



螺纹底孔直径表

RECOMMENDED DRILL HOLE SIZE

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1 挤压丝锥
FORMING TAP

公制 M/MF				公制 M/MF				美制 (粗) UNC				美制 (细) UNF			
METRIC THREAD				METRIC THREAD				UNIFIED COARSE THREAD				UNIFIED FINE THREAD			
规格size D × P mm mm	精度 Precision	底孔 Drill Ø		规格size D × P mm mm	精度 Precision	底孔 Drill Ø		规格size D × P/1" inch (tpi)	精度 Precision	底孔 Drill Ø		规格size D × P/1" inch (tpi)	精度 Precision	底孔 Drill Ø	
		最大 MAX	最小 MIN			最大 MAX	最小 MIN			最大 MAX	最小 MIN			最大 MAX	最小 MIN
M1.0×0.25	RH4	0.92	0.90	M8.0×1.25	RH7	7.41	7.34	N0.2-56	RH4	2.02	1.96	N0.2-64	RH3	2.04	1.98
M1.1×0.25	RH4	1.02	1.00	M8.0×1.0	RH7	7.57	7.48	N0.3-48	RH4	2.32	2.25	N0.3-56	RH4	2.35	2.29
M1.2×0.25	RH4	1.12	1.10	M10×1.50	RH7	9.28	9.18	N0.4-40	RH5	2.60	2.52	N0.4-48	RH4	2.64	2.57
M1.4×0.30	RH4	1.294	1.270	M10×1.25	RH7	9.41	9.34	N0.5-40	RH5	2.93	2.86	N0.5-44	RH4	2.95	2.88
M1.6×0.35	RH4	1.48	1.44	M10×1.0	RH7	9.57	9.48	N0.6-32	RH5	3.17	3.09	N0.6-40	RH5	3.26	3.19
M1.7×0.35	RH4	1.58	1.54	M12×1.75	RH8	11.15	11.05	N0.8-32	RH6	3.83	3.75	N0.8-36	RH5	3.88	3.80
M2.0×0.40	RH4	1.85	1.81	M12×1.5	RH7	11.28	11.18	N0.10-24	RH6	4.35	4.26	N0.10-32	RH5	4.48	4.41
M2.3×0.40	RH4	2.15	2.11	M12×1.25	RH7	11.41	11.34	N0.12-24	RH6	5.01	4.92	N0.12-28	RH5	5.08	5.00
M2.5×0.45	RH4	2.33	2.28	M12×1.0	RH7	11.57	11.48	1/4-20	RH6	5.76	5.66	1/4-28	RH5	5.93	5.86
M2.6×0.45	RH4	2.43	2.38	M14×2.0	RH10	13.04	12.92	5/16-18	RH7	7.29	7.18	5/16-24	RH6	7.46	7.38
M3.0×0.50	RH5	2.81	2.76	M14×1.5	RH9	13.30	13.21	3/8-16	RH7	8.78	8.66	3/8-24	RH6	9.05	8.96
M3.5×0.60	RH5	3.26	3.20	M16×2.0	RH10	15.04	14.92	7/16-14	RH7	10.25	10.11	7/16-20	RH7	10.54	10.44
M4.0×0.70	RH6	3.70	3.65	M16×1.5	RH9	15.30	15.21	1/2-13	RH8	11.78	11.62	1/2-20	RH7	12.12	12.02
M5.0×0.80	RH6	4.66	4.59	M18×2.5	RH11	16.78	16.63	9/16-12	RH10	13.27	13.14	9/16-18	RH9	13.66	13.55
M6.0×1.0	RH7	5.57	5.48	M18×1.5	RH10	17.31	17.22	5/8-11	RH11	14.76	14.62	5/8-18	RH9	15.25	15.14
M7.0×1.0	RH7	6.57	6.48	M20×2.5	RH11	18.78	18.63	3/4-10	RH12	17.88	17.67	3/4-16	RH10	18.32	18.22
				M20×1.5	RH10	19.31	19.22	7/8-9	RH12	20.85	20.68	7/8-14	RH11	21.38	21.27
								1-8	RH13	23.84	23.65	1-12	RH12	24.41	24.28

