

YAMAWA 螺絲攻選用參考基準表

◎ 最適用 ○ 適用

| 螺絲攻 | | 商品記號 | 適用機械 | | | | 低碳鋼 | 中碳鋼 | 高碳鋼 | 合金鋼 | 不銹鋼 | | 調質鋼 | | | | 鑄鐵 | | 銅 | 輕合金材 (鋁, 鎂, 鋅等合金) | | | | 鈦合金 | 鎳合金 | |
|------------|----------------|----------------|------------------|--------|------|----------------|------|-------------|-------|----------|---------------|---------------|-----------|-----------|-----------|-----------|----|-----|----|-------------------|------------|----|----|-----|-----|---|
| 種類 | 用途 | | 手動/氣動攻牙 | 一般攻牙機械 | 數控機械 | 數控機械 M/C . T/C | ~25C | S25C ~ S45C | S45C~ | SCM SNCM | SUS303 SUS304 | SUS316 SUS317 | 25~35 HRC | 35~45 HRC | 45~55 HRC | 50~63 HRC | FC | FCD | Cu | AL | ADC ZDC AC | Mg | Ti | Ni | | |
| 螺旋絲攻 (盲孔用) | 標準系列 | I 系列 (低速/手動用) | ISP | ◎ | ◎ | | | ◎ | ◎ | ○ | | | | | | | | | | | | | | | | |
| | | 標準型 | SP / OS-SP | ○ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | ○ | | | | | ○ | ○ | ○ | ○ | | | |
| | | | SP (OX) | ○ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | ○ | | ○ | | | | | ○ | ○ | ○ | ○ | | | |
| | | | LS-SP / OS-LS-SP | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | ○ | | | | | ○ | ○ | ○ | ○ | | | |
| | | + 系列 (中速度加工用) | +SP | | | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | ○ | | | | | ○ | ○ | ○ | ○ | | | |
| | | | AU+SP | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | | | | ○ | ◎ | ◎ | ◎ | | | |
| | 用途別系列 | X 系列 (中高速度加工用) | XSP | | | ◎ | ◎ | ◎ | ◎ | ○ | | ◎ | ○ | ○ | | | | | | ○ | ○ | ○ | | | | |
| | | | AUXSP | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | ○ | | | | | | ○ | ○ | ○ | | | | |
| | | | SUXSP | | | ◎ | ◎ | ◎ | ◎ | ○ | ○ | ◎ | ◎ | ○ | ○ | | | | | | | | | | | |
| | | 鋁合金用 | AL+SP | | ○ | ◎ | ◎ | | | | | | | | | | | | | ◎ | ◎ | ◎ | ◎ | | | |
| | | | AL-SP | | ○ | ◎ | ◎ | | | | | | | | | | | | | ◎ | ◎ | ◎ | ◎ | | | |
| | | 不銹鋼用 | SU+SP/SU-SP | | ○ | ◎ | ◎ | | | | ◎ | ◎ | ○ | | | | | | | | | | | | | |
| | | | SU2-SP | | ○ | ◎ | ◎ | | | ○ | ◎ | ◎ | ◎ | ○ | | | | | | | | | | | | |
| | | 深孔用 | S-SP/OS-S-SP | | ○ | ◎ | ◎ | ◎ | ○ | ◎ | ◎ | ○ | | ○ | | | | | | | | | | | | |
| | | 鈦合金專用 (超難切削材用) | ZET-B | | | ◎ | ◎ | | | ○ | ○ | | | ○ | ○ | | | ○ | ○ | | | | | ◎ | ○ | |
| | | 鎳基合金用 (超難切削材用) | ZEN-B | | | ◎ | ◎ | ◎ | ◎ | ○ | ◎ | ◎ | ◎ | ○ | ○ | | | | | | | | | | | ◎ |
| | | 高碳鋼用 | HC+SP/HC-SP | | ◎ | ◎ | ○ | | | ◎ | ◎ | ○ | ○ | | | | | | | ○ | ○ | ○ | ○ | | | |
| | | | HC+SP(OX) | | ◎ | ◎ | ○ | | | ◎ | ◎ | ○ | ○ | | | | | | | ○ | ○ | ○ | ○ | | | |
| 先端絲攻 (通孔用) | 標準系列 | I 系列 (低速/手動用) | IPO | ◎ | ◎ | | | ◎ | ◎ | | | | | | | | | | | | | | | | | |
| | | 標準型 | PO/OS-PO | ○ | ◎ | ◎ | ◎ | ○ | ◎ | ○ | | | | ○ | | | | | | ○ | ○ | ○ | ○ | | | |
| | | | PO(OX) | ○ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | ○ | | ○ | | | | | | ○ | ○ | ○ | ○ | | | |
| | | | LS-PO | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | ○ | | ○ | | | | | | ○ | ○ | ○ | ○ | | | |
| | | + 系列 (中速度加工用) | +PO | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | ○ | | ○ | | | | | ○ | ○ | ○ | ○ | | | |
| | | | AU+SL | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | | | | ○ | ◎ | ◎ | ◎ | | | |
| | X 系列 (中高速度加工用) | XSL | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | | | | ○ | ○ | ○ | | | | | |
| | | AUXSL | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | | | ○ | | ○ | ○ | ○ | | | | |
| | | SUXSL | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | ○ | | | | | | ○ | ○ | ○ | | | | |
| | 不銹鋼用 | SU+PO/SU-PO | | ○ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | ○ | | | | | | | | | | | | | | |
| | | SU+SL | | | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | | | | | | | | | | | | | |
| | 深孔用 | S-PO | | ○ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ○ | | | | | | | | | | | | | | | |
| | 難削材用 | EH-PO | | ○ | ◎ | ◎ | ◎ | | ○ | ○ | ○ | ○ | ◎ | ○ | | | | ○ | | | | | | | | |
| | 鈦合金專用 (超難切削材用) | ZET-P | | | ◎ | ◎ | | | | ○ | ○ | | ○ | ○ | | | | ○ | ○ | ○ | ○ | ○ | ◎ | | | |
| | 鎳基合金用 (超難切削材用) | ZEN-P | | | ◎ | ◎ | | | ○ | ○ | ○ | ○ | ○ | ○ | | | | | | | | | | | ◎ | |
| 高碳鋼用 | HC+PO/HC-PO | | ◎ | ◎ | ○ | | | ◎ | ◎ | | | | | | | | ○ | | | | | | | | | |

