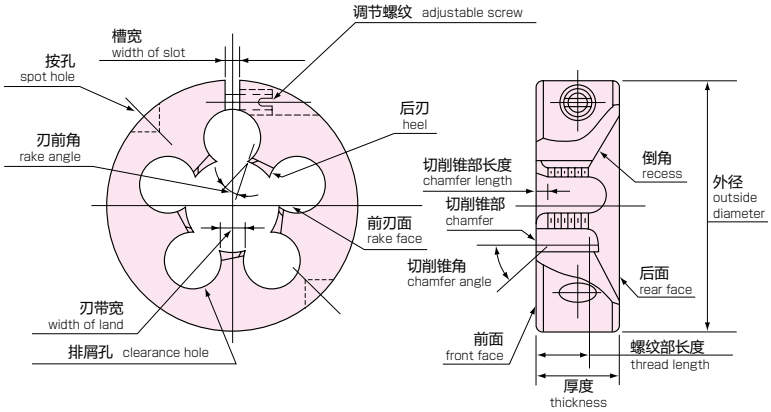
高速钢SUS-SD不锈钢用
HSS SOLID DIES: FOR STAINLESS STEEL
- (M) 公制螺纹 METRIC — 985

- 本样本登载的产品，虽标有库存，但由于新材料、新产品的开发，更改废番的情况也有。
- 式样，形状，表内数值也可能会有变动。
- The inventory status is indicated for respective products on this catalogue. However, the products may be improved or discontinued due to development of new materials and products, etc.
- Specifications, shapes, values in the tables, etc. are subject to change without prior notice.

板牙工具 ROUND DIES

OSG所生产的板牙，以高精度和长寿命而知名，长年的研究经验和顶尖的设备诞生了高品质的产品。有可调式和整体式两种，常用可调式。整体无需调节尺寸，专用于重切削。

OSG round dies are accurate and durable because of our advanced production facilities and many years of technical experience.
We offer dies with slot(Adjustable) and without slot (Solid) . Adjustable dies are more popular, while solid dies are especially suited for heavy cutting conditions without any measurement changes with consistent thread accuracy.



注) 板牙牙数随螺纹尺寸而变化。
Note: The number of teeth varies by thread nominal size.

常用板牙
FOR GENERAL USE
RD

■用途 Applications

作为常用切削螺纹工具，可用于手用和机械用，因带有可调式螺纹因而能够进行尺寸调整。
有SKS，SKH两种材质可供选择

The most common thread cutting dies. Because the thread is adjustable, measurement can be altered. Used by hand as well as by machines.
Available materials include SKS and HSS with excellent wear resistance.

管用螺纹板牙
FOR PIPE THREAD
TPD • A-TPD • SPD

(TPD)

(A-TPD)

■用途 Applications

锥管用板牙，我们库存有整体式和可调式两种。
重切削时整体式尺寸不变较为稳定。而可调式的尺寸会有微调。
（整体式记号：TPD
可调式记号：A-TPD）

For taper pipe thread processing, we stock both solid and adjustable types. The solid type provides stability even in heavy cutting conditions without changes in measurement. The adjustable type allows for minor adjustments of sizes.
Solid type : TPD
Adjustable type : A-TPD

平行管螺纹用板牙，我们库存只有可调式。
(可调式记号：SPD)

The adjustable type die is the only type available for parallel pipe thread.
(Adjustable type : SPD)

不锈钢用板牙
FOR STAINLESS STEELS
SUS-SD

■用途 Applications

以高速钢作为母材，为防止溶着而实施氧化处理。另外，切削锥长及螺纹部长选择最适合于不锈钢的材料，使得工具寿命得到提高。板牙没有沟槽的简单设计使其得到稳定的螺纹精度。

HSS as the tool material, and a steam oxide coating is applied to resist welding.
In addition, the chamfer length and thread length are ideal for stainless steels, These arrangement improves tool life remarkably.
Solid dies do not have a slot. Therefore, thread precision and stability is possible by simple arrangements.

剥离切面
Peeling Cut

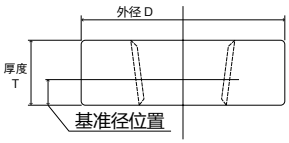
剥离切面是在切削锥部设计螺尖槽，是减少切削扭矩，防止切屑堵塞。
一般用板牙(RD)以及不锈钢用(SUS-SD)的标准品是20径，25径

The Peeling Cut (see diagram below) is a spiral pointed flute on the chamfer of the die that reduces the cutting torque and prevents chip packing.

■形状式样 Specifications

RD・SPD・SUS-SD (单位mm)(Unit:mm)

外径 D	20	25	38	50	57	63	75	100
厚度 T	7	9	13	16	20	20	25	30



TPD PT螺纹 (单位mm)(Unit:mm)

螺纹尺寸 Thread size \ 外径 D	38		50		57		63		75		100	
	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置
PT 1/8	11	5	13	8								
1/4	16	7.5	16	7.5								
3/8	16	8	18	8								
1/2			22	10	22	10						
5/8			22	11	22	11						
3/4			22	11.5	22	11.5	24	11.5				
7/8							24	13				
1							28	13	28	13		
1 - 1/8							28	13				
1 - 1/4							30	17.5	30	15		
1 - 3/8									30	17.5		
1 - 1/2									30	17.5		
1 - 3/4											36	22.5
2											36	22.5

A-TPD PT螺纹 (单位mm)(Unit:mm)

螺纹尺寸 Thread size \ 外径 D	38		50		57		63	
	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置
PT 1/8	13	5						
1/4	13	7.5	16	7.5				
3/8	13	8	16	8				
1/2			16	10	20	10		
3/4			16	11.5	20	11.5	20	11.5
7/8							24	13
1							20	13

TPD NPT螺纹・NPTF螺纹 (单位mm)(Unit:mm)

螺纹尺寸 Thread size \ 外径 D	38		50		57		63		75		100	
	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置	厚度	基准径位置
NPT 1/16	10	5										
1/8	11	6										
1/4	16	8	16	8								
3/8	16	8	18	10								
1/2	18	9	22	11								
3/4			22	11			24	13.5				
1					28	15	28	15				
1 - 1/4							30	17.5				
1 - 1/2									30	17.5		
2											36	22

A-TPD NPT螺纹 (单位mm)(Unit:mm)

螺纹尺寸 Thread size \ 外径 D	38		50	
	厚度	基准径位置	厚度	基准径位置
NPT 1/8	13	5.5		
1/4	13	5		
3/8	13	5		
1/2			16	7
3/4			16	7

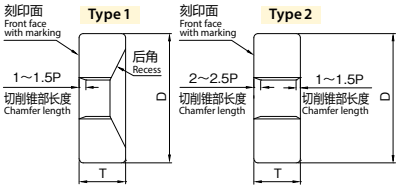
G-LIST No. | SH1001

一般用可调式板牙

Round Dies • Adjustable type for general use

RD(SKS)

公制螺纹 (M) Metric



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46011	20	7	M2 × 0.4	1	
46013			M2.2 × 0.45		
46014			M2.2 × 0.25		
46015			M2.3 × 0.4		
46017			M2.5 × 0.45		
46018			M2.5 × 0.35		
46020			M2.6 × 0.45		
46021			M2.6 × 0.35		
46022			M3 × 0.6	2	
46023			M3 × 0.5		
46024			M3 × 0.35	1	
46025			M3.5 × 0.6	2	
46027			M3.5 × 0.35	1	
46028			M4 × 0.75	2	
46029			M4 × 0.7		
46030			M4 × 0.5		
46031			M4.5 × 0.75		
46033			M5 × 0.9		
46034			M5 × 0.8		
46035			M5 × 0.5		
46037			M5.5 × 0.5		
46038			M6 × 1		
46039			M6 × 0.75		
46040			M6 × 0.5		
46061	25	9	M3 × 0.6	1	●
46062			M3 × 0.5		
46063			M3 × 0.35		
46064			M3.5 × 0.6		
46066			M3.5 × 0.35		
46067			M4 × 0.75	2	
46068			M4 × 0.7		
46069			M4 × 0.5	1	
46070			M4.5 × 0.75	2	
46072			M4.5 × 0.5	1	
46073			M5 × 0.9	2	
46074			M5 × 0.8		
46075			M5 × 0.75		
46076			M5 × 0.5	1	
46077			M5.5 × 0.9	2	
46078			M5.5 × 0.5	1	
46079			M6 × 1	2	
46080			M6 × 0.75		
46081			M6 × 0.5	1	
46082			M7 × 1	2	
46083			M7 × 0.75		
46084			M7 × 0.5	1	
46085			M8 × 1.25	2	
46086			M8 × 1		
46087			M8 × 0.75		
46088			M8 × 0.5	1	
46089			M9 × 1.25	2	
46090			M9 × 1		
46091			M9 × 0.75		

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46092	25	9	M9 × 0.5	1	
46093			M10 × 1.5	2	
46094			M10 × 1.25		
46095			M10 × 1		
46096			M10 × 0.75		
46097			M10 × 0.5	1	
46121	38	13	M5 × 0.9		
46122			M5 × 0.8		
46127			M6 × 1		
46128			M6 × 0.75		
46133			M8 × 1.25	2	
46134			M8 × 1	1	
46135			M8 × 0.75		
46137			M9 × 1.25	2	
46139			M9 × 1	1	
46140			M9 × 0.75		
46141			M9 × 0.5		
46142			M10 × 1.5	2	
46143			M10 × 1.25		
46144			M10 × 1	1	
46145			M10 × 0.75		
46146			M10 × 0.5		
46147			M11 × 1.5	2	
46148			M11 × 1.25		
46149			M11 × 1	1	
46150			M11 × 0.75		
46151			M11 × 0.5		●
46152			M12 × 1.75	2	
46153			M12 × 1.5		
46154			M12 × 1.25		
46155			M12 × 1	1	
46156			M12 × 0.75		
46157			M12 × 0.5		
46158			M13 × 1.75	2	
46159			M13 × 1.5		
46160			M13 × 1	1	
46161			M13 × 0.75		
46162			M13 × 0.5		
46163			M14 × 2	2	
46164			M14 × 1.5		
46165			M14 × 1.25		
46166			M14 × 1	1	
46167			M14 × 0.75		
46168			M14 × 0.5		
46169			M15 × 2	2	
46170			M15 × 1.5		
46171			M15 × 1	1	
46172			M15 × 0.75		
46173			M15 × 0.5		
46174			M16 × 2	2	
46175			M16 × 1.5		
46176			M16 × 1.25		
46177			M16 × 1	1	

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外径 D 38～63 NEXT

●=标准库存品 ●=Standard stock item.

（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46178	38	13	M16 × 0.75	1	
46179			M16 × 0.5		
46191	50	16	M8 × 1.25	2	
46196			M10 × 1.5	1	
46197			M10 × 1.25		
46198			M10 × 1	2	
46204			M12 × 1.75		
46205			M12 × 1.5	1	
46206			M12 × 1.25		
46207			M12 × 1	2	
46210			M13 × 1.75		
46215			M14 × 2		
46216			M14 × 1.5	1	
46217			M14 × 1.25		
46218			M14 × 1	2	
46221			M15 × 2		
46222			M15 × 1.5	1	
46223			M15 × 1.25		
46224			M15 × 1		
46225			M15 × 0.75	2	
46227			M16 × 2		
46228			M16 × 1.5	1	
46230			M16 × 1		
46231			M16 × 0.75		
46232			M16 × 0.5	2	
46233			M17 × 2		
46234			M17 × 1.5	1	
46235			M17 × 1.25		
46236			M17 × 1		
46237			M17 × 0.75		
46238			M17 × 0.5	2	
46239			M18 × 2.5		
46240			M18 × 2		
46241			M18 × 1.5	1	
46242			M18 × 1.25		
46243			M18 × 1		
46244			M18 × 0.75		
46245			M18 × 0.5	2	
46246			M19 × 2		
46247			M19 × 1.5		
46248			M19 × 1	1	
46251			M20 × 2.5	2	
46252			M20 × 2		
46253			M20 × 1.5		
46254			M20 × 1	1	
46255			M20 × 0.75		
46257			M21 × 2.5	2	
46259			M21 × 1.5		
46260			M21 × 1.25	1	
46261			M21 × 1		
46263			M22 × 2.5	2	
46264			M22 × 2		
46265			M22 × 1.5		
46266	50	16	M22 × 1.25	1	
46267			M22 × 1		
46268			M22 × 0.75		
46272			M23 × 2	2	
46273			M23 × 1.5		
46274			M23 × 1	1	
46276			M24 × 3	2	
46277			M24 × 2.5		
46278			M24 × 2		
46279			M24 × 1.5		
46280			M24 × 1.25	1	
46281			M24 × 1		
46282			M24 × 0.5		
46284			M25 × 2	2	
46285			M25 × 1.5		
46286			M25 × 1.25	1	
46287			M25 × 1		
46291			M26 × 2	2	
46292			M26 × 1.5		
46293			M26 × 1	1	
46321	57	20	M24 × 2	2	
46326			M25 × 2		
46329			M26 × 3		
46330			M26 × 2		
46331			M26 × 1.5		
46332			M26 × 1	1	
46334			M27 × 3	2	
46335			M27 × 2		
46336			M27 × 1.5		
46337			M27 × 1	1	
46340			M28 × 2	2	
46341			M28 × 1.5		
46342			M28 × 1	1	
46344			M30 × 3.5	2	
46347			M30 × 1.5		
46374	63		M26 × 3		
46376			M26 × 1.5		
46379			M27 × 3		
46380			M27 × 2		
46381			M27 × 1.5		
46383			M28 × 3		
46384			M28 × 2		
46385			M28 × 1.5		
46386			M28 × 1	1	
46388			M30 × 3.5	2	
46389			M30 × 3		
46390			M30 × 2		
46391			M30 × 1.5		
46392			M30 × 1	1	
46394			M32 × 3	2	
46395			M32 × 2		
46396			M32 × 1.5		
46397			M32 × 1	1	

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外径 D 63～75 NEXT

●=标准库存品 ●=Standard stock item.

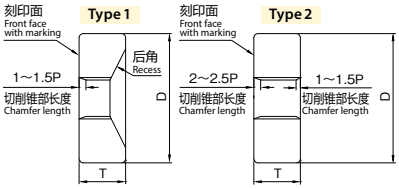
G-LIST No. | **SH1001**

一般用可调式板牙

Round Dies • Adjustable type for general use

RD(SKS)

公制螺纹 (M) Metric



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FROM 外径 D 38～63

（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46399	63	20	M33 × 3.5	2	●
46400			M33 × 3		
46401			M33 × 2		
46402			M33 × 1.5		
46403			M33 × 1	1	
46404			M34 × 3	2	
46405			M34 × 2		
46406			M34 × 1.5		
46407			M34 × 1	1	
46411			M35 × 1.5	2	
46413			M36 × 4		
46414			M36 × 3		
46415			M36 × 2		
46416			M36 × 1.5		
46421			M38 × 1.5		
46429			M40 × 1.5		
46451	75	25	M30 × 3.5		
46452			M30 × 3		
46453			M30 × 2		
46454			M30 × 1.5		
46457			M32 × 1.5	1	
46461			M33 × 1.5		
46463			M34 × 3	2	
46464			M34 × 2		
46465			M34 × 1.5	1	
46467			M35 × 3	2	
46468			M35 × 2		
46469			M35 × 1.5	1	
46470			M35 × 1		
46472			M36 × 4	2	
46473			M36 × 3		
46474			M36 × 2		
46475			M36 × 1.5	1	
46476			M36 × 1		

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46479	75	25	M38 × 4	2	●
46480			M38 × 3		
46481			M38 × 2		
46482			M38 × 1.5	1	
46483			M38 × 1		
46484			M39 × 4	2	
46485			M39 × 3		
46486			M39 × 2		
46487			M39 × 1.5	1	
46488			M39 × 1		
46489			M40 × 4	2	
46490			M40 × 3		
46491			M40 × 2		
46492			M40 × 1.5	1	
46493			M40 × 1		
46494			M42 × 4.5	2	
46495			M42 × 4		
46496			M42 × 3		
46497			M42 × 2		
46498			M42 × 1.5	1	
46499			M42 × 1		
46502			M45 × 4.5	2	
46503			M45 × 4		
46504			M45 × 3		
46505			M45 × 2		
46506			M45 × 1.5	1	
46507			M45 × 1		
46510			M48 × 5	2	
46511			M48 × 4		
46512			M48 × 3		
46513			M48 × 2		
46514			M48 × 1.5	1	
46515			M48 × 1		

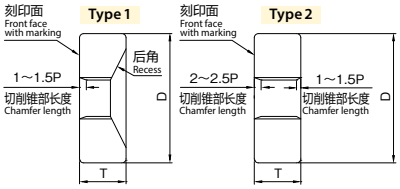
●=标准库存品 ●=Standard stock item.

一般用可调式板牙

Round Dies • Adjustable type for general use

RD(SKS)

公制螺纹 (M) 左螺纹 Metric LH



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46602	20	7	M3 × 0.5 - L	2	
46603			M3 × 0.35 - L	1	
46604			M3.5 × 0.6 - L	2	
46607			M4 × 0.7 - L		
46609			M4.5 × 0.75 - L		
46610			M4.5 × 0.5 - L		
46612			M5 × 0.8 - L		
46614			M5 × 0.5 - L		
46615			M5.5 × 0.9 - L		
46617			M5.5 × 0.5 - L		
46618			M6 × 1 - L		
46619			M6 × 0.75 - L		
46620			M6 × 0.5 - L		
46641	25	9	M2 × 0.4 - L	1	●
46644			M2.2 × 0.25 - L		
46645			M2.3 × 0.4 - L		
46646			M2.3 × 0.25 - L		
46651			M2.6 × 0.45 - L		
46653			M3 × 0.6 - L		
46654			M3 × 0.5 - L		
46655			M3 × 0.35 - L		
46656			M3.5 × 0.6 - L		
46659			M4 × 0.75 - L	2	
46660			M4 × 0.7 - L		
46661			M4 × 0.5 - L	1	
46663			M4.5 × 0.75 - L	2	
46664			M4.5 × 0.5 - L	1	
46665			M5 × 0.9 - L	2	
46666			M5 × 0.8 - L		
46667			M5 × 0.5 - L	1	
46668			M5.5 × 0.9 - L	2	
46670			M5.5 × 0.5 - L	1	
46671			M6 × 1 - L	2	
46672			M6 × 0.75 - L		
46673			M6 × 0.5 - L	1	
46674			M7 × 1 - L	2	
46675			M7 × 0.75 - L		
46676			M7 × 0.5 - L	1	
46677			M8 × 1.25 - L	2	
46678			M8 × 1 - L		
46679			M8 × 0.75 - L		
46680			M8 × 0.5 - L	1	
46681			M9 × 1.25 - L	2	
46682			M9 × 1 - L		
46685			M10 × 1.5 - L		
46686			M10 × 1.25 - L		
46687			M10 × 1 - L		
46688			M10 × 0.75 - L		
46701	38	13	M5 × 0.8 - L	1	
46705			M6 × 1 - L		
46710			M8 × 1.25 - L	2	
46711			M8 × 1 - L	1	
46715			M9 × 1 - L		

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46718	38	13	M10 × 1.5 - L	2	●
46719			M10 × 1.25 - L		
46720			M10 × 1 - L	1	
46721			M10 × 0.75 - L		
46722			M10 × 0.5 - L		
46723			M11 × 1.5 - L	2	
46725			M11 × 1 - L	1	
46726			M11 × 0.75 - L		
46728			M12 × 1.75 - L	2	
46729			M12 × 1.5 - L		
46730			M12 × 1.25 - L		
46731			M12 × 1 - L	1	
46732			M12 × 0.75 - L		
46733			M12 × 0.5 - L		
46734			M13 × 1.75 - L	2	
46735			M13 × 1.5 - L		
46736			M13 × 1 - L	1	
46739			M14 × 2 - L	2	
46740			M14 × 1.5 - L		
46741			M14 × 1.25 - L		
46742			M14 × 1 - L	1	
46745			M15 × 1.5 - L	2	
46747			M15 × 1 - L	1	
46751			M16 × 2 - L	2	
46752			M16 × 1.5 - L		
46754			M16 × 1 - L	1	
46771	50	16	M14 × 2 - L	2	●
46772			M14 × 1.5 - L		
46773			M14 × 1.25 - L		
46774			M14 × 1 - L	1	
46775			M15 × 2 - L	2	
46776			M15 × 1.5 - L		
46777			M15 × 1.25 - L	1	
46778			M15 × 1 - L		
46781			M16 × 2 - L	2	
46782			M16 × 1.5 - L		
46784			M16 × 1 - L	1	
46787			M17 × 2 - L	2	
46788			M17 × 1.5 - L		
46791			M18 × 2.5 - L		
46792			M18 × 2 - L		
46793			M18 × 1.5 - L		
46794			M18 × 1 - L	1	
46796			M19 × 2.5 - L	2	
46800			M20 × 2.5 - L		
46801			M20 × 2 - L		
46802			M20 × 1.5 - L		
46804			M20 × 1 - L	1	
46806			M22 × 2.5 - L	2	
46807			M22 × 2 - L		
46808			M22 × 1.5 - L		
46809			M22 × 1 - L	1	
46811			M24 × 3 - L	2	

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外径 D 50～63 NEXT

●=标准库存品 ●=Standard stock item.

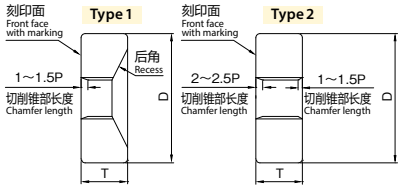
G-LIST No. | SH1001

一般用可调式板牙

Round Dies • Adjustable type for general use

RD(SKS)

公制螺纹 （M） 左螺纹 Metric LH



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FROM 外径 D 20～50

（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46813	50	16	M24 × 2 - L	2	●
46814			M24 × 1.5 - L		
46831	57	20	M27 × 3 - L		
46832			M27 × 2 - L		
46833			M27 × 1.5 - L		
46837			M30 × 3.5 - L		
46839			M30 × 2 - L		
46840			M30 × 1.5 - L		
46861	63		M30 × 3.5 - L		
46863			M30 × 2 - L		
46864			M30 × 1.5 - L		

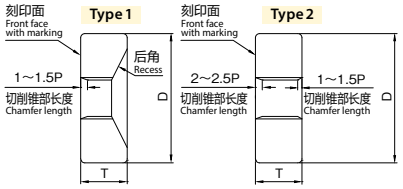
G-LIST No. | SH1001

一般用可调式板牙

Round Dies • Adjustable type for general use

RD(SKS)

惠氏螺纹（W） Whitworth



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
47121	20	7	W1/8 - 40	2	●
47122			W5/32 - 32		
47123			W3/16 - 24		
47124			W1/4 - 20		
47141	25	9	W1/8 - 40	1	
47142			W5/32 - 32	2	
47143			W3/16 - 24		
47144			W1/4 - 20		
47145			W5/16 - 18		
47146			W3/8 - 16		
47151	38	13	W3/16 - 24	1	
47152			W1/4 - 20	2	
47153			W5/16 - 18		
47154			W3/8 - 16		
47155			W7/16 - 14		
47156			W1/2 - 12		
47158			W5/8 - 11		
47171	50	16	W1/4 - 20	1	
47172			W5/16 - 18	2	
47173			W3/8 - 16		
47175			W1/2 - 12		
47177			W5/8 - 11		
47178			W3/4 - 10		
47179			W7/8 - 9		
47180			W1 - 8		
47191	57	20	W1/2 - 12		
47192			W5/8 - 11		
47193			W3/4 - 10		
47194			W7/8 - 9		
47195			W1 - 8		
47196			W1 -1/8 - 7		
47197			W1 -1/4 - 7		
47211	63		W1 -3/8 - 6		
47212			W1 -1/2 - 6		
47221	75	25	W1 -1/2 - 6		
47222			W1 -5/8 - 5		
47223			W1 -3/4 - 5		
47224			W1 -7/8 - 4 -1/2		
47225			W2 - 4 -1/2		
47231	100	30	W2 -1/4 - 4		

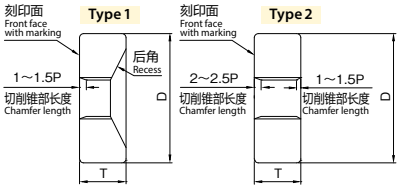
●=标准库存品 ●=Standard stock item.

一般用可调式板牙

Round Dies • Adjustable type for general use

RD(SKS)

美制螺纹 (U) Unify



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46904	20	7	No.2 - 56 UNC	1	
46905			No.2 - 64 UNF		
46906			No.3 - 48 UNC	2	
46907			No.3 - 56 UNF	1	
46908			No.4 - 40 UNC	2	
46909			No.4 - 48 UNF		
46910			No.5 - 40 UNC		
46911			No.5 - 44 UNF		
46912			No.6 - 32 UNC		
46913			No.6 - 40 UNF		
46914			No.8 - 32 UNC		
46915			No.8 - 36 UNF		
46916			No.10 - 24 UNC		
46917			No.10 - 32 UNF		
46918			No.12 - 24 UNC		
46919			No.12 - 28 UNF		
46929	25	9	No.4 - 40 UNC	1	●
46930			No.4 - 48 UNF		
46931			No.5 - 40 UNC		
46932			No.5 - 44 UNF		
46933			No.6 - 32 UNC	2	
46934			No.6 - 40 UNF	1	
46935			No.8 - 32 UNC	2	
46936			No.8 - 36 UNF		
46937			No.10 - 24 UNC		
46938			No.10 - 32 UNF		
46939			No.12 - 24 UNC		
46940			No.12 - 28 UNF		
46941			1/4 - 20 UNC		
46942			1/4 - 28 UNF		
46944			5/16 - 18 UNC		
46945			5/16 - 24 UNF		
46946			5/16 - 32 UNEF		
46961	38	13	1/4 - 20 UNC	2	
46962			1/4 - 28 UNF	1	
46964			5/16 - 18 UNC	2	
46965			5/16 - 24 UNF	1	
46967			3/8 - 16 UNC	2	
46968			3/8 - 24 UNF	1	
46969			3/8 - 32 UNEF		
46971			7/16 - 14 UNC	2	

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
46972	38	13	7/16 - 20 UNF	2	●
46974			1/2 - 13 UNC		
46975			1/2 - 20 UNF		
46976			1/2 - 24 UNS	1	
46977			1/2 - 28 UNEF		
46978			1/2 - 32 UN		
47001	50	16	3/8 - 16 UNC	2	
47002			3/8 - 24 UNF	1	
47004			7/16 - 14 UNC	2	
47005			7/16 - 20 UNF		
47007			1/2 - 13 UNC		
47008			1/2 - 20 UNF	1	
47011			9/16 - 12 UNC	2	
47012			9/16 - 18 UNF		
47014			5/8 - 11 UNC		
47015			5/8 - 18 UNF		
47016			5/8 - 24 UNEF	1	
47018			3/4 - 10 UNC	2	
47019			3/4 - 16 UNF		
47020			3/4 - 20 UNEF	1	
47021			7/8 - 9 UNC	2	
47022			7/8 - 14 UNF		
47023			7/8 - 20 UNEF	1	
47024			1 - 8 UNC	2	
47025			1 - 12 UNF		
47026			1 - 14 UNS		
47027			1 - 20 UNEF	1	
47042	57	20	1 - 1/8 - 12 UNF	2	
47043			1 - 1/4 - 7 UNC		
47044			1 - 1/4 - 12 UNF		
47062	63		1 - 1/4 - 12 UNF		
47066			1 - 3/8 - 6 UNC		
47067			1 - 3/8 - 12 UNF		
47069			1 - 1/2 - 6 UNC		
47070			1 - 1/2 - 12 UNF		
47081	75	25	1 - 3/8 - 6 UNC		
47082			1 - 3/8 - 12 UNF		
47084			1 - 1/2 - 6 UNC		
47085			1 - 1/2 - 12 UNF		
47087			1 - 3/4 - 5 UNC		
47090			2 - 4 -1/2 UNC		

●=标准库存品 ●=Standard stock item.

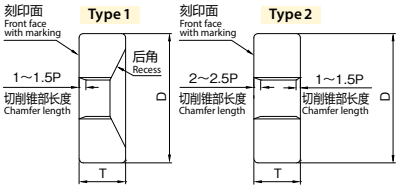
G-LIST No. | SH1004

平行管螺纹用

Round Dies • Adjustable type for parallel pipe threads

SPD(SKS)

平行管螺纹（PS） PS: previous JIS



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
47671	38	13	PS1/8 - 28	1	●
47672			PS1/4 - 19	2	
47673			PS3/8 - 19		
47681	50	16	PS1/8 - 28	1	
47682			PS1/4 - 19	2	
47683			PS3/8 - 19		
47684			PS1/2 - 14		
47685			PS5/8 - 14		
47686			PS3/4 - 14		
47691	57	20	PS3/4 - 14		
47701	63		PS3/4 - 14		
47702			PS7/8 - 14		
47703			PS1 - 11		
47704			PS1-1/8 - 11		
47705			PS1-1/4 - 11		
47711	75	25	PS1 - 11		
47713			PS1-1/4 - 11		
47715			PS1-1/2 - 11		
47721	100	30	PS1-3/4 - 11		
47722			PS2 - 11		

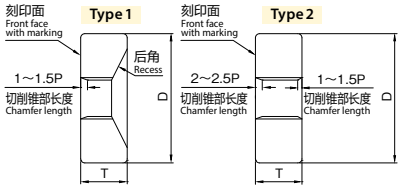
G-LIST No. | SH1004

平行管螺纹用

Round Dies • Adjustable type for parallel pipe threads

SPD(SKS)

平行管螺纹（PF） PF: previous JIS



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
47601	38	13	PF1/8 - 28	1	●
47602			PF1/4 - 19	2	
47603			PF3/8 - 19		
47611	50	16	PF1/8 - 28	1	
47612			PF1/4 - 19	2	
47613			PF3/8 - 19		
47614			PF1/2 - 14		
47615			PF5/8 - 14		
47616			PF3/4 - 14		
47617			PF7/8 - 14		
47621	57	20	PF3/4 - 14		
47622			PF1 - 11		
47631	63		PF3/4 - 14		
47632			PF7/8 - 14		
47633			PF1 - 11		
47634			PF1-1/8 - 11		
47635			PF1-1/4 - 11		
47641	75	25	PF1 - 11		
47644			PF1-3/8 - 11		
47645			PF1-1/2 - 11		
47651	100	30	PF1-3/4 - 11		
47652			PF2 - 11		

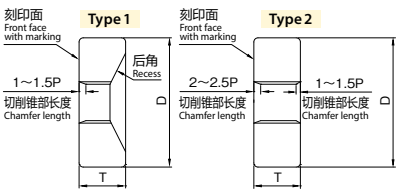
G-LIST No. | SH1004

平行管螺纹用

Round Dies • Adjustable type for parallel pipe threads

SPD(SKS)

平行管螺纹用（NPS） NPS: ANSI



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
47811	38	13	1/8 - 27 NPS	1	●
47812			1/4 - 18 NPS	2	
47813			3/8 - 18 NPS		
47821	50	16	1/2 - 14 NPS		
47822			3/4 - 14 NPS		
47831	57	20	1-11-1/2 NPS		
47841	63		1-1/4-11-1/2 NPS		
47851	75	25	1-1/2-11-1/2 NPS		
47861	100	30	2-11-1/2 NPS		

G-LIST No. | SH1002

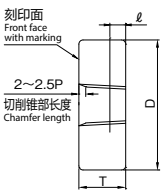
锥管螺纹用

Round Dies • Solid type for taper pipe threads

TPD(SKS)

锥管螺纹用（NPT） NPT: ANSI

整体式 Solid Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
47871	38	10	1/16 - 27 NPT	5	●
47872		11	1/8 - 27 NPT	6	
47873		16	1/4 - 18 NPT	8	
47874			3/8 - 18 NPT		
47881	50	22	1/2 - 14 NPT	11	
47882			3/4 - 14 NPT		
47885	57	28	1 - 11-1/2 NPT	15	
47891	63	24	3/4 - 14 NPT	13.5	
47892		30	1-1/4-11-1/2 NPT	17.5	
47895	75		1-1/2-11-1/2 NPT		
47898	100	36	2 - 11-1/2 NPT	22	

●=标准库存品 ●=Standard stock item.

G-LIST No. | **SH1002**

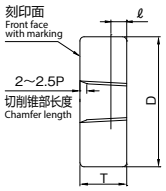
锥管螺纹用

Round Dies • Solid type for taper pipe threads

TPD(SKS)

锥管螺纹用（PT） PT: previous JIS

整体式 Solid Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	基准径位置 ℓ	库存 Stock
47741	38	11	PT1/8 - 28	5	●
47742		16	PT1/4 - 19	7.5	
47743			PT3/8 - 19	8	
47751	50	13	PT1/8 - 28		
47752		16	PT1/4 - 19	7.5	
47753		18	PT3/8 - 19	8	
47754		22	PT1/2 - 14	10	
47755			PT5/8 - 14	11	
47756			PT3/4 - 14	11.5	
47761	57		PT1/2 - 14	10	
47762			PT5/8 - 14	11	
47763			PT3/4 - 14	11.5	
47771	63	24	PT3/4 - 14		
47772			PT7/8 - 14	13	
47773		28	PT1 - 11		
47774			PT1 - 1/8 - 11		
47775		30	PT1 - 1/4 - 11	17.5	
47781	75	28	PT1 - 11	13	
47783		30	PT1 - 1/4 - 11	15	
47784			PT1 - 3/8 - 11	17.5	
47785			PT1 - 1/2 - 11		
47791	100	36	PT1 - 3/4 - 11	22.5	
47792			PT2 - 11		

G-LIST No. | **SH1003**

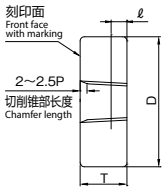
锥管螺纹用

Round Dies • Adjustable type for taper pipe threads

A-TPD(SKS)

锥管螺纹用（PT） PT: previous JIS

可调整式 Adjustable Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	基准径位置 ℓ	库存 Stock
44941	38	13	PT1/8 - 28	5	●
44942			PT1/4 - 19	7.5	
44943			PT3/8 - 19	8	
44952	50	16	PT1/4 - 19	7.5	
44953			PT3/8 - 19	8	
44954			PT1/2 - 14	10	
44956			PT3/4 - 14	11.5	
44961	57	20	PT1/2 - 14	10	
44971	63		PT3/4 - 14	11.5	
44973			PT1 - 11	13	

G-LIST No. | **SH1002**

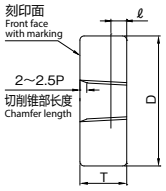
锥管螺纹用

Round Dies • Solid type for taper pipe threads

TPD(SKS)

锥管螺纹用（NPTF） NPTF: ANSI

整体式 Solid Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
47901	38	11	1/8 - 27 NPTF	5	●
47902		16	1/4 - 18 NPTF	8	
47903			3/8 - 18 NPTF		
47904		18	1/2 - 14 NPTF	9	
47912	50	22	3/4 - 14 NPTF	11	
47918	63	28	1 - 11-1/2 NPTF	15	

G-LIST No. | **SH1003**

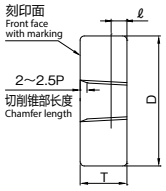
锥管螺纹用

Round Dies • Adjustable type for taper pipe threads

A-TPD(SKS)

锥管螺纹用（NPT） NPT: ANSI

可调整式 Adjustable Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
44871	38	13	1/8 - 27 NPT	5.5	●
44872			1/4 - 18 NPT	5	
44873			3/8 - 18 NPT		
44884	50	16	1/2 - 14 NPT	7	
44886			3/4 - 14 NPT		

●=标准库存品 ●=Standard stock item.

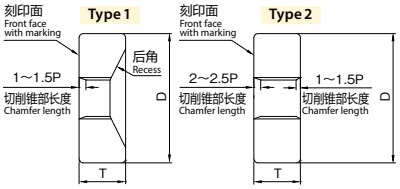
G-LIST No. | **SH1001**

一般用可调式板牙

HSS Round Dies • Adjustable type for general use

RD(HSS)

公制螺纹 (M) Metric



（单位:mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
42011	20	7	M2 × 0.4	1	
42015			M2.3 × 0.4		
42017			M2.5 × 0.45		
42020			M2.6 × 0.45		
42023			M3 × 0.5	2	
42024			M3 × 0.35	1	
42029			M4 × 0.7	2	
42030			M4 × 0.5		
42034			M5 × 0.8		
42035			M5 × 0.5		
42038			M6 × 1		
42039			M6 × 0.75		
42040			M6 × 0.5		
42062	25	9	M3 × 0.5	1	●
42063			M3 × 0.35		
42068			M4 × 0.7	2	
42069			M4 × 0.5	1	
42074			M5 × 0.8	2	
42076			M5 × 0.5	1	
42079			M6 × 1	2	
42080			M6 × 0.75		
42081			M6 × 0.5	1	
42082			M7 × 1	2	
42085			M8 × 1.25		
42086			M8 × 1		
42087			M8 × 0.75		
42088			M8 × 0.5	1	
42089			M9 × 1.25	2	
42093			M10 × 1.5		
42094			M10 × 1.25		
42095			M10 × 1		
42096			M10 × 0.75		
42122	38	13	M5 × 0.8	1	
42123			M5 × 0.5		
42127			M6 × 1		
42128			M6 × 0.75		
42129			M6 × 0.5		
42130			M7 × 1		
42133			M8 × 1.25	2	
42134			M8 × 1	1	

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
42135	38	13	M8 × 0.75	1	
42136			M8 × 0.5		
42137			M9 × 1.25	2	
42142			M10 × 1.5		
42143			M10 × 1.25		
42144			M10 × 1	1	
42145			M10 × 0.75		
42152			M12 × 1.75	2	
42153			M12 × 1.5		
42154			M12 × 1.25		
42155			M12 × 1	1	
42156			M12 × 0.75		
42163			M14 × 2	2	
42164			M14 × 1.5		
42165			M14 × 1.25		
42166			M14 × 1	1	
42174			M16 × 2	2	
42175			M16 × 1.5		
42177			M16 × 1	1	
42191	50	16	M8 × 1.25	2	●
42196			M10 × 1.5		
42204			M12 × 1.75		
42215			M14 × 2		
42216			M14 × 1.5		
42218			M14 × 1	1	
42227			M16 × 2	2	
42228			M16 × 1.5		
42230			M16 × 1	1	
42239			M18 × 2.5	2	
42241			M18 × 1.5		
42251			M20 × 2.5		
42252			M20 × 2		
42253			M20 × 1.5		
42263			M22 × 2.5		
42265			M22 × 1.5		
42276			M24 × 3		
42278			M24 × 2		
42279			M24 × 1.5		
42285			M25 × 1.5		

●=标准库存品 ●=Standard stock item.

