

# 螺纹底孔直径表(挤压丝锥用) RECOMMENDED DRILL HOLE SIZE (FOR FLUTELSS TAPS)

## 公制螺纹 (NRT 丝锥) Metric screw threads (Nu-Roll tap)

红字 = JIS 粗牙螺攻  
Red character = JIS coarse pitch thread

(单位: mm)  
(Unit: mm)

螺纹尺寸 Thread size	旧 JIS 1 级螺攻 for JIS class 1 drill hole dia.			旧 JIS 2 级螺攻 for JIS class 2 drill hole dia.			4H			5H			6H		
	RH 精度 (μm)	最小~最大(嵌合率%) Min.~Max.(Thread Overlap Ratio)	RH 精度 (μm)	RH 精度 (μm)	最小~最大(嵌合率%) Min.~Max.(Thread Overlap Ratio)	RH 精度 (μm)	RH 精度 (μm)	最小~最大(嵌合率%) Min.~Max.(Thread Overlap Ratio)	RH 精度 (μm)	最小~最大(嵌合率%) Min.~Max.(Thread Overlap Ratio)	RH 精度 (μm)	最小~最大(嵌合率%) Min.~Max.(Thread Overlap Ratio)	RH 精度 (μm)	最小~最大(嵌合率%) Min.~Max.(Thread Overlap Ratio)	RH 精度 (μm)
<b>M 1 × 0.25</b>	2	0.87 ~ 0.89 (100%~85%)	4	0.90 ~ 0.92 (100%~80%)	2	0.875 ~ 0.889 (100%~85%)	4	0.901 ~ 0.920 (100%~80%)	—	—	—	—	—	—	
<b>1.1 × 0.25</b>	2	0.97 ~ 0.99 #	4	1.00 ~ 1.02 #	2	0.975 ~ 0.989 #	4	1.001 ~ 1.020 #	—	—	—	—	—	—	
<b>1.2 × 0.25</b>	2	1.07 ~ 1.09 #	4	1.10 ~ 1.12 #	2	1.075 ~ 1.089 #	4	1.101 ~ 1.120 #	—	—	—	—	—	—	
<b>1.4 × 0.3</b>	2	1.244 ~ 1.263 #	4	1.270 ~ 1.294 #	2	1.245 ~ 1.262 #	4	1.270 ~ 1.294 #	4	1.270 ~ 1.294 #	4	1.270 ~ 1.291 (100%~82%)	—	—	
<b>1.6 × 0.35</b>	2	1.41 ~ 1.44 (100%~80%)	4	1.44 ~ 1.48 (100%~75%)	2	1.415 ~ 1.442 (100%~80%)	4	1.440 ~ 1.466 (100%~81%)	4	1.440 ~ 1.466 (100%~81%)	4	1.440 ~ 1.475 (100%~75%)	—	—	
<b>1.6 × 0.2</b>	—	—	—	—	—	—	—	—	—	—	—	—	4	1.530 ~ 1.550 (100%~75%)	
※ <b>1.7 × 0.35</b>	—	—	4	*1.54 ~ 1.58 #	—	—	—	—	—	—	—	—	—	—	
<b>1.8 × 0.35</b>	2	1.61 ~ 1.64 (100%~80%)	4	1.64 ~ 1.68 #	2	1.615 ~ 1.634 (100%~86%)	4	1.640 ~ 1.666 (100%~81%)	4	1.640 ~ 1.666 (100%~81%)	4	1.640 ~ 1.675 (100%~75%)	—	—	
<b>2 × 0.4</b>	2	1.78 ~ 1.82 #	4	1.81 ~ 1.85 #	2	1.785 ~ 1.806 #	4	1.810 ~ 1.840 #	4	1.810 ~ 1.840 #	4	1.810 ~ 1.849 #	—	—	
