



DOHRE 哆乐数控工具有限公司
Dohre Tools Co.,Ltd DOHRE CNC TOOL CO.,LTD

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PREMIUM

Screw Thread Cutting Tools



2017
Top Version

哆乐数控工具有限公司
DOHRE CNC TOOL CO.,LTD

Introduction

MEMO



DOHRE CNC TOOL CO.,LTD

DOHRE Tool Co.,Ltd is professional manufacturer and services provider of CNC cutting tools, mainly service for the users of cnc machines from different cities in the world, provide high quality、favourable price、short deliver cutting tools and full technology supports.

DOHRE Tool Co.,Ltd always advocates "integrity、pragmatism、innovation、efficiency" operation principle, introduced the latest German cnc 5 axis grinding machines、cnc 5 axis automatic detection equipments and advanced grinding technology. Till now, we have 20 imported grinding machines,adopted the top quality carbide rods from home and abroad, thus developed high-class、high efficiency、advanced manufacturing system,the good quality products we produced-cnc tungsten carbide end mills、forming cutting tools、cnc high accuracy tool holder、high precision collets,and full range cutting tools design program has been well received in lots of users. DOHRE will be confident to meet your needs with good quality products、competetive prices and fast services.

哆乐数控工具有限公司是CNC切削刀具专业制造销售商和技术服务商，主要面向全世界各工业城市的数控机床使用企业，提供高品质，高性价比，短交货期的切削工具和全方位的技术支持。

哆乐数控工具有限公司一直倡导诚信、务实、创新、高效率的经营理念，引进德国最先进的CNC五轴磨床设备和CNC五轴全自动测量设备，CNC螺纹磨床领先磨刀技术，公司现有进口磨床20台，采用国内外最优质的棒材，从而形成了优质、高效、先进的生产制造系统，所生产的高品质CNC钨钢铣刀、钨钢丝攻、非标丝攻、成型刀具、CNC高精度刀柄、高精度筒夹和全方位切削刀具设计方案，在国内外受到众多使用者的好评。带着最优质的产品，最有竞争力的价格和最快捷的服务，哆乐将以完全的自信来满足您的需求。



Production & Measuring 生产/检测

采用进口机器加工中心生产

- *More Stable, More Reliable*

品質穩定，堅實可靠

- *High Precision, High Efficiency*

高精度，高效率

- *Flexible To Produce Non-Standard Cutters*

非標制作，功能可變性強



Measuring Technology From Germany

We inspect our product by the measuring machine from Germany. With high definition(HD) CCD camera and unique image processing software, the instrument can examine various types of tools (especially is good at Ball nosed and Corner Radius Cutters) The accuracy can reach 0.001mm.

來自德國測量技術的魅力

采用德国制um级（精密螺纹刀具与测量设备）全方位立体测量刀具，是螺纹精度测量的一大利器。



Tungsten Screw Thread Cutters 钨钢丝锥

High speed

高速

高精

high precision

切削

Cutting

高精度产品切削最佳选择
是您工作新利器！新选择！

High precision products for your best choices.

To be your new weapon & new options.

Brand new Dohre Tungsten Taps

全新哆乐钨钢丝锥

With Unique & Geometric design for

独特刀具几何设计让您的

High Efficiency
高效率

High Precision
高精度

及

High Speed
高进给

Long Life
长寿命

可行！

DOHRE CONCEPT CONSIST OF:

- R&D of High-end thread cutters
- International standardization
- Cutters durable testing
- Technical assistance
- Warehouse management control
- R & D according to end user requirements

哆乐的理念包括

- 开发及生产高端的螺纹刀具
- 标准化
- 刀具寿命测试及相对性的评估
- 为客户提供技术培训或研讨会
- 仓库管理
- 不断地研发客户需求的刀具

大幅度降低刀具震动（抗震性好）
钨钢丝锥是普通HSS的10倍寿命，
效果是2-3倍，精度稳定性很强！

Drastically low vibration (good chattering resistance)

With strong stability and highly accuracy,

Working life is 10 times longer & efficiency is 2-3 times than ordinary HSS

PICTURE INDEX

CARBIDE THREAD MILLING CUTTER

硬質合金螺紋銑刀

CARBIDE THREAD MILLING CUTTER WITH SPIRAL FLUTE 硬質合金螺旋槽螺紋銑刀		C01
CARBIDE STRAIGHT GROOVE THREAD MILLING CUTTER 硬質合金直槽螺紋銑刀		C02

C1.1

THREAD FORMING TAP SERIES

擠壓絲錐

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UNIFIED THREADE 美制螺紋		C05
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SPIRAL FLUTED TAP SERIES

螺旋槽絲錐

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PICTURE INDEX

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C1.2

PICTURE INDEX

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C1.3

PICTURE INDEX

SOLID CARBIDE SPIRAL FLUTED TAP SERIES

硬質合金螺旋紋絲錐

LONG SHANK

長柄型



C43

CARBIDE PARALLEL PIPE THREAD TAP SERIES

硬質合金平行管螺紋絲錐

CARBIDE PARALLEL PIPE THREAD TAP WITH SPIRAL FLUTE

硬質合金螺旋紋平行管螺紋絲錐



C44

LONG SHANK CARBIDE PARALLEL PIPE THREAD TAP WITH SPIRAL FLUTE

硬質合金螺旋紋長柄平行管螺紋絲錐



C44

SOLID CARBIDE SPIRAL POINTED TAP SERIES

硬質合金刀傾角絲錐

SOLID CARBIDE SPIRAL POINTED TAP

硬質合金刀傾角絲錐



C45

LONG SHANK SOLID CARBIDE SPIRAL POINTED TAP

硬質合金長柄刀傾角絲錐



C46

GENERAL APPLICATION UNIFIED THREAD FORM

一般用美制螺紋刀傾角絲錐



C47

STRAIGHT FLUTED CARBIDE TAP SERIES

硬質合金直槽絲錐

METRIC COARSE THREAD

公制螺紋



C48

LONG SHANK

長柄型



C50

LONG SHANK TAPER PIPE THREAD TAP WITH STRAIGHT FLUTE

硬質合金長柄直槽管螺紋絲錐



C51

STRAIGHT FLUTED CARBIDE PARALLEL PIPE THREAD TAP

硬質合金直槽平行管螺紋



C51

LONG SHANK CARBIDE PARALLEL PIPE THREAD TAP STRAIGHT FLUTE

硬質合金長柄直槽平行管螺紋



C51

C1.4

THREAD MILLING CUTTER

螺紋銑刀

硬质合金螺旋槽螺紋銑刀
CARBIDE THREAD MILLING CUTTER WITH SPIRAL FLUTE



For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
用于铝合金、镁合金、铜合金的大量高精度加工，塑料变形无切屑，能实现稳定连续加工。

