

螺纹底孔直径表(嵌套螺纹用) RECOMMENDED DRILL HOLE SIZE (FOR SCREW THREAD INSERT)

一般螺纹用请参考 P 834。For general screw thread: Please refer to p.834

公制粗牙螺纹

Metric Coarse screw threads

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
M 2 × 0.4 (2.520)	2.1	2.17	2.1
2.5 × 0.45 (3.085)	2.6	2.65	2.6
2.6 × 0.45 (3.185)	2.7	2.75	2.7
3 × 0.5 (3.650)	3.12	3.2	3.15
4 × 0.7 (4.909)	4.17	4.3	4.2
5 × 0.8 (6.039)	5.16	5.33	5.2
6 × 1 (7.300)	6.25	6.42	6.3
8 × 1.25 (9.624)	8.31	8.52	8.4
10 × 1.5 (11.948)	10.37	10.62	10.5
12 × 1.75 (14.274)	12.43	12.73	12.5
14 × 2 (16.598)	14.49	14.83	14.5
16 × 2 (18.598)	16.49	16.83	16.5
18 × 2.5 (21.248)	18.58	19.04	19
20 × 2.5 (23.248)	20.58	21.04	21
22 × 2.5 (25.248)	22.58	23.04	23
24 × 3 (27.898)	24.7	25.25	25
27 × 3 (30.898)	27.65	28.05	27.8
30 × 3.5 (34.547)	30.76	31.2	31

公制细牙螺纹

Metric Fine screw threads

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
M 10 × 1 (11.300)	10.25	10.42	10.3
10 × 1.25 (11.624)	10.31	10.52	10.4
12 × 1.25 (13.624)	12.31	12.52	12.5
12 × 1.5 (13.948)	12.37	12.62	12.5
14 × 1.5 (15.948)	14.37	14.62	14.5
16 × 1.5 (17.948)	16.37	16.62	16.5
18 × 1.5 (19.948)	18.37	18.62	18.5
20 × 1.5 (21.948)	20.37	20.62	20.5
20 × 2 (22.598)	20.47	20.83	20.5
22 × 1.5 (23.948)	22.37	22.62	22.5
24 × 1.5 (25.948)	24.37	24.62	24.5
24 × 2 (26.598)	24.47	24.83	24.5
27 × 1.5 (28.948)	27.33	27.56	27.4
30 × 1.5 (31.948)	30.37	30.62	30.5

美制粗牙螺纹

Unified Coarse screw threads

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
No. 2 - 56UNC (2.773)	2.29	2.39	2.3
No. 3 - 48 (3.202)	2.64	2.74	2.7
No. 4 - 40 (3.670)	2.95	3.07	3
No. 5 - 40 (4.000)	3.25	3.38	3.3
No. 6 - 32 (4.536)	3.66	3.81	3.7
No. 8 - 32 (5.197)	4.32	4.47	4.4
No. 10 - 24 (6.201)	5.05	5.21	5.1
No. 12 - 24 (6.861)	5.61	5.77	5.7
1/4 - 20 (8.000)	6.63	6.78	6.7
3/8 - 18 (9.771)	8.33	8.48	8.4
1/2 - 16 (11.587)	9.91	10.11	10
3/4 - 14 (13.469)	11.51	11.76	11.5
1 - 13 (15.238)	13.08	13.34	13.1
1 1/8 - 12 (17.038)	14.68	14.94	14.7
1 1/4 - 11 (18.875)	16.59	16.84	16.7
1 1/2 - 10 (22.350)	19.84	20.09	20
1 3/4 - 9 (25.891)	23.01	23.27	23.1
2 - 8 (29.524)	26.19	26.52	26.4

美制细牙螺纹

Unified Fine screw threads

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	底孔直径 Drill hole dia.		钻头直径 Suitable Drill dia.
	最小尺寸 Min.	最大尺寸 Max.	
No. 4 - 48UNF (3.532)	2.97	3.05	3
No. 6 - 40 (4.330)	3.66	3.78	3.7
No. 8 - 36 (5.083)	4.32	4.44	4.4
No. 10 - 32 (5.857)	4.98	5.13	5
No. 12 - 28 (6.665)	5.7	5.86	5.8
1/4 - 28 (7.528)	6.53	6.71	6.6
3/8 - 24 (9.313)	8.2	8.38	8.2
1/2 - 20 (10.900)	9.78	9.96	9.8
3/4 - 20 (12.762)	11.43	11.63	11.5
1 - 20 (14.350)	13.03	13.26	13.1
1 1/8 - 18 (16.121)	14.66	14.88	14.7
1 1/4 - 18 (17.708)	16.26	16.48	16.3
1 1/2 - 16 (21.112)	19.43	19.68	19.5
1 3/4 - 14 (24.582)	22.61	22.86	22.7
2 - 12 (28.150)	25.76	26.04	26

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

(单位: mm)
(Unit: mm)

螺纹尺寸 Thread size	RH 精度 RH Limits	最小~最大(嵌合率%) Min.-Max.(Threads Overlap Ratio:%)	
		2	3
M 2 × 0.4 (2.520)	2	2.31 ~ 2.33 (100 ~80)	
2.5 × 0.45 (3.085)	2	2.84 ~ 2.87 (100 ~80)	
2.6 × 0.45 (3.185)	2	2.94 ~ 2.97 (100 ~80)	
3 × 0.5 (3.650)	3	3.39 ~ 3.43 (100 ~80)	
4 × 0.7 (4.909)	4	4.54 ~ 4.58 (100 ~85)	
5 × 0.8 (6.039)	4	5.61 ~ 5.66 (100 ~85)	
6 × 1 (7.300)	4	6.75 ~ 6.81 (100 ~85)	

螺纹尺寸 Thread size	RH 精度 RH Limits	最小~最大(嵌合率%) Min.-Max.(Threads Overlap Ratio:%)	
		5	6
8 × 1.25 (9.624)	5	8.93 ~ 9.01 (100 ~85)	
10 × 1.5 (11.948)	5	11.11 ~ 11.17 (100 ~90)	
10 × 1.25 (11.624)	5	10.93 ~ 11.01 (100 ~85)	
12 × 1.75 (14.274)	5	13.28 ~ 13.35 (100 ~90)	
12 × 1.5 (13.948)	5	13.11 ~ 13.17 (100 ~90)	
12 × 1.25 (13.624)	5	12.93 ~ 13.01 (100 ~85)	