



# 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。

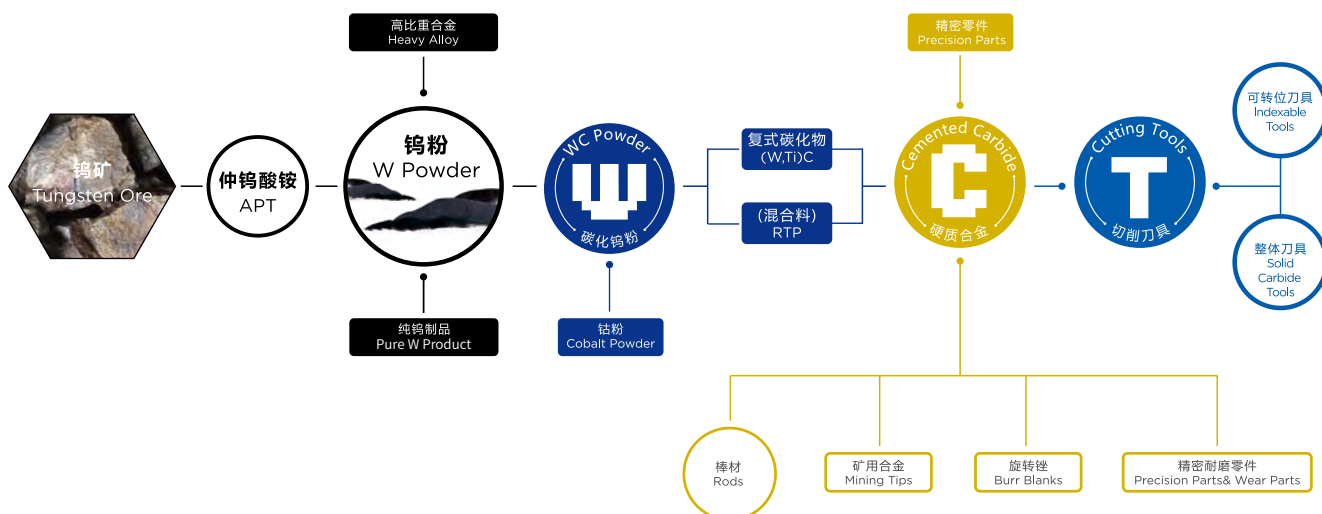
凭借完整钨产业链的产品集成技术研发，以及务实、创新的管理理念，厦门金鹭始终保持着强劲的发展势头，为全球用户提供最高性价比的钨粉末产品和服务，为现代工业领域解决高硬度、耐高温、耐磨损问题，提供了优良的产品和完善的解决方案，客户遍布全球四十多个工业发达国家和地区，享誉海内外。

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”.





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# 丝锥选用指南

## Taps Selection Guide




















## 丝锥系列目录 Contents of Tap Series

| 产品系列<br>Tap Series | 内部型号<br>Tool Type | 刀具名称及外形<br>Description and Profile  | 尺寸标准<br>Dimension Standard | 涂层/牌号<br>Coating/Grade | 适合加工孔类型<br>Suitable Hole Types   | 推荐加工深度<br>Drilling Depth L/D | 冷却形式<br>Coolant Type  | 尺寸范围<br>Dimension Range | 丝锥精度等级<br>Accuracy Class | 尺寸表页码<br>Dimension Table Page | 切削参数<br>Cutting Parameters |
|--------------------|-------------------|---|----------------------------|------------------------|--|------------------------------|---|-------------------------|--------------------------|-------------------------------|----------------------------|
| T118               | T118-FDN          | 高性能 通用加工挤压丝锥<br>High performance fluteless tap  | D371/<br>D376              | TiAl-C                 |       | ≤2.5D                        |    | M4-<br>M30              | 6HX                      | P14-17                        | P27                        |
|                    | T118-FDC          | 高性能 内冷通用加工挤压丝锥<br>High-performance internal coolant fluteless tap                           | D371/<br>D376              | TiAl-C                 |       | ≤2.5D                        |    | M4-<br>M30              | 6HX                      | P18-19                        | P27                        |
|                    | T118-FDR          | 高性能 内冷通用加工挤压丝锥<br>High-performance internal coolant fluteless tap                           | D371/<br>D376              | TiAl-C                 |       | ≤2.5D                        |    | M4-<br>M30              | 6HX                      | P20-21                        | P27                        |
|                    | T118-SDN          | 高性能 通用加工螺旋丝锥<br>High-performance spiral fluted tap  | D371/<br>D376              | TiAl-C                 |     | ≤2.5D                        |   | M4-<br>M16              | 6HX                      | P22                           | P27                        |
|                    | T118-PDN          | 高性能 通用加工刃倾角丝锥<br>High-performance spiral pointed tap  | D371/<br>D376              | TiAl-C                 |   | ≤2.5D                        |  | M4-<br>M16              | 6HX                      | P23                           | P27                        |
| T128               | T128-HDN          | 高性能 铸铁加工直槽丝锥<br>High-performance cast iron machining straight fluted tap                    | D371/<br>D376              | TiAl-Si                |   | ≤2.5D                        |  | M5-<br>M16              | 6HX                      | P24                           | P27                        |
|                    | T128-HDC          | 高性能 内冷铸铁加工直槽丝锥<br>High-performance internal coolant cast iron machining straight fluted tap | D371/<br>D376              | TiAl-Si                |   | ≤2.5D                        |  | M5-<br>M16              | 6HX                      | P25                           | P27                        |
|                    | T128-HDR          | 高性能 内冷铸铁加工直槽丝锥<br>High-performance internal coolant cast iron machining straight fluted tap | D371/<br>D376              | TiAl-Si                |   | ≤2.5D                        |  | M5-<br>M16              | 6HX                      | P26                           | P27                        |
| ET138              | ET138-FJN         | 经济型 钢用加工挤压丝锥<br>Economy steel machining fluteless tap                                       | JIS                        | AlCrN                  |   | ≤2.5D                        |  | M1-<br>M16              | RH4-<br>10               | P29-32                        | P62                        |
|                    | ET138-SJN         | 经济型 钢用加工螺旋丝锥<br>Economy steel machining spiral fluted tap                                   | JIS                        | AlCrN                  |   | ≤2.5D                        |  | M1-<br>M16              | P1-5                     | P33-35                        | P62                        |
|                    | ET138-PJN         | 经济型 钢用加工刃倾角丝锥<br>Economy steel machining spiral pointed tap                                 | JIS                        | AlCrN                  |   | ≤2.5D                        |  | M1-<br>M16              | P1-5                     | P36-38                        | P62                        |
| ET168              | ET168-FJN         | 经济型 不锈钢加工挤压丝锥<br>Economy stainless steel machining fluteless tap                            | JIS                        | TiAlN                  |   | ≤2.5D                        |  | M1-<br>M16              | RH4-<br>10               | P39-42                        | P62                        |
|                    | ET168-SJN         | 经济型 不锈钢加工螺旋丝锥<br>Economy stainless steel machining spiral fluted tap                        | JIS                        | TiAlN                  |   | ≤2.5D                        |  | M1-<br>M16              | P1-5                     | P43-45                        | P62                        |
|                    | ET168-PJN         | 经济型 不锈钢加工刃倾角丝锥<br>Economy stainless steel machining spiral pointed tap                      | JIS                        | TiAlN                  |   | ≤2.5D                        |  | M1-<br>M16              | P1-5                     | P46-48                        | P62                        |

🕒 最适合 Most Suitable    ⦿ 适合 Suitabel

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

## 丝锥系列目录 Contents of Tap Series

| 产品系列<br>Tap Series | 内部型号<br>Tool Type | 刀具名称及外形<br>Description and Profile  | 尺寸标准<br>Dimension Standard | 涂层/牌号<br>Coating/Grade | 适合加工孔类型<br>Suitable Hole Types   | 推荐加工深度<br>Drilling Depth L/D | 冷却形式<br>Coolant Type  | 尺寸范围<br>Dimension Range | 丝锥精度等级<br>Accuracy Class | 尺寸表页码<br>Dimension Table Page | 切削参数<br>Cutting Parameters |
|--------------------|-------------------|---|----------------------------|------------------------|--|------------------------------|---|-------------------------|--------------------------|-------------------------------|----------------------------|
| ET166              | ET166-FJN         | 经济型 铜铝加工挤压丝锥<br>Economy copper & aluminum machining fluteless tap                       | JIS                        | DLC                    |       | ≤2.5D                        |    | M1-M16                  | RH4-10                   | P49-52                        | P62                        |
|                    | ET166-SJN         | 经济型 铜铝加工螺旋丝锥<br>Economy copper & aluminum machining spiral fluted tap                   | JIS                        | DLC                    |       | ≤2.5D                        |    | M1-M16                  | P1-5                     | P53-55                        | P62                        |
|                    | ET166-PJN         | 经济型 铜铝加工刃倾角丝锥<br>Economy copper & aluminum machining spiral pointed tap                 | JIS                        | DLC                    |   | ≤2.5D                        |    | M1-M16                  | P1-5                     | P56-58                        | P62                        |
| ET128              | ET128-HJN         | 经济型 铸铁加工直槽丝锥<br>Economy cast iron machining straight fluted tap                         | JIS                        | TiAl-Si                |     | ≤2.5D                        |   | M5-M16                  | P3-6                     | P59                           | P62                        |
|                    | ET128-HJC         | 经济型 内冷铸铁加工直槽丝锥<br>Economy internal coolant cast iron machining straight fluted tap      | JIS                        | TiAl-Si                |   | ≤2.5D                        |  | M5-M16                  | P3-6                     | P60                           | P62                        |
|                    | ET128-HJR         | 经济型 内冷铸铁加工直槽丝锥<br>Economy internal coolant cast iron machining hand straight fluted tap | JIS                        | TiAl-Si                |   | ≤2.5D                        |  | M5-M16                  | P3-6                     | P61                           | P62                        |

● 最适合 Most Suitable    ○ 适合 Suitable



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

## 名词解释 Glossary

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

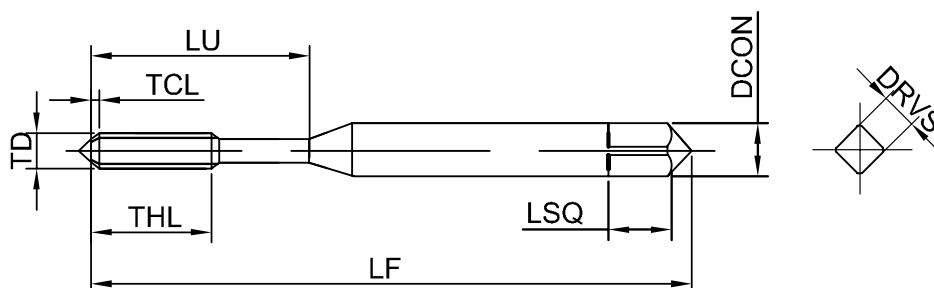
|                                  | 图标<br>Sign   | 含义<br>Note                                    |
|----------------------------------|--|---|
| 涂层类型<br>Coating                  |   | 铬铝涂层<br>Chrome Aluminum                       |
|                                  |   | DLC涂层<br>Diamond-Like Carbon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

# 名词解释

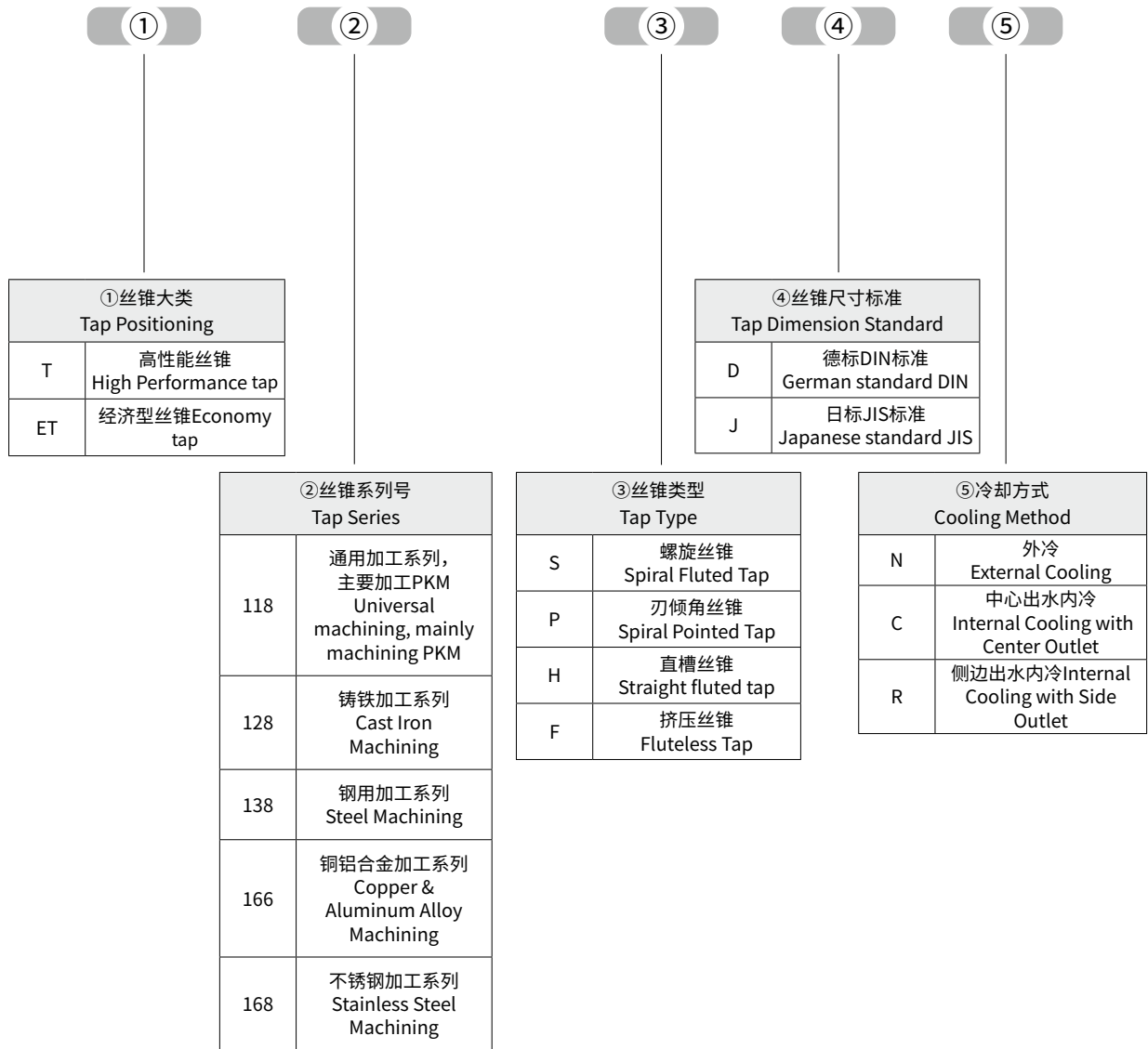
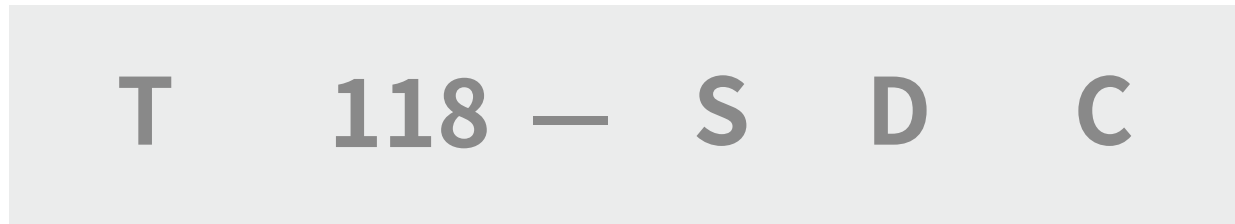
## Glossary

