

ROUND TOOLS ONE-STOP

GENERAL SERVICE PROVIDER

S-TAP

高效多用途涂层丝锥



苏州用朴精密科技有限公司

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版本号：YP-Tap-202501



一站式服务



非标定制



百余年技术加持

www.yp-tec.com

圆柄类刀具
一站式综合服务商

CATALOG

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圆柄类刀具 一站式综合服务商



一站式服务



非标定制



百余年技术加持

苏州用朴精密科技有限公司成立于2013年，是一家专注圆柄类精密刀具的研发生产和销售的高新技术企业，提供圆柄类棒材、精密刀具、涂层的全产业链一站式服务。现有苏州吴江和安徽滁州两处制造基地，拥有专业的技术团队，先进的生产设备和完善的质量管理体系，依托山特维克的技术支持以及完整的产业链打造客户值得信赖的圆柄类刀具一站式综合服务商。

Suzhou Yongpu Precision Technology Co., Ltd. was established in 2013 and is a high-tech enterprise specializing in the research, development, production, and sales of high precision solid carbide round tools. It provides one-stop services for the entire industry chain of round tool blanks, high precision cutting tools, and coatings. There are two production units in Wujiang, Suzhou and Chuzhou, Anhui, with professional technical teams, advanced production equipment, and a comprehensive quality control system. With Sandvik's technical support and a complete industrial chain, we aim to create a trustworthy one-stop general service provider for solid carbide round tools for our customers.



Round Tools
One-stop General
Service Provider

涂层螺旋丝锥

ST300

M
DIN 13

M
JIS

6H

6HX



≤
2.5xD1

C=2-3



∠40°



∠45°



32HRC
1200
~700
N/mm²

P

M

K

全新切削刃几何形状
可适用于广泛的材料种类

切削刃口精研
确保最佳的切屑形成

优化的齿背几何形状
确保针对不同的材料工艺可靠地使用
以最佳方式剪断切削并使切削根部平滑

AICrN 纳米润滑涂层带来极佳的耐磨性
同时更小的摩擦降低了切削温度

最佳排屑
得益于特殊的排屑槽几何形状



- 适合对多种类型材料加工的客户。
 - 采用高性能HSS-E材料，具有耐久稳定的使用寿命。
 - 采用优化的槽型设计，可适用于多种材料的加工-包括碳钢及合金钢、不锈钢、球磨铸铁。
- 优化的螺旋槽设计，可使盲孔加工中的切屑有效排出。
 - 适用于同步和非同步攻丝机的螺纹加工。
 - 采用适合的PVD涂层处理，具有可靠的性能。

高效多用途涂层丝锥

ST300



DIN系列-高效螺旋丝锥

DIN series high productivity spiral flute tap

M
DIN 13

6H

6HX



≤
2.5xD1

C=2-3



∠40°



32HRC
1200
~700
N/mm²

P

M

K

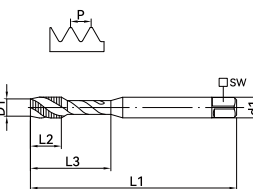
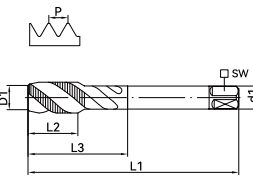
N

S

H

O

AICrN

DIN371	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S335D213-M3x0.5	M3	0.5	3.5	2.7	56	10.0	18	3	6H
	S335D213-M4x0.7	M4	0.7	4.5	3.4	63	8.4	21	3	6H
	S335D213-M5x0.8	M5	0.8	6.0	4.9	70	9.6	25	3	6H
	S335D213-M6x1.0	M6	1.0	6.0	4.9	80	12.0	30	3	6H
	S335D213-M8x1.0	M8	1.0	8.0	6.2	90	15.0	35	3	6HX
	S335D213-M8x1.25	M8	1.25	8.0	6.2	90	15.0	35	3	6H
	S335D213-M10x1.0	M10	1.0	10.0	8.0	100	18.0	39	3	6HX
	S335D213-M10x1.25	M10	1.25	10.0	8.0	100	18.0	39	3	6HX
	S335D213-M10x1.5	M10	1.5	10.0	8.0	100	18.0	39	3	6H
	S335D213-M12x1.25	M12	1.25	9.0	7.0	110	18.0	--	3	6H
	S335D213-M12x1.5	M12	1.5	9.0	7.0	110	18.0	--	3	6H
	S335D213-M12x1.75	M12	1.75	9.0	7.0	110	18.0	--	3	6H
	S335D213-M14x1.5	M14	1.5	11.0	9.0	110	20.0	--	3	6HX
	S335D213-M14x2.0	M14	2.0	11.0	9.0	110	20.0	--	3	6HX
	S335D213-M16x1.5	M16	1.5	12.0	9.0	110	20.0	--	3	6HX
	S335D213-M16x2.0	M16	2.0	12.0	9.0	110	20.0	--	3	6HX
	S335D213-M18x1.5	M18	1.5	14.0	11.0	125	25.0	--	4	6HX
	S335D213-M18x2.5	M18	2.5	14.0	11.0	125	25.0	--	4	6HX
	S335D213-M20x1.5	M20	1.5	16.0	12.0	140	25.0	--	4	6HX
	S335D213-M20x2.5	M20	2.5	16.0	12.0	140	25.0	--	4	6HX
	S335D213-M24x3.0	M24	3.0	18.0	14.5	160	30.0	--	4	6HX

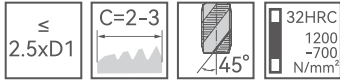


高效多用途涂层丝锥
ST300



JIS系列-高效螺旋丝锥

JIS series high productivity spiral flute tap



	P	M	K	N	S	H	O
ZrN	●●	●●	●●				
CrN+X	●●	●●	●				
AlCrN	●●	●	●●				

JIS	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	工具NO. EDP NO.AlCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S359J215-M3x0.5	S355J215-M3x0.5	S357J215-M3x0.5	M3	0.5	4.0	3.2	46	10.0	19	3	6H
	S359J215-M4x0.7	S355J215-M4x0.7	S357J215-M4x0.7	M4	0.7	5.0	4.0	52	8.4	20	3	6H
	S359J215-M5x0.8	S355J215-M5x0.8	S357J215-M5x0.8	M5	0.8	5.5	4.5	60	9.6	24	3	6H
	S359J215-M6x1.0	S355J215-M6x1.0	S357J215-M6x1.0	M6	1.0	6.0	4.5	62	12.0	29	3	6H
	S359J215-M8x1.0	S355J215-M8x1.0	S357J215-M8x1.0	M8	1.0	6.2	5.0	70	15.0	37	3	6HX
	S359J215-M8x1.25	S355J215-M8x1.25	S357J215-M8x1.25	M8	1.25	6.2	5.0	70	15.0	37	3	6H
	S359J215-M10x1.0	S355J215-M10x1.0	S357J215-M10x1.0	M10	1.0	7.0	5.5	75	18.0	41	3	6HX
	S359J215-M10x1.25	S355J215-M10x1.25	S357J215-M10x1.25	M10	1.25	7.0	5.5	75	18.0	41	3	6HX
	S359J215-M10x1.5	S355J215-M10x1.5	S357J215-M10x1.5	M10	1.5	7.0	5.5	75	18.0	41	3	6H
	S359J215-M12x1.25	S355J215-M12x1.25	S357J215-M12x1.25	M12	1.25	8.5	6.5	82	18.0	48	3	6HX
	S359J215-M12x1.5	S355J215-M12x1.5	S357J215-M12x1.5	M12	1.5	8.5	6.5	82	18.0	48	3	6HX
	S359J215-M12x1.75	S355J215-M12x1.75	S357J215-M12x1.75	M12	1.75	8.5	6.5	82	18.0	48	3	6H
	S359J215-M14x1.5		S357J215-M14x1.5	M14	1.5	10.5	8.0	88	20.0	48	3	6HX
	S359J215-M14x2.0		S357J215-M14x2.0	M14	2.0	10.5	8.0	88	20.0	48	3	6HX
	S359J215-M16x1.5		S357J215-M16x1.5	M16	1.5	12.5	10.0	95	20.0	52	4	6HX
	S359J215-M16x2.0		S357J215-M16x2.0	M16	2.0	12.5	10.0	95	20.0	52	4	6HX
	S359J215-M18x1.5		S357J215-M18x1.5	M18	1.5	14.0	11.0	100	25.0	55	4	6HX
	S359J215-M18x2.5		S357J215-M18x2.5	M18	2.5	14.0	11.0	100	25.0	55	4	6HX
	S359J215-M20x1.5		S357J215-M20x1.5	M20	1.5	15.0	12.0	105	25.0	58	4	6HX
	S359J215-M20x2.5		S357J215-M20x2.5	M20	2.5	15.0	12.0	105	25.0	58	4	6HX
	S359J215-M24x3.0		S357J215-M24x3.0	M24	3.0	19.0	15.0	120	30.0	66	4	6HX

