



# 2023 丝锥 Tap



# 公司简介 About GESAC

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

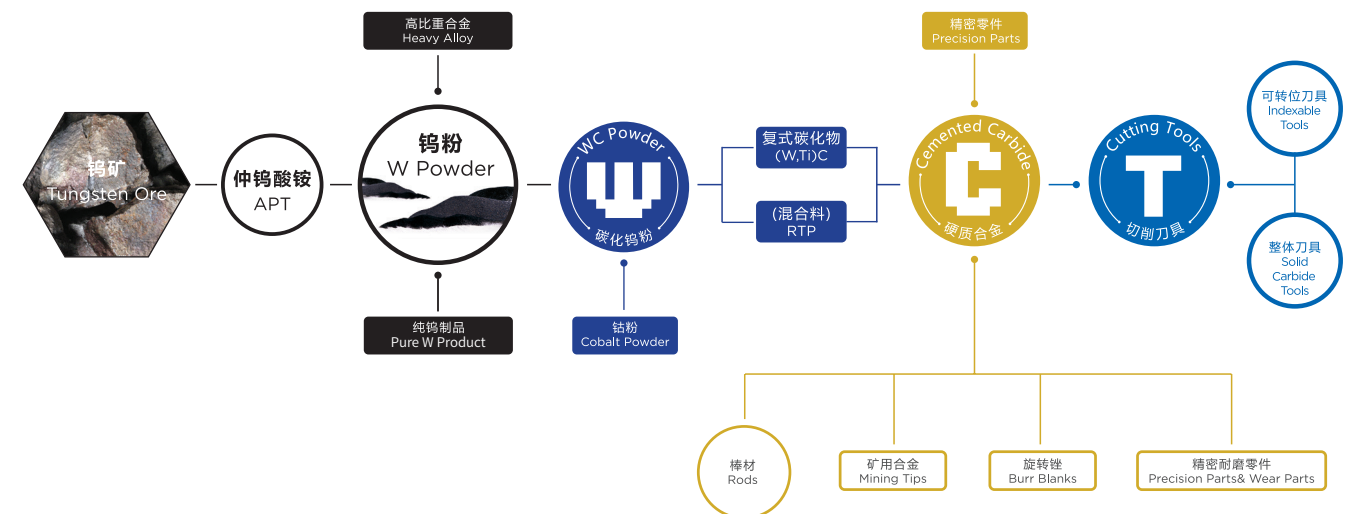
凭借完整钨产业链的产品集成技术研发，以及务实、创新的管理理念，厦门金鹭始终保持着强劲的发展势头，为全球用户提供最高性价比的钨粉末产品和服务，为现代工业领域解决高硬度、耐高温、耐磨损问题，提供了优良的产品和完善的解决方案，客户遍布全球四十多个工业发达国家和地区，享誉海内外。

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

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

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

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







# 丝锥选用指南 Taps Selection Guide

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### 名词解释 Glossary

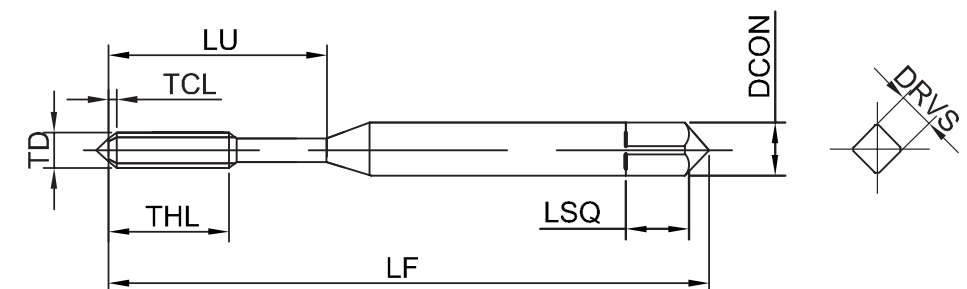
	图标 Sign	含义 Note
丝锥材料 Tap Material		粉末冶金高速钢 Powder Metallurgy High Speed Steel
		含钴高速钢 Cobalt-containing High Speed Steel
尺寸标准 Size Standard		DIN371/DIN376尺寸标准 Dimension Standard
		JIS尺寸标准 Dimension Standard
冷却方式 Cooling Method		侧向内冷 Coolant Directed Sideways
		轴向内冷 Coolant Directed Axially
		外冷 External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