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

标准：采用ISO 13399  
Standard: ISO 13399



# 金鹭丝锥内部型号 Tap Identification System



# 030 050 C — 6HX

| ⑥ 螺纹直径<br>Thread Diameter |  | ⑦ 螺距 (公制) Pitch (metric)/<br>每英寸牙数 (英制)<br>Threads per Inch (Unified) |  | ⑨ 丝锥精度等级<br>Thread Tolerance class |                                       |
|---------------------------|--|---|--|------------------------------------|---------------------------------------|
| 030                       | 公制丝锥直径M3 mm<br>Metric Thread Dia.M3 mm | 030   | 公制丝锥螺距0.5 mm<br>Metric Pitch 0.5mm         | 6HX                                | 丝锥精度等级<br>Thread Tolerance class 6HX  |
| U0                        | 美制No.0<br>Unified Thread No.0          | 12  | 美制螺纹每英寸12个牙<br>Unified 12 Threads per Inch | P2                                 | 丝锥精度等级<br>Thread Tolerance class P2   |
| U916                      | 美制9/16英寸<br>Unified Thread 9/16 Inch   |   |  | RH10                               | 丝锥精度等级<br>Thread Tolerance class RH10 |

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

## 丝锥产品应用一览表

### Overview of tap applications

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

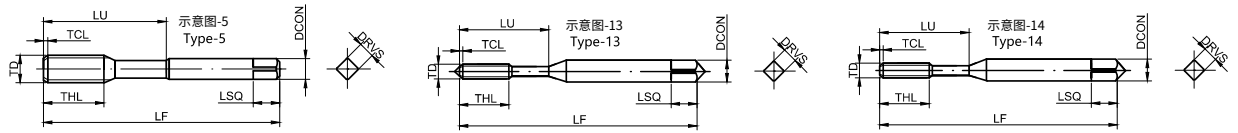
A

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

## 工件材料 Workpiece Material

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

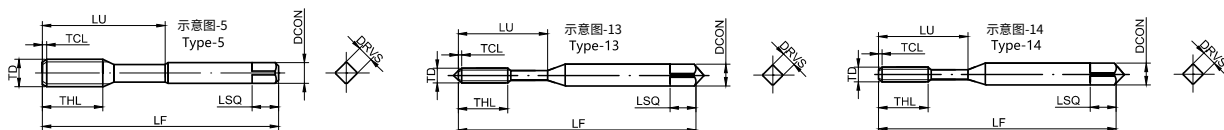
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

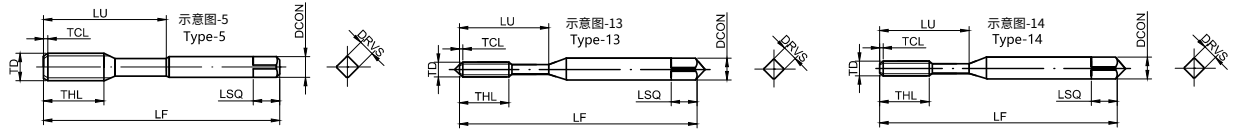
| P                                     |                                      |  | M                      | K   |                               |   | N                              |                      |                           | S                                   | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 12  | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD | TP  | TCTR | TCL  | THCHT | Type | LF  | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>Stocks |
|----------------------|----------------------|----|-----|------|------|-------|------|-----|-----|----|------|------|-----|---------|------|-----|-------|--------------|
| T118-FDN-180200D-6HX | M18×2                | 18 | 2   | 6HX  | 4P   | D     | 5    | 125 | 25  | 61 | 14   | 11   | 14  | 14×11   | 45.0 | 12  | 16.99 | ○            |
| T118-FDN-180200C-6HX | M18×2                | 18 | 2   | 6HX  | 2.5P | C     | 5    | 125 | 25  | 61 | 14   | 11   | 14  | 14×11   | 45.0 | 12  | 16.99 | ○            |
| T118-FDN-180150D-6HX | M18×1.5              | 18 | 1.5 | 6HX  | 4P   | D     | 5    | 125 | 25  | 61 | 14   | 11   | 14  | 14×11   | 45.0 | 12  | 17.26 | ○            |
| T118-FDN-180150C-6HX | M18×1.5              | 18 | 1.5 | 6HX  | 2.5P | C     | 5    | 125 | 25  | 61 | 14   | 11   | 14  | 14×11   | 45.0 | 12  | 17.26 | ○            |
| T118-FDN-200250D-6HX | M20×2.5              | 20 | 2.5 | 6HX  | 4P   | D     | 5    | 140 | 25  | 69 | 16   | 12   | 15  | 16×12   | 50.0 | 12  | 18.72 | ○            |
| T118-FDN-200250C-6HX | M20×2.5              | 20 | 2.5 | 6HX  | 2.5P | C     | 5    | 140 | 25  | 69 | 16   | 12   | 15  | 16×12   | 50.0 | 12  | 18.72 | ○            |
| T118-FDN-200200D-6HX | M20×2                | 20 | 2   | 6HX  | 4P   | D     | 5    | 140 | 25  | 69 | 16   | 12   | 15  | 16×12   | 50.0 | 12  | 18.99 | ○            |
| T118-FDN-200200C-6HX | M20×2                | 20 | 2   | 6HX  | 2.5P | C     | 5    | 140 | 25  | 69 | 16   | 12   | 15  | 16×12   | 50.0 | 12  | 18.99 | ○            |
| T118-FDN-200150D-6HX | M20×1.5              | 20 | 1.5 | 6HX  | 4P   | D     | 5    | 140 | 25  | 69 | 16   | 12   | 15  | 16×12   | 50.0 | 12  | 19.26 | ○            |
| T118-FDN-200150C-6HX | M20×1.5              | 20 | 1.5 | 6HX  | 2.5P | C     | 5    | 140 | 25  | 69 | 16   | 12   | 15  | 16×12   | 50.0 | 12  | 19.26 | ○            |
| T118-FDN-220250D-6HX | M22×2.5              | 22 | 2.5 | 6HX  | 4P   | D     | 5    | 140 | 25  | 69 | 18   | 14.5 | 17  | 18×14.5 | 55.0 | 12  | 20.72 | ○            |
| T118-FDN-220250C-6HX | M22×2.5              | 22 | 2.5 | 6HX  | 2.5P | C     | 5    | 140 | 25  | 69 | 18   | 14.5 | 17  | 18×14.5 | 55.0 | 12  | 20.72 | ○            |
| T118-FDN-220200D-6HX | M22×2                | 22 | 2   | 6HX  | 4P   | D     | 5    | 140 | 25  | 69 | 18   | 14.5 | 17  | 18×14.5 | 55.0 | 12  | 20.99 | ○            |
| T118-FDN-220200C-6HX | M22×2                | 22 | 2   | 6HX  | 2.5P | C     | 5    | 140 | 25  | 69 | 18   | 14.5 | 17  | 18×14.5 | 55.0 | 12  | 20.99 | ○            |
| T118-FDN-220150D-6HX | M22×1.5              | 22 | 1.5 | 6HX  | 4P   | D     | 5    | 140 | 25  | 69 | 18   | 14.5 | 17  | 18×14.5 | 55.0 | 12  | 21.26 | ○            |
| T118-FDN-220150C-6HX | M22×1.5              | 22 | 1.5 | 6HX  | 2.5P | C     | 5    | 140 | 25  | 69 | 18   | 14.5 | 17  | 18×14.5 | 55.0 | 12  | 21.26 | ○            |
| T118-FDN-240300D-6HX | M24×3                | 24 | 3   | 6HX  | 4P   | D     | 5    | 160 | 30  | 78 | 18   | 14.5 | 17  | 18×14.5 | 60.0 | 12  | 22.45 | ○            |
| T118-FDN-240300C-6HX | M24×3                | 24 | 3   | 6HX  | 2.5P | C     | 5    | 160 | 30  | 78 | 18   | 14.5 | 17  | 18×14.5 | 60.0 | 12  | 22.45 | ○            |
| T118-FDN-240250D-6HX | M24×2.5              | 24 | 2.5 | 6HX  | 4P   | D     | 5    | 160 | 30  | 78 | 18   | 14.5 | 17  | 18×14.5 | 60.0 | 12  | 22.72 | ○            |
| T118-FDN-240250C-6HX | M24×2.5              | 24 | 2.5 | 6HX  | 2.5P | C     | 5    | 160 | 30  | 78 | 18   | 14.5 | 17  | 18×14.5 | 60.0 | 12  | 22.72 | ○            |
| T118-FDN-240200D-6HX | M24×2                | 24 | 2   | 6HX  | 4P   | D     | 5    | 160 | 30  | 78 | 18   | 14.5 | 17  | 18×14.5 | 60.0 | 12  | 22.99 | ○            |
| T118-FDN-240200C-6HX | M24×2                | 24 | 2   | 6HX  | 2.5P | C     | 5    | 160 | 30  | 78 | 18   | 14.5 | 17  | 18×14.5 | 60.0 | 12  | 22.99 | ○            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

### 工件材料 Workpiece Material

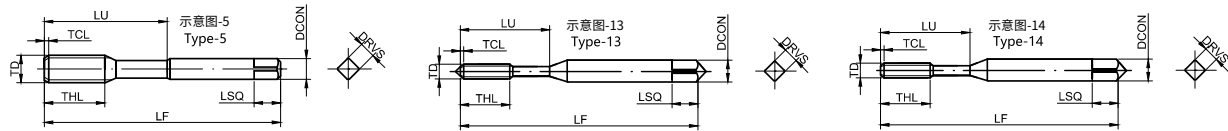
| P                                     |                                      |  | M                      | K   |                               | N   |                                |                      | S                         | H                                   |                        |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 1 2   | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD | TP  | TCTR | TCL  | THCHT | Type | LF  | THL | LU | DCON | DRVS | LSQ | CZCMS | TDRM | NOF | PHD   | 库存<br>Stocks |
|----------------------|----------------------|----|-----|------|------|-------|------|-----|-----|----|------|------|-----|-------|------|-----|-------|--------------|
| T118-FDN-270300D-6HX | M27×3                | 27 | 3   | 6HX  | 4P   | D     | 5    | 160 | 30  | 78 | 20   | 16   | 19  | 20×16 | 67.5 | 12  | 25.45 | ○            |
| T118-FDN-270300C-6HX | M27×3                | 27 | 3   | 6HX  | 2.5P | C     | 5    | 160 | 30  | 78 | 20   | 16   | 19  | 20×16 | 67.5 | 12  | 25.45 | ○            |
| T118-FDN-270250D-6HX | M27×2.5              | 27 | 2.5 | 6HX  | 4P   | D     | 5    | 160 | 30  | 78 | 20   | 16   | 19  | 20×16 | 67.5 | 12  | 25.72 | ○            |
| T118-FDN-270250C-6HX | M27×2.5              | 27 | 2.5 | 6HX  | 2.5P | C     | 5    | 160 | 30  | 78 | 20   | 16   | 19  | 20×16 | 67.5 | 12  | 25.72 | ○            |
| T118-FDN-270200D-6HX | M27×2                | 27 | 2   | 6HX  | 4P   | D     | 5    | 160 | 30  | 78 | 20   | 16   | 19  | 20×16 | 67.5 | 12  | 25.99 | ○            |
| T118-FDN-270200C-6HX | M27×2                | 27 | 2   | 6HX  | 2.5P | C     | 5    | 160 | 30  | 78 | 20   | 16   | 19  | 20×16 | 67.5 | 12  | 25.99 | ○            |
| T118-FDN-300350D-6HX | M30×3.5              | 30 | 3.5 | 6HX  | 4P   | D     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.18 | ○            |
| T118-FDN-300350C-6HX | M30×3.5              | 30 | 3.5 | 6HX  | 2.5P | C     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.18 | ○            |
| T118-FDN-300300D-6HX | M30×3                | 30 | 3   | 6HX  | 4P   | D     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.45 | ○            |
| T118-FDN-300300C-6HX | M30×3                | 30 | 3   | 6HX  | 2.5P | C     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.45 | ○            |
| T118-FDN-300250D-6HX | M30×2.5              | 30 | 2.5 | 6HX  | 4P   | D     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.72 | ○            |
| T118-FDN-300250C-6HX | M30×2.5              | 30 | 2.5 | 6HX  | 2.5P | C     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.72 | ○            |
| T118-FDN-300200D-6HX | M30×2                | 30 | 2   | 6HX  | 4P   | D     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.99 | ○            |
| T118-FDN-300200C-6HX | M30×2                | 30 | 2   | 6HX  | 2.5P | C     | 5    | 180 | 35  | 88 | 22   | 18   | 21  | 22×18 | 75.0 | 12  | 28.99 | ○            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

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

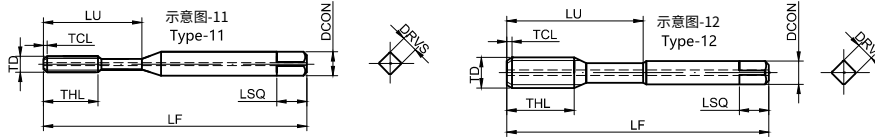
推荐切削参数 ※P27  
Recommended Cutting Data ※P27

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm

[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.