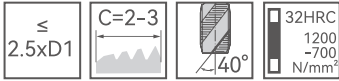


高效多用途涂层丝锥
ST300



JIS系列-通用螺旋丝锥

JIS series general spiral flute tap



	P	M	K	N	S	H	O
ZrN	●●	●●	●●				
CrN+X	●●	●●	●				
AlCrN	●●	●	●●				

JIS	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	工具NO. EDP NO.AlCrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S339J213-M3x0.5	S335J213-M3x0.5	S337J213-M3x0.5	M3	0.5	4.0	3.2	46	10.0	19	3	6H
	S339J213-M4x0.7	S335J213-M4x0.7	S337J213-M4x0.7	M4	0.7	5.0	4.0	52	8.4	20	3	6H
	S339J213-M5x0.8	S335J213-M5x0.8	S337J213-M5x0.8	M5	0.8	5.5	4.5	60	9.6	24	3	6H
	S339J213-M6x1.0	S335J213-M6x1.0	S337J213-M6x1.0	M6	1.0	6.0	4.5	62	12.0	29	3	6H
	S339J213-M8x1.0	S335J213-M8x1.0	S337J213-M8x1.0	M8	1.0	6.2	5.0	70	15.0	37	3	6HX
	S339J213-M8x1.25	S335J213-M8x1.25	S337J213-M8x1.25	M8	1.25	6.2	5.0	70	15.0	37	3	6H
	S339J213-M10x1.0	S335J213-M10x1.0	S337J213-M10x1.0	M10	1.0	7.0	5.5	75	18.0	41	3	6HX
	S339J213-M10x1.25	S335J213-M10x1.25	S337J213-M10x1.25	M10	1.25	7.0	5.5	75	18.0	41	3	6HX
	S339J213-M10x1.5	S335J213-M10x1.5	S337J213-M10x1.5	M10	1.5	7.0	5.5	75	18.0	41	3	6H
	S339J213-M12x1.25	S335J213-M12x1.25	S337J213-M12x1.25	M12	1.25	8.5	6.5	82	18.0	48	3	6HX
	S339J213-M12x1.5	S335J213-M12x1.5	S337J213-M12x1.5	M12	1.5	8.5	6.5	82	18.0	48	3	6HX
	S339J213-M12x1.75	S335J213-M12x1.75	S337J213-M12x1.75	M12	1.75	8.5	6.5	82	18.0	48	3	6H
	S339J213-M14x1.5		S335J213-M14x1.5	M14	1.5	10.5	8.0	88	20.0	48	3	6HX
	S339J213-M14x2.0		S335J213-M14x2.0	M14	2.0	10.5	8.0	88	20.0	48	3	6HX
	S339J213-M16x1.5		S335J213-M16x1.5	M16	1.5	12.5	10.0	95	20.0	52	3	6HX
	S339J213-M16x2.0		S335J213-M16x2.0	M16	2.0	12.5	10.0	95	20.0	52	3	6HX
	S339J213-M18x1.5		S335J213-M18x1.5	M18	1.5	14.0	11.0	100	25.0	55	4	6HX
	S339J213-M18x2.5		S335J213-M18x2.5	M18	2.5	14.0	11.0	100	25.0	55	4	6HX
	S339J213-M20x1.5		S335J213-M20x1.5	M20	1.5	15.0	12.0	105	25.0	58	4	6HX
	S339J213-M20x2.5		S335J213-M20x2.5	M20	2.5	15.0	12.0	105	25.0	58	4	6HX
	S339J213-M24x3.0		S335J213-M24x3.0	M24	3.0	19.0	15.0	120	30.0	66	4	6HX

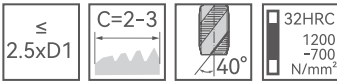
高效多用途涂层丝锥

ST300

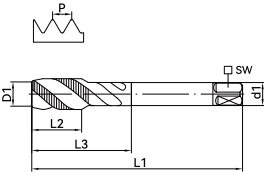


JIS系列-通用长柄螺旋丝锥

JIS series general purpose long shank spiral flute tap



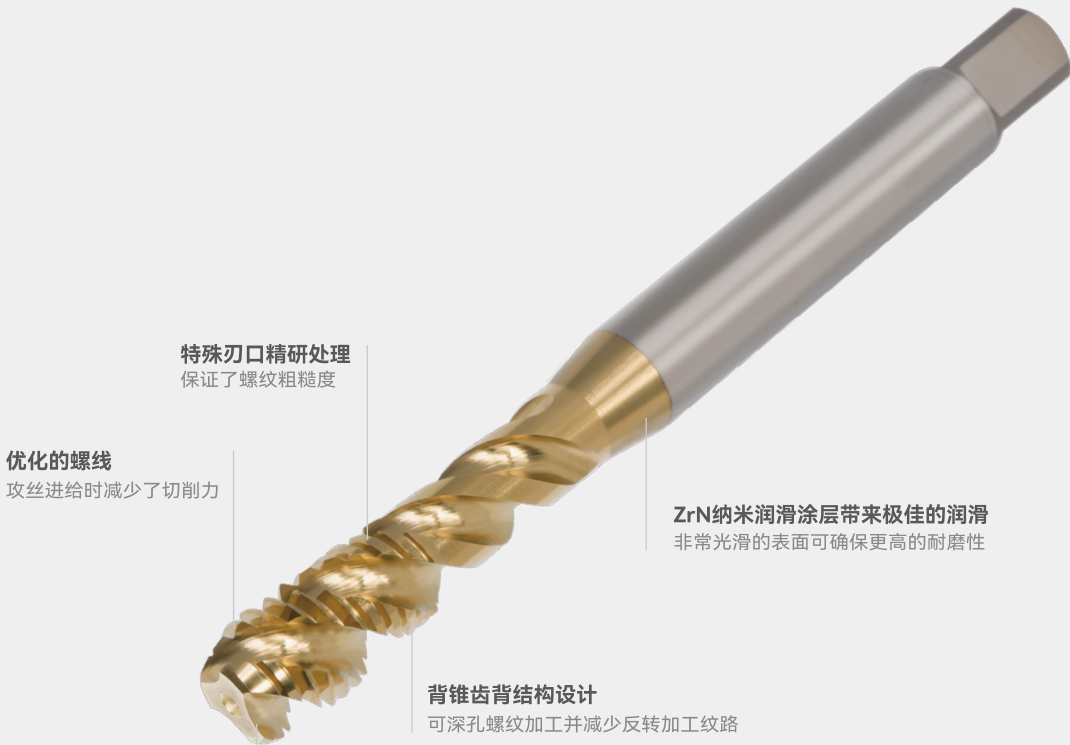
	P	M	K	N	S	H	O
ZrN	●●	●●	●●				
CrN+X	●●	●●	●				

JIS-L100	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S339JL213-M3x0.5	S335JL213-M3x0.5	M3	0.5	4.0	3.2	100	10.0	19	3	6H
	S339JL213-M4x0.7	S335JL213-M4x0.7	M4	0.7	5.0	4.0	100	8.4	21	3	6H
	S339JL213-M5x0.8	S335JL213-M5x0.8	M5	0.8	5.5	4.5	100	9.6	25	3	6H
	S339JL213-M6x1.0	S335JL213-M6x1.0	M6	1.0	6.0	4.5	100	12.0	29	3	6H
	S339JL213-M8x1.0	S335JL213-M8x1.0	M8	1.0	6.2	5.0	100	15.0	40	3	6HX
	S339JL213-M8x1.25	S335JL213-M8x1.25	M8	1.25	6.2	5.0	100	15.0	40	3	6H
	S339JL213-M10x1.0	S335JL213-M10x1.0	M10	1.0	7.0	5.5	100	18.0	41	3	6HX
	S339JL213-M10x1.25	S335JL213-M10x1.25	M10	1.25	7.0	5.5	100	18.0	41	3	6HX
	S339JL213-M10x1.5	S335JL213-M10x1.5	M10	1.5	7.0	5.5	100	18.0	41	3	6H
	S339JL213-M12x1.25	S335JL213-M12x1.25	M12	1.25	8.5	6.5	100	18.0	48	3	6HX
	S339JL213-M12x1.5	S335JL213-M12x1.5	M12	1.5	8.5	6.5	100	18.0	48	3	6HX
	S339JL213-M12x1.75	S335JL213-M12x1.75	M12	1.75	8.5	6.5	100	18.0	48	3	6H

■ YONGPUPRECISION

涂层螺旋丝锥

ST300



- 适合SUS304、SUS316及HRC<25软钢多种材料的深孔攻丝。
 - 大螺旋角切削槽型设计，降低切削负载，提升铁屑形成和排屑性能。
 - 独特刃口精研和表面处理，确保最优切屑形成和涂层的附着力。
 - 采用ZrN纳米低润滑涂层，降低排屑阻力，获得极佳的抗粘连性能。
- 通用性好，适合不锈钢304、316、HRC<25软钢及铝合金等深孔攻丝。
 - 适应攻丝机、车床、多轴机及加工中心等多种工况。
 - 适用中、高速攻丝，加工效率和稳定性好。