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

### 名词解释 Glossary

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

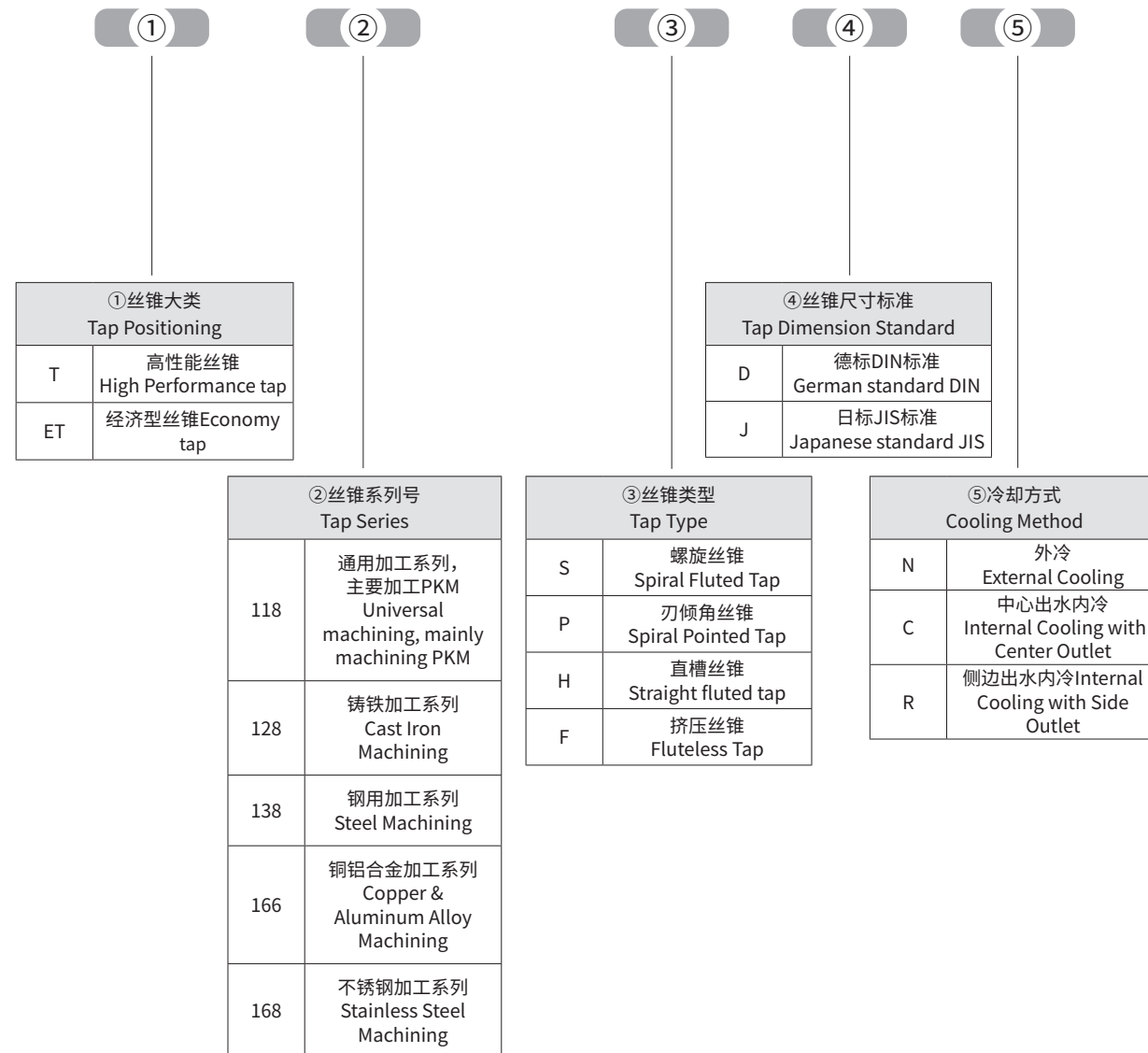
标准：采用ISO 13399  
Standard: ISO 13399



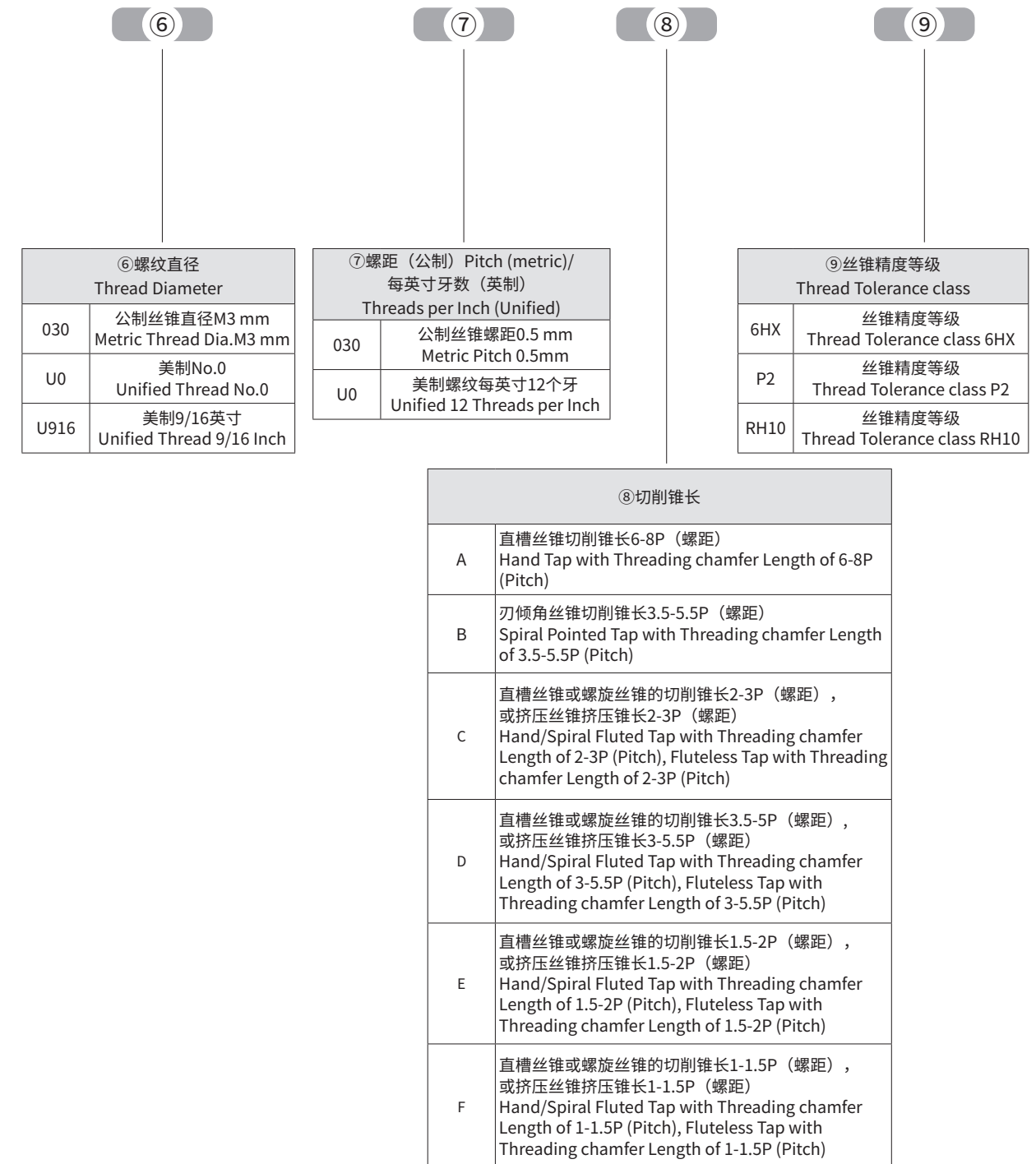


### 金鹭丝锥内部型号 Tap Identification System

**T 118 — S D C**



**030 050 C — 6HX**



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

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

A

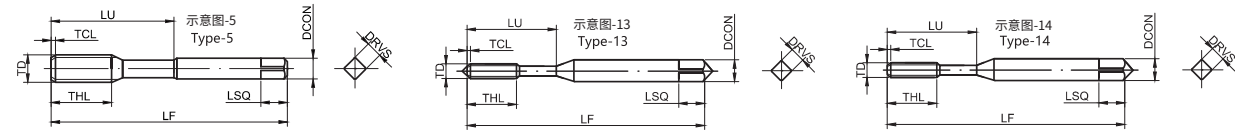
高性能丝锥  
High Performance Taps





# T118-FDN

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



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

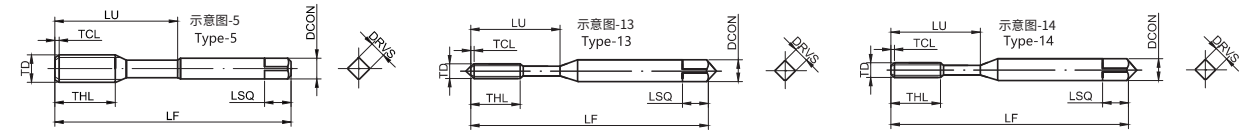
● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

○ 最适合 Most Suitable ○ 适合 Suitabel  
推荐切削参数 ※P27 Recommended Cutting Data ※P27

# T118-FDN

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



» 续前 Continue

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

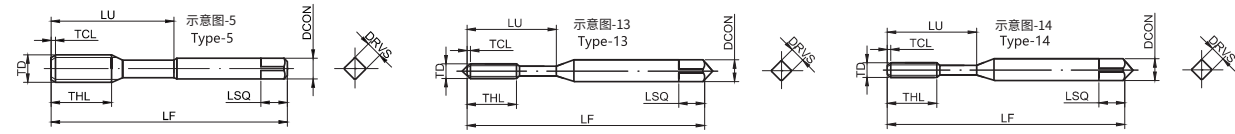
● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

○ 最适合 Most Suitable ○ 适合 Suitabel  
推荐切削参数 ※P27 Recommended Cutting Data ※P27

# T118-FDN

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



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

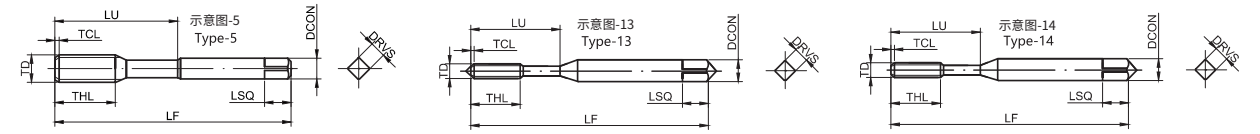
● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

◎ 最适合 Most Suitable ○ 适合 Suitabel  
推荐切削参数 ※P27 Recommended Cutting Data ※P27

# T118-FDN

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



» 续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

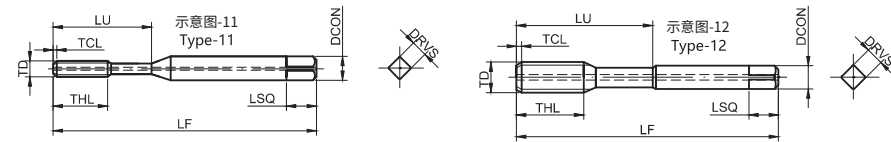
◎ 最适合 Most Suitable ○ 适合 Suitabel  
推荐切削参数 ※P27 Recommended Cutting Data ※P27



# T118-FDC

高性能内冷通用加工挤压丝锥

High-performance internal coolant general machining fluteless tap



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

● 标准库存Stock ○ 需预定Available upon Order

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

单位:mm  
unit:mm

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

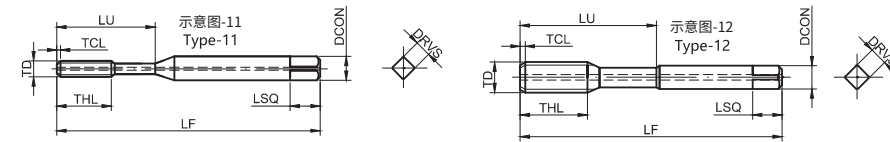
○ 最适合 Most Suitable ○ 适合 Suitabel

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

# T118-FDC

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High-performance internal coolant general machining fluteless tap