TYPE A



C01

Product code 產品編號	Specification 規格	External diameter 外徑	Pitch 螺距	Overall length (L) 全長(L)	Thread length (L1) 螺紋長度(L1)	Second section length (L2) 二節長度(L2)	Shank diameter (d) 柄徑(d)	Inventory 庫存
DLOT-PNGT730	M1.0	0.73	0.25	50	0.5	2.0	4	
DLOT-PNGT930	M1.2	0.93	0.25	50	0.5	2.0	4	
DLOT-PNGT108	M1.4	1.08	0.30	50	0.6	2.5	4	
DLOT-PNGT123	M1.6	1.23	0.35	50	0.7	3.0	4	
DLOT-PNGT158	M2.0	1.58	0.40	50	0.8	4.0	4	
DLOT-PNGT200	M2.5	2.0	0.45	50	0.9	5.0	4	
DLOT-PNGT245	M3.0	2.45	0.50	50	1.5	8.0	4	
DLOT-PNGT285	M3.5	2.85	0.60	50	1.8	10.0	4	
DLOT-PNGT320	M4.0	3.20	0.70	50	2.1	10.0	4	
DLOT-PNGT410	M5.0	4.10	0.80	50	2.4	12.0	6	
DLOT-PNGT451	M6.0	4.5	1.00	60	12.0	—	6	
DLOT-PNGT601	M8.0	6.0	1.00	70	16.0	—	6	
DLOT-PNGT602	M8.0	6.0	1.25	70	16.0	—	6	
DLOT-PNGT751	M8.0	7.5	1.50	70	20.0	—	6	
DLOT-PNGT901	M12	9.0	1.25	90	24.0	—	8	
DLOT-PNGT902			1.75			—		
DLOT-PNGT101	M14	10.0	1.00	90	25.0	35.0	10	
DLOT-PNGT102			1.50			35.0		
DLOT-PNGT103			2.00			—		
DLOT-PNGT121	M16	12.0	1.50	105	30.0	40.0	12	
DLOT-PNGT122			2.00			—		
DLOT-PNGT161	M20	16.0	1.50	125	40.0	50.0	16	
DLOT-PNGT162			2.50			—		
DLOT-PNGT201	M24	20.0	1.50	145	50.0	60.0	20	
DLOT-PNGT202			2.00			—		
DLOT-PNGT203			3.00			—		

Ordering code 訂購編號 Product code 產品編號 Selection of materials 材料選擇 Surface treatment 表面處理 TYPE 類型

For example: DLOT-PNGT730 - CPM - TiN - A

THREAD MILLING CUTTER

硬质合金直槽螺纹铣刀
CARBIDE STRAIGHT GROOVE THREAD MILLING CUTTER

螺纹铣刀



For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing.
用于铝合金、镁合金、铜合金的大量高精度加工，塑性变形无切屑，能实现稳定的连续加工。

C02

TYPE B



Product code 产品型号	Specification 规格	External diameter 外径	Pitch 螺距	Overall length (L) 全长 (mm)	Thread length (L1) 螺纹长度 (mm)	Second section length (L2) 二节段长度 (mm)	Shank diameter (d) 柄径 (mm)	Inventory 库存
DLLT-PNGT730	M1.0	0.73	0.25	50	0.5	2.0	4	
DLLT-PNGT930	M1.2	0.93	0.25	50	0.5	2.0	4	
DLLT-PNGT108	M1.4	1.08	0.30	50	0.6	2.5	4	
DLLT-PNGT123	M1.6	1.23	0.35	50	0.7	3.0	4	
DLLT-PNGT158	M2.0	1.58	0.40	50	0.8	4.0	4	
DLLT-PNGT200	M2.5	2.0	0.45	50	0.9	5.0	4	
DLLT-PNGT245	M3.0	2.45	0.50	50	1.5	8.0	4	
DLLT-PNGT285	M3.5	2.85	0.60	50	1.8	10.0	4	
DLLT-PNGT320	M4.0	3.20	0.70	50	2.1	10.0	4	
DLLT-PNGT410	M5.0	4.10	0.80	50	2.4	12.0	6	
DLLT-PNGT451	M6.0	4.5	1.00	60	12.0	—	6	
DLLT-PNGT601	M8.0	6.0	1.00	70	16.0	—	6	
DLLT-PNGT602	M8.0	6.0	1.25	70	16.0	—	6	
DLLT-PNGT751	M8.0	7.5	1.50	70	20.0	—	6	
DLLT-PNGT901	M12	9.0	1.25	90	24.0	—	8	
DLLT-PNGT902			1.75			—		
DLLT-PNGT101	M14	10.0	1.00	90	25.0	35.0	10	
DLLT-PNGT102			1.50			35.0		
DLLT-PNGT103			2.00			—		
DLLT-PNGT121	M16	12.0	1.50	105	30.0	40.0	12	
DLLT-PNGT122			2.00			—		
DLLT-PNGT161	M20	16.0	1.50	125	40.0	50.0	16	
DLLT-PNGT162			2.50			—		
DLLT-PNGT201	M24	20.0	1.50	145	50.0	60.0	20	
DLLT-PNGT202			2.00			—		
DLLT-PNGT203			3.00			—		

Ordering code (订购代码) → Product code (产品型号) → Selection of materials (材料选择) → Surface treatment (表面处理) → TYPE

For example: DLLT-PNGT203 - CPM - TiN - B

METRIC COARSE THREAD

挤压丝锥
THREAD FORMING TAP SERIES

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

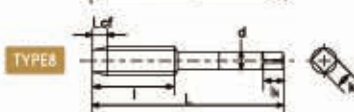
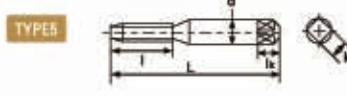
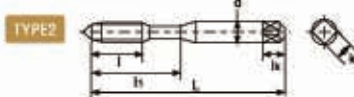
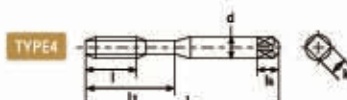
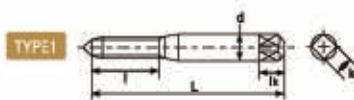
H

TiN

TiCN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing.



