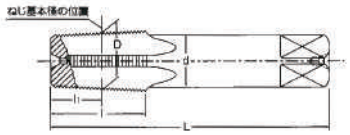
## ต๊าปเกลียวแป๊บเทเปอร์ (Taper Pipe Taps)

NACHI นาชิ

**List 6918** HSS



Unit : mm

| Thread Size | Number of Thread | D | L | l | d | l1 | Number of Flutes | ราคา |
|---|---|---|---|---|---|---|---|---|
| PT 1/8 | 28 | 9.728 | 55 | 19 | 8 | 13 | 4 | |
| 1/4 | 19 | 13.157 | 62 | 28 | 11 | 21 | 4 | |
| 3/8 | 19 | 16.662 | 65 | 28 | 14 | 21 | 4 | |
| 1/2 | 14 | 20.955 | 80 | 35 | 18 | 25 | 4 | |
| 3/4 | 14 | 26.441 | 85 | 35 | 23 | 25 | 4 | |
| 1 | 11 | 33.249 | 95 | 45 | 26 | 32 | 4 | |
| 1 1/4 | 11 | 41.910 | 105 | 45 | 32 | 32 | 6 | |
| 1 1/2 | 11 | 47.803 | 110 | 45 | 38 | 32 | 6 | |

B

## TECHNICAL INFORMATION : CUTTING TAPS

ข้อมูลทางด้านเทคนิค ของดอกต๊าปแบบ Cutting Taps

### Drill Hole Size For Taps

#### • Recommended Drill Hole Size of Cutting Taps

Unit : mm

| Thread Size | Drill Diameter | | Internal Thread Minor Dia.Min. | Internal Thread Minor Dia.Max. | | |
|---|---|---|---|---|---|---|
| | Standard Drill | Coated Drill | | 4H | 5H | 6H |
| M1.4 x 0.3 | 1.1 | 1.15 | 1.075 | 1.128 | 1.142 | 1.160 |
| M1.6 x 0.35 | 1.25 | 1.3 | 1.221 | 1.284 | 1.301 | 1.321 |
| M1.7 x 0.35 | 1.35 | 1.4 | 1.321 | 1.384 | 1.401 | 1.421 |
| M2 x 0.4 | 1.6 | 1.65 | 1.567 | 1.638 | 1.657 | 1.679 |
| M2.3 x 0.4 | 1.9 | 1.95 | 1.867 | 1.938 | 1.957 | 1.979 |
| M2.5 x 0.45 | 2.05 | 2.1 | 2.013 | 2.093 | 2.113 | 2.138 |
| M2.6 x 0.45 | 2.25 | 2.2 | 2.113 | 2.193 | 2.213 | 2.238 |
| M3 x 0.5 | 2.5 | 2.55 | 2.459 | 2.549 | 2.571 | 2.599 |
| M3.5 x 0.6 | 2.9 | 2.95 | 2.850 | 2.950 | 2.975 | 3.010 |
| M4 x 0.7 | 3.3 | 3.4 | 3.242 | 3.354 | 3.382 | 3.422 |
| M5 x 0.8 | 4.2 | 4.3 | 4.134 | 4.259 | 4.294 | 4.334 |
| M6 x 1 | 5 | 5.1 | 4.917 | 5.067 | 5.107 | 5.153 |
| M6 x 0.75 | 5.3 | 5.35 | 5.188 | 5.306 | 5.338 | 5.378 |
| M8 x 1.25 | 6.8 | 6.9 | 6.647 | 6.817 | 6.859 | 6.912 |
| M8 x 1 | 7 | 7.1 | 6.917 | 7.067 | 7.107 | 7.153 |
| M8 x 0.75 | 7.3 | 7.35 | 7.188 | 7.306 | 7.338 | 7.378 |
| M9 x 1.25 | 7.8 | 7.9 | 7.647 | 7.817 | 7.859 | 7.912 |
| M10 x 1.5 | 8.5 | 8.6 | 8.376 | 8.566 | 8.612 | 8.676 |
| M10 x 1.25 | 8.8 | 8.9 | 8.647 | 8.817 | 8.859 | 8.912 |
| M10 x 1 | 9 | 9.1 | 8.917 | 9.067 | 9.107 | 9.153 |
| M12 x 1.75 | 10.2 | 10.3 | 10.106 | 10.318 | 10.371 | 10.441 |
| M12 x 1.5 | 10.5 | 10.6 | 10.376 | 10.566 | 10.612 | 10.676 |

