

YA-CT26 ASIA



Combo^{TAP}

HSS-PM & HSS-E TAPS for Multi-Purpose

NEW

AOS Tap (FSH Coated)

- Spiral Flute

- Spiral Point

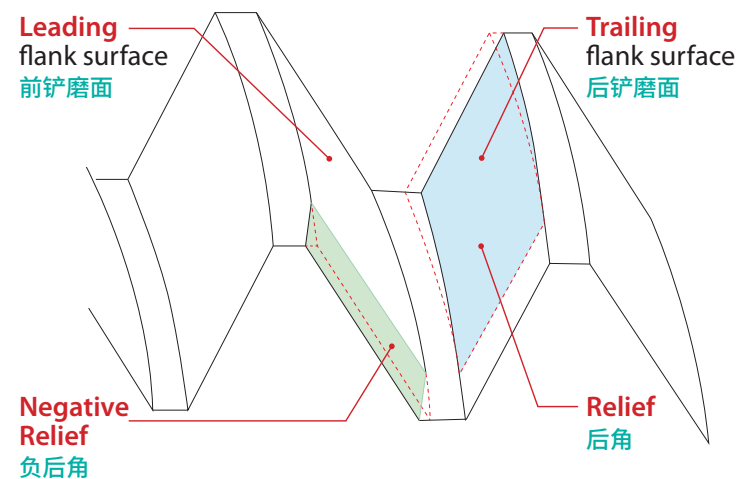
COMBO TAPS FOR MULTI-PURPOSE TAPPING

General Use for Various Materials 广泛适用于多种材质

Combo Tap's geometry provides enough flute space resulting in smooth chip evacuation and therefore a continuous production process. Guarantee a high level of process reliability even under unfavorable conditions.

Combo 丝锥采用优化的几何设计，可提供充足的容屑空间，实现顺畅排屑与连续生产。
即使在恶劣工况下，也能确保极高的加工可靠性。

- For Steels, Stainless Steels, Cast Iron and Non-Ferrous Materials 适用于钢、不锈钢、铸铁及有色金属
- Prevents over & under feeding by its optimized flank geometry 优化铲背几何结构，有效防止进给过多与进给不足
- Constant threading quality preventing oversized threading 保障稳定的螺纹加工质量，有效防止螺纹尺寸偏大



- Optimized flank geometry to prevent over & under feeding
- Enables smoother tapping with better chip evacuation
- Compensation of cutting force, which reduces tap wear and extends tool life
- 最佳的铲背形状，以防止过切和攻丝不足
- 攻丝更平稳，排屑更顺畅
- 补偿切削力，减少丝锥磨损，延长刀具寿命

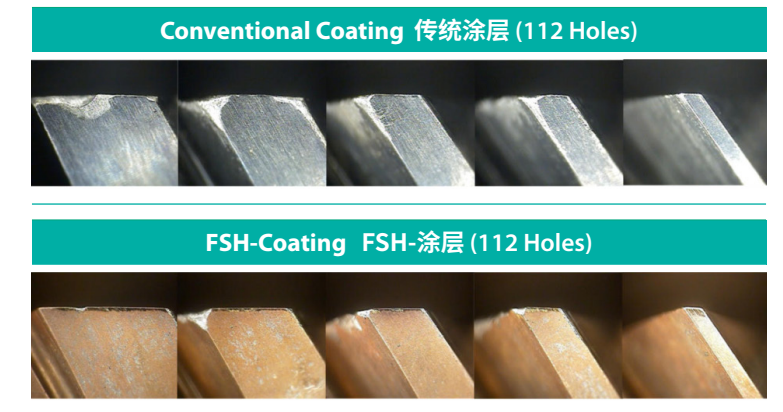
CASE STUDY 案例分析

TEST I SPIRAL FLUTE 螺旋槽

Cutting Condition 加工条件

Tool 刀具	NEW Combo AOS Tap - Spiral Flute
Size 尺寸	M10×1.5
Work Material 工件材质	- JIS : SCM440 (HRC30) - DIN : 42CrMo4 - WR : 1.7225
Tapping Depth 钻孔深度	20mm
Coolant 冷却	Wet Cut
Vc 螺纹速度	10m/min.

RESULT

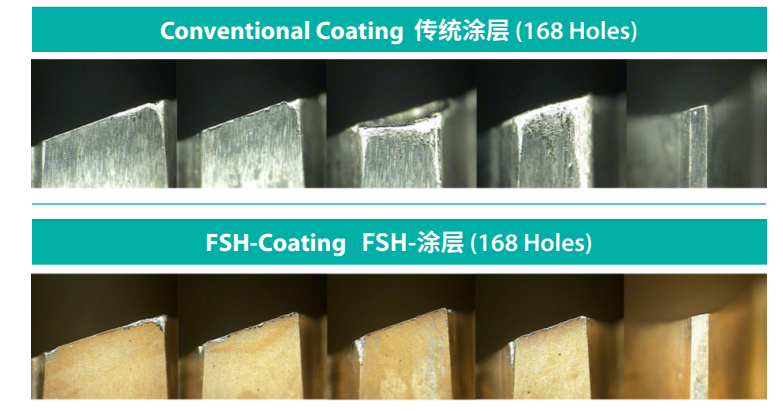


TEST II SPIRAL POINT 先端

Cutting Condition 加工条件

Tool 刀具	NEW Combo AOS Tap - Spiral Point
Size 尺寸	M10×1.5
Work Material 工件材质	- JIS : SCM440 (HRC30) - DIN : 42CrMo4 - WR : 1.7225
Tapping Depth 钻孔深度	20mm
Coolant 冷却	Wet Cut
Vc 螺纹速度	10m/min.

RESULT



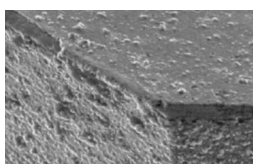
Working Material 工件材质

For Steels, Stainless Steels, Ductile Iron and Cast Aluminum materials
适用于钢、不锈钢、球墨铸铁及铸铝材料

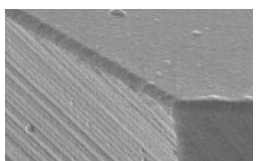
FSH-Coating FSH-涂层 **NEW**

Combining the advantages of all current coating technologies, it features high hardness, high toughness, and an extremely smooth surface. These characteristics provide highly reliable performance in threading processes.

该涂层融合了现有各类涂层工艺的全部优势，具备高硬度、高韧性、表面极致光洁三大特性；依托以上优势，在螺纹加工工艺中可实现稳定可靠的加工表现。



Conventional Coating
传统涂层



FSH-Coating
FSH-涂层

CASE STUDY 案例分析

TEST III SPIRAL FLUTE 螺旋槽

Cutting Condition 加工条件

Tool 刀具	Combo Spiral Flute Tap
Size 尺寸	M8×1.25
Work Material 工件材质	- JIS : S45C (HRC35) - DIN : C45 - WR : 1.0503
Tapping Depth 钻孔深度	20mm
Coolant 冷却	Water Soluble Oil
Vc 螺纹速度	10m/min.

Surface Roughness of Workpiece

YG-1 Total Tapping 204 Holes YG-1 总共攻丝204个孔	Competitor A Total Tapping 159 Holes 竞争社 A 总共攻丝159个孔	Competitor B Total Tapping 204 Holes 竞争社 B 总共攻丝204个孔

TEST IV SPIRAL POINT 先端

Cutting Condition 加工条件

Tool 刀具	Combo Spiral Point Tap
Size 尺寸	M2×0.4
Work Material 工件材质	- JIS : S45C (HRC35) - DIN : C45 - WR : 1.0503
Tapping Depth 钻孔深度	6mm
Coolant 冷却	Tapping Oil
Vc 螺纹速度	10m/min.

Surface Roughness of Workpiece

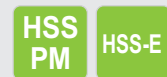
YG-1 Total Tapping 450 Holes YG-1 总共攻丝450个孔	Competitor A Total Tapping 318 Holes 竞争社 A 总共攻丝318个孔	Competitor B Total Tapping 103 Holes 竞争社 B 总共攻丝103个孔
	Tool broke after tapping 318 holes 318孔丝锥折断	Tool broke after tapping 103 holes 103孔丝锥折断

GUIDE TO ICONS 标记的说明

Working Material 切削工件



Tool Material 刀具材质



Class of Thread 螺纹等级



Standard of Tools 刀具标准



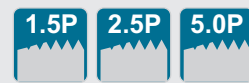
Thread Angle 螺纹角



Helix Angle 螺旋角



Chamfer Lead 倒角长度



Surface Treatment 表面处理



Cutting Condition 加工条件



HSS-PM & HSS-E COMBO TAPS

For Multi-Purpose Tapping
多用途丝锥



Please visit
globalyg1.com/mat
for material search

◎ : Excellent (优秀) ○ : Good (良好)

ISO 公制	VDI 3323	Material Description 材料描述	Composition / Structure / Heat Treatment 成分 / 组织 / 热处理	HB 布氏硬度	HRc 硬度			
P	1	Non-alloy steel	About 0.15% C Annealed	125		○ (15-20)	○ (20-25)	○ (15-20)
	2		About 0.45% C Annealed	190	13	◎ (15-20)	◎ (20-25)	◎ (15-20)
	3		About 0.45% C Quenched & Tempered	250	25	◎ (12-18)	◎ (18-24)	◎ (12-18)
	4		About 0.75% C Annealed	270	28	◎ (10-15)	◎ (15-20)	◎ (10-15)
	5		About 0.75% C Quenched & Tempered	300	32	◎ (6-10)	◎ (10-14)	◎ (6-10)
	6	Low alloy steel	Annealed	180	10	◎ (10-15)	◎ (15-20)	◎ (10-15)
	7		Quenched & Tempered	275	29	◎ (10-15)	◎ (15-20)	◎ (10-15)
	8		Quenched & Tempered	300	32	◎ (6-10)	◎ (10-14)	◎ (6-10)
	9		Quenched & Tempered	350	38	◎ (3-5)	◎ (5-7)	◎ (3-5)
	10	High alloyed steel, and tool steel	Annealed	200	15	○ (3-5)	○ (5-7)	○ (3-5)
	11		Quenched & Tempered	325	35			
M	12	Stainless steel	Ferritic / Martensitic Annealed	200	15	◎ (7-10)	◎ (10-15)	◎ (7-10)
	13		Martensitic Quenched & Tempered	240	23	◎ (5-8)	◎ (8-11)	◎ (5-8)
	14		Austenitic	180	10	◎ (4-6)	◎ (6-8)	◎ (4-6)
K	15	Grey cast iron	Pearlitic / Ferritic	180	10	◎ (10-15)	◎ (15-20)	◎ (10-15)
	16		Pearlitic (Martensitic)	260	26	◎ (5-8)	◎ (8-11)	◎ (5-8)
	17	Nodular cast iron	Ferritic	160	3	◎ (10-15)	◎ (15-20)	◎ (10-15)
	18		Pearlitic	250	25	◎ (5-8)	◎ (8-11)	◎ (5-8)
	19	Malleable cast iron	Ferritic	130				
	20		Pearlitic	230	21			
N	21	Aluminum-wrought alloy	Not Curable	60				
	22		Curable Hardened	100				
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable	75		◎ (15-20)	◎ (20-25)	◎ (15-20)
	24		≤ 12% Si, Curable Hardened	90				
	25		> 12% Si, Not Curable	130				
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%	110		◎ (25-35)	◎ (35-40)	◎ (25-35)
	27		CuZn, CuSnZn (Brass)	90		◎ (8-12)	◎ (12-17)	◎ (8-12)
	28		CuSn, lead-free copper and electrolytic copper	100		◎ (15-20)	◎ (20-25)	◎ (15-20)
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic					
	30		Rubber, Wood, etc.					
S	31	Heat Resistant Super Alloys	Fe Based Annealed	200	15			
	32		Cured	280	30			
	33		Annealed	250	25			
	34		Ni or Co Based Cured	350	38			
	35		Cast	320	34			
	36	Titanium Alloys	Pure Titanium	400 Rm				
	37		Alpha + Beta Alloys Hardened	1050 Rm				
H	38	Hardened steel	Hardened	550	55			
	39		Hardened	630	60			
	40	Chilled Cast Iron	Cast	400	42			
	41	Hardened Cast Iron	Hardened	550	55			

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ISO 公制	VDI 3323	Material Description 材料描述	Composition / Structure / Heat Treatment 成分 / 组织 / 热处理		HB 布氏硬度	HRC 硬度	Long Shank	Long Shank	Long Shank	Long Shank
P	1	Non-alloy steel	About 0.15% C Annealed		125		○ (15-20)	○ (15-20)	○ (15-20)	○ (15-20)
	2		About 0.45% C Annealed		190	13	◎ (15-20)	◎ (15-20)	◎ (15-20)	◎ (15-20)
	3		About 0.45% C Quenched & Tempered		250	25	◎ (12-18)	◎ (12-18)	◎ (12-18)	◎ (12-18)
	4		About 0.75% C Annealed		270	28	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)
	5		About 0.75% C Quenched & Tempered		300	32	◎ (6-10)	◎ (6-10)	◎ (6-10)	◎ (6-10)
	6	Low alloy steel	Annealed		180	10	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)
	7		Quenched & Tempered		275	29	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)
	8		Quenched & Tempered		300	32	◎ (6-10)	◎ (6-10)	◎ (6-10)	◎ (6-10)
	9		Quenched & Tempered		350	38	◎ (3-5)	◎ (3-5)	◎ (3-5)	◎ (3-5)
	10	High alloyed steel, and tool steel	Annealed		200	15	○ (3-5)	○ (3-5)	○ (3-5)	○ (3-5)
	11		Quenched & Tempered		325	35				
M	12	Stainless steel	Ferritic / Martensitic Annealed		200	15	◎ (7-10)	◎ (7-10)	◎ (7-10)	◎ (7-10)
	13		Martensitic Quenched & Tempered		240	23	◎ (5-8)	◎ (5-8)	◎ (5-8)	◎ (5-8)
	14		Austenitic		180	10	◎ (4-6)	◎ (4-6)	◎ (4-6)	◎ (4-6)
K	15	Grey cast iron	Pearlitic / Ferritic		180	10	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)
	16		Pearlitic (Martensitic)		260	26	◎ (5-8)	◎ (5-8)	◎ (5-8)	◎ (5-8)
	17	Nodular cast iron	Ferritic		160	3	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)
	18		Pearlitic		250	25	◎ (5-8)	◎ (5-8)	◎ (5-8)	◎ (5-8)
	19	Malleable cast iron	Ferritic		130					
	20		Pearlitic		230	21				
N	21	Aluminum- wrought alloy	Not Curable		60					
	22		Curable Hardened		100					
	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		◎ (15-20)	◎ (15-20)	◎ (15-20)	◎ (15-20)
	24		≤ 12% Si, Curable Hardened		90					
	25		> 12% Si, Not Curable		130					
	26	Copper and Copper Alloys (Bronze / Brass)	Cutting Alloys, PB>1%		110		◎ (25-35)	◎ (25-35)	◎ (25-35)	◎ (25-35)
	27		CuZn, CuSnZn (Brass)		90		◎ (8-12)	◎ (8-12)	◎ (8-12)	◎ (8-12)
	28		CuSn, lead-free copper and electrolytic copper		100		◎ (15-20)	◎ (15-20)	◎ (15-20)	◎ (15-20)
	29	Non Metallic Materials	Duroplastic, Fiber Reinforced Plastic							
	30		Rubber, Wood, etc.							
S	31	Heat Resistant Super Alloys	Fe Based	Annealed	200	15				
	Cured			280	30					
	33		Ni or Co Based	Annealed	250	25				
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	36	Titanium Alloys	Pure Titanium		400 Rm					
	37		Alpha + Beta Alloys Hardened		1050 Rm					
H	38	Hardened steel	Hardened		550	55				
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	40	Chilled Cast Iron	Cast		400	42				
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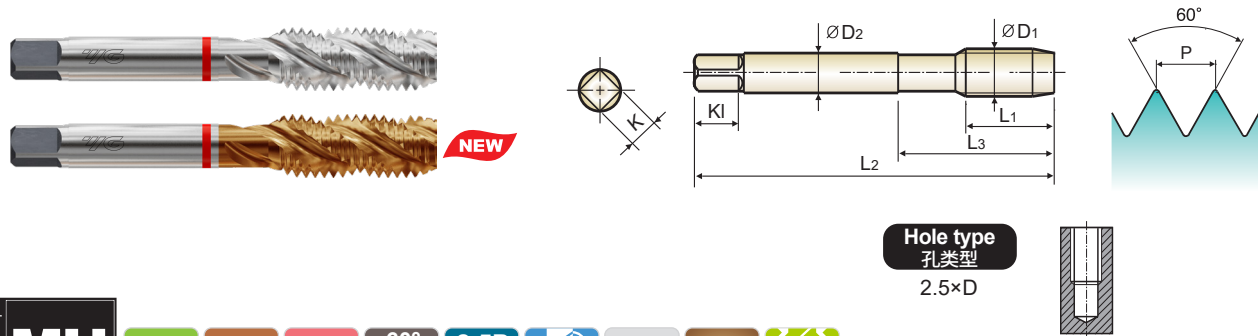
 Max. 2.5xD Blind Hole 盲孔		 Max. 3.0xD Through Hole 通孔						
HSS-PM		HSS-E						
2.5P		5.0P						
Spiral Flute 螺旋槽		Spiral Point 先端						
R40		-						
YH		YH						
I	I	I	I	I	I	I	I	
TR450 (p.20)	TT450 (p.20)	T2829 (p.21-24) T2849 (p.25-26)	T2829-U (p.21-24)	T2818 (p.27)	T2828 (p.28)	T2838 (p.29)	T2848 (p.30)	M/MF
								UNC/F
								W
								M-LH W-LH
								PIPE TAPS
Bright	TiN	Bright	FSH	Bright	Bright	Bright	Bright	
								