<b>2 × 0.25</b>	2	1.88 ~ 1.89 #	—	—	2	1.875 ~ 1.888 (100%~87%)	4	1.901 ~ 1.918 (99%~82%)	—	—	—	—	—	—	
<b>2.2 × 0.45</b>	2	1.95 ~ 1.99 #	4	1.98 ~ 2.03 (100%~75%)	2	1.955 ~ 1.979 (100%~86%)	4	1.980 ~ 2.012 (100%~82%)	4	1.980 ~ 2.012 (100%~82%)	4	1.980 ~ 2.024 (100%~75%)	—	—	
※ <b>2.3 × 0.4</b>	—	—	4	*2.11 ~ 2.15 #	—	—	—	—	—	—	—	—	—	—	
<b>2.5 × 0.45</b>	2	2.25 ~ 2.29 (100%~80%)	4	2.28 ~ 2.33 #	2	2.255 ~ 2.279 (100%~86%)	4	2.280 ~ 2.312 (100%~82%)	4	2.280 ~ 2.312 (100%~82%)	4	2.280 ~ 2.324 (100%~75%)	—	—	
※ <b>2.6 × 0.45</b>	—	—	4	*2.38 ~ 2.43 #	—	—	—	—	—	—	—	—	—	—	
※ <b>3 × 0.6</b>	3	2.68 ~ 2.70 (100%~90%)	5	2.70 ~ 2.73 (100%~90%)	—	—	—	—	—	—	—	—	—	—	
<b>3 × 0.5</b>	3	2.74 ~ 2.78 (100%~80%)	5	2.76 ~ 2.81 (100%~75%)	3	2.737 ~ 2.764 (100%~86%)	5	2.762 ~ 2.798 (100%~82%)	5	2.762 ~ 2.812 (100%~75%)	5	2.762 ~ 2.812 (100%~75%)	—	—	
<b>3.5 × 0.6</b>	3	3.18 ~ 3.21 (100%~85%)	5	3.20 ~ 3.26 #	3	3.177 ~ 3.210 #	5	3.202 ~ 3.242 (100%~83%)	5	3.202 ~ 3.250 (100%~80%)	5	3.202 ~ 3.250 (100%~80%)	—	—	
※ <b>4 × 0.75</b>	4	3.60 ~ 3.64 #	6	3.62 ~ 3.67 (100%~85%)	—	—	—	—	—	—	—	—	—	—	
<b>4 × 0.7</b>	4	3.63 ~ 3.67 #	6	3.65 ~ 3.70 #	4	3.63 ~ 3.66 (100%~88%)	4	3.63 ~ 3.67 (100%~85%)	6	3.66 ~ 3.69 (100%~85%)	6	3.66 ~ 3.69 (100%~85%)	—	—	
<b>4.5 × 0.75</b>	4	4.10 ~ 4.14 #	6	4.12 ~ 4.18 (100%~80%)	4	4.10 ~ 4.13 #	4	4.10 ~ 4.14 #	6	4.13 ~ 4.18 (100%~80%)	6	4.13 ~ 4.18 (100%~80%)	—	—	
※ <b>5 × 0.9</b>	4	4.51 ~ 4.56 #	6	4.53 ~ 4.59 (100%~85%)	—	—	—	—	—	—	—	—	—	—	
<b>5 × 0.8</b>	4	4.57 ~ 4.62 #	6	4.59 ~ 4.66 (100%~80%)	4	4.57 ~ 4.60 (100%~88%)	4	4.57 ~ 4.61 (100%~85%)	6	4.60 ~ 4.65 (100%~80%)	6	4.60 ~ 4.65 (100%~80%)	—	—	
<b>6 × 1</b>	4	5.45 ~ 5.51 #	7	5.48 ~ 5.57 #	4	5.45 ~ 5.49 #	4	5.45 ~ 5.50 #	7	5.49 ~ 5.56 #	7	5.49 ~ 5.56 #	—	—	
<b>7 × 1</b>	4	6.45 ~ 6.51 #	7	6.48 ~ 6.57 #	4	6.45 ~ 6.49 (100%~89%)	4	6.45 ~ 6.50 #	7	6.49 ~ 6.56 #	7	6.49 ~ 6.56 #	—	—	