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

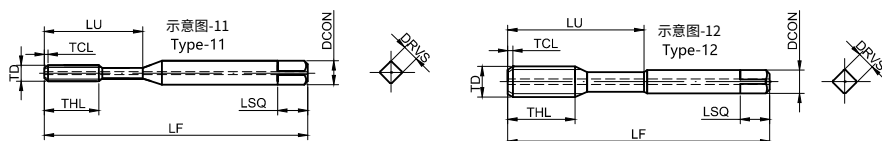
○ 最适合 Most Suitable ○ 适合 Suitabel

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

# T118-FDC

高性能内冷通用加工挤压丝锥

High-performance internal coolant general machining fluteless tap



» 续前 Continue

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

● 标准库存Stock ○ 需预定Available upon Order

单位:mm

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

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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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

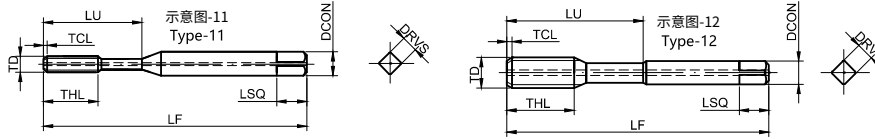
推荐切削参数 ※P27  
Recommended Cutting Data ※P27

# T118-FDR



高性能内冷通用加工挤压丝锥

High-performance internal coolant general machining fluteless tap



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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm

[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.

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

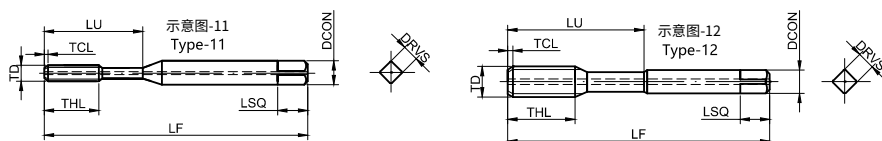
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存Stock ○ 需预定Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

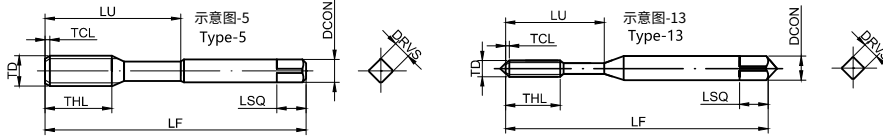
| P                                     |                                      |  | M                      | K   |                               | N   |                                |                      | S                         | H                                   |                        |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 1 2   | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD | TP   | TCTR     | TCL | THCHT | Type | LF | THL | LU  | DCON | DRVS | LSQ     | CZCMS | TDRM | NOF   | PHD | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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

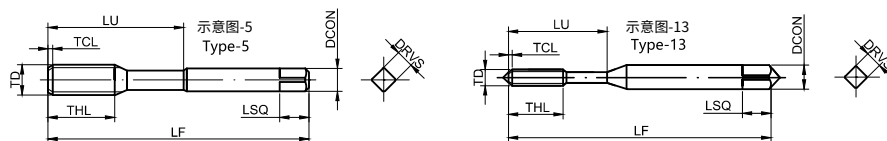
推荐切削参数 ※P27  
Recommended Cutting Data ※P27



# T118-PDN

高性能 通用加工刃倾角丝锥

High-performance general machining spiral pointed tap



| 订货号<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD | TP   | TCTR | TCL | THCHT | Type | LF  | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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

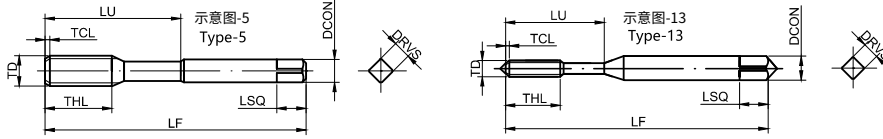
| 工件材料 Workpiece Material               |                                      |  |                        |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD | TP   | TCTR | TCL  | THCHT | Type | LF  | THL | LU | DCON | DRVS | LSQ | CZCMS | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
|                                       |                                      |  |                        | ◎   | ○                             |   |                                |                      |                           |                                     |                        |                        |                        |

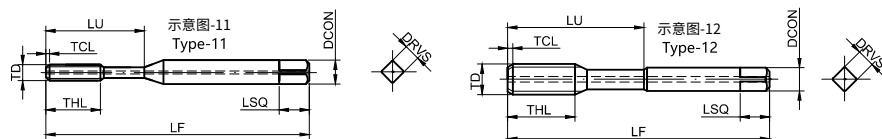
◎ 最适合 Most Suitable ○ 适合 Suitabel

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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD | TP   | TCTR | TCL  | THCHT | Type | LF  | THL | LU | DCON | DRVS | LSQ | CZCMS | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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

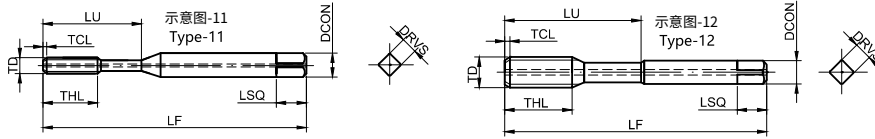
推荐切削参数 ※P27  
Recommended Cutting Data ※P27

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

● 标准库存Stock ○ 需预定Available upon Order

单位:mm

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

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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Workpiece Material |   | T118-FDN                  | T118-FDC<br>T118-FDR      | T118-SDN               | T118-PDN | T128-HDN | T128-HDC<br>T128-HDR      |
|----------------------------|---|---------------------------|---------------------------|------------------------|----------|----------|---------------------------|
|                            |   | 外冷<br>External<br>Cooling | 内冷<br>Internal<br>Coolant | 外冷<br>External Cooling |          |          | 内冷<br>Internal<br>Coolant |
| P                          | 低碳钢<br>Low carbon steel<br>(<125HB)   | 10-25                     | 15-30                     | 15-25                  | 15-25    |          |                           |
|                            | 高碳钢及合金钢<br>High carbon steel and alloy<br>steel<br>(<35HRC)                       | 8-20                      | 15-25                     | 10-20                  | 10-20    |          |                           |
|                            | 调质钢和工具钢<br>(35-48HRC)<br>Quenched and tempered<br>steel and tool steel            | 5-12                      | 5-15                      | 5-15                   | 5-15     |          | 5-20                      |
| M                          | 奥氏体不锈钢<br>(35-48HRC)<br>Austenitic stainless steel<br>(130-200HB)<br>(130-200HB)  | 10-25                     | 15-30                     | 10-25                  | 10-25    |          |                           |
|                            | 高强度的奥氏体和铸造不锈钢<br>High-strength austenitic and<br>cast stainless steel<br>(<25HRC) | 8-20                      | 15-25                     | 10-25                  | 10-25    |          |                           |
|                            | 双相不锈钢<br>Duplex stainless steel<br>(<30HRC)                                       | 5-12                      | 5-15                      | 5-12                   | 5-12     |          |                           |
| K                          | 灰铸铁和球墨铸铁<br>Gray cast iron and ductile<br>iron<br>(<32HRC)                        |                           |                           | 10-20                  | 10-20    | 20-40    | 30-50                     |
|                            | 高合金铸铁<br>Gray cast iron and ductile<br>iron<br>(<43HRC)                           |                           |                           | 5-15                   | 5-15     | 10-25    | 15-35                     |
| N                          | 锻造铝合金和<br>铸造铝合金<br>Forged aluminum alloy and<br>cast aluminum alloy<br>(Si<12%)   | 20-50                     | 30-60                     | 20-50                  | 20-50    |          |                           |
|                            | 铸造铝合金<br>Cast aluminum alloy<br>(Si>12%)  |                           |                           | 10-35                  | 10-35    |          |                           |
|                            | 铜合金<br>Copper alloy<br>(<HB200)   | 20-50                     | 30-60                     | 20-50                  | 20-50    |          |                           |

## 【注意Note】

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

单位:m/min  
unit:m/min

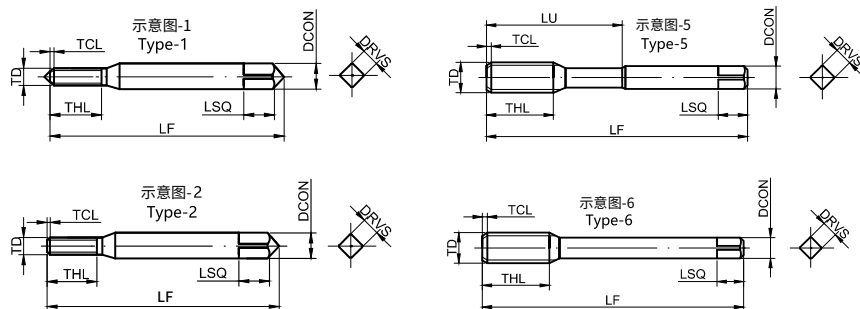
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经济型丝锥  
Economy Taps



# ET138-FJN

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



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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