○ (15-20)	○ (20-25)	○ (15-20)	○ (20-25)	○ (15-20)	○ (15-20)	○ (15-20)	○ (15-20)	1
◎ (15-20)	◎ (20-25)	◎ (15-20)	◎ (20-25)	◎ (15-20)	◎ (15-20)	◎ (15-20)	◎ (15-20)	2
◎ (12-18)	◎ (18-24)	◎ (12-18)	◎ (18-24)	◎ (12-18)	◎ (12-18)	◎ (12-18)	◎ (12-18)	3
◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)	4
◎ (6-10)	◎ (10-14)	◎ (6-10)	◎ (10-14)	◎ (6-10)	◎ (6-10)	◎ (6-10)	◎ (6-10)	5
◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)	6
◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)	7
◎ (6-10)	◎ (10-14)	◎ (6-10)	◎ (10-14)	◎ (6-10)	◎ (6-10)	◎ (6-10)	◎ (6-10)	8
◎ (3-5)	◎ (5-7)	◎ (3-5)	◎ (5-7)	◎ (3-5)	◎ (3-5)	◎ (3-5)	◎ (3-5)	9
○ (3-5)	○ (5-7)	○ (3-5)	○ (5-7)	○ (3-5)	○ (3-5)	○ (3-5)	○ (3-5)	10
								11
◎ (7-10)	◎ (10-15)	◎ (7-10)	◎ (10-15)	◎ (7-10)	◎ (7-10)	◎ (7-10)	◎ (7-10)	12
◎ (5-8)	◎ (8-11)	◎ (5-8)	◎ (8-11)	◎ (5-8)	◎ (5-8)	◎ (5-8)	◎ (5-8)	13
◎ (4-6)	◎ (6-8)	◎ (4-6)	◎ (6-8)	◎ (4-6)	◎ (4-6)	◎ (4-6)	◎ (4-6)	14
◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)	15
◎ (5-8)	◎ (8-11)	◎ (5-8)	◎ (8-11)	◎ (5-8)	◎ (5-8)	◎ (5-8)	◎ (5-8)	16
◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (15-20)	◎ (10-15)	◎ (10-15)	◎ (10-15)	◎ (10-15)	17
◎ (5-8)	◎ (8-11)	◎ (5-8)	◎ (8-11)	◎ (5-8)	◎ (5-8)	◎ (5-8)	◎ (5-8)	18
								19
								20
								21
								22
◎ (15-20)	◎ (20-25)	◎ (15-20)	◎ (20-25)	◎ (15-20)	◎ (15-20)	◎ (15-20)	◎ (15-20)	23
								24
								25
◎ (25-35)	◎ (35-40)	◎ (25-35)	◎ (35-40)	◎ (25-35)	◎ (25-35)	◎ (25-35)	◎ (25-35)	26
◎ (8-12)	◎ (12-17)	◎ (8-12)	◎ (12-17)	◎ (8-12)	◎ (8-12)	◎ (8-12)	◎ (8-12)	27
◎ (15-20)	◎ (20-25)	◎ (15-20)	◎ (20-25)	◎ (15-20)	◎ (15-20)	◎ (15-20)	◎ (15-20)	28
								29
								30
								31
								32
								33
								34
								35
								36
								37
								38
								39
								40
								41

I-SP SPIRAL FLUTE TAPS for Multi-Purpose
I-SP 多用途螺旋槽丝锥

Bright T2809
FSH T2809-U

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



MU HSS-E I YH 60° 2.5P R40 Bright FSH p.5 Machine Taps

Tap Limits: p.31												Unit(单位) : mm			
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute				
尺寸	牙距	型号	NEW AOSTAP	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数				
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI					
M1	x 0.25	T2809011	-	YH1	30	-	5.5	3	2.5	5	2				
M1.1	x 0.25	T2809031	-	YH1	32	-	5.5	3	2.5	5	2				
M1.2	x 0.25	T2809051	-	YH1	32	-	5.5	3	2.5	5	2				
M1.4	x 0.3	T2809071	-	YH1	34	-	8	3	2.5	5	2				
M1.6	x 0.35	T2809091	-	YH1	36	-	8	3	2.5	5	2				
M1.7	x 0.35	T2809K51	-	YH1	36	-	8	3	2.5	5	2				
M1.8	x 0.35	T2809111	-	YH1	36	-	8	3	2.5	5	2				
M2	x 0.4	T2809131	T2809131U	YH1	40	15	9.5	3	2.5	5	2				
M2.2	x 0.45	T2809151	-	YH1	42	15	9.5	3	2.5	5	2				
M2.3	x 0.4	T2809191	-	YH1	42	15	9.5	3	2.5	5	2				
M2.5	x 0.45	T2809171	T2809171U	YH1	44	16	9.5	3	2.5	5	2				
M2.5	x 0.35	T2809181	-	YH1	44	16	9.5	3	2.5	5	2				
M2.6	x 0.45	T2809491	-	YH1	44	16	9.5	3	2.5	5	2				
M2.6	x 0.35	T2809K71	-	YH1	44	16	9.5	3	2.5	5	2				
M3	x 0.5	T2809202-C	T2809202U-C	YH2	46	18	11	4	3.2	6	3				
M3	x 0.35	T2809211-C	-	YH1	46	18	11	4	3.2	6	3				
M3.5	x 0.6	T2809222-C	-	YH2	48	20	13	4	3.2	6	3				
M3.5	x 0.35	T2809231-C	-	YH1	48	20	13	4	3.2	6	3				
M4	x 0.7	T2809242-C	T2809242U-C	YH2	52	20	13	5	4	7	3				
M4	x 0.5	T2809251-C	-	YH1	52	20	13	5	4	7	3				
M4.5	x 0.75	T2809262-C	-	YH2	55	20	13	5	4	7	3				
M5	x 0.8	T2809282-C	T2809282U-C	YH2	60	25	16	5.5	4.5	7	3				
M5	x 0.5	T2809292-C	-	YH2	60	25	16	5.5	4.5	7	3				
M5.5	x 0.5	T2809301-C	-	YH1	60	25	16	5.5	4.5	7	3				
M6	x 1.0	T2809312-C	T2809312U-C	YH2	62	28	19	6	4.5	7	3				
M6	x 0.75	T2809322-C	-	YH2	62	28	19	6	4.5	7	3				

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制
* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸
* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖 ; M8及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

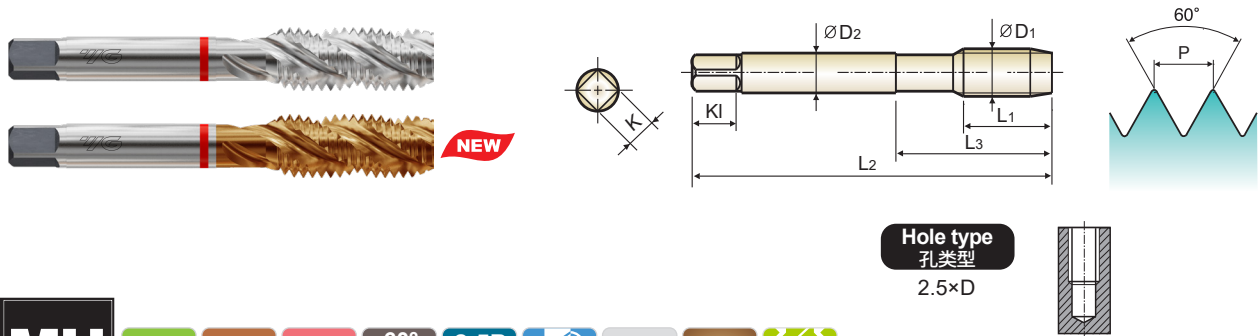
ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		
ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34	36	37	55	60	42	41	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

I-SP SPIRAL FLUTE TAPS for Multi-Purpose
I-SP 多用途螺旋槽丝锥

Bright T2809
FSH T2809-U

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



MU HSS-E I YH 60° 2.5P R40 Bright FSH p.5 Machine Taps

Tap Limits: p.31												Unit(单位) : mm			
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute				
尺寸	牙距	型号	NEW AOSTAP	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数				
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI					
M6	x 0.5	T2809332-C	-	YH2	62	28	19	6	4.5	7	3				
M7	x 1.0	T2809342-C	-	YH2	65	30	19	6.2	5	8	3				
M7	x 0.75	T2809352-C	-	YH2	65	30	19	6.2	5	8	3				
M8	x 1.25	T2809362-C	T2809362U-C	YH2	70	35	22	6.2	5	8	3				
M8	x 1.0	T2809372-C	-	YH2	70	35	22	6.2	5	8	3				
M8	x 0.75	T2809382-C	-	YH2	70	35	22	6.2	5	8	3				
M9	x 1.25	T2809392-C	-	YH2	72	37	22	7	5.5	8	3				
M9	x 1.0	T2809402-C	-	YH2	72	37	22	7	5.5	8	3				
M10	x 1.5	T2809422-C	T2809422U-C	YH2	75	39	24	7	5.5	8	3				
M10	x 1.25	T2809432-C	T2809432U-C	YH2	75	39	24	7	5.5	8	3				
M10	x 1.0	T2809442-C	T2809442U-C	YH2	75	39	24	7	5.5	8	3				
M10	x 0.75	T2809452-C	-	YH2	75	39	24	7	5.5	8	3				
M11	x 1.5	T2809462-C	-	YH2	80	40	25	8	6	9	3				
M11	x 1.0	T2809472-C	-	YH2	80	40	25	8	6	9	3				
M11	x 0.75	T2809482-C	-	YH2	80	40	25	8	6	9	3				
M12	x 1.75	T2809502-C	T2809502U-C	YH2	82	42	29	8.5	6.5	9	3				
M12	x 1.5	T2809512-C	T2809512U-C	YH2	82	42	29	8.5	6.5	9	3				
M12	x 1.25	T2809522-C	T2809522U-C	YH2	82	42	29	8.5	6.5	9	3				
M12	x 1.0	T2809532-C	-	YH2	82	42	29	8.5	6.5	9	3				
M14	x 2.0	T2809542	T2809542U	YH2	88	46	30	10.5	8	11	3				
M14	x 1.5	T2809552	T2809552U	YH2	88	46	30	10.5	8	11	3				
M14	x 1.25	T2809562	-	YH2	88	46	30	10.5	8	11	3				
M14	x 1.0	T2809572	-	YH2	88	46	30	10.5	8	11	3				
M15	x 1.5	T2809582	-	YH2	90	47	30	10.5	8	11	3				
M15	x 1.0	T2809592	-	YH2	90	47	30	10.5	8	11	3				
M16	x 2.0	T2809602	T2809602U	YH2	95	50	32	12.5	10	13	3				

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制
* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸
* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖 ; M8及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M				K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	○	○	○	○	○	○	○	○	○		○	○	○	○	○	○	○		

ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			○			○	○	○														

M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

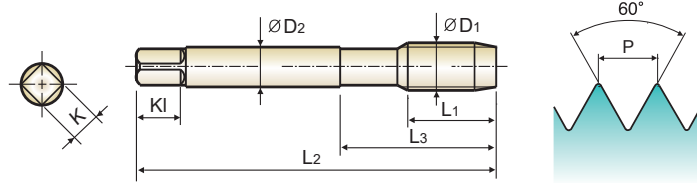
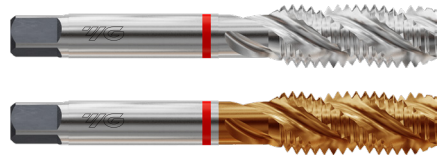
I-SP 多用途螺旋槽丝锥

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

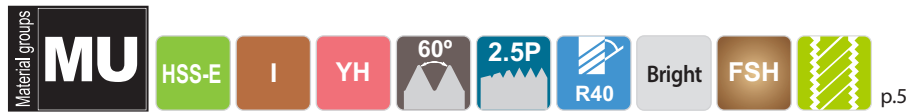
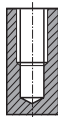
► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命