C03

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Exclusion cone length 排除锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长度(l)	Second section length (l) 第二段长度(l)	Shank diameter (d) 柄径(d)	TYPE 形式
DL1102534	M1	0.25	RH3	4P	30	5.5	-	3	1
DL1102532			RH3	2P					5
DL1102544			RH4	4P					1
DL1102542			RH4	2P					5
DL1122534	M1.2	0.25	RH3	4P	32	5.5	-	3	1
DL1122532			RH3	2P					5
DL1122544			RH4	4P					1
DL1122542			RH4	2P					5
DL1143044	M1.4	0.3	RH4	4P	34	6	-	3	1
DL1143042			RH4	2P					5
DL1143054			RH5	4P					1
DL1143052			RH5	2P					5
DL1163544	M1.6	0.35	RH4	4P	36	6	-	3	1
DL1163542			RH4	2P					5
DL1163554			RH5	4P					1
DL1163552			RH5	2P					5
DL1173544	M1.7	0.35	RH4	4P	36	6	-	3	1
DL1173542			RH4	2P					5
DL1173584			RH5	4P					1
DL1173552			RH5	2P					5
DL1173564			RH6	4P					1
DL1173562			RH6	2P					5
DL1183544	M1.8	0.35	RH4	4P	36	6	-	3	1
DL1183542			RH4	2P					5
DL1183554			RH5	4P					1
DL1183552			RH5	2P					5
DL1204044	M2	0.4	RH4	4P	40	9.5	-	3	1
DL1204042			RH4	2P					5
DL1204054			RH5	4P					1
DL1204052			RH5	2P					5
DL1204064			RH6	4P					1
DL1204062			RH6	2P					5
DL1234044	M2.3	0.4	RH4	4P	42	9.5	-	3	1
DL1234042			RH4	2P					5
DL1234054			RH5	4P					1
DL1234052			RH5	2P					5
DL1234064			RH6	4P					1
DL1234062			RH6	2P					5
DL1254544	M2.5	0.45	RH4	4P	44	9.5	-	3	1
DL1254542			RH4	2P					5
DL1254554			RH5	4P					1
DL1254552			RH5	2P					5
DL1254564			RH6	4P					1
DL1254562			RH6	2P					5

Ordering code: Product code Selection of materials Surface treatment TYPE
For example: DL1254562 - CPM - TiN - 1

METRIC COARSE THREAD

公制螺紋

C04

Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Exclusion cone length 排屑錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Second section length (l) 二節長(l)	Shank diameter (d) 柄徑(d)	TYPE 形狀
DL1264544	M2.6	0.45	RH4	4P	44	12	-	3	1
DL1264542			RH4	2P					5
DL1264554			RH5	4P					1
DL1264552			RH5	2P					5
DL1264564			RH6	4P					1
DL1264562			RH6	2P					5
DL1305054	M3	0.5	RH5	4P	46	9	12	4	2
DL1305052		0.5	RH5	2P					4
DL1356054	M3.5	0.6	RH5	4P	48	9	12	4	2
DL1356052		0.6	RH5	2P					4
DL1407064	M4	0.7	RH6	4P	52	10	14	5	2
DL1407062		0.7	RH6	2P					4
DL1508064	M5	0.8	RH6	4P	60	11	22	5.5	2
DL1508062		0.8	RH6	2P					4
DL1601074	M6	1	RH7	4P	62	12	24	6	2
DL1601072		1	RH7	2P					4
DL1701064	M7	1	RH6	4P	65	13	26	6.2	8
DL1701062		1	RH6	2P					8
DL18012574	M8	1.25	RH7	4P	70	18	-	6.2	8
DL18012572		1.25	RH7	2P					8
DL110015074	M10	1.5	RH7	4P	75	19	-	7	8
DL110015072		1.5	RH7	2P					8
DL112017584	M12	1.75	RH8	4P	82	23	-	8.5	8
DL112017582		1.75	RH8	2P					8

Ordering code 產品編號 Product code 產品編號 Selection of materials 材料選擇 Surface treatment 表面處理 TYPE 形狀

For example: DL1264544 - CPM - TIN - 1

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

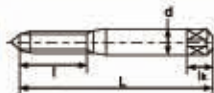
TiN

TiCN

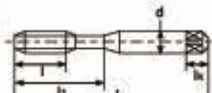
DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing.

TYPE1



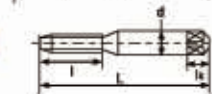
TYPE4



TYPE2



TYPE5



C05

Product code 产品编号	Specification 规格	Accuracy class 精度等级	Extrusion cone length 挤压锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (l) 第二段长度	Shank diameter (d) 柄部直径	TYPE 类型
DL2008034	No.0-80	RH3	4P	36	6	-	3	1
DL2008032		RH3	2P					5
DL2008044		RH4	4P					1
DL2008042		RH4	2P					5
DL2016434	No.1-64	RH3	4P	36	6	-	3	1
DL2016432		RH3	2P					5
DL2046444		RH4	4P					1
DL2016442		RH4	2P					5
DL2017234	No.1-72	RH3	4P	36	6	-	3	1
DL2017232		RH3	2P					5
DL2017244		RH4	4P					1
DL2017242		RH4	2P					5
DL2025644	No.2-56	RH4	4P	42	9.5	-	3	1
DL2025642		RH4	2P					5
DL2025654		RH5	4P					1
DL2025652		RH5	2P					5
DL2026444	No.2-64	RH4	4P	42	9.5	-	3	1
DL2026442		RH4	2P					5
DL2026454		RH5	4P					1
DL2026452		RH5	2P					5
DL2034844	No.3-48	RH4	4P	44	14	-	3	1
DL2034842		RH4	2P					5
DL2034884		RH5	4P					1
DL2034852		RH5	2P					5
DL2035644	No.3-56	RH4	4P	44	14	-	3	1
DL2035642		RH4	2P					5
DL2035654		RH5	4P					1
DL2035652		RH5	2P					5
DL2044054	No.4-40	RH5	4P	44	15	-	3	1
DL2044052		RH5	2P					5
DL2044064		RH6	4P					1
DL2044062		RH6	2P					5
DL2044854	No.4-48	RH5	4P	44	15	-	3	2
DL2044852		RH5	2P					4
DL2044864		RH6	4P					2
DL2044862		RH6	2P					4
DL2054054	No.5-40	RH5	4P	46	9	18	4	2
DL2054052		RH5	2P					4
DL2054064		RH6	4P					2
DL2054062		RH6	2P					4
DL2054454	No.5-44	RH5	4P	46	9	18	4	2
DL2054452		RH5	2P					4
DL2054464		RH6	4P					2
DL2054462		RH6	2P					4
DL2063254	No.6-32	RH5	4P	48	9	18	4	2
DL2063252		RH5	2P					4
DL2063264		RH6	4P					2
DL2063262		RH6	2P					4
DL2064054	No.6-40	RH5	4P	48	9	18	4	2
DL2064052		RH5	2P					4
DL2064064		RH6	4P					2
DL2064062		RH6	2P					4