2 切削丝锥
CUTTING TAP

公制 (粗) M				公制 (细) MF				美制 (粗) UNC				美制 (细) UNF			
METRIC COARSE THREAD				METRIC FINE THREAD				UNIFIED COARSE THREAD				UNIFIED FINE THREAD			
规格size D × P mm mm	标准径 Standard hole Dia	2级牙钻孔径 For jis class 2 drill hole dia		规格size D × P mm mm	标准径 Standard hole Dia	2级牙钻孔径 For jis class 2 drill hole dia		规格size D × P/1" inch (tpi)	标准径 Standard hole Dia	2级牙钻孔径 For jis class 2 drill hole dia		规格size D × P/1" inch (tpi)	标准径 Standard hole Dia	2级牙钻孔径 For jis class 2 drill hole dia	
		最大 MAX	最小 MIN			最大 MAX	最小 MIN			最大 MAX	最小 MIN			最大 MAX	最小 MIN
M1.0x0.25	0.75	0.785	0.729	M1.0x0.2	0.80	0.821	0.783	N0.1-64	1.55	1.582	1.425	N0.0-80	1.25	1.305	1.182
M1.2x0.25	0.95	0.985	0.929	M1.2x0.2	1.00	1.021	0.983	N0.2-56	1.80	1.871	1.695	N0.1-72	1.55	1.612	1.474
M1.4x0.3	1.10	1.142	1.075	M1.4x0.2	1.20	1.221	1.183	N0.3-48	2.10	2.146	1.941	N0.2-64	1.85	1.912	1.756
M1.6x0.35	1.25	1.321	1.221	M1.6x0.2	1.40	1.421	1.383	N0.4-40	2.30	2.385	2.157	N0.3-56	2.10	2.197	2.025
M1.7x0.35	1.35	1.421	1.321	M1.7x0.2	1.5	1.521	1.483	N0.5-40	2.60	2.697	2.487	N0.4-48	2.40	2.458	2.271
M1.8x0.35	1.45	1.521	1.421	M1.8x0.2	1.60	1.621	1.583	N0.6-32	2.80	2.895	2.642	N0.5-44	2.70	2.740	2.551
M2.0x0.4	1.60	1.679	1.567	M2.0x0.25	1.75	1.785	1.729	N0.8-32	3.40	3.530	3.302	N0.6-40	2.90	3.022	2.820
M2.3x0.4	1.90	1.979	1.867	M2.3x0.25	2.05	2.061	2.001	N0.10-24	3.90	3.962	3.683	N0.8-36	3.50	3.606	3.404
M2.5x0.45	2.10	2.138	2.013	M2.5x0.35	2.20	2.221	2.121	N0.12-24	4.50	4.597	4.344	N0.10-32	4.10	4.165	3.963
M2.6x0.45	2.20	2.238	2.113	M2.6x0.35	2.20	2.246	2.186	1/4-20	5.10	5.257	4.979	N0.12-28	4.60	4.724	4.496
M3.0x0.5	2.50	2.599	2.459	M3.0x0.35	2.70	2.721	2.621	5/16-18	6.60	6.731	6.401	1/4-28	5.50	5.588	5.360
M3.5x0.6	2.90	3.010	2.850	M3.5x0.35	3.20	3.221	3.121	3/8-16	8.00	8.153	7.798	5/16-24	6.90	7.035	6.782
M4.0x0.7	3.30	3.422	3.242	M4.0x0.5	3.50	3.599	3.459	7/16-14	9.40	9.550	9.144	3/8-24	8.50	8.636	8.382
M4.5x0.75	3.80	3.878	3.688	M5.0x0.5	4.50	4.599	4.459	1/2-13	10.90	11.023	10.592	7/16-20	9.90	10.033	9.729
M5.0x0.8	4.20	4.334	4.134	M6.0x0.75	5.30	5.378	5.188	9/16-12	12.20	12.466	11.989	1/2-20	11.50	11.607	11.329
M6.0x1.0	5.00	5.153	4.917	M8.0x1.0	7.00	7.153	6.917	5/8-11	13.60	13.868	13.386	9/16-18	12.90	13.081	12.751
M7.0x1.0	6.00	6.153	5.917	M10x1.25	8.80	8.912	8.647	3/4-10	16.60	16.840	16.307	5/8-18	14.50	14.681	14.351
M8.0x1.25	6.80	6.912	6.647	M10x1.0	9.00	9.153	8.917					3/4-16	17.50	17.678	17.323
M10x1.5	8.50	8.676	8.376	M12x1.5	10.50	10.676	10.376								
M12x1.75	10.30	10.441	10.106	M12x1.25	10.80	10.912	10.647								
M14x2.0	12.00	12.210	11.835	M12x1.0	11.00	11.153	10.917								
M16x2.0	14.00	14.210	13.835	M14x1.5	12.50	12.676	12.376								
M18x2.5	15.50	15.744	15.294	M16x1.5	14.50	14.676	14.376								
M20x2.5	17.50	17.744	17.294	M18x2.0	16.00	16.210	15.835								
				M20x2.5	18.00	18.210	17.835								

