

螺纹底孔直径表 RECOMMENDED DRILL HOLE SIZE

嵌套螺纹用请参考 P 8 4 3。For screw thread insert: Please refer to p.843

公制螺纹

Metric screw threads
JIS B 0209-1:2007 (单位: mm)
JIS B 8031-2007 (Unit: mm)

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

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最大底孔径 Max. drill hole dia.				
		各精度通用	旧JIS级用	4H用	5H用	6H用
M 1 x 0.25	0.75	0.73	0.78	0.77	0.78	0.8
* 1 x 0.2	0.8	0.79	—	0.82	0.83	0.84
1.1 x 0.25	0.85	0.83	0.88	0.87	0.88	0.9
* 1.1 x 0.2	0.9	0.89	—	0.92	0.93	0.94
1.2 x 0.25	0.95	0.93	0.98	0.97	0.98	1
* 1.2 x 0.2	1	0.99	—	1.02	1.03	1.04
1.4 x 0.3	1.1	1.08	1.14	1.12	1.14	1.16
* 1.4 x 0.2	1.2	1.19	—	1.22	1.23	1.24
1.6 x 0.35	1.25	1.23	1.32	1.28	1.3	1.32
* 1.6 x 0.2	1.4	1.39	—	1.42	1.43	1.44
* 1.7 x 0.35	1.35	—	—	1.38	1.4	1.42
* 1.7 x 0.3	1.4	—	—	1.42	1.44	1.46
* 1.7 x 0.25	1.45	—	—	1.47	1.48	1.5
* 1.7 x 0.2	1.5	—	—	1.52	1.53	1.54
1.8 x 0.35	1.45	1.43	1.52	1.48	1.5	1.52
* 1.8 x 0.2	1.6	1.59	—	1.62	1.63	1.64
2 x 0.4	1.6	1.57	1.67	1.63	1.65	1.67
* 2 x 0.25	1.75	1.73	—	1.77	1.78	1.8
2.2 x 0.45	1.75	1.72	1.83	1.79	1.81	1.83
* 2.2 x 0.25	1.95	1.93	—	1.97	1.98	2
* 2.3 x 0.4	1.9	—	—	1.93	1.95	1.97
* 2.3 x 0.35	1.95	—	—	1.98	2	2.02
* 2.3 x 0.25	2.05	—	—	2.07	2.08	2.1
2.5 x 0.45	2.05	2.02	2.13	2.09	2.11	2.13
2.5 x 0.35	2.15	2.13	2.22	2.18	2.2	2.22
* 2.6 x 0.45	2.15	—	—	2.19	2.22	2.23
* 2.6 x 0.35	2.25	—	—	2.28	2.3	2.32
* 3 x 0.6	2.4	2.35	2.42	2.45	2.47	2.51
3 x 0.5	2.5	2.46	2.59	2.54	2.57	2.59
3 x 0.35	2.65	2.63	2.72	2.68	2.7	2.72
3.5 x 0.6	2.9	2.85	3.01	2.95	2.97	3.01
* 3.5 x 0.5	3	2.96	—	3.04	3.07	3.09
3.5 x 0.35	3.15	3.13	3.22	3.18	3.2	3.22
4 x 0.75	3.25	3.19	3.32	3.3	3.33	3.37
4 x 0.7	3.3	3.25	3.42	3.35	3.38	3.42
4 x 0.5	3.5	3.46	3.59	3.54	3.57	3.59
4.5 x 0.75	3.75	3.69	3.87	3.8	3.83	3.87
4.5 x 0.5	4	3.96	4.09	4.04	4.07	4.09
* 5 x 0.9	4.1	—	—	4.15	4.19	4.23
5 x 0.8	4.2	4.14	4.33	4.25	4.29	4.33
* 5 x 0.75	4.25	4.19	—	4.3	4.33	4.37
5 x 0.5	4.5	4.46	4.59	4.54	4.57	4.59
* 5.5 x 0.9	4.6	—	—	4.65	4.69	4.73
* 5.5 x 0.75	4.75	—	—	4.8	4.83	4.87
5.5 x 0.5	5	4.96	5.09	5.04	5.07	5.09
6 x 1	5	4.92	5.15	5.06	5.1	5.15
6 x 0.75	5.25	5.19	5.37	5.3	5.33	5.37
* 6 x 0.5	5.5	—	—	5.54	5.57	5.59
7 x 1	6	5.92	6.15	6.06	6.1	6.15
7 x 0.75	6.25	6.19	6.37	6.3	6.33	6.37

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最大底孔径 Max. drill hole dia.				
		各精度通用	旧JIS级用	4H用	5H用	6H用
* 7 x 0.5	6.5	—	—	6.54	6.57	6.59
8 x 1.25	6.75	6.65	6.91	6.81	6.85	6.91
8 x 1	7	6.92	7.15	7.06	7.1	7.15
8 x 0.75	7.25	7.19	7.37	7.3	7.33	7.37
* 8 x 0.5	7.5	—	—	7.54	7.57	7.59
9 x 1.25	7.75	7.65	7.91	7.81	7.85	7.91
9 x 1	8	7.92	8.15	8.06	8.1	8.15
9 x 0.75	8.25	8.19	8.37	8.3	8.33	8.37
* 9 x 0.5	8.5	—	—	8.54	8.57	8.59
10 x 1.5	8.5	8.38	8.67	8.52	8.61	8.67
10 x 1.25	8.75	8.65	8.91	8.81	8.85	8.91
10 x 1	9	8.92	9.15	9.06	9.1	9.15
10 x 0.75	9.25	9.19	9.37	9.3	9.33	9.37
* 10 x 0.5	9.5	—	—	9.54	9.57	9.59
11 x 1.5	9.5	9.38	9.67	9.52	9.61	9.67
11 x 1.25	9.75	9.65	9.8	9.81	9.85	9.91
11 x 1	10	9.92	10.15	10.06	10.1	10.15
11 x 0.75	10.25	10.19	10.37	10.3	10.33	10.37
* 11 x 0.5	10.5	—	—	10.54	10.57	10.59
12 x 1.75	10.25	10.11	10.44	10.31	10.37	10.44
12 x 1.5	10.5	10.38	10.67	10.56	10.61	10.67
12 x 1.25	10.75	10.65	10.91	10.81	10.85	10.91
12 x 1	11	10.92	11.15	11.06	11.1	11.15
* 12 x 0.75	11.25	—	—	11.3	11.33	11.37
* 12 x 0.5	11.5	—	—	11.54	11.57	11.59
* 13 x 1.75	11.25	—	—	11.31	11.37	11.44
* 13 x 1.5	11.5	—	—	11.56	11.61	11.67
* 13 x 1.25	11.75	—	—	11.81	11.85	11.91
* 13 x 1	12	—	—	12.06	12.1	12.15
* 13 x 0.75	12.3	—	—	12.3	12.33	12.37
* 13 x 0.5	12.5	—	—	12.54	12.57	12.59
14 x 2	12	11.84	12.21	12.07	12.13	12.21
14 x 1.5	12.5	12.38	12.67	12.56	12.61	12.67
14 x 1.25	12.75	12.65	—	—	—	12.91
14 x 1	13	12.92	13.15	13.06	13.1	13.15
* 14 x 0.75	13.3	—	—	13.3	13.33	13.37
* 14 x 0.5	13.5	—	—	13.54	13.57	13.59
* 15 x 2	13	—	—	13.07	13.13	13.21
15 x 1.5	13.5	13.4	13.6	13.56	13.61	13.67
15 x 1.25	13.8	13.7	13.9	13.81	13.85	13.91
15 x 1	14	13.95	14.15	14.06	14.1	14.15
* 15 x 0.75	14.3	—	—	14.3	14.33	14.37
* 15 x 0.5	14.5	—	—	14.54	14.57	14.59
16 x 2	14	13.9	14.2	14.07	14.13	14.21
16 x 1.5	14.5	14.4	14.6	14.56	14.61	14.67
* 16 x 1.25	14.75	14.65	—	14.81	14.85	14.91
16 x 1	15	14.95	15.15	15.06	15.1	15.15
* 16 x 0.75	15.25	15.19	—	15.3	15.33	15.37
16 x 0.5	15.5	15.46	15.52	15.54	15.57	15.59
* 17 x 2	15	—	—	15.07	15.13	15.21