Drawing type Product code Selection of materials Surface treatment TYPE

For example: DL2064062 - CPM - TiN - 1

UNIFIED THREAD

美制螺紋

Product code 產品編號	Specification 規格	Accuracy class 精度等級	Extrusion cone length 擠壓錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Second section length (l) 二節長(l')	Shank diameter (d) 柄徑(d)	TYPE 形式
DL2083254	No.8-32	RH5	4P	52	10	20	5	2
DL2083252		RH5	2P					4
DL2083264		RH6	4P					2
DL2083262		RH6	2P					4
DL2083654	No.8-36	RH5	4P	52	10	20	5	2
DL2083652		RH5	2P					4
DL2083664		RH6	4P					2
DL2083642		RH6	2P					4
DL2102474	No.10-24	RH7	4P	60	11	22	5.5	2
DL2102472		RH7	2P					4
DL2102484		RH8	4P					2
DL2102482		RH8	2P					4
DL2103264	No.10-32	RH6	4P	60	11	22	5.5	2
DL2103262		RH6	2P					4
DL2103274		RH7	4P					2
DL2103272		RH7	2P					4
DL2122464	No.12-24	RH6	4P	60	11	22	5.5	2
DL2122462		RH6	2P					4
DL2122474		RH7	4P					2
DL2122472		RH7	2P					4
DL2122874	No.12-28	RH7	4P	60	11	22	5.5	2
DL2122872		RH7	2P					4

Ordering code
訂購編號

Product code
產品編號

Selection of material
材料選擇

Surface treatment
表面處理

TYPE
形式

For example: DL2083254 - CPM - TIN - 2

METRIC FINE THREAD

挤压丝锥
THREAD FORMING TAP SERIES

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

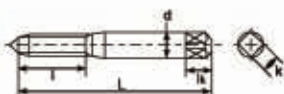
TICN

DLC

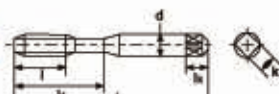
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝合金、镁合金、铜合金的大量高精度切削、塑性变形无屑加工，可实现稳定连续加工。

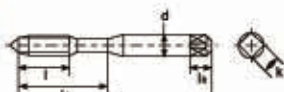
TYPE1



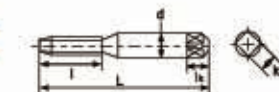
TYPE4



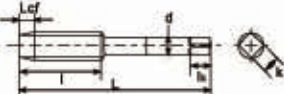
TYPE2



TYPE5



TYPE8



C07

Product code 产品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Exclusion cone length 排屑锥长度	Overall length (L) 全长 (mm)	Thread length (l) 螺纹长度 (mm)	Second section length (l) 第二段长度 (mm)	Shank diameter (d) 柄径 (mm)	TYPE 规格
DL3102034	M1	0.2	RH3	4P	32	5.5	-	3	1
DL3102032			RH3	2P					5
DL3122034	M1.2	0.2	RH3	4P	32	5.5	-	3	1
DL3122032			RH3	2P					5
DL3142034	M1.4	0.2	RH3	4P	34	6	-	3	1
DL3142032			RH3	2P					5
DL3162044	M1.6	0.2	RH4	4P	36	6	-	3	1
DL3162042			RH4	2P					5
DL3202544	M2	0.25	RH4	4P	40	9.5	-	3	1
DL3202542			RH4	2P					5
DL3253544	M2.5	0.35	RH4	4P	42	9.5	-	3	1
DL3253442			RH4	2P					5
DL3263544	M2.6	0.35	RH4	4P	44	9.5	-	3	1
DL3263542			RH4	2P					5
DL3303554	M3	0.35	RH5	4P	46	9	12	4	2
DL3303552			RH5	2P					4
DL3353564	M3.5	0.35	RH6	4P	46	9	12	4	2
DL3353562			RH6	2P					4
DL3408064	M4	0.5	RH6	4P	52	10	14	5	2
DL3405262			RH6	2P					4
DL3505064	M5	0.5	RH6	4P	60	11	22	5.5	2
DL3505062			RH6	2P					4
DL3607564	M6	0.75	RH6	4P	62	12	24	6	2
DL3607562			RH6	2P					4
DL3707564	M7	0.75	RH6	4P	65	13	26	6.2	8
DL3707562			RH6	2P					8
DL38010074	M8	1.0	RH7	4P	70	18	-	6.2	8
DL38010072			RH7	2P					8
DL39010074	M9	1.0	RH7	4P	72	19	-	7	8
DL39010072			RH7	2P					8
DL310012584	M10	1.25	RH8	4P	75	19	-	7	8
DL310012582			RH8	2P					8
DL311012584	M11	1.25	RH8	4P	80	23	-	8.0	8
DL311012582			RH8	2P					8
DL312012584	M12	1.25	RH8	4P	82	23	-	8.5	8
DL312012582			RH8	2P					8

Drawing code Product code Selection of materials Surface treatment TYPE

For example: DL3102034 - CPM - TIN - 1

LONG SHANK

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

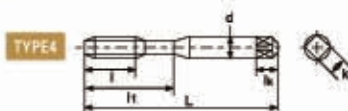
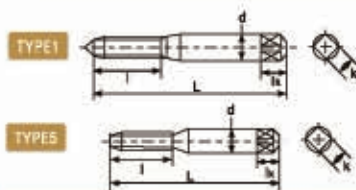
H

TiN

TiCN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing.