3 圆柱管螺纹 G
CYLINDRICAL PIPE THREADS

4 锥管螺纹
TAPERED PIPE THREADS
备注: 锥度1:16

规格size D	外径	底孔 Drill Ø	
		最小 MIN	最大 MAX
G 1/16	7.723	6.561	6.843
1/8	9.728	8.566	8.848
1/4	13.157	11.445	11.89
3/8	16.662	14.95	15.395
1/2	20.955	18.631	19.172
3/4	26.441	24.117	24.658
1	33.249	30.291	30.931
1 1/4	41.91	38.952	39.592
1 1/2	47.803	44.845	45.485
2	59.614	56.656	57.296

英制惠氏螺线				BSPT	
BRITISH STANDARD PIPE THREAD					
规格size D inch	外径	锥管内螺线Rc(PT)		平行内螺线Rp(PS)	
		计算值	底孔直径 Drill Ø	计算值	底孔直径 Drill Ø
1/16	7.723	6.23	6.2	6.49	6.5
1/8	9.728	8.235	8.2	8.495	8.5
1/4	13.157	10.941	10.9	11.341	11.4
3/8	16.662	14.428	14.4	14.846	14.9
1/2	20.955	17.95	18	18.489	18.5
3/4	26.441	23.349	23	23.975	24
1	33.249	29.423	29	30.111	30
1 1/4	41.91	37.94	38	38.772	39
1 1/2	47.803	43.833	44	44.565	45
2	59.614	55.412	55	56.476	56

美标锥管螺线				NPT			
AMERICAN TAPERED PIPE THREAD							
规格size D inch	外径	锥管螺线Rc				平行螺线Rp	
		钻头直径Drill Ø				钻头直径 Drill Ø	
		使用铰刀时		不使用铰刀时			
1/16	7.77	-	5.94	-	6.15	-	6.35
1/8	10.117	21/64	8.33	-	8.43	-	8.74
1/4	13.426	27/64	10.72	7/16	11.13	7/16	11.13
3/8	16.866	9/16	14.27	9/16	14.27	4/4820	14.68
1/2	20.98	11/16	17.48	45/64	17.86	23/32	18.26
3/4	26.325	57/64	22.63	29/32	23.01	59/64	23.42
1	32.934	1-1/8	28.58	1-9/64	28.98	1-5/32	29.36
1 1/4	41.689	1-15/32	37.31	1-31/64	37.69	1-1/2	38.1
1 1/2	47.76	1-45/64	43.26	1-23/32	43.66	1-3/4	44.45
2	59.797	2-11/64	55.17	2-3/16	55.58	2-7/32	56.36