高效多用途涂层丝锥
ST300



DIN系列-高效深孔螺旋丝锥

DIN series high productivity spiral flute tap



	≤ 3.5xD1	C=2-3			28HRC 1000 ~700 N/mm²		
ZrN	P	M	K	N	S	H	O
	●	●●	●				

DIN371	工具NO. EDP NO.ZrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S369D217-M3x0.5	M3	0.5	3.5	2.7	56	10.0	18	3	6HX
	S369D217-M4x0.7	M4	0.7	4.5	3.4	63	8.4	21	3	6HX
	S369D217-M5x0.8	M5	0.8	6.0	4.9	70	9.6	25	3	6HX
	S369D217-M6x1.0	M6	1.0	6.0	4.9	80	12.0	30	3	6HX
	S369D217-M8x1.0	M8	1.0	8.0	6.2	90	15.0	35	3	6HX
	S369D217-M8x1.25	M8	1.25	8.0	6.2	90	15.0	35	3	6HX
	S369D217-M10x1.0	M10	1.0	10.0	8.0	100	18.0	39	3	6HX
	S369D217-M10x1.25	M10	1.25	10.0	8.0	100	18.0	39	3	6HX
	S369D217-M10x1.5	M10	1.5	10.0	8.0	100	18.0	39	3	6HX
	S369D217-M12x1.25	M12	1.25	9.0	7.0	110	18.0	--	3	6HX
DIN376	工具NO. EDP NO.ZrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S369D217-M12x1.5	M12	1.5	9.0	7.0	110	18.0	--	3	6HX
	S369D217-M12x1.75	M12	1.75	9.0	7.0	110	18.0	--	3	6HX
	S369D217-M14x1.5	M14	1.5	11.0	9.0	110	20.0	--	3	6HX
	S369D217-M14x2.0	M14	2.0	11.0	9.0	110	20.0	--	3	6HX
	S369D217-M16x1.5	M16	1.5	12.0	9.0	110	20.0	--	3	6HX
	S369D217-M16x2.0	M16	2.0	12.0	9.0	110	20.0	--	3	6HX
	S369D217-M18x1.5	M18	1.5	14.0	11.0	125	25.0	--	4	6HX
	S369D217-M18x2.5	M18	2.5	14.0	11.0	125	25.0	--	4	6HX
	S369D217-M20x1.5	M20	1.5	16.0	12.0	140	25.0	--	4	6HX
	S369D217-M20x2.5	M20	2.5	16.0	12.0	140	25.0	--	4	6HX
	S369D217-M24x3.0	M24	3.0	18.0	14.5	160	30.0	--	4	6HX

高效多用途涂层丝锥
ST300



JIS系列-高效深孔螺旋丝锥

JIS series high productivity spiral flute tap



								
ZrN								
CrN+X								

JIS	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S369J217-M3x0.5	S365J217-M3x0.5	M3	0.5	4.0	3.2	46	10.0	19	3	6HX
	S369J217-M4x0.7	S365J217-M4x0.7	M4	0.7	5.0	4.0	52	8.4	20	3	6HX
	S369J217-M5x0.8	S365J217-M5x0.8	M5	0.8	5.5	4.5	60	9.6	24	3	6HX
	S369J217-M6x1.0	S365J217-M6x1.0	M6	1.0	6.0	4.5	62	12.0	29	3	6HX
	S369J217-M8x1.0	S365J217-M8x1.0	M8	1.0	6.2	5.0	70	15.0	37	3	6HX
	S369J217-M8x1.25	S365J217-M8x1.25	M8	1.25	6.2	5.0	70	15.0	37	3	6HX
	S369J217-M10x1.0	S365J217-M10x1.0	M10	1.0	7.0	5.5	75	18.0	41	3	6HX
	S369J217-M10x1.25	S365J217-M10x1.25	M10	1.25	7.0	5.5	75	18.0	41	3	6HX
	S369J217-M10x1.5	S365J217-M10x1.5	M10	1.5	7.0	5.5	75	18.0	41	3	6HX
	S369J217-M12x1.25	S365J217-M12x1.25	M12	1.25	8.5	6.5	82	18.0	48	3	6HX
	S369J217-M12x1.5	S365J217-M12x1.5	M12	1.5	8.5	6.5	82	18.0	48	3	6HX
	S369J217-M12x1.75	S365J217-M12x1.75	M12	1.75	8.5	6.5	82	18.0	48	3	6HX
	S369J217-M14x1.5		M14	1.5	10.5	8.0	88	20.0	48	3	6HX
	S369J217-M14x2.0		M14	2.0	10.5	8.0	88	20.0	48	3	6HX
	S369J217-M16x1.5		M16	1.5	12.5	10.0	95	20.0	52	4	6HX
	S369J217-M16x2.0		M16	2.0	12.5	10.0	95	20.0	52	4	6HX
	S369J217-M18x1.5		M18	1.5	14.0	11.0	100	25.0	55	4	6HX
	S369J217-M18x2.5		M18	2.5	14.0	11.0	100	25.0	55	4	6HX
	S369J217-M20x1.5		M20	1.5	15.0	12.0	105	25.0	58	4	6HX
	S369J217-M20x2.5		M20	2.5	15.0	12.0	105	25.0	58	4	6HX
	S369J217-M24x3.0		M24	3.0	19.0	15.0	120	30.0	66	4	6HX



涂层先端丝锥 ST200

M
DIN 13

M
JIS

6H

6HX

≤
3.5xD1

B=4-5

32HRC
1200
~700
N/mm²

P

M

K

特殊微观几何结构
刃口精研以螺距参数

经过优化的螺线中心点
攻丝进给时减小了切削力

AICrN 纳米润滑涂层带来极佳的耐磨性
同时更小的摩擦降低了切削温度

齿背结构稳定
反转时避免产生加工纹路

经过优化的排屑槽结构
受控的切削成形以及排出

- 适合对多种类型材料加工的客户。
 - 采用高性能HSS-E材料，具有耐久稳定的使用寿命。
 - 采用优化的槽型设计，可适用于多种材料的加工-包括碳钢及合金钢、不锈钢、球磨铸铁以及铸铝材料。
- 优化的直槽刃倾角设计，可使通孔加工中的切屑有效排出。
 - 适用于同步和非同步攻丝机的螺纹加工。
 - 采用适合的PVD涂层处理，具有可靠的性能。



高效多用途涂层丝锥 ST200



DIN系列-高效先端丝锥 DIN series high productivity spiral point tap

M
DIN 13

6H

6HX

≤
3.5xD1

B=4-5

32HRC
1200
~700
N/mm²

	P	M	K	N	S	H	O
AICrN	●●	●	●●	●	●	●	●

DIN371	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S330HD215-M3x0.5	M3	0.5	3.5	2.7	56	10.0	18	3	6HX
	S330HD215-M4x0.7	M4	0.7	4.5	3.4	63	13.0	21	3	6HX
	S330HD215-M5x0.8	M5	0.8	6.0	4.9	70	16.0	25	3	6HX
	S330HD215-M6x1.0	M6	1.0	6.0	4.9	80	18.0	30	3	6HX
	S330HD215-M8x1.0	M8	1.0	8.0	6.2	90	20.0	35	4	6HX
	S330HD215-M8x1.25	M8	1.25	8.0	6.2	90	20.0	35	4	6HX
	S330HD215-M10x1.0	M10	1.0	10.0	8.0	100	20.0	39	4	6HX
	S330HD215-M10x1.25	M10	1.25	10.0	8.0	100	20.0	39	4	6HX
	S330HD215-M10x1.5	M10	1.5	10.0	8.0	100	20.0	39	4	6HX
	S330HD215-M12x1.25	M12	1.25	9.0	7.0	110	25.0	--	5	6HX
	S330HD215-M12x1.5	M12	1.5	9.0	7.0	110	25.0	--	5	6HX
	S330HD215-M12x1.75	M12	1.75	9.0	7.0	110	25.0	--	5	6HX
	S330HD215-M14x1.5	M14	1.5	11.0	9.0	110	25.0	--	5	6HX
	S330HD215-M14x2.0	M14	2.0	11.0	9.0	110	25.0	--	4	6HX
	S330HD215-M16x1.5	M16	1.5	12.0	9.0	110	25.0	--	4	6HX
	S330HD215-M16x2.0	M16	2.0	12.0	9.0	110	25.0	--	4	6HX
	S330HD215-M18x1.5	M18	1.5	14.0	11.0	125	25.0	--	4	6HX
	S330HD215-M18x2.5	M18	2.5	14.0	11.0	125	25.0	--	4	6HX
	S330HD215-M20x1.5	M20	1.5	16.0	12.0	140	28.0	--	4	6HX
	S330HD215-M20x2.5	M20	2.5	16.0	12.0	140	28.0	--	4	6HX
	S330HD215-M24x3.0	M24	3.0	18.0	14.5	160	32.0	--	4	6HX