* 推荐底孔径为旧JIS2级内螺纹用。
* JIS规格中没有的内螺纹底孔为参考值。

The recommended tap limit corresponds to the old JIS class 2 internal thread standard.
* Recommended drill hole diameters that are not listed in JIS are reference values.

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嵌套螺纹用请参考 P 8 4 3。For screw thread insert: Please refer to p.843

公制螺纹

Metric screw threads

JIS B 0209-1:2007(单位: mm)
JIS B 8031-2007(Unit: mm)

红字 = JIS 粗牙螺纹

Red character = JIS coarse pitch thread

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最大底孔径 Max. drill hole dia.				
		各精度通用	旧 JIS 级用	4H 用	5H 用	6H 用
17 X 1.5	15.5	15.4	15.68	15.56	15.61	15.67
* 17 X 1.25	15.8	—	—	15.81	15.85	15.91
17 X 1	16	15.95	16.15	16.06	16.1	16.15
* 17 X 0.75	16.3	—	—	16.3	16.33	16.37
* 17 X 0.5	16.5	—	—	16.54	16.57	16.59
18 X 2.5	15.5	15.3	15.7	15.57	15.64	15.74
18 X 2	16	15.9	16.2	16.07	16.13	16.21
18 X 1.5	16.5	16.4	16.6	16.56	16.61	16.67
* 18 X 1.25	16.75	16.65	—	16.81	16.85	16.91
18 X 1	17	16.95	17.15	17.06	17.1	17.15
* 18 X 0.75	17.25	17.19	—	17.3	17.33	17.37
18 X 0.5	17.5	17.46	17.52	17.54	17.57	17.59
* 19 X 2.5	16.5	—	—	16.57	16.64	16.74
* 19 X 2	17	—	—	17.07	17.13	17.21
* 19 X 1.5	17.5	—	—	17.56	17.61	17.67
* 19 X 1.25	17.8	—	—	17.81	17.85	17.91
* 19 X 1	18	—	—	18.06	18.1	18.15
* 19 X 0.75	18.3	—	—	18.3	18.33	18.37
* 19 X 0.5	18.5	—	—	18.54	18.57	18.59
20 X 2.5	17.5	17.3	17.7	17.57	17.64	17.74
20 X 2	18	17.9	18.2	18.07	18.13	18.21
20 X 1.5	18.5	18.4	18.6	18.56	18.61	18.67
* 20 X 1.25	18.75	18.65	—	18.81	18.85	18.91
20 X 1	19	18.95	19.15	19.06	19.1	19.15
20 X 0.5	19.5	19.46	19.52	19.54	19.57	19.59
* 21 X 2.5	18.5	—	—	18.57	18.64	18.74
* 21 X 1.5	19.5	—	—	19.56	19.61	19.67
* 21 X 1	20	—	—	20.06	20.1	20.15
22 X 2.5	19.5	19.3	19.7	19.57	19.64	19.74
22 X 2	20	19.9	20.2	20.07	20.13	20.21
22 X 1.5	20.5	20.4	20.6	20.56	20.61	20.67
22 X 1	21	20.95	21.15	21.06	21.1	21.15
22 X 0.5	21.5	21.46	21.52	21.54	21.57	21.59
* 23 X 2.5	20.5	—	—	20.57	20.64	20.74
* 23 X 2	21	—	—	21.07	21.13	21.21
* 23 X 1.5	21.5	—	—	21.56	21.61	21.67
* 23 X 1	22	—	—	22.06	22.1	22.15
24 X 3	21	20.8	21.2	21.06	21.15	21.25
* 24 X 2.5	21.5	21.29	—	21.57	21.64	21.74
24 X 2	22	21.9	22.2	22.07	22.13	22.21
24 X 1.5	22.5	22.4	22.6	22.56	22.61	22.67
* 24 X 1.25	22.75	22.65	—	22.81	22.85	22.91
24 X 1	23	22.95	23.15	23.06	23.1	23.15
* 25 X 3	22	—	—	22.06	22.15	22.25
25 X 2	23	22.9	23.2	23.07	23.13	23.21
25 X 1.5	23.5	23.4	23.6	23.56	23.61	23.67
25 X 1	24	23.95	24.15	24.06	24.1	24.15
* 26 X 3	23	—	—	23.06	23.15	23.25
* 26 X 2	24	—	—	24.07	24.13	24.21
26 X 1.5	24.5	24.4	24.6	24.56	24.61	24.67