C08

Product code	Specification	Pitch	Accuracy class	Extrusion cone length	Overall length (L)	Thread length (l)	Second section length (l1)	Shank diameter (d)	TYPE
DL4102534	M1	0.25	RH3	4P	60	5.5	-	3	1 4 5
DL4102532	M1	0.25	RH3	2P	60	5.5	-	3	1 4 5
DL4122534	M1.2	0.25	RH3	4P	60	5.5	-	3	1 4 5
DL4122532	M1.2	0.25	RH3	2P	60	5.5	-	3	1 4 5
DL4143044	M1.4	0.3	RH4	4P	60	6	-	3	1 4 5
DL4143042	M1.4	0.3	RH4	2P	60	6	-	3	1 4 5
DL4163544	M1.6	0.35	RH4	4P	60	6	-	3	1 4 5
DL4163542	M1.6	0.35	RH4	2P	60	6	-	3	1 4 5
DL4173544	M1.7	0.35	RH4	4P	60	6	-	3	1 4 5
DL4173542	M1.7	0.35	RH4	2P	60	6	-	3	1 4 5
DL4204044	M2	0.4	RH4	4P	80	9.5	-	3	1 4 5
DL4204042	M2	0.4	RH4	2P	80	9.5	-	3	1 4 5
DL4234044	M2.3	0.4	RH4	4P	80	9.5	-	3	1 4 5
DL4234042	M2.3	0.4	RH4	2P	80	9.5	-	3	1 4 5
DL4254544	M2.5	0.45	RH4	4P	80	9.5	-	3	1 4 5
DL4254542	M2.5	0.45	RH4	2P	80	9.5	-	3	1 4 5
DL4264544	M2.6	0.45	RH4	4P	80	9.5	-	3	1 4 5
DL4264542	M2.6	0.45	RH4	2P	80	9.5	-	3	1 4 5
DL43050541	M3	0.5	RH5	4P	80	9	12	4	1 4 5
DL43050521	M3	0.5	RH5	2P	80	9	12	4	1 4 5
DL43050542	M3	0.5	RH5	4P	120	9	12	4	1 4 5
DL43050522	M3	0.5	RH5	2P	120	9	12	4	1 4 5
DL43560441	M3.5	0.6	RH4	4P	80	9	12	4	1 4 5
DL43560421	M3.5	0.6	RH4	2P	80	9	12	4	1 4 5
DL43560442	M3.5	0.6	RH4	4P	120	9	12	4	1 4 5
DL43560422	M3.5	0.6	RH4	2P	120	9	12	4	1 4 5
DL44070641	M4	0.7	RH6	4P	80	10	14	5	1 4 5
DL44070621	M4	0.7	RH6	2P	80	10	14	5	1 4 5
DL44070642	M4	0.7	RH6	4P	120	10	14	5	1 4 5
DL44070622	M4	0.7	RH6	2P	120	10	14	5	1 4 5
DL45080641	M5	0.8	RH6	4P	100	11	22	5.5	1 4 5
DL45080621	M5	0.8	RH6	2P	100	11	22	5.5	1 4 5
DL45080642	M5	0.8	RH6	4P	120	11	22	5.5	1 4 5
DL45080622	M5	0.8	RH6	2P	120	11	22	5.5	1 4 5
DL460100741	M6	1	RH7	4P	100	12	24	6	1 4 5
DL460100721	M6	1	RH7	2P	100	12	24	6	1 4 5
DL460100742	M6	1	RH7	4P	150	12	24	6	1 4 5
DL460100722	M6	1	RH7	2P	150	12	24	6	1 4 5
DL480125741	M8	1.25	RH7	4P	100	18	-	6.2	1 4 5
DL480125721	M8	1.25	RH7	2P	100	18	-	6.2	1 4 5
DL480125742	M8	1.25	RH7	4P	150	18	-	6.2	1 4 5
DL480125722	M8	1.25	RH7	2P	150	18	-	6.2	1 4 5
DL480100741	M8	1	RH7	4P	100	18	-	6.2	1 4 5
DL480100721	M8	1	RH7	2P	100	18	-	6.2	1 4 5
DL480100742	M8	1	RH7	4P	150	18	-	6.2	1 4 5
DL480100722	M8	1	RH7	2P	150	18	-	6.2	1 4 5
DL4100150741	M10	1.5	RH7	4P	100	19	-	7	1 4 5
DL4100150721	M10	1.5	RH7	2P	100	19	-	7	1 4 5
DL4100150742	M10	1.5	RH7	4P	150	19	-	7	1 4 5
DL4122150722	M10	1.5	RH7	2P	150	19	-	7	1 4 5

Drawing code: Product code: Selection of materials: Surface treatment: TYPE:
For example: DL4102534 - CPM - TiN - 4

Product code 产品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Extrusion cone length 挤压锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (l') 二段长(l')	Shank diameter (d) 柄径(d)	TYPE 形状
DL4100125741	M10	1.25	RH7	4P	100	19	—	7	4
DL4100125721			RH7	2P					4
DL4100125742			RH7	4P	150				4
DL4100125722			RH7	2P					4
DL4100100741	M10	1	RH7	4P	100	19	—	7	4
DL4100100721			RH7	2P					4
DL4100100742			RH7	4P	150				4
DL4100100722			RH7	2P					4
DL4120175841	M12	1.75	RH8	4P	150	23	—	8.5	4
DL4120175821			RH8	2P					4
DL4120175842			RH8	4P	200				4
DL4120175822			RH8	2P					4
DL4120150741	M12	1.5	RH7	4P	150	23	—	8.5	4
DL4120150721			RH7	2P					4
DL4120150742			RH7	4P	200				4
DL4120150722			RH7	2P					4
DL4120125741	M12	1.25	RH7	4P	150	23	—	8.5	4
DL4120175721			RH7	2P					4
DL4120125742			RH7	4P	200				4
DL4120125722			RH7	2P					4
DL4120100741	M12	1	RH7	4P	150	23	—	8.5	4
DL4120100721			RH7	2P					4
DL4120100742			RH7	4P	200				4
DL4120100722			RH7	2P					4



Drawing type: C09
 Product code: DL4100415741-
 Selection of material: CPM
 Surface treatment: TIN
 TYPE: 4

SHORT THREAD

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

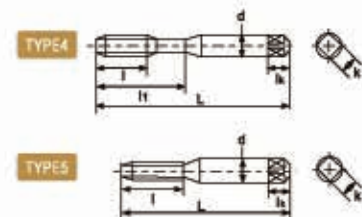
H

TiN

TiCN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing



C10

Product code	Specification	Pitch	Accuracy class	Bit outer length	Overall length (L)	Thread length (L1)	Second thread length (L2)	Shank diameter (d)	Four corners (R)	Four corners (R1)	Convex number	TYPE
DL5102542	M1	0.25	RH4	2P	32	3.5	-	3	2.5	5	4	5
DL5102552			RH5	2P								5
DL5122542	M1.2	0.25	RH4	2P	32	3.5	-	3	2.5	5	4	5
DL5122552			RH5	2P								5
DL5143042	M1.4	0.3	RH4	2P	34	4.5	-	3	2.5	5	4	5
DL5143052			RH5	2P								5
DL5163542	M1.6	0.35	RH4	2P	36	5	-	3	2.5	5	4	5
DL5163552			RH5	2P								5
DL5173542	M1.7	0.35	RH4	2P	36	5	-	3	2.5	5	4	5
DL5173552			RH5	2P								5
DL5173562			RH6	2P								5
DL5183542	M1.8	0.35	RH4	2P	36	5	-	3	2.5	5	4	5
DL5183552			RH5	2P								5
DL5204042	M2	0.4	RH4	2P	40	8	-	3	2.5	5	4	5
DL5204052			RH5	2P								5
DL5204062			RH6	2P								5
DL5224542	M2.2	0.45	RH4	2P	40	9	-	3	2.5	5	4	5
DL5224552			RH5	2P								5
DL5234042	M2.3	0.4	RH4	2P	42	9	-	3	2.5	5	4	5
DL5234052			RH5	2P								5
DL5234062			RH6	2P								5
DL5254542	M2.5	0.45	RH4	2P	42	9.5	-	3	2.5	5	4	5
DL5254552			RH5	2P								5
DL5254562			RH6	2P								5
DL5264542	M2.6	0.45	RH4	2P	44	9.5	-	3	2.5	5	4	5
DL5264552			RH5	2P								5
DL5305042	M3.0	0.5	RH4	2P	46	9	12	4	3.2	6	4	4
DL5305052			RH5	2P								4
DL5305062			RH6	2P								4
DL5356042	M3.5	0.6	RH4	2P	46	9	12	4	3.2	6	4	4
DL5356052			RH5	2P								4
DL5356062			RH6	2P								4
DL5407052	M4.0	0.7	RH5	2P	52	10	14	5	4	7	4	4
DL5407062			RH6	2P								4
DL5407072			RH7	2P								4
DL5407082			RH8	2P								4