SERIES

Bright **T2809**
FSH **T2809-U**



Hole type
孔类型
2.5×D



Machine Taps

Tap Limits: p.31												Unit(单位) : mm		
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute			
尺寸	牙距	型号	NEW AOSTAP	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数			
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI				
M16	x 1.5	T2809612	T2809612U	YH2	95	50	32	12.5	10	13	3			
M16	x 1.0	T2809622	-	YH2	95	50	32	12.5	10	13	3			
M18	x 2.5	T2809653	T2809653U	YH3	100	55	37	14	11	14	4			
M18	x 2.0	T2809663	-	YH3	100	55	37	14	11	14	4			
M18	x 1.5	T2809672	T2809672U	YH2	100	55	37	14	11	14	4			
M18	x 1.0	T2809682	-	YH2	100	55	37	14	11	14	4			
M20	x 2.5	T2809703	T2809703U	YH3	105	56	37	15	12	15	4			
M20	x 2.0	T2809713	-	YH3	105	56	37	15	12	15	4			
M20	x 1.5	T2809723	T2809723U	YH3	105	56	37	15	12	15	4			
M20	x 1.0	T2809732	-	YH2	105	56	37	15	12	15	4			
M22	x 2.5	T2809743	-	YH3	115	65	38	17	13	16	4			
M22	x 2.0	T2809753	-	YH3	115	65	38	17	13	16	4			
M22	x 1.5	T2809763	-	YH3	115	65	38	17	13	16	4			
M22	x 1.0	T2809772	-	YH2	115	65	38	17	13	16	4			
M24	x 3.0	T2809783	T2809783U	YH3	120	72	45	19	15	18	4			
M24	x 2.0	T2809793	-	YH3	120	72	45	19	15	18	4			
M24	x 1.5	T2809803	T2809803U	YH3	120	72	45	19	15	18	4			
M24	x 1.0	T2809812	-	YH2	120	72	45	19	15	18	4			
M25	x 2.0	T2809823	-	YH3	125	75	45	19	15	18	4			
M25	x 1.5	T2809833	-	YH3	125	75	45	19	15	18	4			
M26	x 2.0	T2809N43	-	YH3	125	75	45	20	15	18	4			
M26	x 1.5	T2809853	-	YH3	125	75	45	20	15	18	4			
M27	x 3.0	T2809863	-	YH3	130	77	45	20	15	18	4			
M27	x 2.0	T2809873	-	YH3	130	77	45	20	15	18	4			
M27	x 1.5	T2809883	-	YH3	130	77	45	20	15	18	4			
M28	x 2.0	T2809903	-	YH3	130	77	45	21	17	20	4			

* TiN, TiCN, Steam Oxide is available on your request. **TiN, TiCN, Steam Oxide 可根据要求定制**
 * Refer to p.32-34 for recommended tap drill sizes. **参考p.32-34 底孔尺寸**
 * M1~M7: Male Center / M8~: Female Center **M1~M7: 公顶尖 ; M8及以上: 母顶尖**

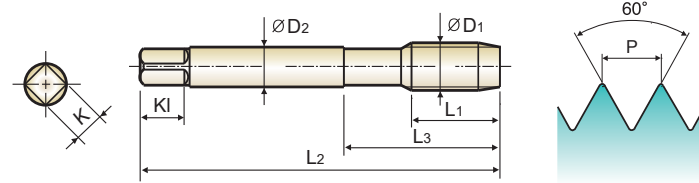
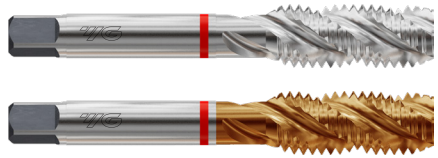
◎: Excellent (优秀) ○: Good (良好)																					
ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○		◎	◎	◎	◎	◎	◎	◎			
ISO	N									S							H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials	Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

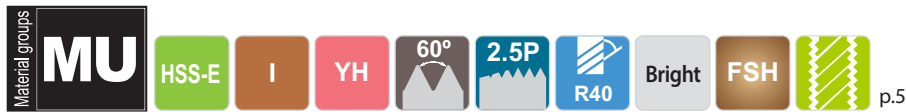
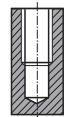
I-SP 多用途螺旋槽丝锥

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Hole type
孔类型
2.5×D



Machine Taps

Tap Limits: p.31												Unit(单位) : mm		
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute			
尺寸	牙距	型号	NEW AOSTAP	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数			
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI				
M28	x 1.5	T2809913	-	YH3	130	77	45	21	17	20	4			
M30	x 3.5	T2809944	-	YH4	135	80	48	23	17	20	4			
M30	x 3.0	T2809953	-	YH3	135	80	48	23	17	20	4			
M30	x 2.0	T2809963	-	YH3	135	80	48	23	17	20	4			
M30	x 1.5	T2809973	-	YH3	135	80	48	23	17	20	4			
M33	x 3.5	T2809A44	-	YH4	145	85	51	25	19	22	4			
M33	x 2.0	T2809A63	-	YH3	145	85	45	25	19	22	4			
M33	x 1.5	T2809A73	-	YH3	145	85	45	25	19	22	4			
M35	x 1.5	T2809B13	-	YH3	155	90	45	26	21	24	4			
M36	x 4.0	T2809B34	-	YH4	155	90	57	28	21	24	4			
M36	x 3.0	T2809B43	-	YH3	155	90	57	28	21	24	4			
M36	x 2.0	T2809B53	-	YH3	155	90	45	28	21	24	4			
M36	x 1.5	T2809B63	-	YH3	155	90	45	28	21	24	4			
M39	x 4.0	T2809C04	-	YH4	165	93	60	30	23	26	4			
M40	x 1.5	T2809C63	-	YH3	165	93	45	30	23	26	4			
M42	x 4.5	T2809C84	-	YH4	175	95	60	32	26	30	4			
M42	x 3.0	T2809D04	-	YH4	175	95	60	32	26	30	4			
M42	x 2.0	T2809D13	-	YH3	175	95	45	32	26	30	4			
M42	x 1.5	T2809D23	-	YH3	175	95	45	32	26	30	4			
M45	x 4.5	T2809D54	-	YH4	180	95	67	35	26	30	4			
M45	x 1.5	T2809D93	-	YH3	180	95	45	35	26	30	4			
M48	x 5.0	T2809E24	-	YH4	185	97	67	38	29	32	4			
M48	x 3.0	T2809E54	-	YH4	185	97	67	38	29	32	4			
M48	x 1.5	T2809E73	-	YH3	185	97	45	38	29	32	4			
M52	x 5.0	T2809F34	-	YH4	195	102	70	42	32	35	4			

* TiN, TiCN, Steam Oxide is available on your request. **TiN, TiCN, Steam Oxide 可根据要求定制**
 * Refer to p.32-34 for recommended tap drill sizes. **参考p.32-34 底孔尺寸**
 * M1~M7: Male Center / M8~: Female Center **M1~M7: 公顶尖 ; M8及以上: 母顶尖**

																			◎ : Excellent (优秀) ○ : Good (良好)					
ISO	P											M				K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron				
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20				
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21				
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230				
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○		◎	◎	◎	◎	◎	◎	◎						
ISO	N										S								H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron					
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41			
HRc											15	30	25	38	34			55	60	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550			
Recommended			◎			◎	◎	◎																

UNC/F I-SP SPIRAL FLUTE TAPS for Multi-Purpose

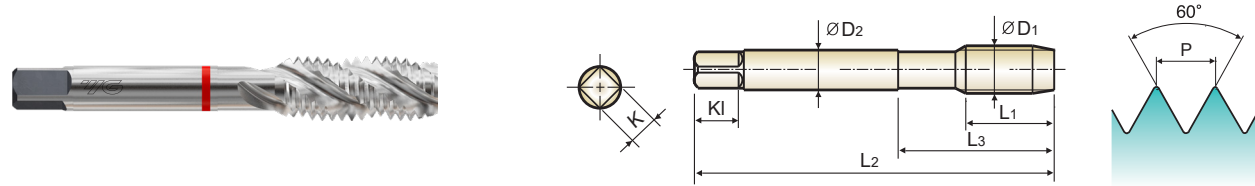
I-SP 多用途螺旋槽丝锥

SERIES

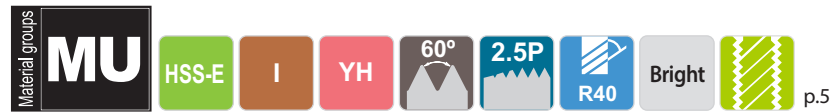
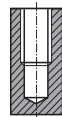
Bright **T2839**

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Hole type
孔类型
2.5×D



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	TPI	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1		Bright		L2	L3	L1	ØD2	K	KI		
#4 - 40UNC		T2839161	YH1	44	16	9.5	3	2.5	5	3	
#4 - 48UNF		T2839181	YH1	44	16	9.5	3	2.5	5	3	
#5 - 40UNC		T2839201-C	YH1	46	18	11	4	3.2	6	3	
#5 - 44UNF		T2839221-C	YH1	46	18	11	4	3.2	6	3	
#6 - 32UNC		T2839242-C	YH2	48	20	13	4	3.2	6	3	
#6 - 40UNF		T2839261-C	YH1	48	20	13	4	3.2	6	3	
#8 - 32UNC		T2839282-C	YH2	52	21	13	5	4	7	3	
#8 - 36UNF		T2839302-C	YH2	52	21	13	5	4	7	3	
#10 - 24UNC		T2839322-C	YH2	60	25	16	5.5	4.5	7	3	
#10 - 32UNF		T2839342-C	YH2	60	25	16	5.5	4.5	7	3	
#12 - 24UNC		T2839362-C	YH2	60	25	16	5.5	4.5	7	3	
#12 - 28UNF		T2839382-C	YH2	60	25	16	5.5	4.5	7	3	
1/4 - 20UNC		T2839402-C	YH2	62	30	19	6	4.5	7	3	
1/4 - 28UNF		T2839422-C	YH2	62	30	19	6	4.5	7	3	
5/16 - 18UNC		T2839442-C	YH2	70	35	22	6.1	5	8	3	
5/16 - 24UNF		T2839462-C	YH2	70	35	22	6.1	5	8	3	
3/8 - 16UNC		T2839482-C	YH2	75	39	24	7	5.5	8	3	
3/8 - 24UNF		T2839502-C	YH2	75	39	24	7	5.5	8	3	
7/16 - 14UNC		T2839523-C	YH3	80	40	25	8	6	9	3	
7/16 - 20UNF		T2839542-C	YH2	80	40	25	8	6	9	3	
1/2 - 13UNC		T2839563-C	YH3	85	44	29	9	7	10	3	
1/2 - 20UNF		T2839582-C	YH2	85	44	29	9	7	10	3	
9/16 - 12UNC		T2839603	YH3	90	47	30	10.5	8	11	3	
9/16 - 18UNF		T2839622	YH2	90	47	30	10.5	8	11	3	
5/8 - 11UNC		T2839643	YH3	95	50	32	12	9	12	3	
5/8 - 18UNF		T2839662	YH2	95	50	32	12	9	12	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* #0~5/16: Male Center / 3/8~: Female Center #0~5/16: 公顶尖 ; 3/8及以上: 母顶尖

► NEXT PAGE 下页

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M			K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160		130	230
Recommended	○	◎		◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎		

ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

UNC/F I-SP SPIRAL FLUTE TAPS for Multi-Purpose

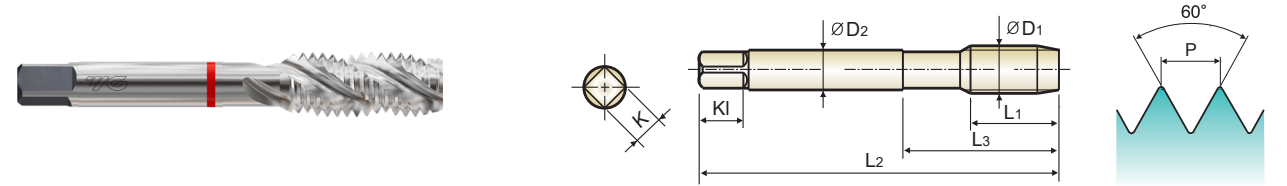
I-SP 多用途螺旋槽丝锥

SERIES

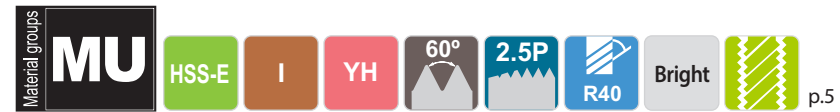
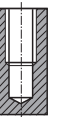
Bright **T2839**

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Hole type
孔类型
2.5×D



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	TPI	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1		Bright		L2	L3	L1	ØD2	K	KI		
3/4 - 10UNC		T2839703	YH3	105	56	37	14	11	14	4	
3/4 - 16UNF		T2839723	YH3	105	56	37	14	11	14	4	
7/8 - 9UNC		T2839743	YH3	115	65	38	17	13	16	4	
7/8 - 14UNF		T2839763	YH3	115	65	38	17	13	16	4	
1" - 8UNC		T2839783	YH3	125	75	45	20	15	18	4	
1" - 12UNF		T2839803	YH3	125	75	45	20	15	18	4	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* #0~5/16: Male Center / 3/8~: Female Center #0~5/16: 公顶尖 ; 3/8及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	◎	◎				
ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc											15	30	25	38	34			55	60	42	55	
HB	60	100		75	90	130	110	90	100		200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

I-SP 多用途螺旋槽丝锥

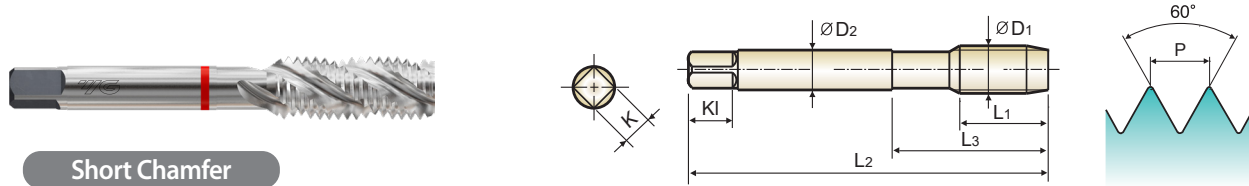
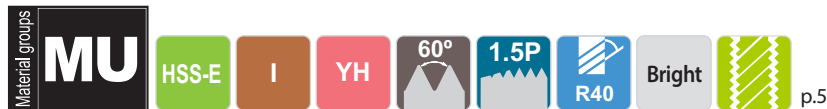
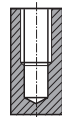
SERIES