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最大底孔径 Max. drill hole dia.				
		各精度通用	旧 JIS 级用	4H 用	5H 用	6H 用
26 X 1	25	24.95	25.15	25.06	25.1	25.15
27 X 3	24	23.8	24.2	24.06	24.15	24.25
* 27 X 2.5	24.5	—	—	24.57	24.64	24.74
27 X 2	25	24.9	25.2	25.07	25.13	25.21
27 X 1.5	25.5	25.4	25.6	25.56	25.61	25.67
27 X 1	26	25.95	26.15	26.06	26.1	26.15
* 28 X 3	25	—	—	25.06	25.15	25.25
28 X 2	26	25.9	26.2	26.07	26.13	26.21
28 X 1.5	26.5	26.4	26.6	26.56	26.61	26.67
28 X 1	27	26.95	27.15	27.06	27.1	27.15
30 X 3.5	26.5	26.3	26.7	26.56	26.66	26.77
30 X 3	27	26.8	27.2	27.06	27.15	27.25
30 X 2	28	27.9	28.2	28.07	28.13	28.21
30 X 1.5	28.5	28.4	28.6	28.56	28.61	28.67
30 X 1	29	28.95	29.15	29.06	29.1	29.15
* 32 X 3	29	—	—	29.06	29.15	29.25
32 X 2	30	29.9	30.2	30.07	30.13	30.21
32 X 1.5	30.5	30.4	30.6	30.56	30.61	30.67
32 X 1	31	30.95	31.15	31.06	31.1	—
33 X 3.5	29.5	29.3	29.7	29.56	29.66	29.77
33 X 3	30	29.8	30.2	30.06	30.15	30.25
33 X 2	31	30.9	31.2	31.07	31.13	31.21
33 X 1.5	31.5	31.4	31.6	31.56	31.61	31.67
* 33 X 1	32	—	—	32.06	32.1	32.15
* 34 X 3	31	—	—	31.06	31.15	31.25
* 34 X 2	32	—	—	32.07	32.13	32.21
* 34 X 1.5	32.5	—	—	32.56	32.61	32.67
* 34 X 1	33	—	—	33.06	33.1	33.15
* 35 X 3	32	—	—	32.06	32.15	32.25
* 35 X 2	33	—	—	33.07	33.13	33.2
35 X 1.5	33.5	33.4	33.6	33.56	33.61	33.67
* 35 X 1	34	—	—	34.06	34.1	34.15
36 X 4	32	31.7	32.2	32.04	32.14	32.27
36 X 3	33	32.8	33.2	33.06	33.15	33.25
36 X 2	34	33.9	34.2	34.07	34.13	34.21
36 X 1.5	34.5	34.4	34.6	34.56	34.61	34.67
* 36 X 1	35	—	—	35.06	35.1	35.15
* 37 X 1.5	35.5	—	—	35.56	35.61	35.67
* 37 X 1	36	—	—	36.06	36.1	36.15
* 38 X 4	34	—	—	34.04	34.14	34.27
* 38 X 3	35	—	—	35.06	35.15	35.25
* 38 X 2	36	—	—	36.07	36.13	36.21
38 X 1.5	36.5	36.4	36.6	36.56	36.61	36.67
38 X 1	37	36.95	37.15	37.06	37.1	37.15
39 X 4	35	34.7	35.2	35.04	35.14	35.27
39 X 3	36	35.8	36.2	36.06	36.15	36.25
39 X 2	37	36.9	37.2	37.07	37.13	37.21
39 X 1.5	37.5	37.4	37.6	37.56	37.61	37.67
* 39 X 1	38	—	—	38.06	38.1	38.15
* 40 X 4	36	—	—	36.04	36.14	36.27

※ 推荐底孔径为旧 JIS2 级内螺纹用。
※ JIS 规格中没有的内螺纹底孔为参考值。

The recommended tap limit corresponds to the old JIS class 2 internal thread standard.
※ Recommended drill hole diameters that are not listed in JIS are reference values.

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公制螺纹

Metric screw threads

JIS B 0209-1: 2007(单位: mm)
JIS B 8031-2007(Unit: mm)

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

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最大底孔径 Max. drill hole dia.				
		各精度通用	旧JIS选用	4H用	5H用	6H用
40 x 3	37	36.8	37.2	37.06	37.15	37.25
40 x 2	38	37.9	38.2	38.07	38.13	38.21
40 x 1.5	38.5	38.4	38.6	38.56	38.61	38.67
* 40 x 1	39	—	—	39.06	39.1	39.15
42 x 4.5	37.5	37.2	37.7	37.55	37.65	37.79
42 x 4	38	37.7	38.2	38.04	38.14	38.27
42 x 3	39	38.8	39.2	39.06	39.15	39.25
42 x 2	40	39.9	40.2	40.07	40.13	40.21
42 x 1.5	40.5	40.4	40.6	40.56	40.61	40.67
42 x 1	41	40.95	41.03	41.06	41.1	41.15
45 x 4.5	40.5	40.2	40.7	40.55	40.65	40.79
45 x 4	41	40.7	41.2	41.04	41.14	41.27
45 x 3	42	41.8	42.2	42.06	42.15	42.25
45 x 2	43	42.9	43.2	43.07	43.13	43.21
45 x 1.5	43.5	43.4	43.6	43.56	43.61	43.67
* 45 x 1	44	—	—	44.06	44.1	44.15
* 46 x 1.5	44.5	—	—	44.56	44.61	44.67
48 x 5	43	42.6	43.2	43.03	43.14	43.29
48 x 4	44	43.7	44.2	44.04	44.14	44.27
48 x 3	45	44.8	45.2	45.06	45.15	45.25
48 x 2	46	45.9	46.2	46.07	46.13	46.21
48 x 1.5	46.5	46.4	46.6	46.56	46.61	46.67
* 48 x 1	47	—	—	47.06	47.1	47.15
* 50 x 5	45	—	—	45.03	45.14	45.29
* 50 x 4	46	45.7	—	46	46.1	46.2
50 x 3	47	46.8	47.2	47.06	47.15	47.25
50 x 2	48	47.9	48.2	48.07	48.13	48.21
50 x 1.5	48.5	48.4	48.6	48.56	48.61	48.67
* 50 x 1	49	—	—	49.1	49.1	49.15
52 x 5	47	46.6	47.2	47	47.1	47.2
52 x 4	48	47.7	48.2	48	48.1	48.2
52 x 3	49	48.8	49.2	49	49.1	49.2
52 x 2	50	49.9	50.2	50	50.1	50.2
52 x 1.5	50.5	50.4	50.6	50.5	50.6	50.6
55 x 4	51	50.7	51.2	51	51.1	51.2
55 x 3	52	51.8	52.2	52	52.1	52.2
55 x 2	53	52.9	53.2	53	53.1	53.2
55 x 1.5	53.5	53.4	53.6	53.5	53.6	53.6
56 x 5.5	50.5	50.1	50.7	50.5	50.6	50.7
56 x 4	52	51.7	52.2	52	52.1	52.2
56 x 3	53	52.8	53.2	53	53.1	53.2
56 x 2	54	53.9	54.2	54	54.1	54.2
56 x 1.5	54.5	54.4	54.6	54.5	54.6	54.6
58 x 4	54	53.7	54.2	54	54.1	54.2
58 x 3	55	54.8	55.2	55	55.1	55.2
58 x 2	56	55.9	56.2	56	56.1	56.2
58 x 1.5	56.5	56.4	56.6	56.5	56.6	56.6
60 x 5.5	54.5	54.1	54.7	54.5	54.6	54.7
60 x 4	56	55.7	56.2	56	56.1	56.2
60 x 3	57	56.8	57.2	57	57.1	57.2