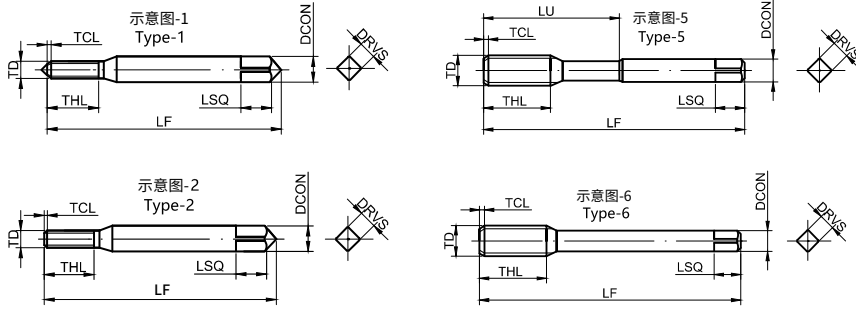
| P                                     |                                      |  | M                      | K   |                               |   | N                              |                      |                           | S                                   | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 1 2   | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code   | 螺纹尺寸<br>Nominal Size | TD  | TP   | TCTR | TCL | THCHT | Type | LF   | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>Stocks |
|------------------------|----------------------|-----|------|------|-----|-------|------|------|-----|----|------|------|-----|---------|------|-----|-------|--------------|
| ET138-FJN-030050E-RH7  | M3×0.5               | 3   | 0.5  | RH7  | 2P  | E     | 2    | 48   | 16  | —  | 4    | 3.2  | 6   | 4×3.2   | 7.5  | —   | 2.82  | ●            |
| ET138-FJN-035060D-RH7  | M3.5×0.6             | 3.5 | 0.6  | RH7  | 4P  | D     | 1    | 50   | 16  | —  | 4    | 3.2  | 6   | 4×3.2   | 8.8  | —   | 3.26  | ●            |
| ET138-FJN-035060E-RH7  | M3.5×0.6             | 3.5 | 0.6  | RH7  | 2P  | E     | 2    | 48   | 16  | —  | 4    | 3.2  | 6   | 4×3.2   | 8.8  | —   | 3.26  | ●            |
| ET138-FJN-040070D-RH7  | M4×0.7               | 4   | 0.7  | RH7  | 4P  | D     | 1    | 57   | 18  | —  | 5    | 4    | 7   | 5×4     | 10.0 | —   | 3.71  | ●            |
| ET138-FJN-040070E-RH7  | M4×0.7               | 4   | 0.7  | RH7  | 2P  | E     | 2    | 55   | 18  | —  | 5    | 4    | 7   | 5×4     | 10.0 | —   | 3.71  | ●            |
| ET138-FJN-050080D-RH7  | M5×0.8               | 5   | 0.8  | RH7  | 4P  | D     | 1    | 66   | 20  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.5 | —   | 4.65  | ●            |
| ET138-FJN-050080E-RH7  | M5×0.8               | 5   | 0.8  | RH7  | 2P  | E     | 2    | 63.5 | 20  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.5 | —   | 4.65  | ●            |
| ET138-FJN-060100D-RH7  | M6×1                 | 6   | 1    | RH7  | 4P  | D     | 1    | 69   | 27  | —  | 6    | 4.5  | 7   | 6×4.5   | 15.0 | 2   | 5.55  | ●            |
| ET138-FJN-060100E-RH7  | M6×1                 | 6   | 1    | RH7  | 2P  | E     | 2    | 66.5 | 27  | —  | 6    | 4.5  | 7   | 6×4.5   | 15.0 | 2   | 5.55  | ●            |
| ET138-FJN-070100D-RH7  | M7×1                 | 7   | 1    | RH7  | 4P  | D     | 5    | 70   | 13  | 23 | 6.2  | 5    | 8   | 6.2×5   | 17.5 | 2   | 6.55  | ○            |
| ET138-FJN-070100E-RH7  | M7×1                 | 7   | 1    | RH7  | 2P  | E     | 5    | 70   | 13  | 23 | 6.2  | 5    | 8   | 6.2×5   | 17.5 | 2   | 6.55  | ○            |
| ET138-FJN-080125D-RH7  | M8×1.25              | 8   | 1.25 | RH7  | 4P  | D     | 5    | 70   | 13  | 36 | 6.2  | 5    | 8   | 6.2×5   | 20.0 | 3   | 7.41  | ●            |
| ET138-FJN-080125E-RH7  | M8×1.25              | 8   | 1.25 | RH7  | 2P  | E     | 5    | 70   | 13  | 36 | 6.2  | 5    | 8   | 6.2×5   | 20.0 | 3   | 7.41  | ●            |
| ET138-FJN-100150D-RH8  | M10×1.5              | 10  | 1.5  | RH8  | 4P  | D     | 5    | 75   | 15  | 43 | 7    | 5.5  | 8   | 7×5.5   | 25.0 | 6   | 9.29  | ○            |
| ET138-FJN-100150E-RH8  | M10×1.5              | 10  | 1.5  | RH8  | 2P  | E     | 5    | 75   | 15  | 43 | 7    | 5.5  | 8   | 7×5.5   | 25.0 | 6   | 9.29  | ●            |
| ET138-FJN-120175D-RH9  | M12×1.75             | 12  | 1.75 | RH9  | 4P  | D     | 5    | 82   | 17  | 42 | 8.5  | 6.5  | 9   | 8.5×6.5 | 30.0 | 6   | 11.16 | ○            |
| ET138-FJN-120175E-RH9  | M12×1.75             | 12  | 1.75 | RH9  | 2P  | E     | 5    | 82   | 17  | 42 | 8.5  | 6.5  | 9   | 8.5×6.5 | 30.0 | 6   | 11.16 | ●            |
| ET138-FJN-140200D-RH10 | M14×2                | 14  | 2    | RH10 | 4P  | D     | 5    | 88   | 20  | 51 | 10.5 | 8    | 11  | 10.5×8  | 35.0 | 6   | 13.04 | ○            |
| ET138-FJN-140200E-RH10 | M14×2                | 14  | 2    | RH10 | 2P  | E     | 5    | 88   | 20  | 51 | 10.5 | 8    | 11  | 10.5×8  | 35.0 | 6   | 13.04 | ●            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm

[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.

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

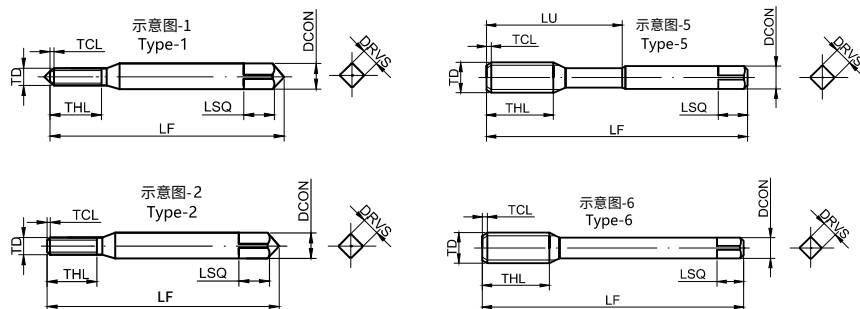
◎ 最适合 Most Suitable ○ 适合 Suitable

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

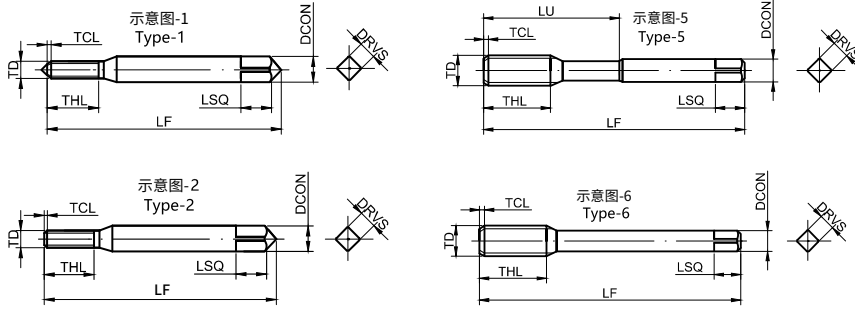
| P                                     |                                      |  | M                      | K   |                               |   | N                              |                      |                           | S                                   | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 1 2   | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code  | 螺纹尺寸<br>Nominal Size | TD     | TPI | TCTR | TCL | THCHT | Type | LF   | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>Stocks |
|-----------------------|----------------------|--------|-----|------|-----|-------|------|------|-----|----|------|------|-----|---------|------|-----|-------|--------------|
| ET138-FJN-U1224E-RH7  | NO.12-24UNC          | 5.486  | 24  | RH7  | 2P  | E     | 2    | 63.5 | 23  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 13.7 | —   | 5.00  | ●            |
| ET138-FJN-U1420D-RH7  | 1/4-20UNC            | 6.350  | 20  | RH7  | 4P  | D     | 6    | 62   | 27  | —  | 6    | 4.5  | 7   | 6×4.5   | 15.9 | 2   | 5.75  | ●            |
| ET138-FJN-U1420E-RH7  | 1/4-20UNC            | 6.350  | 20  | RH7  | 2P  | E     | 6    | 62   | 27  | —  | 6    | 4.5  | 7   | 6×4.5   | 15.9 | 2   | 5.75  | ●            |
| ET138-FJN-U51618D-RH8 | 5/16-18UNC           | 7.938  | 18  | RH8  | 4P  | D     | 5    | 70   | 15  | 30 | 6.1  | 5    | 8   | 6.1×5   | 19.8 | 3   | 7.27  | ●            |
| ET138-FJN-U51618E-RH8 | 5/16-18UNC           | 7.938  | 18  | RH8  | 2P  | E     | 5    | 70   | 15  | 30 | 6.1  | 5    | 8   | 6.1×5   | 19.8 | 3   | 7.27  | ●            |
| ET138-FJN-U3816D-RH8  | 3/8-16UNC            | 9.525  | 16  | RH8  | 4P  | D     | 5    | 75   | 16  | 43 | 7    | 5.5  | 8   | 7×5.5   | 23.8 | 6   | 8.77  | ●            |
| ET138-FJN-U3816E-RH8  | 3/8-16UNC            | 9.525  | 16  | RH8  | 2P  | E     | 5    | 75   | 16  | 43 | 7    | 5.5  | 8   | 7×5.5   | 23.8 | 6   | 8.77  | ●            |
| ET138-FJN-U71614D-RH8 | 7/16-14UNC           | 11.113 | 14  | RH8  | 4P  | D     | 5    | 80   | 20  | 40 | 8    | 6    | 9   | 8×6     | 27.8 | 6   | 10.23 | ○            |
| ET138-FJN-U71614E-RH8 | 7/16-14UNC           | 11.113 | 14  | RH8  | 2P  | E     | 5    | 80   | 20  | 40 | 8    | 6    | 9   | 8×6     | 27.8 | 6   | 10.23 | ○            |
| ET138-FJN-U1213D-RH8  | 1/2-13UNC            | 12.700 | 13  | RH8  | 4P  | D     | 5    | 85   | 21  | 48 | 9    | 7    | 10  | 9×7     | 31.8 | 6   | 11.74 | ○            |
| ET138-FJN-U1213E-RH8  | 1/2-13UNC            | 12.700 | 13  | RH8  | 2P  | E     | 5    | 85   | 21  | 48 | 9    | 7    | 10  | 9×7     | 31.8 | 6   | 11.74 | ●            |
| ET138-FJN-U91612D-RH9 | 9/16-12UNC           | 14.288 | 12  | RH9  | 4P  | D     | 5    | 90   | 21  | 50 | 10.5 | 8    | 11  | 10.5×8  | 35.7 | 6   | 13.25 | ○            |
| ET138-FJN-U91612E-RH9 | 9/16-12UNC           | 14.288 | 12  | RH9  | 2P  | E     | 5    | 90   | 21  | 50 | 10.5 | 8    | 11  | 10.5×8  | 35.7 | 6   | 13.25 | ○            |
| ET138-FJN-U5811D-RH10 | 5/8-11UNC            | 15.875 | 11  | RH10 | 4P  | D     | 5    | 95   | 23  | 48 | 12   | 9    | 12  | 12×9    | 39.7 | 6   | 14.75 | ○            |
| ET138-FJN-U5811E-RH10 | 5/8-11UNC            | 15.875 | 11  | RH10 | 2P  | E     | 5    | 95   | 23  | 48 | 12   | 9    | 12  | 12×9    | 39.7 | 6   | 14.75 | ●            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

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

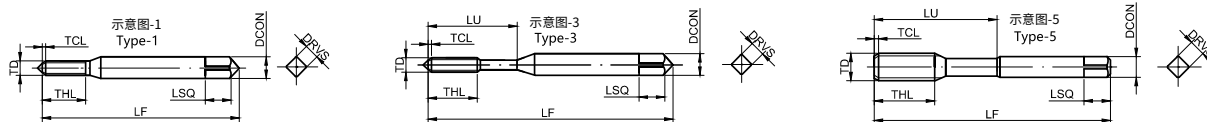
◎ 最适合 Most Suitable ○ 适合 Suitable

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

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

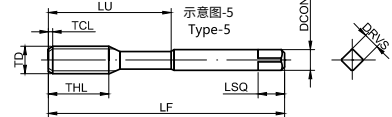
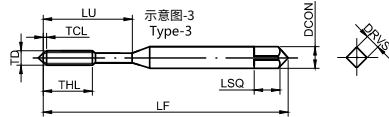
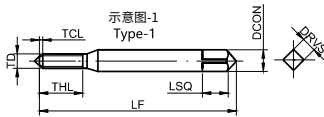
推荐切削参数 ※P62  
Recommended Cutting Data ※P62

# 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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD    | TP<br>/TPI | TCTR | TCL  | THCHT | Type | LF | THL | LU   | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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

单位:mm

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

unit:mm

### 工件材料 Workpiece Material

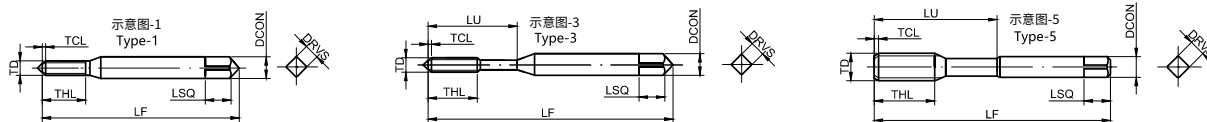
| P                                     |                                      |  | M                      | K   |                               | N   |                                |                      |                           | S                                   | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD     | TPI | TCTR | TCL  | THCHT | Type | LF | THL | LU | DCON | DRVS | LSQ | CZCMS  | TDRM | NOF | PHD   | 库存<br>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

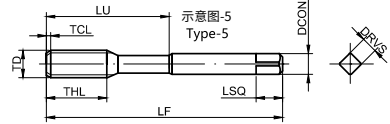
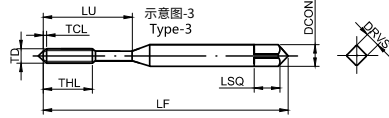
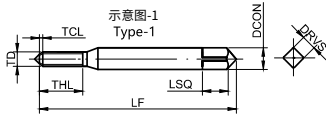
| P                                     |                                      |  | M                      | K   |                               | N   |                                |                      |                           | S                                   | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD  | TP   | TCTR | TCL | THCHT | Type | LF | THL  | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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