Ordering code: Product code Selection of materials Surface treatment TYPE
For example: DL5102542 - CPM - TiN - 5

SHORT CHAMFER

挤压丝锥
THREAD FORMING TAP SERIES

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

TiN

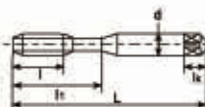
TiCN

DLC

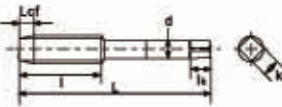
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

适用于铝合金、镁合金、铜合金的大量高精度加工，塑性变形无屑，可实现稳定的连续加工。

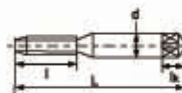
TYPE4



TYPE8



TYPE5



C11

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Extension cone length 加长锥体长度	Overall length (L) 总长度	Thread length (L) 螺纹长度	Second section length (L) 第二段长度	Shank diameter (d) 柄部直径	TYPE 类型
DL6102541	M1	0.25	RH4	1P	32	5.5	-	3	5
DL6102551			RH5	1P					5
DL6122541	M1.2	0.25	RH4	1P	32	5.5	-	3	5
DL6122551			RH5	1P					5
DL6143041	M1.4	0.3	RH4	1P	34	6	-	3	5
DL6143051			RH5	1P					5
DL6163541	M1.6	0.35	RH4	1P	36	6	-	3	5
DL6163551			RH5	1P					5
DL6173541	M1.7	0.35	RH4	1P	36	6	-	3	5
DL6173551			RH5	1P					5
DL6173561			RH6	1P					5
DL6183541	M1.8	0.35	RH4	1P	36	6	-	3	5
DL6183551			RH5	1P					5
DL6204041	M2	0.4	RH4	1P	40	8	-	3	5
DL6204051			RH5	1P					5
DL6204061			RH6	1P					5
DL6224541	M2.2	0.45	RH4	1P	40	9.5	-	3	5
DL6224551			RH5	1P					5
DL6234041	M2.3	0.4	RH4	1P	42	9.5	-	3	5
DL6234051			RH5	1P					5
DL6234061			RH6	1P					5
DL6254541	M2.5	0.45	RH4	1P	42	9.5	-	3	5
DL6254551			RH5	1P					5
DL6254561			RH6	1P					5
DL6264541	M2.6	0.45	RH4	1P	44	9.5	-	3	5
DL6264551			RH5	1P					5
DL6305041	M3.0	0.5	RH4	1P	46	9	12	4	4
DL6305051			RH5	1P					4
DL6305061			RH6	1P					4
DL6356041	M3.5	0.6	RH4	1P	46	9	12	4	4
DL6356051			RH5	1P					4
DL6356061			RH6	1P					4
DL6407051	M4.0	0.7	RH5	1P	52	10	14	5	4
DL6407061			RH6	1P					4
DL6407071			RH7	1P					4
DL6407081			RH8	1P					4
DL6508061	M5.0	0.8	RH6	1P	60	11	22	5.5	4
DL65010071	M6.0	1.0	RH7	1P	62	12	24	6	4
DL68012571	M8.0	1.25	RH7	1P	70	18	-	6.2	8
DL610015071	M10.0	1.5	RH7	1P	75	19	-	7	8
DL612017581	M12.0	1.75	RH8	1P	82	23	-	8.5	8

Drilling rate 钻头速度 Product code 商品编号 Selection of materials 材料选择 Surface treatment 表面处理 TYPE 类型

For example: DL6102541 - CPM - TiN - 5

LONG CHAMFER

超长倒角

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

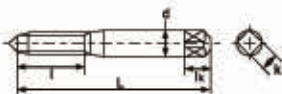
TICN

DLC

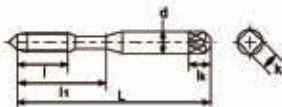
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝、镁、铜合金的大量高精度加工，可实现无屑塑性变形，可稳定连续加工。

TYPE1



TYPE2



Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Exclusion cone length 排除锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (l) 第二段长度	Shank diameter (d) 柄径	TYPE 类型
DL7102546	M1	0.25	RH4	6P	32	5.5	-	3	1
DL7102556			RH5	6P					1
DL7122546	M1.2	0.25	RH4	6P	32	5.5	-	3	1
DL7122556			RH5	6P					1
DL7143046	M1.4	0.3	RH4	6P	34	6	-	3	1
DL7143056			RH5	6P					1
DL7163546	M1.6	0.35	RH4	6P	36	6	-	3	1
DL7163556			RH5	6P					1
DL7173546	M1.7	0.35	RH4	6P	36	6	-	3	1
DL7173556			RH5	6P					1
DL7173566			RH6	6P					1
DL7183546	M1.8	0.35	RH4	6P	36	6	-	3	1
DL7183556			RH5	6P					1
DL7204046	M2	0.4	RH4	6P	40	8	-	3	1
DL7204056			RH5	6P					1
DL7204066			RH6	6P					1
DL7224546	M2.2	0.45	RH4	6P	40	9.5	-	3	1
DL7224556			RH5	6P					1
DL7234046	M2.3	0.4	RH4	6P	42	9.5	-	3	1
DL7234056			RH5	6P					1
DL7234066			RH6	6P					1
DL7254546	M2.5	0.45	RH4	6P	42	9.5	-	3	1
DL7254556			RH5	6P					1
DL7254566			RH6	6P					1
DL7264546	M2.6	0.45	RH4	6P	44	9.5	-	3	1
DL7264556			RH5	6P					1
DL7305046	M3.0	0.5	RH4	6P	46	9	12	4	2
DL7305056			RH5	6P					2
DL7305066			RH6	6P					2
DL7356046	M3.5	0.6	RH4	6P	46	9	12	4	2
DL7356056			RH5	6P					2
DL7356066			RH6	6P					2
DL7407056	M4.0	0.7	RH5	6P	52	10	14	5	2
DL7407066			RH6	6P					2
DL7407076			RH7	6P					2
DL7407086			RH8	6P					2
DL7508066	M5.0	0.8	RH6	6P	60	11	22	5.5	2
DL76010076	M6.0	1.0	RH7	6P	62	12	24	6	2
DL78012576	M8.0	1.25	RH7	6P	70	18	-	6.2	2
DL710015076	M10.0	1.5	RH7	6P	75	19	-	7	2
DL712017586	M12.0	1.75	RH8	6P	82	23	-	8.5	2