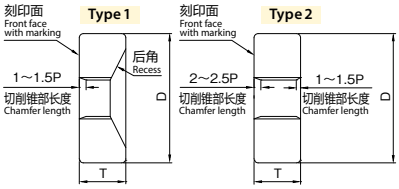
G-LIST No. | **SH1001**

一般用可调式板牙

HSS Round Dies • Adjustable type for general use

RD(HSS)

公制螺纹 (M) 左螺纹 Metric LH



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
42654	25	9	M3 × 0.5 - L	1	●
42660			M4 × 0.7 - L	2	
42666			M5 × 0.8 - L		
42671			M6 × 1 - L		
42710	38	13	M8 × 1.25 - L		
42718			M10 × 1.5 - L		
42728			M12 × 1.75 - L		
42739			M14 × 2 - L		
42751			M16 × 2 - L		
42800	50	16	M20 × 2.5 - L		

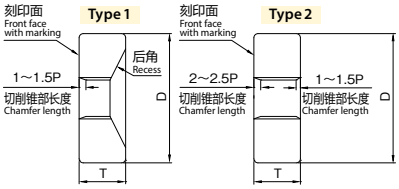
G-LIST No. | **SH1004**

管用平行螺纹用

HSS Round Dies • Adjustable type for parallel pipe threads

SPD(HSS)

平行管螺纹用 (PF) PF: previous JIS



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
43711	38	13	PF1/8 - 28	1	●
43712			PF1/4 - 19	2	
43713			PF3/8 - 19		
43722	50	16	PF1/4 - 19		
43723			PF3/8 - 19		
43724			PF1/2 - 14		
43726			PF3/4 - 14		

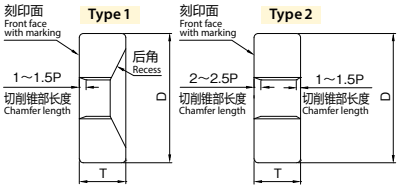
G-LIST No. | **SH1001**

一般用可调式板牙

HSS Round Dies • Adjustable type for general use

RD(HSS)

惠氏螺纹 (W) Whitworth



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	形状 Type	库存 Stock
43141	25	9	W1/8 - 40	1	●
43151	38	13	W3/16 - 24	2	
43152			W1/4 - 20		
43153			W5/16 - 18		
43154			W3/8 - 16		
43156			W1/2 - 12		
43173	50	16	W3/8 - 16		
43175			W1/2 - 12		
43177			W5/8 - 11		
43178			W3/4 - 10		
43179			W7/8 - 9		
43180			W1 - 8		

●=标准库存品 ●=Standard stock item.

G-LIST No. | **SH1002**

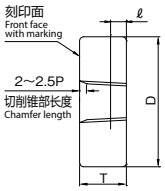
锥管螺纹用

HSS Round Dies • Solid type for taper pipe threads

TPD(HSS)

锥管螺纹用 (PT) PT: previous JIS

整体式 Solid Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	基准径位置 ℓ	库存 Stock
43741	38	11	PT1/8 - 28	5	●
43742		16	PT1/4 - 19	7.5	
43743			PT3/8 - 19	8	
43752	50		PT1/4 - 19	7.5	
43753		18	PT3/8 - 19	8	
43754		22	PT1/2 - 14	10	
43756			PT3/4 - 14	11.5	
43773	63	28	PT1 - 11	13	

G-LIST No. | **SH1002**

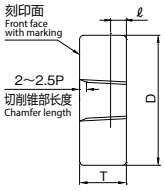
锥管螺纹用

HSS Round Dies • Solid type for taper pipe threads

TPD(HSS)

锥管螺纹用 (NPT) NPT: ANSI

整体式 Solid Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	基准径位置 ℓ	库存 Stock
43872	38	11	1/8 - 27 NPT	6	●
43873		16	1/4 - 18 NPT	8	
43874			3/8 - 18 NPT		
43879	50		1/4 - 18 NPT		
43880		18	3/8 - 18 NPT	10	
43881		22	1/2 - 14 NPT	11	
43882			3/4 - 14 NPT		
43893	63	28	1 - 11 - 1/2 NPT	15	

G-LIST No. | **SH1005**

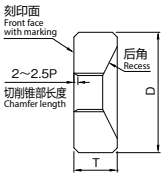
不锈钢用

HSS Solid Dies • for stainless steel

SUS-SD(HSS)

公制螺纹 (M) Metric

整体式 Solid Type



（单位：mm）（Unit:mm）

商品号 EDP No.	外径 D	厚度 T	螺纹	库存 Stock
45611	20	7	M2 × 0.4	●
45615			M2.3 × 0.4	
45617			M2.5 × 0.45	
45620			M2.6 × 0.45	
45623			M3 × 0.5	
45624			M3 × 0.35	
45625			M3.5 × 0.6	
45629			M4 × 0.7	
45630			M4 × 0.5	
45634			M5 × 0.8	
45635			M5 × 0.5	
45638			M6 × 1	
45639			M6 × 0.75	
45640			M6 × 0.5	
45662	25	9	M3 × 0.5	
45663			M3 × 0.35	
45664			M3.5 × 0.6	
45668			M4 × 0.7	
45669			M4 × 0.5	
45670			M4.5 × 0.75	
45674			M5 × 0.8	
45676			M5 × 0.5	
45679			M6 × 1	
45680			M6 × 0.75	
45681			M6 × 0.5	
45682			M7 × 1	
45683			M7 × 0.75	
45684			M7 × 0.5	
45685			M8 × 1.25	
45686			M8 × 1	
45687			M8 × 0.75	
45688			M8 × 0.5	
45689			M9 × 1.25	
45690			M9 × 1	
45691			M9 × 0.75	
45693			M10 × 1.5	
45694			M10 × 1.25	
45695			M10 × 1	
45696			M10 × 0.75	

●=标准库存品 ●=Standard stock item.

滚造工具

ROLLING DIES

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滚造工具式样选择图 MAP FOR ROLLING DIE DESIGN SELECTION	1001
滚造毛坯径表 RECOMMENDED BLANK DIAMETER	1002
六角冲头 TRIMMING DIES	1003

滚造工具的材料中含有钴成分。
There as some rolling dies which include cobalt.

- 本样本登载的产品，虽标有库存，但由于新材料、新产品的开发，更改废番的情况也有。
- 式样，形状，表内数值也可能会有变动。
- The inventory status is indicated for respective products on this catalogue. However, the products may be improved or discontinued due to development of new materials and products, etc.
- Specifications, shapes, values in the tables, etc. are subject to change without prior notice.

滚丝轮 THREAD ROLLING CYLINDRICAL DIES

滚丝轮
THREAD ROLLING CYLINDRICAL DIES

TR

滚丝轮一般可分滚丝机上使用的普通滚丝轮和自动车床上使用的小径滚丝轮两种。请参见P.943

There are two types of cylindrical dies - those used with thread rolling machines and those (with small diameters) used with automatic lathes. For small diameter dies, refer to p.989.

■计算丝轮外径

通过下面的计算式可计算出滚丝轮外径

$D = d_2N + 2ha$

ha ＝被滚造螺纹的牙底高，也等于滚丝轮上的螺纹的牙顶高。

d_2 ＝被滚造外螺纹的中径。

N ＝为整数值，需使滚丝轮操作便利，经济实用。必须在各自设备的限定范围之内选择。

＊Calculation of outer diameters of thread rolling cylindrical dies.

$D = d_2N + 2ha$

ha ：a value of the deddendum of the thread to be rolled, which is equivalent to the addendum of the die thread.

d_2 ：pitch diameter of the external screw to be rolled.

N ：Number of Starts of die.

■制作范围 Production Capability Range

外径 Outer Dia. －MAX. 370mm

宽度 Width －MAX. 300mm

螺距 Pitch －MIN. 0.15mm 160牙/英寸 (T.P.I)

■JIS (B4501) 分类 Classifications based on JIS(B4501)

JIS记号分类	最大外径(mm)	滚造螺纹范围		对应滚丝机的主要类型
		公制螺纹用	美制统一螺纹用	

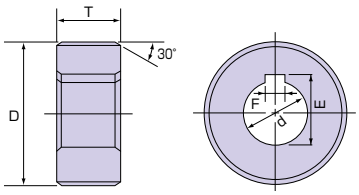
JIS type No.	Max O.D. of die (mm)	Thread to be rolled		Typical thread rolling machine
		Metric	Unified	
1	60	M 3～M 6	No.3～48UNC～¼-20UNC	FA-3S、FA-3SN
2	100	M 3～M16	No.6～32UNC～⅝-11UNC	FA-5S
3	140	M 3～M22	No.6～32UNC～⅞-90UNC	A5D、5D、TR、FA-6U、FA-10
4	160	M 3～M48	No.6～32UNC～2-4½0UNC	TR-Ⅱ、KTR-7
5	170	M 5～M56	No.10～24UNC 2¼-4½0UNC	15D、20D、TK、FA-15、FA-16、FA-20、KTR12、KTR20
6	210	M10～M68	⅜-16UNC ～2½-4UNC	25D、TRⅢ

关于搓丝板的圆弧倒角和材质请参见P.954。
For details on Radius Run-out and die material, refer to p.1000.

■滚丝轮的形状和种类 Specifications and types of Thread Rolling Cylindrical Dies

滚丝机制造厂家 Thread rolling machine bullders	型号 Types		被滚造螺纹尺寸 Work Thread			滚丝轮尺寸 Die specifiations				轴间距离 Spindle distance	
	机种名 Model	JIS 型式 JIS type No.	最大外径 Max. O.D.	最大长度 Max. length	最大螺距 Max. pitch	外径 Outer dia	最大宽度 Max. width	孔径 Bore dia.	键槽宽度 × 键高 key-way width × key-way depth	最小 minimum	最大 maximum
日精 Nissei Co.,Ltd.	FA-3S	1	6	30	1	～ 60	30	26.05	—	58	63
	FA-3SN	1	6	28	1	～ 60	30	26.05	5 × 28.55	58	63
	FA-5S	2	14	48	2	～ 100	50	40	6 × 43.5	84	115
	FA-6U	3	45	80	2.5	～ 150	80	54	12 × 59.2	125	180
	FA-6UN	3	35	75	2.5	～ 150	80	54	12 × 59.2	125	190
	FA-10	3	35	80	3.5	～ 140	80	54	12 × 59.2	125	175
	FA-10N	3	35	75	3	～ 140	80	54	12 × 59.2	125	175
	FA-15	5	50	180	5	～ 180	180	54	12 × 59.2	125	235
	FA-15U	5	30	145	6	～ 180	150	54	12 × 59.2	125	235
	FA-16	5	60	145	5	～ 160	150	54	12 × 59.2	135	240
	FA-20	5	100	200	8	～ 200	200	70	15 × 77.5	130	300
	FA-20U	5	100	145	8	～ 180	150	54	15 × 59.2	145	300
	FA-30		100	300	12	～ 300	300	85	18 × 92	190	350
	FA-30U		100	295	12	～ 240	300	85	18 × 92	190	370
	FA-50		100	245	15	～ 300	250	85	18 × 92	170	400
	COMET500	4	10	500	1.5	～ 160	40	54	12 × 59.2	130	180
津上 Tsugami Corp.	5D	3	30	60	2	125 ～ 150	60	54	12 × 59.2	125	180
	T-ROL6（A5D）	3	45	60	2.5	125 ～ 149	60	54	12 × 59.2	125	180
	R6A	3	45	60	2.5	125 ～ 150	60	54	12 × 59.2	125	180
	T-ROL15（15D）	5	100	150	5	135 ～ 180	150	54	12 × 59.2	135	250
	R15A	5	75	150	5	135 ～ 180	150	54	12 × 59.2	135	250
	T-ROL20(20D) ※	5	100	150	8	135 ～ 200	150	54	12 × 59.2	135	265
		5	100	180	8	135 ～ 200	180	70	14 × 74.5	135	265
	R20A※	5	75	150	8	135 ～ 180	150	54	12 × 59.2	135	250
		5	100	200	8	135 ～ 180	200	70	14 × 74.5	135	250
	T-R0L25（25D）	6	100	300	12	165 ～ 210	300	85	18 × 92	165	295
	T-ROL50（50D）		100	250	15	185 ～ 300	250	100	24 ×109	180	420
	T-ROL60(60D) ※		100	250	15	～ 300	250	85	18 × 92	180	420
			100	250	15	～ 300	250	100	24 ×109	180	420
	T-ROL80（80D）		150	300	15	～ 300	300	100	24 ×109	205	430
共荣精工 Kyoei Seiko Co., Ltd.	KTR-7	4	45	100	2.5	～ 160	100	54	12 × 59.2	125	200
	KTR-12	5	50	150	3	～ 180	150	54	12 × 59.2	125	205
	KTR-20※	5	100	180	8	～ 220	180	54	12 × 59.2	160	280
		5	100	180	8	～ 220	180	70	15 × 77.5	160	280
	KTR-20S※		100	180	10	～ 220	180	75	15 × 82.5	160	280
			100	180	10	～ 220	180	85	18 × 92	160	280
	KTR-35※		100	300	12	～ 250	300	75	15 × 82.5	175	350
			100	300	12	～ 250	300	85	18 × 92	175	350
森光机工 Morimitsu Kiko	ROTAX-KM-01	1	6	30	1	～ 62	30	26	5 × 29	57	65
	ROTAX-KM-1	2	20	60	2	～ 100	60	40	6 × 43.5	84	120
	ROTAX-KM-6		45	80	2.5	～ 150	80	54	12 × 59.2	128	180
	ROTAX-KM-2	5	50	100	3.5	～ 180	100	54	12 × 59.2	125	200
	ROTAX-KM-3	5	60	180	5	～ 180	180	54	12 × 59.2	130	240
	ROTAX-KM-20		100	200	8	～ 200	200	70	15 × 75.2	150	260
	D8-500		10	500	1.5	～ 160	38	72	12 × 77.5		
	D10-700		10	700	1.5	～ 170	38	80	18 × 86		
	D10-1050		10	1,050	1.5	～ 170	38	80	18 × 86		
	D10-1500		10	1,550	1.5	～ 170	38	80	18 × 86		
			10	1,500	1.5	～ 170	155	65	12 × 70.5		
	D10-3000		10	3,000	1.5	～ 170	38	80	18 × 86		
	D10-4000		10	4,000	1.5	～ 170	38	80	18 × 86		
斯巴鲁精工 Subaru Seiko Co., Ltd.	SA-ACE		10		1.5	94 ～ 102	35	40	6 × 43.5	100	
	SA-5		18		2.5	94 ～ 102	50	40	6 × 43.5	110	
	SA-10B		25		3	～ 140	60	54	12 × 59.2	150	
	SA-10		35		3.5	～ 140	60	54	12 × 59.2	165	
	SR-1		8		1.25	～ 100	40	40	6 × 43.5	100	
	SR-5		16		2	94 ～ 102	50	40	6 × 43.5	110	
	SR-1X		12		1.75	～ 100	40	40	6 × 43.5	100	

打※的有2种孔径，请在订货时说明。
※ There are two type of bore die. Specify your requirements when you order.



D：外径 **Outer Dia.**
T：宽度 **Width**
d：孔径 **Bore Dia.**
E：键高 **depth of key way**
F：键槽宽度 **width of key way**

小径滚丝轮 THREAD ROLLS

螺纹滚造装置用滚丝轮
THREAD ROLLS FOR THREAD ROLLING ATTACHMENT

TR-2E

螺纹滚造装置使用在多轴自动车床上，相对与工件，滚造装置与其成直角，并沿此方向移动以加工。滚造螺纹、滚丝轮通常使用2个为1副，也有使用一个的。

Thread rolling attachment are often used on multi-spindle automatic lathes.
The attachment moves at a right angle to the workpiece in order to imprint the thread.

螺纹滚造头用滚丝轮
THREAD ROLLS FOR END ROLLING HEADS

TR-3E

用螺纹造头，使一端被夹持的工件吃入滚丝轮中，利用步动式滚造螺纹。加工完成后，滚丝轮张开，工件不用逆转即可取出。滚丝轮3支为一套。

End rolling heads are designed for through feed thread rolling, during which the cylindrical dies make contact with one end of the workpiece. At the end of the rolling process, the distance between the dies increases, thus allowing for easy unloading of the work material, without reversal.

蜗杆滚轧轮 CYLINDRICAL DIES FOR WORMS

蜗杆滚轧轮
CYLINDRICAL DIES FOR WORMS

TR-WR

滚轧蜗杆与滚造螺纹相比时导向角都要大，毛胚的流动性差，因此在滚轧中受到强大的压力。作为滚轧轮，必须韧性好，精度高。

Worm forming involves larger pitches and lead angles. and often requires higher pressure than many thread rolling operations. These cylinders must therefore be extremely tough and accurate.

■制作范围 **Production Capability Range**

外径 Outer Dia.	－MAX. 370mm
宽度 Width	－MAX. 300mm
模数 Module	－MIN. 0.15

花键滚轧轮
CYLINDRICAL DIES FOR SPLINE

SR

ＯＳＧ的花键滚扎轮集合了最高的研磨技术，与铣齿加工相比，花键滚轧可得到更好的精度，赤面粗糙度，而且，加工效率也可显著提高。

OSG also manufactures cylindrical dies for splines finished by grinding operations. In operations for involute spline for automotive parts, these dies provide unprecedented accuracy and finished surface that cannot be achieved with conventional cylindrical dies.

■花键滚轧的范围　Capability Range of Spline Rolling

加工方法 Rolling method	机种 Used Rolling machines	最大模数 Max.Module	最小齿数 Min.No.of teeth
径向滚轧 In-feed roling	T-ROL6, T-ROL15, FA10	0.75	18
径向 轴向同时滚轧 Thru-feed rolling with a hydraulic actuation system	T-ROL25, FA30	2.0	16
（搓齿） (Rack type rolling)		1.75	14

■常见滚轧机的规格　Dimensions and types of Cylindrical Dies for Spline

滚轧机厂家 Rolling machine builders	机种名称 Models	加工工件 (mm) Workpiece 外径 Outer Dia.	最大长 Max.Length	滚轧轮 Spline Rollers (SR) 齿距（模数） Pitch(module)	外径 Outer Dia.	宽度 Width
津上 Tsugami Corp.	5D	3～ 30	60	0.5 ～2 (0.2 ～0.6)	125～150	30～60
	T-ROL 6(A5D)	3～ 45	60	0.5 ～2.5 (0.2 ～0.75)	125～150	30～60
	R6A	3～ 45	60	0.5 ～2.5 (0.2 ～0.75)	125～150	30～60
	T-ROL15(15D)	3～100	150	0.5 ～2.5 (0.2 ～0.75)	135～180	30～150
	R15A	3～ 75	150	0.5 ～2.5 (0.2 ～0.75)	135～180	30～150
	T-ROL20(20D)	3～100	150	0.5 ～2.5 (0.2 ～0.75)	135～200	40～150 (180)
	R20A	3～ 75	150	0.5 ～2.5 (0.2 ～0.75)	135～200	40～150 (180)
	T-ROL25(25D)	4～100	200	0.7 ～3 (0.2.5 ～ 1)	165～210	40～200
大阪工作所 Osaka Kosakusho Ltd.	TR	4～ 40	65	0.5～2 (0.2～0.6)	110～140	30 ～ 65
	TRⅡ	3～ 50	120	0.5～2.5 (0.2～0.6)	110～180	30 ～120
	TK	7～ 75	180	0.5～2.5 (0.2～0.75)	110～170	40 ～180
日精 Nissei Co.,Ltd.	FA-10	4～ 35	75	0.5～2 (0.2～0.6)	～140	40 ～175
	FA-10N	3～ 35	75	0.5～3 (0.2～0.9)	～140	40 ～ 80
	FA-15	4～ 60	150	0.5～2.5 (0.2～0.75)	～180	40 ～180
	FA-15U	4～ 30	145	0.5～4 (0.2～1.25)	～180	40 ～150
	FA-20	4～100	150	0.5～2.5 (0.2～0.75)	～200	40 ～180
	FA-20U	4～100	150	0.5～8 (0.2～2.5)	～180	40 ～150

由于比一般的螺纹滚造所需要的压力大，请选择强压力的滚轧机（通常15D以上）
Note:Increased rolling pressure. Use rolling machines with high pressure(Usually model 15D or larger is most suitable.)

■制作范围　Production Capability Range

外径 Outer Dia　－MAX. 250mm

宽度 Width　－MAX. 250mm

孔径 Bore Dia.　－MAX. 100 mm

齿距 Pitch　－MAX.　6 mm　MIN.　0.3mm

模数 Module　－MAX.　2　MIN.　0.1

滚轧轮用材质请参考 P954。
For details on die material, refer to p.1000.

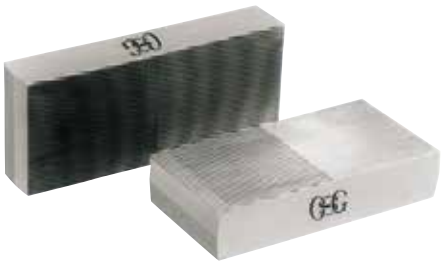
搓丝板 THREAD ROLLING FLAT DIES

搓丝板
THREAD ROLLING FLAT DIES

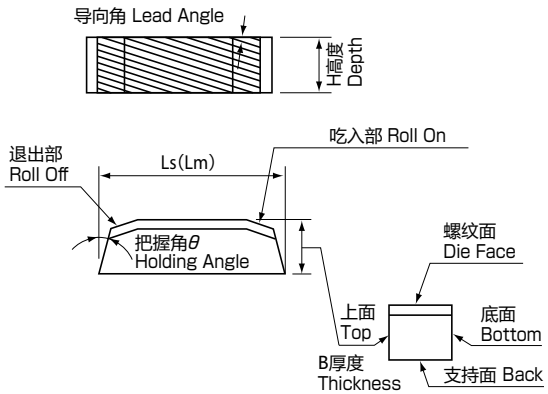
DP

搓丝板的形状有多种多样，OSG公司将其中常用形状作为标准规格，以备半成品，因此交货迅捷。

We offer a wide variety of flat dies with different specifications. OSG prepares many semi-finished, standard form flat dies for stock in order to ensure faster delivery.



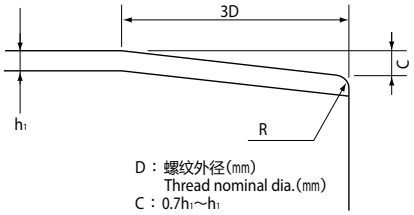
■各部分的名称和形状尺寸 (JIS B4502 规定)
Terminology and dimensions
(In accordance with JIS B4502)



Ls ＝固定端长度　Length of the Stationary Die
Lm＝移动端长度　Length of the Moving Die

■吃入部和退出部　Roll On and Roll Off

OSG 标准形状 (吃入部与退出部兼用)
OSG standard (combined use as a Roll On and as a Roll Off)



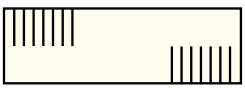
1. 由于一般会将其对调使用，因此两侧都有切削部，并兼有退出部。
2. 仅固定侧兼有切削部与退出部。
3. 切削部为了防滑采取了衍磨处理。
4. 切削部的倒角部分有一定的圆弧角。

1.Because they are reversible, both edges of the standard type have a Roll On, which can also be used as a Roll Off.
2.Only stationary dies have a standardized Roll On and Roll Off.
3.Honing processed Roll On for slip prevention.
4.Adequate radius is provided in chamfering the Roll On.

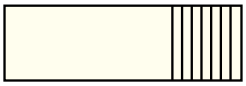
■防滑纹
Slip-prevention serration

请注意在希望场所附属，反转用或是一方使用的。
This specification is not included in standard dies. Please specify at time of order whether you need the double or single setting.

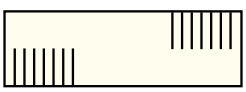
防滑型 A 型
反转使用
Serration A type
(For double setting use)



防滑型B型
单向使用
Serration B type
(For single setting use)



防滑型C型
特殊用
Serration C type
(For special setting use)



■调整螺距
Matching the Dies

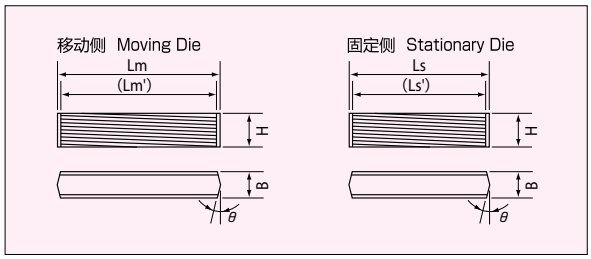
为缩短操作安装时间，可按1/2螺距。
For reduced setup time, matched dies are also available.

■制作范围
Production Capability Range

长度 Length	－MAX. 450mm
厚度 Thickness	－MAX. 120mm
高度 Depth	－MAX. 300mm
螺距 Pitch	－MIN. 0.25mm 100牙/英寸 (T.P.I)

关于搓丝板的圆弧倒角和材质请参见P.1000。
For details on Radius Run-out and die material, refer to p.1000.

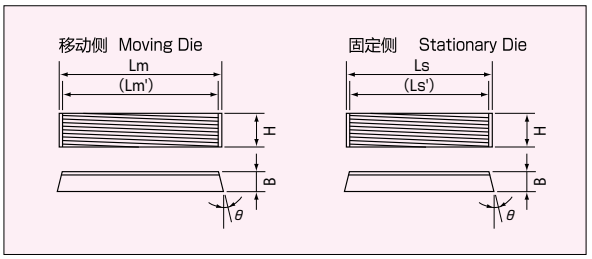
■附有把握角的双面搓丝板
Duplex face Dies (with holding angle)



（单位 UNIT:mm）

机种 Type			长度 Length		厚度 Thickness	高度 Depth	把握角 Holding Angle
大日 Dainichi	Waterbury (W·F·F)	Hartford (H·F)	Lm(Lm')	Ls(Ls')	B	H	θ
	00		52.3(50.8)	46.0 (44.5)	17.5	15.9	5°
						28.6	
DR-125A	0	0-400	84.4(82.6)	71.7 (69.9)	20.6	19.1	5°
						31.8	
						41.3	
DRS-200 DRS-200A	1015		103.4 (101.6)	90.7 (88.9)	20.6	31.8	5°
						41.3	
DRS-250 DRS-250A	10	10-300	129.1 (127.0)	110.1 (108.0)	23.8	28.6	5°
						41.3	
						54.0	
DRS-375 DRS-375A	20	20-225	174.1 (171.5)	155.0 (152.4)	30.2	41.3	5°
						54.0	
						66.7	
						79.4	
DR-500A	30		219.1 (215.9)	193.7 (190.5)	36.5	50.8	5°
						69.9	
						104.8	
DR-625	40		257.8 (254.0)	232.4 (228.6)	42.9	66.7	5°
						82.6	
DR-750	50		309.1 (304.8)	283.7 (279.4)	49.2	104.8	5°
						117.5	

■附有把握角的单面搓丝板
Single face Dies (with holding angle)



（单位 UNIT:mm）

机种 Type	长度 Length		厚度 Thickness	高度 Depth	把握角 Holding Angle
三明制作所 Sanmei Seisakusyo Co.,Ltd	Lm(Lm')	Ls(Ls')	B	H	θ
THI—4R	70	60	20	25	0°
THI—6R	105	90	25	32	0°
THI—R875	140	125	25	40	0°
THI—10R	150	135	40	40	0°
THI—12R	203	190	38	50	0°
THI—16R	280	260	40	50	0°
THI—18R	310	280	50	50	0°
THI—20R	330	300	60	60	0°
THI—22R	350	320	60	60	0°
THI—25R	450	400	60	85	0°
THI—R2000	220	200	38	50	0°
THI—12AL	370	350	38	50	0°

（单位 UNIT:mm）

机种 Type	长度 Length		厚度 Thickness	高度 Depth	把握角 Holding Angle
国家标准 National(MBM)	Lm(Lm')	Ls(Ls')	B	H	θ
1/4	129.8(127.0)	110.8(108.0)	15.9	38.1	5°
5/16	148.9(146.1)	129.8(127.0)	15.9	38.1	5°
				44.5	
3/8	174.3(171.5)	155.2(152.4)	15.9	38.1	5°
				50.8	
1/2	219.5(215.9)	194.1(190.5)	20.6	38.1	5°
				50.8	
				63.5	
5/8	257.9(254.0)	232.5(228.6)	22.2	50.8	5°
				57.2	
				63.5	
				76.2	
3/4	309.2(304.8)	283.8(279.4)	25.4	50.8	5°
				57.2	
				69.9	
				82.6	

自攻螺丝用搓丝板 THREAD ROLLING FLAT DIES FOR TAPPING SCREWS

自攻螺丝用搓丝板
THREAD ROLLING FLAT DIES FOR TAPPING SCREWS

T-DP

自攻螺丝可自行攻入，而无须螺母。

These are flat dies for self tapping screws. Because there are many types of tapping screws, the flat rolling dies differ accordingly.

■自攻螺丝种类
Different tapping screws

形状 Shape	新JIS New JIS	旧 JIS Previous JIS	USA	备注 Remarks	尺寸 Size Samples JIS	尺寸 Size Samples USA
	C形 Type C	—	—	—	ST4.2-1.4	—
	F形 Type F	—	—	—	ST4.2-1.4	—
	—	1种 Type 1	—	尽量不用 Seldom Used	4-16	—
	—	2种 Type 2	—	新旧相同规格 Same between previous+new JIS	4-18	—
	—	3种 Type 3	(C形) Type C	JIS-公制尺寸 (USA-公制尺寸) JIS:metric size (USA-inch size)	M4×0.7	No.8-32 No.8-36
	—	4种 Type 4	—	ISO导入尺寸 ISO compatible size	4-18	—
	—	AB Type AB	AB形 Type AB	ISO导入尺寸 ISO compatible size	4.2-18	No.8-18
	—	B Type B	B形 Type B	ISO导入尺寸 ISO compatible size	4.2-18	No.8-18
	—	—	A形 Type A	尽量不用 Seldom Used	—	No.8-15

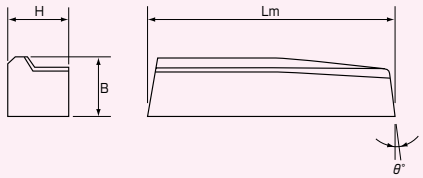
■特殊自攻螺丝的种类和使用搓丝板
Types of special tapping screws and appropriate Flat Dies

形状 Shape	形式 Type of Screw	使用搓丝板 Type of Die used	搓丝板种类 Die types
	Wood screw	Gimlet Point Dies Cut Threaded	Single Face
	Coach screw	Gimlet Point Dies Cut Threaded	Single Face
	BP	Ground Dies (Equivalent to type B.Type 2)	Single Face Duplex Face
	CA	Gimlet Point Dies Cut Threaded	Single Face
	F	Taper Thread Point dies and Tapered Fluting insert	Single Face
	F "Paint Scraper"	Ground Dies and Straight Fluting insert	Single Face Duplex Face
	BF	Taper Thread Point dies and Tapered Fluting insert	Single Face
	(BF)	Ground Dies and Straight Fluting insert	Single Face Duplex Face
	Tap Tight	Taper Thread Point dies	Single Face
	U (Drive screw)	Ground Dies	Single Face Duplex Face

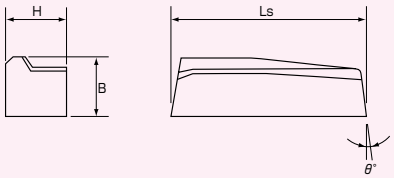
自攻螺丝用搓丝板 THREAD ROLLING FLAT DIES FOR TAPPING SCREWS

■形状规格 Specifications

移动侧 Moving Die



固定侧 Stationary



■没有把握角 Without holding angle

(单位 UNIT:mm)

形状 Die specitications				
长度 Length		厚度 Thickness	高度 Depth	把握角 Holding Angle
Lm	Ls	B	H	θ
60	45	20	20	0°
75	63	20	20	0°
			25	
			32	
95	82	25	25	0°
			32	
			40	
105	90	25	32	0°
			40	
125	110	25	32	0°
			40	
			51	
140	125	25	32	0°
			40	
			51	
170	150	32	40	0°
			51	

■有把握角 With holding angle

(单位 UNIT:mm)

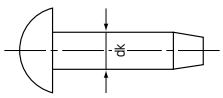
机种 Types			形状 Die specitications				
大日铁工 Dainichi Machinery Works Co.,Ltd.	Waterbury	Hartford	长度 Length		厚度 Thickness	高度 Depth	把握角 Holding Angle
	WFF	HF	Lm	Ls	B	H	θ
(DR-75)	00	——	53.9	47.6	17.5	15.9	5°
DR-125A	0	0-400	86.2	73.5	20.6	19.1	5°
						31.8	
						41.3	
DRS-200 DRS-200A	1015	——	105.2	92.5	20.6	19.1	5°
						31.8	
						41.3	
DRS-250 DRS-250A	10	10-400	131.2	112.2	23.8	28.6	5°
						41.3	
						54.0	
DRS-375	20	20-225	176.8	157.7	30.2	41.3	5°
DRS-375A						54.0	

■毛坯直径表 Blank diameters

〈JIS 1种〉 JIS Type 1

(单位 UNIT:mm)

尺寸	2-32	2.3-32	2.6-28	3-24	3.5-18	4-16	4.5-14	5-12	6-10	8-9
dk	1.72	1.88	2.11	2.43	2.81	3.22	3.58	3.96	4.77	6.41



〈USA A形〉 USA Type A

(单位 UNIT:mm)

尺寸	0-40	1-32	2-32	3-28	4-24	5-20	6-18	7-16	8-15	10-12	12-11	14-10	16-10
dk	1.16	1.44	1.75	2.08	2.30	2.55	2.81	3.14	3.30	3.72	4.40	5.06	5.53

〈USA AB形〉 USA Type AB

(单位 UNIT:mm)

尺寸	0-48	1-42	2-32	3-28	4-24	5-20	6-20	7-19	8-18	10-16	12-14	¼-14	⅝-12
dk	1.15	1.48	1.75	2.03	2.30	2.57	2.80	3.13	3.33	3.82	4.39	5.14	6.60

此表仅为计算值，必须进行试加工以确定最佳值。
The blank information given here is spproximate and all blank diameters should be confirmed with test rolls before producing large quantities.

■自攻螺丝1型、4型、A 型、AB型专用搓丝板的特长
Features of flat dies for Type 1, Type 4, Type A, and Type AB Tapping screws.

1. 锋利的顶尖部分 **Sharp Point**
   由于表面形状设计独到，不需要以往对搓丝板的手动修磨即可获得锋利的顶尖。
2. 安装简单 **Easy Setup**
   由于不需要对表面进行修磨，各螺距咬合正确，所以大幅度缩短了安装时间。
3. 稳定的寿命 **Excellent durabillity**
   此类搓丝板要求具备韧性和耐磨性，因此对热处理的要求较高。OSG的转造工具利用常年积累的热处理经验，寿命稳定长久。

■制作可能范围(制作范围)
Production Capability Range

长度 Length	－MAX. 350mm
厚度 Thickness	－MAX. 52mm
高度 Depth	－MAX. 200mm
螺距 Pitch	－MIN. 0.3mm
导向角 Lead Angle	－MAX. 30° Max.30°

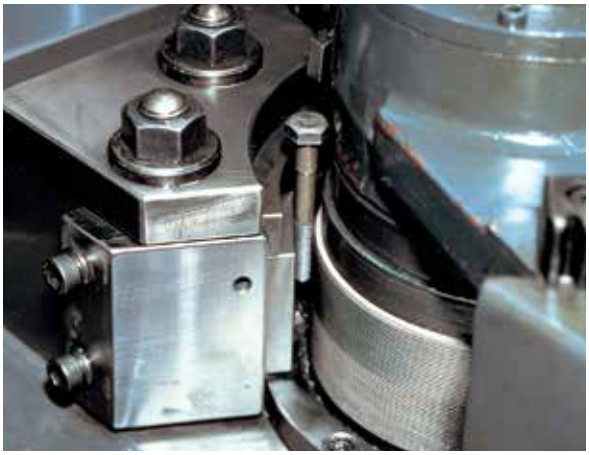
旋转式滚丝轮 THREAD ROLLING PLANETARY DIES

旋转式滚丝轮
THREAD ROLLING PLANETARY DIES

RCD·RSD

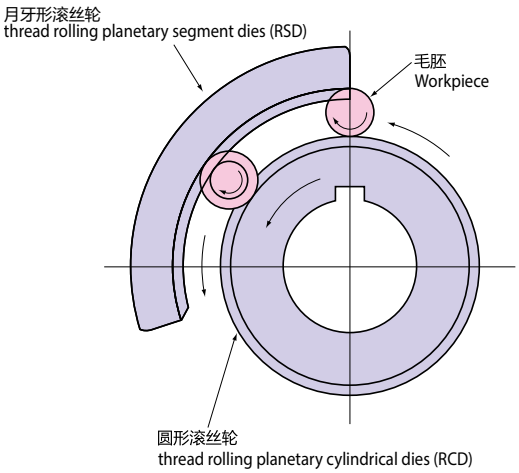
旋转式滚丝方式是在旋转的圆形滚丝轮和固定的月牙形滚丝轮之间边转动工件边加工工件的滚丝方法。

During planetary thread rolling, threads are imprinted when the work piece travels between a fixed die and a moving planetary cylindrical dies. Unlike rolling with flat dies-that must continually stop and start again-planetary rolling can accomplish high speed operations because the dies do not need to stop moving.