<b>8 × 1.25</b>	5	7.31 ~ 7.38 #	7	7.34 ~ 7.41 (100%~85%)	5	7.31 ~ 7.36 (100%~90%)	7	7.34 ~ 7.40 (100%~87%)	7	7.34 ~ 7.41 (100%~85%)	7	7.34 ~ 7.41 (100%~85%)	—	—	
<b>8 × 1</b>	4	7.45 ~ 7.51 #	7	7.48 ~ 7.57 (100%~80%)	4	7.45 ~ 7.48 (100%~91%)	4	7.45 ~ 7.50 (100%~85%)	7	7.49 ~ 7.56 (100%~80%)	7	7.49 ~ 7.56 (100%~80%)	—	—	
<b>10 × 1.5</b>	5	9.16 ~ 9.22 (100%~90%)	7	9.18 ~ 9.28 (100%~85%)	5	9.16 ~ 9.21 #	7	9.19 ~ 9.24 (100%~90%)	7	9.19 ~ 9.27 (100%~85%)	7	9.19 ~ 9.27 (100%~85%)	—	—	
<b>10 × 1.25</b>	5	9.31 ~ 9.38 (100%~85%)	7	9.34 ~ 9.41 #	5	9.31 ~ 9.36 (100%~90%)	7	9.34 ~ 9.40 (100%~87%)	7	9.34 ~ 9.41 #	7	9.34 ~ 9.41 #	—	—	
<b>10 × 1</b>	5	9.46 ~ 9.52 #	7	9.48 ~ 9.57 (100%~80%)	5	9.47 ~ 9.50 #	5	9.47 ~ 9.52 (100%~85%)	7	9.49 ~ 9.56 (100%~80%)	7	9.49 ~ 9.56 (100%~80%)	—	—	
<b>12 × 1.75</b>	5	11.01 ~ 11.08 (100%~90%)	8	11.05 ~ 11.15 (100%~85%)	5	11.01 ~ 11.07 (100%~91%)	8	11.05 ~ 11.11 (100%~90%)	8	11.05 ~ 11.15 (100%~85%)	8	11.05 ~ 11.15 (100%~85%)	—	—	
<b>12 × 1.5</b>	5	11.16 ~ 11.22 #	7	11.18 ~ 11.28 #	5	11.16 ~ 11.21 #	7	11.19 ~ 11.24 #	7	11.19 ~ 11.27 #	7	11.19 ~ 11.27 #	—	—	
<b>12 × 1.25</b>	5	11.31 ~ 11.38 (100%~85%)	7	11.34 ~ 11.41 #	5	11.31 ~ 11.36 (100%~90%)	7	11.34 ~ 11.40 (100%~87%)	7	11.34 ~ 11.41 #	7	11.34 ~ 11.41 #	—	—	
<b>12 × 1</b>	5	11.46 ~ 11.52 #	7	11.48 ~ 11.57 (100%~80%)	5	11.47 ~ 11.50 #	5	11.47 ~ 11.52 (100%~85%)	7	11.49 ~ 11.56 (100%~80%)	7	11.49 ~ 11.56 (100%~80%)	—	—	
<b>14 × 2</b>	6	12.83 ~ 12.95 (100%~90%)	10	12.92 ~ 13.04 (100%~85%)	6	12.88 ~ 12.93 (100%~92%)	10	12.93 ~ 13.00 (100%~90%)	10	12.93 ~ 13.04 (100%~85%)	10	12.93 ~ 13.04 (100%~85%)	—	—	
<b>14 × 1.5</b>	5	13.16 ~ 13.22 #	9	13.21 ~ 13.30 #	5	13.16 ~ 13.21 (100%~91%)	9	13.21 ~ 13.27 #	9	13.21 ~ 13.30 #	9	13.21 ~ 13.30 #	—	—	