Unit : mm

| Thread Size | Drill Diameter | | Internal Thread Minor Dia.Min. | Internal Thread Minor Dia.Max. | | |
|---|---|---|---|---|---|---|
| | Standard Drill | Coated Drill | | 4H | 5H | 6H |
| M12 x 1.25 | 10.8 | 10.9 | 10.647 | 10.817 | 10.859 | 10.912 |
| M12 x 1 | 11 | 11.1 | 10.917 | 11.067 | 11.107 | 11.153 |
| M14 x 2 | 12 | 12.1 | 11.835 | 12.071 | 12.135 | 12.210 |
| M14 x 1.5 | 12.5 | 12.6 | 12.376 | 12.566 | 12.612 | 12.676 |
| M14 x 1.25 | 12.8 | 12.85 | 12.647 | 12.817 | 12.859 | 12.912 |
| M14 x 1 | 13 | 13.1 | 12.917 | 13.067 | 13.107 | 13.153 |
| M16 x 2 | 14 | 14.1 | 13.835 | 14.071 | 14.135 | 14.210 |
| M16 x 1.5 | 14.5 | 14.6 | 14.376 | 14.566 | 14.612 | 14.676 |
| M18 x 2.5 | 15.5 | 15.6 | 15.294 | 15.574 | 15.649 | 15.744 |
| M18 x 1.5 | 16.5 | 16.6 | 16.376 | 16.566 | 16.612 | 16.676 |
| M20 x 2.5 | 17.5 | 17.6 | 17.294 | 17.574 | 17.649 | 17.744 |
| M20 x 1.5 | 18.5 | 18.6 | 18.376 | 18.566 | 18.612 | 18.676 |
| M22 x 2.5 | 19.5 | 19.6 | 19.294 | 19.574 | 19.649 | 19.744 |
| M22 x 1.5 | 20.5 | 20.6 | 20.376 | 20.566 | 20.612 | 20.676 |
| M24 x 3 | 21 | 21.1 | 20.752 | 21.067 | 21.152 | 21.252 |
| M24 x 1.5 | 22.5 | 22.6 | 22.376 | 22.566 | 22.612 | 22.676 |
| M27 x 3 | 24 | 24.1 | 23.752 | 24.067 | 24.152 | 24.252 |
| M27 x 1.5 | 25.5 | 25.6 | 25.376 | 25.566 | 25.612 | 25.676 |
| M30 x 3.5 | 26.5 | 26.6 | 26.211 | 26.566 | 26.661 | 26.771 |
| M30 x 1.5 | 28.5 | 28.6 | 28.376 | 28.566 | 28.612 | 28.676 |
| M33 x 3.5 | 29.5 | 29.5 | 29.211 | 29.566 | 29.661 | 29.771 |
| M36 x 4 | 32 | 32 | 31.670 | 32.025 | 32.120 | 32.230 |

#### • Recommended Drill Hole Size of TAFLET

**Metric Coarse screw thread**

Unit : mm

| Thread Size | Pitch | Class | Hole Size (Thread Overlap Ratio) 70% ~ 100% |
|---|---|---|---|
| M1.4 | 0.30 | 4 | 1.28~1.23 |
| M1.7 | 0.35 | 4 | 1.56~1.50 |
| M2 | 0.40 | 4 | 1.84~1.77 |
| M2.3 | 0.40 | 4 | 2.14~2.07 |
| M2.5 | 0.45 | 4 | 2.32~2.24 |
| M2.6 | 0.45 | 4 | 2.42~2.34 |
| M3 | 0.50 | 5 | 2.80~2.72 |
| M3.5 | 0.60 | 5 | 3.26~3.16 |
| M4 | 0.70 | 6 | 3.72~3.60 |
| M5 | 0.80 | 6 | 4.68~4.55 |
| M6 | 1.00 | 7 | 5.60~5.43 |
| M8 | 1.25 | 7 | 7.50~7.29 |
| M10 | 1.50 | 7 | 9.40~9.15 |

**Metric Fine screw thread**

Unit : mm

| Thread Size | Pitch | Class | Hole Size (Thread Overlap Ratio) 70% ~ 100% |
|---|---|---|---|
| M4 | 0.50 | 6 | 3.80~3.72 |
| M5 | 0.50 | 6 | 4.80~4.72 |
| M6 | 0.75 | 7 | 5.70~5.57 |
| M6 | 0.50 | 7 | 5.80~5.72 |
| M8 | 1.00 | 7 | 7.60~7.43 |
| M10 | 1.25 | 7 | 9.50~9.29 |
| M10 | 1.00 | 7 | 9.60~9.43 |