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	最大底孔径 Max. drill hole dia.				
		各精度通用	旧JIS选用	4H用	5H用	6H用
60 x 2	58	57.9	58.2	58	58.1	58.2
60 x 1.5	58.5	58.4	58.6	58.5	58.6	58.6
62 x 4	58	57.7	58.2	58	58.1	58.2
62 x 3	59	58.8	59.2	59	59.1	59.2
62 x 2	60	59.9	60.2	60	60.1	60.2
62 x 1.5	60.5	60.4	60.6	60.5	60.6	60.6
64 x 6	58	57.6	58.3	58	58.1	58.2
64 x 4	60	59.7	60.2	60	60.1	60.2
64 x 3	61	60.8	61.2	61	61.1	61.2
64 x 2	62	61.9	62.2	62	62.1	62.2
64 x 1.5	62.5	62.4	62.6	62.5	62.6	62.6
65 x 4	61	60.7	61.2	61	61.1	61.2
65 x 3	62	61.8	62.2	62	62.1	62.2
65 x 2	63	62.9	63.2	63	63.1	63.2
65 x 1.5	63.5	63.4	63.6	63.5	63.6	63.6
68 x 6	62	61.6	62.3	62	62.1	62.2
68 x 4	64	63.7	64.2	64	64.1	64.2
68 x 3	65	64.8	65.2	65	65.1	65.2
68 x 2	66	65.9	66.2	66	66.1	66.2
68 x 1.5	66.5	66.4	66.6	66.5	66.6	66.6
70 x 6	64	63.6	64.3	64	64.1	64.3
70 x 4	66	65.7	66.2	66	66.1	66.2
70 x 3	67	66.8	67.2	67	67.1	67.2
70 x 2	68	67.9	68.2	68	68.1	68.2
72 x 6	66	65.6	66.3	66	66.1	66.3
72 x 4	68	67.7	68.2	68	68.1	68.2
72 x 3	69	68.8	69.2	69	69.1	69.2
72 x 2	70	69.9	70.2	70	70.1	70.2
75 x 4	71	70.7	71.2	71	71.1	71.2
75 x 3	72	71.8	72.2	72	72.1	72.2
75 x 2	73	72.9	73.2	73	73.1	73.2
76 x 2	74	73.9	74.2	74	74.1	74.2
80 x 6	74	73.6	74.3	74	74.1	74.3
80 x 4	76	75.7	76.2	76	76.1	76.2
80 x 3	77	76.8	77.2	77	77.1	77.2
80 x 2	78	77.9	78.2	78	78.1	78.2
85 x 6	79	78.6	79.3	79	79.1	79.3
85 x 4	81	80.7	81.2	81	81.1	81.2
85 x 3	82	81.8	82.2	82	82.1	82.2
85 x 2	83	82.9	83.2	83	83.1	83.2
90 x 6	84	83.6	84.3	84	84.1	84.3
90 x 4	86	85.7	86.2	86	86.1	86.2
90 x 2	88	87.9	88.2	88	88.1	88.2
95 x 6	89	88.6	89.3	89	89.1	89.3
95 x 4	91	90.7	91.2	91	91.1	91.2
95 x 2	93	92.9	93.2	93	93.1	93.2
100 x 6	94	93.6	94.3	94	94.1	94.3
100 x 4	96	95.7	96.2	96	96.1	96.2
100 x 2	98	97.9	98.2	98	98.1	98.2

* 推荐底孔径为旧 JIS2 级内螺纹用。
* JIS 规格中没有的内螺纹底孔为参考值。

The recommended tap limit corresponds to the old JIS class 2 internal thread standard.
* Recommended drill hole diameters that are not listed in JIS are reference values.

螺纹底孔直径表 RECOMMENDED DRILL HOLE SIZE

嵌套螺纹用请参考 P 8 4 3。For screw thread insert: Please refer to p.843

美制螺纹

Unified screw threads

(单位: mm)
(Unit: mm)

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	JIS2B级用 JIS class 2B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
No. 0 - 80UNF	1.25	1.19	1.3
1 - 64UNC	1.5	1.43	1.57
1 - 72UNF	1.55	1.48	1.61
2 - 56UNC	1.79	1.7	1.87
2 - 64UNF	1.84	1.76	1.91
3 - 48UNC	2.05	1.95	2.14
3 - 56UNF	2.11	2.03	2.19
4 - 40UNC	2.27	2.16	2.38
4 - 48UNF	2.37	2.28	2.45
5 - 40UNC	2.59	2.49	2.69
5 - 44UNF	2.65	2.56	2.74
6 - 32UNC	2.77	2.65	2.89
6 - 40UNF	2.92	2.82	3.02
8 - 32UNC	3.42	3.31	3.53
8 - 36UNF	3.51	3.41	3.6
10 - 24UNC	3.81	3.69	3.93
10 - 32UNF	4.07	3.97	4.16
12 - 24UNC	4.47	4.35	4.59
12 - 28UNF	4.61	4.5	4.72
1/4 - 20UNC	5.12	4.98	5.25
1/4 - 28UNF	5.47	5.36	5.58
* 1/4 - 32UNEF	5.59	5.49	5.68
* 5/16 - 18UNC	6.57	6.41	6.73
* 5/16 - 24UNF	6.91	6.79	7.03
* 5/16 - 32UNEF	7.18	7.09	7.26
* 3/8 - 16UNC	7.98	7.8	8.15
* 3/8 - 20UN	8.3	8.16	8.43
* 3/8 - 24UNF	8.51	8.39	8.63
* 3/8 - 32UNEF	8.77	8.67	8.86
* 7/16 - 14UNC	9.35	9.15	9.55
* 7/16 - 20UNF	9.88	9.73	10.03
* 1/2 - 13UNC	10.81	10.6	11.02
* 1/2 - 20UNF	11.47	11.33	11.6
* 9/16 - 12UNC	12.2	12	12.4
* 9/16 - 18UNF	12.9	12.8	13
* 5/8 - 11UNC	13.6	13.4	13.8
* 5/8 - 18UNF	14.5	14.4	14.6
* 5/8 - 24UNEF	14.9	14.8	14.9
* 3/4 - 10UNC	16.6	16.4	16.8
* 3/4 - 16UNF	17.5	17.4	17.6
* 3/4 - 20UNEF	17.8	17.7	17.9
* 7/8 - 9UNC	19.5	19.2	19.7
* 7/8 - 14UNF	20.5	20.3	20.6
* 7/8 - 20UNEF	21	20.9	21.1
1 - 8UNC	22.3	22	22.6
1 - 12UNF	23.4	23.2	23.5
* 1 - 14UNS	23.7	23.5	23.8
* 1 1/16 - 12UN	24.9	24.7	25.1
* 1 1/8 - 7UNC	25	24.7	25.3
* 1 1/8 - 8UN	25.5	25.2	25.7
1 1/8 - 12UNF	26.5	26.3	26.7
1 1/4 - 7UNC	28.2	27.9	28.5
* 1 1/4 - 8UN	28.7	28.4	28.9
1 1/4 - 12UNF	29.7	29.5	29.9