高效多用途涂层丝锥
ST200



JIS系列-高效先端丝锥

JIS series high productivity spiral point tap



	P	M	K	N	S	H	O
AlCrN	●●	●	●●	●	●	●	●

JIS	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S330HJ215-M6x1.0	M6	1.0	6.0	4.5	62	16.0	29	3	6H
	S330HJ215-M8x1.0	M8	1.0	6.2	5.0	70	21.0	37	4	6HX
	S330HJ215-M8x1.25	M8	1.25	6.2	5.0	70	21.0	37	4	6H
	S330HJ215-M10x1.0	M10	1.0	7.0	5.5	75	23.0	41	4	6HX
	S330HJ215-M10x1.25	M10	1.25	7.0	5.5	75	23.0	41	4	6HX
	S330HJ215-M10x1.5	M10	1.5	7.0	5.5	75	23.0	41	4	6H
	S330HJ215-M12x1.25	M12	1.25	8.5	6.5	82	24.0	48	5	6H
	S330HJ215-M12x1.5	M12	1.5	8.5	6.5	82	24.0	48	5	6H
	S330HJ215-M12x1.75	M12	1.75	8.5	6.5	82	24.0	48	5	6H
	S330HJ215-M14x1.5	M14	1.5	10.5	8.0	88	24.0	48	5	6HX
	S330HJ215-M14x2.0	M14	2.0	10.5	8.0	88	24.0	48	4	6HX
	S330HJ215-M16x1.5	M16	1.5	12.5	10.0	95	24.0	52	4	6HX
	S330HJ215-M16x2.0	M16	2.0	12.5	10.0	95	24.0	52	4	6HX
	S330HJ215-M18x1.5	M18	1.5	14.0	11.0	100	24.0	55	4	6HX
	S330HJ215-M18x2.5	M18	2.5	14.0	11.0	100	24.0	55	4	6HX
	S330HJ215-M20x1.5	M20	1.5	15.0	12.0	105	26.0	58	4	6HX
	S330HJ215-M20x2.5	M20	2.5	15.0	12.0	105	26.0	58	4	6HX
	S330HJ215-M24x3.0	M24	3.0	19.0	15.0	120	32.0	66	4	6HX



高效多用途涂层丝锥
ST200



JIS系列-通用先端丝锥

JIS series general purpose spiral point tap



	P	M	K	N	S	H	O
ZrN	●●	●●	●●	●	●	●	●
CrN+X	●●	●●	●●	●	●	●	●
AlCrN	●●	●	●●	●	●	●	●

JIS	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S336J213-M3x0.5	S330J213-M3x0.5	S332J213-M3x0.5	M3	0.5	4.0	3.2	46	11.5	19	3	6H
	S336J213-M4x0.7	S330J213-M4x0.7	S332J213-M4x0.7	M4	0.7	5.0	4.0	52	13.0	20	3	6H
	S336J213-M5x0.8	S330J213-M5x0.8	S332J213-M5x0.8	M5	0.8	5.5	4.5	60	16.0	24	3	6H
	S336J213-M6x1.0	S330J213-M6x1.0	S332J213-M6x1.0	M6	1.0	6.0	4.5	62	19.0	29	3	6H
	S336J213-M8x1.0	S330J213-M8x1.0	S332J213-M8x1.0	M8	1.0	6.2	5.0	70	21.0	37	3	6HX
	S336J213-M8x1.25	S330J213-M8x1.25	S332J213-M8x1.25	M8	1.25	6.2	5.0	70	21.0	37	3	6H
	S336J213-M10x1.0	S330J213-M10x1.0	S332J213-M10x1.0	M10	1.0	7.0	5.5	75	23.0	41	3	6HX
	S336J213-M10x1.25	S330J213-M10x1.25	S332J213-M10x1.25	M10	1.25	7.0	5.5	75	23.0	41	3	6HX
	S336J213-M10x1.5	S330J213-M10x1.5	S332J213-M10x1.5	M10	1.5	7.0	5.5	75	23.0	41	3	6H
	S336J213-M12x1.25	S330J213-M12x1.25	S332J213-M12x1.25	M12	1.25	8.5	6.5	82	24.0	48	3	6HX
	S336J213-M12x1.5	S330J213-M12x1.5	S332J213-M12x1.5	M12	1.5	8.5	6.5	82	24.0	48	3	6HX
	S336J213-M12x1.75	S330J213-M12x1.75	S332J213-M12x1.75	M12	1.75	8.5	6.5	82	24.0	48	3	6H
	S336J215-M14x1.5		S332J213-M14x1.5	M14	1.5	10.5	8.0	88	24.0	48	3	6HX
	S336J215-M14x2.0			M14	2.0	10.5	8.0	88	24.0	48	4	6HX
	S336J215-M16x1.5			M16	1.5	12.5	10.0	95	24.0	52	4	6HX
	S336J215-M16x2.0			M16	2.0	12.5	10.0	95	24.0	52	4	6HX
	S336J215-M18x1.5			M18	1.5	14.0	11.0	100	24.0	55	4	6HX
	S336J215-M18x2.5			M18	2.5	14.0	11.0	100	24.0	55	4	6HX
	S336J215-M20x1.5			M20	1.5	15.0	12.0	105	26.0	58	4	6HX
	S336J215-M20x2.5			M20	2.5	15.0	12.0	105	26.0	58	4	6HX
	S336J215-M24x3.0			M24	3.0	19.0	15.0	120	32.0	66	4	6HX



高效多用途涂层丝锥
ST200



JIS系列通用长柄先端丝锥
JIS series general purpose tap with long shank



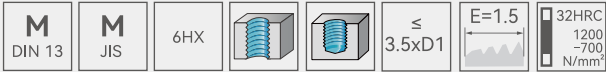
	P	M	K	N	S	H	O
ZrN	••	••	••	••	••	••	••
CrN+X	••	••	•	•	•	•	•

JIS-L100	工具NO. EDP NO.ZrN	工具NO. EDP NO.CrN+X	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S336JL213-M3x0.5	S330JL213-M3x0.5	M3	0.5	4.0	3.2	100	10.0	20	3	6H
	S336JL213-M4x0.7	S330JL213-M4x0.7	M4	0.7	5.0	4.0	100	13.0	27	3	6H
	S336JL213-M5x0.8	S330JL213-M5x0.8	M5	0.8	5.5	4.5	100	16.0	33	3	6H
	S336JL213-M6x1.0	S330JL213-M6x1.0	M6	1.0	6.0	4.5	100	19.0	40	3	6H
	S336JL213-M8x1.0	S330JL213-M8x1.0	M8	1.0	6.2	5.0	100	22.0	40	3	6HX
	S336JL213-M8x1.25	S330JL213-M8x1.25	M8	1.25	6.2	5.0	100	22.0	40	3	6H
	S336JL213-M10x1.0	S330JL213-M10x1.0	M10	1.0	7.0	5.5	100	24.0	41	3	6HX
	S336JL213-M10x1.25	S330JL213-M10x1.25	M10	1.25	7.0	5.5	100	24.0	41	3	6HX
	S336JL213-M10x1.5	S330JL213-M10x1.5	M10	1.5	7.0	5.5	100	24.0	41	3	6H
	S336JL213-M12x1.25	S330JL213-M12x1.25	M12	1.25	8.5	6.5	100	24.0	48	3	6HX
	S336JL213-M12x1.5	S330JL213-M12x1.5	M12	1.5	8.5	6.5	100	24.0	48	3	6HX
	S336JL213-M12x1.75	S330JL213-M12x1.75	M12	1.75	8.5	6.5	100	24.0	48	3	6H

■ YONGPUPRECISION



涂层直槽丝锥
ST100



- 采用优化的槽型设计，适用铸铁、球墨铸铁、合金钢及碳钢的加工。
- 优化的多槽设计，可使短切屑材料在通孔和盲孔攻丝中的切屑有效排出。
- 适用于同步和非同步攻丝机的螺纹加工。
- 高性能HSS-E材料和PVD涂层处理，具有耐久稳定的使用寿命和可靠的性能。



高效多用途涂层丝锥
ST100



JIS系列-高效直槽丝锥

JIS series high productivity straight flute tap



	P	M	K	N	S	H	O
ZrN	●●	●●	●●	●●	●●	●●	●●

JIS	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S336J215-M3x0.5	M3	0.5	4.0	3.2	46	10.0	19	4	6HX
	S336J215-M4x0.7	M4	0.7	5.0	4.0	52	12.0	20	4	6HX
	S336J215-M5x0.8	M5	0.8	5.5	4.5	60	14.0	24	4	6HX
	S336J215-M6x1.0	M6	1.0	6.0	4.5	62	16.0	29	4	6HX
	S336J215-M8x1.0	M8	1.0	6.2	5.0	70	21.0	37	4	6HX
	S336J215-M8x1.25	M8	1.25	6.2	5.0	70	21.0	37	4	6HX
	S336J215-M10x1.0	M10	1.0	7.0	5.5	75	23.0	41	4	6HX
	S336J215-M10x1.25	M10	1.25	7.0	5.5	75	23.0	41	4	6HX
	S336J215-M10x1.5	M10	1.5	7.0	5.5	75	23.0	41	4	6HX
	S336J215-M12x1.25	M12	1.25	8.5	6.5	82	24.0	48	4	6HX
	S336J215-M12x1.5	M12	1.5	8.5	6.5	82	24.0	48	4	6HX
	S336J215-M12x1.75	M12	1.75	8.5	6.5	82	24.0	48	4	6HX
	S336J215-M14x1.5	M14	1.5	10.5	8.0	88	24.0	48	4	6HX
	S336J215-M14x2.0	M14	2.0	10.5	8.0	88	24.0	48	4	6HX
	S336J215-M16x1.5	M16	1.5	12.5	10.0	95	24.0	52	4	6HX
	S336J215-M16x2.0	M16	2.0	12.5	10.0	95	24.0	52	4	6HX
	S336J215-M18x1.5	M18	1.5	14.0	11.0	100	24.0	55	4	6HX
	S336J215-M18x2.5	M18	2.5	14.0	11.0	100	24.0	55	4	6HX
	S336J215-M20x1.5	M20	1.5	15.0	12.0	105	26.0	58	4	6HX
	S336J215-M20x2.5	M20	2.5	15.0	12.0	105	26.0	58	4	6HX
	S336J215-M24x3.0	M24	3.0	19.0	15.0	120	32.0	66	4	6HX