■月牙形滚丝轮，圆形滚丝轮
thread rolling planetary dies configuration

原理　Thread Rolling Planetary Dies



1组月牙形滚丝轮与圆形滚丝轮的螺纹有着以下的关系。

Relationship between planetary segment die and planetary cylindrical die.

圆形滚丝轮上的螺纹=左N条外螺纹

其中径= Nx产品外螺纹中径

(thread rolling) planetary cylindrical dies = Left hand thread male screw, N starts. (N:Number of start)

Pitch diameter = N × pitch diameter of the external screw to be rolled.

牙形滚丝轮上的螺纹=右(N+2)条内螺纹

其中径=(N+2) ×产品外螺纹中径

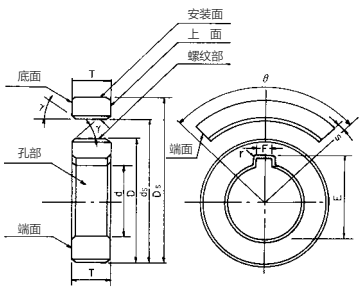
(thread rolling) planetary segment dies = Right hand thread female screw, (N+2) starts.

Pitch diameter = (N+2) × pitch diameter of the external screw to be rolled.

■旋转式滚丝机及滚丝轮
Thread Rolling Planetary Dies and Thread Rolling Machines

(单位 UNIT:mm)

滚丝机厂家 Thread rolling machine builders	机型 Models	被滚造螺纹 Threads to rolled		滚造速度 (根/分) Forming Speed (pieces/minute)	滚丝轮宽度 Die Width	月牙形滚丝轮 Segment dies		圆形滚丝轮 Rotary dies		
		大径 Nominal Dia	螺纹长 Thread Length		T	外径 Ds Outer dia Ds	圆弧角θ Segment angle θ	内径 d Bore dia.d	键槽宽度 F Key-way width F	键槽高度 H Key-way depth H
三明制作所 Sanmei Seisakusho Co., Ltd.	THI-SRD80	4 ～ 8	～ 55	50～500	～ 60	241.3	90°	127	13	132
	THI-SRD120	6 ～ 12	～ 55	50～500	～ 60	240	120°	127	13	132
	THI-SRD160	8 ～ 16	～ 75	40～200	～ 80	340	120°	152.4 (127)	15	158.9 (133.5)
	THI-SRD220	12 ～ 22	～ 75	40～200	～ 80	420	120°	228.6	18	235.1
阪村机械 Sakamura Machine Co.,Ltd.	SSR30	3 ～ 10	～ 80	300～400	～ 80	240	120°	127	13	132
	SSR50	12 ～ 16	～ 80	150～200	～ 80	340	120°	127	13	132
	SSR50D	12 ～ 16	～ 80	150～200	～ 80	340	120°	152.4	15	159
	SSR70	16 ～ 22	～ 75	100～150	～ 75	420	120°	228.6	18	233.6
	SSR100	22 ～ 30	～ 90	50～80	～ 90	520	120°	228.6	20	235
	SSR100HD	22 ～ 30	～ 110	50～80	～ 110	520	120°	266.7	20	273.2
	SSR120	24 ～ 38	～ 110	50～80	～ 110	600	120°	300	24	307.5
帝人精机 Teijin Seiki Co., Ltd.	TR6	3 ～ 8	～ 50	～1,200	～ 50	250	120°	127	13	132
大日铁工 Dainichi Machinery Works Co., Ltd.	RR200	3 ～ 6	～ 50	200～600	～ 52.25	241.5	(100mm)	140	(10)	(144)
神山铁工 Kamiyama Tekko-sho Co., Ltd.	KRT600	3 ～ 6	～ 50	600	～ 50	241.4	90°	110	12.7	113.2
	KRT450	8 ～ 12	～ 80	450	～ 80	360	120°	180	15	186
SIMA(意大利) SIMA(Italy)	RAP4	1.7 ～ 4	～ 30	300～1,500	～ 30	120	(90°)	40	10	43.5
	RAP6 RAP7	3 ～ 6	～ 50	300～1,500	～ 50	240	120°	127	13	132
	RAP10	6 ～ 12	～ 50	～1,000	～ 50	305	120°	127	13	132
	RAP11 RAP12	6 ～ 12	～ 75	～1,000	～ 75	305	120°	127	13	132
	RAP16	12 ～ 22	～ 75	～800	～ 75	420	120°	228.4	18	234.9
WATERBURY(美国) Waterbury(USA)	No.1	3 ～ 6	～ 57.2		～ 57.2	241.3	120°	127	12.7	130.2
	No.10	3 ～ 6	～ 57.2		～ 57.2	241.3	90°	127	12.7	130.2
	No.20	6 ～ 10	～ 79.4		～ 79.4	342.9	90°·120°	152.4	15.875	158.9
INGRAMATIC (意大利) Ingramatic(Italy)	GR1	1.7 ～ 4	～ 22		～ 22	120	90°	40	10	43.5
	GR2	4 ～ 8	～ 50		～ 50	241.3	90°	127	12.8	132
OMEGA (意大利) Omega(Italy)	RR4	2 ～ 4	～ 20		～ 20	120	90°	40	10	43.5
	RR6	2.6 ～ 6	～ 40		～ 40	241.3	120°	127	13	132
SACMA (意大利) Sacma(Italy)	RU2	4 ～ 12	～ 69.9		～ 69.9	280	120°	127	12.7	130.2
春雨机械工业 Harusame Machine Co., Ltd.	SRM6	3 ～ 6	～ 48	200～1,600	～ 50	240	120°	127	13	132
	SRM12	6 ～ 12	～ 73	75～1,000	～ 75	305	120°	127	13	132
日精 Nissei Co., Ltd.	75	1.4 ～ 10	～ 76	～1,500	～ 80	241.3	(90°)	127	13	132



D ：滚轮的外径
Ds：月牙侧的外径
d ：滚轮的孔径
ds：月牙侧的内径
T ：滚丝轮的宽度
θ ：弧度
F ：键槽宽度
E ：键槽高度
r ：键槽圆弧角度
γ ：倒角角度
s ：滚丝轮的横截面宽度

参考)
1. 通常按照以下 r 角度进行倒角。
螺距 0.75 以下 45°
螺距 0.75 以上 30°
2. 根据机器不同，滚丝轮的形状和键槽的形状等参数会有所变化。

■生产范围
Production Capability

月牙形滚丝轮 (RSD)
Segment die (RSD)
外径 Outer Dia — MAX. 600mm
宽度 Width — MAX. 165mm
螺距 Pitch — MIN. 0.4mm 64山/英寸 (T.P.I)

圆形滚丝轮 (RCD)
Rotary die(RCD)
外径 Outer Dia — MAX. 470mm
宽度 Width — MAX. 300mm
螺距 Pitch — MIN. 0.4mm 64山/英寸 (T.P.I)

滚丝轮的圆弧倒角和材质请参见P.1000。
For details on Radius Run-out and die material, refer to p.1000.

搓齿板 RACK TYPE ROLLING DIES

搓齿板
RACK TYPE ROLLING DIES

RF

▲花键和螺纹部同时滚轧
*Specifications and types of counter-flow rolling dies

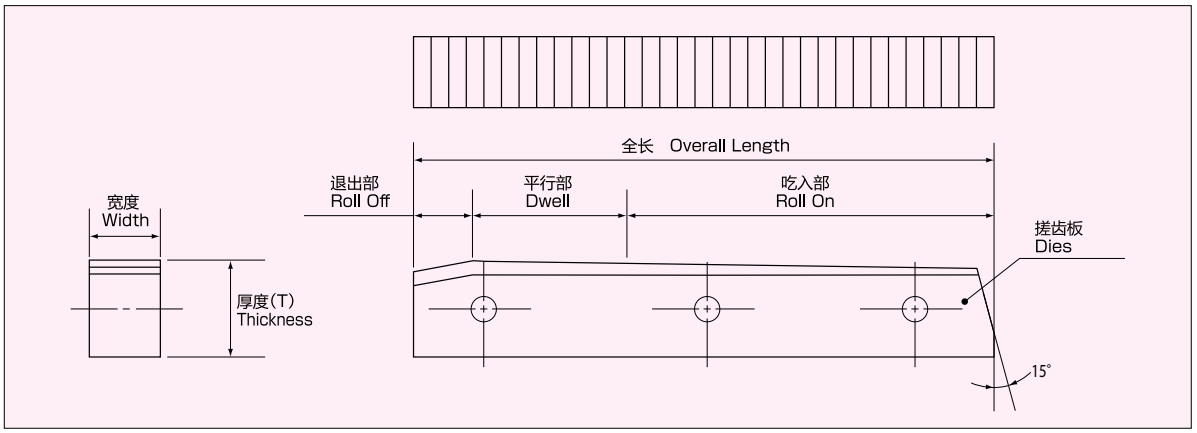
(立式)
(VERTICAL TYPE)

(卧式)
(HORIZONTAL TYPE)

搓齿板使用搓齿板可以对汽车零部件上渐开线花键，蜗杆齿轮等进行高效批量加工。由于搓齿板的形状简单，搓齿机的操作也便捷，因此搓齿加工今后将会得到越来越广泛的应用。

Mainly used for automotive parts production, RACK TYPE rolling dies are for fast, large volume production of parts with involute splines. Compared with other rolling systems, the RACK TYPE is a simple, user-friendly process. RACK TYPE systems are becoming increasingly popular.

■COUNTER-FLOW式搓齿板形状和种类 Specifications and types of Counter-Flow Rolling Dies



(单位 UNIT:mm)

项目 Items / 机型 Models	搓齿范围 Prodction Capability Range			全长 Overall Length
	最大加工径 Max. Diameter	最大搓齿宽度 Max. Width	最大模数 Max. Module	(L)
CT400	20	70	1.0	410
PCT-700	37	120	1.5	715.2
PCT-1000	50	150	1.7	928

1.可滚造的范围由荷重系数决定。
(荷重系数请询问搓齿机制造商)
2.最搓齿宽度、最大加工径为搓齿机所能安装的最大范围。
3.厚度(T)由被加工零件的外径来计算。

1.Production capability is determined by load factors. (For load factor specifics, contact the counter-flow rolling machine builder.)
2.Maximum diameter and maximum width are the dimensions accepted by the rolling machine.
3.Thickness (T) is determined by the nominal size of the work piece.

搓齿机 RACK TYPE ROLLING MACHINE

■特长 FEATURES

1.加工精密度高、稳定性好。
2.搓齿板可自由组合，进行同时搓齿加工。
3.搓齿板刚性高，不占面积。

1.This machine is designed to perform rapid, high-precision forming.
2.With several dies combined, simultaneous complex rolling operations are posible.
3.The vertical structure helps to save floor space.

■工件实例

Samples of parts to be produced

NHK 公司制搓齿机
NHK ROLLING MACHINE
(PCT-1000)

CNK 公司制搓齿机
CNK ROLLING MACHINE
(TNIO-14×100)

圆角滚轮 / 支撑滚轮 / 抛光工具 FILLET ROLLER / BACK-UP ROLLER / BURNISHING TOOL

曲轴加工用圆角滚轮
FiletRoller

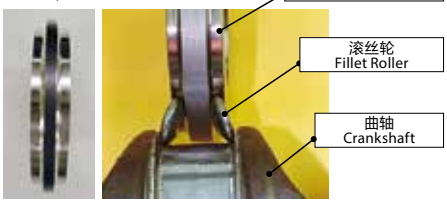
对汽车等曲轴的圆弧角部进行镜面精加工的工具。
强化曲轴为主要目的。

【材　　质】　CPM、XPM（粉末高速钢），或者是硬质合金
【制作范围基准】　外径 φ11～φ18　　厚度 3.2～6

Tool to make mirror finish on corners of crankshaft for automotives main purpose is to mirease strength of a shaft.

【Material】　CPM、XPM (Powdered Steel)　or　Carbide Steel
【Applicable ranges】　Outer Dia. φ11～φ18　　Thickness 3.2～6

曲轴加工用支撑滚轮
Back-up Roller



从背后推压圆角滚轮而使用的工具。
一般和圆角滚轮装在一起使用。

【材　　质】　SKD、SKH、CPM、XPM
【制作范围基准】　外径 φ60～φ80　　宽 13～25

A Part to press fillet rollers from back usually used with fillet rollers as a set.

【Material】　SKD、SKH、CPM、XPM
【Applicable ranges】　Outer Dia. φ60～φ80　　Width 13～25

抛光工具
Burnishing Tool

为防止曲轴轴向面烧结而进行抛光加工。
这是针对此加工而使用的工具。

【材　　质】　CPM
【制作范围基准】　外径 φ12～φ16　　外径 80～110

Burnishing tool on the surface of thrust area to avoid burning.

【Material】　CPM
【Applicable ranges】　Outer Dia. φ12～φ16　　Length 80～110

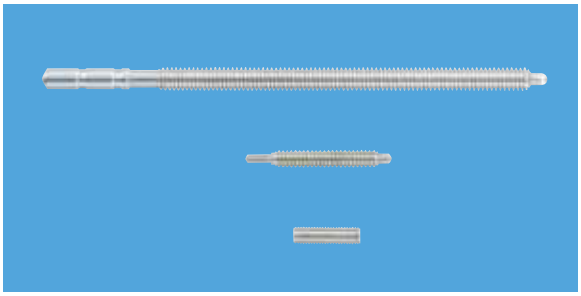
丝杆用滚造工具 ROLLING DIES FOR LEAD SCREW

丝杆用滚造工具
ROLLING DIES FOR LEAD SCREW

丝杆比起普通的螺纹来，其累计误差，牙角度，牙精度，螺纹面的圆周误差均有很高的要求。
因此，丝杆用滚造工具的制作比普通螺纹滚丝轮，花键滚轮，其螺纹中心部位的精度的设定非常之高。
Compare to regular threads, Lead Screw requires tighter tolerances as the accumulated pitch error,
thread angle, tolerance, runout of circler thread face
with such reason, rolling dies for lead screw being made with higher accuracy especially at thread part.

可以制作丝杆滚丝轮及丝杆搓丝板，可以制作的最小螺距为0.15
(请详细咨询我司营业担当联系是否可以制作)
For Lead Screw Forming dies, we can make both Round Dies and Rack Dies.
The die production capacity of the smallest pitch is 0.15
(please call our salesmen close by for die production capacity)

■加工案例
Samples of parts to be produced

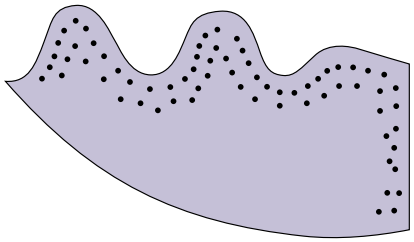


OSG 公司各种滚造工具的圆弧倒角度
RADIUS RUN-OUT

对于金属拉伸要求较高的螺栓(主要就应用在飞机零配件上)，不完全牙部的牙底需进行圆弧加工，为此，公司可以在各种滚造工具的角部进行圆弧倒角加工。根据不同的精度要求，我们准备了3种规格 (S、C、I) 。

By rounding the sharp crest of incomplete threads on die edges, the rolled bolts have a radius root run-out which increases durability. Radius Run-out is used for dies in the bolt production industry, particularly where high durability is required, (such as the aircraft industry).

■圆弧倒角加工
RADIUS RUN-OUT PROCESS



■圆弧倒角加工范围
Radius Run-out Process Capability Range

TR、DP、T-DP、RF、RCD、RSD

Die Type : Thread Rolling Cylindrical Dies, Thread Rolling Flat Dies, Planetary Dies (Rotary and Segment Dies), Thread Rolling Flat Dies for Tapping Screws, Rack Type Rolling Dies

圆弧倒角 RADIUS RUN-OUT

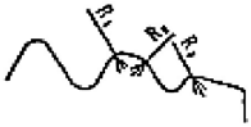
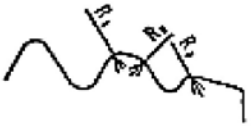
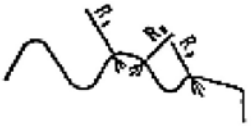
■圆弧倒角的式样及加工范围
OSG Radius Run-out is available in three forms, depending on the application.

我社的圆弧倒角有以下三种
一般加工范围
- ●螺纹牙全角60°
- ●螺距1.0以上
- ●模具端面倒角角度 约为30°

3types of Radius Run-out are available
Available Range
- ●60degree thread angle
- ●Thread pitch 1.0 & over
- ●chamfer angle about 30 degree

注) 根据不同加工模具的螺距(基准：螺距不满1.0)，倒角角度(基准：30以外)，下述圆弧倒角不能加工，亦或是牙顶R的大小不能得到保证的情况也是有的。详细情况请与我社营业人员咨询。

Some dies may not be able to have Radius Run-out (Ex. pitch less than 1.0 chamfer angle not 30 degree) Please consult with OSG Sales.

种类① Type	RR-S (R-S)	RR-C (R-C)	RR-I (R-I)
圆弧倒角形状 Radius size of crest	**Rn≧牙顶R** **Crest Radius** 	**Rn≧0.108P** 	**Rn≧0.072P** 
规格 Standard	不完全牙的圆弧角大于平行部牙顶的圆弧角 **Imperfect thread will have larger radius than regular threads**	不完全牙的圆弧角大于等于0.108P **Imperfect thread will have 0.108P & over radius**	不完全牙大于等于0.072P **Imperfect thread will have 0.072P & over radius**
用途 Use	JIS规格强度在8.8以上的外螺纹 ② MIL-8879 (UNJ) 外螺纹等 **Male thread with JIS standard strength group 8.8 & over.②** **male thread with MIL-8879 (UNJ).**	旧JIS规格针对疲劳，冲击等考究强度的外螺纹 ③ IFI (UNR) 外螺纹等 **Male thread require strength against fatigue, impact by old JIS standard.③** **male thread with IFI (UNR).**	防止端面缺损 **Avoid corner chipping.**

① "RR" 是双面圆弧倒角加工，"R" 是单面(一般指表面) 圆弧倒角加工
② JIS规定强度在8.8以上的外螺纹其切削锥部的牙底圆弧需要在0.125P以上。因此R-C以下的圆弧倒角不满规格须使用RR-S(R-S) 的倒角
③ 旧JIS规定切削锥部的圆弧须大于等于0.1P

① Radius Run-Out are applied on both side on RR, single side for R.
② JIS strength 8.8 & over need 0.125P on root radius.
This R-C& less radius is not enough, will need RR-S (R-S)
③ with old JIS need radius 1.0 & over (over RR-C)

表面处理/特殊材质 SURFACE TREATMENT／SPECIAL MATERIAL

表面处理 Surface Treatment

●GM处理	喷丸硬化处理的一种。可以提高模具寿命。 (注) 滚造螺纹的面粗糙度有变差的趋势。
●氮化处理(一般氮化)	滚造工具最常见的表面处理。主要提升耐磨损度。滚丝轮，花键滚轧等万能的表面处理。
●XBT处理	表面硬度高(1350Hv) 耐磨损性，耐缺损性以及润滑性得到提升。
●其他处理	氧化处理，特殊表面处理等。
●Gammer Treatment (GM Treatment)	A kind of shot Peening Treatment can expect dies tool durability (Surface Rolled thread may be little rough)
●Nitride Treatment (Nitride)	Very popular treatment on rolling dies for thread rolling spline rolling, etc
●XBT Treatment	Increase surface hardness (1350) wear resistance chip-resistance better lubrication
●SQT Treatment	SQT treatment provides greater abrasion resistance, chipping resistance and lubricity versus conventional nitriding treatment.
●Other Special Treatments	Steam oxide treatment Special surface treatment

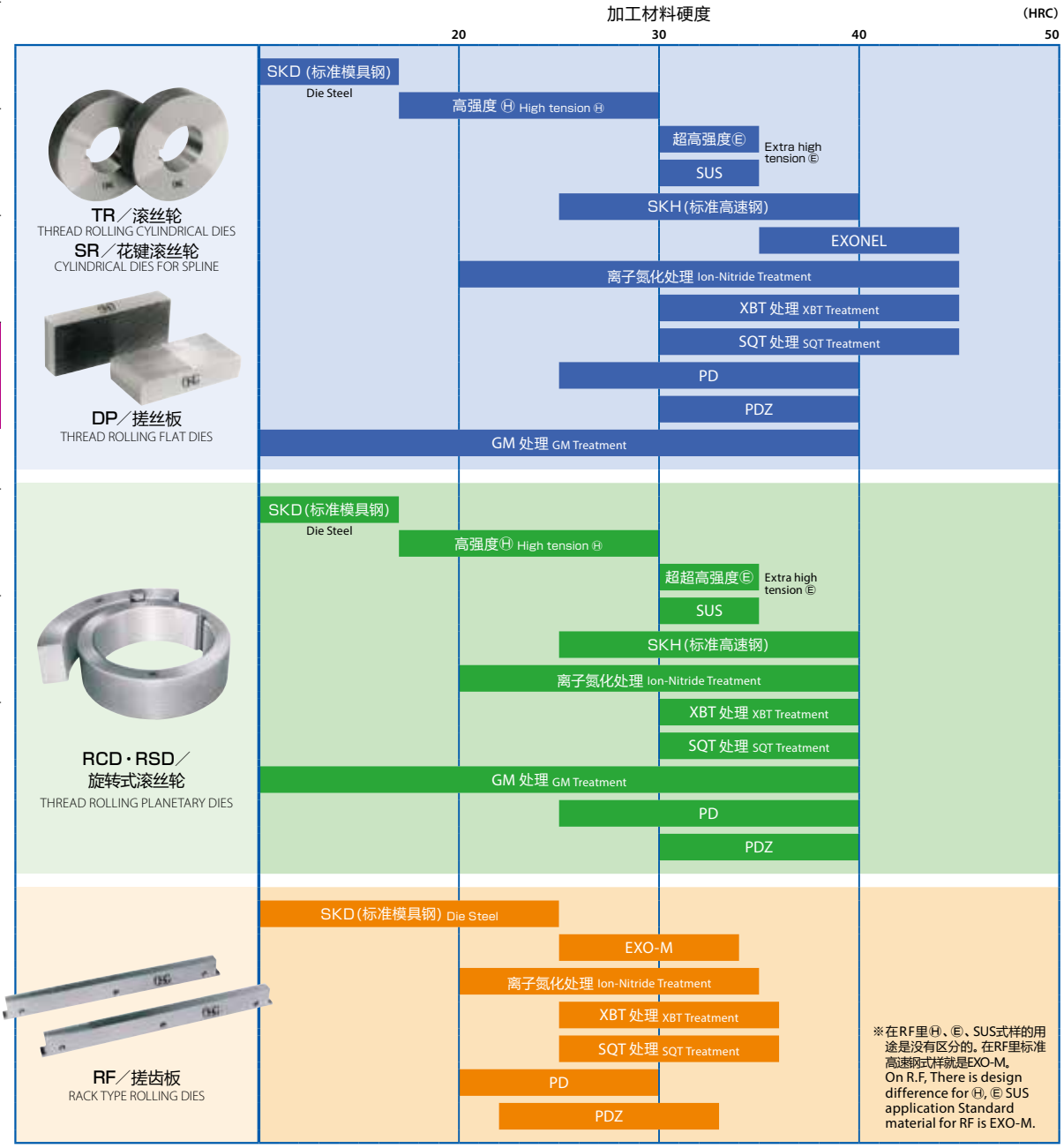
标准材质 Regular Material

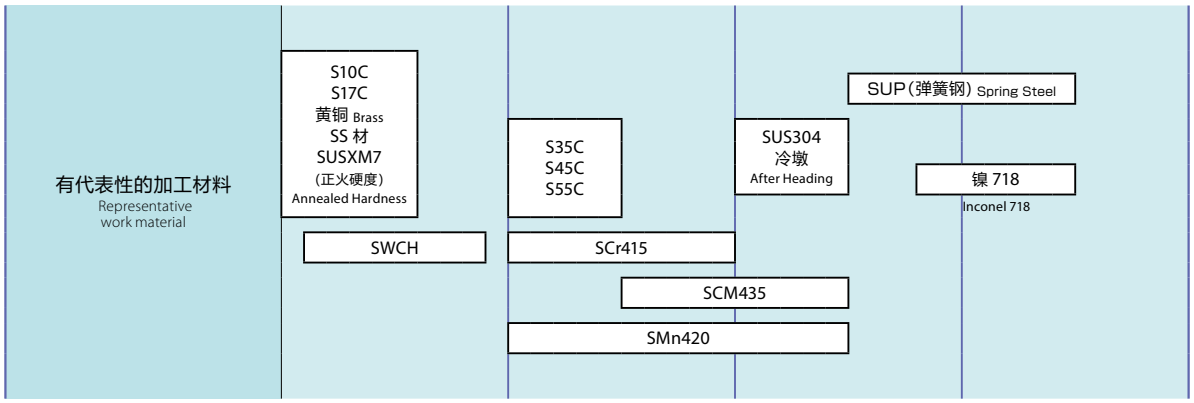
●SKD　标准模具钢	14HRC以下的钢铁材料，有色金属材料用
●高强度	15HRC以上31HRC以下的材料用
●超高强度	32HRC以上的材料，高加工硬化性的材料用
●不锈钢	不锈钢用
●SKH　标准高速钢	25HRC以上40HRC以下的材料用
●General use	For Material of less than 14HRC
●High tension Ⓗ	For Material of 15HRC～31HRC
●Extra high tension Ⓔ	For Material of over 31HRC, Material with work-hardened properties
●Stainless SUS	For Stainless steels
●SKH	For Material of 25HRC～40HRC

特殊材质 Special Material

●PD	实现耐磨损性高于以往模具钢
●PDZ	实现价格低于高速钢及其同等硬度锋钢
●PD	Has better wear-resistance than regular die steel
●PDZ	Equivalent hardness as high speed steel & better price

滚造工具式样选择图 MAP FOR ROLLING DIE DESIGN SELECTION





滚造毛坯径表 RECOMMENDED BLANK DIAMETER

■公制粗牙螺纹 (H/6)
Metric Coarse screw threads (H/6)

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread Size	等级 tolerance class		
	4h 级 (旧 JIS1 级) 4h class(previous JIS class1)	6g 级 (旧 JIS2 级) 6g class(previous JIS class2)	8g 级 (旧 JIS3 级) 8g class(previous JIS class3)
M2 × 0.4	1.73 — 1.71	1.7 — 1.67	1.68 — 1.63
2.3 × 0.4	2.03 — 2.01	2 — 1.97	1.98 — 1.93
2.6 × 0.45	2.29 — 2.27	2.27 — 2.23	2.24 — 2.19
3 × 0.5	2.66 — 2.64	2.63 — 2.6	2.61 — 2.55
3.5 × 0.6	3.1 — 3.08	3.07 — 3.02	3.04 — 2.97
4 × 0.7	3.54 — 3.51	3.5 — 3.45	3.47 — 3.4
4.5 × 0.75	4.01 — 3.98	3.97 — 3.92	3.94 — 3.86
5 × 0.8	4.47 — 4.44	4.43 — 4.38	4.4 — 4.33
6 × 1	5.34 — 5.31	5.3 — 5.24	5.26 — 5.17
7 × 1	6.34 — 6.31	6.3 — 6.24	6.26 — 6.17
8 × 1.25	7.18 — 7.14	7.14 — 7.08	7.1 — 7.01
9 × 1.25	8.18 — 8.14	8.13 — 8.08	8.1 — 8
10 × 1.5	9.03 — 8.99	8.97 — 8.9	8.93 — 8.82
11 × 1.5	10.02 — 9.98	9.97 — 9.9	9.93 — 9.82
12 × 1.75	10.86 — 10.82	10.8 — 10.73	10.76 — 10.64
14 × 2	12.7 — 12.65	12.64 — 12.56	12.59 — 12.47
16 × 2	14.7 — 14.65	14.63 — 14.55	14.59 — 14.46
18 × 2.5	16.38 — 16.33	16.32 — 16.23	16.27 — 16.14
20 × 2.5	18.38 — 18.33	18.31 — 18.23	18.27 — 18.13
22 × 2.5	20.38 — 20.33	20.31 — 20.22	20.26 — 20.13
24 × 3	22.07 — 22.01	21.98 — 21.88	21.92 — 21.76
27 × 3	25.06 — 25	24.97 — 24.87	24.92 — 24.76
30 × 3.5	27.75 — 27.68	27.65 — 27.55	27.59 — 27.42
33 × 3.5	30.74 — 30.68	30.65 — 30.54	30.59 — 30.42
36 × 4	33.43 — 33.37	33.33 — 33.21	33.26 — 33.08
39 × 4	36.43 — 36.36	36.32 — 36.21	36.26 — 36.08
42 × 4.5	39.11 — 39.04	39 — 38.88	38.93 — 38.74
45 × 4.5	42.11 — 42.04	42 — 41.88	41.93 — 41.74

■公制细牙螺纹 (H/6)
Metric Fine screw threads (H/6)

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread Size	等级 tolerance class		
	4h 级 (旧 JIS1 级) 4h class(previous JIS class1)	6g 级 (旧 JIS2 级) 6g class(previous JIS class2)	8g 级 (旧 JIS3 级) 8g class(previous JIS class3)
M4 × 0.5	3.66 — 3.63	3.63 — 3.59	3.61 — 3.54
4.5 × 0.5	4.16 — 4.13	4.13 — 4.09	4.1 — 4.04
5 × 0.5	4.66 — 4.63	4.63 — 4.59	4.6 — 4.54
6 × 0.75	5.5 — 5.47	5.46 — 5.41	5.43 — 5.36
7 × 0.75	6.5 — 6.47	6.46 — 6.41	6.43 — 6.35
8 × 1	7.33 — 7.3	7.29 — 7.24	7.26 — 7.17
9 × 1	8.33 — 8.3	8.29 — 8.24	8.26 — 8.17
10 × 1.25	9.18 — 9.14	9.13 — 9.07	9.1 — 9
10 × 1	9.33 — 9.3	9.29 — 9.23	9.26 — 9.17
12 × 1.5	11.01 — 10.97	10.96 — 10.89	10.92 — 10.81
12 × 1.25	11.17 — 11.13	11.12 — 11.06	11.08 — 10.98
14 × 1.5	13.01 — 12.97	12.96 — 12.89	12.92 — 12.81
16 × 1.5	15.01 — 14.97	14.96 — 14.89	14.91 — 14.8
18 × 2	16.7 — 16.65	16.63 — 16.55	16.59 — 16.46
18 × 1.5	17.01 — 16.96	16.96 — 16.89	16.91 — 16.8
20 × 2	18.7 — 18.65	18.63 — 18.55	18.58 — 18.46
20 × 1.5	19 — 18.95	18.95 — 18.88	18.91 — 18.8
22 × 1.5	21 — 20.95	20.95 — 20.88	20.91 — 20.8
24 × 1.5	23 — 22.95	22.95 — 22.87	22.9 — 22.79
26 × 1.5	25 — 24.95	24.95 — 24.87	24.9 — 24.79
27 × 1.5	26 — 25.95	25.95 — 25.87	25.9 — 25.78
28 × 1.5	27 — 26.95	26.95 — 26.87	26.9 — 26.78
30 × 1.5	29 — 28.95	28.95 — 28.87	28.9 — 28.78
32 × 1.5	31 — 30.95	30.94 — 30.87	30.9 — 30.78
33 × 1.5	32 — 31.95	31.94 — 31.87	31.9 — 31.78
35 × 1.5	34 — 33.95	33.94 — 33.87	33.9 — 33.78
36 × 1.5	35 — 34.95	34.94 — 34.87	34.9 — 34.78

■美制粗牙螺纹
Unified Coarse screw threads

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread Size	等级 tolerance class		
	3A	2A	1A
No. 1 —64UNC	1.59 — 1.57	1.57 — 1.54	—
No. 2 —56	1.89 — 1.87	1.86 — 1.84	—
No. 3 —48	2.17 — 2.15	2.14 — 2.11	—
No. 4 —40	2.42 — 2.4	2.4 — 2.36	—
No. 5 —40	2.75 — 2.73	2.72 — 2.69	—
No. 6 —32	2.98 — 2.95	2.95 — 2.91	—
No. 8 —32	3.64 — 3.61	3.6 — 3.57	—
No.10 —24	4.12 — 4.09	4.09 — 4.05	—
No.12 —24	4.78 — 4.75	4.75 — 4.7	—
¼ —20	5.53 — 5.5	5.5 — 5.45	5.47 — 5.4
5/16 —18	7.03 — 6.99	6.98 — 6.93	6.96 — 6.88
3/8 —16	8.5 — 8.46	8.45 — 8.4	8.43 — 8.34
7/16 —14	9.94 — 9.9	9.89 — 9.83	9.86 — 9.77
½ —13	11.44 — 11.39	11.39 — 11.32	11.35 — 11.26
9/16 —12	12.92 — 12.87	12.87 — 12.8	12.83 — 12.73
5/8 —11	14.39 — 14.34	14.33 — 14.26	14.3 — 14.19
¾ —10	17.41 — 17.35	17.34 — 17.27	17.31 — 17.2
7/8 — 9	20.4 — 20.34	20.34 — 20.26	20.3 — 20.17
1 — 8	23.35 — 23.29	23.28 — 23.2	23.24 — 23.11
1⅛ — 7	26.24 — 26.17	26.16 — 26.07	26.12 — 25.98
1¼ — 7	29.41 — 29.34	29.33 — 29.24	29.28 — 29.14
1⅜ — 6	32.2 — 32.13	32.12 — 32.02	32.07 — 31.91

■美制细牙螺纹
Unified Fine screw threads

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread Size	等级 tolerance class		
	3A	2A	1A
No. 2 —64UNF	1.92 — 1.9	1.9 — 1.87	—
No. 3 —56	2.21 — 2.19	2.19 — 2.16	—
No. 4 —48	2.49 — 2.47	2.46 — 2.43	—
No. 5 —44	2.79 — 2.76	2.76 — 2.73	—
No. 6 —40	3.08 — 3.06	3.05 — 3.02	—
No. 8 —36	3.69 — 3.67	3.66 — 3.63	—
No.10 —32	4.29 — 4.26	4.26 — 4.22	—
No.12 —28	4.88 — 4.85	4.84 — 4.8	—
¼ —28	5.75 — 5.72	5.72 — 5.68	5.7 — 5.63
5/16 —24	7.24 — 7.21	7.2 — 7.16	7.18 — 7.11
3/8 —24	8.83 — 8.79	8.79 — 8.74	8.76 — 8.69
7/16 —20	10.28 — 10.24	10.23 — 10.18	10.21 — 10.13
½ —20	11.86 — 11.82	11.82 — 11.76	11.79 — 11.71
9/16 —18	13.36 — 13.32	13.31 — 13.25	13.28 — 13.19
5/8 —18	14.94 — 14.9	14.89 — 14.83	14.86 — 14.77
¾ —16	18 — 17.96	17.95 — 17.89	17.92 — 17.82
7/8 —14	21.03 — 20.98	20.98 — 20.91	20.94 — 20.84
1 —12	24.01 — 23.96	23.95 — 23.87	23.91 — 23.8
1⅛ —12	27.19 — 27.13	27.12 — 27.05	27.08 — 26.97
1¼ —12	30.36 — 30.3	30.29 — 30.21	30.25 — 30.14
1⅜ —12	33.53 — 33.47	33.46 — 33.38	33.42 — 33.3
1½ —12	36.7 — 36.64	36.63 — 36.55	36.59 — 36.47

■惠氏螺纹 旧 JIS 精度
Whitworth screw threads(acc. to previous JIS)

(单位：mm)
(Unit : mm)

螺纹尺寸 Thread Size	等级 tolerance class		
	2 级 class2	3 级 class3	4 级 class4
W3/16 — 24	4.08 — 4.05	4.06 — 4.02	4.04 — 3.97
¼ — 20	5.51 — 5.46	5.49 — 5.42	5.47 — 5.38
5/16 — 18	7.01 — 6.95	6.99 — 6.91	6.97 — 6.87
3/8 — 16	8.48 — 8.41	8.46 — 8.37	8.44 — 8.33
7/16 — 14	9.92 — 9.85	9.9 — 9.81	9.87 — 9.76
½ — 12	11.31 — 11.24	11.29 — 11.19	11.27 — 11.15
9/16 — 12	12.89 — 12.82	12.87 — 12.77	12.85 — 12.73
5/8 — 11	14.36 — 14.29	14.34 — 14.24	14.31 — 14.18
¾ — 10	17.38 — 17.3	17.36 — 17.25	17.33 — 17.19
7/8 — 9	20.38 — 20.29	20.34 — 20.23	20.32 — 20.18
1 — 8	23.32 — 23.23	23.29 — 23.17	23.26 — 23.11

■管用螺纹
Pipe threads

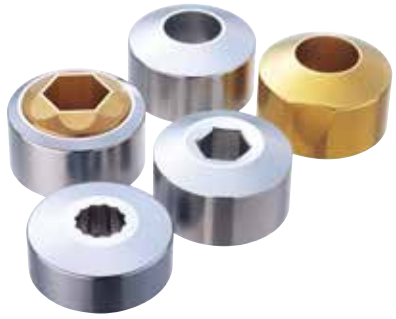
(单位：mm)
(Unit : mm)

螺纹尺寸 Thread Size	PF		PS	PT	
	A 级 classA	B 级 classB		基准径位置 position of gauge plane	毛坯直径 blank dia.
1/8 — 28	9.1 — 9.05	9.05 — 8.94	9 — 8.92	3.97	9.16 — 9.1
¼ — 19	12.25 —12.19	12.19 —12.07	12.11 —12.01	6.01	12.32 —12.23
3/8 — 19	15.76 —15.69	15.69 —15.57	15.61 —15.51	6.35	15.82 —15.73
½ — 14	19.74 —19.67	19.67 —19.53	19.55 —19.43	8.16	19.81 —19.7
¾ — 14	25.22 —25.15	25.15 —25.01	25.03 —24.9	9.53	25.29 —25.18
1 — 11	31.7 —31.61	31.61 —31.43	31.47 —31.34	10.39	31.79 —31.64

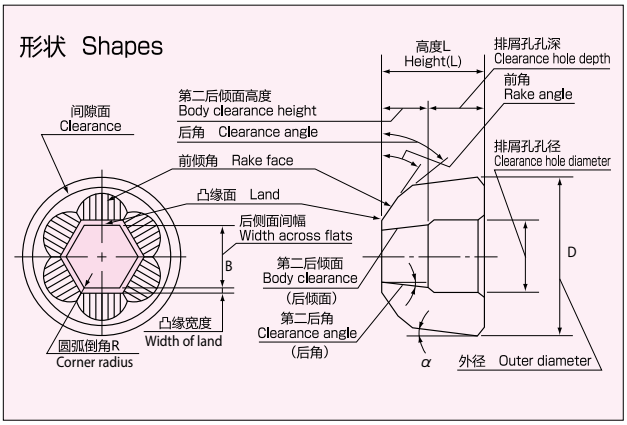
六角冲头 TRIMMING DIES

六角冲头
TRIMMING DIES

TMD



形状 Shapes



六角冲头是加工螺栓的外六方形头部的工具，OSG公司采用了耐冲击、切削锋利的钼系高速钢为刀体母材。

Trimming dies are used for high speed punching to from polygonal-shaped bolt heads. OSG trimming dies are made of high quality Molybdenum high speed steel, which has been cold-press fitted and heat-treated. OSG uses Type I as our standard. We also have a wide range of coated products.