Ordering code Product code Selection of materials Surface treatment TYPE

For example: DL7102546 - CPM - TIN - 1

METRIC COARSE THREAD

螺旋丝攻
SPIRAL FLUTED TAP SERIES

Selection of materials

HSSEX

H56V

CPM

Surface treatment

N

H

TiN

TiCN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

高精度、高刚性、高耐磨性、高寿命、高可靠性。

TYPE1



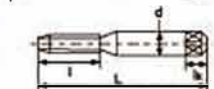
TYPE4



TYPE2



TYPE5



C13

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting core length 切削芯长	Overall length (L) 总长(L)	Thread length (l) 螺纹长(l)	Second section length (l1) 二段长(l1)	Shank diameter (d) 柄径(d)	TYPE 类型
DLSFT101	M1	0.25	P1	2.5P	30	5.5	-	3	1 5
DLSFT111	M1.1		P1	2.5P	32	5.5	-	3	1 5
DLSFT122	M1.2		P2	2.5P	32	5.5	-	3	1 5
DLSFT142	M1.4	0.3	P2	2.5P	34	7	-	3	1 5
DLSFT162	M1.6	0.35	P2	2.5P	36	8	-	3	1 5
DLSFT171	M1.7		P1	2.5P					1 5
DLSFT172	M1.7		P2	2.5P					1 5
DLSFT182	M1.8		P2	2.5P					1 5
DLSFT201	M2	0.4	P1	2.5P	40	12	-	3	1 2 4 5
DLSFT202			P2	2.5P					1 2 4 5
DLSFT203			P3	2.5P					1 2 4 5
DLSFT222	M2.2	0.45	P1	2.5P	42	13	-	3	1 2 4 5
DLSFT231	M2.3	0.4	P1	2.5P					1 2 4 5
DLSFT232			P2	2.5P					1 2 4 5
DLSFT233			P3	2.5P					1 2 4 5
DLSFT251	M2.5	0.45	P1	2.5P	44	14	-	3	1 2 4 5
DLSFT252			P2	2.5P					1 2 4 5
DLSFT253			P3	2.5P					1 2 4 5
DLSFT261	M2.6	0.45	P1	2.5P	44	14	-	3	1 2 4 5
DLSFT262			P2	2.5P					1 2 4 5
DLSFT263			P3	2.5P					1 2 4 5
DLSFT264			P4	2.5P					1 2 4 5
DLSFT302	M3	0.5	P2	2.5P	46	11	19	4	1 2 4 5
DLSFT303			P3	2.5P					1 2 4 5
DLSFT304			P4	2.5P					1 2 4 5
DLSFT351	M3.5	0.8	P1	2.5P	48	13	20	4	1 2 4 5
DLSFT352			P2	2.5P					1 2 4 5
DLSFT402	M4	0.7	P2	2.5P	52	13	21	5	1 2 4 5
DLSFT403			P3	2.5P					1 2 4 5
DLSFT404			P4	2.5P					1 2 4 5
DLSFT502	M5	0.8	P2	2.5P	60	16	24	5.5	1 2 4 5
DLSFT503			P3	2.5P					1 2 4 5
DLSFT504			P4	2.5P					1 2 4 5
DLSFT602	M6	1	P2	2.5P	62	19	29	6	1 2 4 5
DLSFT603			P3	2.5P					1 2 4 5
DLSFT604			P4	2.5P					1 2 4 5
DLSFT702	M7	1	P2	2.5P	65	22	33	6.2	1 2 4 5
DLSFT703		0.5	P2	2.5P					1 2 4 5
DLSFT802	M8	1.25	P2	2.5P	70	22	37	6.2	1 2 4 5
DLSFT803			P3	2.5P					1 2 4 5
DLSFT804			P4	2.5P					1 2 4 5
DLSFT902	M9	1.25	P2	2.5P	72	22	38	7	1 2 4 5
DLSFT1002	M10	1.5	P2	2.5P	75	24	41	7	1 2 4 5
DLSFT1003			P3	2.5P					1 2 4 5
DLSFT1004			P4	2.5P					1 2 4 5
DLSFT1102	M11	1.5	P2	2.5P	80	25	48	8	1 2 4 5
DLSFT1202	M12	1.75	P2	2.5P	82	29	48	8.5	1 2 4 5
DLSFT1203			P3	2.5P					1 2 4 5
DLSFT1204			P4	2.5P					1 2 4 5

Material: HSSEX H56V CPM Surface treatment: N H TiN TiCN DLC

For example: DLSFT101 - CPM - TiN - 1

LEFT HAND

左旋钻头

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

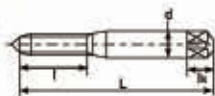
TiN

TiCN

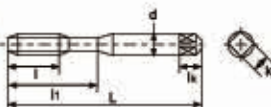
DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
对于铝合金、镁合金、铜合金大量高精度加工，塑性变形无屑，可稳定连续加工