Bright

T2819

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命


 Hole type
孔类型
1.5×D

Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M1	x 0.25	T2819011	YH1	30	-	5.5	3	2.5	5	2	
M1.2	x 0.25	T2819051	YH1	32	-	5.5	3	2.5	5	2	
M1.4	x 0.3	T2819071	YH1	34	-	8	3	2.5	5	2	
M1.6	x 0.35	T2819091	YH1	36	-	8	3	2.5	5	2	
M1.7	x 0.35	T2819K51	YH1	36	-	8	3	2.5	5	2	
M1.8	x 0.35	T2819111	YH1	36	-	8	3	2.5	5	2	
M2	x 0.4	T2819131	YH1	40	15	9.5	3	2.5	5	2	
M2.3	x 0.4	T2819191	YH1	42	15	9.5	3	2.5	5	2	
M2.5	x 0.45	T2819171	YH1	44	16	9.5	3	2.5	5	2	
M2.6	x 0.45	T2819491	YH1	44	16	9.5	3	2.5	5	2	
M3	x 0.5	T2819202-C	YH2	46	18	11	4	3.2	6	3	
M4	x 0.7	T2819242-C	YH2	52	20	13	5	4	7	3	
M5	x 0.8	T2819282-C	YH2	60	25	16	5.5	4.5	7	3	
M6	x 1.0	T2819312-C	YH2	62	28	19	6	4.5	7	3	
M8	x 1.25	T2819362-C	YH2	70	35	22	6.2	5	8	3	
M8	x 1.0	T2819372-C	YH2	70	35	22	6.2	5	8	3	
M10	x 1.5	T2819422-C	YH2	75	39	24	7	5.5	8	3	
M10	x 1.25	T2819432-C	YH2	75	39	24	7	5.5	8	3	
M10	x 1.0	T2819442-C	YH2	75	39	24	7	5.5	8	3	
M12	x 1.75	T2819502-C	YH2	82	42	29	8.5	6.5	9	3	
M12	x 1.5	T2819512-C	YH2	82	42	29	8.5	6.5	9	3	
M12	x 1.25	T2819522-C	YH2	82	42	29	8.5	6.5	9	3	
M12	x 1.0	T2819532-C	YH2	82	42	29	8.5	6.5	9	3	
M14	x 2.0	T2819542	YH2	88	46	30	10.5	8	11	3	
M14	x 1.5	T2819552	YH2	88	46	30	10.5	8	11	3	
M16	x 2.0	T2819602	YH2	95	50	32	12.5	10	13	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖 ; M8及以上: 母顶尖

► NEXT PAGE 下页

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M			K								
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎				
ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

I-SP 多用途螺旋槽丝锥

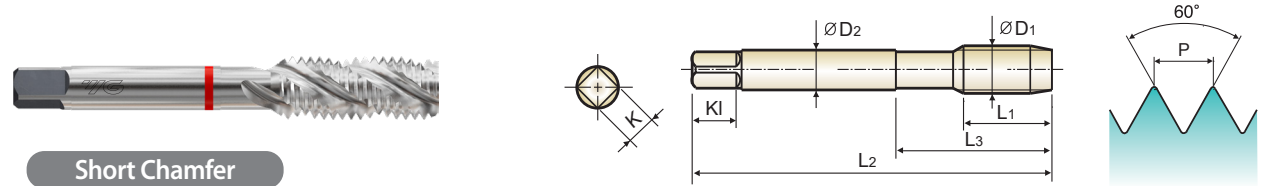
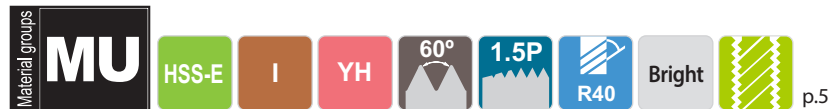
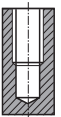
SERIES

Bright

T2819

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命


 Hole type
孔类型
1.5×D

Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M16	x 1.5	T2819612	YH2	95	50	32	12.5	10	13	3	
M18	x 2.5	T2819653	YH3	100	55	37	14	11	14	4	
M18	x 1.5	T2819672	YH2	100	55	37	14	11	14	4	
M20	x 2.5	T2819703	YH3	105	56	37	15	12	15	4	
M20	x 1.5	T2819723	YH3	105	56	37	15	12	15	4	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖 ; M8及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P											M			K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○		◎	◎	◎	◎	◎	◎	◎			

ISO	N										S						H						
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRC											15	30	25	38	34			55	60	42	41		
HB	60	100		75	90	130	110	90	100		200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommended			◎			◎	◎	◎															

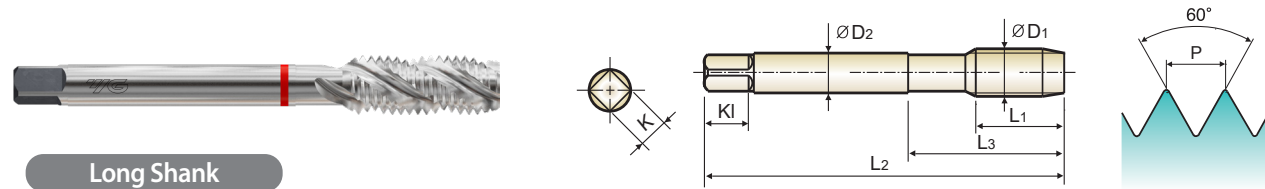
M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

I-SP 多用途螺旋槽丝锥

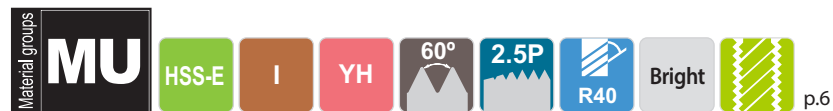
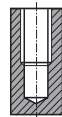
Bright **T2817** SERIES

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Hole type
孔类型
2.5×D



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M2 x 0.4		T2817131	YH1	100	-	11	4	3.2	6	2	
M2.5 x 0.45		T2817171	YH1	100	-	11	4	3.2	6	2	
M3 x 0.5		T2817202-C	YH2	100	18	11	4	3.2	6	3	
M4 x 0.7		T2817242-C	YH2	100	21	13	5	4	7	3	
M5 x 0.8		T2817282-C	YH2	100	25	16	5.5	4.5	7	3	
M6 x 1.0		T2817312-C	YH2	100	30	19	6	4.5	7	3	
M8 x 1.25		T2817362-C	YH2	100	35	22	6.2	5	8	3	
M8 x 1.0		T2817372-C	YH2	100	35	22	6.2	5	8	3	
M8 x 0.75		T2817382-C	YH2	100	35	22	6.2	5	8	3	
M10 x 1.5		T2817422-C	YH2	100	39	24	7	5.5	8	3	
M10 x 1.25		T2817432-C	YH2	100	39	24	7	5.5	8	3	
M10 x 1.0		T2817442-C	YH2	100	39	24	7	5.5	8	3	
M12 x 1.75		T2817502-C	YH2	100	42	29	8.5	6.5	9	3	
M12 x 1.5		T2817512-C	YH2	100	42	29	8.5	6.5	9	3	
M12 x 1.25		T2817522-C	YH2	100	42	29	8.5	6.5	9	3	
M12 x 1.0		T2817532-C	YH2	100	42	29	8.5	6.5	9	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖 ; M8及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M			K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommended	○	◎		◎	◎	◎	◎	◎	◎	○		◎	◎	◎	◎	◎	◎	◎		

ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast iron	Hardened Cast iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

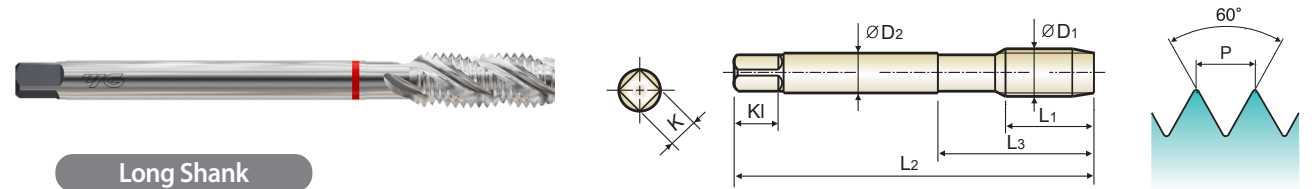
M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

I-SP 多用途螺旋槽丝锥

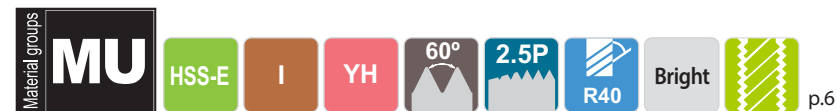
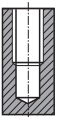
Bright **T2827** SERIES

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Hole type
孔类型
2.5×D



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M3 x 0.5		T2827202-C	YH2	120	18	11	4	3.2	6	3	
M4 x 0.7		T2827242-C	YH2	120	21	13	5	4	7	3	
M5 x 0.8		T2827282-C	YH2	120	25	16	5.5	4.5	7	3	
M6 x 1.0		T2827312-C	YH2	120	30	19	6	4.5	7	3	
M8 x 1.25		T2827362-C	YH2	120	35	22	6.2	5	8	3	
M8 x 1.0		T2827372-C	YH2	120	35	22	6.2	5	8	3	
M10 x 1.5		T2827422-C	YH2	120	39	24	7	5.5	8	3	
M10 x 1.25		T2827432-C	YH2	120	39	24	7	5.5	8	3	
M10 x 1.0		T2827442-C	YH2	120	39	24	7	5.5	8	3	
M12 x 1.75		T2827502-C	YH2	120	42	29	8.5	6.5	9	3	
M12 x 1.5		T2827512-C	YH2	120	42	29	8.5	6.5	9	3	
M12 x 1.25		T2827522-C	YH2	120	42	29	8.5	6.5	9	3	
M12 x 1.0		T2827532-C	YH2	120	42	29	8.5	6.5	9	3	
M14 x 2.0		T2827542	YH2	120	47	30	10.5	8	11	3	
M14 x 1.5		T2827552	YH2	120	47	30	10.5	8	11	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖 ; M8及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
Hrc		13	25	28	32	10	29	32	38	15	35	12	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎			
ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast iron	Hardened Cast iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
Hrc											15	30	25	38	34			55	60	42	55
HB	60	100		75	90	130	110	90	100		200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

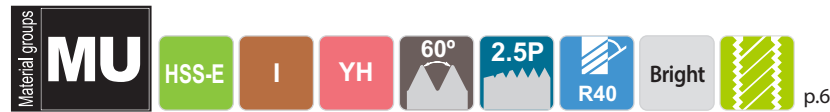
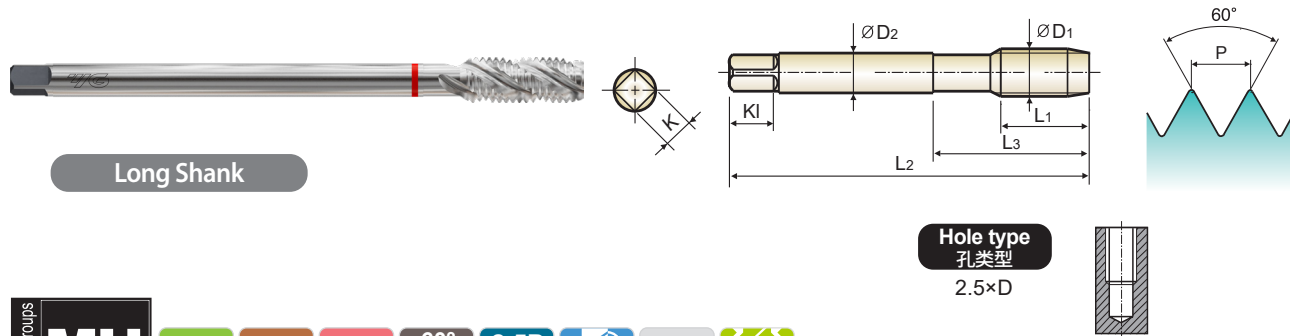
I-SP 多用途螺旋槽丝锥

SERIES

 Bright **T2837**

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命


Machine Taps

Tap Limits: p.31										Unit(单位): mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块尺寸	方块长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M3 x 0.5		T2837202-C	YH2	150	18	11	4	3.2	6	3	
M4 x 0.7		T2837242-C	YH2	150	21	13	5	4	7	3	
M5 x 0.8		T2837282-C	YH2	150	25	16	5.5	4.5	7	3	
M6 x 1.0		T2837312-C	YH2	150	30	19	6	4.5	7	3	
M8 x 1.25		T2837362-C	YH2	150	35	22	6.2	5	8	3	
M8 x 1.0		T2837372-C	YH2	150	35	22	6.2	5	8	3	
M10 x 1.5		T2837422-C	YH2	150	39	24	7	5.5	8	3	
M10 x 1.25		T2837432-C	YH2	150	39	24	7	5.5	8	3	
M10 x 1.0		T2837442-C	YH2	150	39	24	7	5.5	8	3	
M12 x 1.75		T2837502-C	YH2	150	42	29	8.5	6.5	9	3	
M12 x 1.5		T2837512-C	YH2	150	42	29	8.5	6.5	9	3	
M12 x 1.25		T2837522-C	YH2	150	42	29	8.5	6.5	9	3	
M12 x 1.0		T2837532-C	YH2	150	42	29	8.5	6.5	9	3	
M14 x 2.0		T2837542	YH2	150	47	30	10.5	8	11	3	
M14 x 1.5		T2837552	YH2	150	47	30	10.5	8	11	3	
M15 x 1.0		T2837592	YH2	150	47	30	10.5	8	11	3	
M16 x 2.0		T2837602	YH2	150	50	32	12.5	10	13	3	
M16 x 1.5		T2837612	YH2	150	50	32	12.5	10	13	3	
M18 x 2.5		T2837653	YH3	150	55	37	14	11	14	4	
M18 x 1.5		T2837672	YH2	150	55	37	14	11	14	4	
M20 x 2.5		T2837703	YH3	150	56	37	15	12	15	4	
M20 x 1.5		T2837723	YH3	150	56	37	15	12	15	4	
M22 x 2.5		T2837743	YH3	150	65	38	17	13	16	4	
M22 x 1.5		T2837763	YH3	150	65	38	17	13	16	4	
M24 x 3.0		T2837783	YH3	150	72	45	19	15	18	4	
M24 x 1.5		T2837803	YH3	150	72	45	19	15	18	4	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖; M8及以上: 母顶尖

◎: Excellent (优秀) ○: Good (良好)

ISO	P										M				K									
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20				
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21				
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160		130	230				
Recommended	○	◎		◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎						
ISO	N										S										H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron			
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41			
HRC											15	30	25	38	34			55	60	42	55			
HB	60	100		75	90	130	110	90	100		200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550			
Recommended			◎			◎	◎	◎																

M I-SP SPIRAL FLUTE TAPS for Multi-Purpose

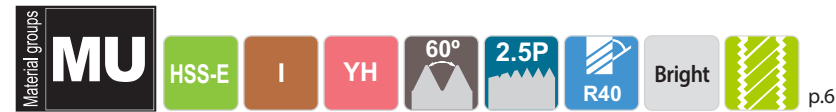
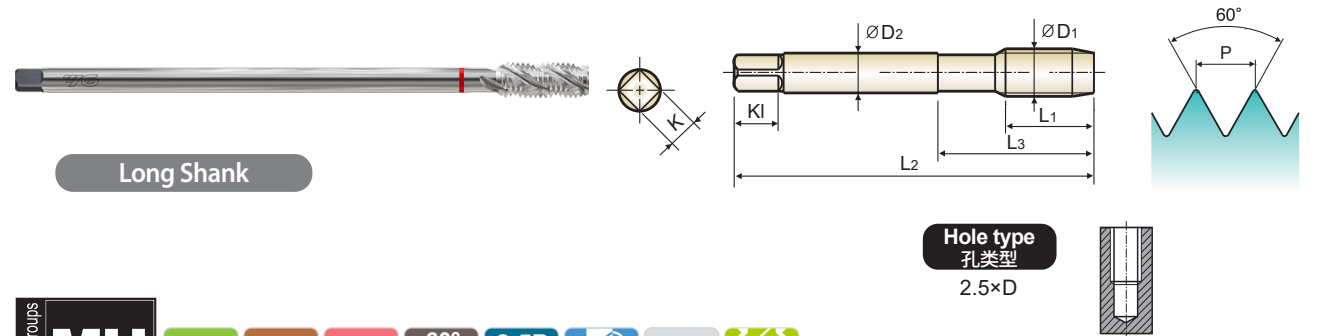
I-SP 多用途螺旋槽丝锥