<b>16 × 2</b>	6	14.87 ~ 14.95 #	10	14.92 ~ 15.04 #	6	14.88 ~ 14.93 (100%~92%)	6	14.88 ~ 14.95 #	10	14.93 ~ 15.04 #	10	14.93 ~ 15.04 #	—	—	
<b>16 × 1.5</b>	5	15.16 ~ 15.22 #	9	15.21 ~ 15.30 (100%~80%)	5	15.16 ~ 15.21 (100%~91%)	9	15.21 ~ 15.27 #	9	15.21 ~ 15.30 #	9	15.21 ~ 15.30 #	—	—	
<b>18 × 2.5</b>	6	16.57 ~ 16.67 #	11	16.63 ~ 16.78 (100%~85%)	6	16.57 ~ 16.64 (100%~92%)	11	16.64 ~ 16.73 #	11	16.64 ~ 16.78 #	11	16.64 ~ 16.78 #	—	—	
<b>18 × 1.5</b>	6	17.17 ~ 17.23 #	10	17.22 ~ 17.31 #	6	17.18 ~ 17.22 (100%~91%)	6	17.18 ~ 17.23 #	10	17.23 ~ 17.31 #	10	17.23 ~ 17.31 #	—	—	
<b>20 × 2.5</b>	6	18.57 ~ 18.67 #	11	18.63 ~ 18.78 #	6	18.57 ~ 18.64 (100%~92%)	11	18.64 ~ 18.73 #	11	18.64 ~ 18.78 #	11	18.64 ~ 18.78 #	—	—	
<b>20 × 1.5</b>	6	19.17 ~ 19.23 #	10	19.22 ~ 19.31 #	6	19.18 ~ 19.22 (100%~91%)	6	19.18 ~ 19.23 #	10	19.23 ~ 19.31 #	10	19.23 ~ 19.31 #	—	—	
<b>22 × 2.5</b>	—	—	11	20.63 ~ 20.78 (100%~85%)	—	—	—	—	11	20.63 ~ 20.78 (100%~85%)	11	20.63 ~ 20.78 (100%~85%)	—	—	
<b>22 × 1.5</b>	—	—	10	21.22 ~ 21.31 #	—	—	—	—	10	21.22 ~ 21.31 #	10	21.22 ~ 21.31 #	—	—	
<b>24 × 3</b>	—	—	13	22.36 ~ 22.53 #	—	—	—	—	13	22.36 ~ 22.53 #	13	22.36 ~ 22.53 #	—	—	
<b>24 × 1.5</b>	—	—	10	23.22 ~ 23.31 #	—	—	—	—	10	23.22 ~ 23.31 #	10	23.22 ~ 23.31 #	—	—	
<b>27 × 3</b>	—	—	13	25.36 ~ 25.53 #	—	—	—	—	13	25.36 ~ 25.53 #	13	25.36 ~ 25.53 #	—	—	
<b>30 × 3.5</b>	—	—	14	28.07 ~ 28.25 #	—	—	—	—	14	28.07 ~ 28.25 #	14	28.07 ~ 28.25 #	—	—	
<b>33 × 3.5</b>	—	—	14	31.07 ~ 31.25 #	—	—	—	—	14	31.07 ~ 31.25 #	14	31.07 ~ 31.25 #	—	—	
<b>36 × 4</b>	—	—	15	33.78 ~ 33.99 #	—	—	—	—	15	33.78 ~ 33.99 #	15	33.78 ~ 33.99 #	—	—	
<b>42 × 4.5</b>	—	—	16	39.49 ~ 39.71 #	—	—	—	—	16	39.49 ~ 39.71 #	16	39.49 ~ 39.71 #	—	—	
<b>45 × 4.5</b>	—	—	16	42.49 ~ 42.71 #	—	—	—	—	16	42.49 ~ 42.71 #	16	42.49 ~ 42.71 #	—	—	