■六角冲头和螺栓的关系表 Relation between dies and bolts

被加工螺栓的二面宽度 Width across flats of bolts			螺纹尺寸 Nominal diameter of screw thread							B		生产范围 Available Die Range									
标准尺寸 Basic dimension	公差 tolerance		JIS(並形)螺纹 JIS Metric thread (Regular)		JIS(小形)螺纹 JIS Metric thread (Small)		JIS 螺纹 JIS Whitworth thread		SAE UN SAE Unified thread	标准尺寸 Basic dimension	公差 tolerance	Ⅰ形 Type Ⅰ						Ⅱ形 Type Ⅱ				
	A 级 A	B·C 级 B·C	新 new	前 previous	新 new	前 previous	小螺纹 Screws	螺栓 Bolts				1	2	3	4	5	6	1	2	3	4	5
5.5	$_{-0.18}^{0}$	$_{-0.30}^{0}$	M3	M3						5.3	+0.048											
6	$_{-0.18}^{0}$	$_{-0.30}^{0}$	M3.5	M3.5						5.8	+0.048											
7	$_{-0.22}^{0}$	$_{-0.36}^{0}$	M4	M4						6.8	+0.058											
8	$_{-0.22}^{0}$	$_{-0.36}^{0}$	M4.5 M5	M4.5 M5						7.8	+0.058											
10	$_{-0.22}^{0}$	$_{-0.36}^{0}$	M6	M6			W1¼			9.8	+0.058											
11	$_{-0.27}^{0}$	$_{-0.43}^{0}$	M7							10.75	+0.07											
11.11	$_{-0.23}^{0}$	—							¼	10.88	+0.07											
12	$_{-0.27}^{0}$	$_{-0.43}^{0}$			M8	M8	W5⁄16			11.75	+0.07											
12.7	$_{-0.27}^{0}$	—							5⁄16	12.43	+0.07											
13	$_{-0.27}^{0}$	$_{-0.43}^{0}$	M8							12.75	+0.07											
14	$_{-0.27}^{0}$	$_{-0.43}^{0}$		M8	M10	M10	W3⁄8			13.75	+0.07											
14.28	$_{-0.28}^{0}$	—							3⁄8	14	+0.07											
15.87	$_{-0.32}^{0}$	—							7⁄16	15.55	+0.07											
17	$_{-0.27}^{0}$	$_{-0.43}^{0}$	M10		M12	M12	W7⁄16	W3⁄8		16.75	+0.07											
19	$_{-0.25}^{0}$	—					W1½			18.75	+0.084											
19	$_{-0.33}^{0}$	$_{-0.52}^{0}$	M12		M14					18.67	+0.084											
19.05	$_{-0.35}^{0}$	—							½	18.7	+0.084											
20.63	$_{-0.36}^{0}$	—							9⁄16	20.27	+0.084											
21	$_{-0.33}^{0}$	$_{-0.84}^{0}$		M12		M14		W1½		20.67	+0.084											
22	$_{-0.33}^{0}$	$_{-0.84}^{0}$	M14		M16					21.67	+0.084											
23	$_{-0.33}^{0}$	$_{-0.84}^{0}$		M14		M16				22.67	+0.084											
23.81	$_{-0.39}^{0}$	—							5⁄8	23.42	+0.084											
24	$_{-0.33}^{0}$	$_{-0.84}^{0}$	M16		M18					23.67	+0.084											
26	$_{-0.33}^{0}$	$_{-0.84}^{0}$		M16		M18		W5⁄8		25.67	+0.084											
27	$_{-0.33}^{0}$	$_{-0.84}^{0}$	M18		M20					26.67	+0.084											
28.57	$_{-0.63}^{0}$	—							¾	27.94	+0.084											
29	$_{-0.33}^{0}$	$_{-0.84}^{0}$		M18		M20				28.67	+0.084											
30	$_{-0.33}^{0}$	$_{-0.84}^{0}$	M20		M22					29.67	+0.084											
32	$_{-0.39}^{0}$	$_{-1.0}^{0}$	M22	M20	M24	M22		W¾		31.61	+0.1											
33.34	$_{-0.70}^{0}$	—							7⁄8	32.64	+0.1											
35	$_{-0.62}^{0}$	$_{-1.0}^{0}$		M22	M27	M24		W7⁄8		34.6	+0.1											
36	$_{-0.62}^{0}$	$_{-1.0}^{0}$	M24							35.6	+0.1											

■形状表 Specifications

Ⅰ形(直形) Type Ⅰ (Straight type)

No.	D	L	锥度α Taper
1	30	19	0°
2	35	23	0°
3	42	23	0°
4	45	28	0°
5	60	40	0°
6	70	50	0°

Ⅱ形(锥形) Type Ⅱ (Taper type)

No.	D	L	锥度α Taper
1	30	16	1°
2	36	16	1°
3	45	20	1°
4	60	30	1°
5	70	50	1°

■定制冲头时的注意事项 When ordering trimming dies

1. 冲床的厂家和型号 …… Ⅰ形No.3
2. 冲头的形状和表示方法
   外径×高度 D L
   螺栓的二面宽度和公差 42×23×17 $^{+0}_{-0.2}$
   冲头的二面宽度和公差 42×23×B16.75 $^{+0.07}_{0}$
   (用冲头的二面宽度进行表示时，请在尺寸前标记)
3. 要加工的螺栓的材质和硬度 …… S45C 15HRC
4. 冲头的二面角
   (请尽量标明是否为OSG的标准型号) …… 2°
5. 其他的必要指示 …… 外径附锥度

1. Trimmer manufacturer and Model eg. Model Ⅰ No.3
2. Die shapes and indication methods
   Outer Diameter D × Height L
   Width across flats of bolts and tolerances
   eg. 42×23×17
   Width across flats of dies and tolerances $^{+0}_{-0.2}$
   eg. 42×23×B16.75 $^{+0.07}_{0}$
   (When you indicate the width across flats of dies, also specify the relative dimension.)
3. Material and Hardness of bolts to be produced.
   eg. S45C 15HRC
   eg. 2°
4. Clearance angle of die.
   (When possible, use OSG standard type, otherwise specify the relative type.)
5. Additional information required, such as the outer dia. with taper.

也可定制非标品。详情请咨询我司销售人员。
Special orders are accepted. Please contact OSG's sales division for details.

攻 牙 油 膏

Tapping Paste

改善表面质量、提高工作效率，延长工具寿命

含特殊添加剂

优越的切削性能

■使用方法简单■

常温下为油膏状，使用方便且用量较小，最适合于立式的螺纹加工及钻孔加工。在加工时受热成液态，可充分渗透加工部位。加工后切屑清理方便，不会污染环境。

■适用各种材质■

适用于除铜材之外的所有材料。炭素钢、合金钢、不锈钢、铸铁、铝合金、无论何种材质均不需要更换切削油剂，特别针对不锈钢、耐热钢等难加工材料的攻丝作业，可发挥出巨大的威力。（铜及铜合金请使用 C 型攻牙油膏）

■应用范围广泛■

可广泛运用在攻丝作业等所有低速切削作业中。可使用毛刷、笔涂。在攻丝、车削、铣削、孔加工时发生切削困难的情况下使用，可发挥出良好效果。

■非氯化系产品■

为了保护环境，在保持原有产品性能的前提下改良了配方，产品均不含有氯化合物成分。

注意事项

●请使用毛刷将油膏涂在丝锥上使用。（在粘性大时，请用少量的机油或非水溶性切削油充分搅拌稀释，以适当的浓度使用。）

●清洗时请使用碱液或煤油刷洗。（不可使用酸液）

★如使用油管供油，请使用 C-104B 型切削油。

研磨中心用 电镀金刚石工具 ELECTROPLATED DIAMOND TOOLS FOR CERAMICS

陶瓷用钻头 · 螺纹铣刀的特点 Features

1 有效利用工具制造厂特有的技术，实现陶瓷的高速 · 长寿命加工。
OSG's ED-DS and ED-PNT combine high speed capability with long tool life when working with ceramics. Using OSG's advanced electroplating technology, we have developed these revolutionary new tools.

2 为了使之有出色的工具刚性，母材使用进行淬火处理过高速钢。
These tools are made of high speed steel, with diamond powder electroplated onto the surface.

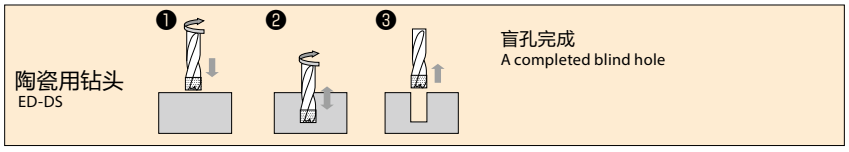
3 陶瓷用钻头，采用了独特切屑排出的沟槽 · 横刃修磨形状，通孔 · 盲孔两者都可加工。
The ED-DS can drill both through and blind holes. Unique flutes and special thinning enable smooth chip removal.

4 陶瓷用螺纹铣刀，考虑到与游星运动时加工材料的干涉而设计的螺纹牙形状，可进行JIS2级精度的螺纹加工。
The ED-PNT provides a JIS class 2 thread limit, taking into consideration the interference of the work.

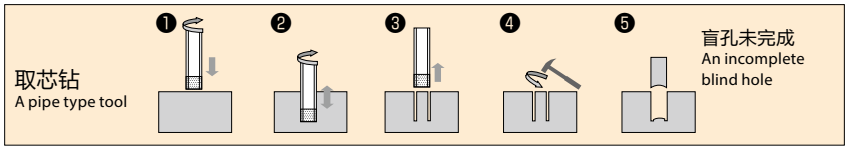
陶瓷用钻头 ED-DS的特点 Features of ED-DS

陶瓷用钻头与取芯钻的比较 Comparison between ED-DS and pipe type tool

盲孔加工 Blind Hole



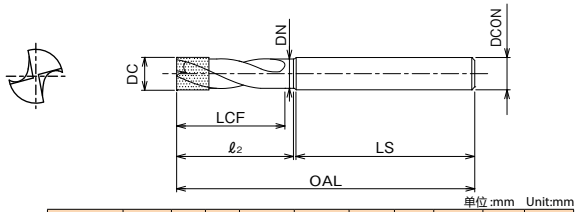
●陶瓷用钻头采用了易于切屑排出的形状，也可加工深孔的盲孔。
Thanks to its unique flute form, it can make deep holes as well.



●取芯钻的加工工序多，且孔底断裂面粗糙，需要另外进行精加工。
A pipe type tool involves a longer process. Due to its imperfect surface finish, a finishing operation is required.

电镀金刚石螺纹钻头 陶瓷用 Electroplated Diamond Drills for Ceramics

ED-DS



单位 :mm Unit:mm

商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	颈径 DN	电镀长度 Length of electroplating	粒度 Grit Size	库存 Stock
8599720	2	7	39	3	27.9	8.5	1.6	8.5	#100	●
8599725	2.5	9	41	3	28.8	10.5	2.1	10.5	#100	●
8599730	3	11	43	3	29.7	12.5	2.6	12.5	#100	●
8599735	3.5	15	47	4	28.5	16.5	3.1	10	#100	●
8599740	4	17	49	4	29.7	18.5	3.6	10	#100	●
8599745	4.5	19	63	6	35.8	21	4.1	10	#100	●
8599750	5	21	65	6	37.2	23	4.6	10	#100	●
8599755	5.5	23	67	6	38.7	25	5.1	10	#100	●
8599760	6	25	69	6	41.6	27.4	5.6	10	#100	●
8599765	6.5	28	72	8	35.9	30	6.1	10	#100	●
8599770	7	28	72	8	38	30	6.6	10	#100	●
8599775	7.5	31	75	8	38.8	33	7.1	10	#100	●
8599780	8	34	78	8	41.6	36.4	7.6	10	#100	●

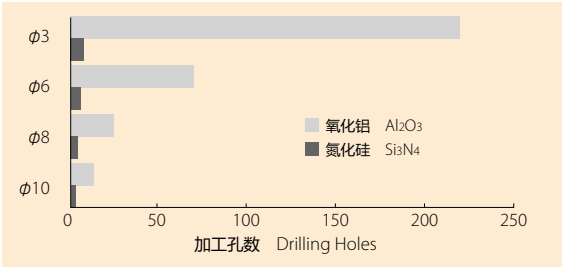
商品号 EDP No.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	ℓ2	颈径 DN	电镀长度 Length of electroplating	粒度 Grit Size	库存 Stock
8599785	8.5	34	84	10	41.6	36	8.1	10	#100	●
8599790	9	37	87	10	43.3	39	8.6	10	#100	●
8599795	9.5	37	87	10	44.7	39	9.1	10	#100	●
8599800	10	40	90	10	47.6	42.4	9.6	10	#100	●
8599805	10.5	40	97	12	48.9	42	10.1	10	#100	●
8599810	11	40	97	12	50.3	42	10.6	10	#100	●
8599815	11.5	44	101	12	51.7	46	11.1	10	#100	●
8599820	12	44	101	12	54.6	46.4	11.6	10	#100	●
8599825	12.5	48	105	12	55	51	12.1	10	#100	●
8599830	13	48	105	12	55	51	12.6	10	#100	●

库存记号 Inventory symbols
●＝标准库存品 Standard stock item
○＝准标准库存品(请确认库存。) Limited standard stock item
▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item
△＝停产产品(请确认库存。) Discontinued item

陶瓷用钻头加工数据 Cutting Data

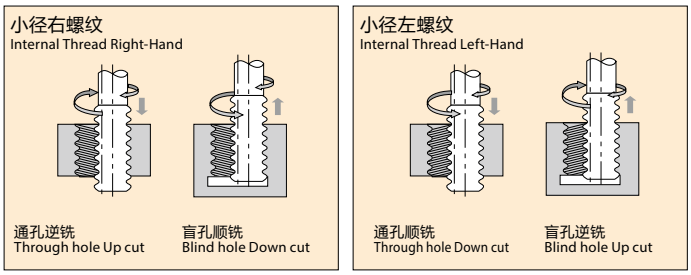
研削条件 Grinding Conditions

	氧化铝 Al_2O_3	氮化硅 Si_3N_4
研削速度 Grinding Speed	90m/mim	50m/min
进给 Feed	3～5mm/min	2～3mm/min
阶梯进给 Step Feed	0.1mm/step	0.05mm/step
孔深 Depth of Hole	1D(D:钻头直径) - 盲孔 (Drill Dia.) (Blind Hole)	
研削油剂 Coolant	水溶性(溶液型) 50倍 Water - Soluble Fluid (×50)	
使用机械 Machine	研磨中心 Grinding Center	



陶瓷用螺纹铣刀 ED-PNT的特点 Features of ED-PNT

加工原理 Machining Technique



ED-PNT采用三轴数控机床对螺纹进行铣削加工。螺纹加工是利用刀具的行星式旋转和公转运动，在轴向每转一圈进给一个螺距。内螺纹和外螺纹，右螺纹和左螺纹都可以用此工具来制作，只需改变旋转和/或进给的方向。(参照左图)

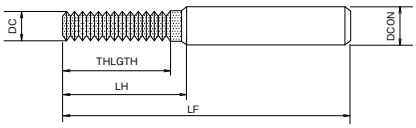
The OSG ED-PNT has been developed for thread milling with a 3 axis CNC controlled machine tool. Thread is processed by advancing one pitch feed per revolution in the axial direction, utilizing the planet like rotation and revolution movements of the tool. Internal and external thread, right or left hand threads can all be produced with this one tool, simply by changing the direction of rotation and/or feed.

主轴旋转方向 Direction of the tool's rotation

切削进给方向 Direction of the tool's feed

电镀金刚石螺纹铣刀 陶瓷用 Electroplated Diamond Taps for Ceramics

ED-PNT



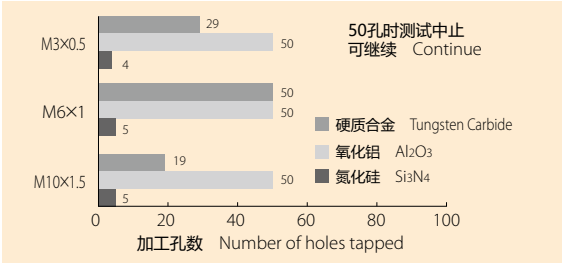
单位 :mm Unit:mm

商品号 EDP NO.	尺寸 Mill Dia	外径 DC	螺距 TP	全长 LF	螺纹长 THLGTH	颈长 LH	柄径 DCON	电镀长度 Length of electroplating	最小加工径 Min.Cutting Bore Dia.	粒度 Grit Size	库存 Stock
8315981	2.2× 7.5 ×P0.5	2.2	0.5	50	7.5	8.5	4	8.5	3	#600	●
8315982	3 × 9.8 ×P0.7	3	0.7	60	9.8	12	6	12	4	#400	●
8315983	3.7×12 ×P0.8	3.7	0.8	60	12	14	6	14	5	#400	●
8315984	4.5×15 ×P1	4.5	1	70	15	18	8	18	6	#400	●
8315985	6 ×20 ×P1.25	6	1.25	70	20	23	8	23	8	#400	●
8315986	7.5×24 ×P1.5	7.5	1.5	80	24	27	10	27	10	#400	●
8315987	9 ×30 ×P1.75	9	1.75	80	30	33	10	33	12	#400	●
8315988	10 ×34 ×P2	10	2	80	34	39	10	39	14	#400	●

陶瓷用螺纹铣刀加工数据 Cutting Data

研削条件 Grinding Conditions

	氧化铝 Al_2O_3	硬质合金 · 氮化硅 Tungsten Carbide/Si_3N_4
研削速度 Grinding Speed	25～40m/mim	25～40m/min
进给 Feed	10～50mm/min	5～20mm/min
切削深度 Depth of cut	0.01～0.02mm/rev	0.005～0.01mm/rev
螺纹长 Tapping Length	2D(盲孔) (Blind Hole)	
研削油剂 Coolant	水溶性(溶液型) 50倍 Water - Soluble Fluid (×50)	
使用机械 Machine	研磨中心 Grinding Center	



库存记号 Inventory symbols

●＝标准库存品 Standard stock item

○＝准标准库存品(请确认库存。) Limited standard stock item

▲＝由新产品及后续产品替代(请确认库存。) Scheduled to be replaced by new product or successor item

△＝停产产品(请确认库存。) Discontinued item

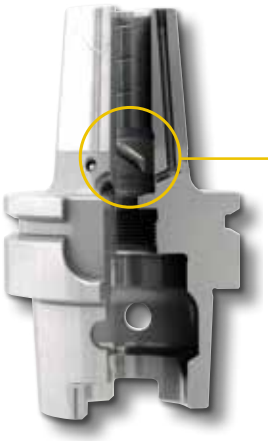
UVX-TI + SAFE-λOCK®新提案
New Tool & Holder Combo

Safe-Lock™系统的特点
Features of Safe-Lock™ system

- 高振动精度（3μm以下）
- 可调整刀具悬伸长度
- 刀具折损也能取出
- 刀柄支持内部供油
- 也适用于高速钢刀具

· High runout accuracy (less than 3㎛)
· Adjustable tool overhang length
· Easy removal of broken tools
· Internal coolant supply capability from the holder
· Applicable to high speed steel tools

即使是高效条件下也能确保加工的安全
The key to stability in high performance machining



SAFE-λOCK®
by HAIMER

SAFE-λOCK®是 Haimer 公司的注册商标。
SAFE-λOCK® is a registered trademark of the Haimer GmbH.

这种时候用Safe-Lock™效果良好
On the safe side with Safe-Lock™

- 加工中的刀具滑出时
- 提高加工效率时
- 不想在加工高价工件时出现不良品
- 大径加工时

· No pull out of the tool
· Achieves maximum metal removal rate
· No damages on expensive work piece
· Ideal for large diameter milling

SAFE-λOCK® 刀柄
SAFE-λOCK® Mechanism Equipped Holder

热缩刀柄 Shrink Fit Type			筒夹刀柄 Collet Type
标准型 Standard Type	强力型 Power Type	重型 Heavy Duty Type	强力型 Power Type
标准热缩刀柄 Shrink Fit Chuck	**强力热缩刀柄** Power Shrink Chuck	**重型热缩刀柄** Heavy Duty Chuck	**强力筒夹刀柄** Power Collet Chuck

热缩机 Power Clamp的特点
Features of the Shrink Fit Machine "Power Clamp"

・可对应柄径φ3~φ50的刀具
・可热缩高速钢刀具
・可短时间内加热冷却
・高安全性
　→避免触碰高热部分的设计
　→带有防止过热的功能
・ 操作性优良

- Applicable to φ3-φ50 of tool shank diameter
- Applicable to high speed steel tools
- Short heating and cooling time
- High level of safety
  →A design decreasing the danger of touching highly heated areas
  →Equipped with an overheating prevention function
- Easy to operate

Power Clamp 配套产品一览
The Power Clamp Package List

OSG-HAIMER将必要的配套品打包化。结合客户的加工环境，选定最合适的机种。
具体详情请咨询我司营业。

OSG-HAIMER includes the parts and accessories necessary for operation in a package.
We select the appropriate machine according to the customer's work environment.
For further details, please contact our sales representative.

套餐名 Package name	Nano	Starter	Standard	Standard Plus	Premium
外观 Appearance	小径用卧式模块 Horizontal model for small diameters	经济款 Simple for first time users	标准模块 Standard model	大径、重型刀柄也可少量热缩*2 Able to do low-volume shrink-fitting with large diameters and heavy duty chucks	大径、重型刀柄也可持续使用 Able to do continuous shrink-fitting with large diameters and heavy duty chucks
机种 Machine name	Power Clamp Nano	Power Clamp Economic NG	Power Clamp Economic Plus NG		Power Clamp Profi Plus NG
对应柄径 Tool shank Dia.	φ3 - φ16	φ3 - φ32	φ3 - φ32	φ3 - φ50	φ3 - φ50
对应主轴类型 Spindle type	BT30/40 HSK25/32/40/50/63	BT30/40/45/50 HSK25/32/40/50/63/80/100/125 Capto C3/C4/C5/C6/C8	BT30/40/45/50 HSK25/32/40/50/63/80/100/125 Capto C3/C4/C5/C6/C8		BT30/40/45/50 HSK25/32/40/50/63/80/100/125 Capto C3/C4/C5/C6/C8
最大长度 Maxmum length	230mm	570mm	570mm		570mm

※ Standard Plus 是在 Standard 中追加 13KW HD 线圈的套餐。

柄部形状 / 突顶尖长 SHANKS/LENGTH OF EXTERNAL CENTER

■柄部四方部形状 Straight shank with flat part

公制螺纹 Metric thread

单位:mm Unit:mm

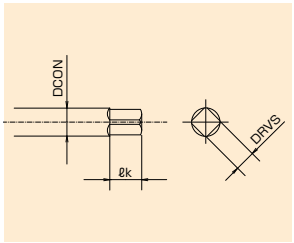
柄径 DCON	四方部长 ℓk	四方部宽 DRVS
3	5	2.5
4	6	3.2
5	7	4
5.5		4.5
6		
6.1	8	5
6.2		
7		5.5
8	9	6
8.5		6.5
9	10	7
9.5		
10	11	8
10.5		
11	12	9
12		
12.5	13	10
13		
14	14	11
15	15	12
16		
17	16	13
18	17	14
19	18	15
20	18	15
21	20	17
22		
23		
24	22	19
25		
26	24	21
28		
30	26	23
32	30	26
35		
38	32	29
40	35	32
42		
44	38	35
46		
48	42	38
50		
52	44	41
55		
58	50	46
60		
65	52	50

美制螺纹 Unified thread

柄径 DCON	四角部长 ℓk	四角部宽 DRVS
3	5	2.5
4	6	3.2
5	7	4
5.5		4.5
6		
6.1	8	5
7		5.5
8	9	6
8.5	9	6.5
9	10	7
10.5	11	8
12	12	9
14	14	11
17	16	13
20	18	15
22	20	17
24	22	19
26	24	21
30	26	23
32	30	26
35		
40	35	32
44	38	35
48	42	38
55	44	41
58	50	46
60		
65	52	50

管用螺纹 Pipe thread

柄径 DCON	四角部长 ℓk	四角部宽 DRVS
8	9	6
11	12	9
14	14	11
18	17	14
19	18	15
23	20	17
24	22	19
26	24	21
28		
32	30	26
35		
38	32	29
42	35	32
46	38	35
55	44	41
65	52	50
70	58	54
75	62	58



■突顶尖长 Length of external center

公制螺纹 Metric thread

单位:mm Unit:mm

尺寸 Size	长度 Length
M 1	(0.4)
M 1.1	(0.4)
M 1.2	(0.5)
M 1.4	(0.6)
M 1.6	(0.6)
M 1.7	(0.7)
M 1.8	(0.7)
M 2	(0.8)
M 2.2	(0.8)
M 2.3	(1)
M 2.5	(1)
M 2.6	(1.1)
M 3	(1.2)
M 3.5	(1.5)
M 4	(1.7)
M 4.5	(1.9)
M 5	(2.2)
M 5.5	(2.4)
M 6	(2.6)
M 7	(3.1)
M 8	(3.5)

仅POT Only for spiral pointed taps

美制螺纹 Unified thread

尺寸 Size	长度 Length
No. 0	(0.6)
No. 1	(0.8)
No. 2	(0.9)
No. 3	(1.1)
No. 4	(1.2)
No. 5	(1.3)
No. 6	(1.5)
No. 8	(1.8)
No. 10	(2.1)
No. 12	(2.4)
U 1/4	(2.7)

※突顶尖长是参考值。 ※The Lengths above are for reference only.

突顶尖长(嵌套螺纹用) LENGTH OF EXTERNAL CENTER(FOR SCREW THREAD INSERT)

■突顶尖长 Length of external center

公制螺纹 Metric thread

单位:mm Unit:mm

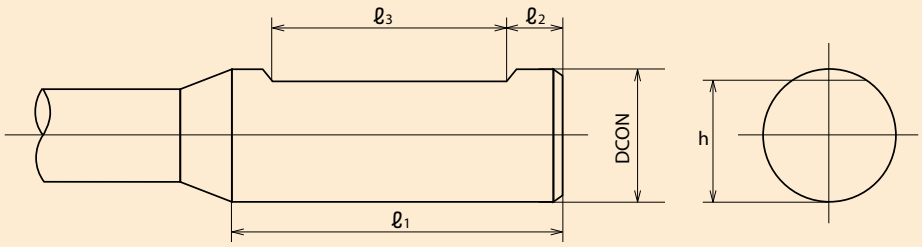
尺寸 Size	先端径 Point Dia.	突顶尖长（设计标准） External Center（Design bas's）	突顶尖长（计算值） External Center（Calculated value）
M 2.5 × 0.45	2.54	1.4	1.4
M 2.6 × 0.45	2.64	1.4	1.4
M 3 × 0.5	3.05	1.6	1.7
M 4 × 0.7	4.07	2.2	2.2
M 5 × 0.8	5.08	2.7	2.8

美制螺纹 Unified thread

单位:mm Unit:mm

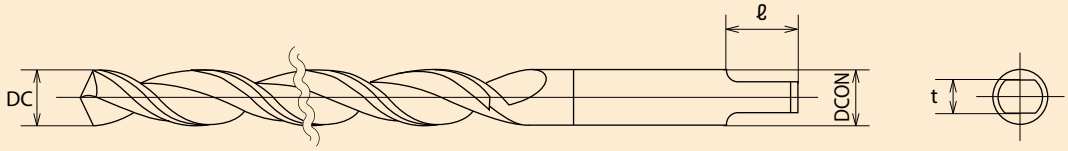
尺寸 Size	先端径 Point Dia.	突顶尖长（设计标准） External Center（Design bas's）	突顶尖长（计算值） External Center（Calculated value）
No. 4 - 40UNC	2.91	1.6	1.6
No. 5 - 40UNC	3.24	1.7	1.8
No. 6 - 40UNF	3.57	1.9	1.9
No. 6 - 32UNC	3.58	1.9	2
No. 8 - 36UNF	4.24	2.3	2.3
No. 8 - 32UNC	4.24	2.3	2.3
No. 10 - 32UNF	4.93	2.6	2.7
No. 10 - 24UNC	4.9	2.6	2.7

■侧固平台式直柄形状
Straight shank with flat part.



柄径 DCON Shank dia.	ℓ1	ℓ2	ℓ3	h
16	48	7	35	15
20	50		38	18.5
25	56		43	23.5
32	60		48	30

■长刃钻头柄部形状
Straight shank with tang part.



钻头直径 DC Drill dia.	柄径 DCON Shank dia		t		ℓ
	标准尺寸 Dimensions	容许差 Tolerance	标准尺寸 Dimensions	容许差 Tolerance	
3 ≦DC≦ 3.98	DC−0.025	0 −0.018	2.4	0 −0.1	7
3.98 <DC≦ 4.77	DC−0.038				
4.77 <DC≦ 6			3.1		8
6 <DC≦ 6.35		0 −0.022			
6.35 <DC≦ 7.94	DC−0.05		4.1		9
7.94 <DC≦ 9.53			5.2		10
9.53 <DC≦ 10			6.2		12
10 <DC≦ 11.91		0 −0.027			
11.91 <DC≦ 12.7			7.7	0 −0.15	13
12.7 <DC≦ 13	DC−0.025				

材料规格比较表 MATERIAL SYMBOL CHART BY STANDARD

材料区分 Description	Japan JIS	U.S.A. ASTM/AISI	Germany DIN	ISO
一般构造用钢 General Structural Steel	SM490A			
	SM490B			
	SM570	C		
	SS400			
	SS330	A	St33	
		B		
		C		
		30		
		33		
		36		
		40		
	SS490	70	St52-3	
	SS540	C		
	SM490A	D		
	SM490B	E		
	SM490C	A		
	SM490Y	B		
	SM520	50W		
	SV330	A	USt36	
	SV400	B		
碳素钢 Carbon Steel	S15C	1015	C15E	C15E4
			C15R	C15M2
	S15CK		C15E	
	S20CK		C20E	
	S25C	1025	C25	C25
			C25E	C25E4
			C25R	C25M2
	S45C	1045	C45	C45
		1046	C45E	C45E4
			C45R	C45M2
	S50C	1050	C50	C50
			C50E	C50E4
			C50R	C50M2
	SB410	Grade60	P265GH	PH265
	SB450	Grade65	P265GH	PH290
	SB450 M	GradeA		
	SB480	Grade70	P355GH	PH315
	SB480 M	GradeB		
合金钢 Alloy Steel	SCM415			
	SCM415H			
	SCM418H		18CrMo4	18CrMo4
			18CrMoS4	18CrMoS4
	SCM420			
	SCM421		22CrMoS35	
	SCM430	4130		
	SCM432			
	SCM435	4135	34CrMo4	34CrMo4
		4137	34CrMoS4V	34CrMoS4
	SCM435H	4135H	34CrMo4	34CrMo4
		4137H	34CrMoS4	34CrMoS4
	SCM440	4140	42CrMo4	42CrMo4
		4142	42CrMoS4	42CrMoS4
	SCM440H	4140H	42CrMo4	42CrMo4
		4142H	42CrMoS4	42CrMoS4
	SCM445	4145		
		4147		
	SCM445H	4145H		
	SCM822			
	SCM822H			
	SCr415		17Cr3	
			17CrS3	
	SCr415H		17Cr3	
			17CrS3	
	SCr420	5120		20Cr4
				20CrS4
	SCr420H	5120H		20Cr4H
				20CrS4
	SCr430	5130	34Cr4	34Cr4
		5132	34CrS4	34CrS4
	SCr430H	5130H	34Cr4	34Cr4
		5132H	34CrS4	34CrS4
	SCr435	5135	37Cr4	34Cr4
			37CrS4	34CrS4
				37Cr4
				37CrS4
	SCr435H	5135H	37Cr4	34Cr4
			37CrS4	37Cr4
	SCr440	5140	41Cr4	37Cr4
			41CrS4	41Cr4
				41CrS4
	SCr440H	5140H	41Cr4	37Cr4
			41CrS4	37CrS4
				41Cr4
				41CrS4
	SCr445			

材料区分 Description	Japan JIS	U.S.A. ASTM/AISI	Germany DIN	ISO
合金钢 Alloy Steel	SMn420	1522		22Mn6
	SMn420H	1522H		22Mn6H
	SMn433	1536		
	SMn433H			
	SMn438	1541		36Mn6
	SMn438H	1541H		36Mn6H
	SMn443	1541		42Mn6
	SMn443H			
	SNC236			
	SNC415			
	SNC415H			
	SNC631			
	SNC631H			
	SNC815		15NiCr13	15NiCr13
	SNC815H		15NiCr13	15NiCr13
	SNC836			
	SNCM220	8615	20NiCrMo2-2	20NiCrMo2
		8617	20NiCrMoS2-2	20NiCrMoS2
		8620		
		8622		
	SNCM220H	8617H	20NiCrMo2-2	20NiCrMo2
		8620H	20NiCrMoS2-2	20NiCrMoS2
		8622H		
	SNCM240	8637		41CrNiMo2
		8640		41CrNiMoS2
	SNCM415			
	SNCM420	4320		
	SNCM420H	4320H		
	SNCM431			
	SNCM439	4340		
	SNCM447			
	SNCM616			
	SNCM625			
	SNCM630			
	SNCM815			
碳素工具钢 Carbon Tool Steel	SK140			
	SK120	W1-11 1/2		C120U
	SK105	W1-10	C105W1	C105U
	SK95	W1-9		
	SK90			C90U
	SK85	W1-8	C80W1	
	SK80			C80U
	SK75	W1-7	C80W1	
	SK65		C70W2	
	SKS2		105WCr6	105WCr1
	SKS11	F2		
	SKS21			
	SKS31		105WCr6	105WCr1
	SKS41			
	SKS43	W2-91/2		TCV105
	SKS44	W2-81/2		
	SKS51	L6		
	SUJ2	52100	100Cr6	1
模具钢 Die Steel	SKD11	D2		
	SKD61	H13	X40CrMoV51	40CrMoV5
高速钢 High Speed Steel	SKH2	T1		HS18-01
	SKH50			HS-1-8-1
	SKH51	M2		HS-6-5-2
	SKH52	M3-1		HS6-5-2
	SKH53	M3-2		HS6-5-3
	SKH54	M4		HS6-6-4
	SKH55			HS6-5-2-5
	SKH56	M36		
	SKH57			HS10-4-3-10
	SKH58	M7		HS2-9-2
	SKH59	M42		HS2-9-1-8
工具钢 Tool Steel	SKT3			
	SKT4			55NiCrMoV7
	SKT6			45NiCrMoV16
管钢 Pipe Steel	STAM290GB			
	SGP	TypeF	St33	
	STKM11A	1008	St34-2	
	STPT370	A	St35.8	
	STB340		St35.8	
	St37.8			
	STPG370	E-A	St37.0	
		A		
	STS370		St37.4	
	STPT410	B	St42.8	
	STB410	C	St42.8	
		A-1	St45.8	
	STPG410	E-B	St44.0	
		B	St44.0	
	STK400		St44-2	TS9
	STKM12B		St44-2	

材料规格比较表 MATERIAL SYMBOL CHART BY STANDARD

材料区分 Description	Japan JIS	U.S.A. ASTM/AISI	Germany DIN	ISO
管钢 Pipe Steel	STKR400		St44-2	
	STAM390G		St44-2	
	STS410		St44.4	
	STKM14A		St45	
	STKM13C	1020	St45	
	STKM18C		St52	
	STKM19A		St52	
	STKM19C		St52	
	STK490		St52-3	TS18
	STKR490		St52-3	
	STS480		St52.4	
	STKM12A			R33
	STKM12B		St44-2	
	STKM13A	1020		
	STKM13C	1020	St45	
	STKM14B	1026		
		1025		
	STKM14C	1026		
		1025		
	STKM17A	1050		
	STKM18B			R50
	STKM18C		St52	
			St52-3	
	STKM19A		St52	
	STKM19C		St52	
耐热钢 Heat Resistant Steel	SUH1	S65007		X45CrSi93
	SUH3			
	SUH4			
	SUH11			X50CrSi182
	SUH21			
	SUH31			
	SUH35			X53CRMnNiN219
	SUH36	S63008		
	SUH37	S63017		
	SUH38			
	SUH309	S30900		
	SUH310	S31000		
	SUH330	N08330		
	SUH409	S40900	X6CrTi12	L-No37X6CrTi12
	SUH409L			L-No36X2CrTi12
	SUH446	S44600		X15CrN26
	SUH600			
	SUH616	S42200		
	SUH660	S66286		
	SUH661	R30155		
快削钢 Free Cutting Steel	SUM11	1110		
	SUM12	1109		
	SUM21	1212		9S20
	SUM22	1213	9SMn28	11SMn28
	SUM22L	12L13	9SMnPb28	11SMnPb
	SUM23	1215		
	SUM23L	12L15		
	SUM24L	12L14	9SMnPb28	11SMnPb28
	SUM25		9SMn36	12SMn35
	SUM31	1117	15S10	
	SUM31L	11L17		
	SUM32			
	SUM41	1137		
	SUM42	1141		
	SUM43	1144		44SMn28
弹性钢 Spring Steel	SUP3	1078		
	SUP6			59Si7
	SUP7	9260		59Si7
	SUP9	5155	55Cr3	55Cr3
	SUP9A	5160		
	SUP10	6150	50CrV4	51CrV4
	SUP11A	51B60		60CrB3
	SUP12		54SiCr6	55SiCr63
	SUP13	4161		60CrMo32
不锈钢 Stainless Steel	SUS304	S30400	X5CrNi1810	L-No6X5CrNi18-9
	SUS405	S40500	X6CrAl13	L-No40X6Cr13
	SUS420F	S42020		
	SUS430	S43000	X6Cr17	L-No41X6Cr17
	SUS430LX	S43035	X6CrNb17	L-No44X3CrTi17
	SUS440A	S44002		
	SUS630	S17400		L-No58-X5CrNiCuNb16-4
	SUS631	S17700	X7CrNiAl177	L-No59X7CrNiAl17-7
	SUS410	S41000	X10Cr13	L-No48X12Cr13
铸钢 Cast Steel	SCH15	HT		
		HT50		
铸铁 Cast Iron	FC250	Class No.35		250
	FC300	Class No.45		300
球墨铸铁 Ductile Cast Iron	FCD400-18	60-40-18	EN GJS-400-18	400-18
	FCD400-15	60-40-18	EN GJS-400-18	400-15
	FCD600-3	80-55-06	EN GJS-600-3	600-3