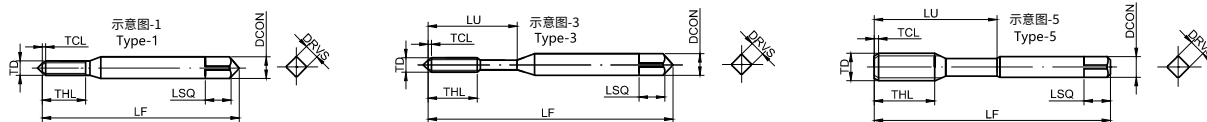
| 工件材料 Workpiece Material               |                                      |  |                        |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD    | TP/TPH | TCT | TCL | THCHT | Type | LF | THL  | LU   | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>Stocks |
|----------------------|----------------------|-------|--------|-----|-----|-------|------|----|------|------|------|------|-----|---------|------|-----|-------|--------------|
| ET138-PJN-140200B-P5 | M14×2                | 14    | 2      | P5  | 5P  | B     | 5    | 88 | 20   | 51   | 10.5 | 8    | 11  | 10.5×8  | 35.0 | 3   | 12.00 | ●            |
| ET138-PJN-140150B-P4 | M14×1.5              | 14    | 1.5    | P4  | 5P  | B     | 5    | 88 | 20   | 51   | 10.5 | 8    | 11  | 10.5×8  | 35.0 | 3   | 12.50 | ●            |
| ET138-PJN-140125B-P4 | M14×1.25             | 14    | 1.25   | P4  | 5P  | B     | 5    | 88 | 20   | 51   | 10.5 | 8    | 11  | 10.5×8  | 35.0 | 3   | 12.75 | ○            |
| ET138-PJN-140100B-P3 | M14×1                | 14    | 1      | P3  | 5P  | B     | 5    | 88 | 20   | 51   | 10.5 | 8    | 11  | 10.5×8  | 35.0 | 3   | 13.00 | ○            |
| ET138-PJN-160200B-P5 | M16×2                | 16    | 2      | P5  | 5P  | B     | 5    | 95 | 20   | 52   | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 3   | 14.00 | ●            |
| ET138-PJN-160150B-P4 | M16×1.5              | 16    | 1.5    | P4  | 5P  | B     | 5    | 95 | 20   | 52   | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 3   | 14.50 | ●            |
| ET138-PJN-160125B-P4 | M16×1.25             | 16    | 1.25   | P4  | 5P  | B     | 5    | 95 | 20   | 52   | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 3   | 14.75 | ○            |
| ET138-PJN-160100B-P3 | M16×1                | 16    | 1      | P3  | 5P  | B     | 5    | 95 | 20   | 52   | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 3   | 15.00 | ○            |
| ET138-PJN-U080B-P1   | NO.0-80UNF           | 1.524 | 80     | P1  | 5P  | B     | 1    | 37 | 10   | —    | 3    | 2.5  | 3   | 3×2.5   | 3.8  | 2   | 1.21  | ○            |
| ET138-PJN-U164B-P1   | NO.1-64UNC           | 1.854 | 64     | P1  | 5P  | B     | 1    | 37 | 11   | —    | 3    | 2.5  | 3   | 3×2.5   | 4.6  | 2   | 1.46  | ○            |
| ET138-PJN-U256B-P1   | NO.2-56UNC           | 2.184 | 56     | P1  | 5P  | B     | 1    | 45 | 12   | —    | 3    | 2.5  | 3   | 3×2.5   | 5.5  | 2   | 1.73  | ○            |
| ET138-PJN-U348B-P1   | NO.3-48UNC           | 2.515 | 48     | P1  | 5P  | B     | 1    | 45 | 14   | —    | 3    | 2.5  | 3   | 3×2.5   | 6.3  | 2   | 1.99  | ○            |
| ET138-PJN-U440B-P2   | NO.4-40UNC           | 2.845 | 40     | P2  | 5P  | B     | 1    | 45 | 13   | —    | 3    | 2.5  | 3   | 3×2.5   | 7.1  | 3   | 2.21  | ●            |
| ET138-PJN-U540B-P2   | NO.5-40UNC           | 3.175 | 40     | P2  | 5P  | B     | 3    | 50 | 12   | 19   | 4    | 3.2  | 6   | 4×3.2   | 7.9  | 3   | 2.54  | ○            |
| ET138-PJN-U632B-P2   | NO.6-32UNC           | 3.505 | 32     | P2  | 5P  | B     | 3    | 50 | 13   | 20   | 4    | 3.2  | 6   | 4×3.2   | 8.8  | 3   | 2.71  | ●            |
| ET138-PJN-U832B-P2   | NO.8-32UNC           | 4.166 | 32     | P2  | 5P  | B     | 3    | 57 | 13.5 | 21.5 | 5    | 4    | 7   | 5×4     | 10.4 | 3   | 3.37  | ●            |
| ET138-PJN-U1024B-P2  | NO.10-24UNC          | 4.826 | 24     | P2  | 5P  | B     | 3    | 66 | 16.5 | 26   | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.1 | 3   | 3.77  | ●            |
| ET138-PJN-U1032B-P2  | NO.10-32UNF          | 4.826 | 32     | P2  | 5P  | B     | 3    | 66 | 16.5 | 26   | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.1 | 3   | 4.03  | ○            |
| ET138-PJN-U1224B-P2  | NO.12-24UNC          | 5.486 | 24     | P2  | 5P  | B     | 3    | 66 | 16.5 | 26   | 5.5  | 4.5  | 7   | 5.5×4.5 | 13.7 | 3   | 4.43  | ○            |
| ET138-PJN-U1228B-P2  | NO.12-28UNF          | 5.486 | 28     | P2  | 5P  | B     | 3    | 66 | 16.5 | 26   | 5.5  | 4.5  | 7   | 5.5×4.5 | 13.7 | 3   | 4.58  | ○            |
| ET138-PJN-U1420B-P2  | 1/4-20UNC            | 6.350 | 20     | P2  | 5P  | B     | 3    | 69 | 19.5 | 29   | 6    | 4.5  | 7   | 6×4.5   | 15.9 | 3   | 5.08  | ●            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

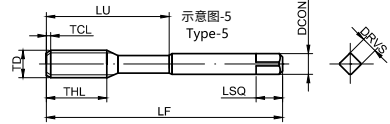
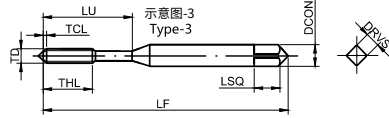
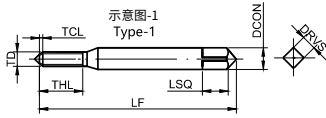
| 工件材料 Workpiece Material               |                                      |  |                        |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| P                                     |                                      |  | M                      | K   |                               |   | N                              |                      |                           | S                                   | H                      |                        |                        |
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 1 2   | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD     | TPI | TCTR | TCL | THCHT | Type | LF | THL  | LU | DCON | DRVS | LSQ | CZCMS  | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
| ◎                                     |                                      |  | ○                      |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |

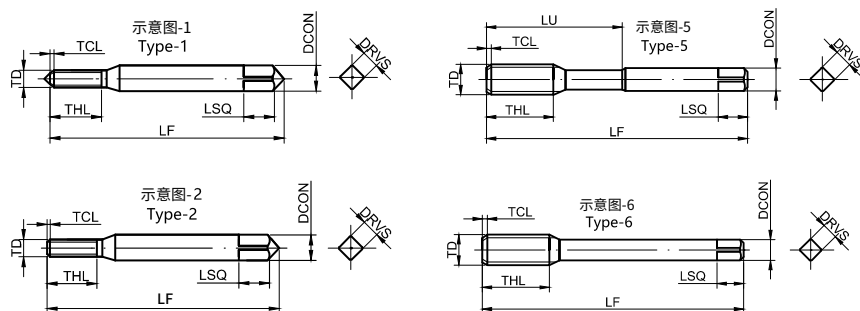
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

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

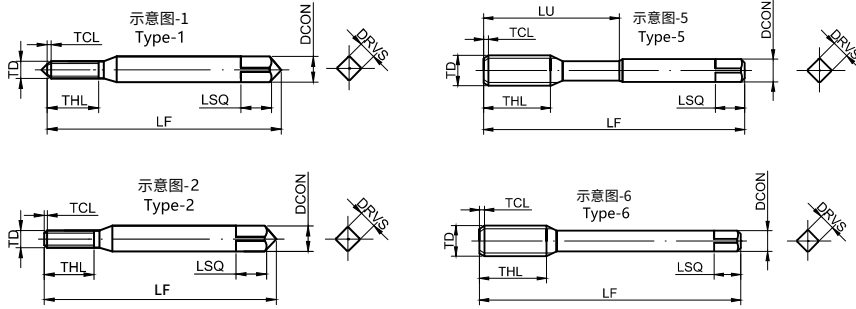
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm

[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.

unit:mm

工件材料 Workpiece Material

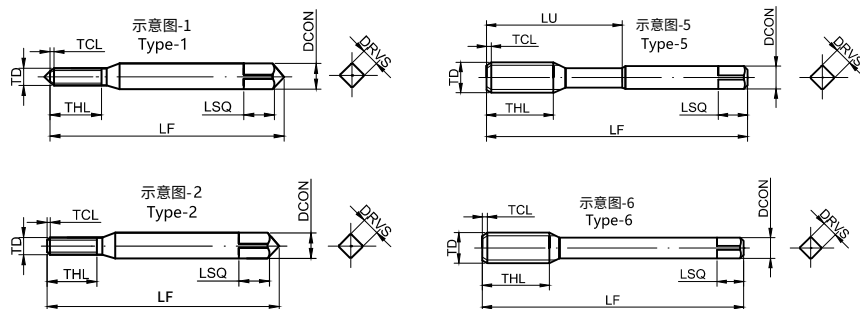
| P                                     |                                      |  | M                      | K   |                               | N   |                                |                      |                           | S                                   | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code   | 螺纹尺寸<br>Nominal Size | TD    | TP<br>/TPI | TCTR | TCL | THCT | Type | LF   | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>Stocks |
|------------------------|----------------------|-------|------------|------|-----|------|------|------|-----|----|------|------|-----|---------|------|-----|-------|--------------|
| ET168-FJN-160200D-RH10 | M16×2                | 16    | 2          | RH10 | 4P  | D    | 5    | 95   | 20  | 52 | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 6   | 15.04 | ○            |
| ET168-FJN-160200E-RH10 | M16×2                | 16    | 2          | RH10 | 2P  | E    | 5    | 95   | 20  | 52 | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 6   | 15.04 | ●            |
| ET168-FJN-U164D-RH4    | NO.1-64UNC           | 1.854 | 64         | RH4  | 4P  | D    | 1    | 37   | 9   | —  | 3    | 2.5  | 3   | 3×2.5   | 4.6  | —   | 1.69  | ○            |
| ET168-FJN-U164E-RH4    | NO.1-64UNC           | 1.854 | 64         | RH4  | 2P  | E    | 2    | 35.5 | 9   | —  | 3    | 2.5  | 3   | 3×2.5   | 4.6  | —   | 1.69  | ○            |
| ET168-FJN-U256D-RH4    | NO.2-56UNC           | 2.184 | 56         | RH4  | 4P  | D    | 1    | 45   | 12  | —  | 3    | 2.5  | 3   | 3×2.5   | 5.5  | —   | 1.99  | ○            |
| ET168-FJN-U256E-RH4    | NO.2-56UNC           | 2.184 | 56         | RH4  | 2P  | E    | 2    | 43.5 | 12  | —  | 3    | 2.5  | 3   | 3×2.5   | 5.5  | —   | 1.99  | ○            |
| ET168-FJN-U348D-RH4    | NO.3-48UNC           | 2.515 | 48         | RH4  | 4P  | D    | 1    | 45   | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 6.3  | —   | 2.28  | ○            |
| ET168-FJN-U348E-RH4    | NO.3-48UNC           | 2.515 | 48         | RH4  | 2P  | E    | 2    | 43.5 | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 6.3  | —   | 2.28  | ○            |
| ET168-FJN-U440D-RH4    | NO.4-40UNC           | 2.845 | 40         | RH4  | 4P  | D    | 1    | 45   | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 7.1  | —   | 2.55  | ○            |
| ET168-FJN-U440E-RH4    | NO.4-40UNC           | 2.845 | 40         | RH4  | 2P  | E    | 2    | 43.5 | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 7.1  | —   | 2.55  | ●            |
| ET168-FJN-U540D-RH4    | NO.5-40UNC           | 3.175 | 40         | RH4  | 4P  | D    | 1    | 50   | 15  | —  | 4    | 3.2  | 6   | 4×3.2   | 7.9  | —   | 2.88  | ○            |
| ET168-FJN-U540E-RH4    | NO.5-40UNC           | 3.175 | 40         | RH4  | 2P  | E    | 2    | 48   | 15  | —  | 4    | 3.2  | 6   | 4×3.2   | 7.9  | —   | 2.88  | ●            |
| ET168-FJN-U632D-RH7    | NO.6-32UNC           | 3.505 | 32         | RH7  | 4P  | D    | 1    | 50   | 16  | —  | 4    | 3.2  | 6   | 4×3.2   | 8.8  | —   | 3.16  | ●            |
| ET168-FJN-U632E-RH7    | NO.6-32UNC           | 3.505 | 32         | RH7  | 2P  | E    | 2    | 48   | 16  | —  | 4    | 3.2  | 6   | 4×3.2   | 8.8  | —   | 3.16  | ●            |
| ET168-FJN-U832D-RH7    | NO.8-32UNC           | 4.166 | 32         | RH7  | 4P  | D    | 1    | 57   | 18  | —  | 5    | 4    | 7   | 5×4     | 10.4 | —   | 3.82  | ●            |
| ET168-FJN-U832E-RH7    | NO.8-32UNC           | 4.166 | 32         | RH7  | 2P  | E    | 2    | 54.5 | 18  | —  | 5    | 4    | 7   | 5×4     | 10.4 | —   | 3.82  | ●            |
| ET168-FJN-U1024D-RH7   | NO.10-24UNC          | 4.826 | 24         | RH7  | 4P  | D    | 1    | 66   | 20  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.1 | —   | 4.34  | ●            |
| ET168-FJN-U1024E-RH7   | NO.10-24UNC          | 4.826 | 24         | RH7  | 2P  | E    | 2    | 63.5 | 20  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.1 | —   | 4.34  | ●            |
| ET168-FJN-U1224D-RH7   | NO.12-24UNC          | 5.486 | 24         | RH7  | 4P  | D    | 1    | 66   | 23  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 13.7 | —   | 5.00  | ●            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