4H~6H 根据 JIS B 0209-2001。  
粗牙尺寸根据 JIS B 0209-1982 附属书 1。  
细牙尺寸根据 JIS B 0209-1982 附属书。  
印\*是根据 JIS B0209-1982 附属书 2。  
印※ JIS 已经废除。

4H~6H corresponds to JIS B 0209-2001.  
Coarse thread sizes correspond to the appendix 1 of JIS B 0209-1982.  
Fine pitch thread sizes correspond to the appendix of JIS B 0211-1982.  
\*Corresponds to the appendix 2 of JIS B 0209-1982.  
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1. 上表的底孔径会因工件材质不同而变化, 仅供参考。
2. 底孔径会因材质, 硬度, 形状尺寸等因素而变化, 请事先进行试加工。
3. 底孔稍大会利于延长寿命, 请根据加工目的合理选择。
4. 底孔的变形, 错位会导致加工问题, 请注意。

1. The proper drill hole size may change due to material variety. Use the recommended drill hole size as a benchmark.
2. As the hole diameter may vary by behavior of plasticity depending on the material, hardness and shapes of workpiece, the hole diameter should be determined through trial tapping prior to final machining.
3. A larger drill hole size is better for extending tool life. Select a drill hole size based on your particular application.
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## 公制螺纹 (HRT 丝锥) Metric screw threads (HI-Roll tap)

红字 = JIS 粗牙螺纹 (Red character = JIS coarse pitch thread) (单位: mm) (Unit: mm)