高效多用途涂层丝锥
ST100



DIN系列-高效直槽丝锥

DIN series high productivity straight flute tap



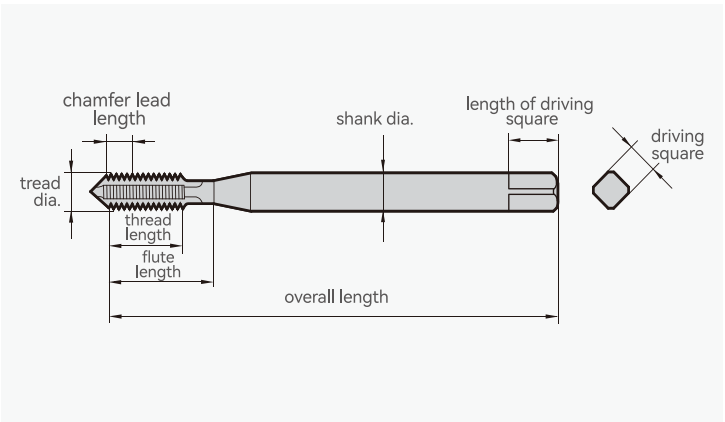
	P	M	K	N	S	H	O
AICrN	●●	●●	●●	●●	●●	●●	●●

DIN371	工具NO. EDP NO.AICrN	直径 D1	螺距 P(mm)	柄径 d1(mm)	方径 SW	全长 L1(mm)	螺纹长度 L2(mm)	颈长 L3(mm)	槽数 Number of flute	精度 TAP tolerance
	S332ID215-M3x0.5	M3	0.5	3.5	2.7	56	10.0	18	4	6HX
	S332ID215-M4x0.7	M4	0.7	4.5	3.4	63	13.0	21	4	6HX
	S332ID215-M5x0.8	M5	0.8	6.0	4.9	70	16.0	25	4	6HX
	S332ID215-M6x1.0	M6	1.0	6.0	4.9	80	18.0	30	4	6HX
	S332ID215-M8x1.0	M8	1.0	8.0	6.2	90	20.0	35	4	6HX
	S332ID215-M8x1.25	M8	1.25	8.0	6.2	90	20.0	35	4	6HX
	S332ID215-M10x1.0	M10	1.0	10.0	8.0	100	20.0	39	4	6HX
	S332ID215-M10x1.25	M10	1.25	10.0	8.0	100	20.0	39	4	6HX
	S332ID215-M10x1.5	M10	1.5	10.0	8.0	100	20.0	39	4	6HX
	S332ID215-M12x1.25	M12	1.25	9.0	7.0	110	25.0	--	4	6HX
	S332ID215-M12x1.5	M12	1.5	9.0	7.0	110	25.0	--	4	6HX
	S332ID215-M12x1.75	M12	1.75	9.0	7.0	110	25.0	--	4	6HX
	S332ID215-M14x1.5	M14	1.5	11.0	9.0	110	25.0	--	4	6HX
	S332ID215-M14x2.0	M14	2.0	11.0	9.0	110	25.0	--	4	6HX
	S332ID215-M16x1.5	M16	1.5	12.0	9.0	110	25.0	--	4	6HX
	S332ID215-M16x2.0	M16	2.0	12.0	9.0	110	25.0	--	4	6HX
	S332ID215-M18x1.5	M18	1.5	14.0	11.0	125	25.0	--	4	6HX
	S332ID215-M18x2.5	M18	2.5	14.0	11.0	125	25.0	--	4	6HX
	S332ID215-M20x1.5	M20	1.5	16.0	12.0	140	28.0	--	4	6HX
	S332ID215-M20x2.5	M20	2.5	16.0	12.0	140	28.0	--	4	6HX
	S332ID215-M24x3.0	M24	3.0	18.0	14.5	160	32.0	--	4	6HX

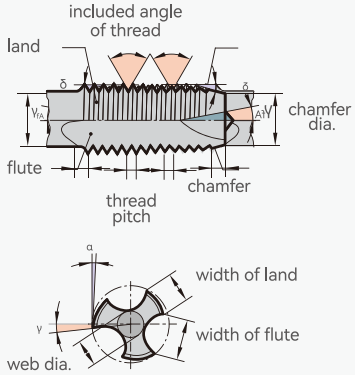


丝锥产品信息

General information



δ = chamfer angle
 V_{α} = spiral point angle
 α = clearance angle
 γ = rake angle



刃型

Flute forms



straight fluted, form C
without spiral point



helix angle
15°



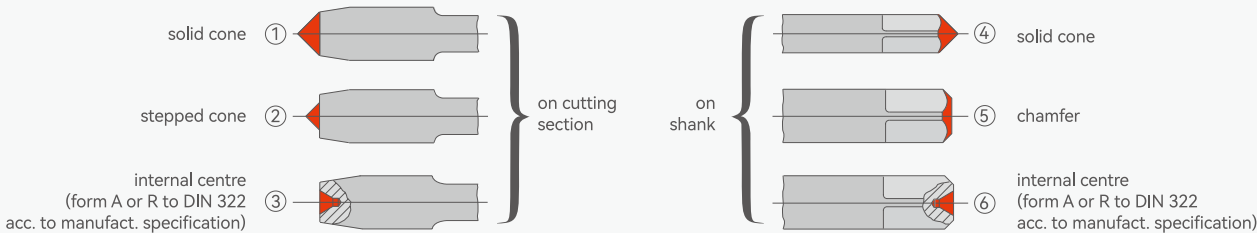
straight fluted, form B
with spiral point



helix angle
40°

中心形式标准

Types of centres (standard, to DIN 2197/DIN 2175)



Thread dia. range mm	Centre on cutting section		Centre on shank
	with chamfer forms A, C, D, E	with chamfer form B	
≤ 4.2	①	①	④ ⑤ ⑥
> 4.2 ... 5.6	① ②	①	④ ⑤ ⑥
> 5.6 ... 10.0	① ② ③	① ② ③	④ ⑤ ⑥
> 10.0	③	③	⑥

槽型冷却形式

Coolant duct geometries



axial coolant
delivery
with axial coolant
duct exit



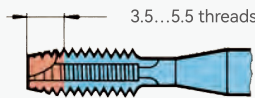
axial coolant
delivery with radial
coolant duct exit in the flutes
at the chamfer



切削锥类型

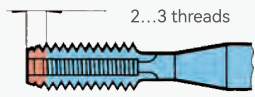
Threading chamfer type

Form B



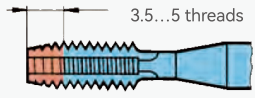
medium, 3.5 - 5.5 threads,
with spiral point,
for all through holes
and deep tapping holes in medium
and long-chipping materials

Form C



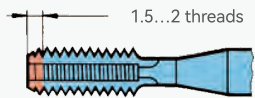
short, 2 - 3 threads
for blind holes
and generally for
aluminium, grey cast iron
and brass

Form D



medium, 3.5 - 5 threads
for short
through holes

Form E



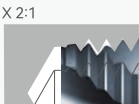
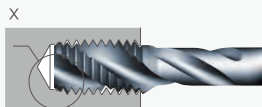
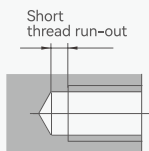
extremely short, 1.5-2 threads,
for blind holes with
little run-out depth.

E型 切削锥选择

Selection of E-type Cutting Cone

除了传统的B型和C型丝锥外，我们越来越多地将E型工具纳入我们的标准范围。因此，在加工盲孔时，我们考虑到对丝锥的需求日益增长，在加工盲孔时，丝锥的螺纹应尽可能靠近孔底，在加工通孔时，丝锥的螺纹应尽可能深。

In addition to the conventional Form B and C for machine taps we are increasingly including Form E tools in our standard range. Thus, we are taking into account the increasing demand for taps with which threads can be produced as close as possible to the bottom of the bore when machining blind holes and to produce deepest threads as possible when machining through holes.