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	JIS2B级用 JIS class 2B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大底孔径 Max. drill hole dia.
* 1 1/16 - 12UN	31.3	31.1	31.4
* 1 3/8 - 6UNC	30.8	30.4	31.1
* 1 3/8 - 8UN	31.8	31.5	32.1
* 1 3/8 - 12UNF	32.9	32.7	33
* 1 1/2 - 6UNC	33.9	33.6	34.2
* 1 1/2 - 8UN	35	34.7	35.3
* 1 1/2 - 12UNF	36.1	35.9	36.2
* 1 5/8 - 5UNS	36.2	35.8	36.6
* 1 5/8 - 8UN	38.2	37.9	38.4
* 1 5/8 - 12UN	39.2	39	39.4
* 1 3/4 - 5UNC	39.4	39	39.8
* 1 3/4 - 8UN	41.4	41.1	41.6
* 1 3/4 - 12UN	42.4	42.2	42.6
* 1 7/8 - 8UN	44.5	44.2	44.8
* 2 - 4.5UNC	45.1	44.7	45.5
* 2 - 8UN	47.7	47.4	48
* 2 - 12UN	48.8	48.6	48.9
* 2 1/4 - 4.5UNC	51.5	51.1	51.9
* 2 1/2 - 4UNC	57.1	56.7	57.5
* 2 1/2 - 8UN	60.4	60.1	60.7
* 2 3/4 - 4UNC	63.5	63	63.9
* 2 3/4 - 8UN	66.8	66.5	67
* 3 - 4UNC	69.8	69.4	70.2
* 3 - 8UN	73.1	72.8	73.4
* 3 1/4 - 4UNC	76.2	75.7	76.6
* 3 1/2 - 4UNC	82.5	82.1	82.9
* 3 1/2 - 8UN	85.8	85.5	86.1
* 3 3/4 - 4UNC	88.9	88.4	89.3
* 4 - 4UNC	95.2	94.8	95.6
* 4 - 8UN	98.5	98.2	98.8
* 4 1/4 - 4UNC	101.6	101.1	102
* 4 1/4 - 6UN	103.8	103.4	104.1
* 4 1/4 - 8UN	104.9	104.6	105.1
* 4 1/2 - 4UNC	107.9	107.5	108.3
* 4 1/2 - 6UN	110.1	109.8	110.4
* 4 1/2 - 8UN	111.2	110.9	111.5
* 4 3/4 - 4UNC	126.3	137.8	114.7
* 4 3/4 - 6UN	116.5	116.1	116.8
* 4 3/4 - 8UN	117.6	117.3	117.8
* 5 - 4UNC	120.6	120.2	121
* 5 - 6UN	122.8	122.5	123.1
* 5 - 8UN	123.9	123.6	124.2
* 5 1/4 - 4UNC	127	126.5	127.4
* 5 1/4 - 6UN	129.2	128.8	129.5
* 5 1/4 - 8UN	130.3	130	130.5
* 5 1/2 - 4UNC	133.3	132.9	133.7
* 5 1/2 - 6UN	134.5	135.2	133.8
* 5 1/2 - 8UN	136.6	136.3	136.9
* 5 3/4 - 4UNC	139.7	139.2	140.1
* 5 3/4 - 6UN	141.9	141.5	142.2
* 5 3/4 - 8UN	143	142.7	143.2
* 6 - 4UNC	146	145.6	146.4
* 6 - 6UN	148.2	147.9	148.5
* 6 - 8UN	149.3	149	149.6

* JIS 规格内没有的内螺纹的底孔径为参考值。
根据 JIS B 1004-1975。
基准牙形与各数值与公制螺纹相同。

* Recommended drill hole diameters that are not listed in JIS are reference values.
In accordance to JIS B 1004-1975.
Thread value are the same as metric standard.

螺纹底孔直径表 RECOMMENDED DRILL HOLE SIZE

航天航空用UNJ螺纹规格 UNJ thread for aircraft and aerospace industry

ISO 3161 Third edition 1999-12-01による。(单位: mm)
MIL-S-8879C 25 July 1991 による。(Unit: mm)

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	3B级用 3B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大直径 Max. drill hole dia.
No. 6 - 32UNJC	2.84	2.74	2.93
6 - 40UNJF	2.97	2.89	3.05
8 - 32UNJC	3.5	3.4	3.59
8 - 36UNJF	3.57	3.48	3.66
10 - 24UNJC	3.93	3.8	4.06
10 - 32UNJF	4.16	4.06	4.25
1/4 - 20UNJC	5.25	5.12	5.38
1/4 - 28UNJF	5.57	5.47	5.66

螺纹尺寸 Thread size	推荐底孔径 Recommended drill hole dia.	3B级用 3B drill hole dia.	
		最小底孔径 Min. drill hole dia.	最大直径 Max. drill hole dia.
5/16 - 18UNJC	6.7	6.57	6.83
5/16 - 24UNJF	7.01	6.91	7.1
3/8 - 16UNJC	8.12	7.98	8.25
3/8 - 24UNJF	8.59	8.5	8.67
7/16 - 14UNJC	9.49	9.35	9.63
7/16 - 20UNJF	9.98	9.88	10.08
1/2 - 13UNJC	10.95	10.8	11.09
1/2 - 20UNJF	11.57	11.47	11.66

缝纫机螺纹 Screw threads for sewing machines

(单位: mm)
(Unit: mm)