SERIES

 Bright **T2847**

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命


Machine Taps

Tap Limits: p.31										Unit(单位): mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块尺寸	方块长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M6 x 1.0		T2847312-C	YH2	200	30	19	6	4.5	7	3	
M8 x 1.25		T2847362-C	YH2	200	35	22	6.2	5	8	3	
M10 x 1.5		T2847422-C	YH2	200	39	24	7	5.5	8	3	
M10 x 1.25		T2847432-C	YH2	200	39	24	7	5.5	8	3	
M12 x 1.75		T2847502-C	YH2	200	42	29	8.5	6.5	9	3	
M14 x 2.0		T2847542	YH2	200	47	30	10.5	8	11	3	
M14 x 1.5		T2847552	YH2	200	47	30	10.5	8	11	3	
M16 x 2.0		T2847602	YH2	200	50	32	12.5	10	13	3	
M18 x 2.5		T2847653	YH3	200	55	37	14	11	14	4	
M20 x 2.5		T2847703	YH3	200	56	37	15	12	15	4	
M22 x 2.5		T2847743	YH3	200	65	38	17	13	16	4	
M24 x 3.0		T2847783	YH3	200	72	45	19	15	18	4	
M27 x 3.0		T2847863	YH3	200	77	45	20	15	18	4	
M30 x 3.5		T2847944	YH4	200	80	48	23	17	20	4	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖; M8及以上: 母顶尖

◎: Excellent (优秀) ○: Good (良好)

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○			◎	◎	◎	◎	◎	◎			
ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC											15	30	25	38	34			55	60	42	55
HB	60	100		75	90	130	110	90	100		200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

I-SP SPIRAL FLUTE TAPS for Multi-Purpose

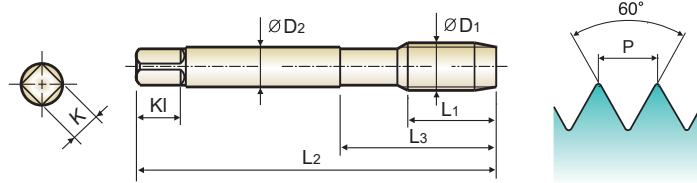
I-SP 多用途螺旋槽丝锥

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

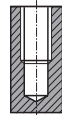
► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Short Thread Length



Hole type
孔类型
2.5×D



Machine Taps

Tap Limits: p.31												Unit(单位): mm			
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute				
尺寸	牙距	型号		精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数				
ØD1	P	Bright	TiN		L2	L3	L1	ØD2	K	KI					
M3	x 0.5	TR450202	TT450202	YH2	46	18	3.5	4	3.2	6	3				
M4	x 0.7	TR450242	TT450242	YH2	52	21	4.9	5	4	7	3				
M5	x 0.8	TR450282	TT450282	YH2	60	25	5.6	5.5	4.5	7	3				
M6	x 1.0	TR450312	TT450312	YH2	62	29	7	6	4.5	7	3				
M8	x 1.25	TR450363	TT450363	YH3	70	37	8.5	6.2	5	8	3				
M8	x 1.0	TR450372	TT450372	YH2	70	37	8.5	6.2	5	8	3				
M10	x 1.5	TR450423	TT450423	YH3	75	41	10.5	7	5.5	8	3				
M10	x 1.25	TR450433	TT450433	YH3	75	41	10.5	7	5.5	8	3				
M12	x 1.75	TR450503	TT450503	YH3	82	48	12	8.5	6.5	9	3				
M12	x 1.5	TR450513	TT450513	YH3	82	48	12	8.5	6.5	9	3				
M12	x 1.25	TR450523	TT450523	YH3	82	48	12	8.5	6.5	9	3				
M12	x 1.0	TR450532	TT450532	YH2	82	48	12	8.5	6.5	9	3				
M14	x 2.0	TR450543	TT450543	YH3	88	48	14	10.5	8	11	3				
M14	x 1.5	TR450553	TT450553	YH3	88	48	14	10.5	8	11	3				
M16	x 2.0	TR450603	TT450603	YH3	95	52	14	12.5	10	13	3				
M16	x 1.5	TR450613	TT450613	YH3	95	52	14	12.5	10	13	3				
M18	x 2.5	TR450653	TT450653	YH3	100	55	17.5	14	11	14	4				
M18	x 1.5	TR450673	TT450673	YH3	100	55	17.5	14	11	14	4				
M20	x 2.5	TR450703	TT450703	YH3	105	58	17.5	15	12	15	4				
M20	x 1.5	TR450723	TT450723	YH3	105	58	17.5	15	12	15	4				
M22	x 2.5	TR450744	TT450744	YH4	115	63	17.5	17	13	16	4				
M22	x 1.5	TR450763	TT450763	YH3	115	63	17.5	17	13	16	4				
M24	x 3.0	TR450784	TT450784	YH4	120	66	21	19	15	18	4				
M24	x 1.5	TR450803	TT450803	YH3	120	66	21	19	15	18	4				

* TiCN, Steam Oxide is available on your request. TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8~: Female Center M1~M7: 公顶尖 ; M8及以上: 母顶尖

◎: Excellent (优秀) ○: Good (良好)

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	15	26	3	25		21		
HB		125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎		◎	◎		◎	◎	◎	◎			
ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34	36	37	55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

I-GP SPIRAL POINT TAPS for Multi-Purpose

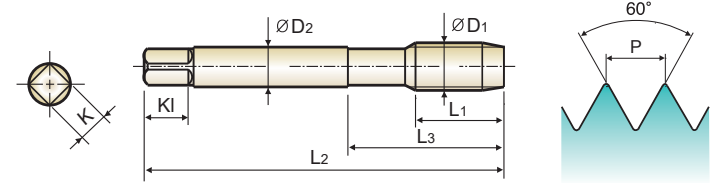
I-GP 多用途先端丝锥

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

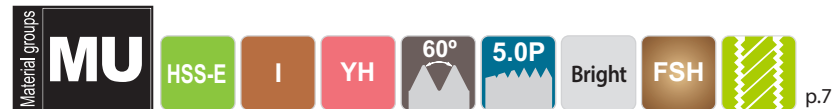
► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



NEW



Hole type
孔类型
3.0×D



Machine Taps

Tap Limits: p.31												Unit(单位): mm			
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute				
尺寸	牙距	型号		精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数				
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI					
M1	x 0.25	T2829011	-	YH1	30	-	5.5	3	2.5	5	2				
M1.1	x 0.25	T2829031	-	YH1	32	-	5.5	3	2.5	5	2				
M1.2	x 0.25	T2829051	-	YH1	32	-	5.5	3	2.5	5	2				
M1.4	x 0.3	T2829071	-	YH1	34	-	8	3	2.5	5	2				
M1.6	x 0.35	T2829091	-	YH1	36	-	8	3	2.5	5	2				
M1.7	x 0.35	T2829K51	-	YH1	36	-	8	3	2.5	5	2				
M1.8	x 0.35	T2829112	-	YH2	36	-	8	3	2.5	5	2				
M2	x 0.4	T2829132	T2829132U	YH2	40	15	9.5	3	2.5	5	2				
M2.2	x 0.45	T2829152	-	YH2	42	15	9.5	3	2.5	5	2				
M2.3	x 0.4	T2829192	-	YH2	42	15	9.5	3	2.5	5	2				
M2.5	x 0.45	T2829172	T2829172U	YH2	44	16	9.5	3	2.5	5	2				
M2.6	x 0.45	T2829492	-	YH2	44	16	9.5	3	2.5	5	2				
M3	x 0.5	T2829202-C	T2829202U-C	YH2	46	18	11	4	3.2	6	3				
M3	x 0.35	T2829212-C	-	YH2	46	18	11	4	3.2	6	3				
M3.5	x 0.6	T2829222-C	-	YH2	48	20	13	4	3.2	6	3				
M3.5	x 0.35	T2829232-C	-	YH2	48	20	13	4	3.2	6	3				
M4	x 0.7	T2829242-C	T2829242U-C	YH2	52	20	13	5	4	7	3				
M4	x 0.5	T2829252-C	-	YH2	52	20	13	5	4	7	3				
M4.5	x 0.75	T2829262-C	-	YH2	55	20	13	5	4	7	3				
M5	x 0.8	T2829282-C	T2829282U-C	YH2	60	25	16	5.5	4.5	7	3				
M5	x 0.5	T2829292-C	-	YH2	60	25	16	5.5	4.5	7	3				
M5.5	x 0.5	T2829302-C	-	YH2	60	25	16	5.5	4.5	7	3				
M6	x 1.0	T2829312-C	T2829312U-C	YH2	62	28	19	6	4.5	7	3				
M6	x 0.75	T2829322-C	-	YH2	62	28	19	6	4.5	7	3				
M6	x 0.5	T2829332-C	-	YH2	62	28	19	6	4.5	7	3				
M7	x 1.0	T2829342-C	-	YH2	65	30	19	6.2	5	8	3				

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖

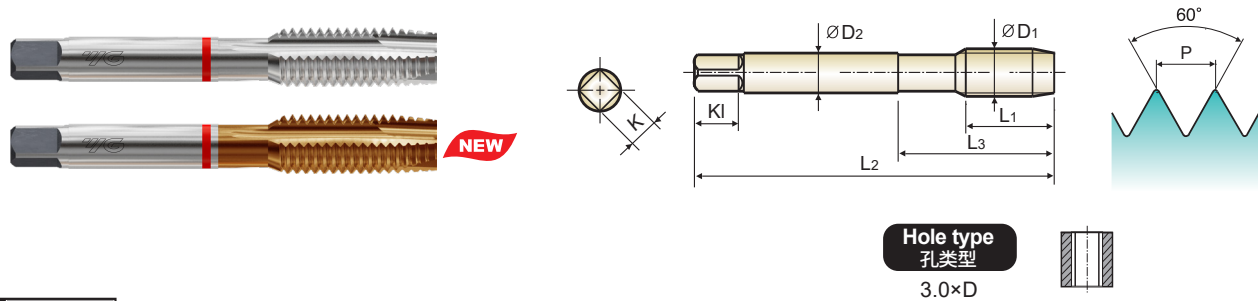
														◎ : Excellent (优秀) ○ : Good (良好)									
ISO	P										M				K								
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○		◎	◎	◎	◎	◎	◎	◎					
ISO	N										S						H						
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRC											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommended			◎			◎	◎	◎															

I-GP SPIRAL POINT TAPS for Multi-Purpose
I-GP 多用途先端丝锥

Bright T2829
FSH T2829-U

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Material groups MU HSS-E I YH 60° 5.0P Bright FSH p.7

Machine Taps

Tap Limits: p.31												Unit(单位) : mm			
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute				
尺寸	牙距	型号	NEW AOSTAP	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数				
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI					
M7 x 0.75		T2829352-C	-	YH2	65	30	19	6.2	5	8	3				
M8 x 1.25		T2829363-C	T2829363U-C	YH3	70	35	22	6.2	5	8	3				
M8 x 1.0		T2829373-C	-	YH3	70	35	22	6.2	5	8	3				
M8 x 0.75		T2829383-C	-	YH3	70	35	22	6.2	5	8	3				
M9 x 1.25		T2829393-C	-	YH3	72	37	22	7	5.5	8	3				
M9 x 1.0		T2829403-C	-	YH3	72	37	22	7	5.5	8	3				
M10 x 1.5		T2829423-C	T2829423U-C	YH3	75	39	24	7	5.5	8	3				
M10 x 1.25		T2829433-C	T2829433U-C	YH3	75	39	24	7	5.5	8	3				
M10 x 1.0		T2829443-C	T2829443U-C	YH3	75	39	24	7	5.5	8	3				
M10 x 0.75		T2829453-C	-	YH3	75	39	24	7	5.5	8	3				
M11 x 1.5		T2829463-C	-	YH3	80	40	25	8	6	9	3				
M11 x 1.0		T2829473-C	-	YH3	80	40	25	8	6	9	3				
M11 x 0.75		T2829483-C	-	YH3	80	40	25	8	6	9	3				
M12 x 1.75		T2829504-C	T2829504U-C	YH4	82	42	29	8.5	6.5	9	3				
M12 x 1.5		T2829513-C	T2829513U-C	YH3	82	42	29	8.5	6.5	9	3				
M12 x 1.25		T2829523-C	T2829523U-C	YH3	82	42	29	8.5	6.5	9	3				
M12 x 1.0		T2829533-C	-	YH3	82	42	29	8.5	6.5	9	3				
M14 x 2.0		T2829544	T2829544U	YH4	88	46	30	10.5	8	11	3				
M14 x 1.5		T2829553	T2829553U	YH3	88	46	30	10.5	8	11	3				
M14 x 1.25		T2829563	-	YH3	88	46	30	10.5	8	11	3				
M14 x 1.0		T2829573	-	YH3	88	46	30	10.5	8	11	3				
M15 x 1.5		T2829583	-	YH3	90	47	30	10.5	8	11	3				
M15 x 1.0		T2829593	-	YH3	90	47	30	10.5	8	11	3				
M16 x 2.0		T2829604	T2829604U	YH4	95	50	32	12.5	10	13	3				
M16 x 1.5		T2829613	T2829613U	YH3	95	50	32	12.5	10	13	3				
M16 x 1.0		T2829623	-	YH3	95	50	32	12.5	10	13	3				

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制
* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸
* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖
◎ : Excellent (优秀) ○ : Good (良好)

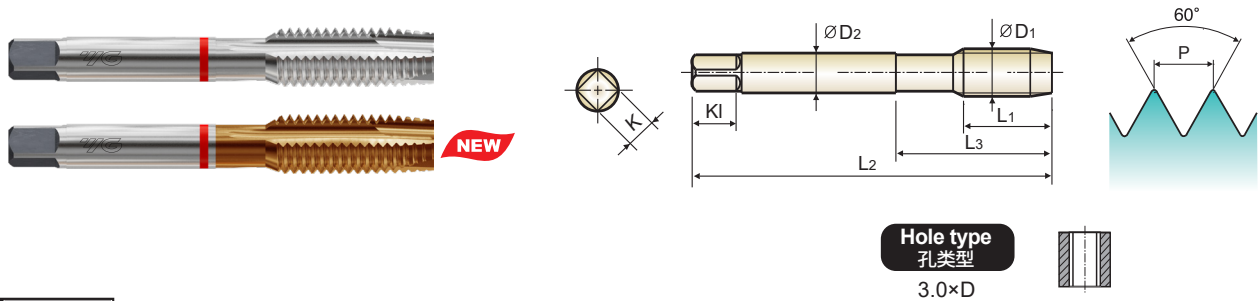
ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	
ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC											15	30	25	38	34	36	37	55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

I-GP SPIRAL POINT TAPS for Multi-Purpose
I-GP 多用途先端丝锥

Bright T2829
FSH T2829-U

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Material groups MU HSS-E I YH 60° 5.0P Bright FSH p.7