材料区分 Description	Japan JIS	U.S.A. ASTM/AISI	Germany DIN	ISO
铝合金 Aluminum Alloy	A1080P			
	A1070P			
	A1050P		EN AW-1050A	
	A1100P	1100		Al99.0Cu
	A1200P		EN AW-1200	Al99.0
	A2014P	2014	EN AW-2014	
	A2017P			
	A2017AP	2014	EN AW-2017	AlCu4MgSi (A)
	A2024P	2024	EN AW-2024	AlCu4Mg1
	A2024PC	Alclad 2024		
	A2024BE	2024	EN AW-2024	AlCu4Mg1
	A2024BD	2024	EN AW-2024	AlCu4Mg1
	A2024W	2024	EN AW-2024	AlCu4Mg1
	A2024TD	2024	EN AW-2024	AlCu4Mg1
	A2024S	2024	EN AW-2024	AlCu4Mg1
	A3003P	3003	EN AW-3003	AlMn1Cu
	A5052P	5052	EN AW-5052	AlMg2.5
	A5052BE	5052	EN AW-5052	AlMg2.5
	A5052BD	5052	EN AW-5052	AlMg2.5
	A5052W	5052	EN AW-5052	AlMg2.5
	A5052TD	5052	EN AW-5052	AlMg2.5
	A5052TWA	5052		Al-Mg4.5Mn0.7
	A5052S	5052	EN AW-5052	
	A5052FH			
	A5083BD		EN AW-5083	Al-Mg4.5Mn0.7
	A5083W		EN AW-5083	Al-Mg4.5Mn0.7
	A5083TE	5083	EN AW-5083	Al-Mg4.5Mn0.7
	A5083TD	5083	EN AW-5083	Al-Mg4.5Mn0.7
	A5083TWA	5083		
	A5083S	5083	EN AW-5083	Al-Mg4.5Mn0.7
	A6061P	6061	EN AW-6061	
	A6063TE	6063	EN AW-6083	Al-Mg0.7Si
	A7075P	7075	EN AW-7075	AlZn5.5MgCu
	A7075BE	7075	EN AW-7075	AlZn5.5MgCu
	A7075BD	7075	EN AW-7075	AlZn5.5MgCu
	A7075TE	7075	EN AW-7075	AlZn5.5MgCu
	A7075TD	7075	EN AW-7075	AlZn5.5MgCu
	A7075S	7075	EN AW-7075	AlZn5.5MgCu
	A7075FH	7075	EN AW-7075	
	A7075FD	7075	EN AW-7075	
铝合金铸件 Aluminum Alloy Casting	AC1A			
	AC1B	204.2		
	AC2A			
	AC2B	319.2		
	AC3A			
	AC4A			
	AC4B	333.1	EN AB-46200	
	AC4C	356.2	EN AB-42000	
	AC4CH	A356.2	EN AB-42100	
	AC4D	355.1	EN AB-45300	
	AC5A	242.1		
	AC7A	514.2		
	AC7B			
	AC8A	336.1	EN AB-48000	
	AC8B			
	AC8C	332.1		
	AC9A			
	AC9B			
	ADC1	A413.0		
	ADC3	A360.0		
	ADC5	518.0		
	ADC6			
	ADC10			
	ADC10Z	A380.0		
	ADC12			
	ADC12Z	383.0		
	ADC14	A390.0		
镁合金 Magnesium Alloy	MD1A			
	MD1B	AZ91B		
	MD1D	AZ91D	EN-MB21120	
	MD2B	AM60B	EN-MB21230	
	MD3B	AS41B	EN-MB21320	
	MD4	AM50A	EN-MB21220	
	MD5		EN-MC21210	
	MD6	AS21A	EN-MB21310	
铜、铜铸件 Copper, Copper Casting	C1020P	C10200(B152:97)	OF-Cu	
	C1020PS	C10200(B152:97)	OF-Cu	
	C1020R	C10200(B152:97)	OF-Cu	
	C1020RS	C10200(B152:97)	OF-Cu	
黄铜、黄铜铸件 Brass, Brass Casting	C2600P	C26000(B36:01)	17660:83 CuZn30	
	C2600R	C26000(B36:01)	17660:83 CuZn30	
	C2600RS	C26000(B36:01)	17660:83 CuZn30	
青铜、青铜铸件 Bronze, Bronze Casting	C6140P	C61400(B169:01)		

JIS中规定的代表性公制螺纹的标准尺寸和公差极限尺寸

EXCERPTS OF STANDARD DIMENSIONS AND ALLOWABLE LIMIT DIMENSIONS OF TYPICAL METRIC SCREW THREADS SPECIFIED IN JIS

JIS B 0205-4:2001 表1
Excerpt from JIS B 0205-4: 2001 table 1

JIS B 0209-2:2001 表1,2,3,4
Excerpt from JIS B 0209-2: 2001 table 1, 2, 3 and 4

	螺纹尺寸 Thread size	标准尺寸 Basic dimensions			公差极限尺寸 Tolerance limit dimensions									
		内螺纹 Internal thread			内螺纹 Internal thread					外螺纹 External thread				
		大径 Major dia.	中径 Pitch dia.	小径 Minor dia.	公差等级 Class	中径 Pitch dia.		小径 Minor dia.		公差等级 Class	大径 Major dia.		中径 Pitch dia.	
		外螺纹 External thread												
		大径 Major dia.	中径 Pitch dia.	小径 Minor dia.		最大 Max	最小 Min	最大 Max	最小 Min		最大 Max	最小 Min	最大 Max	最小 Min
	M 1 × 0.25	1.000	0.838	0.729	5H	0.894	0.838	0.785	0.729	6h	1.000	0.933	0.838	0.785
※1	1.1 × 0.25	1.100	0.938	0.829	5H	0.994	0.938	0.885	0.829	6h	1.100	1.033	0.938	0.885
	1.2 × 0.25	1.200	1.038	0.929	5H	1.094	1.038	0.985	0.929	6h	1.200	1.133	1.038	0.985
	1.4 × 0.3	1.400	1.205	1.075	5H	1.265	1.205	1.142	1.075	6h	1.400	1.325	1.205	1.149
	1.6 × 0.35	1.600	1.373	1.221	6H	1.458	1.373	1.321	1.221	6g	1.581	1.496	1.354	1.291
	1.7 × 0.35	—	—	—	—	—	—	—	—	—	—	—	—	—
	1.8 × 0.35	1.800	1.573	1.421	6H	1.658	1.573	1.521	1.421	6g	1.781	1.696	1.554	1.491
	2 × 0.4	2.000	1.740	1.567	6H	1.830	1.740	1.679	1.567	6g	1.981	1.886	1.721	1.654
※1	2.2 × 0.45	2.200	1.908	1.713	6H	2.003	1.908	1.838	1.713	6g	2.180	2.080	1.888	1.817
	2.3 × 0.4	—	—	—	—	—	—	—	—	—	—	—	—	—
	2.5 × 0.45	2.500	2.208	2.013	6H	2.303	2.208	2.138	2.013	6g	2.480	2.380	2.188	2.117
	2.6 × 0.45	—	—	—	—	—	—	—	—	—	—	—	—	—
	3 × 0.5	3.000	2.675	2.459	6H	2.775	2.675	2.599	2.459	6g	2.980	2.874	2.655	2.580
	3.5 × 0.6	3.500	3.110	2.850	6H	3.222	3.110	3.010	2.850	6g	3.479	3.354	3.089	3.004
	4 × 0.7	4.000	3.545	3.242	6H	3.663	3.545	3.422	3.242	6g	3.978	3.838	3.523	3.433
※1	4.5 × 0.75	4.500	4.013	3.688	6H	4.131	4.013	3.878	3.688	6g	4.478	4.338	3.991	3.901
	5 × 0.8	5.000	4.480	4.134	6H	4.605	4.480	4.334	4.134	6g	4.976	4.826	4.456	4.361
	6 × 1	6.000	5.350	4.917	6H	5.500	5.350	5.153	4.917	6g	5.974	5.794	5.324	5.212
	7 × 1	7.000	6.350	5.917	6H	6.500	6.350	6.153	5.917	6g	6.974	6.794	6.324	6.212
	8 × 1.25	8.000	7.188	6.647	6H	7.348	7.188	6.912	6.647	6g	7.972	7.760	7.160	7.042
※1	9 × 1.25	9.000	8.188	7.647	6H	8.348	8.188	7.912	7.647	6g	8.972	8.760	8.160	8.042
※1	9 × 1	9.000	8.350	7.917	6H	8.500	8.350	8.153	7.917	6g	8.974	8.794	8.324	8.212
	10 × 1.5	10.000	9.026	8.376	6H	9.206	9.026	8.676	8.376	6g	9.968	9.732	8.994	8.862
	10 × 1.25	10.000	9.188	8.647	6H	9.348	9.188	8.912	8.647	6g	9.972	9.760	9.160	9.042
	10 × 1	10.000	9.350	8.917	6H	9.500	9.350	9.153	8.917	6g	9.974	9.794	9.324	9.212
※2	10S × 1	10.000	9.350	8.917	—	9.500	9.350	9.153	8.917	—	9.974	9.794	9.324	9.212
※1	11 × 1.5	11.000	10.026	9.376	6H	10.206	10.026	9.676	9.376	6g	10.968	10.732	9.994	9.862
	12 × 1.75	12.000	10.863	10.106	6H	11.063	10.863	10.441	10.106	6g	11.966	11.701	10.829	10.679
	12 × 1.5	12.000	11.026	10.376	6H	11.216	11.026	10.676	10.376	6g	11.968	11.732	10.994	10.854
	12 × 1.25	12.000	11.188	10.647	6H	11.368	11.188	10.912	10.647	6g	11.972	11.760	11.160	11.028
※2	12S × 1.25	12.000	11.188	10.647	—	11.368	11.188	10.912	10.647	—	11.937	11.725	11.125	10.993
※1	12 × 1	12.000	11.350	10.917	6H	11.510	11.350	11.153	10.917	6g	11.974	11.794	11.324	11.206
	14 × 2	14.000	12.701	11.835	6H	12.913	12.701	12.210	11.835	6g	13.962	13.682	12.663	12.503
	14 × 1.5	14.000	13.026	12.376	6H	13.216	13.026	12.676	12.376	6g	13.968	13.732	12.994	12.854
※2	14S × 1.25	14.000	13.188	12.647	—	13.368	13.188	12.912	12.647	—	13.937	13.725	13.125	12.993
	16 × 2	16.000	14.701	13.835	6H	14.913	14.701	14.210	13.835	6g	15.962	15.682	14.663	14.503
	16 × 1.5	16.000	15.026	14.376	6H	15.216	15.026	14.676	14.376	6g	15.968	15.732	14.994	14.854
	18 × 2.5	18.000	16.376	15.294	6H	16.600	16.376	15.744	15.294	6g	17.958	17.623	16.334	16.164
	20 × 2.5	20.000	18.376	17.294	6H	18.600	18.376	17.744	17.294	6g	19.958	19.623	18.334	18.164
	20 × 2	20.000	18.701	17.835	6H	18.913	18.701	18.210	17.835	6g	19.962	19.682	18.663	18.503
	20 × 1.5	20.000	19.026	18.376	6H	19.216	19.026	18.676	18.376	6g	19.968	19.732	18.994	18.854
	22 × 2.5	22.000	20.376	19.294	6H	20.600	20.376	19.744	19.294	6g	21.958	21.623	20.334	20.164
	24 × 3	24.000	22.051	20.752	6H	22.316	22.051	21.252	20.752	6g	23.952	23.577	22.003	21.803
	27 × 3	27.000	25.051	23.752	6H	25.316	25.051	24.252	23.752	6g	26.952	26.577	25.003	24.803
	30 × 3.5	30.000	27.727	26.211	6H	28.007	27.727	26.771	26.211	6g	29.947	29.522	27.674	27.462
	33 × 3.5	33.000	30.727	29.211	6H	31.007	30.727	29.771	29.211	6g	32.947	32.522	30.674	30.462

※1 此螺纹尺寸的公差极限尺寸依据JIS B 0209-3:2001 表1。
※2 摘自JIS B 8031:2006 内燃机 - 火花塞5.2 安装螺钉的尺寸及公差表6安装螺钉的尺寸及公差

*1 Tolerance limit dimensions of thread size are based on JIS B0209-3: 2001 table 1.
*2 Excerpt from JIS B 8031: 2006 internal combustion engine spark plug 5.2 mounting screw dimensions and tolerances table 6 mounting screw dimensions and tolerances.

JIS中规定的代表性公制螺纹的标准尺寸和公差极限尺寸

EXCERPTS OF STANDARD DIMENSIONS AND ALLOWABLE LIMIT DIMENSIONS OF TYPICAL METRIC SCREW THREADS SPECIFIED IN PREVIOUS JIS

JIS B 0205:1982 附录、附属表 ※1
*1 Excerpt from JIS B 0205: 1982 appendix annex
JIS B 0209:1982 附属表1 附录3,4※2
*2 Excerpt from JIS B 0209: 1982 annex 1 appendix table 3 and 4

JIS B 0207:1982 表4※1
*1 Excerpt from JIS B 0207: 1982 table 4
JIS B 0211:1982 附属表1 附录3,4※2
*2 Excerpt from JIS B 0211: 1982 annex appendix table 3 and 4

	螺纹尺寸 Thread size	标准尺寸 Basic dimensions			公差极限尺寸 Tolerance limit dimensions									
		内螺纹 Internal thread			内螺纹 Internal thread					外螺纹 External thread				
		大径 Major dia.	中径 Pitch dia.	小径 Minor dia.	等级 Class	中径 Pitch dia.		小径 Minor dia.		等级 Class	大径 Major dia.		中径 Pitch dia.	
		外螺纹 External thread												
		大径 Major dia.	中径 Pitch dia.	小径 Minor dia.		最大 Max	最小 Min	最大 Max	最小 Min		最大 Max	最小 Min	最大 Max	最小 Min
	M 1 × 0.25	1.000	0.838	0.729	2	0.898	0.838	0.785	0.729	2	0.985	0.940	0.823	0.778
	1.1 × 0.25	1.100	0.938	0.829	2	0.994	0.938	0.885	0.829	2	1.100	1.033	0.938	0.885
	1.2 × 0.25	1.200	1.038	0.929	2	1.098	1.038	0.985	0.929	2	1.185	1.140	1.023	0.978
	1.4 × 0.3	1.400	1.205	1.075	2	1.265	1.205	1.142	1.075	2	1.380	1.320	1.185	1.135
	1.6 × 0.35	1.600	1.373	1.221	2	1.458	1.373	1.321	1.221	2	1.581	1.496	1.354	1.291
	1.7 × 0.35	1.700	1.473	1.321	2	1.543	1.473	1.421	1.321	2	1.680	1.610	1.453	1.393
	1.8 × 0.35	1.800	1.573	1.421	2	1.658	1.573	1.521	1.421	2	1.781	1.696	1.554	1.491
	2 × 0.4	2.000	1.740	1.567	2	1.810	1.740	1.679	1.567	2	1.980	1.890	1.720	1.660
	2.2 × 0.45	2.200	1.908	1.713	2	2.003	1.908	1.838	1.713	2	2.180	2.080	1.888	1.817
	2.3 × 0.4	2.300	2.040	1.867	2	2.110	2.040	1.979	1.867	2	2.280	2.190	2.020	1.960
	2.5 × 0.45	2.500	2.208	2.013	2	2.303	2.208	2.138	2.013	2	2.480	2.380	2.188	2.117
	2.6 × 0.45	2.600	2.308	2.113	2	2.388	2.308	2.238	2.113	2	2.580	2.480	2.288	2.218
	3 × 0.5	3.000	2.675	2.459	2	2.775	2.675	2.599	2.459	2	2.980	2.874	2.655	2.580
	3.5 × 0.6	3.500	3.110	2.850	2	3.200	3.110	3.010	2.850	2	3.470	3.360	3.080	3.010
	4 × 0.7	4.000	3.545	3.242	2	3.663	3.545	3.422	3.242	2	3.978	3.838	3.523	3.433
	4.5 × 0.75	4.500	4.013	3.688	2	4.113	4.013	3.878	3.688	2	4.470	4.340	3.983	3.893
	5 × 0.8	5.000	4.480	4.134	2	4.605	4.480	4.334	4.134	2	4.976	4.826	4.456	4.361
	6 × 1	6.000	5.350	4.917	2	5.470	5.350	5.153	4.917	2	5.970	5.820	5.320	5.220
	7 × 1	7.000	6.350	5.917	2	6.470	6.350	6.153	5.917	2	6.970	6.820	6.320	6.220
	8 × 1.25	8.000	7.188	6.647	2	7.318	7.188	6.912	6.647	2	7.960	7.790	7.148	7.038
	9 × 1.25	9.000	8.188	7.647	2	8.318	8.188	7.912	7.647	2	8.960	8.790	8.148	8.038
	9 × 1	9.000	8.350	7.917	2	8.470	8.350	8.153	7.917	2	8.970	8.830	8.320	8.220
	10 × 1.5	10.000	9.026	8.376	2	9.166	9.026	8.676	8.376	2	9.960	9.770	8.986	8.866
	10 × 1.25	10.000	9.188	8.647	2	9.318	9.188	8.912	8.647	2	9.960	9.810	9.148	9.038
	10 × 1	10.000	9.350	8.917	2	9.480	9.350	9.153	8.917	2	9.970	9.820	9.320	9.210
※3	10S × 1	10.000	9.350	8.917	—	9.480	9.370	8.950	8.790	—	9.974	9.794	9.324	9.212
	11 × 1.5	11.000	10.026	9.376	2	10.206	10.026	9.676	9.376	2	10.968	10.732	9.994	9.862
	12 × 1.75	12.000	10.863	10.106	2	11.023	10.863	10.441	10.106	2	11.950	11.760	10.813	10.683
	12 × 1.5	12.000	11.026	10.376	2	11.176	11.026	10.676	10.376	2	11.960	11.790	10.986	10.856
	12 × 1.25	12.000	11.188	10.647	2	11.368	11.188	10.912	10.647	2	11.972	11.760	11.160	11.028
※3	12S × 1.25	12.000	11.188	10.647	—	11.338	11.208	10.676	10.491	—	11.937	11.725	11.125	10.993
	12 × 1	12.000	11.350	10.917	2	11.490	11.350	11.153	10.917	2	11.960	11.810	11.310	11.190
	14 × 2	14.000	12.701	11.835	2	12.871	12.701	12.210	11.835	2	13.950	13.740	12.651	12.511
	14 × 1.5	14.000	13.026	12.376	2	13.176	13.026	12.676	12.376	2	13.960	13.790	12.986	12.856
※3	14S × 1.25	14.000	13.188	12.647	—	13.338	13.208	12.676	12.491	—	13.937	13.725	13.125	12.993
	16 × 2	16.000	14.701	13.835	2	14.871	14.701	14.210	13.835	2	15.950	15.740	14.651	14.511
	16 × 1.5	16.000	15.026	14.376	2	15.176	15.026	14.676	14.376	2	15.960	15.790	14.986	14.856
	18 × 2.5	18.000	16.376	15.294	2	16.566	16.376	15.744	15.294	2	17.950	17.710	16.326	16.166
	20 × 2.5	20.000	18.376	17.294	2	18.566	18.376	17.744	17.294	2	19.950	19.710	18.326	18.166
	20 × 2	20.000	18.701	17.835	2	18.881	18.701	18.210	17.835	2	19.950	19.650	18.651	18.491
	20 × 1.5	20.000	19.026	18.376	2	19.196	19.026	18.676	18.376	2	19.950	19.780	18.976	18.826
	22 × 2.5	22.000	20.376	19.294	2	20.566	20.376	19.744	19.294	2	21.950	21.710	20.326	20.166
	24 × 3	24.000	22.051	20.752	2	22.251	22.051	21.252	20.752	2	23.940	23.680	21.991	21.821
	27 × 3	27.000	25.051	23.752	2	25.251	25.051	24.252	23.752	2	26.940	26.680	24.991	24.821
	30 × 3.5	30.000	27.727	26.211	2	27.947	27.727	26.771	26.211	2	29.940	29.660	27.667	27.477
	33 × 3.5	33.000	30.727	29.211	2	30.947	30.727	29.771	29.211	2	32.940	32.660	30.667	30.477

※1 JIS B 0205,0207,0209,JIS B 0211,JIS B 0215已废除，修订为JIS B 0209-1,-2,-3,-4,-5:2001。
※2 JIS B 0209:1982 公制粗牙螺纹的公差极限尺寸及公差 附属表1、附属表2，JIS B 0211:1982 公制细牙螺纹的公差极限尺寸及公差附属表于1997年被废除。
※3 摘自 JIS B 8031:1974 内燃机用火花塞公差极限尺寸

*1 JIS B 0205,0207,0209, JIS B 0211, JIS B 0215 have been abolished and revised to JIS B 0209-1, -2, -3, -4, -5: 2001.
*2 The appendixes of the following have been abolished in 1997: JIS B 0209: 1982 tolerance limit dimensions and tolerances for metric coarse threads annex 1, annex 2 and JIS B 0211: 1982 tolerance limit dimensions and tolerances for metric fine threads.
*3 Excerpt from JIS B 8031: 1974 allowable limit of spark plugs for internal combustion engines.

孔和轴的公差表 TABLE OF TOLERANCES FOR HOLES AND SHAFTS

孔公差 (摘自JIS B 0401-2:2016(ISO286-2:2010)表3,4,5,6,7,8,9)

Tolerance for Holes (Excerpt from JIS B 0401-2: 2016 (ISO286-2: 2010) Table 3,4,5,6,7,8,9)

(单位：μm)(Unit：μm)

图示尺寸 Illustrated Size (mm)		E			F			G		H					JS		K		M		N	
以上 Over	以下 Up to	7	8	9	6	7	8	6	7	6	7	8	9	10	6	7	6	7	6	7	6	7
—	3	+24 +14	+28 +14	+39 +14	+12 +6	+16 +6	+20 +6	+8 +2	+12 +2	+6 0	+10 0	+14 0	+25 0	+40 0	±3	±5	0 -6	0 -10	-2 -8	-2 -12	-4 -10	-4 -14
3	6	+32 +20	+38 +20	+50 +20	+18 +10	+22 +10	+28 +10	+12 +4	+16 +4	+8 0	+12 0	+18 0	+30 0	+48 0	±4	±6	+2 -6	+3 -9	-1 -9	0 -12	-5 -13	-4 -16
6	10	+40 +25	+47 +25	+61 +25	+22 +13	+28 +13	+35 +13	+14 +5	+20 +5	+9 0	+15 0	+22 0	+36 0	+58 0	±4.5	±7.5	+2 -7	+5 -10	-3 -12	0 -15	-7 -16	-4 -19
10	14	+50 +32	+59 +32	+75 +32	+27 +16	+34 +16	+43 +16	+17 +6	+24 +6	+11 0	+18 0	+27 0	+43 0	+70 0	±5.5	±9	+2 -9	+6 -12	-4 -15	0 -18	-9 -20	-5 -23
14	18																					
18	24	+61 +40	+73 +40	+92 +40	+33 +20	+41 +20	+53 +20	+20 +7	+28 +7	+13 0	+21 0	+33 0	+52 0	+84 0	±6.5	±10.5	+2 -11	+6 -15	-4 -17	0 -21	-11 -24	-7 -28
24	30																					
30	40	+75 +50	+89 +50	+112 +50	+41 +25	+50 +25	+64 +25	+25 +9	+34 +9	+16 0	+25 0	+39 0	+62 0	+100 0	±8	±12.5	+3 -13	+7 -18	-4 -20	0 -25	-12 -28	-8 -33
40	50																					
50	65	+90 +60	+106 +60	+134 +60	+49 +30	+60 +30	+76 +30	+29 +10	+40 +10	+19 0	+30 0	+46 0	+74 0	+120 0	±9.5	±15	+4 -15	+9 -21	-5 -24	0 -30	-14 -33	-9 -39
65	80																					
80	100	+107 +72	+126 +72	+159 +72	+58 +36	+71 +36	+90 +36	+34 +12	+47 +12	+22 0	+35 0	+54 0	+87 0	+140 0	±11	±17.5	+4 -18	+10 -25	-6 -28	0 -35	-16 -38	-10 -45
100	120																					
120	140	+125 +85	+148 +85	+185 +85	+68 +43	+83 +43	+106 +43	+39 +14	+54 +14	+25 0	+40 0	+63 0	+100 0	+160 0	±12.5	±20	+4 -21	+12 -28	-8 -33	0 -40	-20 -45	-12 -52
140	160																					
160	180																					

上表的每格中，上面的数值是上公差，下面的是下公差。

In every step given in the table, the value on the upper side shows the upper deviation and the value on the lower side, the lower deviation.

轴公差 (摘自JIS B 0401-2:2016(ISO286-2:2010)表19,20,21,22,23,24,25)

Tolerance for Holes (Excerpt from JIS B 0401-2: 2016 (ISO286-2: 2010) Table 19,20,21,22,23,24,25)

(单位：μm)(Unit：μm)

图示尺寸 Illustrated Size (mm)		e			f			g		h						js			k		m		n
以上 Over	以下 Up to	7	8	9	6	7	8	5	6	4	5	6	7	8	9	5	6	7	5	6	5	6	6
—	3	-14 -24	-14 -28	-14 -39	-6 -12	-6 -16	-6 -20	-2 -6	-2 -8	0 -3	0 -4	0 -6	0 -10	0 -14	0 -25	±2	±3	±5	+4 0	+6 0	+6 +2	+8 +2	+10 +4
3	6	-20 -32	-20 -38	-20 -50	-10 -18	-10 -22	-10 -28	-4 -9	-4 -12	0 -4	0 -5	0 -8	0 -12	0 -18	0 -30	±2.5	±4	±6	+6 +1	+9 +1	+9 +4	+12 +4	+16 +8
6	10	-25 -40	-25 -47	-25 -61	-13 -22	-13 -28	-13 -35	-5 -11	-5 -14	0 -4	0 -6	0 -9	0 -15	0 -22	0 -36	±3	±4.5	±7.5	+7 +1	+10 +1	+12 +6	+15 +6	+19 +10
10	14	-32 -50	-32 -59	-32 -75	-16 -27	-16 -34	-16 -43	-6 -14	-6 -17	0 -5	0 -8	0 -11	0 -18	0 -27	0 -43	±4	±5.5	±9	+9 +1	+12 +1	+15 +7	+18 +7	+23 +12
14	18																						
18	24	-40 -61	-40 -73	-40 -92	-20 -33	-20 -41	-20 -53	-7 -16	-7 -20	0 -6	0 -9	0 -13	0 -21	0 -33	0 -52	±4.5	±6.5	±10.5	+11 +2	+15 +2	+17 +8	+21 +8	+28 +15
24	30																						
30	40	-50 -75	-50 -89	-50 -112	-25 -41	-25 -50	-25 -64	-9 -20	-9 -25	0 -7	0 -11	0 -16	0 -25	0 -39	0 -62	±5.5	±8	±12.5	+13 +2	+18 +2	+20 +9	+25 +9	+33 +17
40	50																						
50	65	-60 -90	-60 -106	-60 -134	-30 -49	-30 -60	-30 -76	-10 -23	-10 -29	0 -8	0 -13	0 -19	0 -30	0 -46	0 -74	±6.5	±9.5	±15	+15 +2	+21 +2	+24 +11	+30 +11	+39 +20
65	80																						
80	100	-72 -107	-72 -126	-72 -159	-36 -58	-36 -71	-36 -90	-12 -27	-12 -34	0 -10	0 -15	0 -22	0 -35	0 -54	0 -87	±7.5	±11	±17.5	+18 +3	+25 +3	+28 +13	+35 +13	+45 +23
100	120																						
120	140	-85 -125	-85 -148	-85 -185	-43 -68	-43 -83	-43 -106	-14 -32	-14 -39	0 -12	0 -18	0 -25	0 -40	0 -63	0 -100	±9	±12.5	±20	+21 +3	+28 +3	+33 +15	+40 +15	+52 +27
140	160																						
160	180																						

上表的每格中，上面的数值是上公差，下面的是下公差。

In every step given in the table, the value on the upper side shows the upper deviation and the value on the lower side, the lower deviation.

硬度换算表 COMPARISON CHART SCALE FOR HARDNESS

钢的洛氏硬度的近似换算表 Approximate relationship between various hardness scales

(HRC) 洛氏硬度[注1] Rockwell hardness C scale 150kg Brale	(HV) 维氏硬度 Diamond Pyramid hardness number, Vickers	布氏硬度 10mm 球，负重 29.42KN Brinell hardness 29.42kN			洛氏硬度[注1] Rockwell hardness			洛氏superficial硬度 金刚石圆锥压子 Rockwell hardness			(Hs) 肖氏硬度 Shore scleroscope hardness number	拉伸强度 N/mm² Approx. tensile strength N/mm²	(HRC) 洛氏硬度[注1] Rockwell hardness C scale 150kg Brale
		标准球 Standard 10mm ball	Hultgren球 Hultgren 10mm ball	硬质合金球 Tungsten carbide 10mm	(HRA) 负重558.4N 金刚石圆锥压子 A scale 60Kg Brale	(HRB) 负重980.7N 直径1/16in球 B scale 100Kg 1/16-in	(HRD) 负重980.7N 金刚石圆锥压子 D scale 100Kg Brale	15N 负重147.1N Superficial 15N	30N 负重294.2N Superficial 30N	45N 负重441.3N Superficial 45N			
68	**940**	—	—	—	**85.6**	—	**76.9**	**93.2**	**84.4**	**75.4**	97	—	**68**
67	**900**	—	—	—	**85.0**	—	**76.1**	**92.9**	**83.6**	**74.2**	95	—	**67**
66	**865**	—	—	—	**84.5**	—	**75.4**	**92.5**	**82.8**	**73.3**	92	—	**66**
65	**832**	—	—	**739**	**83.9**	—	**74.5**	**92.2**	**81.9**	**72.0**	91	—	**65**
64	**800**	—	—	**722**	**83.4**	—	**73.8**	**91.8**	**81.1**	**71.0**	88	—	**64**
63	**772**	—	—	**705**	**82.8**	—	**73.0**	**91.4**	**80.1**	**69.9**	87	—	**63**
62	**746**	—	—	**688**	**82.3**	—	**72.2**	**91.1**	**79.3**	**68.8**	85	—	**62**
61	**720**	—	—	**670**	**81.8**	—	**71.5**	**90.7**	**78.4**	**67.7**	83	—	**61**
60	**697**	—	**613**	**654**	**81.2**	—	**70.7**	**90.2**	**77.5**	**66.6**	81	—	**60**
59	**674**	—	**599**	**634**	**80.7**	—	**69.9**	**89.8**	**76.6**	**65.5**	80	—	**59**
58	**653**	—	**587**	**615**	**80.1**	—	**69.2**	**89.3**	**75.7**	**64.3**	78	—	**58**
57	**633**	—	**575**	**595**	**79.6**	—	**68.5**	**88.9**	**74.8**	**63.2**	76	—	**57**
56	**613**	—	**561**	**577**	**79.0**	—	**67.7**	**88.3**	**73.9**	**62.0**	75	—	**56**
55	**595**	—	**546**	**560**	**78.5**	—	**66.9**	**87.9**	**73.0**	**60.9**	74	**2079**	**55**
54	**577**	—	**534**	**543**	**78.0**	—	**66.1**	**87.4**	**72.0**	**59.8**	72	**2010**	**54**
53	**560**	—	**519**	**525**	**77.4**	—	**65.4**	**86.9**	**71.2**	**58.6**	71	**1952**	**53**
52	**544**	**500**	**508**	**512**	**76.8**	—	**64.6**	**86.4**	**70.2**	**57.4**	69	**1883**	**52**
51	**528**	**487**	**494**	**496**	**76.3**	—	**63.8**	**85.9**	**69.4**	**56.1**	68	**1824**	**51**
50	**513**	**475**	**481**	**481**	**75.9**	—	**63.1**	**85.5**	**68.5**	**55.0**	67	**1755**	**50**
49	**498**	**464**	**469**	**469**	**75.2**	—	**62.1**	**85.0**	**67.6**	**53.8**	66	**1687**	**49**
48	**484**	**451**	**455**	**455**	**74.7**	—	**61.4**	**84.5**	**66.7**	**52.5**	64	**1638**	**48**
47	**471**	**442**	**443**	**443**	**74.1**	—	**60.8**	**83.9**	**65.8**	**51.4**	63	**1579**	**47**
46	**458**	**432**	**432**	**432**	**73.6**	—	**60.0**	**83.5**	**64.8**	**50.3**	62	**1530**	**46**
45	**446**	**421**	**421**	**421**	**73.1**	—	**59.2**	**83.0**	**64.0**	**49.0**	60	**1481**	**45**
44	**434**	**409**	**409**	**409**	**72.5**	—	**58.5**	**82.5**	**63.1**	**47.8**	58	**1432**	**44**
43	**423**	**400**	**400**	**400**	**72.0**	—	**57.7**	**82.0**	**62.2**	**46.7**	57	**1383**	**43**
42	**412**	**390**	**390**	**390**	**71.5**	—	**56.9**	**81.5**	**61.3**	**45.5**	56	**1334**	**42**
41	**402**	**381**	**381**	**381**	**70.9**	—	**56.2**	**80.9**	**60.4**	**44.3**	55	**1294**	**41**
40	**392**	**371**	**371**	**371**	**70.4**	—	**55.4**	**80.4**	**59.5**	**43.1**	54	**1245**	**40**
39	**382**	**362**	**362**	**362**	**69.9**	—	**54.6**	**79.9**	**58.6**	**41.9**	52	**1216**	**39**
38	**372**	**353**	**353**	**353**	**69.4**	—	**53.8**	**79.4**	**57.7**	**40.8**	51	**1177**	**38**
37	**363**	**344**	**344**	**344**	**68.9**	—	**53.1**	**78.8**	**56.8**	**39.6**	50	**1157**	**37**
36	**354**	**336**	**336**	**336**	**68.4**	(109.0)	**52.3**	**78.3**	**55.9**	**38.4**	49	**1118**	**36**
35	**345**	**327**	**327**	**327**	**67.9**	(108.5)	**51.5**	**77.7**	**55.0**	**37.2**	48	**1079**	**35**
34	**336**	**319**	**319**	**319**	**67.4**	(108.0)	**50.8**	**77.2**	**54.2**	**36.1**	47	**1059**	**34**
33	**327**	**311**	**311**	**311**	**66.8**	(107.5)	**50.0**	**76.6**	**53.3**	**34.9**	46	**1030**	**33**
32	**318**	**301**	**301**	**301**	**66.3**	(107.0)	**49.2**	**76.1**	**52.1**	**33.7**	44	**1000**	**32**
31	**310**	**294**	**294**	**294**	**65.8**	(106.0)	**48.4**	**75.6**	**51.3**	**32.5**	43	**981**	**31**
30	**302**	**286**	**286**	**286**	**65.3**	(105.5)	**47.7**	**75.0**	**50.4**	**31.3**	42	**951**	**30**
29	**294**	**279**	**279**	**279**	**64.7**	(104.5)	**47.0**	**74.5**	**49.5**	**30.1**	41	**932**	**29**
28	**286**	**271**	**271**	**271**	**64.3**	(104.0)	**46.1**	**73.9**	**48.6**	**28.9**	41	**912**	**28**
27	**279**	**264**	**264**	**264**	**63.8**	(103.0)	**45.2**	**73.3**	**47.7**	**27.8**	40	**883**	**27**
26	**272**	**258**	**258**	**258**	**63.3**	(102.5)	**44.6**	**72.8**	**46.8**	**26.7**	38	**863**	**26**
25	**266**	**253**	**253**	**253**	**62.8**	(101.5)	**43.8**	**72.2**	**45.9**	**25.5**	38	**843**	**25**
24	**260**	**247**	**247**	**247**	**62.4**	(101.0)	**43.1**	**71.6**	**45.0**	**24.3**	37	**824**	**24**
23	**254**	**243**	**243**	**243**	**62.0**	100.0	**42.1**	**71.0**	**44.0**	**23.1**	36	**804**	**23**
22	**248**	**237**	**237**	**237**	**61.5**	99.0	**41.6**	**70.5**	**43.2**	**22.0**	35	**785**	**22**
21	**243**	**231**	**231**	**231**	**61.0**	98.5	**40.9**	**69.9**	**42.3**	**20.7**	35	**775**	**21**
20	**238**	**226**	**226**	**226**	**60.5**	97.8	**40.1**	**69.4**	**41.5**	**19.6**	34	**755**	**20**
(18)	230	219	219	219	—	96.7	—	—	—	—	33	736	(18)
(16)	222	212	212	212	—	95.5	—	—	—	—	32	706	(16)
(14)	213	203	203	203	—	93.9	—	—	—	—	31	677	(14)
(12)	204	194	194	194	—	92.3	—	—	—	—	29	647	(12)
(10)	196	187	187	187	—	90.7	—	—	—	—	28	618	(10)
(8)	188	179	179	179	—	89.5	—	—	—	—	27	598	(8)
(6)	180	171	171	171	—	87.1	—	—	—	—	26	579	(6)
(4)	173	165	165	165	—	85.5	—	—	—	—	25	549	(4)
(2)	166	158	158	158	—	83.5	—	—	—	—	24	530	(2)
(0)	160	152	152	152	—	81.7	—	—	—	—	24	520	(0)

字体大的数字是根据 ASTM E 140 所示，这些是由 SAE、ASM 和 ASTM 共同调整的。

注 1： 表中括号（ ）内的数字表示不经常使用范围。

Figures shown in boldface is based on ASTM E140 Figure 2, which is jointly coordinated by SAE, ASM and ASTM.