5 护套切削丝锥
STI CUTTING TAPS

6 护套挤压丝锥
STI FORMING TAPS

7 航天工业螺线 UNJC/UNJF
THREADS FOR THE AEROSPACE INDUSTRY

公制螺线				M(STI)		美制螺线				U(STI)		公制螺线				M(STI)		规格 Specification	推荐底孔径 Recommend Drill Hole Dia	3B级用 3B drill hole dia	
规格size D × P mm mm	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.	规格size D × P/1" inch (tpi)	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.	规格size D × P mm mm	精度 Precision	最小~最大(嵌合率%) Min.-Max (Threads Overlap Rveto:%)	规格size D × P mm mm	精度 Precision	最小~最大(嵌合率%) Min.-Max (Threads Overlap Rveto:%)	最大 MAX	最小 MIN						
	最小 MIN	最大 MAX			最小 MIN	最大 MAX															
ST M2.5×0.45	2.6	2.69	2.65	ST NO.2-56UNC	2.29	2.44	2.35	ST M2×0.4	RH2	2.31~2.33(100-80)	M2.5×0.45	RH2	2.84~2.87(100-80)	NO.6-32UNJC	2.84	2.74	2.93				
M2.6×0.45	2.7	2.79	2.75	NO.3-48UNC	2.64	2.83	2.75	M2.5×0.45	RH2	2.84~2.87(100-80)	6-40UNJF	2.97	2.89	3.05							
M3×0.5	3.12	3.2	3.15	NO.4-40UNC	2.99	3.18	3.10	M2.6×0.45	RH2	2.94~2.97(100-80)	8-32UNJC	3.5	3.4	3.59							
M4×0.7	4.17	4.3	4.25	NO.5-40UNC	3.31	3.52	3.40	M3×0.5	RH3	3.39~3.43(100-80)	8-36UNJF	3.57	3.48	3.66							
M5×0.8	5.18	5.33	5.25	NO.6-32UNC	3.68	3.87	3.75	M4×0.7	RH4	4.54~4.58(100-85)	10-24UNJC	3.93	3.8	4.06							
M6×1	6.22	6.4	6.3	NO.8-32UNC	4.33	4.52	4.45	M5×0.8	RH4	5.61~5.66(100-85)	10-32UNJF	4.16	4.06	4.25							
M8×1.25	8.28	8.48	8.4	NO.10-24UNC	5.60	5.25	5.20	M6×1	RH4	6.75~6.81(100-85)	1/4-20UNJC	5.25	5.12	5.38							
M10×1.5	10.33	10.56	10.45	NO.12-24UNC	5.72	5.92	5.80	M8×1.25	RH5	8.93~9.01(100-85)	1/4-28UNJF	5.57	5.47	5.66							
M12×1.75	12.38	12.64	12.5	1/4-20UNC	6.63	6.86	6.75	M10×1.5	RH5	11.11~11.17(100-90)	5/16-18UNJC	6.7	6.57	6.83							
M14×2	14.44	14.73	14.6	5/16-18UNC	8.33	8.48	8.40	M10×1.25	RH5	10.93~11.01(100-85)	5/16-24UNJF	7.01	6.91	7.1							
M16×2	16.44	16.73	16.66	3/8-16UNC	9.87	10.12	10.00	M12×1.75	RH5	13.28~13.35(100-90)	3/8-16UNJC	8.12	7.98	8.25							
M10×1	10.25	10.4	10.3	NO.4-48UNF	2.97	3.15	3.05	M12×1.5	RH5	13.11~13.17(100-90)	3/8-24UNJF	8.59	8.5	8.67							
M10×1.25	10.31	10.48	10.4	NO.6-40UNF	3.66	3.81	3.75	M12×1.25	RH4	12.93~13.01(100-85)	7/16-14UNJC	9.49	9.35	9.63							
M12×1.25	12.28	12.48	12.4	NO.8-36UNF	4.33	4.49	4.40				7/16-20UNJF	9.98	9.88	10.08							
M12×1.5	12.33	12.56	12.5	NO.10-32UNF	5.00	4.18	5.10				1/2-13UNJC	10.95	10.8	11.09							
M14×1.5	14.33	14.56	14.5	1/4-28UNF	6.55	6.72	6.65				1/2-20UNJF	11.57	11.47	11.66							
M16×1.5	16.33	16.56	16.5	5/16-24UNF	8.2	8.35	8.25														
				3/8-24UNF	9.78	9.96	9.85														