Machine Taps

Tap Limits: p.31												Unit(单位) : mm			
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute				
尺寸	牙距	型号	NEW AOSTAP	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数				
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI					
M18 x 2.5		T2829654	T2829654U	YH4	100	55	37	14	11	14	3				
M18 x 2.0		T2829664	-	YH4	100	55	37	14	11	14	3				
M18 x 1.5		T2829674	T2829674U	YH4	100	55	37	14	11	14	3				
M18 x 1.0		T2829683	-	YH3	100	55	37	14	11	14	3				
M20 x 2.5		T2829704	T2829704U	YH4	105	56	37	15	12	15	3				
M20 x 2.0		T2829714	-	YH4	105	56	37	15	12	15	3				
M20 x 1.5		T2829724	T2829724U	YH4	105	56	37	15	12	15	3				
M20 x 1.0		T2829733	-	YH3	105	56	37	15	12	15	3				
M22 x 2.5		T2829744	-	YH4	115	65	38	17	13	16	3				
M22 x 2.0		T2829754	-	YH4	115	65	38	17	13	16	3				
M22 x 1.5		T2829764	-	YH4	115	65	38	17	13	16	3				
M22 x 1.0		T2829773	-	YH3	115	65	38	17	13	16	3				
M24 x 3.0		T2829784	T2829784U	YH4	120	72	45	19	15	18	3				
M24 x 2.0		T2829794	-	YH4	120	72	45	19	15	18	3				
M24 x 1.5		T2829804	T2829804U	YH4	120	72	45	19	15	18	3				
M24 x 1.0		T2829813	-	YH3	120	72	45	19	15	18	3				
M25 x 2.0		T2829824	-	YH4	125	75	45	19	15	18	3				
M25 x 1.5		T2829834	-	YH4	125	75	45	19	15	18	3				
M26 x 2.0		T2829N44	-	YH4	125	75	45	20	15	18	4				
M26 x 1.5		T2829854	-	YH4	125	75	45	20	15	18	4				
M27 x 3.0		T2829864	-	YH4	130	77	45	20	15	18	4				
M27 x 2.0		T2829874	-	YH4	130	77	45	20	15	18	4				
M27 x 1.5		T2829884	-	YH4	130	77	45	20	15	18	4				
M28 x 2.0		T2829904	-	YH4	130	77	45	21	17	20	4				
M28 x 1.5		T2829914	-	YH4	130	77	45	21	17	20	4				
M30 x 3.5		T2829945	-	YH5	135	80	48	23	17	20	4				

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制
* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸
* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖
◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M				K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230		
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎				
ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

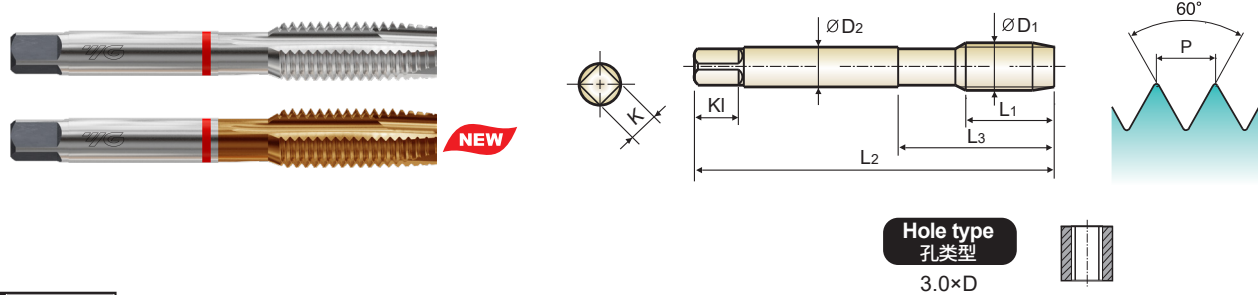
M I-GP SPIRAL POINT TAPS for Multi-Purpose
I-GP 多用途先端丝锥

SERIES

Bright T2829
FSH T2829-U

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



MU HSS-E I YH 60° 5.0P Bright FSH p.7 Machine Taps

Tap Limits: p.31				Unit(单位) : mm							
Size	Pitch	EDP No.		Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute
尺寸	牙距	型号	NEW AOSTAP	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数
ØD1	P	Bright	FSH		L2	L3	L1	ØD2	K	KI	
M30 x 3.0		T2829954	-	YH4	135	80	48	23	17	20	4
M30 x 2.0		T2829964	-	YH4	135	80	48	23	17	20	4
M30 x 1.5		T2829974	-	YH4	135	80	48	23	17	20	4
M30 x 1.0		T2829982	-	YH2	135	80	48	23	17	20	4
M33 x 3.5		T2829A45	-	YH5	145	85	51	25	19	22	4
M33 x 2.0		T2829A63	-	YH3	145	85	45	25	19	22	4
M33 x 1.5		T2829A74	-	YH4	145	85	45	25	19	22	4
M36 x 4.0		T2829B35	-	YH5	155	90	57	28	21	24	4
M36 x 3.0		T2829B44	-	YH4	155	90	57	28	21	24	4
M36 x 2.0		T2829B53	-	YH3	155	90	45	28	21	24	4
M36 x 1.5		T2829B64	-	YH4	155	90	45	28	21	24	4

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制
* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸
* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
HB																				
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
ISO	N										S				H					
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)				Non Metallic Materials		Heat Resistant Super Alloys			
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	200	280	250	350	320
HB																				
Recommended			◎			◎	◎	◎												

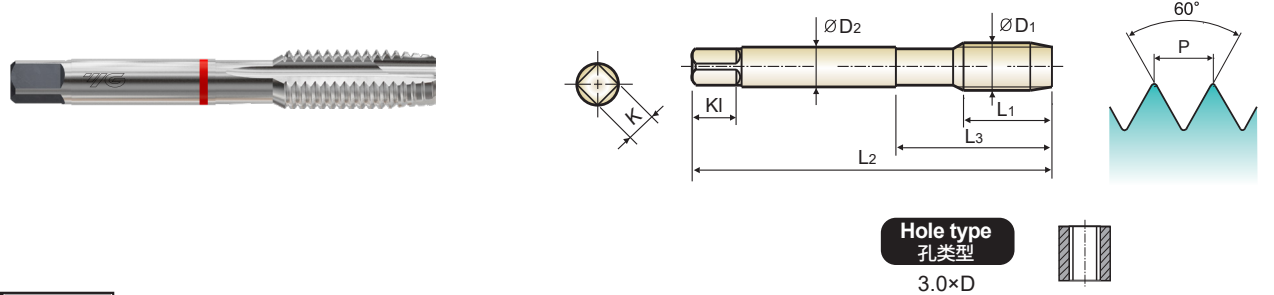
UNC/F I-GP SPIRAL POINT TAPS for Multi-Purpose
I-GP 多用途先端丝锥

SERIES

Bright T2849

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



MU HSS-E I YH 60° 5.0P Bright p.7 Machine Taps

Tap Limits: p.31								Unit(单位) : mm			
Size	TPI	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1		Bright		L2	L3	L1	ØD2	K	KI		
#2	-	56UNC	T2849081	YH1	42	-	9.5	3	2.5	5	2
#2	-	64UNF	T2849101	YH1	42	-	9.5	3	2.5	5	2
#3	-	48UNC	T2849121	YH1	44	16	9.5	3	2.5	5	2
#3	-	56UNF	T2849141	YH1	44	16	9.5	3	2.5	5	2
#4	-	40UNC	T2849162	YH2	44	16	9.5	3	2.5	5	2
#4	-	48UNF	T2849182	YH2	44	16	9.5	3	2.5	5	2
#5	-	40UNC	T2849202-C	YH2	46	18	11	4	3.2	6	3
#5	-	44UNF	T2849222-C	YH2	46	18	11	4	3.2	6	3
#6	-	32UNC	T2849242-C	YH2	48	20	13	4	3.2	6	3
#6	-	40UNF	T2849262-C	YH2	48	20	13	4	3.2	6	3
#8	-	32UNC	T2849282-C	YH2	52	21	13	5	4	7	3
#8	-	36UNF	T2849302-C	YH2	52	21	13	5	4	7	3
#10	-	24UNC	T2849322-C	YH2	60	25	16	5.5	4.5	7	3
#10	-	32UNF	T2849342-C	YH2	60	25	16	5.5	4.5	7	3
#12	-	24UNC	T2849362-C	YH2	60	25	16	5.5	4.5	7	3
#12	-	28UNF	T2849382-C	YH2	60	25	16	5.5	4.5	7	3
1/4	-	20UNC	T2849402-C	YH2	62	30	19	6	4.5	7	3
1/4	-	28UNF	T2849422-C	YH2	62	30	19	6	4.5	7	3
5/16	-	18UNC	T2849442-C	YH2	70	35	22	6.1	5	8	3
5/16	-	18UNC	T2849443-C	YH3	70	35	22	6.1	5	8	3
5/16	-	24UNF	T2849462-C	YH2	70	35	22	6.1	5	8	3
3/8	-	16UNC	T2849483-C	YH3	75	39	24	7	5.5	8	3
3/8	-	24UNF	T2849502-C	YH2	75	39	24	7	5.5	8	3
7/16	-	14UNC	T2849523-C	YH3	80	40	25	8	6	9	3
7/16	-	20UNF	T2849543-C	YH3	80	40	25	8	6	9	3
1/2	-	13UNC	T2849563-C	YH3	85	44	29	9	7	10	3

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制
* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸
* #0~5/16: Male Center / 3/8~: Female Center #0~5/16: 公顶尖 ; 3/8及以上: 母顶尖

ISO	P										M				K					
	Non-alloy steel					Low alloy steel					Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
VDI 3323	1	13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25	21	
HRc	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
HB																				
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
ISO	N										S				H					
	Aluminum-wrought alloy					Aluminum-cast, alloyed					Copper and Copper Alloys (Bronze / Brass)				Non Metallic Materials		Heat Resistant Super Alloys			
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
HRc	60	100	75	90	130	110	90	100			15	30	25	38	34	200	280	250	350	320
HB																				
Recommended			◎			◎	◎	◎												

UNC/F I-GP SPIRAL POINT TAPS for Multi-Purpose

I-GP 多用途先端丝锥

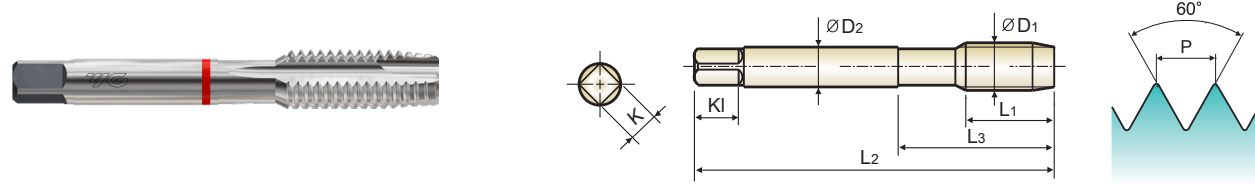
SERIES

Bright

T2849

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Hole type

孔类型
3.0xD



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	TPI	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1		Bright		L2	L3	L1	ØD2	K	KI		
1/2 -	20UNF	T2849582-C	YH2	85	44	29	9	7	10	3	
9/16 -	12UNC	T2849603	YH3	90	47	30	10.5	8	11	3	
9/16 -	18UNF	T2849622	YH2	90	47	30	10.5	8	11	3	
5/8 -	11UNC	T2849643	YH3	95	50	32	12	9	12	3	
5/8 -	18UNF	T2849663	YH3	95	50	32	12	9	12	3	
3/4 -	10UNC	T2849703	YH3	105	56	37	14	11	14	3	
3/4 -	16UNF	T2849723	YH3	105	56	37	14	11	14	3	
7/8 -	9UNC	T2849744	YH4	115	65	38	17	13	16	3	
7/8 -	14UNF	T2849763	YH3	115	65	38	17	13	16	3	
1" -	8UNC	T2849784	YH4	125	75	45	20	15	18	3	
1" -	12UNF	T2849803	YH3	125	75	45	20	15	18	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* #0~5/16: Male Center / 3/8~: Female Center #0~5/16: 公顶尖 ; 3/8及以上: 母顶尖

M I-GP SPIRAL POINT TAPS for Multi-Purpose

I-GP 多用途先端丝锥

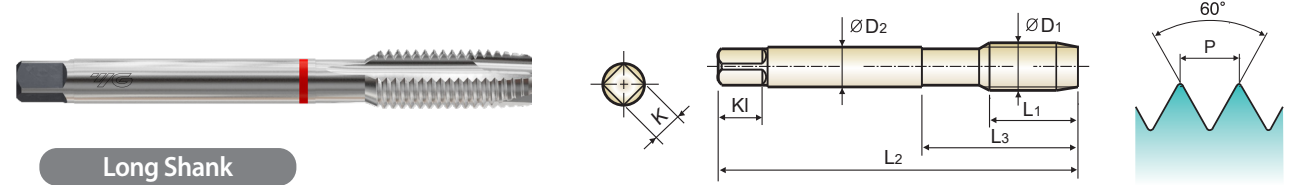
SERIES

Bright

T2818

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Long Shank

Hole type

孔类型
3.0xD



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M2 x	0.4	T2818131	YH1	100	15	9.5	3	2.5	5	2	
M2.5 x	0.45	T2818172	YH2	100	16	9.5	3	2.5	5	2	
M3 x	0.5	T2818202-C	YH2	100	18	11	4	3.2	6	3	
M4 x	0.7	T2818242-C	YH2	100	20	13	5	4	7	3	
M5 x	0.8	T2818282-C	YH2	100	25	16	5.5	4.5	7	3	
M6 x	1.0	T2818312-C	YH2	100	28	19	6	4.5	7	3	
M8 x	1.25	T2818363-C	YH3	100	35	22	6.2	5	8	3	
M8 x	1.0	T2818373-C	YH3	100	35	22	6.2	5	8	3	
M8 x	0.75	T2818383-C	YH3	100	35	22	6.2	5	8	3	
M10 x	1.5	T2818423-C	YH3	100	39	24	7	5.5	8	3	
M10 x	1.25	T2818433-C	YH3	100	39	24	7	5.5	8	3	
M10 x	1.0	T2818443-C	YH3	100	39	24	7	5.5	8	3	
M12 x	1.75	T2818504-C	YH3	100	42	29	8.5	6.5	9	3	
M12 x	1.5	T2818513-C	YH3	100	42	29	8.5	6.5	9	3	
M12 x	1.25	T2818523-C	YH3	100	42	29	8.5	6.5	9	3	
M12 x	1.0	T2818533-C	YH3	100	42	29	8.5	6.5	9	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P										M				K						
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎		◎	◎	◎		◎	◎	○	◎		◎	◎	◎	◎	◎	◎		◎	

ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P											M				K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎			

ISO	N										S						H				
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast iron	Hardened Cast iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRC											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
Recommended			◎			◎	◎	◎													