In above chart, figures with ( ) are not commonly used.

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产品索引表 CLASSIFIED BY ALPHABETICAL ORDER	1019 ～1034

- 本样本登载的产品，虽标有库存，但由于新材料、新产品的开发，更改废番的情况也有。
- 式样，形状，表内数值也可能会有变动。
- The inventory status is indicated for respective products on this catalogue. However, the products may be improved or discontinued due to development of new materials and products, etc.
- Specifications, shapes, values in the tables, etc. are subject to change without prior notice.

产品索引表 CLASSIFIED BY ALPHABETICAL ORDER

	页码 Page	商品记号 Abbreviation	品名	Description
A	759	A-CHT	FX涂层内冷油孔硬质合金直槽丝锥	FX Coated Carbide Straight Fluted Tap with Internal Coolant Supply
	647	A-CSF	FX涂层内冷油孔硬质合金螺旋槽丝锥	FX Coated Carbide Spiral Fluted Tap with Internal Coolant Supply
	137	AD-2D	EgiAs涂层硬质合金钻头2D型	EgiAs Coated Carbide Drill (2D Type)
	141	AD-4D	EgiAs涂层硬质合金钻头4D型	EgiAs Coated Carbide Drill (4D Type)
	344	ADF-2D	EgiAs涂层硬质合金平头钻2D型	EgiAs Coated Carbide Flat Drill (2D Type)
	356	ADFLS-2D	EgiAs涂层硬质合金平头钻长柄2D型	EgiAs Coated Carbide Flat Drill with Long Shank (2D Type)
	359	ADFO-3D	EgiAs涂层硬质合金内冷油孔平头钻3D型	EgiAs Coated Carbide Flat Drill with Internal Coolant Supply (3D Type)
	325	AD-LDS	EgiAs涂层硬质合金中心钻	EgiAs Coated Carbide Starter Drill
	326	AD-LS-LDS	EgiAs涂层硬质合金中心钻 长柄型	EgiAs Coated Carbide Starter Drill with Long Shank
	149	ADO-3D	EgiAs涂层内冷油孔硬质合金钻头3D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (3D Type)
	153	ADO-5D	EgiAs涂层内冷油孔硬质合金钻头5D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (5D Type)
	157	ADO-8D	EgiAs涂层内冷油孔硬质合金钻头8D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (8D Type)
	160	ADO-10D	EgiAs涂层内冷油孔硬质合金10D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (10D Type)
	162	ADO-15D	EgiAs涂层内冷油孔硬质合金15D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (15D Type)
	164	ADO-20D	EgiAs涂层内冷油孔硬质合金20D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (20D Type)
	166	ADO-25D	EgiAs涂层内冷油孔硬质合金钻头25D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (25D Type)
	168	ADO-30D	EgiAs涂层内冷油孔硬质合金钻头30D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (30D Type)
	170	ADO-40D	EgiAs涂层内冷油孔硬质合金钻头40D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (40D Type)
	171	ADO-50D	EgiAs涂层内冷油孔硬质合金钻头50D型	EgiAs Coated Carbide Drill with Internal Coolant Supply (50D Type)
	144	ADO-MICRO2D	IchAda涂层小径内冷油孔硬质合金钻头2D型	IchAda Coated Small Diameter Carbide Drill with Internal Coolant Supply (2D Type)
	145	ADO-MICRO5D	IchAda涂层小径内冷油孔硬质合金钻头5D型	IchAda Coated Small Diameter Carbide Drill with Internal Coolant Supply (5D Type)
	146	ADO-MICRO12D	IchAda涂层小径内冷油孔硬质合金钻头12D型	IchAda Coated Small Diameter Carbide Drill with Internal Coolant Supply (12D Type)
	147	ADO-MICRO20D	IchAda涂层小径内冷油孔硬质合金钻头20D型	IchAda Coated Small Diameter Carbide Drill with Internal Coolant Supply (20D Type)
	148	ADO-MICRO30D	IchAda涂层小径内冷油孔硬质合金钻头30D型	IchAda Coated Small Diameter Carbide Drill with Internal Coolant Supply (30D Type)
	172	ADO-PLT	超长刃钻头用EgiAs涂层硬质合金导向钻	EgiAs Coated Carbide Pilot Drill with Internal Coolant Supply for Extra Long Drills
	173	ADO-SUS-3D	不锈钢 · 钛合金用WXL涂层内冷油孔硬质合金钻头3D型	WXL Coated Carbide Drill with Internal Coolant Supply for Stainless Steel and Titanium Alloy (3D Type)
	176	ADO-SUS-5D	不锈钢 · 钛合金用WXL涂层内冷油孔硬质合金钻头5D型	WXL Coated Carbide Drill with Internal Coolant Supply for Stainless Steel and Titanium Alloy (5D Type)
	180	ADO-SUS-8D	不锈钢 · 钛合金用WXL涂层内冷油孔硬质合金钻头8D型	WXL Coated Carbide Drill with Internal Coolant Supply for Stainless Steel and Titanium Alloy (8D Type)
	182	ADO-TRS-3D	EgiAs涂层3刃内冷油孔硬质合金钻头 3D型	EgiAs Coated 3-flute Carbide Drill with Internal Coolant Supply (3D Type)
	184	ADO-TRS-5D	EgiAs涂层3刃内冷油孔硬质合金钻头 5D型	EgiAs Coated 3-flute Carbide Drill with Internal Coolant Supply (5D Type)
	373	AERO-ETL	铝合金用DLC涂层3刃硬质合金铣刀长刃型	DLC Coated 3-flute Carbide End Mill Long Length for Aluminum Alloys
	372	AERO-ETS	铝合金用DLC涂层3刃硬质合金铣刀短刃型	DLC Coated 3-flute Carbide End Mill Short Length for Aluminum Alloys
	374	AERO-EXTL	铝合金用DLC涂层3刃硬质合金铣刀超长刃型	DLC Coated 3-flute Carbide End Mill Extra Long Length for Aluminum Alloys
	373	AERO-O-ETS	铝合金用DLC涂层3刃内冷油孔硬质合金铣刀短刃型	DLC Coated 3-flute Carbide End Mill Short Length with Internal Coolant Supply for Aluminum Alloys
	320	AE-BD-H	高硬度钢 · 高精度精加工用DUROREY涂层2刃硬质合金球头铣刀	DUROREY Coated 2-flute High-precision Finishing Carbide Ball End Mill for High-hardness Steels
	333	AE-BM-H	高硬度钢用DUROREY涂层4刃硬质合金球头铣刀 高效率型	DUROREY Coated 4-flute High-efficiency Carbide Ball End Mill for High-hardness Steels
	396	AE-CPR4-H	高硬度钢用DUROREY涂层4刃硬质合金长颈圆弧角铣刀	DUROREY Coated 4-flute Long Neck Carbide End Mill with Corner Radius for High-hardness Steels
	344	AE-LNBD-H	高硬度钢 · 高精度精加工用DUROREY涂层2刃硬质合金长颈球头铣刀	DUROREY Coated 2-flute High-precision Long Neck Carbide Ball End Mill for High-hardness Steels
	353	AE-LNBD-N	铜电极用DLC涂层2刃硬质合金长颈球头铣刀	DLC Coated 2-flute Long Neck Carbide Ball End Mill for Copper Electrodes
	303	AE-ML-H	高硬度钢用DUROREY涂层硬质合金铣刀 长刃型	DUROREY Coated Carbide End Mill Long Length for High-hardness Steels
	286•395	AE-MS-H	高硬度钢用DUROREY涂层硬质合金铣刀 短刃型	DUROREY Coated Carbide End Mill Short Length for High-hardness Steels
	285	AE-MSS-H	高硬度钢用DUROREY涂层硬质合金铣刀 超短刃型	DUROREY Coated Carbide End Mill Stub Length for High-hardness Steels

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	页码 Page	商品记号 Abbreviation	品名	Description
A	280	AE-TL-N	非铁金属加工用DLC涂层3刃硬质合金铣刀 长刃型	DLC Coated 3-flute Carbide End Mills Long Length for Non-ferrous Materials
	274•389	AE-TS-N	非铁金属加工用DLC涂层3刃硬质合金铣刀 短刃型	DLC Coated 3-flute Carbide End Mill Short Length for Non-ferrous Materials
	284•387	AE-VMFE	DUARISE涂层硬质合金抗振铣刀 深壁加工型	DUARISE Coated Carbide End Mill for Deep Side Milling
	301•367	AE-VML	DUARISE涂层硬质合金抗振铣刀 长刃型	DUARISE Coated Anti-Vibration Carbide End Mill Long Length
	297•366	AE-VMS	DUARISE涂层硬质合金抗振铣刀 短刃型	DUARISE Coated Anti-Vibration Carbide End Mill Short Length
	292•314	AE-VMSS	DUARISE涂层硬质合金抗振铣刀 超短刃型	DUARISE Coated Anti-Vibration Carbide End Mill Stub Length
	307•391	AE-VTFE-N	非铁金属加工用DLC涂层3刃硬质合金铣刀 高性能深壁加工型	DLC Coated 3-flute High Performance Carbide End Mill for Deep Side Milling in Non-ferrous Materials
	276•390	AE-VTS-N	非铁金属加工用DLC涂层3刃硬质合金铣刀 高性能短刃型	DLC Coated 3-flute High Performance Carbide End Mill Short Length for Non-ferrous Materials
	305	AE-VTSS	DUARISE涂层硬质合金抗振铣刀自动车床对应型	DUARISE Coated Anti-Vibration Carbide Stub End Mill Compatible with Sliding Head Lathes
	726	AL-EDS	铝合金用2刃高速钢平头铣刀 短刃型	2-flute End Mill Short Length for Aluminum Alloys
	757	AL-HT	铝用高速钢直槽丝锥	Straight Fluted Hand Tap for Aluminum Alloys
	662	A-LT-POT	高效率 · 多功能V涂层高速钢刃倾角丝锥 长柄型	V Coated High-efficiency and Multi-purpose Spiral Pointed Tap with Long Shank
	591	A-LT-SFT	高效率 · 多功能V涂层高速钢螺旋槽丝锥 长柄型	V Coated High-efficiency and Multi-purpose Spiral Fluted Tap with Long Shank
	816	A-LT-SFT HL	高效率 · 多功能V涂层高速钢嵌套螺纹用螺旋槽丝锥 长柄型	V Coated High-efficiency and Multi-purpose Spiral Fluted Tap with Long Shank for Helicoil/EG/STI
	379	AM-CRE	增材制造用DUROREY涂层硬质合金圆弧角铣刀	DUROREY Coated Carbide End Mill with Corner Radius for Additive Manufacturing
	330	AM-EBT	增材制造用DUROREY涂层3刃硬质合金球头铣刀	DUROREY Coated 3-flute Carbide Ball End Mill for Additive Manufacturing
	380	AM-HFC	增材制造用DUROREY涂层6刃高进给硬质合金圆弧角铣刀	DUROREY Coated High Feed 6-flute Carbide End Mill Radius Type for Additive Manufacturing
	657	A-POT	高效率 · 多功能V涂层高速钢刃倾角丝锥	V Coated High-efficiency and Multi-purpose Spiral Pointed Tap
	583	A-SFT	高效率 · 多功能V涂层高速钢螺旋槽丝锥	V Coated High-efficiency and Multi-purpose Spiral Fluted Tap
	815	A-SFT HL	高效率 · 多功能V涂层高速钢嵌套螺纹用螺旋槽丝锥	V Coated High-efficiency and Multi-purpose Spiral Fluted Tap for Helicoil/EG/STI
	796	A-SPT(G)	高效率 · 多功能V涂层高速钢平行管螺纹用螺旋槽丝锥	V Coated High-efficiency and Multi-purpose Spiral Fluted Parallel Pipe Thread Tap
	813	A-SPT(NPS)	高效率 · 多功能V涂层高速钢平行管螺纹用螺旋槽丝锥	V Coated High-efficiency and Multi-purpose Spiral Fluted Parallel Pipe Thread Tap
	792	A-SPT(Rp)	高效率 · 多功能V涂层高速钢平行管螺纹用螺旋槽丝锥	V Coated High-efficiency and Multi-purpose Spiral Fluted Parallel Pipe Thread Tap
	808	A-S-TPT(NPT)	高效率 · 多功能V涂层高速钢锥管螺纹用螺旋槽丝锥 短螺纹型	V Coated High-efficiency and Multi-purpose Spiral Fluted Taper Pipe Thread Tap (Short Thread)
	768	A-S-TPT(PT)	高效率 · 多功能V涂层高速钢锥管螺纹用螺旋槽丝锥 短螺纹型	V Coated High-efficiency and Multi-purpose Spiral Fluted Taper Pipe Thread Tap (Short Thread)
	503	AT-1	EgiAs涂层硬质合金One Revolution螺纹铣刀	EgiAs Coated One Pass Carbide Thread Mill
	506	AT-2	高硬度钢用DUROREY涂层带底刃硬质合金螺纹铣刀	DUROREY Coated Carbide Thread Mill with End-cutting Edge for High-hardness Steels
	509	AT-2 R-SPEC	非铁金属加工用DLC涂层高效率带底刃硬质合金螺纹铣刀	DLC Coated High-efficiency Carbide Thread Mill with End-cutting Edge for Non-ferrous Materials
	982	A-TPD	锥管螺纹用板牙	Adjustable Round Dies for Taper Pipe Thread
	807	A-TPT(NPT)	高效率 · 多功能V涂层高速钢锥管螺纹用螺旋槽丝锥	V Coated High-efficiency and Multi-purpose Spiral Fluted Taper Pipe Thread Tap
	767	A-TPT(PT,Rc)	高效率 · 多功能V涂层高速钢锥管螺纹用螺旋槽丝锥	V Coated High-efficiency and Multi-purpose Spiral Fluted Taper Pipe Thread Tap
	543	A-XPF	高效率 · 多功能挤压丝锥	Highly Efficient Multi-purpose Forming Tap
B	581	B-HRT	非铁合金用氮化处理高速钢挤压丝锥 (Hi-Roll)	Fluteless (Hi-Roll) Tap for Non-ferrous Materials
	813	BKMS	多刃曲纹形铣刀 短刃型	Multiple-flute Best-Kut End Mill Short Length
	571	B-NRT	非铁合金用氮化处理高速钢挤压丝锥(Nu-Roll)	Fluteless (Nu-Roll) Tap for Non-ferrous Materials
C	388	CA-CR-ETS	铜 · 铝合金用3刃硬质合金圆弧角铣刀 短刃型	3-flute Carbide End Mill Short Length with Corner Radius for Copper and Aluminum Alloys
	278	CA-ETS	铜 · 铝合金用3刃硬质合金平头铣刀 短刃型	3-flute Carbide End Mill Short Length for Copper and Aluminum Alloys
	449	CA-LS-SCC	铜 · 铝 · 倒角用2刃硬质合金铣刀 长柄型	2-flute Carbide End Mill with Long Shank for Chamfering Copper and Aluminum Alloys
	306	CA-MFE	铜 · 铝合金用3刃硬质合金铣刀 深壁加工型	3-flute Carbide End Mill for Deep Side Milling in Copper and Aluminum Alloys
	424	CA-MFE-SF	铜 · 铝合金用3刃硬质合金圆弧角铣刀深壁加工型 (热缩刀柄适用)	3-flute Carbide End Mill with Corner Radius for Deep Side Milling in Copper and Aluminum Alloys (Shrink Fit Type)
	205	CAO-GDXL	铜 · 铝用内冷油孔硬质合金超长刃型钻头	Carbide Drill Extra Long Length with Internal Coolant Supply for Copper Alloys and Aluminum Alloys
	327	CAP-EBD	铜 · 铝合金 · 塑料用2刃硬质合金球头铣刀	2-flute Carbide Ball End Mill for Copper, Aluminum Alloys and Plastics

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C	392	CA-PKE	铜 · 铝合金用3刃硬质合金圆弧角铣刀 多功能强力型	3-flute Carbide End Mill with Corner Radius High Speed Pocket Operation Type for Copper and Aluminum Alloys
	273	CA-RG-EDL	铜 · 铝合金用2刃硬质合金平头铣刀 长刃型	2-flute Carbide End Mill Long Length for Copper and Aluminum Alloys
	266	CA-RG-EDS	铜 · 铝合金用2刃硬质合金平头铣刀 短刃型	2-flute Carbide End Mill Short Length for Copper and Aluminum Alloys
	448	CA-SCC	铜 · 铝 · 倒角用2刃硬质合金螺旋槽长柄型	2-flute Carbide End Mill for Chamfering Copper and Aluminum Alloys
	377	CBN-CR-EDS	2刃CBN圆弧角铣刀 短刃型	2-flute CBN End Mill Short Length with Corner Radius
	327	CBN-EBD	2刃CBN球头铣刀	2-flute CBN Ball End Mill
	355	CBN-LN-SXB	2刃小径CBN长颈球头铣刀	2-flute Long Neck Small Size CBN Ball End Mill
	415	CBN-LN-SXR	2刃小径CBN长颈圆弧角铣刀	2-flute Long Neck Small Size CBN End Mill with Corner Radius
	326	CBN-SXB	2刃小径CBN球头铣刀	2-flute Small Size CBN Ball End Mill
	419	CBN-SXR	2刃小径CBN圆弧角铣刀	2-flute Small Size CBN End Mill with Corner Radius
	765	CC-EML	4刃高速钢平头铣刀 中心切削长刃型	4-flute End Mill Center Cut Long Length
	755	CC-EMS	4刃高速钢平头铣刀 中心切削短刃型	4-flute End Mill Center Cut Short Length
	630	CC-SUS-SFT	不锈钢用高速钢螺旋槽丝锥 水溶性切削油剂对应型	Spiral Fluted Tap for Stainless Steels (Compatible with Water-soluble Coolant)
	758	CE-EMS	多刃高速钢平头铣刀 带中心孔短刃型	Multiple-flute End Mill Short Length with Center Hole
	418	CM-CRE	陶瓷铣刀 底刃型	Ceramic End Mill Bottom Cutting Edge Type
	417	CM-RMS	陶瓷铣刀 外周刃型	Ceramic End Mill Outer Cutting Edge Type
	724	CPM-EDS	2刃CPM平头铣刀 短刃型	2-flute CPM End Mill Short Length
	768	CPM-EML	4刃CPM平头铣刀 长刃型	4-flute CPM End Mill Long Length
	761	CPM-EMS	多刃CPM平头铣刀 短刃型	Multiple-flute CPM End Mill Short Length
	749	CPM-HT	难加工材料用粉末高速钢直槽丝锥	CPM Straight Fluted Tap
	750	CPM-LT	难加工材料用粉末高速钢直槽丝锥长柄型	CPM Straight Fluted Tap with Long Shank
	682	CPM-LT-POT	难加工材料用粉末高速钢刃倾角丝锥 长柄型	CPM Spiral Pointed Tap with Long Shank
	629	CPM-LT-SFT	难加工材料用粉末高速钢螺旋槽丝锥 长柄型	CPM Spiral Fluted Tap with Long Shank
	780	CPM-LT-S-TPT	难加工材料用粉末高速钢锥管螺纹用丝锥 长柄短螺纹型	CPM Taper Pipe Thread Tap with Long Shank (Short Thread)
	681	CPM-POT	难加工材料用粉末高速钢刃倾角丝锥	CPM Spiral Pointed Tap
	628	CPM-SFT	难加工材料用粉末高速钢螺旋槽丝锥	CPM Spiral Fluted Tap
	800	CPM-SPT	难加工材料用粉末高速钢平行管螺纹用丝锥	CPM Parallel Pipe Thread Tap
	743	CPM-STDN	成形用2刃CPM铣刀 直刃中等刃长型	2-flute CPM Straight Fluted End Mill Medium Length for Reforming
	780	CPM-S-TPT	难加工材料用粉末高速钢锥管螺纹用丝锥 短螺纹型	CPM Taper Pipe Thread Tap (Short Thread)
	779	CPM-TPT	难加工材料用粉末高速钢锥管螺纹用丝锥	CPM Taper Pipe Thread Tap
	373	CRM	硬质合金直刃铰刀	Carbide Straight Reamer
	783	CR-XPM-EDS	2刃XPM圆弧角铣刀 短刃型	2-flute XPM End Mill Short Length with Corner Radius
	576	CU-NRT	铜用CrN涂层高速钢挤压丝锥	CrN Coated Fluteless (Nu-Roll) Tap for Copper
	692	CU-POT	铜用CrN涂层高速钢刃倾角丝锥	CrN Coated Spiral Pointed Tap for Copper
	649	CU-SFT	铜用CrN涂层高速钢螺旋槽丝锥	CrN Coated Spiral Fluted Tap for Copper
D	461	DCE	硬质合金菱纹刃形铣刀	Diamond Cut Carbide Router
	880	DC-P	WALTER 盘铣刀PRO	WALTER Disc Cutter PRO (Finishing)
	879	DC-S	WALTER 盘铣刀S	WALTER Disc Cutter S (Roughing)
	501	DCT	螺纹铣刀用径补偿工具 (带刻度)	Diameter Correction Tool for Thread Mill (with Scale)
	499	DCT75	螺纹铣刀用径补偿工具	Diameter Correction Tool for Thread Mill
	249	D-DAD	CFRP用DIA涂层硬质合金双角钻头	Diamond Coated Double Angle Carbide Drill for Composite Material
	731	DE-XPM-EDN	深加工用2刃XPM平头铣刀 中等刃长型	2-flute XPM End Mill Medium Length for Deep Contouring

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D	751	DE-XPM-EMS	深加工用4刃XPM平头铣刀 短刃型	4-flute XPM End Mill Short Length for Deep Contouring
	416	DG-CPR	石墨用DG涂层2刃 · 4刃硬质合金长颈圆弧角铣刀	DG Coated 2-flute and 4-flute Long Neck Carbide End Mills with Corner Radius
	243	D-GDN	DIA涂层硬质合金钻头 中等刃长型	Diamond Coated Carbide Drill Medium Length
	251	D-GDN90	CFRP用DIA涂层硬质合金钻头 中等刃长型先端角90°	Diamond Coated Drill for Composite Material (90° Point Angle)
	329	DG-EBD	石墨用DG涂层2刃硬质合金球头铣刀	DG Coated 2-flute Carbide Ball End Mill for Graphite
	334	DG-EBM	石墨用DG涂层4刃硬质合金球头铣刀	DG Coated 4-flute Carbide Ball End Mill for Graphite
	289	DG-EMS	石墨用DG涂层4刃硬质合金平头铣刀 短刃型	DG Coated 4-flute Carbide End Mill Short Length for Graphite
	351	DG-LN-EBD	石墨用DG涂层2刃硬质合金长颈球头铣刀	DG Coated 2-flute Long Neck Carbide Ball End Mill for Graphite
	352	DG-LN-EBM	石墨用DG涂层4刃硬质合金长颈球头铣刀	DG Coated 4-flute Long Neck Carbide Ball End Mill for Graphite
	317	DG-LN-EMS	石墨用DG涂层4刃硬质合金长颈平头铣刀 短刃型	DG Coated 4-flute Long Neck Carbide End Mill Short Length for Graphite
	454	DIA-BNC	DIA涂层硬质合金细菱纹铣刀	Diamond Coated Fine Nicked Carbide Router
	457	DIA-DCE	DIA涂层硬质合金交叉刃形铣刀 含底刃	Diamond Coated Cross-flute Carbide Router with End Mill Cut
	456	DIA-DCR	DIA涂层硬质合金交叉刃形铣刀 含底刃	Diamond Coated Diamond Cut Carbide Router with End Mill Cut
	329	DIA-EBD	DIA涂层2刃硬质合金球头铣刀	Diamond Coated 2-flute Carbide Ball End Mill
	336	DIA-EBD-SF	DIA涂层2刃硬质合金球头铣刀 (热缩刀柄适用)	Diamond Coated 2-flute Carbide Ball End Mill (Shrink Fit Type)
	268	DIA-EDS	DIA涂层2刃硬质合金平头铣刀 短刃型	Diamond Coated 2-flute Carbide End Mill Short Length
	459	DIA-HBC4	DIA涂层4刃硬质合金人字形铣刀	Diamond Coated Carbide Router for CFRP Herringbone Type
	455	DIA-HBC60	DIA涂层硬质合金人字形铣刀 60°	Diamond Coated Carbide Router Herringbone Type (60°)
	351	DIA-LN-EBD	DIA涂层2刃硬质合金长颈球头铣刀	Diamond Coated 2-flute Long Neck Carbide Ball End Mill
	422	DIA-LS-CRED	DIA涂层2刃硬质合金圆弧角铣刀 长柄型	Diamond Coated 2-flute Carbide End Mill with Long Shank
	460	DIA-MFC	精加工用DIA涂层多刃硬质合金铣刀	Diamond Coated Multiple-flute Carbide Router for Finishing
	458	DIA-REC	粗加工用DIA涂层硬质合金铣刀 波纹型	Diamond Coated Carbide Router for Roughing
	372	DLC-AIR-EDS	铝合金用DLC涂层2刃硬质合金铣刀 短刃型	DLC Coated 2-flute Carbide End Mill Short Length for Aluminum Alloys
	328	DLC-EBD	DLC涂层2刃硬质合金球头铣刀	DLC Coated 2-flute Ball Carbide End Mill
	268	DLC-EDS	DLC涂层2刃硬质合金平头铣刀 短刃型	DLC Coated 2-flute Carbide End Mill Short Length
	279	DLC-ETS	DLC涂层3刃硬质合金平头铣刀 短刃型	DLC Coated 3-flute Carbide End Mill Short Length
	938	DLC-LG	DLC涂层螺纹用极限量规	DLC Coated Thread Limit Gauge
	352	DLC-LN-EBD	DLC涂层2刃硬质合金长颈球头铣刀	DLC Coated 2-flute Long Neck Carbide Ball End Mill
	313	DLC-LN-EDS	DLC涂层2刃硬质合金长颈平头铣刀 短刃型	DLC Coated 2-flute Long Neck Carbide End Mill Short Length
	393	DLC-PKE	DLC涂层硬质合金圆弧角铣刀 多功能强力型	DLC Coated 4-flute Carbide End Mill High Speed Pocket Operation Type
	991	DP	搓丝板	Thread Rolling Flat Dies
	522	DR-O-PNAC	复合加工用FX涂层内冷油孔超级螺纹铣刀	FX Coated Super-Planet Cutter (Thread Milling Cutter with Drill) with Internal Coolant Supply
	521	DR-PNAC	复合加工用FX涂层超级螺纹铣刀	FX Coated Super-Planet Cutter (Thread Milling Cutter with Drill)
	827	DRT	钻攻一体式丝锥	Straight Fluted Tap Combined with Drill
	248	D-STAD	CFRP用DIA涂层硬质合金三角钻头	Diamond Coated Triple Angle Carbide Drill for Composite Material
E	780	EBD	2刃高速钢球头铣刀	2-flute Ball End Mill
	782	EBM	多刃高速钢球头铣刀	Multiple-flute Ball End Mill
	245	ED-DS	电镀金刚石钻头 陶瓷用	Electroplated Diamond Drill for Ceramics
	463	ED-EM	电镀金刚石铣刀	Electroplated Diamond Router for CFRP
	739	EDL	2刃高速钢平头铣刀 长刃型	2-flute End Mill Long Length
	733	EDN	2刃高速钢平头铣刀 中等刃长型	2-flute End Mill Medium Length
	522	ED-PNT	电镀金刚石陶瓷用螺纹铣刀	Electroplated Diamond Thread Mill for Ceramics

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产品索引表 CLASSIFIED BY ALPHABETICAL ORDER

	页码 Page	商品记号 Abbreviation	品名	Description
E	716	EDS	2刃高速钢平头铣刀 短刃型	2-flute End Mill Short Length
	705	EDS-3	2刃高速钢平头铣刀 (小径型)	2-flute Miniature End Mill (φ3 Shank)
	723	EKD	键槽用2刃高速钢平头铣刀	2-flute End Mill for Keyway
	744	ETS	3刃高速钢平头铣刀 短刃型	3-flute End Mill Short Length
	645	EX-AL-SFT	铝用高速钢螺旋槽丝锥	Spiral Fluted Tap for Aluminum Alloys
	642	EX-B-DH-SFT	非铁 · 深孔用高速钢螺旋槽丝锥	Spiral Fluted Tap for Non-ferrous Materials and Deep Holes
	758	EX-DC-HT	铸件用氮化处理高速钢直槽丝锥	Straight Fluted Tap for Die Castings
	687	EX-DH-POT	深孔用氧化处理高速钢刃倾角丝锥	Spiral Pointed Tap for Deep Holes (with OX)
	742	EXDL	2刃高速钢平头铣刀 超长刃型	2-flute End Mill Extra Long Length
	753	EX-FC-HT	铸铁用氮化处理高速钢直槽丝锥	Straight Fluted Tap for Cast Iron
	754	EX-FC-LT	铸铁用氮化处理高速钢直槽丝锥 长柄型	Straight Fluted Tap with Long Shank for Cast Iron
	783	EX-FC-TPT	铸铁用高速钢锥管螺纹丝锥	Taper Pipe Thread Tap for Cast Iron
	294	EX-GDN	TiN涂层高速钢钻头 中等刃长型	TiN Coated Drill Medium Length (EX-GOLD Drill)
	297	EX-GDR	TiN涂层高速钢钻头 标准刃长型	TiN Coated Drill Regular Length (EX-GOLD Drill)
	290	EX-GDS	TiN涂层高速钢钻头 超短刃型	TiN Coated Drill Stub Length (EX-GOLD Drill)
	301	EX-GDXL	TiN涂层高速钢钻头 长刃型	TiN Coated Drill Long Length (EX-GOLD Drill)
	648	EX-HC-SFT	高碳素钢用高速钢螺旋槽丝锥	Spiral Fluted Tap for High Carbon Steels
	319	EX-H-DRL	清除折损丝锥用硬质合金钻头	Carbide Drill for Tap Removal
	818	EX-HL-POT	嵌套螺纹用高速钢刃倾角丝锥	Spiral Pointed Tap for Helicoil/EG/STI
	817	EX-HL-SFT	嵌套螺纹用高速钢螺旋槽丝锥	Spiral Fluted Tap for Helicoil/EG/STI
	744	EX-H-LT	氧化处理高速钢直槽丝锥 长柄型	Straight Fluted Tap with Long Shank for General Applications (with OX)
	305	EX-HO-GDR	TiN涂层内冷油孔高速钢钻头 标准刃长型	TiN Coated Drill Regular Length with Internal Coolant Supply (EX-GOLD Drill)
	675	EX-H-POT	氧化处理高速钢刃倾角丝锥	Spiral Pointed Tap for General Applications (with OX)
	613	EX-H-SFT	氧化处理高速钢螺旋槽丝锥	Spiral Fluted Tap for General Applications (with OX)
	789	EX-IRT	氧化处理高速钢锥管螺纹丝锥 跳牙型	Taper Pipe Thread Tap with Interrupted Threads (with OX)
	812	EX-IRT(NPTF)	氧化处理高速钢锥管螺纹丝锥 跳牙型	Taper Pipe Thread Tap with Interrupted Threads (with OX)
	293	EX-LS-GDS	TiN涂层高速钢钻头 长柄超短刃型	TiN Coated Drill Stub Length with Long Shank (EX-GOLD Drill)
	820	EX-LS-REBS	高速钢粗加工球头铣刀 长柄型	Roughing Ball End Mill Short Length with Long Shank
	799	EX-LS-REES	高速钢粗加工铣刀 长柄短刃型	Roughing End Mill Short Length with Long Shank
	797	EX-LS-RESF	细齿纹高速钢粗加工铣刀 长柄短刃型	Roughing End Mill Fine Pitch Short Length with Long Shank
	737	EX-LT	高速钢直槽丝锥 长柄型	Straight Fluted Tap with Long Shank for General Applications
	689	EX-LT-DH-POT	深孔用氧化处理高速钢刃倾角丝锥 长柄型	Spiral Pointed Tap with Long Shank for Deep Holes (with OX)
	676	EX-LT-H-POT	氧化处理高速钢刃倾角丝锥 长柄型	Spiral Pointed Tap with Long Shank for General Applications (with OX)
	615	EX-LT-H-SFT	氧化处理高速钢螺旋槽丝锥 长柄型	Spiral Fluted Tap with Long Shank for General Applications (with OX)
	790	EX-LT-IRT	氧化处理高速钢锥管螺纹丝锥 长柄跳牙型	Taper Pipe Thread Tap with Interrupted Threads with Long Shank (with OX)
	742	EX-LT-OST	中径加大用高速钢直槽丝锥 长柄型	Straight Fluted Tap with Long Shank for Oversize
	671	EX-LT-POT	高速钢刃倾角丝锥 长柄型	Spiral Pointed Tap with Long Shank for General Applications
	606	EX-LT-SFT	高速钢螺旋槽丝锥 长柄型	Spiral Fluted Tap with Long Shank for General Applications
	790	EX-LT-S-IRT	氧化处理高速钢锥管螺纹丝锥 跳牙短螺纹长柄型	Taper Pipe Thread Tap with Interrupted Threads with Long Shank (Short Thread)
	686	EX-LT-SUS-POT	不锈钢用氧化处理高速钢刃倾角丝锥 长柄型	Spiral Pointed Tap with Long Shank for Stainless Steels (with OX)
	635	EX-LT-SUS-SFT	不锈钢用氧化处理高速钢螺旋槽丝锥 长柄型	Spiral Fluted Tap with Long Shank for Stainless Steels (with OX)
	826	EX-MCT	加工中心用氧化处理高速钢丝锥 长柄型	LH Spiral Fluted Tap with Long Shank for Machining Centers (with OX)

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	页码 Page	商品记号 Abbreviation	品名	Description
	769	EXML	多刃高速钢平头铣刀 超长刃型	Multiple-flute End Mill Extra Long Length
	307	EX-MT-GDR	TiN涂层高速钢钻头 MT柄标准刃长型	TiN Coated Drill Regular Length with Morse Taper Shank (EX-GOLD Drill)
	318	EX-MT-TDR	钢筋用TiN涂层高速钢钻头 MT柄	TiN Coated Drill Regular Length with Morse Taper Shank for Steel Frame
	736	EX-OST	中径加大用高速钢直槽丝锥	Straight Fluted Tap for Oversize
	757	EX-PLA-HT	树脂用氮化处理高速钢直槽丝锥	Straight Fluted Tap for Plastic and Resin
	665	EX-POT	高速钢刃倾角丝锥	Spiral Pointed Tap for General Applications
	806	EX-POT-SPT	高速钢平行管螺纹刃倾角丝锥	Spiral Pointed Parallel Pipe Thread Tap
	807	EX-REEL	高速钢粗加工铣刀 长刃型	Roughing End Mill Long Length
	803	EX-REEN	高速钢粗加工铣刀 中等刃长型	Roughing End Mill Medium Length
	798	EX-REES	高速钢粗加工铣刀 短刃型	Roughing End Mill Short Length
	808	EX-REXL	高速钢粗加工铣刀 超长刃型	Roughing End Mill Extra Long Length
	617	EX-SC-SFT	高速钢螺旋槽丝锥 短切削锥型	Spiral Fluted Tap Short Chamfer type
	595	EX-SFT	高速钢螺旋槽丝锥	Spiral Fluted Tap for General Applications
	763	EX-SH-HT	高硬度钢用高速钢直槽丝锥	Straight Fluted Tap for High-hardness Steels
	789	EX-S-IRT	氧化处理高速钢锥管螺纹丝锥 跳牙短螺纹型	Taper Pipe Thread Tap with Interrupted Threads (with OX, Short Thread)
	826	EX-S-MCT	加工中心用氧化处理高速钢丝锥 短刃型	LH Spiral Fluted Tap for Machining Centers (Normal Length)
	798	EX-SPT	中径加大用高速钢平行管螺纹丝锥	Oversize Parallel Pipe Thread Tap
	691	EX-SS-POT	薄板用氧化处理高速钢刃倾角丝锥	Spiral Pointed Tap for Sheet Steels (with OX)
	745	EX-SST	深孔用高速钢直槽丝锥 细柄型	Straight Fluted Tap with Slim Shank for Deep Holes
	281	EX-SUS-GDN	不锈钢 · 软钢用TiN涂层高速钢钻头 中等刃长型	TiN Coated Drill Medium Length for Stainless and Mild Steels (EX-GOLD Drill)
	283	EX-SUS-GDR	不锈钢 · 软钢用TiN涂层高速钢钻头 标准刃长型	TiN Coated Drill Regular Length for Stainless and Mild Steels (EX-GOLD Drill)
	273	EX-SUS-GDS	不锈钢 · 软钢用TiN涂层高速钢钻头 超短刃型	TiN Coated Drill Stub Length for Stainless and Mild Steels (EX-GOLD Drill)
	752	EX-SUS-HT	不锈钢用氧化处理高速钢直槽丝锥	Straight Fluted Tap for Stainless Steels (with OX)
	683	EX-SUS-POT	不锈钢用氧化处理高速钢刃倾角丝锥	Spiral Pointed Tap for Stainless Steels (with OX)
	631	EX-SUS-SFT	不锈钢用氧化处理高速钢螺旋槽丝锥	Spiral Fluted Tap for Stainless Steels (with OX)
	801	EX-SUS-SPT(PF)	不锈钢用氧化处理高速钢平行管螺纹丝锥	Parallel Pipe Thread Tap for Stainless Steels (with OX)
	795	EX-SUS-SPT(PS,Rp)	不锈钢用氧化处理高速钢平行管螺纹丝锥	Parallel Pipe Thread Tap for Stainless Steels (with OX)
	786	EX-SUS-S-TPT	不锈钢用氧化处理高速钢锥管螺纹丝锥 短螺纹型	Taper Pipe Thread Tap for Stainless Steels (with OX, Short Thread)
	786	EX-SUS-TPT	不锈钢用氧化处理高速钢锥管螺纹丝锥	Taper Pipe Thread Tap for Stainless Steels (with OX)
	779	EX-TIN-EBD	TiN涂层2刃高速钢球头铣刀	TiN Coated 2-flute Ball End Mill
	737	EX-TIN-EDL	TiN涂层2刃高速钢平头铣刀 长刃型	TiN Coated 2-flute End Mill Long Length
	732	EX-TIN-EDN	TiN涂层2刃高速钢平头铣刀 中等刃长型	TiN Coated 2-flute End Mill Medium Length
	711	EX-TIN-EDS	TiN涂层2刃高速钢平头铣刀 短刃型	TiN Coated 2-flute End Mill Short Length
	715	EX-TIN-EKD	键槽用TiN涂层2刃高速钢平头铣刀	TiN Coated 2-flute End Mill for Keyway
	764	EX-TIN-EML	TiN涂层4刃高速钢平头铣刀 长刃型	TiN Coated 4-flute End Mill Long Length
	752	EX-TIN-EMS	TiN涂层多刃高速钢平头铣刀 短刃型	TiN Coated 4-flute End Mill Short Length
	806	EX-TIN-RELF	TiN涂层细齿纹高速钢粗加工铣刀 长刃型	TiN Coated Roughing End Mill Fine Pitch Long Length
	801	EX-TIN-RENF	TiN涂层细齿纹高速钢粗加工铣刀 中等刃长型	TiN Coated Roughing End Mill Fine Pitch Medium Length
	795	EX-TIN-RESF	TiN涂层细齿纹高速钢粗加工铣刀 短刃型	TiN Coated Roughing End Mill Fine Pitch Short Length
	605	EXZ-SFT	高耐久型特殊表面处理高速钢螺旋槽丝锥	Highly Durable Spiral Fluted Tap for General Applications
F	209	FH-GDN	高硬度钢用FX涂层硬质合金钻头 中等刃长型	FX Coated Carbide Drill Medium Length for High-hardness Steels
	208	FH-GDS	高硬度钢用FX涂层硬质合金钻头 超短刃型	FX Coated Carbide Drills Stub Length for High-hardness Steels