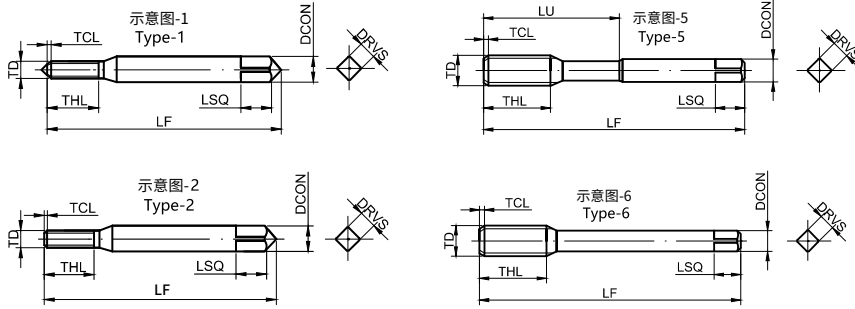
| P                                     |                                      | M  |                        | K   |                               | N   |                                |                      | S                         |                                     | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 1 2   | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code  | 螺纹尺寸<br>Nominal Size | TD     | TPI | TCTR | TCL | THCT | Type | LF   | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>Stocks |
|-----------------------|----------------------|--------|-----|------|-----|------|------|------|-----|----|------|------|-----|---------|------|-----|-------|--------------|
| ET168-FJN-U1224E-RH7  | NO.12-24UNC          | 5.486  | 24  | RH7  | 2P  | E    | 2    | 63.5 | 23  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 13.7 | —   | 5.00  | ●            |
| ET168-FJN-U1420D-RH7  | 1/4-20UNC            | 6.350  | 20  | RH7  | 4P  | D    | 6    | 62   | 27  | —  | 6    | 4.5  | 7   | 6×4.5   | 15.9 | 2   | 5.75  | ●            |
| ET168-FJN-U1420E-RH7  | 1/4-20UNC            | 6.350  | 20  | RH7  | 2P  | E    | 6    | 62   | 27  | —  | 6    | 4.5  | 7   | 6×4.5   | 15.9 | 2   | 5.75  | ●            |
| ET168-FJN-U51618D-RH8 | 5/16-18UNC           | 7.938  | 18  | RH8  | 4P  | D    | 5    | 70   | 15  | 30 | 6.1  | 5    | 8   | 6.1×5   | 19.8 | 3   | 7.27  | ●            |
| ET168-FJN-U51618E-RH8 | 5/16-18UNC           | 7.938  | 18  | RH8  | 2P  | E    | 5    | 70   | 15  | 30 | 6.1  | 5    | 8   | 6.1×5   | 19.8 | 3   | 7.27  | ●            |
| ET168-FJN-U3816D-RH8  | 3/8-16UNC            | 9.525  | 16  | RH8  | 4P  | D    | 5    | 75   | 16  | 43 | 7    | 5.5  | 8   | 7×5.5   | 23.8 | 6   | 8.77  | ●            |
| ET168-FJN-U3816E-RH8  | 3/8-16UNC            | 9.525  | 16  | RH8  | 2P  | E    | 5    | 75   | 16  | 43 | 7    | 5.5  | 8   | 7×5.5   | 23.8 | 6   | 8.77  | ●            |
| ET168-FJN-U71614D-RH8 | 7/16-14UNC           | 11.113 | 14  | RH8  | 4P  | D    | 5    | 80   | 20  | 40 | 8    | 6    | 9   | 8×6     | 27.8 | 6   | 10.23 | ○            |
| ET168-FJN-U71614E-RH8 | 7/16-14UNC           | 11.113 | 14  | RH8  | 2P  | E    | 5    | 80   | 20  | 40 | 8    | 6    | 9   | 8×6     | 27.8 | 6   | 10.23 | ○            |
| ET168-FJN-U1213D-RH8  | 1/2-13UNC            | 12.700 | 13  | RH8  | 4P  | D    | 5    | 85   | 21  | 48 | 9    | 7    | 10  | 9×7     | 31.8 | 6   | 11.74 | ○            |
| ET168-FJN-U1213E-RH8  | 1/2-13UNC            | 12.700 | 13  | RH8  | 2P  | E    | 5    | 85   | 21  | 48 | 9    | 7    | 10  | 9×7     | 31.8 | 6   | 11.74 | ●            |
| ET168-FJN-U91612D-RH9 | 9/16-12UNC           | 14.288 | 12  | RH9  | 4P  | D    | 5    | 90   | 21  | 50 | 10.5 | 8    | 11  | 10.5×8  | 35.7 | 6   | 13.25 | ○            |
| ET168-FJN-U91612E-RH9 | 9/16-12UNC           | 14.288 | 12  | RH9  | 2P  | E    | 5    | 90   | 21  | 50 | 10.5 | 8    | 11  | 10.5×8  | 35.7 | 6   | 13.25 | ○            |
| ET168-FJN-U5811D-RH10 | 5/8-11UNC            | 15.875 | 11  | RH10 | 4P  | D    | 5    | 95   | 23  | 48 | 12   | 9    | 12  | 12×9    | 39.7 | 6   | 14.75 | ○            |
| ET168-FJN-U5811E-RH10 | 5/8-11UNC            | 15.875 | 11  | RH10 | 2P  | E    | 5    | 95   | 23  | 48 | 12   | 9    | 12  | 12×9    | 39.7 | 6   | 14.75 | ●            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

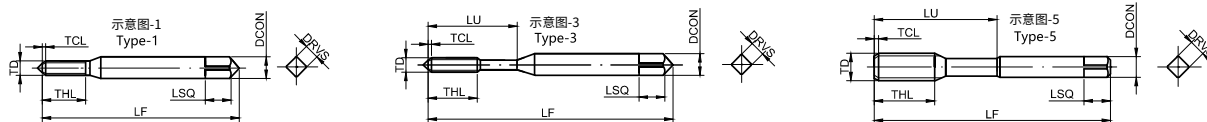
| 工件材料 Workpiece Material               |                                      |  |                        |   |                               |   |                                |                      |                           |                                     |                        |     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

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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD  | TP   | TCTR | TCL  | THCHT | Type | LF | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
| ○                                     |                                      |  | ◎                      |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |

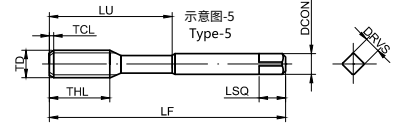
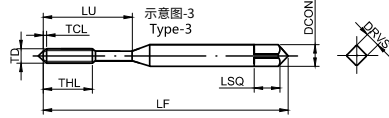
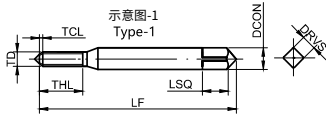
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

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

单位:mm  
unit:mm

### 工件材料 Workpiece Material

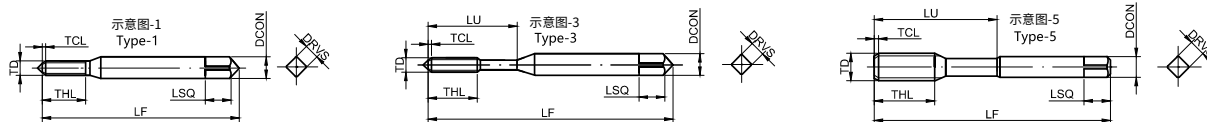
| P                                     |                                      |  | M                      | K   |                               | N   |                                |                      |                           | S                                   | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD     | TPI | TCTR | TCL  | THCHT | Type | LF | THL | LU | DCON | DRVS | LSQ | CZCMS  | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
| ○                                     |                                      |  | ◎                      |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |

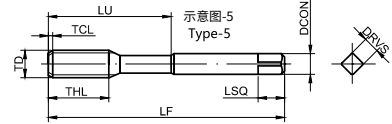
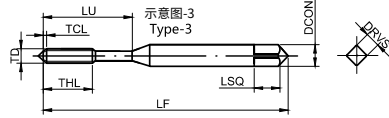
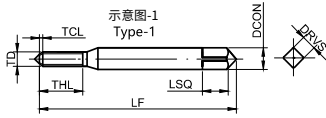
◎ 最适合 Most Suitable ○ 适合 Suitabel

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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD  | TP   | TCTR | TCL | THCHT | Type | LF | THL  | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
| ○                                     |                                      |  | ◎                      |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |

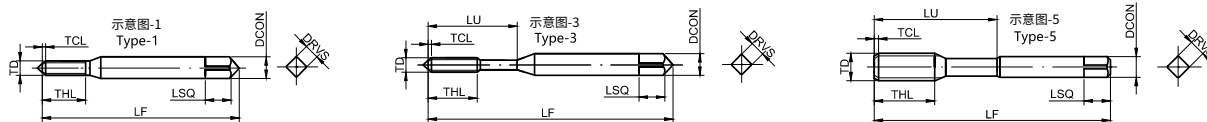
◎ 最适合 Most Suitable ○ 适合 Suitabel

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



» 续前 Continue

| 订货号<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD    | TP/TPI | TCTR | TCL | THCHT | Type | LF | THL  | LU   | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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

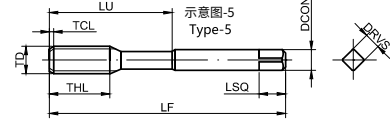
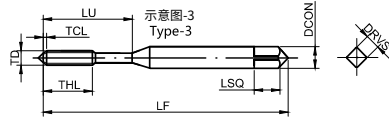
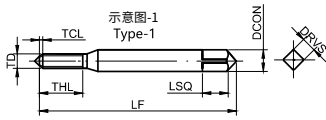
推荐切削参数 ※P62  
Recommended Cutting Data ※P62

# ET168-PJN



经济型 不锈钢加工刃倾角丝锥

Economical stainless steel machining spiral pointed tap



» 续前 Continue

| 订货号<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD     | TPI | TCTR | TCL | THCHT | Type | LF | THL  | LU | DCON | DRVS | LSQ | CZCMS  | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
| ○                                     |                                      |  | ◎                      |   |                               |   |                                |                      |                           |                                     |                        |                        |                        |

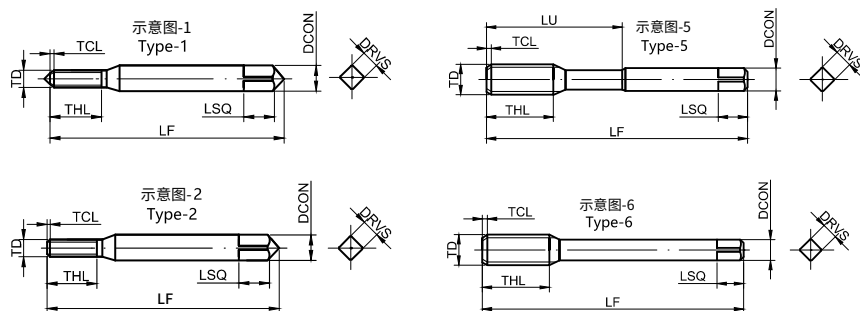
◎ 最适合 Most Suitable ○ 适合 Suitabel

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



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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

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

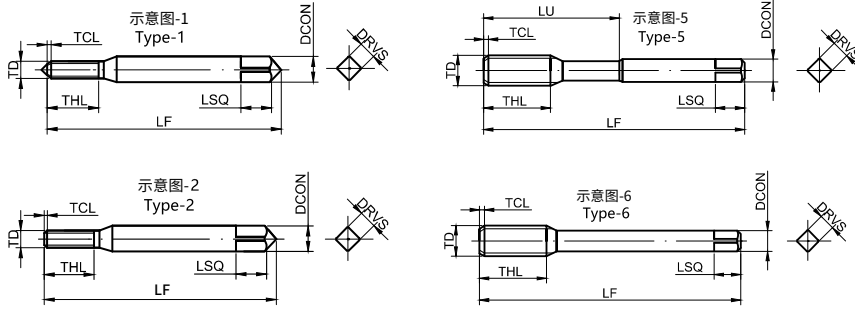
推荐切削参数 ※P62  
Recommended Cutting Data ※P62

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm

[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.