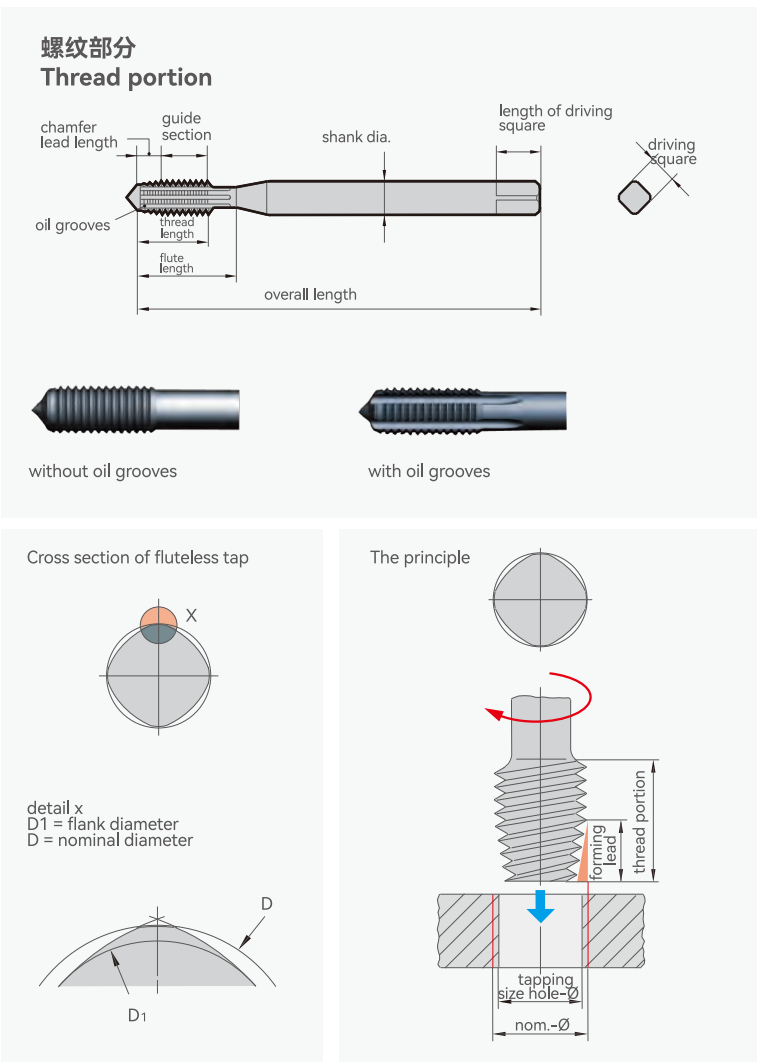


E型丝锥具有非常短的倒角引线，只有1.5到2个螺纹。在加工中心和攻丝夹头上，与B型和C型相比，刀具导向较短切削扭距降低。采用了刚性工具夹持。E型丝锥在生产应用中，完全覆盖螺纹加工具有显著优势。

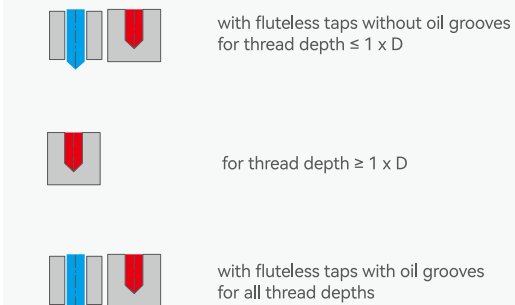
Type E taps have very short chamfered leads, with only 1.5 to 2 threads. In the machining center and tapping chuck, compared with B and C, the tool steering is shorter and the cutting torque is lower. Rigid tool clamping is adopted. In the production and application of E-type taps, the processing of fully covered threads has significant advantages.

螺纹加工信息

Threading hole making

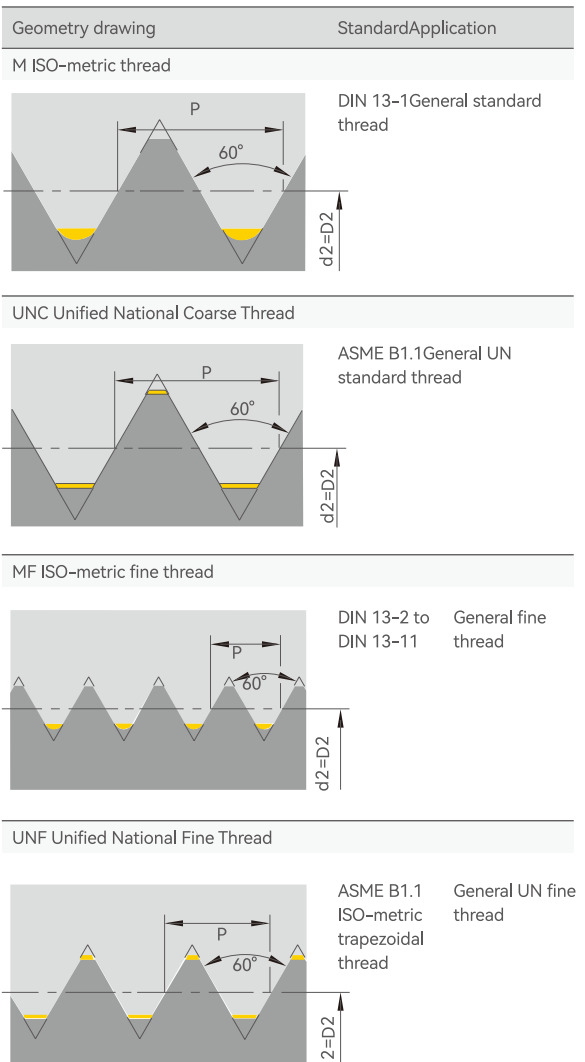


Types of tapping size hole

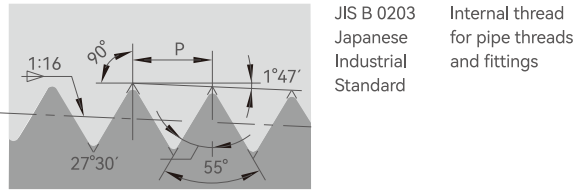


螺纹类型及特点

Types and characteristics



PT Taper Pipe Thread (identical to Rc and BSPT)



external thread internal thread play

螺纹攻丝孔的尺寸

Pre-hole for threading hole

Std. ISO metric threads DIN 13					ISO metric fine threads DIN 13					UNC threads ASME B1.1					UNF threads ASME B1.1								
nom. $\varnothing$		pitch tapping P		core diameter of int. thread 6H		nom. $\varnothing$		pitch tapping P		core diameter of int. thread 6H		nom. $\varnothing$		threads tapping per inch		core diameter of int. thread 2B		nom. $\varnothing$		threads tapping per inch		core diameter of int. thread 2B	
mm		mm		mm		mm		mm		mm		mm		mm		mm		mm		mm		mm	
M 1	0.25	0.75	0.729	0.785	M 4.0	x 0.50	3.50	3.459	3.599	Nr. 1	- 64	1.55	1.425	1.580	Nr. 1	- 72	1.55	1.473	1.610				
M 1.1	0.25	0.85	0.829	0.885	M 4.5	x 0.50	4.00	3.959	4.099	Nr. 2	- 56	1.85	1.694	1.872	Nr. 2	- 64	1.85	1.755	1.910				
M 1.2	0.25	0.95	0.929	0.985	M 5.0	x 0.50	4.50	4.459	4.599	Nr. 3	- 48	2.10	1.941	2.146	Nr. 3	- 56	2.15	2.024	2.197				
M 1.4	0.30	1.10	1.075	1.142	M 5.5	x 0.50	5.00	4.959	5.099	Nr. 4	- 40	2.35	2.157	2.385	Nr. 4	- 48	2.40	2.271	2.459				
M 1.6	0.35	1.25	1.221	1.321	M 6.0	x 0.75	5.20	5.188	5.378	Nr. 5	- 40	2.65	2.487	2.698	Nr. 5	- 44	2.70	2.550	2.741				
M 1.8	0.35	1.45	1.421	1.521	M 7.0	x 0.75	6.20	6.188	6.378	Nr. 6	- 32	2.85	2.642	2.896	Nr. 6	- 40	2.95	2.819	3.023				
M 2	0.40	1.60	1.567	1.679	M 8.0	x 0.50	7.50	7.459	7.599	Nr. 8	- 32	3.50	3.302	3.531	Nr. 8	- 36	3.50	3.404	3.607				
M 2.2	0.45	1.75	1.713	1.838	M 8.0	x 0.75	7.20	7.188	7.378	Nr. 10	- 24	3.90	3.683	3.937	Nr. 10	- 32	4.10	3.962	4.166				
M 2.5	0.45	2.05	2.013	2.138	M 8.0	x 1.00	7.00	6.917	7.153	Nr. 12	- 24	4.50	4.343	4.597	Nr. 12	- 28	4.60	4.496	4.724				
M 3	0.50	2.50	2.459	2.599	M 9.0	x 0.75	8.20	8.188	8.378	1/4	- 20	5.10	4.978	5.258	1/4	- 28	5.50	5.359	5.588				
M 3.5	0.60	2.90	2.850	3.010	M 9.0	x 1.00	8.00	7.917	8.153	5/16	- 18	6.60	6.401	6.731	5/16	- 24	6.90	6.782	7.036				
M 4	0.70	3.30	3.242	3.422	M 10	x 0.75	9.20	9.188	9.378	3/8	- 16	8.00	7.798	8.153	3/8	- 24	8.50	8.382	8.636				
M 4.5	0.75	3.70	3.688	3.878	M 10	x 1.00	9.00	8.917	9.153	7/16	- 14	9.40	9.144	9.550	7/16	- 20	9.90	9.728	10.033				
M 5	0.80	4.20	4.134	4.334	M 10	x 1.25	8.80	8.647	8.912	1/2	- 13	10.80	10.592	11.024	1/2	- 20	11.50	11.328	11.608				
M 6	1.00	5.00	4.917	5.153	M 11	x 0.75	10.20	10.188	10.378	9/16	- 12	12.20	11.989	12.446	9/16	- 18	12.90	12.751	13.081				
M 7	1.00	6.00	5.917	6.153	M 11	x 1.00	10.00	9.917	10.153	5/8	- 11	13.50	13.386	13.868	5/8	- 18	14.50	14.351	14.681				
M 8	1.25	6.80	6.647	6.912	M 12	x 1.00	11.00	10.917	11.153	3/4	- 10	16.50	16.307	16.840	3/4	- 16	17.50	17.323	17.678				
M 9	1.25	7.80	7.647	7.912	M 12	x 1.25	10.80	10.647	10.912	7/8	- 9	19.50	19.177	19.761	7/8	- 14	20.40	20.269	20.650				
M 10	1.50	8.50	8.376	8.676	M 12	x 1.50	10.50	10.376	10.676	1	- 8	22.25	21.971	22.606	1	- 12	23.25	23.114	23.571				
M 11	1.50	9.50	9.376	9.676	M 14	x 1.00	13.00	12.917	13.153						1 1/8	- 12	26.50	26.289	26.746				
M 12	1.75	10.20	10.106	10.441	M 14	x 1.25	12.80	12.647	12.912						1 1/4	- 12	29.50	29.464	29.921				
M 14	2.00	12.00	11.835	12.210	M 14	x 1.50	12.50	12.376	12.676						1 3/8	- 12	32.75	32.639	33.096				
M 16	2.00	14.00	13.835	14.210	M 15	x 1.00	14.00	13.917	14.153						1 1/2	- 12	36.00	35.814	36.271				
M 18	2.50	15.50	15.294	15.744	M 15	x 1.50	13.50	13.376	13.676														
M 20	2.50	17.50	17.294	17.744	M 16	x 1.00	15.00	14.917	15.153														
M 22	2.50	19.50	19.294	19.744	M 16	x 1.25	14.80	14.647	14.912														
M 24	3.00	21.00	20.752	21.252	M 16	x 1.50	14.50	14.376	14.676														
M 27	3.00	24.00	23.752	24.252	M 17	x 1.00	16.00	15.917	16.153														
M 30	3.50	26.50	26.211	26.771	M 17	x 1.50	15.50	15.376	15.676														
					M 18	x 1.00	17.00	16.917	17.153														
					M 18	x 1.50	16.50	16.376	16.676														
					M 20	x 1.00	19.00	18.917	19.153														
					M 20	x 1.50	18.50	18.376	18.676														
					M 20	x 2.00	18.00	17.835	18.210														