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F	215	FHL-GDTS	高硬度钢用FX涂层3刃硬质合金钻头 长颈超短刃型	FX Coated 3-flute Long Neck Carbide Drill Stub Length for High-hardness Steels
	218	FTO-H-GDXL	高硬度模具材料用FX涂层内冷油孔硬质合金钻头 超长刃型	FX Coated Carbide Drill Extra Long Length with Internal Coolant Supply for Hard Mold Materials
	217	FTO-M-GDXL	模具用FX涂层内冷油孔硬质合金钻头 超长刃型	FX Coated Carbide Drill Extra Long Length with Internal Coolant Supply for Molds
	376	FX-CR-MG-EDL	FX涂层2刃硬质合金圆弧角铣刀 长刃型	FX Coated 2-flute Carbide End Mill Long Length with Corner Radius
	375	FX-CR-MG-EDS	FX涂层2刃硬质合金圆弧角铣刀 短刃型	FX Coated 2-flute Carbide End Mill Short Length with Corner Radius
	384	FX-CR-MG-EHS	FX涂层硬质合金圆弧角铣刀 大螺旋短刃型	FX Coated 4-flute High Helix Carbide End Mill Short Length with Corner Radius
	420	FX-CR-MG-EML	FX涂层4刃硬质合金圆弧角铣刀 长刃型	FX Coated 4-flute Carbide End Mill Long Length with Corner Radius
	448	FX-ECR	FX涂层2刃硬质合金圆弧角型	FX Coated 2-flute Carbide End Mill with Corner Rounding
	327	FX-LDS	FX涂层硬质合金中心钻	FX Coated Carbide Starter Drill
	336	FX-LS-LDS	FX涂层硬质合金中心钻 长柄型	FX Coated Carbide Starter Drill with Long Shank
	323	FX-LS-MG-EBD	FX涂层2刃硬质合金球头铣刀 长柄型	FX Coated 2-flute Carbide Ball End Mill with Long Shank
	447	FX-LS-SCC	倒角用FX涂层2刃硬质合金铣刀 长柄型	FX Coated 2-flute Carbide End Mill with Long Shank for Chamfering
	423	FX-MCF	底面精加工用FX涂层金属陶瓷铣刀	FX Coated 4-flute Cermet End Mill for Bottom Finishing
	333	FX-MG-CS×60	FX涂层3刃孔口倒角	FX Coated 3-flute Countersink
	450	FX-MG-CS×60	FX涂层3刃孔口倒角	FX Coated 3-flute Countersink
	334	FX-MG-CS×90	FX涂层3刃孔口倒角	FX Coated 3-flute Countersink
	451	FX-MG-CS×90	FX涂层3刃孔口倒角	FX Coated 3-flute Countersink
	270	FX-MG-EDL	FX涂层2刃硬质合金平头铣刀 长刃型	FX Coated 2-flute Carbide End Mill Long Length
	305	FX-MG-EHL	FX涂层硬质合金平头铣刀 大螺旋长刃型	FX Coated High Helix Carbide End Mill Long Length
	290	FX-MG-EML	FX涂层4刃硬质合金平头铣刀 长刃型	FX Coated 4-flute Carbide End Mill Long Length
	271	FX-MG-EXDL	FX涂层2刃硬质合金平头铣刀 超长刃型	FX Coated 2-flute Carbide End Mill Extra Long Length
	290	FX-MG-EXML	FX涂层4刃硬质合金平头铣刀 超长刃型	FX Coated 4-flute Carbide End Mill Extra Long Length
	427	FX-MG-TPDS	FX涂层2刃硬质合金锥形铣刀 短刃型	FX Coated 2-flute Carbide Taper End Mill Short Length
	446	FX-SCC	倒角用FX涂层2刃硬质合金铣刀	FX Coated 2-flute Carbide End Mill for Chamfering
	332	FXS-EBT	WXS涂层3刃硬质合金球头铣刀 高效率型	WXS Coated 3-flute Carbide Ball End Mill (Highly Efficient Type)
	360	FXS-EQD	FX涂层硬质合金铣刀 球形	FX Coated 2-flute Carbide End Mill Sphere Type
	386	FXS-HS-PKE	FX涂层硬质合金圆弧角铣刀 多功能强力型 (HSK适用))	FX Coated 4-flute Carbide End Mill with HS Shank High Speed Pocket Operation Type
	332	FXS-LS-EBT	WXS涂层3刃硬质合金球头铣刀 长柄高效率型	WXS Coated 3-flute Carbide Ball End Mill with Long Shank (Highly Efficient Type)
	365	FXS-PC-EBT	WXS涂层3刃硬质合金锥颈球头铣刀 高效率型	WXS Coated 3-flute Pencil Neck Carbide Ball End Mill Highly Efficient Type
	385	FXS-PKE	FX涂层硬质合金圆弧角铣刀 多功能强力型	FX Coated 4-flute Carbide End Mill High Speed Pocket Operation Type
	322	FX-SS-EBD	FX涂层2刃硬质合金球头铣刀 细柄型	FX Coated 2-flute Carbide Ball End Mill with Slim Shank
	365	FX-ZDS	沉孔加工用FX涂层2刃硬质合金短刃型	FX Coated 2-flute Carbide End Mill Short Length for Counterboring
	434	FX-ZDS	沉孔加工用FX涂层2刃硬质合金短刃型	FX Coated 2-flute Carbide End Mill Short Length for Counterboring
	394	GX-CR-EDS-SF	GX涂层2刃硬质合金圆弧角铣刀 短刃型 (热缩刀柄适用)	GX Coated 2-flute Carbide End Mill Short Length with Corner Radius (Shrink Fit Type)
	335	GX-EBD-SF	GX涂层2刃硬质合金球头铣刀 (热缩刀柄适用)	GX Coated 2-flute Carbide Ball End Mill (Shrink Fit Type)
	335	GX-EQD-SF	GX涂层硬质合金铣刀 球头型 (热缩刀柄适用)	GX Coated 2-flute Carbide End Mill Sphere Type (Shrink Fit Type)
H	462	HBC60	硬质合金人字形铣刀 60°	Carbide End Mill Herringbone Type (60°)
	371	HFC-TI	钛合金加工用高进给硬质合金圆弧角铣刀	High Feed Carbide End Mill Radius Type for Titanium Alloy
	743	H-HT	氧化处理高速钢直槽丝锥	Straight Fluted Tap for General Applications (with OX)
	823	HL-B-NRT	非铁 · 嵌套螺纹用氮化处理高速钢挤压丝锥	Fluteless (Nu-Roll) Tap for Helicoil/EG/STI Non-ferrous Materials
	819	HL-HT	嵌套螺纹用高速钢直槽丝锥	Straight Fluted Tap for Helicoil/EG/STI
	948	HL-LG	嵌套螺纹用极限塞规	Limit Gauge for Helicoil/EG/STI

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产品索引表 CLASSIFIED BY ALPHABETICAL ORDER

	页码 Page	商品记号 Abbreviation	品名	Description
H	822	HL-LT	嵌套螺纹用高速钢直槽丝锥 长柄型	Straight Fluted Tap with Long Shank for Helicoil/EG/STI
	823	HL-LT-B-NRT	非铁 · 嵌套螺纹用氮化处理高速钢NRT挤压丝锥 长柄型	Fluteless (Nu-Roll) Tap with Long Shank for Helicoil/EG/STI Non-Ferrous Materials
	818	HL-LT-POT	嵌套螺纹用高速钢刃倾角丝锥 长柄型	Spiral Pointed Tap with Long Shank for Helicoil/EG/STI
	817	HL-LT-SFT	嵌套螺纹用高速钢螺旋槽丝锥 长柄型	Spiral Fluted Tap with Long Shank for Helicoil/EG/STI
	580	HRT	钢用氧化处理高速钢挤压丝锥	Fluteless (Hi-Roll) Tap for Steels (with OX)
	577	HS-AL-NRT	铝用高速钢高速同步挤压丝锥	Fluteless (Nu-Roll) Synchro Tap for Aluminum Alloys
	699	HS-AL-RFT	铝用高速钢高速同步丝锥	LH Spiral Fluted Synchro Tap for Aluminum Alloys
	655	HS-AL-SFT	铝用高速钢高速同步螺旋槽丝锥	Spiral Fluted Synchro Tap for Aluminum Alloys
	437	HSCT-N	倒角用3刃硬质合金铣刀 负前角型	3-flute Carbide End Mill for Chamfering (Negative)
	443	HSCT-P	倒角用3刃硬质合金铣刀 正前角型	3-flute Carbide End Mill for Chamfering (Positive)
	697	HS-LT-RFT	TiN涂层高速钢高速同步丝锥 长柄型	TiN Coated LH Spiral Fluted Synchro Tap with Long Shank
	654	HS-LT-SFT	TiN涂层高速钢高速同步螺旋槽丝锥 长柄型	TiN Coated Spiral Fluted Synchro Tap with Long Shank
	760	HS-O-OTT	FX涂层内冷油孔硬质合金高速同步直槽丝锥	FX Coated Carbide Straight Fluted Synchro Tap with Internal Coolant Supply
	799	H-SPT	氧化处理高速钢平行管螺纹丝锥	Parallel Pipe Thread Tap for General Applications (with OX)
	696	HS-RFT	TiN涂层高速钢高速同步丝锥	TiN Coated LH Spiral Fluted Synchro Tap
	653	HS-SFT	TiN涂层高速钢高速同步螺旋槽丝锥	TiN Coated Spiral Fluted Synchro Tap
	771	H-S-TPT	氧化处理高速钢锥管螺纹丝锥 短螺纹型	Taper Pipe Thread Tap for General Applications (with OX, Short Thread)
	701	HT	高速钢直槽丝锥	Straight Fluted Tap for General Applications
	735	HT-3F	高速钢3槽直槽丝锥	Straight Fluted Tap for General Applications (3-flute)
	734	HT-4F	高速钢4槽直槽丝锥	Straight Fluted Tap for General Applications (4-flute)
	771	H-TPT	氧化处理高速钢锥管螺纹丝锥	Taper Pipe Thread Tap for General Applications (with OX)
	624	HXL-SFT	大径卧式加工中心用氧化处理高速钢螺旋槽丝锥	Spiral Fluted Tap for Large Thread Size Horizontal Machines (with OX)
	453	HY-BCC	反面倒角用硬质合金铣刀	Carbide End Mill for Back Chamfering
	445	HY-HSCM-P	倒角用多刃硬质合金铣刀 正前角型	Multiple-flute Carbide End Mill for Chamfering
	531	HY-PRO P PNTC	HY-PRO螺纹铣刀 单牙型	HY-PRO Planet Cutter Single-point (Thread Milling Cutter)
	533	HY-PRO P PNTC	HY-PRO螺纹铣刀 多牙型	HY-PRO Planet Cutter Multi-point (Thread Milling Cutter)
	452	HY-QCC	倒角用硬质合金Q球头铣刀	Carbide Q Ball End Mill for Chamfering
I	432	IB-TPBT	叶轮加工用硬质合金锥形球头铣刀	Carbide Taper Ball End Mill for Impellers and Turbine Blades
	812	IRT(NPT)	氧化处理高速钢锥管螺纹丝锥 跳牙型	Taper Pipe Thread Tap with Interrupted Threads (with OX)
	554	IT-NRT	V涂层粉末高速钢IT挤压丝锥	V Coated CPM Fluteless (IT Nu-Roll) Tap
J	696	J-HS-RFT	TiN涂层高速钢高速同步丝锥 JIS柄	TiN Coated LH Spiral Fluted Synchro Tap with JIS Shank
	653	J-HS-SFT	高速钢高速同步螺旋槽丝锥 JIS柄	Spiral Fluted Synchro Tap with JIS Shank
K	817	KFR	氧化处理高速钢锯齿刃铣刀 标准型	Kraft Mill End Mill Regular Length (with OX)
L	963	LCG	磨耗点检螺纹量规	Wear Check Thread Gauge
	885	LG(螺纹用)	螺纹用极限量规	Limit Gauge for Screw Threads
	940	LG(管用)	平行管螺纹量规	Limit Gauge for Parallel Pipe Threads
	966	LG(XPM)	XPM粉末高速钢螺纹用极限量规	XPM Limit Gauge for Screw Threads
	967	LG(硬质合金)	硬质合金螺纹用极限量规	Carbide Limit Gauge for Screw Threads
	814	LS-BKMS	多刃曲纹形铣刀 长柄短刃型	Multiple-flute Best-Kut End Mill Short Length with Long Shank
	734	LS-EDN	2刃高速钢平头铣刀 长柄中等刃长型	2-flute End Mill Medium Length with Long Shank
	767	LS-EML	4刃高速钢平头铣刀 长柄长刃型	4-flute End Mill Long Length with Long Shank
	759	LS-EMS	4刃高速钢平头铣刀 长柄短刃型	4-flute End Mill Short Length with Long Shank

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	页码 Page	商品记号 Abbreviation	品名	Description
L	438	LS-HSCT-N	倒角用3刃硬质合金铣刀 长柄负前角型	3-flute Carbide End Mill with Long Shank for Chamfering (Negative)
	444	LS-HSCT-P	倒角用3刃硬质合金铣刀 长柄正前角型	3-flute Carbide End Mill with Long Shank for Chamfering (Positive)
	331	LS-NC-LDS	高速钢中心钻 长柄型	Starter Drill with Long Shank
	813	LS-RFES	高速钢粗加工和精加工兼用长柄短刃型	Roughing and Finishing End Mill Short Length with Long Shank
	778	LS-XPM-EBD	2刃XPM球头铣刀 长柄型	2-flute XPM Ball End Mill with Long Shank
	575	LT-B-NRT	非铁金属用氮化处理高速钢挤压丝锥 长柄型	Fluteless (Nu-Roll) Tap with Long Shank for Non-ferrous Materials
	641	LT-MS-DH-SFT	软钢 · 深孔加工用氧化处理螺旋槽丝锥 长柄型	Spiral Fluted Tap with Long Shank for Mild Steels and Deep Holes (with OX)
	568	LT-NRT	钢用氧化处理高速钢挤压丝锥 长柄型	Fluteless (Nu-Roll) Tap with Long Shank for Steels (with OX)
	756	LT-OTT	硬质合金直槽丝锥 长柄型	Carbide Straight Fluted Tap with Long Shank
	620	LT-SC-SFT	高速钢螺旋槽丝锥 长柄短切削锥型	Spiral Fluted Tap Short Chamfer Type with Long Shank
	805	LT-SFT-SPT	高速钢平行管螺纹螺旋槽丝锥 长柄型	Spiral Fluted Parallel Pipe Thread Tap with Long Shank
	774	LT-SFT-S-TPT	高速钢锥管螺纹螺旋槽丝锥 长柄短螺纹型	Spiral Fluted Taper Pipe Thread Tap with Long Shank (Short Thread)
	774	LT-SFT-TPT	高速钢锥管螺纹螺旋槽丝锥 长柄型	Spiral Fluted Taper Pipe Thread Tap with Long Shank
	799	LT-SPT(PF,G)	高速钢平行管螺纹丝锥 长柄型	Parallel Pipe Thread Tap with Long Shank for General Applications
	794	LT-SPT(PS,Rp)	高速钢平行管螺纹丝锥 长柄型	Parallel Pipe Thread Tap with Long Shank for General Applications
	772	LT-S-TPT	高速钢锥管螺纹丝锥 长柄短螺纹型	Taper Pipe Thread Tap with Long Shank for General Applications (Short Thread)
	638	LT-SUS-DH-SFT	不锈钢用深孔用氧化处理高速钢螺旋槽丝锥 长柄型	Spiral Fluted Tap with Long Shank for Stainless Steels and Deep Holes (with OX)
	787	LT-SUS-S-TPT	不锈钢用氧化处理高速钢锥管螺纹丝锥 长柄短螺纹型	Taper Pipe Thread Tap with Long Shank for Stainless Steels (with OX, Short Thread)
	787	LT-SUS-TPT	不锈钢用氧化处理高速钢锥管螺纹丝锥 长柄型	Taper Pipe Thread Tap with Long Shank for Stainless Steels (with OX)
	546	LT-S-XPF	XPF V涂层高速钢挤压丝锥 长柄型	V Coated Fluteless (X Performer Forming) Tap with Long Shank
	772	LT-TPT	高速钢锥管螺纹丝锥 长柄型	Taper Pipe Thread Tap with Long Shank for General Applications
	643	LW-SFT	小螺旋角型丝锥	Low Spiral Fluted Tap
M	265	MBOS	单刃CBN平头铣刀 短刃型	Single-flute CBN Brazed End Mill Short Length
	266	MDOS	单刃PCD铣刀 短刃型	Single-flute PCD End Mill Short Length
	324	MG-EBD	2刃硬质合金球头铣刀	2-flute Carbide Ball End Mill
	272	MG-EDL	2刃硬质合金平头铣刀 长刃型	2-flute Carbide End Mill Long Length
	269	MG-EDN	2刃硬质合金平头铣刀 中等刃长型	2-flute Carbide End Mill Medium Length
	263	MG-EDS	2刃硬质合金平头铣刀 短刃型	2-flute Carbide End Mill Short Length
	264	MG-EDS(OH1)	2刃硬质合金平头铣刀 短刃型 (OH1)	2-flute Carbide End Mill Short Length (OH1)
	262	MG-EDS-3	2刃硬质合金平头铣刀 短刃型 (小径)	2-flute Miniature Carbide End Mill (φ3 Shank)
	265	MG-EKD	键槽用2刃硬质合金平头铣刀 (OH1,OL1)	2-flute Carbide End Mill for Keyway (OH1,OL1)
	291	MG-EML	4刃硬质合金平头铣刀 长刃型	4-flute Carbide End Mill Long Length
	288	MG-EMS	4刃硬质合金平头铣刀 短刃型	4-flute Carbide End Mill Short Length
	272	MG-EXDL	2刃硬质合金平头铣刀 超长刃型	2-flute Carbide End Mill Extra Long Length
	291	MG-EXML	4刃硬质合金平头铣刀 超长刃型	4-flute Carbide End Mill Extra Long Length
	269	MG-STDN	成形用2刃硬质合金铣刀 直刃中等刃长型	2-flute Carbide Straight Fluted End Mill Medium Length for Reforming
	431	MG-TRC	2刃梯形铣刀	2-flute Carbide Taper End Mill for Trapezoidal Runner
	201	MRS-GDL	不锈钢用Smooth涂层小径硬质合金钻头	Smooth Coated Small Size Carbide Drill Long Length for Stainless
	639	MS-DH-SFT	软钢 · 深孔加工用氧化处理螺旋槽丝锥	Spiral Fluted Tap for Mild Steels and Deep Holes (with OX)
	289	MT-SUS-GDR	不锈钢 · 软钢用TiN涂层高速钢钻头 MT柄	TiN Coated Drill Regular Length with Morse Taper Shank for Stainless and Mild Steels (EX-GOLD Drill)
N	328	NC-LDS	高速钢中心钻	Starter Drill
	378	NEO-CR-EMS	6刃硬质合金圆弧角铣刀 不等导程短刃型	FX Coated 6-flute Variable Lead Carbide End Mill Short Length with Corner Radius

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	页码 Page	商品记号 Abbreviation	品名	Description
N	383	NEO-CR-PHS	4刃硬质合金圆弧角铣刀 不等导程强力重切削短刃型	FX Coated 4-flute Variable Lead Carbide End Mill Short Length with Corner Radius (Heavy-duty Operation Type)
	287	NEO-EMS	6刃硬质合金平头铣刀 不等导程短刃型	FX Coated 6-flute Variable Lead Carbide End Mill Short Length
	299	NEO-PHS	4刃硬质合金平头铣刀 不等导程强力重切削短刃型	FX Coated 4-flute Variable Lead Carbide End Mill Short Length (Heavy-duty Operation Type)
	252	NEPTUNE	耐热合金TiAlN涂层手动硬质合金钻头	TiAlN Coated Carbide Starter Hand Drill for HRSA
	272	NEXUS-GDR	WDI涂层高速钢NEXUS钻头 标准刃长型	WDI Coated Drill Regular Length (NEXUS Drill)
	271	NEXUS-GDS	WDI涂层高速钢NEXUS钻头 超短刃型	WDI Coated Drill Stub Length (NEXUS Drill)
	203	NF-GDN	非铁金属加工用硬质合金钻头 中等刃长型	Carbide Drill Medium Length for Non-ferrous Materials
	695	NI-POT	镍基超耐热合金用高速钢刃倾角丝锥	CPM Spiral Pointed Tap for Nickel Alloy
	652	NI-SFT	镍基超耐热合金用高速钢螺旋槽丝锥	Spiral Fluted Tap for Nickel Alloy
	565	NRT	钢用氧化处理高速钢挤压丝锥	Fluteless (Nu-Roll) Tap for Steels (with OX)
	802	NRT-SPT	氧化处理高速钢平行管螺纹挤压丝锥	Fluteless (Nu-Roll) Parallel Pipe Thread Tap (with OX)
	824	NT	高速钢螺母丝锥	Nut Tap
O	751	OIL-HT	氧化处理内冷油孔高速钢直槽丝锥	Straight Fluted Tap with Internal Coolant Supply (with OX)
	690	OIL-POT	氧化处理内冷油孔高速钢刃倾角丝锥	Spiral Pointed Tap with Internal Coolant Supply (with OX)
	644	OIL-SFT	氧化处理内冷油孔高速钢螺旋槽丝锥	Spiral Fluted Tap with Internal Coolant Supply (with OX)
	802	OIL-SPT	氧化处理内冷油孔高速钢平行管螺纹丝锥	Parallel Pipe Thread Tap with Internal Coolant Supply (with OX)
	547	OIL-S-XPF	XPF V涂层内冷油孔高速钢挤压丝锥	V Coated Fluteless (X Performer Forming) Tap with Internal Coolant Supply
	782	OIL-TPT	氧化处理内冷油孔高速钢锥管螺纹丝锥	Taper Pipe Thread Tap with Internal Coolant Supply (with OX)
	825	O-NT	中径加大用高速钢螺母丝锥	Nut Tap for Oversize
	341	OP-SFA	OSG PHOENIX系列螺纹安装型专用刀杆	OSG PHOENIX Indexable Arbor for Screw-Fit Type
	1007	OSG-HAIMER	OSG-HAIMER	OSG-HAIMER
	761	OT-DC-HT	铸件用硬质合金高速钢直槽丝锥	Carbide Straight Fluted Tap for Die Castings
	570	OT-IN-NRT	硬质合金镶刃挤压丝锥	Carbide Fluteless (Nu-Roll) Tap (with Brazed Inserts)
	570	OT-LT-NRT	硬质合金挤压丝锥 长柄型	Carbide Fluteless (Nu-Roll) Tap with Long Shank
	803	OT-LT-SPT	硬质合金平行管螺纹丝锥 长柄型	Carbide Parallel Pipe Thread Tap with Long Shank
	785	OT-LT-TPT	硬质合金锥管螺纹丝锥 长柄型	Carbide Taper Pipe Thread Tap with Long Shank
	569	OT-NRT	硬质合金挤压丝锥	Carbide Fluteless (Nu-Roll) Tap
	518	OT-PNGT	FX涂层硬质合金螺纹铣刀	FX Coated Carbide Planet Cutter (Thread Milling Cutter)
	646	OT-SFT	硬质合金螺旋槽丝锥	Carbide Spiral Fluted Tap
	517	OT-SFT-PNGT	FX涂层硬质合金螺旋槽螺纹铣刀	FX Coated Carbide Spiral Fluted Planet Cutter (Thread Milling Cutter)
	803	OT-SPT	硬质合金平行管螺纹丝锥	Carbide Parallel Pipe Thread Tap
	784	OT-S-TPT	硬质合金锥管螺纹丝锥 短螺纹型	Carbide Taper Pipe Thread Tap (Short Thread)
	755	OTT	硬质合金直槽丝锥	Carbide Straight Fluted Tap
	784	OT-TPT	硬质合金锥管螺纹丝锥	Carbide Taper Pipe Thread Tap
P	229	P2D	OSG PHOENIX系列可转位式钻头 2D 型	OSG PHOENIX Indexable Drill (2D Type)
	231	P3D	OSG PHOENIX系列可转位式钻头 3D 型	OSG PHOENIX Indexable Drill (3D Type)
	233	P4D	OSG PHOENIX系列可转位式钻头 4D 型	OSG PHOENIX Indexable Drill (4D Type)
	235	P5D	OSG PHOENIX 系列可转位式钻头5D用	OSG PHOENIX Indexable Drill (5D Type)
	239	PDZ	OSG PHOENIX系列可转位式平头钻	OSG PHOENIX Indexable Flat Drill
	961	PG	极限圆柱量规	Plain Limit Gauge
	227	PHP	OSG PHOENIX系列可转位式钻头 3D型	OSG PHOENIX Indexable Drill (3D Type)
	382	PHX-CRT	WXS涂层3刃硬质合金圆弧角铣刀	WXS Coated 3-flute High-feed Carbide End Mill with Corner Radius

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	页码 Page	商品记号 Abbreviation	品名	Description
P	331	PHX-DBT	FX涂层3刃硬质合金球头铣刀	FX Coated 3-flute Deep-feed Carbide Ball End Mill
	421	PHX-DFR	WXS涂层3刃硬质合金圆弧角铣刀	WXS Coated 3-flute Deep-feed Carbide End Mill with Corner Radius
	412	PHX-LN-CRE	WXS涂层4刃小径硬质合金长颈圆弧角铣刀	WXS Coated 4-flute Long Neck Carbide End Mill with Corner Radius
	350	PHX-LN-DBT	WXS涂层3刃硬质合金长颈球头铣刀	WXS Coated 3-flute Long Neck Carbide Ball End Mill
	413	PHX-LN-DFR	WXS涂层3刃硬质合金长颈圆弧角铣刀	WXS Coated 3-flute Long Neck Deep-feed Radius Carbide End Mill
	361	PHX-PC-DBT	WXS涂层3刃硬质合金锥颈球头铣刀	WXS Coated 3-flute Pencil Neck Deep-feed Carbide Ball End Mill
	409	PHX-PC-DFR	WXS涂层3刃硬质合金锥颈圆弧角铣刀	WXS Coated 3-flute Pencil Neck Deep-feed Radius Carbide End Mill
	337	PLDS	OSG PHOENIX系列可转位式中心钻	OSG PHOENIX Indexable Centering and Chamfering Cutter
	519	PNGT	TiN涂层高速钢螺纹铣刀	TiN Coated Planet Cutter (Thread Milling Cutter)
	223	PXD (KC)	可换头式钻头用刀头(KC)	Exchangeable Drill Head for Cast Iron
	225	PXD (NC)	可换头式钻头用刀头(NC)	Exchangeable Drill Head for Non-ferrous Materials
	221	PXD (PC)	可换头式钻头用刀头(PC)	Exchangeable Drill Head for Steel
	219	PXDZ	OSG PHOENIX系列可换头式钻头PXD用刀杆	OSG PHOENIX Exchangeable Drill Head (3D/5D Type)
	364・370	PZAG	OSG PHOENIX系列沉孔加工用钻头	OSG PHOENIX Counterboring Cutter
R	995	RCD,RSD	旋转式滚丝轮	Thread Rolling Planetary Dies
	975	RD	板牙	Round Dies Adjustable Type for General Use
	983	RD(HSS)	高速钢板牙	HSS Round Dies Adjustable Type for General Use
	997	RF	搓齿板	Rack Type Rolling Dies
	818	RFE	高速钢粗加工和精加工兼用标准刃型	Roughing and Finishing End Mill Regular Length
	819	RFEL	高速钢粗加工和精加工兼用 长刃型	Roughing and Finishing End Mill Long Length
	812	RFES	高速钢粗加工和精加工兼用 短刃型	Roughing and Finishing End Mill Short Length
	844	RF-TSC	高速钢T型槽铣刀	End Mill for T-slots
	962	RG-M	标准环规	Master Ring Gauge
S	804	SFT-SPT(PF,G)	高速钢平行管螺纹螺旋槽丝锥	Spiral Fluted Parallel Pipe Thread Tap
	795	SFT-SPT(PS,Rp)	高速钢平行管螺纹螺旋槽丝锥	Spiral Fluted Parallel Pipe Thread Tap
	773	SFT-S-TPT	高速钢锥管螺纹螺旋槽丝锥 短螺纹型	Spiral Fluted Taper Pipe Thread Tap (Short Thread)
	811	SFT-TPT(NPT)	高速钢锥管螺纹螺旋槽丝锥	Spiral Fluted Taper Pipe Thread Tap
	773	SFT-TPT(PT,Rc)	高速钢锥管螺纹螺旋槽丝锥	Spiral Fluted Taper Pipe Thread Tap
	951	SG	标准螺纹量规	Standard Screw Thread Gauge
	214	SH-DRL	高硬度钢用硬质合金钻头	Carbide Drill for High-hardness Steels
	426	SI-WC-RESF	WXL涂层硬质合金波纹铣刀 静音型	WXL Coated Carbide Roughing End Mill Fine Pitch Short Length and Silent Type
	788	SI-WH-RESF	WXL涂层波纹形细齿纹短刃铣刀 静音型	WXL Coated CPM Roughing End Mill Fine Pitch Short Length and Silent Type
	981	SPD	平行管螺纹板牙	Round Dies Adjustable Type for Parallel Pipe Thread
	984	SPD(HSS)	高速钢平行管螺纹板牙	HSS Round Dies Adjustable Type for Parallel Pipe Thread
	814	SPT(NPS,NPSF)	高速钢平行管螺纹丝锥	Spiral Fluted Parallel Pipe Thread Tap
	797	SPT(PF,G)	高速钢平行管螺纹丝锥	Spiral Fluted Parallel Pipe Thread Tap
	793	SPT(PS,Rp)	高速钢平行管螺纹丝锥	Spiral Fluted Parallel Pipe Thread Tap
	990	SR	花键滚扎轮	Cylindrical Dies for Spline
	828	SR-HT	内螺纹修补・溶屑清除用高速钢直槽丝锥	Straight Fluted Tap for Spatter Removal
	250	STCH	CFRP/金属叠板加工用FX涂层硬质合金钻头	FX Coated High Helix Drill for Composite Material and Stacks
	781	STL-S-TPT	软钢用高速钢锥管螺纹丝锥 短螺纹型	Taper Pipe Thread Tap for Mild Steels (Short Thread)
	781	STL-TPT	软钢用高速钢锥管螺纹丝锥	Taper Pipe Thread Tap for Mild Steels

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产品索引表 CLASSIFIED BY ALPHABETICAL ORDER

	页码 Page	商品记号 Abbreviation	品名	Description
S	809	S-TPT(NPT)	高速钢锥管螺纹丝锥 短螺纹型	Taper Pipe Thread Tap (Short Thread)
	810	S-TPT(NPTF)	高速钢锥管螺纹丝锥 短螺纹型	Taper Pipe Thread Tap (Short Thread)
	770	S-TPT(PT,Rc)	高速钢锥管螺纹丝锥 短螺纹型	Taper Pipe Thread Tap (Short Thread)
	637	SUS-DH-SFT	不锈钢、深孔用氧化处理高速钢螺旋槽丝锥	Spiral Fluted Tap for Stainless Steels and Deep Holes (with OX)
	727	SUS-EDS	不锈钢用氧化处理2刃高速钢平头铣刀 短刃型	2-flute End Mill Short Length for Stainless Steels (with OX)
	985	SUS-SD	不锈钢用氧化处理板牙	Solid Dies for Stainless Steels (with OX)
	801	SUS-SFT-SPT	不锈钢用氧化处理高速钢平行管螺纹螺旋槽丝锥	Spiral Fluted Parallel Pipe Thread Tap for Stainless Steels (with OX)
	788	SUS-SFT-S-TPT	不锈钢用氧化处理高速钢锥管螺纹螺旋槽丝锥 短螺纹型	Spiral Fluted Taper Pipe Thread Tap (with OX, Short Thread)
	788	SUS-SFT-TPT	不锈钢用氧化处理高速钢锥管螺纹螺旋槽丝锥	Spiral Fluted Taper Pipe Thread Tap for Stainless Steels (with OX)
	544	S-XPF	XPF V涂层高速钢挤压丝锥	V Coated Fluteless (X Performer Forming) Tap
	831	SyncroMaster	攻丝刀柄	Tap Holder
T	310	TDXL	WXL涂层高速钢超长刃型钻头	WXL Coated Extra Long Drill (TDXL 10D, 15D, 20D Type)
	815	TFGN	TiN涂层高速钢齿纹刃铣刀 中等刃长型	TiN Coated TUF-NICK End Mill Medium Length
	810	TFGS	TiN涂层高速钢齿纹刃铣刀 短刃型	TiN Coated TUF-NICK End Mill Short Length
	816	TFN	高速钢齿纹刃铣刀 中等刃长型	TUF-NICK End Mill Medium Length
	811	TFS	高速钢齿纹刃铣刀 短刃型	TUF-NICK End Mill Short Length
	957	TG	锥管螺纹量规	Gauge for Taper Pipe Threads
	950	TIN-HL-LG	TiN涂层嵌套螺纹用极限塞规	TiN Coated Limit Plug Gauge for Helicoil/EG/STI
	747	TIN-HT	TiN涂层高速钢直槽丝锥	TiN Coated Straight Fluted Tap
	791	TIN-IRT(PT,Rc)	TiN涂层高速钢锥管螺纹丝锥 跳牙型	TiN Coated Taper Pipe Thread Tap with Interrupted Threads
	812	TIN-IRT(NPT)	TiN涂层锥管螺纹丝锥 跳牙型	TiN Coated Taper Pipe Thread Tap with Interrupted Threads
	935	TIN-LG	TiN涂层螺纹用极限塞规	TiN Coated Thread Limit Gauge
	796	TIN-LS-RESF	TiN涂层细齿纹刃铣刀 长柄短刃型	TiN Coated Roughing End Mill Fine Pitch Short Length with Long Shank
	748	TIN-LT	TiN涂层高速钢直槽丝锥 长柄型	TiN Coated Straight Fluted Tap with Long Shank
	564	TIN-LT-NRT	TiN涂层高速钢挤压丝锥 长柄型	TiN Coated Fluteless (Nu-Roll) Tap with Long Shank
	680	TIN-LT-POT	TiN涂层高速钢刃倾角丝锥 长柄型	TiN Coated Spiral Pointed Tap with Long Shank
	627	TIN-LT-SFT	TiN涂层高速钢螺旋槽丝锥 长柄型	TiN Coated Spiral Fluted Tap with Long Shank
	791	TIN-LT-S-IRT	TiN涂层高速钢锥管螺纹丝锥 长柄跳牙短螺纹型	TiN Coated Taper Pipe Thread Tap with Interrupted Threads and Long Shank (Short Thread)
	778	TIN-LT-S-TPT	TiN涂层高速钢锥管螺纹丝锥 长柄短螺纹型	TiN Coated Taper Pipe Thread Tap with Long Shank (Short Thread)
	778	TIN-LT-TPT	TiN涂层高速钢锥管螺纹丝锥 长柄型	TiN Coated Taper Pipe Thread Tap with Long Shank
	329	TIN-NC-LDS	TiN涂层高速钢中心钻	TiN Coated Starter Drill
	561	TIN-NRT	TiN涂层高速钢挤压丝锥	TiN Coated Fluteless (Nu-Roll) Tap
	679	TIN-POT	TiN涂层高速钢刃倾角丝锥	TiN Coated Spiral Pointed Tap
	626	TIN-SFT	TiN涂层高速钢螺旋槽丝锥	TiN Coated Spiral Fluted Tap
	791	TIN-S-IRT	TiN涂层高速钢锥管螺纹丝锥 跳牙短螺纹型	TiN Coated Taper Pipe Thread Tap with Interrupted Threads (Short Thread)
	800	TIN-SPT	TiN涂层高速钢平行管螺纹丝锥	TiN Coated Parallel Pipe Thread Tap
	777	TIN-S-TPT	TiN涂层高速钢锥管螺纹丝锥 短螺纹型	TiN Coated Taper Pipe Thread Tap (Short Thread)
	777	TIN-TPT	TiN涂层高速钢锥管螺纹丝锥	TiN Coated Taper Pipe Thread Tap
	729	TIN-XPM-EDN	TiN涂层2刃XPM平头铣刀 中等刃长型	TiN Coated 2-flute XPM End Mill Medium Length
	753	TIN-XPM-EHL	TiN涂层XPM平头铣刀 大螺旋角长刃型	TiN Coated High Helix XPM End Mill Long Length
	772	TIN-XPM-EHS	TiN涂层XPM平头铣刀 大螺旋角短刃型	TiN Coated High Helix XPM End Mill Short Length
	776	T-LS-XPM-EBD	TiN涂层2刃XPM球头铣刀 长柄型	TiN Coated 2-flute XPM Ball End Mill with Long Shank