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

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

单位:mm  
unit:mm

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

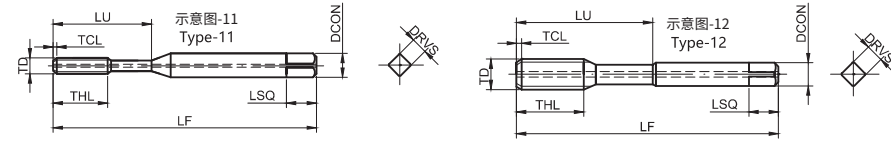
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Recommended Cutting Data ※P27

# T118-FDR

高性能内冷通用加工挤压丝锥

High-performance internal coolant general machining fluteless tap



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

● 标准库存Stock ○ 需预定Available upon Order

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

单位:mm  
unit:mm

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

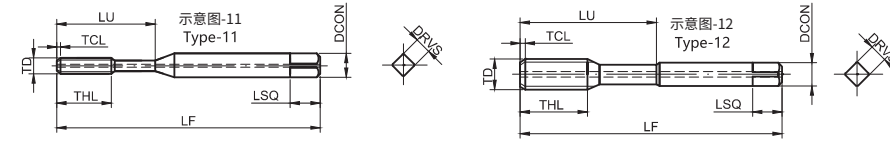
○ 最适合 Most Suitable ○ 适合 Suitabel

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

# T118-FDR

高性能内冷通用加工挤压丝锥

High-performance internal coolant general machining fluteless tap



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order

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

单位:mm  
unit:mm

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

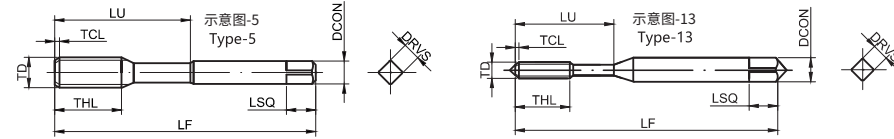
○ 最适合 Most Suitable ○ 适合 Suitabel

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



# T118-SDN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

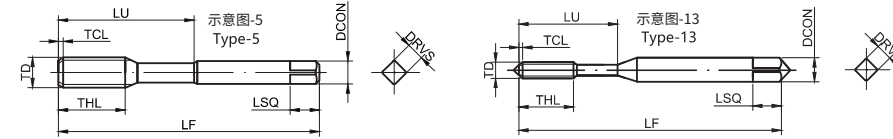
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# T118-PDN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

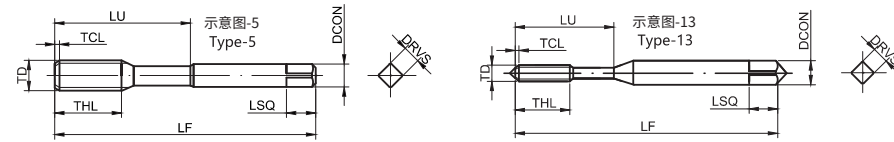
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# T128-HDN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅做参考。PHD for reference only.

单位:mm  
unit:mm

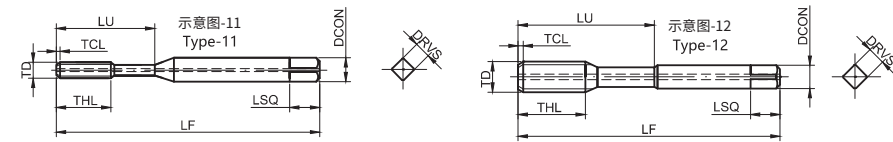
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

● 最适合 Most Suitable ○ 适合 Suitabel

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

# T128-HDC

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅做参考。PHD for reference only.

单位:mm  
unit:mm

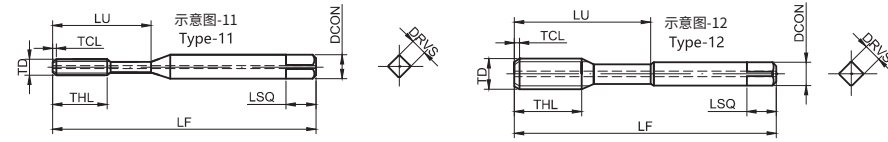
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

● 最适合 Most Suitable ○ 适合 Suitabel

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

# T128-HDR

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅做参考。PHD for reference only.

单位:mm  
unit:mm

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

◎ 最适合 Most Suitable ○ 适合 Suitabel

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

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

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

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

单位:m/min  
unit:m/min



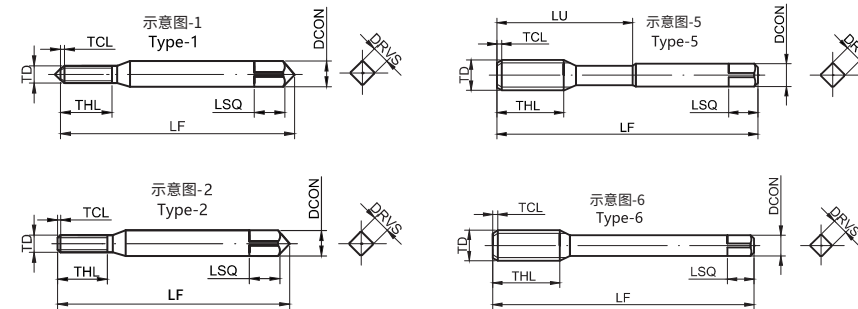
B

# 经济型丝锥 Economy Taps



## ET138-FJN

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



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

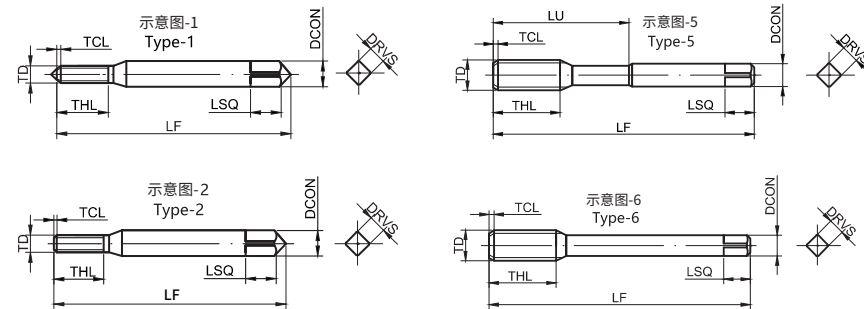
● 标准库存 Stock ○ 需预定 Available upon Order  
 [备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

○ 最适合 Most Suitable ○ 适合 Suitabel  
 推荐切削参数 ※P62 Recommended Cutting Data ※P62

# ET138-FJN

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



» 续前 Continue

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

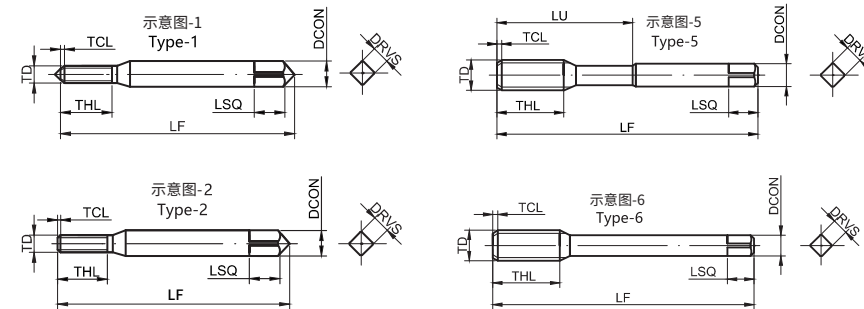
● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

○ 最适合 Most Suitable ○ 适合 Suitabel 推荐切削参数 ※P62 Recommended Cutting Data ※P62

# ET138-FJN

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



» 续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

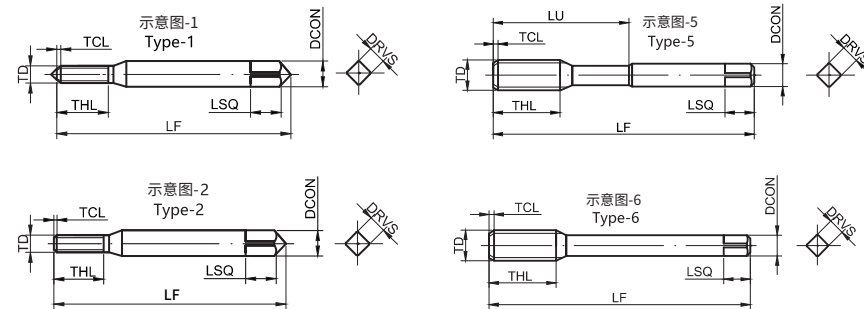
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel 推荐切削参数 ※P62 Recommended Cutting Data ※P62