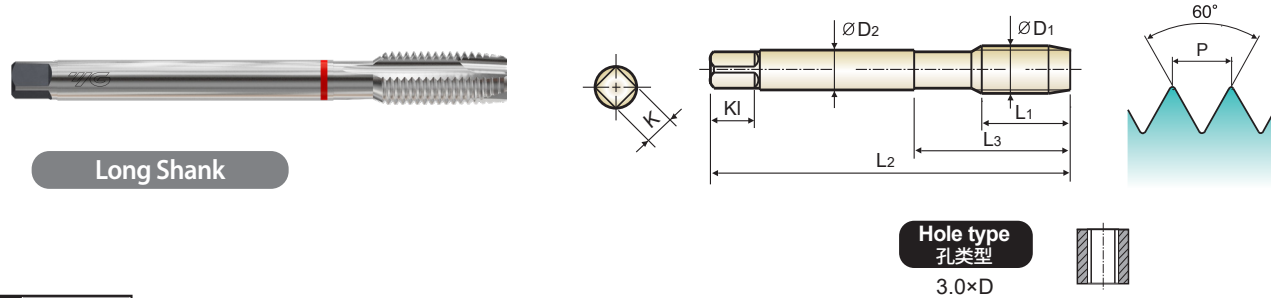
M I-GP SPIRAL POINT TAPS for Multi-Purpose I-GP 多用途先端丝锥

SERIES

Bright **T2828**

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M3 x 0.5		T2828202-C	YH2	120	18	11	4	3.2	6	3	
M4 x 0.7		T2828242-C	YH2	120	20	13	5	4	7	3	
M5 x 0.8		T2828282-C	YH2	120	25	16	5.5	4.5	7	3	
M6 x 1.0		T2828312-C	YH2	120	28	19	6	4.5	7	3	
M8 x 1.25		T2828363-C	YH3	120	35	22	6.2	5	8	3	
M8 x 1.0		T2828373-C	YH3	120	35	22	6.2	5	8	3	
M10 x 1.5		T2828423-C	YH3	120	39	24	7	5.5	8	3	
M10 x 1.25		T2828433-C	YH3	120	39	24	7	5.5	8	3	
M10 x 1.0		T2828443-C	YH3	120	39	24	7	5.5	8	3	
M12 x 1.75		T2828504-C	YH3	120	42	29	8.5	6.5	9	3	
M12 x 1.5		T2828513-C	YH3	120	42	29	8.5	6.5	9	3	
M12 x 1.25		T2828523-C	YH3	120	42	29	8.5	6.5	9	3	
M12 x 1.0		T2828533-C	YH3	120	42	29	8.5	6.5	9	3	
M14 x 2.0		T2828544	YH4	120	46	30	10.5	8	11	3	
M14 x 1.5		T2828553	YH3	120	46	30	10.5	8	11	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖

																				◎ : Excellent (优秀) ○ : Good (良好)									
ISO	P										M				K														
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron									
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20									
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25											
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230									
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎									
ISO	N									S								H											
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron									
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41								
HRc											15	30	25	38	34	36	37	55	60	42	55								
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550								
Recommended			◎			◎	◎	◎																					

◎ : Excellent (优秀) ○ : Good (良好)

ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast iron		Hardened Cast iron	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

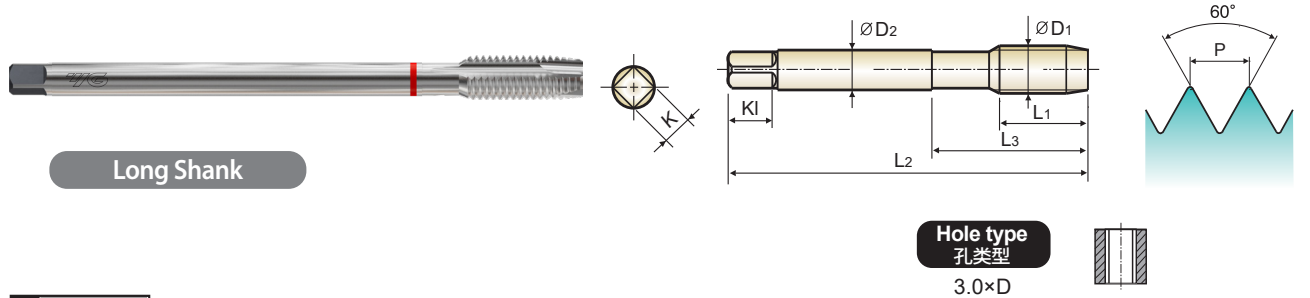
M I-GP SPIRAL POINT TAPS for Multi-Purpose I-GP 多用途先端丝锥

SERIES

Bright **T2838**

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Machine Taps

Tap Limits: p.31										Unit(单位) : mm	
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute	
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块 尺寸	方块 长度	槽数	
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI		
M3 x 0.5		T2838202-C	YH2	150	18	11	4	3.2	6	3	
M4 x 0.7		T2838242-C	YH2	150	20	13	5	4	7	3	
M5 x 0.8		T2838282-C	YH2	150	25	16	5.5	4.5	7	3	
M6 x 1.0		T2838312-C	YH2	150	28	19	6	4.5	7	3	
M8 x 1.25		T2838363-C	YH3	150	35	22	6.2	5	8	3	
M8 x 1.0		T2838373-C	YH3	150	35	22	6.2	5	8	3	
M8 x 0.75		T2838383-C	YH3	150	35	22	6.2	5	8	3	
M10 x 1.5		T2838423-C	YH3	150	39	24	7	5.5	8	3	
M10 x 1.25		T2838433-C	YH3	150	39	24	7	5.5	8	3	
M10 x 1.0		T2838443-C	YH3	150	39	24	7	5.5	8	3	
M12 x 1.75		T2838504-C	YH4	150	42	29	8.5	6.5	9	3	
M12 x 1.5		T2838513-C	YH3	150	42	29	8.5	6.5	9	3	
M12 x 1.25		T2838523-C	YH3	150	42	29	8.5	6.5	9	3	
M12 x 1.0		T2838533-C	YH3	150	42	29	8.5	6.5	9	3	
M14 x 2.0		T2838544	YH4	150	46	30	10.5	8	11	3	
M14 x 1.5		T2838553	YH3	150	46	30	10.5	8	11	3	
M15 x 1.0		T2838593	YH3	150	47	30	10.5	8	11	3	
M16 x 2.0		T2838604	YH4	150	50	32	12.5	10	13	3	
M16 x 1.5		T2838613	YH3	150	50	32	12.5	10	13	3	
M18 x 2.5		T2838654	YH4	150	55	37	14	11	14	3	
M18 x 1.5		T2838674	YH4	150	55	37	14	11	14	3	
M20 x 2.5		T2838704	YH4	150	56	37	15	12	15	3	
M20 x 1.5		T2838724	YH4	150	56	37	15	12	15	3	
M22 x 2.5		T2838744	YH4	150	65	38	17	13	16	3	
M22 x 1.5		T2838764	YH4	150	65	38	17	13	16	3	
M24 x 3.0		T2838784	YH4	150	72	45	19	15	18	3	
M24 x 1.5		T2838804	YH4	150	72	45	19	15	18	3	

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)

ISO	P											M				K							
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron		Malleable cast iron			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20			
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230			
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○	◎	◎	◎	◎	◎	◎	◎	◎					
ISO	N										S										H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron			
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc											15	30	25	38	34			55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550		
Recommended			◎			◎	◎	◎															

◎ : Excellent (优秀) ○ : Good (良好)

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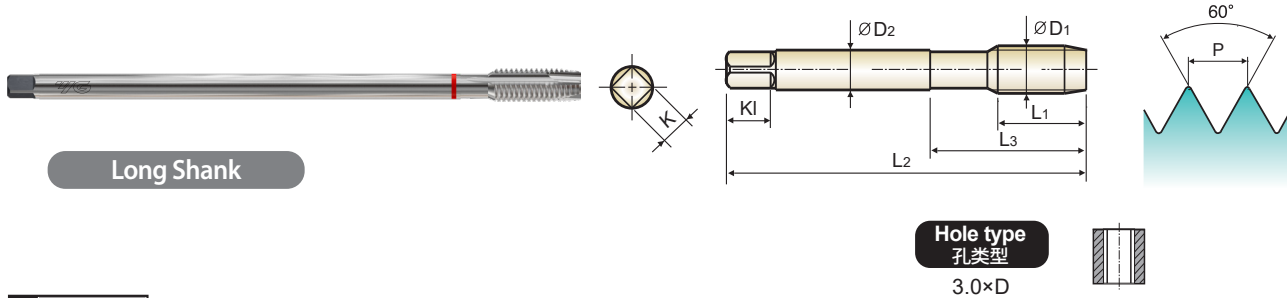
M I-GP SPIRAL POINT TAPS for Multi-Purpose

I-GP 多用途先端丝锥

Bright **T2848**

► For using multi-purpose and correct thread profiles & long tool life due to special tap geometry

► 独特的丝锥设计，满足多功能使用要求，可以修正螺纹形状，大幅延长丝锥使用寿命



Machine Taps

Tap Limits: p.31				Unit(单位): mm						
Size	Pitch	EDP No.	Limits	Overall Length	Neck Length	Thread Length	Shank Diameter	Square Size	Square Length	No. of Flute
尺寸	牙距	型号	精度	全长	颈长	螺纹长	柄径	方块尺寸	方块长度	槽数
ØD1	P	Bright		L2	L3	L1	ØD2	K	KI	
M6 x 1.0		T2848312-C	YH2	200	28	19	6	4.5	7	3
M8 x 1.25		T2848363-C	YH3	200	35	22	6.2	5	8	3
M10 x 1.5		T2848423-C	YH3	200	39	24	7	5.5	8	3
M10 x 1.25		T2848433-C	YH3	200	39	24	7	5.5	8	3
M12 x 1.75		T2848504-C	YH3	200	42	29	8.5	6.5	9	3
M14 x 2.0		T2848544	YH4	200	46	30	10.5	8	11	3
M14 x 1.5		T2848553	YH3	200	46	30	10.5	8	11	3
M16 x 2.0		T2848604	YH4	200	50	32	12.5	10	13	3
M18 x 2.5		T2848654	YH4	200	55	37	14	11	14	3
M20 x 2.5		T2848704	YH4	200	56	37	15	12	15	3
M22 x 2.5		T2848744	YH4	200	65	38	17	13	16	3
M24 x 3.0		T2848784	YH4	200	72	45	19	15	18	3
M27 x 3.0		T2848864	YH4	200	77	45	20	15	18	4
M30 x 3.5		T2848945	YH5	200	80	48	23	17	20	4

* TiN, TiCN, Steam Oxide is available on your request. TiN, TiCN, Steam Oxide 可根据要求定制

* Refer to p.32-34 for recommended tap drill sizes. 参考p.32-34 底孔尺寸

* M1~M7: Male Center / M8: Step Male Center / M9~: Female Center M1~M7: 公顶尖 ; M8: 阶梯公顶尖 ; M9及以上: 母顶尖

◎ : Excellent (优秀) ○ : Good (良好)																												
ISO	P											M				K												
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel				Grey cast iron		Nodular cast iron			Malleable cast iron							
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20								
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25										
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230								
Recommended	○	◎	◎	◎	◎	◎	◎	◎	◎	○		◎	◎	◎		◎	◎	◎	◎									
ISO	N										S										H							
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys						Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron					
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41							
HRC											15	30	25	38	34			55	60	42	55							
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550							
Recommended			◎			◎	◎	◎																				

◎ : Excellent (优秀) ○ : Good (良好)

ISO	N										S						H					
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast iron	Hardened Cast iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRC											15	30	25	38	34			55	60	42	55	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550	
Recommended			◎			◎	◎	◎														

YG-1 YH LIMIT SYSTEM YG-1 YH精度体系

YG-1 applies a unique system of tap pitch diameter limits. We call it the YH limits system.

Using the step method, you can select the best tap pitch diameter limits to match your work condition.

Most YG-1 taps use the YH limit system. The limits calculated as follows;

YG-1 采用一套独创的丝锥中径公差体系，我们将其命名为 YH 公差体系。通过分级选配方式，可根据加工工况匹配最优丝锥中径公差；品牌绝大多数丝锥均搭载此标准，公差计算方式见下文

1. Up to 0.6P (40TPI)

upper limits : $10\mu\text{m} + 15\mu\text{m} \times n$
lower limit : (upper limits) - $15\mu\text{m}$

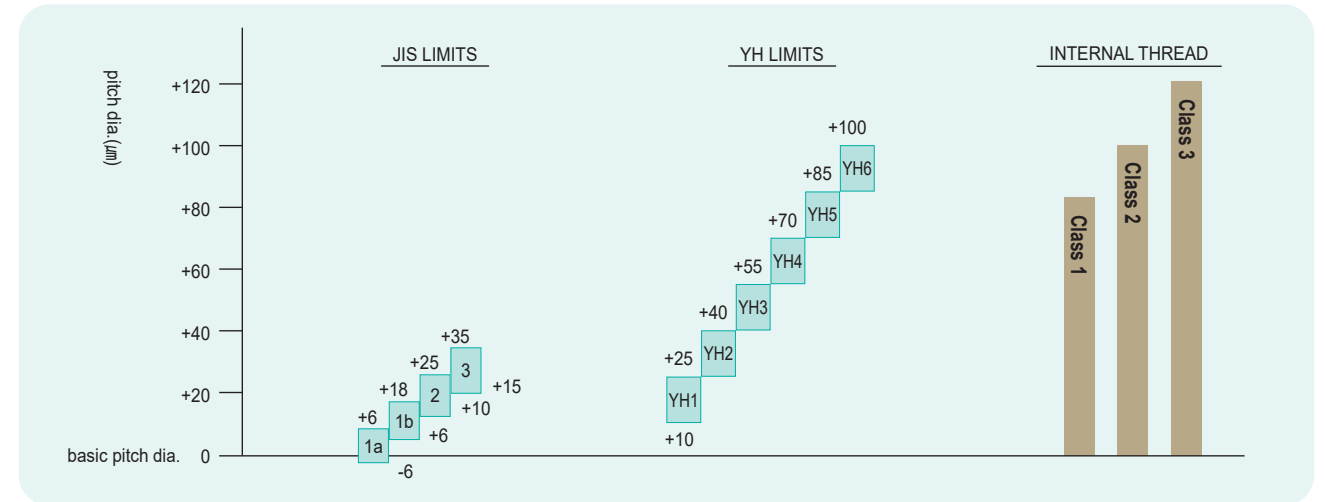
$n = \text{YH No.}$

2. Above 0.7P (36TPI)

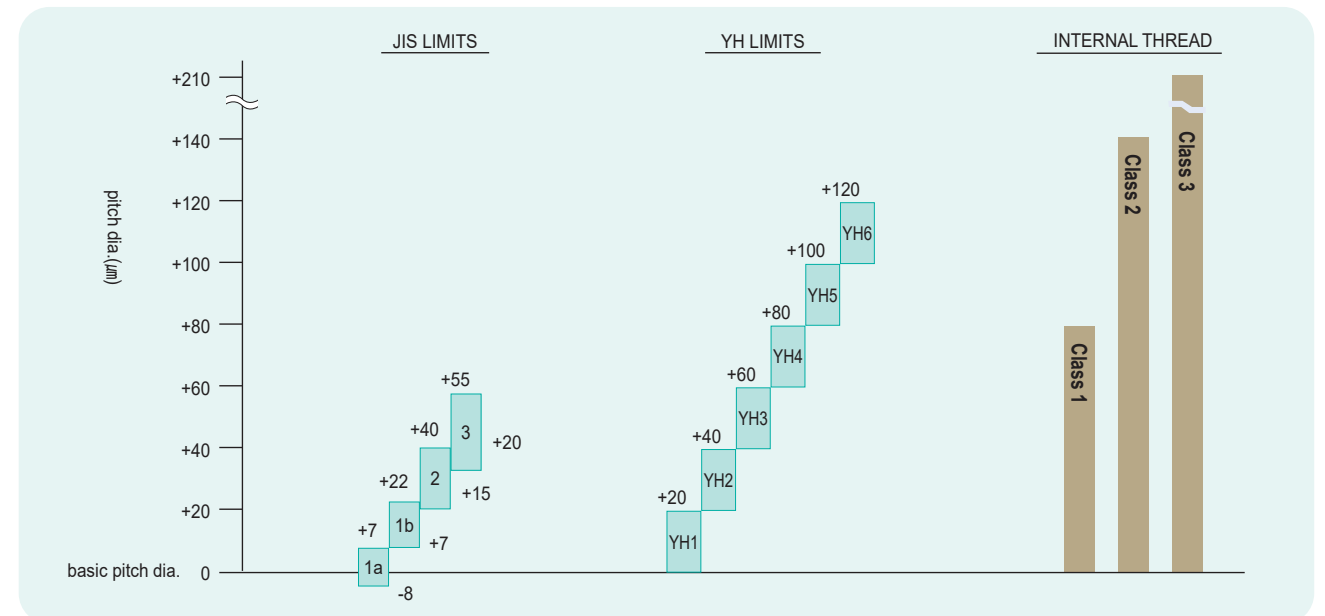
upper limits : $20\mu\text{m} \times n$
lower limit : (upper limits) - $20\mu\text{m}$