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	钻头直径 Drill dia.	2级螺纹及 底孔直径 JIS class 2 drill hole dia.	2级内螺纹小径 JIS class 2B Internal thread minor dia.	
			最小尺寸 Min.	最大尺寸 Max.
SM 1/16 - 80	1.25	1.28(75%)	1.211	1.281
3/64 - 64	1.55	1.57(80%)	1.513	1.593
3/32 - 100	2.1	2.15(70%)	2.081	2.156
3/32 - 56	1.85	1.91(80%)	1.841	1.936
1/8 - 44	2.5	2.58(80%)	2.485	2.605
1/8 - 40	2.45	2.52(80%)	2.421	2.551
9/64 - 40	2.85	2.91(80%)	2.818	2.948
11/64 - 40	3.65	3.71(80%)	3.612	3.742
3/16 - 32	3.9	3.94(80%)	3.82	3.98
3/16 - 28	3.7	3.82(80%)	3.684	3.844
3/16 - 24	3.55	3.59(85%)	3.498	3.658
7/32 - 32	4.7	4.73(80%)	4.614	4.774
15/64 - 28	4.9	5.01(80%)	4.875	5.055
1/4 - 40	5.6	5.69(80%)	5.596	5.726
1/4 - 28	5.3	5.41(80%)	5.272	5.452

螺纹尺寸 Thread size	钻头直径 Drill dia.	2级螺纹及 底孔直径 JIS class 2 drill hole dia.	2级内螺纹小径 JIS class 2B Internal thread minor dia.	
			最小尺寸 Min.	最大尺寸 Max.
SM 1/4 - 24	5.1	5.25(80%)	5.086	5.266
9/32 - 28	6.1	6.2(80%)	6.066	6.256
9/32 - 20	5.7	5.82(80%)	5.634	5.824
5/16 - 28	6.9	6(80%)	6.86	7.05
5/16 - 24	6.7	6.84(80%)	6.674	6.864
5/16 - 18	6.3	6.38(85%)	6.254	6.444
11/32 - 28	7.6	7.79(80%)	7.653	7.843
3/8 - 28	8.5	8.58(80%)	8.447	8.637
3/8 - 18	7.9	7.97(85%)	7.843	8.053
7/16 - 28	10.1	10.17(80%)	10.034	10.224
7/16 - 16	9.3	9.36(85%)	9.22	9.44
1/2 - 28	11.7	11.76(80%)	11.622	11.812
1/2 - 20	11.3	11.38(80%)	11.19	11.41
1/2 - 12	10.3	10.36(85%)	10.18	10.42

惠氏粗牙螺纹 Whitworth Coarse screw threads

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	牙数 Number of thread	内螺纹最小径 Internal thread min. minor dia.	内螺纹最大径 Internal thread max. minor dia.
W 1/8	40	2.452	2.602
5/32	32	3.073	3.253
3/16	24	3.567	3.807
1/4	20	4.914	5.204
5/16	18	6.34	6.67
3/8	16	7.733	8.113
7/16	14	9.048	9.508
1/2	12	10.31	10.83
5/8	12	11.898	12.418
3/4	11	13.257	13.817
7/8	10	16.178	16.778
1	9	19.031	19.691
1 1/8	8	21.814	22.514
1 1/4	7	24.469	25.229

螺纹尺寸 Thread size	牙数 Number of thread	内螺纹最小径 Internal thread min. minor dia.	内螺纹最大径 Internal thread max. minor dia.
1 1/4	7	27.644	28.404
1 3/8	6	30.123	30.923
1 1/2	6	33.298	34.098
1 5/8	5	35.529	36.409
1 3/4	5	38.704	39.584
1 7/8	4 1/2	41.237	42.227
2	4 1/2	44.412	45.402
2 1/8	4	46.783	47.893
2 1/4	4	49.958	51.068
2 3/8	4	53.133	54.243
2 1/2	4	56.308	57.418
2 3/4	3 1/2	61.636	62.816
2 7/8	3 1/2	64.81	65.99
3	3 1/2	67.986	69.166

螺纹底孔直径表 RECOMMENDED DRILL HOLE SIZE

英式锥管螺纹

Taper pipe threads

(单位: mm)

(Unit: mm)

管用螺纹尺寸 Thread		JIS B 0203				JIS B 2301	
		锥管内螺纹 Rc(PT) Taper internal threads(PT)		平行内螺纹 Rp(PS) Parallel internal threads(PS)		锥管内螺纹 Taper internal threads	
尺寸 Thread size	外径 Major dia.	计算值 calculated value	底孔直径 Drill hole dia.	计算值 calculated value	底孔直径 Drill hole dia.	计算值 calculated value	底孔直径 Drill hole dia.
1/16	7.723	6.23	6.2	6.49	6.5	—	—
1/8	9.728	8.235	8.2	8.495	8.5	8.191	8.2
1/4	13.157	10.941	10.9	11.341	11.4	10.945	10.9
3/8	16.662	14.428	14.4	14.846	14.9	14.388	14.4
1/2	20.955	17.95	18	18.489	18.5	17.943	18
3/4	26.441	23.349	23	23.975	24	23.305	23
1	33.249	29.423	29	30.111	30	29.353	29
1 1/4	41.91	37.94	38	38.772	39	37.89	38
1 1/2	47.803	43.833	44	44.565	45	43.72	43
2	59.614	55.412	55	56.476	56	55.406	55
2 1/2	75.184	70.701	71	72.009	72	70.788	70
3	87.884	83.201	83	84.709	85	83.364	83
3 1/2	100.33	95.547	96	97.155	97	95.747	95
4	113.03	107.834	108	109.855	110	108.322	108
5	138.43	133.11	133	135.255	135	133.597	133
6	163.83	158.51	159	160.655	161	158.81	158
7	189.23	183.36	183	185.954	186	—	—
8	214.63	208.56	209	211.354	212	—	—
9	240.03	233.96	234	236.754	237	—	—
10	265.43	259.166	259	262.154	262	—	—
12	316.23	309.747	310	312.875	313	—	—

1982年由于ISO的导入, JIS管用螺纹规格得到修订。螺纹代号有了变更, 但螺纹精度没有改变, 因此丝锥的名称还是延用了旧代号。

The JIS pipe thread standard was revised in 1982 to meet ISO standards. Although thread symbols changed, the limits were not changed. Therefore, it is still acceptable to use taps with both new and old symbols.