# ET138-FJN

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



» 续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order

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

单位:mm  
unit:mm

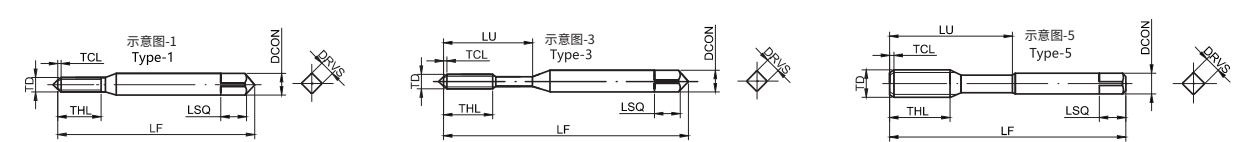
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

◎ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET138-SJN

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



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

● 标准库存Stock ○ 需预定Available upon Order

[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

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

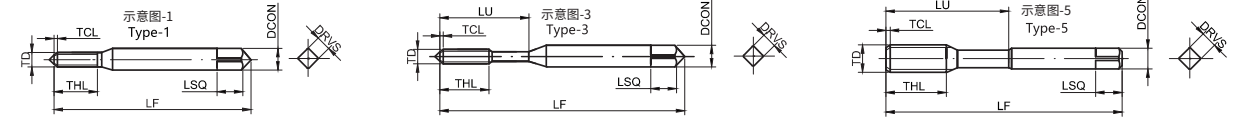
◎ 最适合 Most Suitable ○ 适合 Suitabel

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



# ET138-SJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

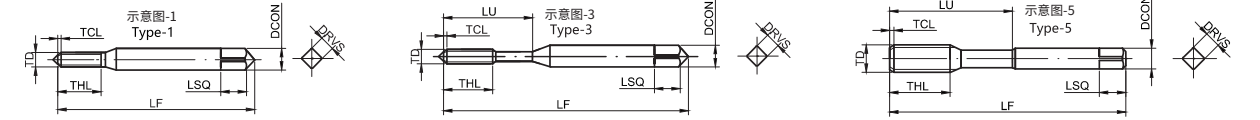
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET138-SJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

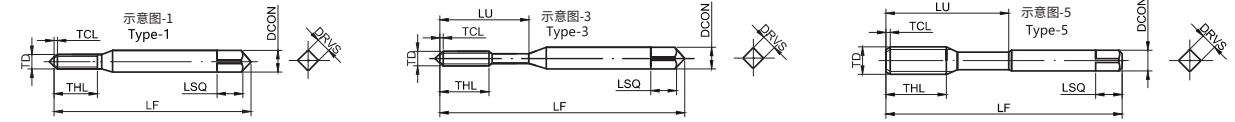
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET138-PJN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

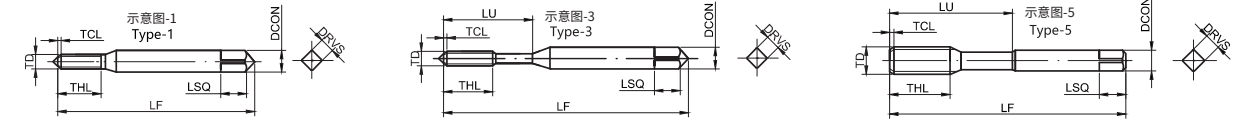
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET138-PJN

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



》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TP11	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET138-PJN-140200B-P5	M14×2	14	2	P5	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET138-PJN-140150B-P4	M14×1.5	14	1.5	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET138-PJN-140125B-P4	M14×1.25	14	1.25	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET138-PJN-140100B-P3	M14×1	14	1	P3	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET138-PJN-160200B-P5	M16×2	16	2	P5	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET138-PJN-160150B-P4	M16×1.5	16	1.5	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	●
ET138-PJN-160125B-P4	M16×1.25	16	1.25	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET138-PJN-160100B-P3	M16×1	16	1	P3	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET138-PJN-U080B-P1	NO.0-80UNF	1.524	80	P1	5P	B	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET138-PJN-U164B-P1	NO.1-64UNC	1.854	64	P1	5P	B	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET138-PJN-U256B-P1	NO.2-56UNC	2.184	56	P1	5P	B	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET138-PJN-U348B-P1	NO.3-48UNC	2.515	48	P1	5P	B	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET138-PJN-U440B-P2	NO.4-40UNC	2.845	40	P2	5P	B	1	45	13	—	3	2.5	3	3×2.5	7.1	3	2.21	●
ET138-PJN-U540B-P2	NO.5-40UNC	3.175	40	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET138-PJN-U632B-P2	NO.6-32UNC	3.505	32	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.71	●
ET138-PJN-U832B-P2	NO.8-32UNC	4.166	32	P2	5P	B	3	57	13.5	21.5	5	4	7	5×4	10.4	3	3.37	●
ET138-PJN-U1024B-P2	NO.10-24UNC	4.826	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	●
ET138-PJN-U1032B-P2	NO.10-32UNF	4.826	32	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET138-PJN-U1224B-P2	NO.12-24UNC	5.486	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET138-PJN-U1228B-P2	NO.12-28UNF	5.486	28	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET138-PJN-U1420B-P2	1/4-20UNC	6.350	20	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.08	●

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

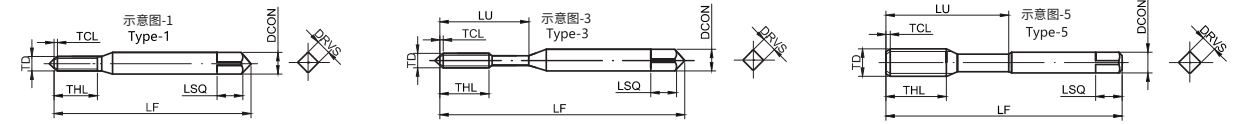
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET138-PJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

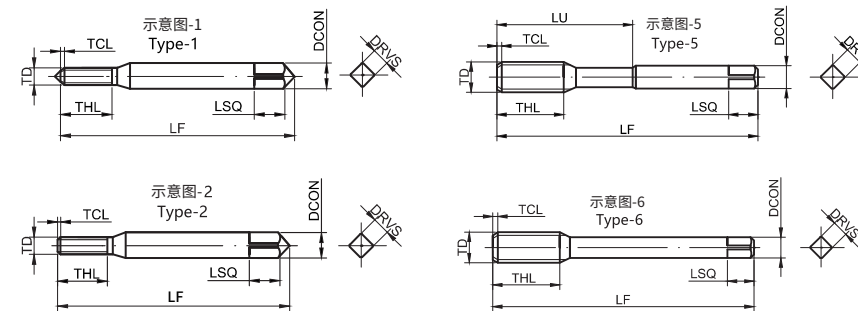
工件材料 Workpiece Material													
P		M		K		N			S		H		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET168-FJN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算，仅供参考。PHD was calculated by overlap ratio 85%, for reference only.