螺纹尺寸 Thread size	旧 JIS 1 级螺纹 for JIS class 1 drill hole dia.			旧 JIS 2 级螺纹 for JIS class 2 drill hole dia.			4H			5H			6H		
	RH 精度 RH(Lite)	最小~最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)		RH 精度 RH(Lite)	最小~最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)		RH 精度 RH(Lite)	最小~最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)		RH 精度 RH(Lite)	最小~最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)		RH 精度 RH(Lite)	最小~最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio)	
M 1 × 0.25	2	0.858 ~ 0.879 (100%~85%)		4	0.858 ~ 0.887 (100%~80%)		2	0.860 ~ 0.879 (100%~85%)		4	0.858 ~ 0.886 (100%~80%)				
1.2 × 0.25	2	1.058 ~ 1.079 #		4	1.058 ~ 1.087 #		2	1.060 ~ 1.079 #		4	1.058 ~ 1.086 #				
1.4 × 0.3	2	1.23 ~ 1.26 #		4	1.23 ~ 1.26 #		2	1.230 ~ 1.255 #		4	1.230 ~ 1.263 #		4	1.230 ~ 1.263 (100%~80%)	
1.6 × 0.35	2	1.40 ~ 1.44 (100%~80%)		4	1.40 ~ 1.45 (100%~75%)		2	1.410 ~ 1.431 #		4	1.402 ~ 1.441 #		4	1.402 ~ 1.451 (100%~75%)	
※ 1.7 × 0.35	—	—		4	*1.50 ~ 1.55 #		—	—		—	—		—	—	
1.8 × 0.35	2	1.60 ~ 1.64 (100%~80%)		4	1.60 ~ 1.65 #		2	1.610 ~ 1.631 (100%~85%)		4	1.602 ~ 1.641 (100%~80%)		4	1.602 ~ 1.651 (100%~75%)	
2 × 0.4	2	1.77 ~ 1.82 #		4	1.77 ~ 1.82 (100%~80%)		2	1.78 ~ 1.80 (100%~86%)		4	1.78 ~ 1.81 #		4	1.78 ~ 1.81 (100%~80%)	
2 × 0.25	2	1.858 ~ 1.887 #		—	—		—	—		4	1.858 ~ 1.886 #		—	—	
※ 2.3 × 0.4	—	—		4	*2.07 ~ 2.13 (100%~75%)		—	—		—	—		—	—	
2.5 × 0.45	3	2.24 ~ 2.30 (100%~80%)		5	2.24 ~ 2.31 #		3	2.25 ~ 2.28 (100%~86%)		3	2.25 ~ 2.30 (100%~75%)		5	2.25 ~ 2.30 (100%~75%)	
※ 2.6 × 0.45	—	—		5	*2.34 ~ 2.41 #		—	—		—	—		—	—	
※ 3 × 0.6	3	2.72 ~ 2.73 (100%~90%)		5	2.66 ~ 2.73 (100%~90%)		—	—		—	—		—	—	
3 × 0.5	5	2.72 ~ 2.77 (100%~80%)		6	2.72 ~ 2.78 (100%~75%)		3	2.72 ~ 2.75 (100%~85%)		5	2.72 ~ 2.77 (100%~80%)		6	2.72 ~ 2.78 (100%~75%)	
3 × 0.35	3	2.80 ~ 2.84 #		5	2.80 ~ 2.85 #		3	2.81 ~ 2.83 #		3	2.81 ~ 2.84 #		5	2.81 ~ 2.85 #	
3.5 × 0.6	3	3.16 ~ 3.21 (100%~85%)		5	3.16 ~ 3.25 #		3	3.16 ~ 3.21 #		5	3.16 ~ 3.21 (100%~85%)		5	3.16 ~ 3.24 #	
※ 4 × 0.75	3	3.57 ~ 3.64 #		6	3.57 ~ 3.64 (100%~85%)		—	—		—	—		—	—	
4 × 0.7	6	3.60 ~ 3.66 #		7	3.60 ~ 3.66 #		4	3.61 ~ 3.65 (100%~87%)		6	3.61 ~ 3.66 (100%~85%)		7	3.61 ~ 3.66 (100%~85%)	
4 × 0.5	3	3.71 ~ 3.77 (100%~80%)		6	3.71 ~ 3.79 (100%~75%)		3	3.72 ~ 3.75 (100%~85%)		5	3.72 ~ 3.77 (100%~80%)		6	3.72 ~ 3.78 (100%~75%)	
※ 5 × 0.9	3	4.49 ~ 4.59 (100%~85%)		7	4.49 ~ 4.59 (100%~85%)		—	—		—	—		—	—	
5 × 0.8	3	4.55 ~ 4.62 #		8	4.55 ~ 4.64 (100%~80%)		5	4.55 ~ 4.60 (100%~88%)		6	4.55 ~ 4.61 (100%~85%)		8	4.55 ~ 4.63 (100%~80%)	
5 × 0.5	3	4.72 ~ 4.77 (100%~80%)		6	4.72 ~ 4.79 (100%~75%)		3	4.72 ~ 4.75 (100%~85%)		5	4.72 ~ 4.77 (100%~80%)		6	4.72 ~ 4.78 (100%~75%)	
6 × 1	4	5.43 ~ 5.52 (100%~85%)		7	5.43 ~ 5.55 (100%~80%)		4	5.44 ~ 5.50 (100%~88%)		7	5.44 ~ 5.51 (100%~85%)		7	5.44 ~ 5.54 (100%~80%)	
6 × 0.75	3	5.57 ~ 5.64 #		7	5.57 ~ 5.66 #		5	5.58 ~ 5.63 (100%~87%)		7	5.58 ~ 5.63 #		7	5.58 ~ 5.65 #	

4H~6H 根据 JIS B 0209-2001。  
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钻头  
DRILLS

丝锥  
TAPS

TAP LIMIT AND  
DRILL HOLE SIZE  
精度与  
底孔径

量规  
GAGES

板条  
ROUNDOVERS

滚压工具  
ROLLING TOOLS

各种产品  
OTHER PRODUCTS

索引  
INDEX

THREAD MILL  
螺纹铣刀

FLUTELESS  
TAP  
挤压丝锥

SPIRAL FLUTED  
TAP  
螺旋槽丝锥

SPIRAL POINTED  
TAP  
刃倾角  
丝锥

HAND TAP  
直槽丝锥

TAPER PIPE  
THREADS (LH)  
锥管螺纹用丝锥  
(英式)

PARALLEL PIPE  
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(美式)

INSERT SCREW  
THREAD TAP  
嵌套螺纹用  
丝锥

NUT TAP  
螺母丝锥

MACHINING  
CENTER TAP  
加工中心  
用丝锥

DRILL TAP  
钻攻一体  
丝锥