(JIS B 0202-1982)
(JIS B 0203-1982)

种类 Type	旧记号 Previous Symbol	新记号 New Symbol
密封用锥管内螺纹 Taper pipe threads for pressure-tight joints	PT	Rc
密封用平行管螺纹 Parallel pipe threads for pressure-tight joints	PS	Rp
一般结合用 平行内螺纹 Parallel pipe threads for mechanical joints	PF	G

- JIS B 0203 锥管内螺纹的计算值为, 当基准值位于连接部端面时, 允许有效螺纹的小端径处存在不完全山形的直孔孔径。
- JIS B 2301 锥管内螺纹的计算值为, 当基准值位于连接部端面时, 不允许在小端径处存在不完全牙形的直孔孔径。
- PT, PS的1/4遵循JIS B 0203-1982Rc, Rp的螺纹规格。
- Calculated value of JIS B 0203 taper thread refers to the diameter of the straight hole in case that the last one thread at the small diameter position in useful threads is allowed to be incomplete when the reference is on the end surface of the joint.
- Calculated value of JIS B 2301 taper thread refers to the diameter of the straight hole in case that the last thread at the small diameter position needs to be complete when the reference is on the end surface of the joint.
- The values for 1/16 of OT and PS conform to those of Rc and Rp threads under JIS B 0203-1982.

英式平行管螺纹

Parallel pipe threads

(单位: mm)

(Unit: mm)

螺纹 Thread		最小底孔径 Drill hole dia min.	最大底孔径 Drill hole dia max.
尺寸 Thread size	大径 Major dia.		
G 1/16	7.723	6.561 (100)	6.843 (80)
G(PF) 1/8	9.728	8.566 //	8.848 //
1/4	13.157	11.445 //	11.89 (75)
3/8	16.662	14.95 //	15.395 //
1/2	20.955	18.631 //	19.172 (80)
5/8	22.911	20.587 //	21.128 //
3/4	26.441	24.117 //	24.658 //
7/8	30.201	27.877 //	28.418 //
1	33.249	30.291 //	30.931 //
1 1/8	37.897	34.939 //	35.579 //
1 1/4	41.91	38.952 //	39.592 (85)
1 3/8	44.323	41.365 //	42.005 (80)
1 1/2	47.803	44.845 //	45.485 //
1 3/4	53.746	50.788 //	51.428 //
2	59.614	56.656 //	57.296 //
2 1/2	75.184	72.226 //	72.866 //
3	87.884	84.926 //	85.566 //
3 1/2	100.33	97.3 //	98 //
4	113.03	110.072 //	110.712 //

英式管用平行螺纹 (NRT 丝锥)

Parallel pipe threads (Nu-Roll tap)

(单位: mm)

(Unit: mm)

尺寸 Thread		RH 精度 RH Limits	最小~最大 (嵌合率%) Min. ~ Max. (Thread Overlap Ratio%)
螺纹尺寸 Thread size	外径 d Major dia.		
PF 1/8	9.728	6	9.24 ~ 9.35 (100 ~ 80)
1/4	13.157	7	12.41 ~ 12.62 (100 ~ 75)
3/8	16.662	7	15.92 ~ 16.12 (100 ~ 75)
1/2	20.955	8	19.93 ~ 20.15 (100 ~ 80)
3/4	26.441	8	25.41 ~ 25.64 (100 ~ 80)
1	33.249	10	31.919 ~ 32.205 (100 ~ 80)

螺纹底孔直径表 RECOMMENDED DRILL HOLE SIZE

美标管用螺纹 (NPT·NPSC)

(单位: mm ()=inch)
(Unit: mm ()=inch)

管用螺纹尺寸 Thread		锥管螺纹 (NPT) Taper threads (NPT)				平行螺纹 (NPSC) Parallel threads (NPSC)	
尺寸 Thread size	外径 Major dia.	钻头直径 Drill dia.		钻头直径 Drill dia.	钻头直径 Drill dia.	钻头直径 Drill dia.	钻头直径 Drill dia.
		使用铰刀时 Where Reamer is used	不使用铰刀时 Where Reamer is not used				
1/16	7.77	—	5.94 (0.234)	—	6.15 (0.242)	1/4	6.35 (0.25)
1/8	10.117	2 1/64	8.33 (0.328)	—	8.43 (0.332)	1 1/32	8.74 (0.344)
1/4	13.426	2 7/64	10.72 (0.422)	7/16	11.13 (0.438)	7/16	11.13 (0.438)
3/8	16.866	9/16	14.27 (0.562)	9/16	14.27 (0.562)	3 7/64	14.68 (0.578)
1/2	20.98	1 1/16	17.48 (0.688)	4 5/64	17.86 (0.703)	2 3/32	18.26 (0.719)
3/4	26.325	5 7/64	22.63 (0.891)	2 9/32	23.01 (0.906)	5 9/64	23.42 (0.922)
1	32.934	1 1/8	28.58 (1.125)	1 9/64	28.98 (1.141)	1 5/32	29.36 (1.156)
1 1/4	41.689	1 15/32	37.31 (1.469)	1 3/64	37.69 (1.484)	1 1/2	38.1 (1.5)
1 1/2	47.76	1 4 5/64	43.26 (1.703)	1 2 3/32	43.66 (1.719)	1 3/4	44.45 (1.75)
2	59.797	2 1 1/64	55.17 (2.172)	2 3/16	55.58 (2.188)	2 7/32	56.36 (2.219)
2 1/2	72.273	2 3 3/64	65.48 (2.578)	2 3 3/64	66.27 (2.609)	2 2 1/32	67.46 (2.656)

上述钻头直径来源于美式管用螺纹 ANSI/ASME B1.20.1-1983 Pipe Threads, General Purpose (Inch) 标准。
The drill sizes are quoted from ANSI/ASME B1.20.1-1983 Pipe Threads, General Purpose (Inch) Appendix.

美标干圈管用螺纹 (NPTF·NPSF)

(单位: mm ()=inch)
(Unit: mm ()=inch)

管用螺纹尺寸 Thread		锥管螺纹 (NPTF) Taper threads (NPTF)				平行螺纹 (NPSF) Parallel threads (NPSF)	
尺寸 Thread size	外径 Major dia.	钻头直径 Drill dia.		钻头直径 Drill dia.	钻头直径 Drill dia.	钻头直径 Drill dia.	钻头直径 Drill dia.
		使用铰刀时 Where Reamer is used	不使用铰刀时 Where Reamer is not used				
1/16	7.77	—	5.94 (0.234)	—	6.15 (0.242)	—	6.25 (0.246)
1/8	10.117	2 1/64	8.33 (0.328)	—	8.43 (0.332)	—	8.61 (0.339)
1/4	13.426	2 7/64	10.72 (0.422)	7/16	11.13 (0.438)	7/16	11.13 (0.438)
3/8	16.866	9/16	14.3 (0.563)	9/16	14.27 (0.562)	3 7/64	14.68 (0.578)
1/2	20.98	1 1/16	17.48 (0.688)	4 5/64	17.86 (0.703)	4 5/64	17.86 (0.703)
3/4	26.325	5 7/64	22.63 (0.891)	2 9/32	23.01 (0.906)	5 9/64	23.42 (0.922)
1	32.934	1 1/8	28.58 (1.125)	1 9/64	28.98 (1.141)	1 5/32	29.36 (1.156)
1 1/4	41.689	1 15/32	37.31 (1.469)	1 3/64	37.69 (1.484)	—	—
1 1/2	47.76	1 4 5/64	43.26 (1.703)	1 2 3/32	43.66 (1.719)	—	—
2	59.797	2 1 1/64	55.17 (2.172)	2 3/16	55.58 (2.188)	—	—
2 1/2	72.273	2 3 3/64	65.48 (2.578)	2 3 3/64	66.27 (2.609)	—	—

上述钻头直径来源于美式干圈管用螺纹 ANSI B1.20.3-1976 Dryseal Pipe Threads. The drill sizes are quoted from ANSI B1.20.3-1976 Dryseal Pipe Threads (Inch) Appendix.