PT JIS B 0203 TAPER PIPE THREAD CONE 1:16				
nom. $\varnothing$	threads	tapping size hole $\varnothing$		cutting depth
	per inch	Version A d1	Version B D1	ET mm
PT 1/16	-28	6.20	6.60	6.20
PT 1/16	-28	8.20	8.60	6.20
PT 1/16	-19	10.90	11.50	9.40
PT 1/16	-19	14.40	15.00	9.70
PT 1/16	-14	17.90	18.70	12.70
PT 1/16	-14	23.30	24.20	14.10
PT 1/16	-11	29.30	30.30	16.20
		Version A (avoid if possible)	Version B	



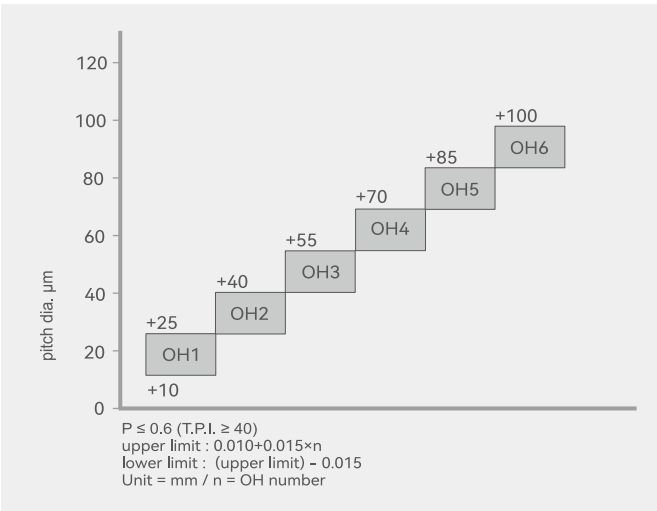
螺纹攻丝孔的尺寸
Pre-hole for threading hole

Std. ISO metric threads DIN 13						Std. ISO metric fine threads DIN 13					
nom. Ø	pitch P	tapping size hole Ø	tapping size hole Ø		core diameter of int. thread 7H	nom. Ø	x pitch P	tapping size hole Ø	tapping size hole Ø		core diameter of int. thread 7H
			min.	max.					min.	max.	
	mm	mm	mm	mm	mm			mm	mm	mm	mm
M 1	0.25		0.729	0.785		M 6	x 0.75	5.65	5.62	5.70	5.188
M 1.1	0.25		0.829	0.885		M 7	x 0.75	6.65	6.62	6.70	6.188
M 1.2	0.25		0.929	0.985		M 8	x 0.75	7.65	7.62	7.70	7.188
M 1.4	0.30		1.076	1.142		M 8	x 1.00	7.55	7.52	7.62	6.917
M 1.6	0.35		1.221	1.321		M 9	x 0.75	8.65	8.62	8.70	8.188
M 1.8	0.35		1.421	1.521		M 9	x 1.00	8.55	8.52	8.62	7.917
M 2	0.40	1.85	1.84	1.88	1.567	M 10	x 0.75	9.65	9.62	9.70	9.188
M 2.2	0.45	2.00	2.01	2.05	1.713	M 10	x 1.00	9.55	9.52	9.62	8.917
M 2.5	0.45	2.30	2.28	2.32	2.013	M 10	x 1.25	9.40	9.36	9.47	8.647
M 3	0.50	2.80	2.78	2.85	2.459	M 11	x 0.75	10.65	10.62	10.70	10.188
M 3.5	0.60	3.25	3.23	3.30	2.850	M 11	x 1.00	10.55	10.52	10.62	9.917
M 4	0.70	3.70	3.68	3.76	3.242	M 12	x 1.00	11.55	11.52	11.62	10.917
M 4.5	0.75	4.20				M 12	x 1.25	11.40	11.36	11.47	10.647
M 5	0.80	4.65	4.62	4.71	4.134	M 12	x 1.50	11.30	11.26	11.38	10.376
M 6	1.00	5.55	5.52	5.62	4.917	M 14	x 1.00	13.55	13.52	13.62	12.917
M 7	1.00	6.55	6.52	6.62	5.917	M 14	x 1.25	13.40	13.36	13.47	12.647
M 8	1.25	7.40	7.36	7.47	6.647	M 14	x 1.50	13.30	13.26	13.38	12.376
M 9	1.25	8.40	8.36	8.47	7.647	M 15	x 1.00	14.55	14.52	14.62	13.917
M 10	1.50	9.30	9.26	9.38	8.376	M 15	x 1.50	14.30	14.26	14.38	13.376
M 11	1.50	10.30	10.26	10.38	9.376	M 16	x 1.00	15.55	15.52	15.62	14.917
M 12	1.75	11.20	11.15	11.29	10.106	M 16	x 1.50	15.30	15.26	15.38	14.376
M 14	2.00	13.10	13.05	13.20	11.835	M 20	x 1.50	19.30	19.26	19.38	18.376
M 16	2.00	15.10	15.05	15.20	13.835						
M 18	2.50	16.90	16.83	17.02	15.294						
M 20	2.50	18.90	18.83	19.02	17.294						