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	页码 Page	商品记号 Abbreviation	品名	Description
T	794	TLS-XPM-RESF	TiN涂层XPM细齿纹刃铣刀 长柄型	TiN Coated XPM Roughing End Mill Fine Pitch Short Length with Long Shank
	1003	TMD	六角冲头	Trimming Dies
	842	TPBDR	2刃高速钢锥形球头铣刀 标准型	2-flute Taper Ball End Mill Regular Length
	839	TPBDS	2刃高速钢锥形球头铣刀 短刃型	2-flute Taper Ball End Mill Short Length
	981	TPD	锥管螺纹用板牙	Solid Type Round Dies for Taper Pipe Threads
	985	TPD(HSS)	高速钢锥管螺纹用板牙	HSS Solid Type Round Dies for Taper Pipe Threads
	828	TPDR	2刃高速钢锥形铣刀 标准型	2-flute 'Taper End Mill Regular Length
	824	TPDS	2刃高速钢锥形铣刀 短刃型	2-flute Taper End Mill Short Length
	835	TPDSS	2刃高速钢锥形铣刀 超短刃型	2-flute Taper End Mill Stub Length
	946	TPG-P	锥管螺纹用小径塞规	Taper Pipe Thread Plug Gauge for Minor Diameter
	836	TPMR	4刃高速钢锥形铣刀 标准型	4-flute Taper End Mill Regular Length
	832	TPMS	4刃高速钢锥形铣刀 短刃型	4-flute Taper End Mill Short Length
	809	TPT(NPT)	高速钢锥管螺纹丝锥	Taper Pipe Thread Tap
	810	TPT(NPTF)	高速钢锥管螺纹丝锥	Taper Pipe Thread Tap
	769	TPT(PT,Rc)	高速钢锥管螺纹丝锥	Taper Pipe Thread Tap
	987	TR	滚丝轮	Thread Rolling Cylindrical Dies
	829	TRP-SFT	照相机三角架螺纹用高速钢螺旋槽丝锥	Spiral Fluted Tap for Camera Tripod Mount Threads
	186	TRS-HO-3D	WDI涂层3刃内冷油孔硬质合金钻头 3D型	WDI Coated 3-flute Carbide Drill with Internal Coolant Supply (3D Type)
	188	TRS-HO-5D	WDI涂层3刃内冷油孔硬质合金钻头 5D型	WDI Coated 3-flute Carbide Drill with Internal Coolant Supply (5D Type)
	190	TRS-HO-10D	WDI涂层3刃内冷油孔硬质合金钻头 10D型	WDI Coated 3-flute Carbide Drill with Internal Coolant Supply (10D Type)
U	555	UM-NRT	CrN涂层粉末高速钢极小径挤压丝锥	CrN Coated CPM Fluteless (UM Nu-Roll) Tap for Ultra-small Diameter Threads
	299	UP-PHS	FX涂层4刃硬质合金平头铣刀 多功能抗振短刃型	FX Coated Multi-purpose 4-flute Carbide End Mill Short Length (Vibration-resistant Type)
	578	US-AL-NRT	铝用V涂层高速钢ULTRA同步挤压丝锥	V Coated Fluteless (Nu-Roll) Ultra Synchro Tap for Aluminum Alloys
	700	US-AL-RFT	铝用高速钢ULTRA同步丝锥	LH Spiral Fluted Ultra Synchro Tap for Aluminum Alloys
	655	US-AL-SFT	高速钢ULTRA同步螺旋槽丝锥	Spiral Fluted Ultra Synchro Tap for Aluminum Alloys
	191	UVM-DRL-5D	Smooth涂层极小径UVM硬质合金钻头 5D型	Smooth Coated Ultra Small Size UVM Carbide Drill (5D Type)
	192	UVM-DRL-10D	Smooth涂层极小径UVM硬质合金钻头 10D型	Smooth Coated Ultra Small Size UVM Carbide Drill (10D Type)
	193	UVM-LDS	Smooth涂层极小径UVM硬质合金中心钻	Smooth Coated Ultra Small Size UVM Carbide Starter Drill
	368	UVX-TI-4FL	钛合金用4刃不等导程硬质合金铣刀	FX Coated 4-flute Carbide End Mill Variable Lead for Titanium Alloy
	369	UVX-TI-5FL	钛合金用5刃不等导程硬质合金铣刀	FX Coated 5-flute Carbide End Mill Variable Lead for Titanium Alloy
	370	UVXL-TI-5FL	钛合金用5刃不等导程硬质合金铣刀 长刃型	FX Coated 5-flute Carbide End Mill Long Variable Lead for Titanium Alloy
V	782	V-AL-TPT	铝用V涂层高速钢锥管螺纹丝锥	V Coated Taper Pipe Thread Tap for Aluminum Alloys
	827	V-DR-SFT	V涂层高速钢钻攻一体式螺旋槽丝锥	V Coated Spiral Fluted Tap Combined with Drill
	560	V-EG-NRT	V涂层带小径精加工刃高速钢挤压丝锥	V Coated Fluteless (Nu-Roll) Tap with Cutting Edge on Minor Diameter
	791	VLS-XPM-RESF	V涂层XPM细齿纹刃铣刀 长柄短刃型	V Coated XPM Roughing End Mill Fine Pitch Short Length with Long Shank
	746	V-LT	V涂层高速钢直槽丝锥 长柄型	V Coated Straight Fluted Tap with Long Shank
	579	V-LT-DH-NRT	深孔用V涂层高速钢挤压丝锥 长柄型	V Coated Fluteless (Nu-Roll) Tap for Deep Holes
	558	V-LT-NRT	V涂层高速钢挤压丝锥 长柄型	V Coated Fluteless (Nu-Roll) Tap with Long Shank
	678	V-LT-POT	V涂层高速钢刃倾角丝锥 长柄型	V Coated Spiral Pointed Tap with Long Shank
	623	V-LT-SFT	V涂层高速钢螺旋槽丝锥 长柄型	V Coated Spiral Fluted Tap with Long Shank
	316	V-MT-GDN	车床用V涂层高速钢钻头 MT柄	V Coated Drill with Morse Taper Shank Medium Length (GOLD Drill)
	557	V-NRT	V涂层高速钢挤压丝锥	V Coated Fluteless (Nu-Roll) Tap

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V	762	VO-DC-HT	铸件用V涂层内冷油孔高速钢直槽零前角丝锥	V Coated Straight Fluted Tap for Die Castings with Internal Coolant Supply (Zero Tap)
	762	VP-DC-HT	铸件用V涂层粉末高速钢直槽零前角丝锥	V Coated CPM Straight Fluted Tap for Die Castings (Zero Tap)
	793	VP-DE-RESF	深加工用V涂层XPM波纹形细齿纹刃铣刀 短刃型	V Coated XPM Roughing End Mill Fine Pitch Short Length for Deep Contouring
	261	VP-GDR	V涂层超级含钴高速钢钻头 标准刃长型	V Coated Super Premium HSS Drill Regular Length
	270	VP-GDXL	V涂层粉末高速钢钻头 超长刃型	V Coated CPM Drill Extra Long Length
	253	VPH-GDS	调质钢用粉末高速钢钻头 超短刃型	V Coated XPM Drill Stub Length for Hardened Steel
	268	VP-HO-GDR	高速加工用V涂层内冷油孔粉末高速钢钻头 标准刃长型	V Coated CPM Drill Regular Length with Internal Coolant Supply for High Speed Processing
	265	VP-HO-GDS	高速加工用V涂层内冷油孔粉末高速钢钻头 超短刃型	V Coated CPM Drill Short Length with Internal Coolant Supply for High Speed Processing
	330	VP-LDS	V涂层粉末高速钢中心钻	V Coated XPM Starter Drill
	332	VP-LS-LDS	V涂层粉末高速钢中心钻 长柄型	V Coated XPM Starter Drill with Long Shank
	550	VP-LT-NRT	V涂层粉末高速钢挤压丝锥 长柄型	V Coated CPM Fluteless (Nu-Roll) Tap with Long Shank
	553	VP-LT-SC-NRT	V涂层粉末高速钢挤压丝锥 短切削锥长柄型	V Coated CPM Fluteless (Nu-Roll) Tap Short Chamfer Type with Long Shank
	548	VP-NRT	V涂层粉末高速钢挤压丝锥	V Coated CPM Fluteless (Nu-Roll) Tap
	556	VP-NRTS	V涂层粉末高速钢挤压丝锥 短螺纹型	V Coated CPM Fluteless (Nu-Roll) Tap (Short Thread Type)
	677	V-POT	V涂层高速钢刃倾角丝锥	V Coated Spiral Pointed Tap
	698	VPO-US-POT	钢用V涂层粉末高速钢内冷油孔高速同步刃倾角丝锥	V Coated CPM Ultra Synchro Spiral Pointed Tap with Internal Coolant Supply for Steels
	656	VPO-US-SFT	钢用V涂层粉末高速钢内冷油孔高速同步螺旋槽丝锥	V Coated CPM Ultra Synchro Spiral Fluted Tap with Internal Coolant Supply for Steels
	805	VP-RELF	V涂层XPM细齿纹刃铣刀 长刃型	V Coated XPM Roughing End Mill Fine Pitch Long Length
	800	VP-RENF	V涂层XPM细齿纹刃铣刀 中等刃长型	V Coated XPM Roughing End Mill Fine Pitch Medium Length
	790	VP-RESF	V涂层XPM细齿纹刃铣刀 短刃型	V Coated XPM Roughing End Mill Fine Pitch Short Length
	849	VP-SCC	倒角用V涂层2刃XPM铣刀	V Coated 2-flute XPM End Mill for Chamfering
	552	VP-SC-NRT	V涂层粉末高速钢挤压丝锥 短切削锥型	V Coated CPM Fluteless (Nu-Roll) Tap Short Chamfer Type
	749• 784	VPS-EMS	V涂层多刃XPM平头铣刀 高刚性短刃型	V Coated Multiple-flute XPM End Mill Short Length (Highly Rigid Type)
	621	VP-SFT	V涂层粉末高速钢螺旋槽丝锥	V Coated CPM Spiral Flutes Tap
	367	VP-ZDS	V 涂层CPM沉孔加工用2刃短刃型	V Coated 2-flute XPM End Mill Short Length for Counterboring
	845	VP-ZDS	V 涂层CPM沉孔加工用2刃短刃型	V Coated 2-flute XPM End Mill Short Length for Counterboring
	321	V-SDR	V涂层高速钢钻头	V Coated Drill Regular (V-SELECT Drill)
	622	V-SFT	V涂层高速钢螺旋槽丝锥	V Coated Spiral Fluted Tap
	559	V-SS-NRT	薄板用V涂层高速钢挤压丝锥	V Coated Fluteless (Nu-Roll) Tap for Sheet Steels
	775	V-SS-XPM-EBD	V涂层2刃XPM球头铣刀 细柄型	V Coated 2-flute XPM Ball End Mill with Slim Shank
	725	V-SS-XPM-EDN	V涂层2刃XPM平头铣刀 细柄中等刃长型	V Coated 2-flute XPM End Mill Medium Length with Slim Shank
	746	V-SS-XPM-EMS	V涂层4刃XPM平头铣刀 细柄短刃型	V Coated 4-flute XPM End Mill Short Length with Slim Shank
	792	VSS-XPM-RESF	V涂层XPM细齿纹刃铣刀 细柄型	V Coated XPM Roughing End Mill Fine Pitch Short Length with Slim Shank
	693	V-TI-POT	钛合金用V涂层高速钢刃倾角丝锥	V Coated CPM Spiral Pointed Tap for Titanium Alloy
	650	V-TI-SFT	钛合金用V涂层高速钢螺旋槽丝锥	V Coated CPM Spiral Fluted Tap for Titanium Alloy
	335	V-UCS	V涂层3刃倒角刀	V Coated 3-flute Countersink
	850	V-UCS	V涂层3刃倒角刀	V Coated 3-flute Countersink
	433	VU-TBR	精加工用WXL涂层硬质合金铣刀 圆锥型	WXL Coated Taper Barrel Type End Mill for Finishing
	625	VXL-SFT	大径立式加工中心用氧化处理高速钢螺旋槽丝锥	Spiral Fluted Tap for Large Thread Size in Vertical Machines (with OX)
	766	VX-OT	高硬度钢用V涂层硬质合金直槽丝锥(50 HRC∽)	V Coated Carbide Straight Fluted Tap for High-hardness Steels (50 HRC∽)
	774	V-XPM-EBD	V涂层2刃XPM球头铣刀	V Coated 2-flute XPM Ball End Mill
	848	V-XPM-ECR	V涂层3刃XPM倒圆弧角型	V coated 3-flute XPM End Mill with Corner Rounding

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产品索引表 CLASSIFIED BY ALPHABETICAL ORDER

	页码 Page	商品记号 Abbreviation	品名	Description
V	735	V-XPM-EDL	V涂层2刃XPM平头铣刀 长刃型	V Coated 2-flute XPM End Mill Long Length
	728	V-XPM-EDN	V涂层2刃XPM平头铣刀 中等刃长型	V Coated 2-flute XPM End Mill Medium Length
	703	V-XPM-EDS	V涂层2刃XPM平头铣刀 短刃型	V Coated 2-flute XPM End Mill Short Length
	750	V-XPM-EHL	V涂层XPM平头铣刀 大螺旋角长刃型	V Coated High Helix XPM End Mill Long Length
	770	V-XPM-EHS	V涂层XPM平头铣刀 大螺旋角短刃型	V Coated High Helix XPM End Mill Short Length
	706	V-XPM-EKD	键槽用V涂层2刃XPM平头铣刀	V Coated 2-flute XPM End Mill for Keyway Slotting
	762	V-XPM-EML	V涂层4刃XPM平头铣刀 长刃型	V Coated 4-flute XPM End Mill Long Length
	745	V-XPM-EMS	V涂层4刃XPM平头铣刀 短刃型	V Coated 4-flute XPM End Mill Short Length
	764	V-XPM-HT	高硬度钢用V涂层粉末高速钢直槽丝锥(42∽52HRC)	V Coated XPN Straight Fluted Tap for High-hardness Steels (42-52 HRC)
	809	V-XPM-NHS	V涂层XPM平头铣刀 大螺旋带断屑槽短刃型	V Coated High Helix XPM Nicked End Mill Short Length
	775	V-XPM-TPT	高硬度钢用V涂层粉末高速钢锥管螺纹丝锥	V Coated XPM Taper Pipe Thread Tap for High-hardness Steels
	776	VX-TPT	高硬度钢用V涂层硬质合金锥管螺纹丝锥	V Coated Carbide Taper Pipe Thread Tap for High-hardness Steels
W	210	WH55-5D	高硬度钢用WXS涂层硬质合金钻头 5D型(~55HRC)	WXS Coated Carbide Drill for High-hardness Steels (5D Type)
	765	WH55-OT	高硬度钢用V涂层硬质合金直槽丝锥(~55HRC)	V Coated Carbide Straight Fluted Tap for High-hardness Steels (~55 HRC)
	212	WH70-DRL	高硬度钢用WXS涂层硬质合金钻头(~70HRC)	WXS Coated Carbide Drill for High-hardness Steels (70HRC)
	211	WHO55-5D	高硬度钢用WXS涂层内冷油孔硬质合金钻头(~55HRC)	WXS Coated Carbide Drill with Internal Coolant Supply (5D Type) for High-hardness Steels
	787	WH-REEL	WXL涂层高速钢波纹形铣刀 长刃型	WXL Coated Roughing End Mill Long Length
	802	WH-REEN	WXL涂层高速钢波纹形铣刀 中等刃长型	WXL Coated Roughing End Mill Medium Length
	785	WH-REES	WXL涂层高速钢波纹形铣刀 短刃型	WXL Coated Roughing End Mill Short Length
	804	WH-RELF	WXL涂层细齿纹高速钢铣刀 长刃型	WXL Coated Roughing End Mill Fine Pitch Long Length
	786	WH-RENF	WXL涂层细齿纹高速钢铣刀 中等刃长型	WXL Coated Roughing End Mill Fine Pitch Medium Length
	789	WH-RESF	WXL涂层细齿纹高速钢铣刀 短刃型	WXL Coated Roughing End Mill Fine Pitch Short Length
	694	WHR-NI-POT	镍基超耐热合金用HR涂层高速钢刃倾角丝锥	HR Coated CPM Spiral Pointed Tap for Nickel Alloy
	651	WHR-NI-SFT	镍基超耐热合金用HR涂层高速钢螺旋槽丝锥	HR Coated CPM Spiral Fluted Tap for Nickel Alloy
	440	W-HSCT-N	倒角用WXL涂层3刃硬质合金铣刀 负前角型	WXL Coated 3-flute Carbide End Mill for Chamfering (Negative)
	439	W-HSCT-P	倒角用WXL涂层3刃硬质合金铣刀 正前角型	WXL Coated 3-flute Carbide End Mill for Chamfering (Positive)
	511	WH-VM-PNC	小径螺纹用硬质合金螺纹铣刀	Carbide Planet Cutter for Small Size (Thread Milling Cutter)
	442	WLS-HSCT-N	倒角用WXL涂层3刃硬质合金铣刀 长柄负前角型	WXL Coated 3-flute Carbide End Mill Long Shank Type for Chamfering (Negative)
	441	WLS-HSCT-P	倒角用WXL涂层3刃硬质合金铣刀 长柄正前角型	WXL Coated 3-flute Carbide End Mill Long Shank Type for Chamfering (Positive)
	381	WX-CRE	WX涂层硬质合金圆弧角铣刀	WX Coated Carbide End Mill with Corner Radius
	261	WX-G-EDSS	WX涂层2刃硬质合金平头铣刀 超短刃型	WX Coated 2-flute Carbide End Mill Stub Length (Corner Protect Type)
	283	WX-G-EMSS	WX涂层4刃硬质合金平头铣刀 超短刃型	WX Coated 4-flute Carbide End Mill Stub Length (Corner Protect Type)
	255	WXL-1.5D-DE	WXL涂层2刃硬质合金平头铣刀 1.5D刃长型	WXL Coated 2-flute Carbide End Mill (1.5D Type)
	256	WXL-2D-DE	WXL涂层2刃硬质合金平头铣刀 2D刃长型	WXL Coated 2-flute Carbide End Mill (2D Type)
	259	WXL-3D-DE	WXL涂层2刃硬质合金平头铣刀 3D刃长型	WXL Coated 2-flute Carbide End Mill (3D Type)
	260	WXL-4D-DE	WXL涂层2刃硬质合金平头铣刀 4D刃长型	WXL Coated 2-flute Carbide End Mill (4D Type)
	318	WXL-EBD	WXL涂层2刃硬质合金球头铣刀	WXL Coated 2-flute Carbide Ball End Mill
	282	WXL-EMS	WXL涂层4刃硬质合金平头铣刀 短刃型	WXL Coated 4-flute Carbide End Mill Short Length
	319	WXL-HS-EBD	WXL涂层2刃硬质合金球头铣刀 (HSK适用)	WXL Coated 2-flute Carbide Ball End Mill with HS Shank
	337	WXL-LN-EBD	WXL涂层2刃硬质合金长颈球头铣刀 (深细槽型)	WXL Coated 2-flute Long Neck Carbide Ball End Mill for Rib Processing
	308	WXL-LN-EDS	WXL涂层2刃硬质合金长颈平头铣刀 短刃型 (深细槽)	WXL Coated 2-flute Long Neck Carbide End Mill Short Length for Rib Processing
	315	WXL-LN-EMS	WXL涂层4刃硬质合金长颈平头铣刀 短刃型 (深细槽)	WXL Coated 4-flute Long Neck Carbide End Mill Short Length for Rib Processing

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产品索引表 CLASSIFIED BY ALPHABETICAL ORDER

	页码 Page	商品记号 Abbreviation	品名	Description
W	356	WXL-PC-EBD	WXL涂层2刃硬质合金锥颈球头铣刀	WXL Coated 2-flute Pencil Neck Carbide Ball End Mill
	194	WX-MS-GDS	极小径 · 精密加工用WX涂层硬质合金钻头 超短刃型	WX Coated Carbide Small Size Drill Stub Length for Precision Operation
	514	WXO-ST-PNC	钢用WX涂层内冷油孔硬质合金螺纹铣刀	WX Coated Carbide Planet Cutter with Internal Coolant Supply for Steel (Thread Milling Cutter)
	302	WX-PHL	WX涂层4刃硬质合金平头铣刀 长刃型	WX Coated 4-flute Carbide End Mill Long Length (Heavy-duty Operation Type)
	300	WX-PHN	WX涂层4刃硬质合金平头铣刀 中等刃长型	WX Coated 4-flute Carbide End Mill Medium Length (Heavy-duty Operation Type)
	295	WX-PHSS	WX涂层4刃硬质合金平头铣刀 强力重切削超短刃型	WX Coated 4-flute Carbide End Mill Stub Length (Heavy-duty Operation Type)
	515	WX-PNC	非铁 · 耐热合金用WX涂层硬质合金螺纹铣刀	WX Coated Carbide Planet Cutter for Non-ferrous Materials and Heat-resistant Alloys (Thread Milling Cutter)
	425	WX-RESF	WX涂层硬质合金波纹型铣刀	WX Coated Carbide Roughing End Mill Fine Pitch Short Length
	401	WXS-CPR	WXS涂层硬质合金圆弧角铣刀 高精度型	WXS Coated High-precision Carbide End Mill with Corner Radius
	321	WXS-EBD	WXS涂层2刃硬质合金球头铣刀	WXS Coated 2-flute Carbide Ball End Mill
	287	WXS-EMS	WXS涂层多刃硬质合金平头铣刀 短刃型	WXS Coated 'Multiple-flute Carbide End Mill Short Length
	304	WX-SHTSS	插铣加工用WX涂层3刃硬质合金平头铣刀 超短刃型	WX Coated 3-flute Carbide End Mill Stub Length for Slotting
	512	WX-ST-PNC	钢用WX涂层硬质合金螺纹铣刀	WX Coated Carbide Planet Cutter for Steel (Thread Milling Cutter)
X	777	XPM-EBD	2刃XPM球头铣刀	2-flute XPM Ball End Mill
	736	XPM-EDL	2刃XPM平头铣刀 长刃型	2-flute XPM End Mill Long Length
	730	XPM-EDN	2刃XPM平头铣刀 中等刃长型	2-flute XPM End Mill Medium Length
	707	XPM-EDS	2刃XPM平头铣刀 短刃型	2-flute XPM End Mill Short Length
	754	XPM-EHL	XPM平头铣刀 大螺旋角长刃型	High Helix XPM End Mill Long Length
	773	XPM-EHS	XPM平头铣刀 大螺旋角短刃型	High Helix XPM End Mill Short Length
	763	XPM-EML	多刃XPM平头铣刀 长刃型	Multi-flute XPM End Mill Long Length
	747	XPM-EMS	4刃XPM平头铣刀 短刃型	4-flute XPM End Mill Short Length
	841	XPM-TPBDR	2刃XPM锥形球头铣刀 标准型	2-flute XPM Taper Ball End Mill Regular Length
	838	XPM-TPBDS	2刃XPM锥形球头铣刀 短刃型	2-flute XPM Taper Ball End Mills Short Length
	826	XPM-TPDR	2刃XPM锥形铣刀 标准型	2-flute XPM Taper End Mill Regular Length
	822	XPM-TPDS	2刃XPM锥形铣刀 短刃型	2-flute XPM Taper End Mill Short Length
	821	XPM-TPDSS	2刃XPM锥形铣刀 超短刃型	2-flute XPM Taper End Mill Stub Length
	834	XPM-TPMR	4刃XPM锥形铣刀 标准型	4-flute XPM Taper End Mill Regular Length
	831	XPM-TPMS	4刃XPM锥形铣刀 短刃型	4-flute XPM Taper End Mill Short Length
	823	XPM-TRC	2刃XPM梯形铣刀	2-flute XPM Taper End Mill for Trapezoidal Runner

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营业·流通基地 BUSINESS AND DISTRIBUTION BASES

网络覆盖全国的万全的技术支持体制

OSG为了能够回应客户们的各种需求，确立了全国范围的技术支持体制。国内分为东部，中部，西部三个板块。在营业所配置销售工程师，从技术咨询到商品讲习会再到投诉处理，配合各地域的产业特色及需求推广我们无微不至的服务。

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八名工場 YANA FACTORY
(生産品目：タップ Taps)

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新城工場 SHINSHIRO FACTORY
(生産品目：超硬ドリル・超硬タップ・ハイスドリル・ハイスエンドミル
Carbide Drills, Carbide Taps, HSS Drills, HSS End Mills)

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Providing high quality coatings to our wide range of customers.

OSG涂层服务公司，汇集了OSG发展20年的涂层经验，技术，以充分满足客户的需求。为了满足日益发展的切削技术以及时刻变化着的被加工材料的要求，OSG涂层服务公司应运而生。因为我们拥有日本中最大的涂层处理能力，所以我们可以在保证质量的前提下快快速写的交付产品。

OSG Coating Service Corporation has collectively incorporated the technologies of OSG developed through 30 years of experience, to meet the needs of customers. OSG Coating Service Corporation has been established to inherit the coating technology and experiences of OSG to respond to the continuously evolving milling technologies and tools for the frequently changing work materials. With our high capacity coating treatment furnaces that is the largest in Japan, we have been able achieve prompt delivery while maintaining high quality.

■涂层的种类与特性 Types and characteristics of coatings

TiN 耐摩耗性 Wear resistance	**V** （TiCN系） 耐摩耗性·低摩擦係数 Wear resistance · Low friction coefficient	**FX** （TiAlN系） 耐熱性·耐摩耗性 Heat resistance · Wear resistance	**DUROREY** 超耐熱性 超耐摩耗性 Super heat resistance Super wear resistance	**WXL** 耐摩耗性 耐溶着性 Wear resistance Anti-welding resistance	**SXL** 耐サーマルクラック性 耐摩耗性 Thermal crack resistance Wear resistance
EgiAs 耐摩耗性 高じん性 Wear resistance High toughness	**IchAda** 表面平滑 耐摩耗性 Smooth surface Wear resistance	**DLC-SUPER HARD** 耐溶着性 高潤滑性 Anti-welding resistance Excellent lubricity	**DLC-IGUSS** 耐溶着性 耐摩耗性 Anti-welding resistance Wear resistance	**DIA** 超微結晶·耐摩耗性 耐溶着性 Ultra Micro Diamond · Wear resistance Anti-welding resistance	**GranDIA** 耐摩耗性 耐熱性·導電性 Wear resistance Heat Resistance · Electrical Conductivity

オーエスジーコーティングサービス㈱
ホームページ

OCS's website
http://www.e-ocs.com

涂层加工服务 COATING SERVICE

■涂层的种类与特性 Coating Equipment

离子束法
这种方法用语生成光滑的抗粘结性涂层，如TiN,TiCN,CrN涂层。

Electron Beam method
This method creates smooth TiN, TiCN, and CrN coatings with superior welding resistance.

电弧离子法
这种方法用于生成良好耐磨性的TiN,TiCN,TiAlN涂层。

Arc Ion Plating method
Equipped with multiple high-energy vapor deposition sources to form multi-element multilayer films, which enables the formation of a highly wear-resistant film with excellent toughness.

除切削工具外,也承接各种零件的涂层服务。
Various coating are available for requested parts

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1968年，OSG公司在美国成立了第一家海外子公司。从那时起，OSG公司积极拓展其全球业务，建立了覆盖33个国家的生产、销售和技术支持网络。

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法令一部改正によるコバルトの特定化学物質指定について

About the designation of cobalt as a specified chemical substance by the revision of the law

2014年10月30日

October 30, 2014

お客様各位

下記に記載の通り、コバルトが特定化学物質に指定されました。工具を通常使用する場合は健康障害を引き起こすことはありませんが、お客様に安心して弊社の製品をご使用いただく為にも、弊社製品のコバルト含有の有無を総合カタログへ記載することにいたしました。ご確認いただきますようお願い申し上げます。

1. 法改正内容について

労働安全衛生法施行令等一部改正により特定化学物質の第2類物質として「コバルト及びその無機化合物」が新たに追加指定され、2012年9月20日公布、2013年1月1日施行されております。

法改正に伴い、特定化学物質による健康障害防止措置として下記対策を講じる必要があります。

- 製品（粉末・合金・工具）への表示　※
- 発散抑制措置（コバルト濃度として0.02mg/㎥以下）
- 漏洩のための措置
- 作業主任者の選任
- 作業環境測定（6ヶ月毎）
- 健康診断（6ヶ月毎）、記録の30年保管
- 保護具装備、作業記録30年保管、休憩室設置、洗浄設備設置、取扱注意表示

※「製品への表示」のうち「工具への表示」につきましては、以下の通りです。
当業界の工具は、労働者による取扱いの過程において工具等の摩耗により作業者が健康障害を生じるコバルト粉じん等の飛散はないため表示対象外製品であると判断されました。従いまして表示に関しましても今まで通り変更ございません。

2. 法改正に伴う対応について

（1）工具をご使用いただくお客様

工具を通常ご使用いただく場合は、工具等の摩耗により作業者が健康障害を引き起こすコバルト粉じん等の発散は生じないことから、特定化学物質による健康障害防止措置を実施する対象となりません。今までどおりご使用いただきますよう、お願い申し上げます。

（2）コバルトを含む工具を購入され、それを研削などにより追加工をされるお客様

コバルトを含む工具の追加工および再研削工程などでは、上記1項の対策を講じる必要があると思われます。なお、詳細は所轄の労働基準監督署または法令等でご確認ください。

Dear Customers

As described below, cobalt has been listed as specified chemical substances. Although it does not cause health problems in regular use of tools, however, for our customers to be able to use our products with confidence, we put a notice on our catalog about which tool contains cobalt. We ask you to refer it for your information.

1. The amendments of the law

"Cobalt and its inorganic compounds" are newly added as second type of specific chemical substances by the partial revision of Ordinance for Enforcement of the Act on Occupational Safety and Health, issued on September 20, 2012, and enforced from January 1, 2013.
According to the amendments to the Act, we must take following actions to prevent health problems caused by specific chemical substances.

- Marking on the tools (Powder, Alloys, Tools) ※
- Divergence control measures (Less than 0.02mg / m^3 as cobalt concentration)
- Measures for leakage
- Appointment of Operations Chief
- Measurement and working environment (every 6 months)
- Keeping health diagnosis records for 30 years (every 6 months)
- Wearing protective equipment, Keep work records for 30 years, Set up a break room, Installation of cleaning equipment, handling notices

※Details of "Making on Tools" found in "Making on Product" are as below:
Scattering of cobalt dust which causes health disorders are not recognized during the machining process using tools of our industry. Therefore, it is judged that the marks indicating cobalt is unnecessary and no changes are made with the marks on products.

2. The correspondence with the revision of the law

(1) Customers who use the tool
Ordinal usage of tools does not cause the scattering of cobalt dust which causes the health disorders. Therefore, it is not subject to take actions preventing the health impairment of workers. Please use our product as before.

(2) Customers who purchase the tool contain cobalt, and make any alterations to it such as by grinding
It is required for the processes as re-grinding and alteration to the tool contains cobalt to take measures above Section 1. Since there is a setting of the grace period, please check the laws of regulations of the competent or Labor Standards Inspection Office for more information.

安全使用注意事项
Observe These Precautions For Safe Use

加工前注意事项 Prior to Operations:

●徒手触碰锋利的切削刃时十分危险，请勿徒手触碰切削刃。特别是从盒子中取出时，亦或是机械上安装时，都请务必戴好防护手套。
●在处理重型工具时，会有落下危险，请使用合适的搬运机器或链滑车并穿着防护靴。
● 如果刀具有缺口，磨损会导致使用过程中破损并飞溅出碎片。故使用前请务必确认刀具没有缺口及磨损。
● 使用前请确认刀具及加工物的尺寸。
● 搞错旋转方向会导致刀具破损，有飞溅危险。使用前请确认旋转方向。
● 包括工作机械保持器的旋转部分产生平衡不良时，容易发生震动导致刀具破损会有危险，请务必实施试运转，确认平衡。危险。使用前请确认旋转方向。
●刀具固定不足时会导致破损飞溅等危险，请根据刀具选择合适的刀柄。请将刀具牢固地安装在刀柄上，确认不发生震动。多刃刀片的场合下请确认刀片及部件都已夹紧。
●加工物固定不足时会导致刀具及加工物破损飞溅等危险，请确认加工物安装牢固。

● Touching sharp cutting edges with bare hands can cause injury. Never touch the cutting edges with bare hands. Wear protective gloves, especially when removing tools from the case and attaching them to the machine.
● When handling heavy tools, dropping poses danger. Use appro-priate transport equipment or chain block and wear safety shoes.
● Scratches or cracks in the tools can cause breakage and flying debris during operation. Ensure that there are no scratches or cracks prior to using the tools.
● Check if the tools and the work materials are correct prior to use.
● If the tool is rotating in the wrong direction, it can cause breakage or flying debris, leading to injury. Check the rotation direction prior to use.
● If the rotational balance is poor (including that for the retainer of the machine tools), the shaking vibration could cause breakage and lead to accidents. Ensure that you always carry out a test operation and check the balance.
● Insufficient retention of the tool can lead to breakage or flying debris, causing injuries. Ensure you use holders, etc. that match the tools and the nature of the processing operations. The tool should be firmly attached to the holder to prevent shaking. When using indexable tools ensure you check before-hand that indexable inserts and parts are securely clamped.
● Insufficient retention of the work materials can cause tools and work materials to break or cause flying debris. Ensure that the work materials are firmly secured.

加工中注意事 During Operations:

●触碰旋转中的刀具，加工物等会有危险，请绝对不要触碰。另外，宽松的衣服会有被卷入的危险，请不要穿宽松的衣物。
●刀具加工中受到冲击的负荷会导致破损及飞溅等危险。另外，高温的切屑飞溅出来会导致烫伤，所以请务必穿戴好安全罩及护目镜。
●刀具改造，或在别的用途上使用，刀具会破损飞溅。所以请不要改造刀具，并按照原目的使用。
●切削条件基准表的数值是重新启动新作业时的基准。请结合加工物的形状及机械刚性进行调节。
●加工中发生异常震动时，请立即停止加工。如果继续加工的话，会导致刀具的破损飞溅等危险。请等到异常问题解决后再开始加工。
●继续使用磨损的刀具是导致破损及飞溅的原因，请在锋利性变差时交换刀具。
●请根据用途选择切削油剂。使用不水溶性切削油剂时，加工时因火花集破损导致发热会引起火灾，所以请事先做好防火措施。

● Touching the tools or the work materials during rotation can cause injury. Never touch tools or work materials during rotation. As loose clothing can become caught in mechanisms, ensure that you wear work clothes that can not become caught.
● If the tool receives a shock load during processing, this can cause breakage or flying debris, leading to injury. As hot flying cutting chips cause injury or burns, ensure you use protective equipment including safety covers and eye protection.
● Modifying the tool or attempting to use it for purposes other than the original purpose can cause breakage or flying debris, leading to possible injury. Never attempt to modify the tool and never use it for any purpose other than the designated purpose.
● The numerical value listed in the table of recommended cutting conditions should be used as a general guide when starting new operations. It is necessary to adjust conditions according to the dimensions of work materials and the rigidity of the machine.
● If abnormal vibration, etc. occurs during processing, stop processing immediately. Attempting to continue processing can cause tool breakage or flying debris, leading to possible injury. Ensure that you eliminate the cause of the abnormality before resuming processing.
● Attempting to use tools with considerable wear can cause breakage or flying debris. Replace the tool when it no longer cuts well.
● Select a cutting oil appropriate to the particular usage. Using a non-water-soluble cutting oil could lead to fires due to sparks generated during processing or heat caused by breakage. Ensure that you take proper fire-prevention measures.

加工中注意事项 After Use:

●刚加工好的刀具，加工物会因为高温导致烫伤。所以请不要徒手去触碰。
●加工物表面的毛刺会刺伤手，所以请不要徒手触碰。
●加工后请务必确认加工物的尺寸
●刀具的再研磨后悔产生粉尘对人体有害，请务必准备防尘面具，吸尘机等粉尘对策。

● Tools and work materials are very hot immediately after processing. Never touch them with your bare hands.
● The burrs generated during processing can cause injury. Never touch them with your bare hands.
● Ensure that you check the measurements of the work materials after processing.
● When the tool is reground, grinding dust is generated which is dangerous to your health. Ensure that you take proper safety measures such as wearing a dustproof mask or using a respirator.

以上是安全使用本公司产品的基本注意事项。
详细情况请咨询本公司。

This completes the basic precautions for safe use of this company's equipment.
Please feel free to contact us at any time if you have any further questions.

欧士机（上海）精密工具有限公司

OSG Corporation

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