单位:mm  
unit:mm

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

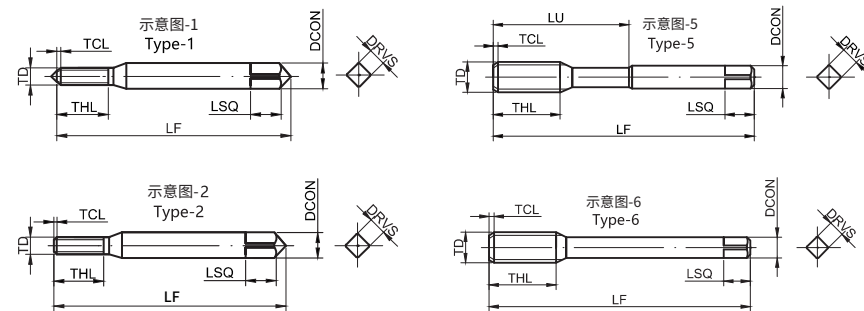
○ 最适合 Most Suitable ○ 适合 Suitabel

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



# ET168-FJN

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



» 续前 Continue

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

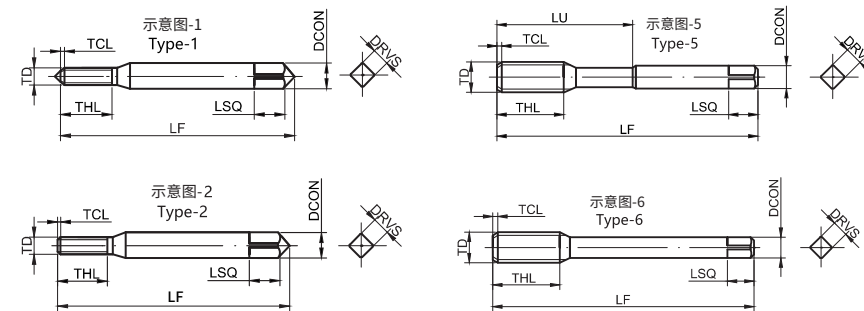
● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

◎ 最适合 Most Suitable ○ 适合 Suitabel  
推荐切削参数 ※P62 Recommended Cutting Data ※P62

# ET168-FJN

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



» 续前 Continue

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

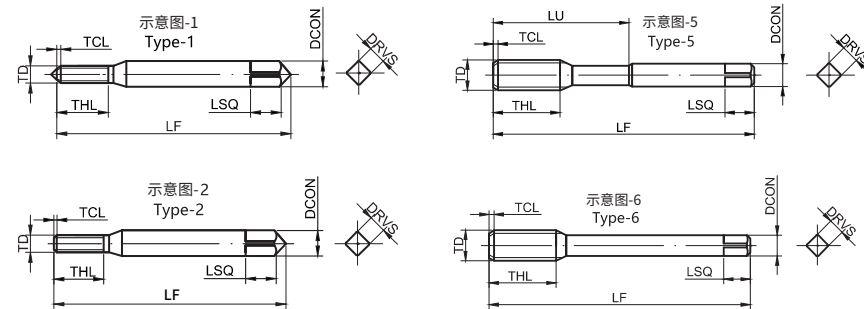
● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

◎ 最适合 Most Suitable ○ 适合 Suitabel  
推荐切削参数 ※P62 Recommended Cutting Data ※P62

# ET168-FJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order

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

单位:mm  
unit:mm

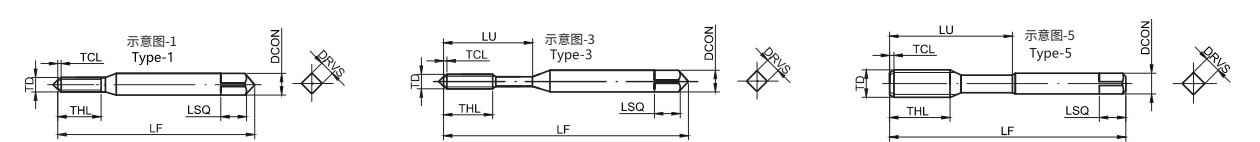
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

◎ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET168-SJN

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



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

● 标准库存Stock ○ 需预定Available upon Order

[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

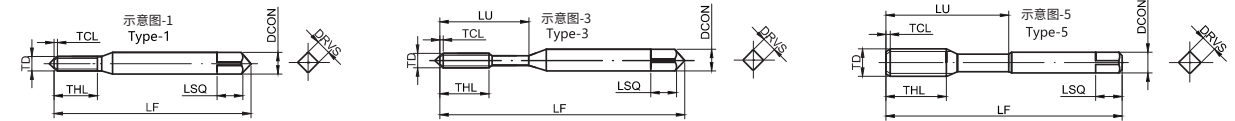
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

◎ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET168-SJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

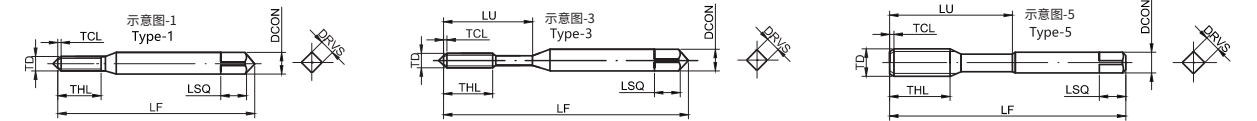
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

◎ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET168-SJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

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

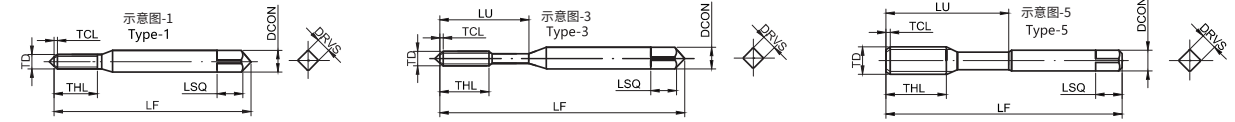
◎ 最适合 Most Suitable ○ 适合 Suitabel

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



# ET168-PJN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

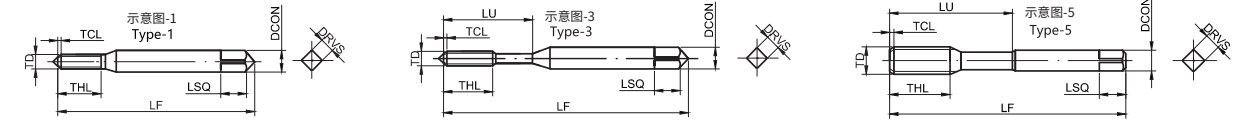
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

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

# ET168-PJN

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



» 续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TP1	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET168-PJN-140200B-P5	M14×2	14	2	P5	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET168-PJN-140150B-P4	M14×1.5	14	1.5	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET168-PJN-140125B-P4	M14×1.25	14	1.25	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET168-PJN-140100B-P3	M14×1	14	1	P3	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET168-PJN-160200B-P5	M16×2	16	2	P5	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET168-PJN-160150B-P4	M16×1.5	16	1.5	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	○
ET168-PJN-160125B-P4	M16×1.25	16	1.25	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET168-PJN-160100B-P3	M16×1	16	1	P3	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET168-PJN-U080B-P1	NO.0-80UNF	1.524	80	P1	5P	B	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET168-PJN-U164B-P1	NO.1-64UNC	1.854	64	P1	5P	B	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET168-PJN-U256B-P1	NO.2-56UNC	2.184	56	P1	5P	B	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET168-PJN-U348B-P1	NO.3-48UNC	2.515	48	P1	5P	B	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET168-PJN-U440B-P2	NO.4-40UNC	2.845	40	P2	5P	B	1	45	13	—	3	2.5	3	3×2.5	7.1	2	2.21	○
ET168-PJN-U540B-P2	NO.5-40UNC	3.175	40	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET168-PJN-U632B-P2	NO.6-32UNC	3.505	32	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.71	○
ET168-PJN-U832B-P2	NO.8-32UNC	4.166	32	P2	5P	B	3	57	13.5	21.5	5	4	7	5×4	10.4	3	3.37	○
ET168-PJN-U1024B-P2	NO.10-24UNC	4.826	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	○
ET168-PJN-U1032B-P2	NO.10-32UNF	4.826	32	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET168-PJN-U1224B-P2	NO.12-24UNC	5.486	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET168-PJN-U1228B-P2	NO.12-28UNF	5.486	28	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET168-PJN-U1420B-P2	1/4-20UNC	6.350	20	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.08	○

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

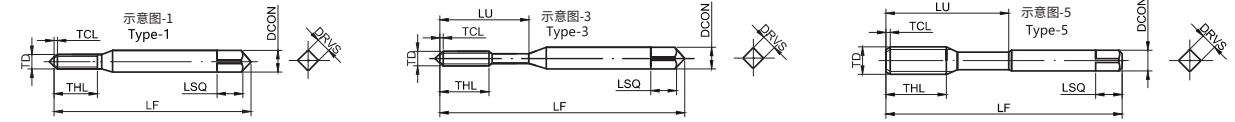
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

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

# ET168-PJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

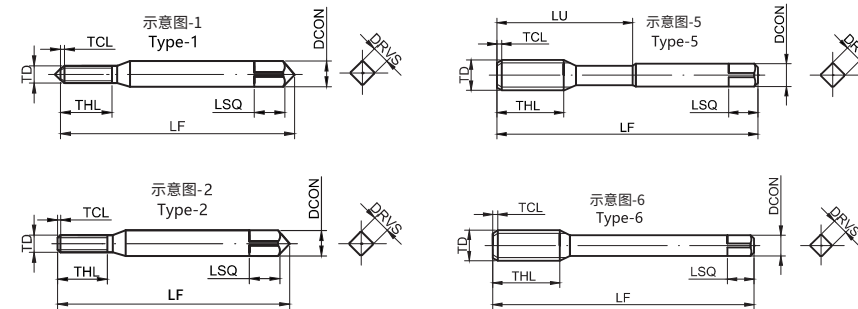
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy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

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

# ET166-FJN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算，仅供参考。PHD was calculated by overlap ratio 85%, for reference only.