切削丝锥公差标准
Tolerance of cutting tap

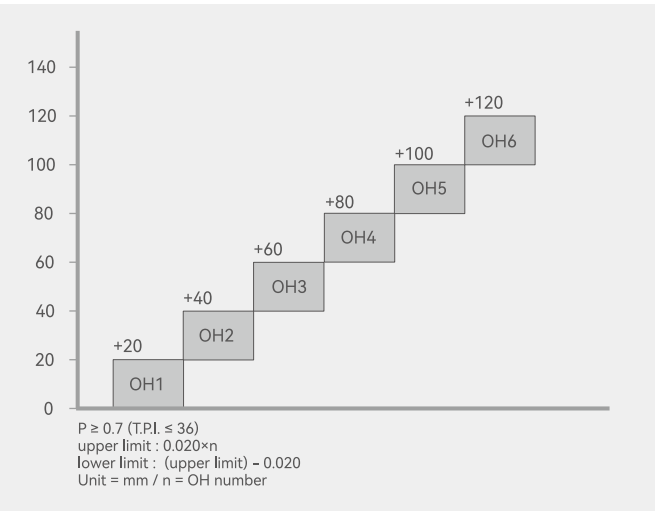
Pitch ≤ 0.6

OH limits



Pitch ≥ 0.7

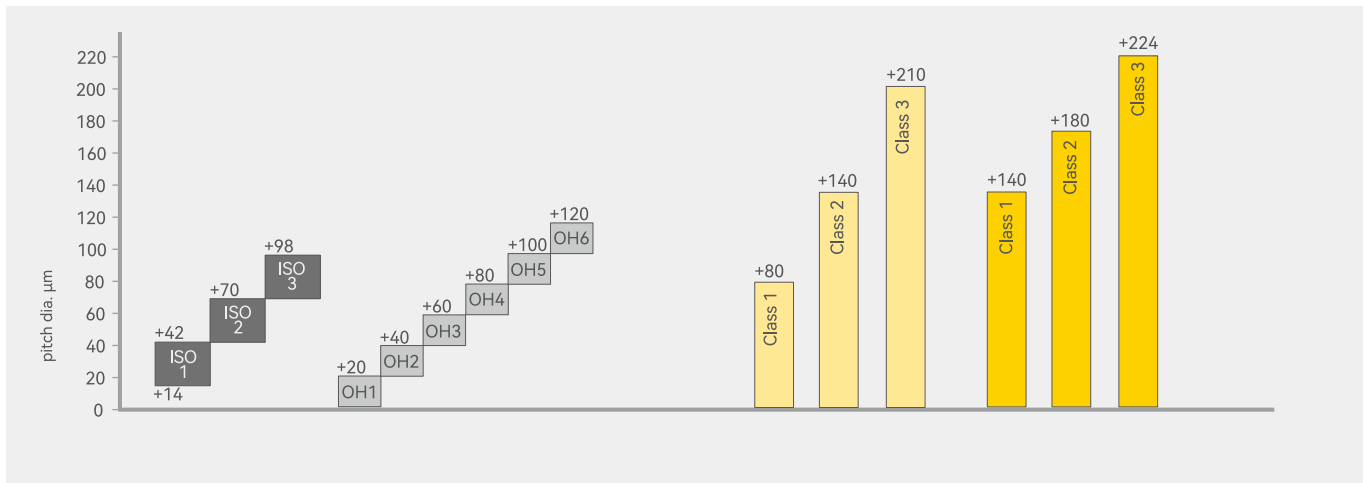
OH limits



Example M10 (x 1.5)

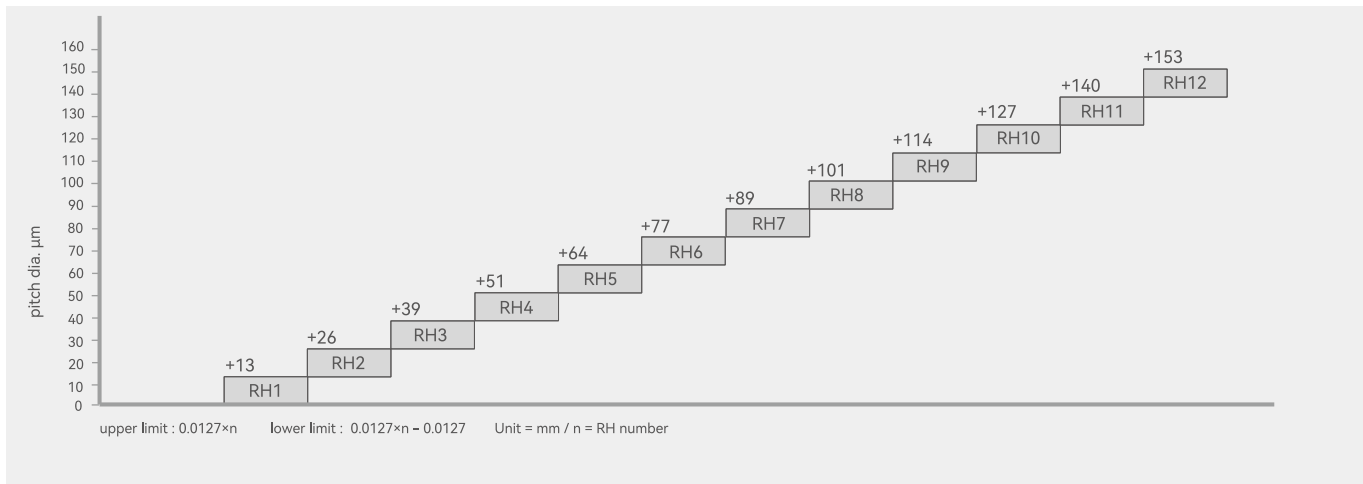
ISO limits
OH limits

JIS internal thread
ISO internal thread



挤压丝锥公差标准
RH limits for fluteless taps

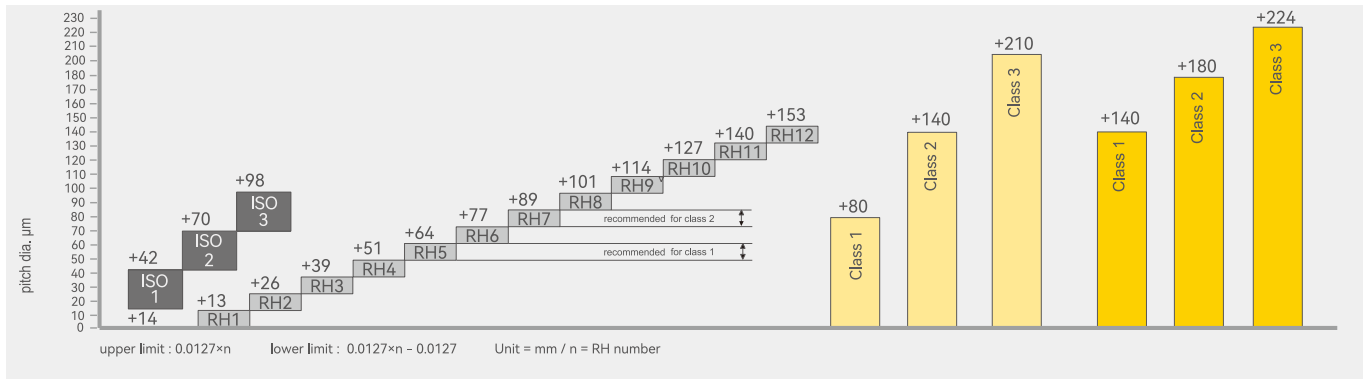
RH limits



Example M10 (x 1.5)

ISO limits
RH limits

JIS internal thread
ISO internal thread





丝锥使用测试报告

Tap test report

丝锥类型 Tap type		☐ 螺旋槽 Spiral flute		☐ 直槽 Straight flute		☐ 涂层 coating		☐ 无涂层 uncoated					
规格型号 Ordering code													
加工条件 Machining conditions		机床类型、制造商及功率大小: Machine , manufacturer and power:		☐ MK		☐ SK		☐ HSK		☐ TR		☐ 其他	
		主轴连接方式 Spindle connection mode		☐ DIN		☐ ANSI		☐ JIS		☐ 其他			
		工作 名称 Process				工件材料/描述 workpiece material / description							
		热处理方式 Heat treatment				抗拉强度 Tensile strength				N/mm ²			
		硬度 Hardness				延伸率 Elongation				%			
加工工艺要求 Process requirements		加工方式选择 Processing mode		☐ 水平切削 Horizontal cutting		☐ 垂直切削 Vertical cutting		☐ 刀具旋转 Tool rotation		☐ 刀具静止 Tool stationary			
		刀具寿命 Tool life		新品寿命 New product life_____				修磨重涂寿命 Service life of grinding and repainting_____					
		寿命判断 Tool change reason		☐ 负载 Load		☐ 表面质量 Surface quality		☐ 尺寸 Size		☐ 其他 Other			
		切削参数 Cutting parameters		转速n Speed_____min ⁻¹				线速度V _c Cutting speed_____m/min					
进给方式 Feed mode		☐ 凸轮式 Cam-type		☐ 液压推动式 Sydraulic		☐ 丝杠式 Screw		☐ NC控制式 CNC					
		☐ 同步式 Synchronous		☐ 齿轮式 Gear type		☐ 其他 Other							
刀具夹紧方式 Tool clamping mode		☐ 弹簧夹头方式 ER collet		☐ 丝锥夹头方式 Tap collet mode		☐ 自动换向夹头方式 Automatic reversing collet mode		☐ 过载保护装置方式 Overload protection device mode					
		☐ 带长度补偿装置方式 With length compensation device		☐ 带轴向调整方式 With axial adjustment mode		☐ 带内冷传输方式 In band cooling transmission mode_____bar							
润滑条件 Lubrication conditions		☐ 油 Oil		☐ 乳化液 Emulsion _____%		☐ 干切削 Dry cutting		☐ 循环 Loop					
		☐ 润滑脂 Grease		☐ 少量润滑 Little lubrication		☐ 其他 Other							
加工过程 Processing		刀具品牌 Tool brand							零件或加工部位草图 Sketch of parts or machining parts				
		切削参数 cutting parameters		切削速度-vm/min Cutting speed									
				转速-nr/min Rotating speed									
						进给量-vfmm/min Feed rate							
结果 result		加工状态及质量 Processing state and quality				注: 加工失效时, 请注明加工失效时的 加工数量: ☐ 件/ ☐ 米							
		刀具使用寿命 Tool life											
结论及建议 Conclution and advise													



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