unit:mm

### 工件材料 Workpiece Material

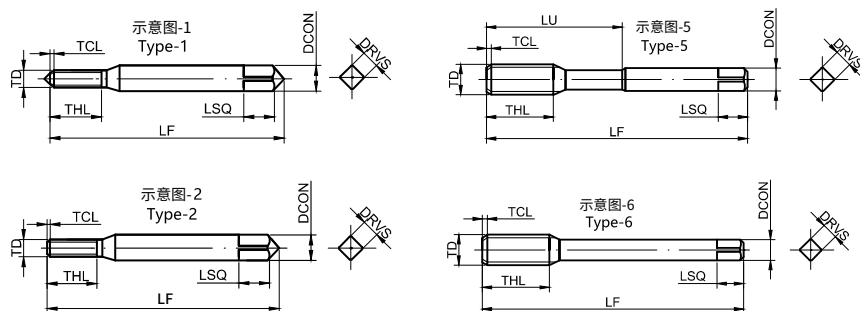
| P                                     |                                      |  | M                      | K   |                               | N   |                                |                      | S                         | H                                   |                        |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Ordering Code   | 螺纹尺寸<br>Nominal Size | TD    | TP<br>/TPI | TCTR | TCL | THCHT | Type | LF   | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>Stocks |
|------------------------|----------------------|-------|------------|------|-----|-------|------|------|-----|----|------|------|-----|---------|------|-----|-------|--------------|
| ET166-FJN-160200D-RH10 | M16×2                | 16    | 2          | RH10 | 4P  | D     | 5    | 95   | 20  | 52 | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 6   | 15.04 | ○            |
| ET166-FJN-160200E-RH10 | M16×2                | 16    | 2          | RH10 | 2P  | E     | 5    | 95   | 20  | 52 | 12.5 | 10   | 13  | 12.5×10 | 40.0 | 6   | 15.04 | ●            |
| ET166-FJN-U164D-RH4    | NO.1-64UNC           | 1.854 | 64         | RH4  | 4P  | D     | 1    | 37   | 9   | —  | 3    | 2.5  | 3   | 3×2.5   | 4.6  | —   | 1.69  | ○            |
| ET166-FJN-U164E-RH4    | NO.1-64UNC           | 1.854 | 64         | RH4  | 2P  | E     | 2    | 35.5 | 9   | —  | 3    | 2.5  | 3   | 3×2.5   | 4.6  | —   | 1.69  | ○            |
| ET166-FJN-U256D-RH4    | NO.2-56UNC           | 2.184 | 56         | RH4  | 4P  | D     | 1    | 45   | 12  | —  | 3    | 2.5  | 3   | 3×2.5   | 5.5  | —   | 1.99  | ○            |
| ET166-FJN-U256E-RH4    | NO.2-56UNC           | 2.184 | 56         | RH4  | 2P  | E     | 2    | 43.5 | 12  | —  | 3    | 2.5  | 3   | 3×2.5   | 5.5  | —   | 1.99  | ○            |
| ET166-FJN-U348D-RH4    | NO.3-48UNC           | 2.515 | 48         | RH4  | 4P  | D     | 1    | 45   | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 6.3  | —   | 2.28  | ○            |
| ET166-FJN-U348E-RH4    | NO.3-48UNC           | 2.515 | 48         | RH4  | 2P  | E     | 2    | 43.5 | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 6.3  | —   | 2.28  | ○            |
| ET166-FJN-U440D-RH4    | NO.4-40UNC           | 2.845 | 40         | RH4  | 4P  | D     | 1    | 45   | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 7.1  | —   | 2.55  | ○            |
| ET166-FJN-U440E-RH4    | NO.4-40UNC           | 2.845 | 40         | RH4  | 2P  | E     | 2    | 43.5 | 15  | —  | 3    | 2.5  | 3   | 3×2.5   | 7.1  | —   | 2.55  | ●            |
| ET166-FJN-U540D-RH4    | NO.5-40UNC           | 3.175 | 40         | RH4  | 4P  | D     | 1    | 50   | 15  | —  | 4    | 3.2  | 6   | 4×3.2   | 7.9  | —   | 2.88  | ○            |
| ET166-FJN-U540E-RH4    | NO.5-40UNC           | 3.175 | 40         | RH4  | 2P  | E     | 2    | 48   | 15  | —  | 4    | 3.2  | 6   | 4×3.2   | 7.9  | —   | 2.88  | ●            |
| ET166-FJN-U632D-RH7    | NO.6-32UNC           | 3.505 | 32         | RH7  | 4P  | D     | 1    | 50   | 16  | —  | 4    | 3.2  | 6   | 4×3.2   | 8.8  | —   | 3.16  | ●            |
| ET166-FJN-U632E-RH7    | NO.6-32UNC           | 3.505 | 32         | RH7  | 2P  | E     | 2    | 48   | 16  | —  | 4    | 3.2  | 6   | 4×3.2   | 8.8  | —   | 3.16  | ●            |
| ET166-FJN-U832D-RH7    | NO.8-32UNC           | 4.166 | 32         | RH7  | 4P  | D     | 1    | 57   | 18  | —  | 5    | 4    | 7   | 5×4     | 10.4 | —   | 3.82  | ●            |
| ET166-FJN-U832E-RH7    | NO.8-32UNC           | 4.166 | 32         | RH7  | 2P  | E     | 2    | 54.5 | 18  | —  | 5    | 4    | 7   | 5×4     | 10.4 | —   | 3.82  | ●            |
| ET166-FJN-U1024D-RH7   | NO.10-24UNC          | 4.826 | 24         | RH7  | 4P  | D     | 1    | 66   | 20  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.1 | —   | 4.34  | ●            |
| ET166-FJN-U1024E-RH7   | NO.10-24UNC          | 4.826 | 24         | RH7  | 2P  | E     | 2    | 63.5 | 20  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 12.1 | —   | 4.34  | ●            |
| ET166-FJN-U1224D-RH7   | NO.12-24UNC          | 5.486 | 24         | RH7  | 4P  | D     | 1    | 66   | 23  | —  | 5.5  | 4.5  | 7   | 5.5×4.5 | 13.7 | —   | 5.00  | ●            |

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

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

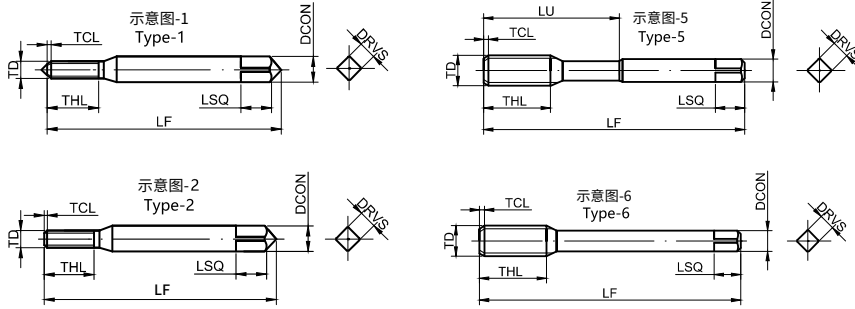
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

### 工件材料 Workpiece Material

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

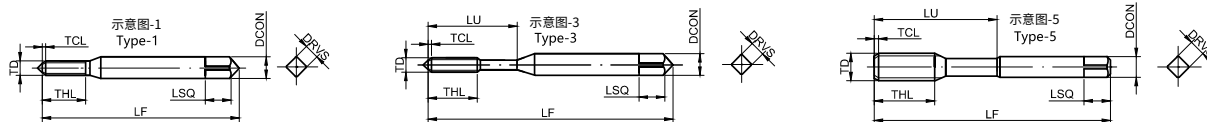
推荐切削参数 ※P62  
Recommended Cutting Data ※P62

# ET166-SJN



经济型 铜铝加工螺旋丝锥

Economical copper and aluminum processing spiral fluted tap



| 订货号<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD  | TP   | TCTR | TCL  | THCHT | Type | LF | THL | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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

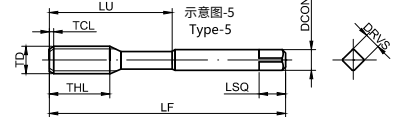
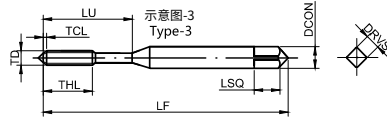
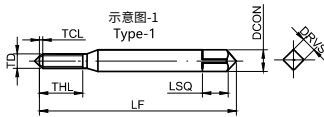
推荐切削参数 ※P62  
Recommended Cutting Data ※P62

# 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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD    | TP/TPI | TCTR | TCL  | THCHT | Type | LF | THL | LU   | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
|                                       |                                      |  |                        |   |                               | ○   | ○                              | ○                    |                           |                                     |                        |                        |                        |

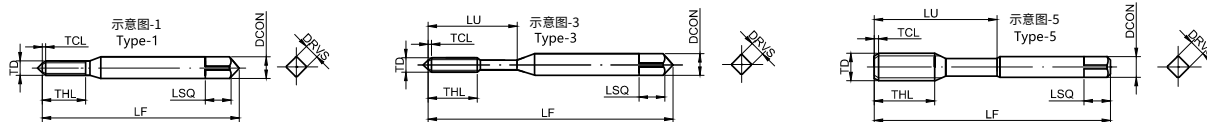
○ 最适合 Most Suitable ○ 适合 Suitabel

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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD     | TPI | TCTR | TCL  | THCHT | Type | LF | THL | LU | DCON | DRVS | LSQ | CZCMS  | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
|                                       |                                      |  |                        |   |                               | ◎   | ◎                              | ◎                    |                           |                                     |                        |                        |                        |

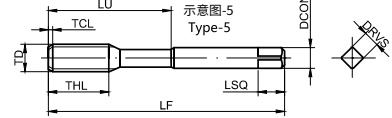
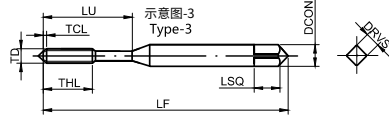
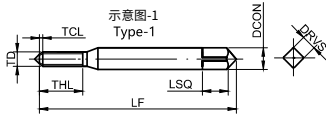
◎ 最适合 Most Suitable ○ 适合 Suitabel

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<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD  | TP   | TCTR | TCL | THCHT | Type | LF | THL  | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
|                                       |                                      |  |                        |   |                               | ○   | ○                              | ○                    |                           |                                     |                        |                        |                        |

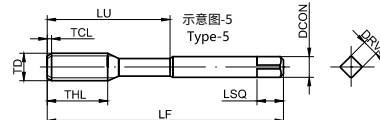
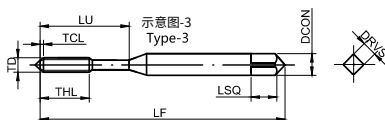
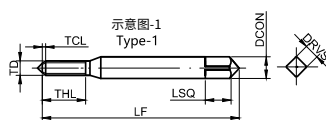
○ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

[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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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

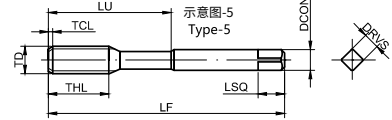
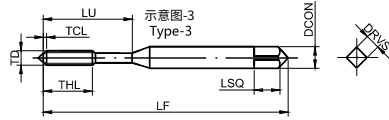
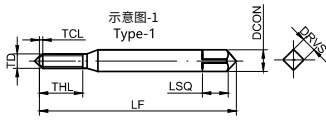
推荐切削参数 ※P62  
Recommended Cutting Data ※P62

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm

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

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

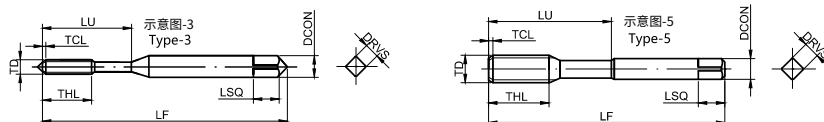
○ 最适合 Most Suitable ○ 适合 Suitabel

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

# ET128-HJN

经济型 铸铁加工直槽丝锥

Economical cast iron processing hand tap



| 订货号<br>Ordering Code | 螺纹尺寸<br>Nominal Size | TD | TP   | TCTR | TCL  | THCHT | Type | LF | THL  | LU | DCON | DRVS | LSQ | CZCMS   | TDRM | NOF | PHD   | 库存<br>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<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>Hardened Steels |
| <35HRC                                | 35-48HRC                             |  |                        | <32HRC  | <43HRC                        | Si<12%  | Si>12%                         | <HB200               |                           | <HB450                              | <HB400                 | 45-55HRC               | 55-60HRC               |
|                                       |                                      |  |                        | ◎   | ○                             |   |                                |                      |                           |                                     |                        |                        |                        |

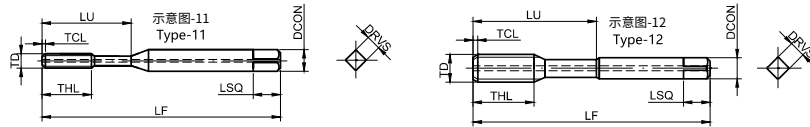
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm

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

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

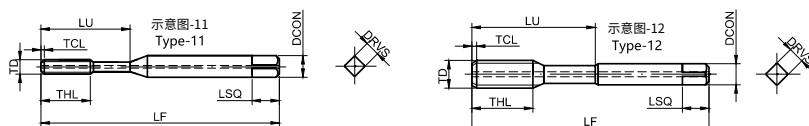
◎ 最适合 Most Suitable ○ 适合 Suitabel

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

● 标准库存 Stock ○ 需预定 Available upon Order

单位:mm  
unit:mm

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

工件材料 Workpiece Material

| P                                     |                                      | M  |                        | K   |                               | N   |                                |                      | S                         |                                     | H                      |                        |                        |
|---------------------------------------|--------------------------------------|--|------------------------|---|-------------------------------|---|--------------------------------|----------------------|---------------------------|-------------------------------------|------------------------|------------------------|------------------------|
| 1 2 3 4                               | 5                                    | 6 7  | 1 2 3                  | 1 2   | 3                             | 1 2   | 3                              | 4                    | 5                         | 1 2 3                               | 4                      | 1                      | 2                      |
| 碳钢、合金钢<br>Carbon Steels, Alloy Steels | 合金钢、工具钢<br>Alloy Steels, Tool Steels | PH与铁素体/马氏体钢<br>PH and Ferritic/Martensitic Stainless Steel | 不锈钢<br>Stainless Steel | 灰铸铁、球墨铸铁<br>Gray Cast Iron, Ductile Cast Iron | 高合金铸铁<br>High Alloy Cast Iron | 锻造铝合金、铸造铝合金<br>Forged Aluminium Alloys, Cast Aluminium Alloys | 铸造铝合金<br>Cast Aluminium Alloys | 铜合金<br>Copper Alloys | 复合材料<br>Compound Material | 高温合金<br>Heat Resistant Super Alloys | 钛合金<br>Titanium Alloys | 淬硬钢<br>Hardened Steels | 淬硬钢<br>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<br>Workpiece Material |  | ET138-FJN              | ET166-FJN | ET168-FJN | ET138-SJN | ET166-SJN | ET168-SJN | ET138-PJN | ET166-PJN | ET168-PJN | ET128-HJN | ET128-HJC<br>ET128-HJR |
|----------------------------|--|------------------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|------------------------|
|                            |  | 外冷<br>External Cooling |           |           |           |           |           |           |           |           |           | 内冷<br>Internal Coolant |
| P                          | 低碳钢<br>Low carbon steel<br>(<125HB)  | 5-15                   |           | 5-10      | 5-15      |           |           | 5-10      | 5-15      |           | 5-10      |                        |
|                            | 高碳钢及合金钢<br>High carbon steel<br>and alloy steel<br>(<35HRC)                              | 5-10                   |           | 5-10      | 5-10      |           |           | 5-10      | 5-10      |           | 5-10      |                        |
|                            | 调质钢和工具钢<br>Quenched and<br>tempered steel and<br>tool steel                              |                        |           |           |           |           |           |           |           |           |           |                        |
| M                          | 奥氏体不锈钢<br>Austenitic stainless<br>steel (130-200HB)<br>(130-200HB)                       | 5-10                   |           | 5-15      | 5-10      |           |           | 5-15      | 5-10      |           | 5-15      |                        |
|                            | 高强度的奥氏体和铸造<br>不锈钢<br>High-strength<br>austenitic and cast<br>stainless steel<br>(<25HRC) | 5-10                   |           | 5-15      | 5-10      |           |           | 5-15      | 5-10      |           | 5-15      |                        |
|                            | 双相不锈钢<br>Duplex stainless steel<br>(<30HRC)  | 4-8                    |           | 5-10      | 4-8       |           |           | 5-10      | 4-8       |           | 5-10      |                        |
| K                          | 灰铸铁和球墨铸铁<br>Gray cast iron and<br>ductile iron<br>(<32HRC)                               |                        |           |           |           |           |           |           |           |           | 15-30     | 20-40                  |
|                            | 高合金铸铁<br>Gray cast iron and<br>ductile iron<br>(<43HRC)                                  |                        |           |           |           |           |           |           |           |           | 10-20     | 15-25                  |
| N                          | 锻造铝合金和<br>铸造铝合金<br>Forged aluminum<br>alloy and cast<br>aluminum alloy<br>(Si<12%)       |                        | 5-10      |           |           | 5-10      |           |           | 5-10      |           |           |                        |
|                            | 铸造铝合金<br>Cast aluminum alloy<br>(Si>12%)   |                        | 4-8       |           |           | 4-8       |           |           | 4-8       |           |           |                        |
|                            | 铜合金<br>Copper alloy<br>(<HB200)  |                        | 5-10      |           |           | 5-10      |           |           | 5-10      |           |           |                        |

**【注意Note】**

1. 推荐使用丝锥专用刀柄加工。

It is recommended to use a dedicated tap handle for machining.

2. 表中切削参数为推荐参数，加工时请根据实际加工情况适当调整切削参数。

During the machining process, please adjust the cutting parameters according to the actual conditions.

单位:m/min  
unit:m/min



C

附录  
Appendix



# 丝锥询单信息表 Tap Desired Form

| 丝锥询单信息表<br>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:                                      |                          |  |                          |                          |
|   |                          |  |                          |                          |
| <input type="checkbox"/>                              | <input type="checkbox"/> | <input type="checkbox"/>   | <input type="checkbox"/> | <input type="checkbox"/> |
| <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<br>Metric Threads |   | 单位: mm<br>Unit:mm                                   |   |   |
|------------------------|---|---|---|---|
| 螺纹尺寸<br>Thread Size    | 1 级螺纹用底孔直径<br>JIS Class 1 Drill Hole Dia. |   | 2 级螺纹用底孔直径<br>JIS Class 2 Drill Hole Dia. |   |
|                        | RH<br>精度<br>Precision                     | 最小~最大 ( 嵌合率 %)<br>MIN ~ MAX(Thread Overlap Ratio:%) | RH<br>精度<br>Precision                     | 最小~最大 ( 嵌合率 %)<br>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<br>Unified Threads |   |                       |                       |   |   |   | 单位: mm<br>Unit:mm |
|-------------------------|---|-----------------------|-----------------------|---|---|---|-------------------|
| 螺纹尺寸<br>Thread Size     | 2B 级螺纹用底孔直径<br>Class 2B Drill Hole Dia. |                       |                       |   | 3B 级螺纹用底孔直径<br>Class 3B Drill Hole Dia. |   |                   |
|                         | 外径<br>Outer<br>Diameter                 | 牙距<br>pitch<br>Thread | RH<br>精度<br>Precision | 最小~最大 (嵌合率 %)<br>MIN ~ MAX(Thread Overlap<br>Ratio:%) | RH<br>精度<br>Precision                   | 最小~最大 (嵌合率 %)<br>MIN ~ MAX(Thread Overlap<br>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<br>Metric Threads |      |                            | 单位: mm<br>Unit:mm                         |           |
|------------------------|------|----------------------------|---|-----------|
| 螺纹尺寸<br>Thread Size    |      | 标准直径<br>Standard Hole Dia. | 2级牙钻孔径<br>For JIS Class 2 Drill Hole Dia. |           |
|                        |      |                            | 最大<br>MAX                                 | 最小<br>MIN |
| M1                     | 0.25 | 0.75                       | 0.785                                     | 0.729     |
| M1.1                   | 0.25 | 0.85                       | 0.885                                     | 0.829     |
| M1.2                   | 0.25 | 0.95                       | 0.985                                     | 0.929     |
| M1.4                   | 0.3  | 1.1                        | 1.142                                     | 1.075     |
| M1.6                   | 0.35 | 1.25                       | 1.321                                     | 1.221     |
| M1.7                   | 0.35 | 1.35                       | 1.421                                     | 1.321     |
| M1.8                   | 0.35 | 1.45                       | 1.521                                     | 1.421     |
| M2                     | 0.4  | 1.6                        | 1.679                                     | 1.567     |
| M2.2                   | 0.45 | 1.75                       | 1.838                                     | 1.713     |
| M2.3                   | 0.4  | 1.9                        | 1.979                                     | 1.867     |
| M2.5                   | 0.45 | 2.1                        | 2.138                                     | 2.013     |
| M2.6                   | 0.45 | 2.2                        | 2.238                                     | 2.113     |
| M3                     | 0.5  | 2.5                        | 2.599                                     | 2.459     |
| M3.5                   | 0.6  | 2.9                        | 3.01                                      | 2.85      |
| M4                     | 0.7  | 3.3                        | 3.422                                     | 3.242     |
| M4.5                   | 0.75 | 3.8                        | 3.878                                     | 3.688     |
| M5                     | 0.8  | 4.2                        | 4.334                                     | 4.134     |
| M6                     | 1    | 5                          | 5.153                                     | 4.917     |
| M7                     | 1    | 6                          | 6.153                                     | 5.917     |
| M8                     | 1.25 | 6.8                        | 6.912                                     | 6.647     |
| M8                     | 1    | 7                          | 7.153                                     | 6.917     |
| M9                     | 1.25 | 7.8                        | 7.912                                     | 7.647     |
| M10                    | 1.5  | 8.5                        | 8.676                                     | 8.376     |
| M10                    | 1.25 | 8.8                        | 8.912                                     | 8.647     |
| M10                    | 1    | 9                          | 9.153                                     | 8.917     |
| M11                    | 1.5  | 9.5                        | 9.676                                     | 9.376     |
| M12                    | 1.75 | 10.3                       | 10.441                                    | 10.106    |
| M12                    | 1.5  | 10.5                       | 10.676                                    | 10.376    |
| M12                    | 1.25 | 10.8                       | 10.912                                    | 10.647    |
| M12                    | 1    | 11                         | 11.153                                    | 10.917    |
| M14                    | 2    | 12                         | 12.21                                     | 11.835    |
| M14                    | 1.5  | 12.5                       | 12.676                                    | 12.376    |
| M14                    | 1    | 13                         | 13.153                                    | 12.917    |
| M16                    | 2    | 14                         | 14.21                                     | 13.835    |
| M16                    | 1.5  | 14.5                       | 14.676                                    | 14.376    |
| M16                    | 1    | 15                         | 15.15                                     | 14.917    |

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

| 公制螺纹<br>Metric Threads          |     |                            |  | 单位: mm<br>Unit:mm |  |
|---------------------------------|-----|----------------------------|--|-------------------|--|
| 美制粗牙螺纹规格<br>Specification (UNC) |     | 标准直径<br>Standard Hole Dia. | 2 级牙钻孔径<br>For JIS Class 2 Drill Hole Dia. |                   |  |
|                                 |     |                            | 最大<br>MAX                                  | 最小<br>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<br>Specification (UNF) |     | 标准直径<br>Standard Hole Dia. | 2 级牙钻孔径<br>For JIS Class 2 Drill Hole Dia. |                   |  |
|                                 |     |                            | 最大<br>MAX                                  | 最小<br>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<br>ISO Material<br>Group  | MC | 工件材料<br>Workpiece Material   | 含量<br>Content  | 抗拉强度<br>Tensile<br>Strength<br>N/mm <sup>2</sup> | 布氏硬度<br>Brinell<br>Hardness<br>HB | 洛氏硬度<br>Rockwell<br>Hardness<br>HRC |
|---|----|--|----------------|--|-----------------------------------|-------------------------------------|
| <br>钢<br>Steels  | P1 | 低碳钢, 长切屑<br>Low-carbon Steels, Long Chipping   | C<0.25%        | <530   | <125                              |                                     |
|   | P2 | 低碳钢, 短切屑, 易切钢<br>Low-carbon Steels, Short Chipping, Freecutting Steels   | C<0.25%        | <530   | <125                              |                                     |
|   | P3 | 高碳钢及中碳钢<br>High-carbon Steels, Medium-carbon Steels  | C>0.25%        | >530   | <220                              | <25                                 |
|   | P4 | 合金钢, 工具钢<br>Alloy Steels, Tool Steels  | C>0.25%        | 600-850  | <330                              | <35                                 |
|   | P5 | 合金钢, 工具钢<br>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<br>Ferritic Stainless Steels, Martensitic Stainless Steels, PH<br>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<br>High-strength Ferritic Stainless Steels, Martensitic Stainless<br>Steels, PH Stainless Steels | C=(0.1-0.6)%   | 900-1350   | 330-450                           | 35-48                               |
| <br>不锈钢<br>Stainless<br>Steels                                     | M1 | 奥氏体不锈钢<br>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<br>High-Strength Austenitic Stainless Steels and Cast Stainless<br>Steels                                    | C=(0.05-0.15)% | 600-800  | 150-230                           | <25                                 |
|   | M3 | 双相不锈钢<br>Duplex Stainless Steels   | C=(0.05-0.20)% | <800   | 135-275                           | <30                                 |
| <br>铸铁<br>Cast Iron  | K1 | 灰铸铁<br>Grey Cast Iron  |                | 125-500  | 120-290                           | <32                                 |
|   | K2 | 中等加工难度的合金铸铁, 球墨铸铁<br>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<br>Difficult High-alloy Cast Iron, Nodular Cast Iron   |                | >600   | 180-350                           | <43                                 |
| <br>有色材料<br>Non-ferrous<br>Materials                             | N1 | 锻造铝合金<br>Wrought Aluminium Alloys  |                | <520   | 60-90                             |                                     |
|   | N2 | 铸造铝合金<br>Cast Aluminium Alloys   | Si<12%         | <350   | 70-100                            |                                     |
|   | N3 | 铸造铝合金<br>Cast Aluminium Alloys   | Si>12%         | 200-320  | 60-120                            |                                     |
|   | N4 | 铜, 铜合金<br>Copper, Copper Alloys  |                | 200-650  | 60-200                            |                                     |
|   | N5 | 石墨, 复合材料<br>Graphite, CFK, CFRP Graphite, Composite Materials  |                | 600-1500   |                                   |                                     |
|   | N6 | 铝基复合材料(MMCs)<br>GFK, CFK Aluminium-based Composite Materials (MMCs)  |                | <700   | <210                              |                                     |
| <br>耐热合金钛合金<br>Heat-resistant<br>SuperAlloys,<br>Titanium Alloys | S1 | 铁基高温合金<br>Iron-based Heat-resistant Alloys   |                | 500-1200   | 160-260                           | 25-48                               |
|   | S2 | 钴基高温合金<br>Cobalt-based Heat-resistant Alloys   |                | 1000-1450  | 250-450                           | 25-48                               |
|   | S3 | 镍基高温合金<br>Nickel-based Heat-resistant Alloys   |                | 600-1700   | 160-450                           | <48                                 |
|   | S4 | 钛及钛合金<br>Titanium and Titanium Alloys  |                | 900-1600   | 300-400                           | 33-48                               |
| <br>高硬度硬材料<br>Hardened<br>Materials                              | H1 | 淬硬钢<br>Hardened Steels   |                |  |                                   | 45-55                               |
|   | H2 | 淬硬钢<br>Hardened Steels   |                |  |                                   | 55-60                               |
|   | H3 | 淬硬钢<br>Hardened Steels   |                |  |                                   | 60-65                               |
|   | H4 | 淬硬钢<br>Hardened Steels   |                |  |                                   | >65                                 |

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

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

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



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

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

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







+ 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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