单位:mm  
unit:mm

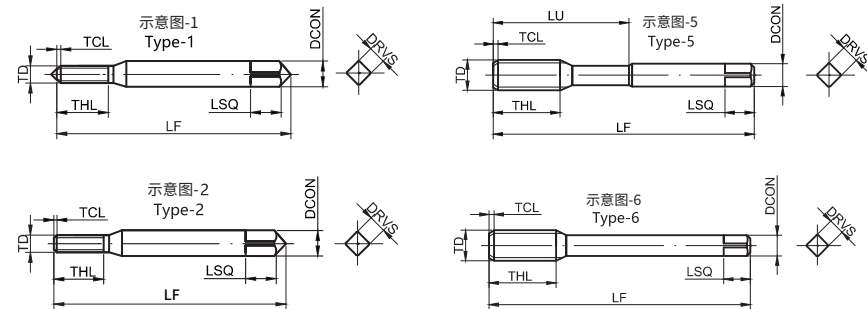
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy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

◎ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET166-FJN

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



» 续前 Continue

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

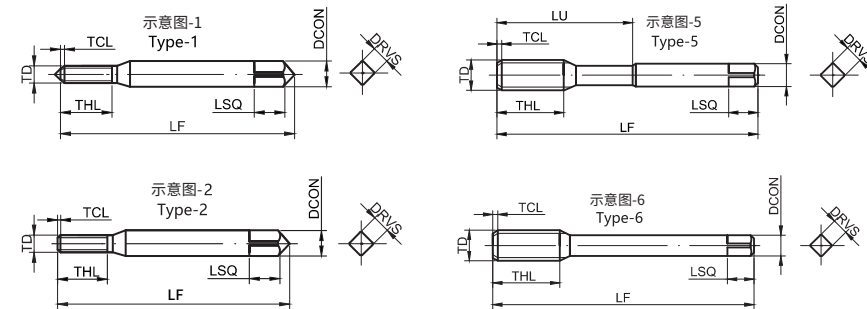
● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

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

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

# ET166-FJN

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



» 续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸以85%嵌合率计算, 仅供参考。PHD was calculated by overlap ratio 85%, for reference only. 单位:mm unit:mm

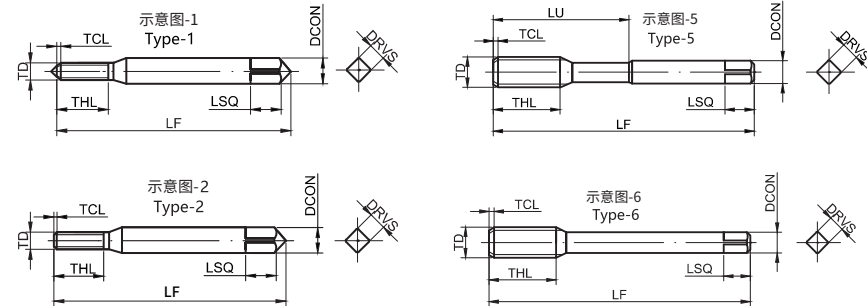
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

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



# ET166-FJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order

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

单位:mm  
unit:mm

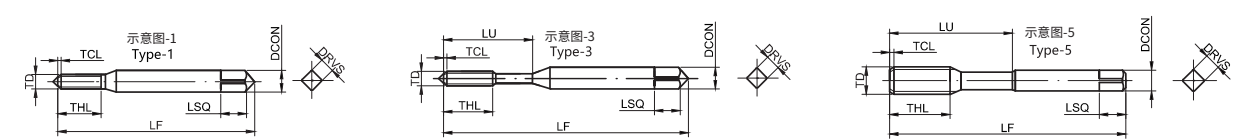
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET166-SJN

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



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

● 标准库存Stock ○ 需预定Available upon Order

[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

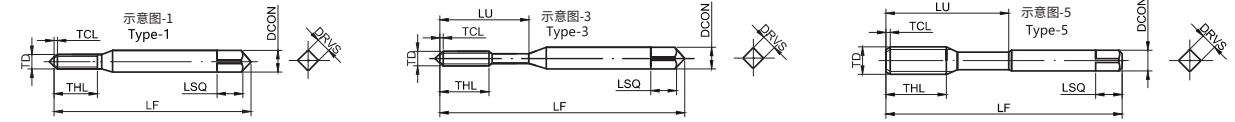
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET166-SJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

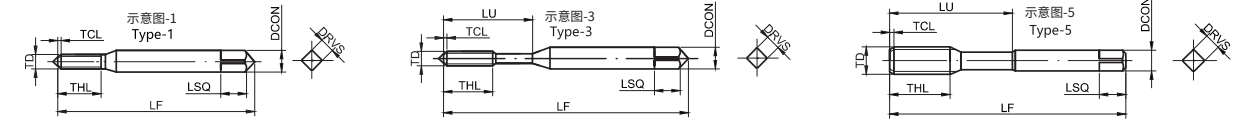
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET166-SJN

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



》续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

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

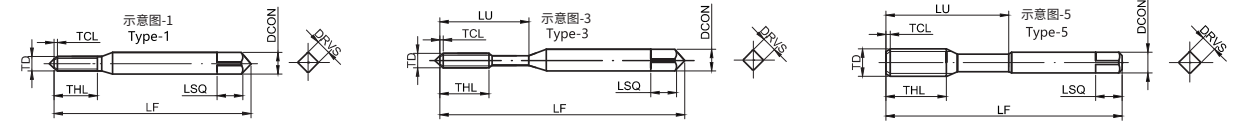
○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET166-PJN

经济型 铜铝加工刃倾角丝锥

Economical copper and aluminum processing spiral pointed tap



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

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

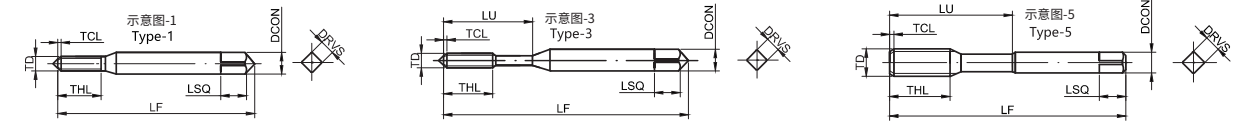
○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET166-PJN