美制粗牙螺纹 (NRT 丝锥)

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	2B级螺纹用底孔直径 for JIS class 2B drill hole dia.				3B级螺纹用底孔直径 for JIS class 3B drill hole dia.				
	RH 精度	最小~最大 (嵌合率%)		RH 精度	最小~最大 (嵌合率%)		RH 精度	最小~最大 (嵌合率%)	
	RH Limits	Min.	Max. (Thread Overlap Ratio%)	RH Limits	Min.	Max. (Thread Overlap Ratio%)	RH Limits	Min.	Max. (Thread Overlap Ratio%)
No. 1 - 64UNC	3	1.66	~ 1.7 (100~65)	2	1.65	~ 1.69 (100~65)			
No. 2 - 56	4	1.96	~ 2.02 (100~65)	3	1.95	~ 2.01 (100~65)			
No. 3 - 48	4	2.25	~ 2.32 (100~65)	3	2.23	~ 2.31 (100~65)			
No. 4 - 40	5	2.52	~ 2.6 (100~70)	3	2.5	~ 2.58 (100~70)			
No. 5 - 40	5	2.86	~ 2.93 (100~70)	3	2.83	~ 2.91 (100~70)			
No. 6 - 32	5	3.09	~ 3.17 (100~75)	3	3.06	~ 3.14 (100~75)			
No. 8 - 32	5	3.75	~ 3.83 (100~75)	4	3.74	~ 3.82 (100~75)			
No.10 - 24	6	4.26	~ 4.35 (100~80)	4	4.24	~ 4.32 (100~80)			
No.12 - 24	6	4.92	~ 5.01 (100~80)	4	4.9	~ 4.96 (100~85)			
1/4 - 20	6	5.66	~ 5.76 (100~80)	4	5.64	~ 5.74 (100~80)			
5/16 - 18	7	7.18	~ 7.29 (100~80)	5	7.15	~ 7.24 (100~85)			
3/8 - 16	7	8.66	~ 8.78 (100~80)	5	8.63	~ 8.73 (100~85)			
7/16 - 14	7	10.11	~ 10.25 (100~80)	5	10.08	~ 10.19 (100~85)			
1/2 - 13	8	11.62	~ 11.78 (100~80)	6	11.6	~ 11.68 (100~90)			
5/8 - 12	10	13.14	~ 13.27 (100~85)	8	13.11	~ 13.24 (100~85)			
3/4 - 11	11	14.62	~ 14.76 (100~85)	8	14.58	~ 14.67 (100~90)			
7/8 - 9	12	17.67	~ 17.88 (100~80)	9	17.63	~ 17.74 (100~90)			
1 - 8	13	23.65	~ 23.84 (100~85)	10	23.61	~ 23.74 (100~90)			

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。

美制细牙螺纹 (NRT 丝锥)

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	2B级螺纹用底孔直径 for JIS class 2B drill hole dia.				3B级螺纹用底孔直径 for JIS class 3B drill hole dia.				
	RH 精度	最小~最大 (嵌合率%)		RH 精度	最小~最大 (嵌合率%)		RH 精度	最小~最大 (嵌合率%)	
	RH Limits	Min.	Max. (Thread Overlap Ratio%)	RH Limits	Min.	Max. (Thread Overlap Ratio%)	RH Limits	Min.	Max. (Thread Overlap Ratio%)
No. 0 - 80UNF	3	1.38	~ 1.41 (100~65)	2	1.36	~ 1.4 (100~65)			
No. 1 - 72	3	1.68	~ 1.72 (100~65)	2	1.67	~ 1.71 (100~65)			
No. 2 - 64	3	1.98	~ 2.04 (100~65)	2	1.97	~ 2.03 (100~65)			
No. 3 - 56	4	2.29	~ 2.35 (100~65)	3	2.28	~ 2.34 (100~65)			
No. 4 - 48	4	2.57	~ 2.64 (100~70)	3	2.56	~ 2.63 (100~70)			
No. 5 - 44	5	2.89	~ 2.96 (100~70)	3	2.87	~ 2.94 (100~70)			
No. 6 - 40	5	3.19	~ 3.26 (100~70)	3	3.16	~ 3.22 (100~75)			
No. 8 - 36	5	3.8	~ 3.88 (100~75)	4	3.79	~ 3.86 (100~75)			
No.10 - 32	5	4.41	~ 4.48 (100~80)	4	4.4	~ 4.46 (100~80)			
No.12 - 28	5	5	~ 5.08 (100~80)	4	4.99	~ 5.06 (100~80)			
1/4 - 28	5	5.86	~ 5.93 (100~80)	4	5.85	~ 5.92 (100~80)			
5/16 - 24	6	7.38	~ 7.46 (100~80)	5	7.36	~ 7.43 (100~85)			
3/8 - 24	6	8.96	~ 9.05 (100~80)	5	8.95	~ 9.02 (100~85)			
7/16 - 20	7	10.44	~ 10.54 (100~80)	5	10.41	~ 10.49 (100~85)			
1/2 - 20	7	12.02	~ 12.12 (100~80)	5	12	~ 12.05 (100~90)			
5/8 - 18	9	13.55	~ 13.66 (100~80)	7	13.53	~ 13.58 (100~90)			
3/4 - 16	9	15.14	~ 15.25 (100~80)	7	15.11	~ 15.17 (100~90)			
7/8 - 14	10	18.22	~ 18.32 (100~85)	7	18.18	~ 18.25 (100~90)			
1 - 12	11	21.27	~ 21.38 (100~85)	8	21.23	~ 21.27 (100~95)			
	12	24.28	~ 24.41 (100~85)	9	24.24	~ 24.32 (100~90)			

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.
4. To avoid tapping trouble, correct hole must be maintained free from warp, deformation, stagger and the like.