$n = \text{YH No.}$

Example M3×0.5 / 例如 M3x0.5



Example M10×1.5 / 例如 M10x1.5





TAP DRILL SIZES : METRIC THREAD
推荐攻丝底孔尺寸 : 公制螺纹

Thread Size	Drill Size (mm)	D1 (mm)	
		Min.	Max.
M2 × 0.4	1.60	1.567	1.679
M2 × 0.25	1.75	(1.729)	(1.785)
M2.2 × 0.45	1.75	1.713	1.838
M2.2 × 0.25	1.95	(1.929)	(1.985)
M2.2 × 0.4	1.90	1.867	1.979
M2.3 × 0.25	2.05	2.001	2.061
M2.5 × 0.45	2.10	5.013	2.138
M2.5 × 0.35	2.20	2.121	2.221
M2.6 × 0.45	2.20	2.113	2.238
M2.6 × 0.35	2.20	2.186	2.246
M3 × 0.5	2.50	2.459	2.599
M3 × 0.35	2.70	2.621	2.721
M3.5 × 0.6	2.90	2.850	3.010
M3.5 × 0.35	3.20	3.121	3.221
M4 × 0.7	3.30	3.242	3.422
M4 × 0.5	3.50	3.459	3.599
M4.5 × 0.75	3.80	3.688	3.878
M4.5 × 0.5	4.00	3.959	4.099
M5 × 0.8	4.20	4.134	4.334
M5 × 0.5	4.50	4.459	4.599
M6 × 1.0	5.00	4.917	5.153
M6 × 0.75	5.30	5.188	5.378
M6 × 0.5	5.50	5.400	5.550
M7 × 1.0	6.00	5.917	6.153
M7 × 0.75	6.30	6.188	6.378
M7 × 0.5	6.50	6.400	6.550
M8 × 1.25	6.80	6.647	6.912
M8 × 1.0	7.00	6.917	7.153
M8 × 0.75	7.30	7.188	7.378
M8 × 0.5	7.50	7.400	7.520
M9 × 1.25	7.80	7.647	7.912
M9 × 1.0	8.00	7.917	8.153
M9 × 0.75	8.30	8.188	8.378

D1: Minor diameter of JIS calss internal thread. But, the minor diameter D1 shown in () are of JIS Class 1 internal threads because their nominal sizes are not specified in JIS Class 2.
D1: JIS 级内螺纹小径, 但 () 内的小径 D1 为 JIS 1 级内螺纹的小径 (因其公称尺寸未在标准中特别规定)。



TAP DRILL SIZES : METRIC THREAD
推荐攻丝底孔尺寸 : 公制螺纹

Thread Size	Drill Size (mm)	D1 (mm)	
		Min.	Max.
M22 × 1.5	20.50	20.376	20.673
M22 × 1.0	21.00	20.917	21.153
M24 × 3.0	21.00	20.752	21.252
M24 × 2.0	22.00	21.835	22.210
M24 × 1.5	22.50	22.376	22.676
M24 × 1.0	23.00	22.917	23.153
M25 × 2.0	23.00	22.835	23.210
M25 × 1.5	23.50	23.376	23.676
M25 × 1.0	24.00	23.917	24.153
M26 × 1.5	24.50	24.376	24.676
M27 × 3.0	24.00	23.752	24.252
M27 × 2.0	25.00	24.835	25.210
M27 × 1.5	25.50	25.376	25.676
M27 × 1.0	26.00	25.917	26.153
M28 × 2.0	26.00	25.835	26.210
M28 × 1.5	26.50	26.376	26.676
M28 × 1.0	27.00	26.917	27.153
M30 × 3.5	26.50	26.211	26.771
M30 × 3.0	27.00	26.752	27.252
M30 × 2.0	28.00	27.835	28.210
M30 × 1.5	28.50	28.376	28.676
M30 × 1.0	29.00	28.917	29.153
M32 × 2.0	30.00	29.835	30.210
M32 × 1.5	30.50	30.376	30.676
M33 × 3.5	29.50	29.211	29.771
M33 × 3.0	30.00	29.752	30.252
M33 × 2.0	31.00	30.835	31.210
M33 × 1.5	31.50	31.376	31.676
M35 × 1.5	33.50	33.376	33.676
M36 × 4.0	32.00	31.670	32.270
M36 × 3.0	33.00	32.752	33.252
M36 × 2.0	34.00	33.835	34.210
M36 × 1.5	34.50	34.376	34.676

D1: Minor diameter of JIS calss internal thread. But, the minor diameter D1 shown in () are of JIS Class 1 internal threads because their nominal sizes are not specified in JIS Class 2.
D1: JIS 级内螺纹小径, 但 () 内的小径 D1 为 JIS 1 级内螺纹的小径 (因其公称尺寸未在标准中特别规定)。



TAP DRILL SIZES : UNIFIED THREAD
推荐攻丝底孔尺寸 : 英制螺纹

Thread Size	Drill Size (mm)	D1 (mm)	
		Min.	Max.
#2 - 56UNC	1.80	1.695	1.871
#2 - 64UNF	1.85	1.756	1.912
#3 - 48UNC	2.10	1.941	2.146
#3 - 56UNF	2.10	2.025	2.197
#4 - 40UNC	2.30	2.157	2.385
#4 - 48UNF	2.40	2.271	2.458
#5 - 40UNC	2.60	2.487	2.697
#5 - 44UNF	2.70	2.551	2.740
#6 - 32UNC	2.80	2.642	2.895
#6 - 40UNF	2.90	2.820	3.022
#8 - 32UNC	3.40	3.302	3.530
#8 - 36UNF	3.50	3.404	3.606
#10 - 24UNC	3.90	3.683	3.962
#10 - 32UNF	4.10	3.963	4.165
#12 - 24UNC	4.50	4.344	4.597
#12 - 28UNF	4.60	4.496	4.724
#12 - 32UNF	4.70	4.623	4.826
1/4 - 20UNC	5.10	4.979	5.257
1/4 - 28UNF	5.50	5.360	5.588
1/4 - 32UNEF	5.60	5.486	5.690
5/16 - 18UNC	6.60	6.401	6.731
5/16 - 24UNF	6.90	6.782	7.035
5/16 - 32UNEF	7.10	7.087	7.264
3/8 - 16UNC	8.00	7.798	8.153
3/8 - 24UNF	8.50	8.382	8.636
3/8 - 32UNEF	8.70	8.661	8.865
7/16 - 14UNC	9.40	9.144	9.550
7/16 - 20UNF	9.90	9.729	10.033
7/16 - 28UNEF	10.20	10.135	10.338
1/2 - 13UNC	10.80	10.592	11.023
1/2 - 20UNF	11.50	11.329	11.607
1/2 - 28UNEF	11.80	11.709	11.938
9/16 - 12UNC	12.20	11.989	12.446
9/16 - 18UNF	12.90	12.751	13.081
9/16 - 24UNEF	13.20	13.132	13.386
5/8 - 11UNC	13.60	13.386	13.868

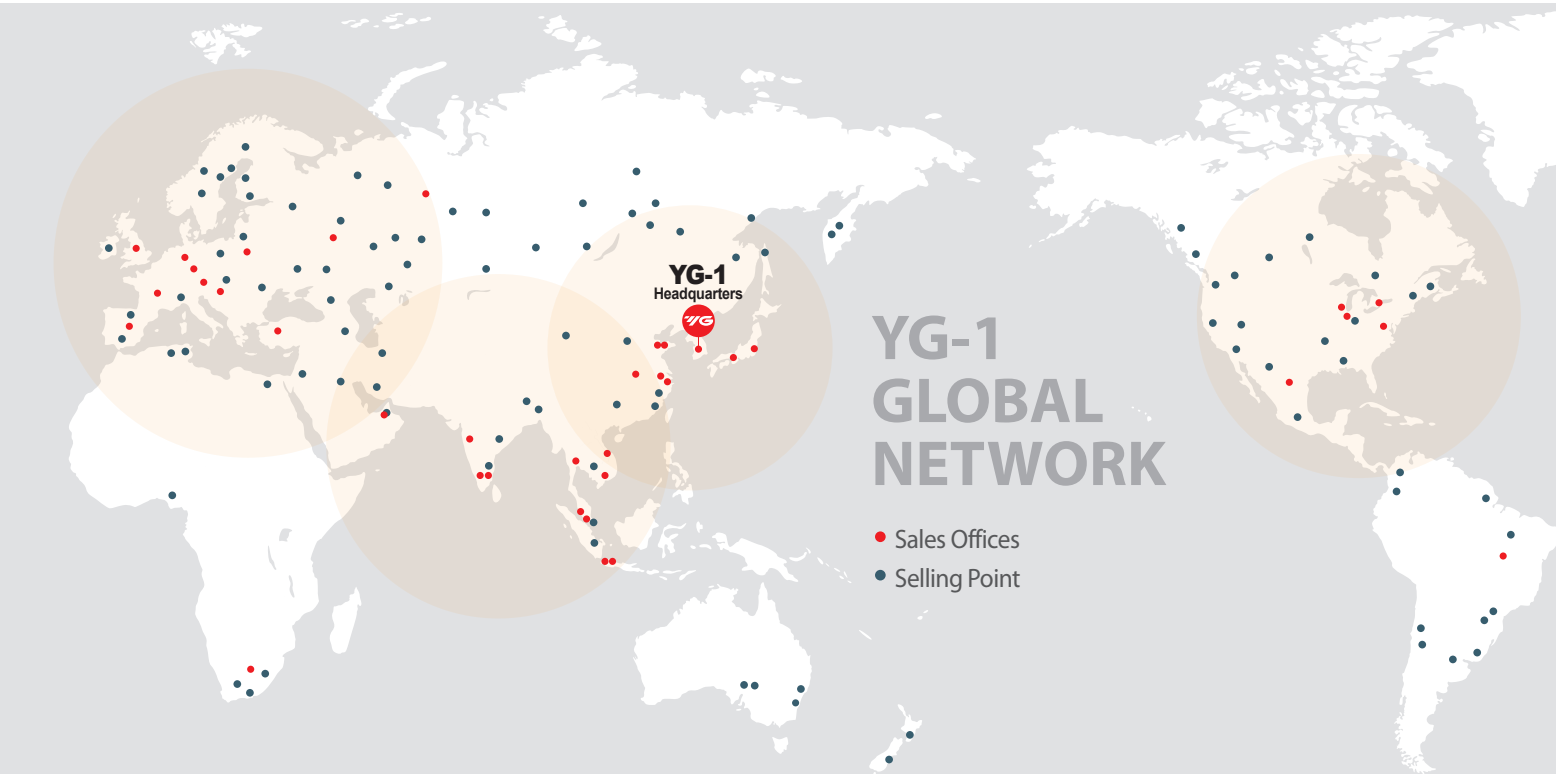
Thread Size	Drill Size (mm)	D1 (mm)	
		Min.	Max.
5/8 - 18UNF	14.50	14.351	14.681
5/8 - 24UNEF	14.80	14.732	14.986
3/4 - 10UNC	16.50	16.307	16.840
3/4 - 16UNF	17.50	17.323	17.678
3/4 - 20UNEF	17.80	17.678	17.958
7/8 - 9UNC	19.50	19.177	19.761
7/8 - 14UNF	20.50	20.270	20.675
7/8 - 20UNEF	21.00	20.853	21.133
1" - 8UNC	22.20	21.971	22.606
1" - 12UNF	23.20	23.114	23.571
1" - 20UNEF	24.00	24.028	24.308
1-1/8 - 7UNC	25.00	24.638	25.349
1-1/8 - 12UNF	26.50	26.289	26.746
1-1/8 - 18UNEF	27.20	27.051	27.381
1-1/8 - 8UN	25.50	25.146	25.781
1-1/4 - 7UNC	28.20	27.813	28.524
1-1/4 - 12UNF	29.50	29.464	29.921
1-1/4 - 18UNEF	30.20	30.226	30.556
1-1/4 - 8UN	28.50	28.321	28.956
1-3/8 - 6UNC	30.80	30.353	31.115
1-3/8 - 12UNF	32.80	32.639	33.096
1-3/8 - 18UNEF	33.50	33.401	33.731
1-3/8 - 8UN	31.80	31.496	32.131
1-1/2 - 6UNC	34.00	33.528	34.290
1-1/2 - 12UNF	36.00	35.814	36.271
1-1/2 - 18UNEF	36.50	36.576	36.881
1-1/2 - 8UN	35.00	34.671	35.306
1-5/8 - 18UNEF	39.80	39.751	40.081
1-5/8 - 8UN	38.20	37.846	38.481
1-5/8 - 12UN	39.20	38.989	39.446
1-3/4 - 5UNC	39.50	38.964	39.827
1-3/4 - 8UN	41.20	41.021	41.656
1-3/4 - 12UN	42.20	42.164	42.621
2" - 4-1/2UNC	45.20	44.679	45.593
2" - 8UN	47.80	47.371	48.006
2" - 12UN	48.50	48.514	48.971

D1: Minor diameter of internal thread.
For UNC and UNF threads, according to JIS Class 2B ;
For UNEF and UN threads, according to ANSI B1.1 Class 2B

D1: 内螺纹小径。
UNC 及 UNF 螺纹, 依据 JIS 2B 级标准
UNEF 及 UN 螺纹, 依据 ANSI B1.1 2B 级标准

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