经济型 铜铝加工刃倾角丝锥

Economical copper and aluminum processing spiral pointed tap



》续前 Continue

订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TP/TP1	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-PJN-140200B-P5	M14×2	14	2	P5	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.00	●
ET166-PJN-140150B-P4	M14×1.5	14	1.5	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.50	●
ET166-PJN-140125B-P4	M14×1.25	14	1.25	P4	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	12.75	○
ET166-PJN-140100B-P3	M14×1	14	1	P3	5P	B	5	88	20	51	10.5	8	11	10.5×8	35.0	3	13.00	○
ET166-PJN-160200B-P5	M16×2	16	2	P5	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.00	●
ET166-PJN-160150B-P4	M16×1.5	16	1.5	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.50	●
ET166-PJN-160125B-P4	M16×1.25	16	1.25	P4	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	14.75	○
ET166-PJN-160100B-P3	M16×1	16	1	P3	5P	B	5	95	20	52	12.5	10	13	12.5×10	40.0	3	15.00	○
ET166-PJN-U080B-P1	NO.0-80UNF	1.524	80	P1	5P	B	1	37	10	—	3	2.5	3	3×2.5	3.8	2	1.21	○
ET166-PJN-U164B-P1	NO.1-64UNC	1.854	64	P1	5P	B	1	37	11	—	3	2.5	3	3×2.5	4.6	2	1.46	○
ET166-PJN-U256B-P1	NO.2-56UNC	2.184	56	P1	5P	B	1	45	12	—	3	2.5	3	3×2.5	5.5	2	1.73	○
ET166-PJN-U348B-P1	NO.3-48UNC	2.515	48	P1	5P	B	1	45	14	—	3	2.5	3	3×2.5	6.3	2	1.99	○
ET166-PJN-U440B-P2	NO.4-40UNC	2.845	40	P2	5P	B	1	45	13	—	3	2.5	3	3×2.5	7.1	2	2.21	●
ET166-PJN-U540B-P2	NO.5-40UNC	3.175	40	P2	5P	B	3	50	12	19	4	3.2	6	4×3.2	7.9	3	2.54	○
ET166-PJN-U632B-P2	NO.6-32UNC	3.505	32	P2	5P	B	3	50	13	20	4	3.2	6	4×3.2	8.8	3	2.71	●
ET166-PJN-U832B-P2	NO.8-32UNC	4.166	32	P2	5P	B	3	57	13.5	21.5	5	4	7	5×4	10.4	3	3.37	●
ET166-PJN-U1024B-P2	NO.10-24UNC	4.826	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	3.77	●
ET166-PJN-U1032B-P2	NO.10-32UNC	4.826	32	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	12.1	3	4.03	○
ET166-PJN-U1224B-P2	NO.12-24UNC	5.486	24	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.43	○
ET166-PJN-U1228B-P2	NO.12-28UNC	5.486	28	P2	5P	B	3	66	16.5	26	5.5	4.5	7	5.5×4.5	13.7	3	4.58	○
ET166-PJN-U1420B-P2	1/4-20UNC	6.350	20	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.08	●

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

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

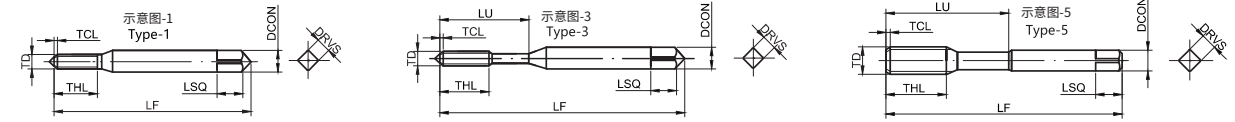
○ 最适合 Most Suitable ○ 适合 Suitabel

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



# ET166-PJN

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



» 续前 Continue

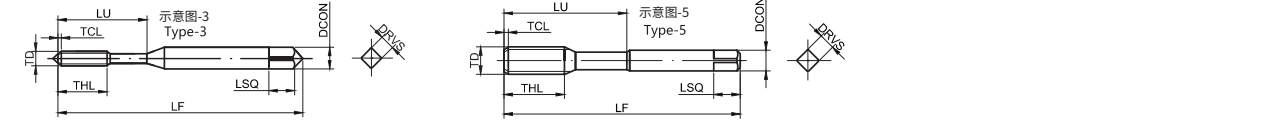
订货号 Ordering Code	螺纹尺寸 Nominal Size	TD	TPI	TCTR	TCL	THCHT	Type	LF	THL	LU	DCON	DRVS	LSQ	CZCMS	TDRM	NOF	PHD	库存 Stocks
ET166-PJN-U1428B-P2	1/4-28UNF	6.350	28	P2	5P	B	3	69	19.5	29	6	4.5	7	6×4.5	15.9	3	5.44	●
ET166-PJN-U51618B-P3	5/16-18UNC	7.938	18	P3	5P	B	5	70	23	38	6.1	5	8	6.1×5	19.8	3	6.53	●
ET166-PJN-U51624B-P3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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

# ET128-HJN

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅供参考。PHD for reference only.

单位:mm  
unit:mm

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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

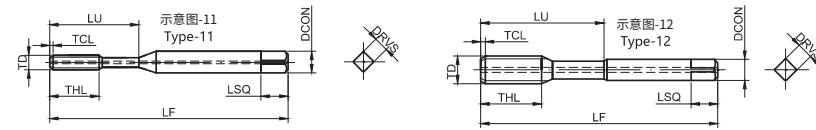
工件材料 Workpiece Material													
P		M		K		N			S		H		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Stainless Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET128-HJC

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅做参考。PHD for reference only.

单位:mm  
unit:mm

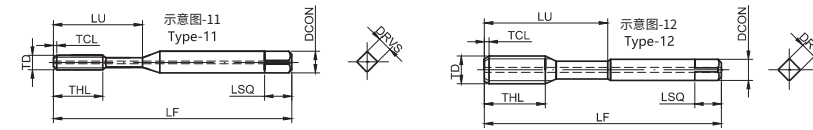
工件材料 Workpiece Material													
P			M		K		N			S		H	
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
碳钢、合金钢 Carbon Steels, Alloy Steels	合金钢、工具钢 Alloy Steels, Tool Steels	PH与铁素体/马氏体钢 PH and Ferritic/Martensitic Steel	不锈钢 Stainless Steel	灰铸铁、球墨铸铁 Gray Cast Iron, Ductile Cast Iron	高合金铸铁 High Alloy Cast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

○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET128-HJR

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



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

● 标准库存Stock ○ 需预定Available upon Order  
[备注 Note] 预孔尺寸仅做参考。PHD for reference only.

单位:mm  
unit:mm

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

○ 最适合 Most Suitable ○ 适合 Suitabel

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



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

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

**【注意Note】**

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

单位:m/min  
unit:m/min

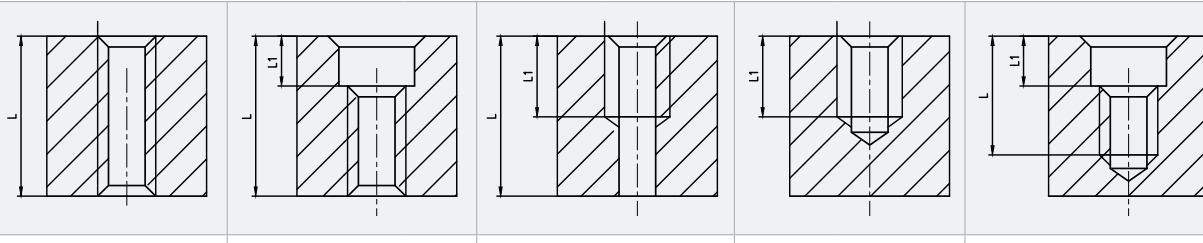
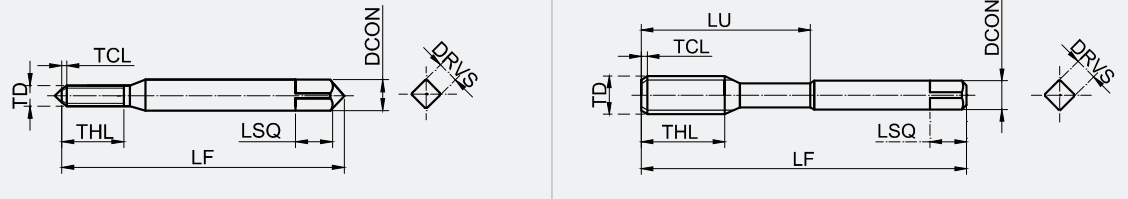
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## 附录 Appendix





### 丝锥询单信息表 Tap Desired Form

丝锥询单信息表 Tap Desired Form		
<b>1、孔的种类 Hole Type</b>		
规格 Specification:	公差 Tolerance:	
螺纹孔特征 Hole Type:		
		
<b>2、加工方式 Machining Method</b>		
机床型号 Machining Machine:	加工特点 Machining Characteristics:	
加工材料 Workpiece Mterial:	材料硬度 Hardness:	
加工参数 Machining Parameters:	冷却方式 Cooling Method:	
<b>3、刀具类型 Tool Type</b>		
<input type="checkbox"/> 新项目打样 Sample for new project	<input type="checkbox"/> 替代 / 优化现有竞品 Replacing/Optimizing Existing Competitors	
丝锥类型 Tap Type:	其 他 Others:	
期望刀具尺寸 Desired Tool Dimensions:	现用品牌 / 规格 Current Brand/Specification:	
		
TD*TP:	TCL:	THL:
DCON:	LSQ:	LF:
其他尺寸要求 Others:		
<b>4、备注 Note:</b>		

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

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

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

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

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

公制螺纹 Metric Threads				单位: mm Unit:mm
螺纹尺寸 Thread Size	标准直径 Standard Hole Dia.	2 级牙钻孔径 For JIS Class 2 Drill Hole Dia.		
		最大 MAX	最小 MIN	
M1	0.25	0.75	0.729	
M1.1	0.25	0.85	0.829	
M1.2	0.25	0.95	0.929	
M1.4	0.3	1.1	1.075	
M1.6	0.35	1.25	1.221	
M1.7	0.35	1.35	1.421	
M1.8	0.35	1.45	1.421	
M2	0.4	1.6	1.679	
M2.2	0.45	1.75	1.838	
M2.3	0.4	1.9	1.867	
M2.5	0.45	2.1	2.138	
M2.6	0.45	2.2	2.238	
M3	0.5	2.5	2.599	
M3.5	0.6	2.9	3.01	
M4	0.7	3.3	3.422	
M4.5	0.75	3.8	3.878	
M5	0.8	4.2	4.334	
M6	1	5	5.153	
M7	1	6	6.153	
M8	1.25	6.8	6.912	
M8	1	7	7.153	
M9	1.25	7.8	7.912	
M10	1.5	8.5	8.676	
M10	1.25	8.8	8.912	
M10	1	9	9.153	
M11	1.5	9.5	9.676	
M12	1.75	10.3	10.441	
M12	1.5	10.5	10.676	
M12	1.25	10.8	10.912	
M12	1	11	11.153	
M14	2	12	12.21	
M14	1.5	12.5	12.676	
M14	1	13	13.153	
M16	2	14	14.21	
M16	1.5	14.5	14.676	
M16	1	15	15.15	

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

公制螺纹 Metric Threads		单位: mm Unit:mm		
美制粗牙螺纹规格 Specification (UNC)	标准直径 Standard Hole Dia.	2 级牙钻孔径 For JIS Class 2 Drill Hole Dia.		
		最大 MAX	最小 MIN	
NO.1	-64	1.55	1.582	1.425
NO.2	-56	1.8	1.871	1.695
NO.3	-48	2.05	2.146	1.941
NO.4	-40	2.3	2.385	2.157
NO.5	-40	2.6	2.697	2.487
NO.6	-32	2.8	2.895	2.642
NO.8	-32	3.4	3.53	3.302
NO.10	-24	3.9	3.962	3.683
NO.12	-24	4.5	4.597	4.344
1/4	-20	5.1	5.257	4.979
5/16	-18	6.6	6.731	6.401
3/8	-16	8	8.153	7.798
7/16	-14	9.4	9.55	9.144
1/2	-13	10.9	11.023	10.592
9/16	-12	12.2	12.466	11.989
5/8	-11	13.6	13.868	13.386
美制细牙螺纹规格 Specification (UNF)	标准直径 Standard Hole Dia.	2 级牙钻孔径 For JIS Class 2 Drill Hole Dia.		
		最大 MAX	最小 MIN	
NO.0	-80	1.25	1.305	1.182
NO.1	-72	1.55	1.612	1.474
NO.2	-64	1.85	1.912	1.756
NO.3	-56	2.1	2.197	2.025
NO.4	-48	2.4	2.458	2.271
NO.5	-44	2.7	2.74	2.551
NO.6	-40	2.9	3.022	2.82
NO.8	-36	3.5	3.606	3.404
NO.10	-32	4.1	4.165	3.963
NO.12	-28	4.6	4.724	4.496
1/4	-28	5.5	5.588	5.36
5/16	-24	6.9	7.035	6.782
3/8	-24	8.5	8.636	8.382
7/16	-20	9.90	10.033	9.729
1/2	-20	11.5	11.607	11.329
9/16	-18	12.9	13.081	12.751
5/8	-18	14.5	14.681	14.351

### 工件材料表 Workpiece Material Table

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



## 切削定义及计算 Cutting Calculations and Definitions

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

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

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

N/mm2	HV10	HB	HRC	N/mm2	HV10	HB	HRC
240	75	71		920	287	273	28
255	80	76		940	293	278	29
270	85	81		970	302	287	30
285	90	86		995	310	295	31
305	95	90		1020	317	301	32
320	100	95		1050	327	311	33
335	105	100		1080	336	319	34
350	110	105		1110	345	328	35
370	115	109		1140	355	337	36
385	120	114		1170	364	346	37
400	125	119		1200	373	354	38
415	130	124		1230	382	363	39
430	135	128		1260	392	372	40
450	140	133		1260	403	383	41
465	145	138		1330	413	393	42
480	150	143		1360	423	402	43
495	155	147		1400	434	413	44
510	160	152		1440	446	424	45
530	165	157		1480	458	435	46
545	170	162		1530	473	449	47
560	175	166		1570	484	460	48
575	180	171		1620	497	472	49
595	185	176		1680	514	488	50
610	190	181		1730	527	501	51
625	195	185		1790	544	517	52
640	200	190		1845	560	632	53
660	205	195		1910	578	549	54
675	210	199		1980	596	567	55
690	215	204		2050	615	584	56
705	220	209		2140	639	607	57
720	225	214			655	622	58
740	230	219			675		59
755	235	223			698		60
770	240	228			720		61
785	245	233			745		62
800	250	238	22		773		63
820	255	242	23		800		64
835	260	247	24		829		65
860	268	255	25		864		66
870	272	258	26		900		67
900	280	266	27		940		68





+ 华东大区  
Eastern China Region

上海市青浦区华强街路三友星墅 203 弄272号 302 室  
Add: Room 302, No. 272, Lane 203, Sanyou Xingshu,  
Huaqiang Street Road, Qingpu District, Shanghai  
Tel: +86-0592-3706375

+ 华南大区  
Southern China Region

广东省东莞市长安镇上洋路霄边居民公寓8栋802  
Add: 802, Building 8, Xiaobian Resident Apartment, Chan  
gan Town, Dongguan City, Guangdong Province  
Tel: +86-0592-7310125

+ 西部大区  
West Region

四川省成都市龙泉驿区成都航空职业技术学院  
Add: Chengdu Aviation Vocational Technology College,  
Longquanyi District, Chengdu City, Sichuan Province  
Tel: +86-0592-7301561

+ 华北大区  
Northern China Region

天津市河东区海河东路与八经路交口以东八经路81号 中海钻石湾信和苑  
11号楼1门4204室  
Add: Room 4204, Gate 1, Building 11, xinheyuan, Diamond Bay,  
Hedong District, Tianjin  
Tel: +86-0592-7301126

+ 华中大区  
Central China Region

湖北省武汉经济技术开发区28R地块金色港湾4期26栋2号  
Add: No. 2, Building 26, Golden Harbor Phase 4, Block 28R, Wuhan  
Economic and Technological Development Zone, Hubei Province  
Tel: +86-0592-7310203

+ 东北大区  
Northeast Region

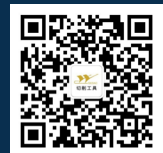
辽宁省沈阳市于洪区白山路151-5号11门  
Add: 11-151-5, Baishan Road, Yuhong District, Shenyang City, Liaoning  
Province  
Tel: +86-0529-7306375

**厦门金鹭特种合金有限公司**  
XIAMEN GOLDEN EGRET SPECIAL ALLOY CO.,LTD.

地址：中国厦门市湖里区兴隆路69号  
Add: No.69 Xinglong Road Huli District Xiamen CHINA  
工厂地址：中国厦门同安工业集中区集成路1601-1629号  
Factory Add: No.1601-1629 Jicheng Road Industrial  
Concentration Area Tongan Xiamen CHINA  
Tel: +86-0592-7301561 Fax: +86-0592-7107322  
PC: 361006 Email: GJ.GLB@CXTC.COM

[www.gesac.com.cn](http://www.gesac.com.cn)

 **400-998-6858**



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