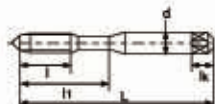
TYPE1



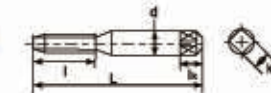
TYPE4



TYPE2



TYPE5



Product code 产品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (l) 第二段长度	Shank diameter (d) 柄径	TYPE 规格		
DLLH-SFT101	M1	0.25	P1	2.5P	32	5.5	—	3	1	5	
DLLH-SFT111	M1.1	0.25	P1	2.5P	32	5.5	—	3	1	5	
DLLH-SFT121	M1.2	0.25	P1	2.5P	32	5.5	—	3	1	5	
DLLH-SFT141	M1.4	0.3	P1	2.5P	34	7	—	3	1	5	
DLLH-SFT161	M1.6	0.35	P1	2.5P	36	8	—	3	1	5	
DLLH-SFT172	M1.7	0.35	P2	2.5P	36	8	—	3	1	5	
DLLH-SFT182	M1.8	0.35	P2	2.5P	36	8	—	3	1	5	
DLLH-SFT202	M2	0.4	P2	2.5P	42	9.5	15	3	1	2	5
DLLH-SFT203			P3	2.5P					1	2	5
DLLH-SFT222	M2.2	0.45	P2	2.5P	44	9.5	16	3	1	2	4 5
DLLH-SFT232	M2.3	0.4	P2	2.5P					1	2	4 5
DLLH-SFT252	M2.5	0.45	P2	2.5P	44	9.5	16	3	1	2	4 5
DLLH-SFT253			P3	2.5P					1	2	4 5
DLLH-SFT262	M2.6	0.45	P2	2.5P	44	9.5	16	3	1	2	4 5
DLLH-SFT263			P3	2.5P					1	2	4 5
DLLH-SFT302	M3	0.5	P2	2.5P	46	11	18	4	1	2	4 5
DLLH-SFT303			P3	2.5P					1	2	4 5
DLLH-SFT352	M3.5	0.6	P2	2.5P	48	13	20	4	1	2	4 5
DLLH-SFT353			P3	2.5P					1	2	4 5
DLLH-SFT402	M4	0.7	P2	2.5P	52	13	20	5	1	2	4 5
DLLH-SFT403			P3	2.5P					1	2	4 5
DLLH-SFT502	M5	0.8	P2	2.5P	60	16	24	5.5	1	2	4 5
DLLH-SFT602	M6	1	P2	2.5P	62	19	29	6	1	2	4 5
DLLH-SFT802	M8	1.25	P3	2.5P	70	22	37	6.2	1	2	4 5
DLLH-SFT1003	M10	1.5	P3	2.5P	75	24	41	7	1	2	4 5
DLLH-SFT1203	M12	1.75	P3	2.5P	82	29	48	8.5	1	2	4 5

Ordering rule: Product code Selection of materials Surface treatment TYPE

For example: DLLH-SFT101- CPM - TiN - 1

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

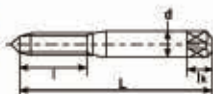
TIN

TICN

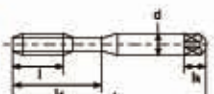
DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
铝合金、镁合金、铜合金大量高精度加工，塑性变形无屑，可稳定连续加工。

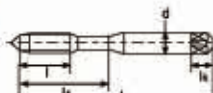
TYPE1



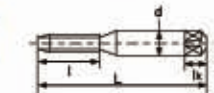
TYPE4



TYPE2



TYPE5



C15

Product code 产品规格	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长(L)	Thread length (l) 螺纹长度(l)	Second cone length (l) 二锥长度(l)	Shank diameter (d) 柄部直径(d)	TYPE 形式	
DLSFTT101	M1	0.2	P1	2.5P	32	5	-	3	1	5
DLSFTT111	M1.1	0.2	P1	2.5P	32	5	-	3	1	5
DLSFTT121	M1.2	0.2	P1	2.5P	32	5	-	3	1	5
DLSFTT141	M1.4	0.2	P1	2.5P	34	5	-	3	1	5
DLSFTT162	M1.6	0.2	P2	2.5P	36	6	-	3	1	5
DLSFTT172	M1.7	0.2	P2	2.5P	36	6	-	3	1	5
DLSFTT182	M1.8	0.2	P2	2.5P	36	6	-	3	1	5
DLSFTT202	M2	0.25	P2	2.5P	42	7	15	3	1	2 4 5
DLSFTT222	M2.2	0.25	P2	2.5P	42	7	15	3	1	2 4 5
DLSFTT232	M2.3	0.25	P2	2.5P	42	7	15	3	1	2 4 5
DLSFTT252	M2.5	0.35	P2	2.5P	44	8	16	3	1	2 4 5
DLSFTT262	M2.6	0.35	P2	2.5P	44	8	16	3	1	2 4 5
DLSFTT302	M3	0.35	P2	2.5P	46	9.5	18	4	1	2 4 5
DLSFTT352	M3.5	0.35	P2	2.5P	48	9.5	20	4	1	2 4 5
DLSFTT402	M4	0.5	P2	2.5P	52	9.5	20	5	1	2 4 5
DLSFTT503	M5	0.5	P2	2.5P	60	11	22	5.5	1	2 4 5
DLSFTT602	M6	0.75	P2	2.5P	62	12	24	6	1	2 4 5
DLSFTT702	M7	0.75	P2	2.5P	65	13	26	6.2	1	2 4 5
DLSFTT803	M8	1.0	P3	2.5P	70	18	-	6.2	1	2 4 5
DLSFTT903	M9	1.0	P3	2.5P	72	19	-	7	1	2 4 5
DLSFTT1003	M10	1.25	P3	2.5P	75	19	-	7	1	2 4 5
DLSFTT1113	M11	1.25	P3	2.5P	80	23	-	8	1	2 4 5
DLSFTT1203	M12	1.25	P3	2.5P	82	23	-	8.5	1	2 4 5

Ordering rule: Product code Selection of materials Surface treatment TYPE

For example: DLSFTT101 + CPM + TIN + 1

UNIFIED THREAD

统一螺纹

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

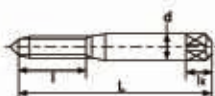
TICN

DLC

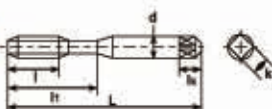
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

对于铝、镁、铜合金大量高精度加工，无屑塑性变形，可稳定连续加工。

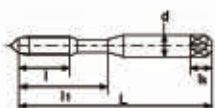
TYPE1



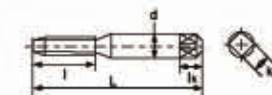
TYPE4



TYPE2



TYPE5



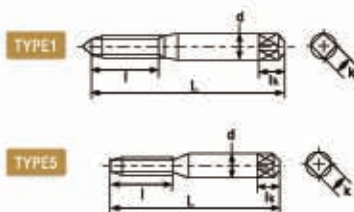
C16

Product code 商品编号	Specification 规格	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长度(l)	Second section length (l1) 第二段长度(l1)	Shank diameter (d) 柄部直径(d)	TYPE 类型	
DLSFTU801	No.0-80	P1	2.5P	36	8	-	3	1	5
DLSFTU641	No.1-64	P1	2.5P					1	5
DLSFTU721	No.1-72	P1	2.5P					1	5
DLSFTU561	No.2-56	P1	2.5P	42	9.5	15	3	1 2 4 5	
DLSFTU642	No.2-64	P1	2.5P					1 2 4 5	
DLSFTU481	No.3-48	P1	2.5P	44	9.5	16	3	1 2 4 5	
DLSFTU562	No.3-56	P1	2.5P					1 2 4 5	
DLSFTU401	No.4-40	P1	2.5P	44	9.5	16	3	1 2 4 5	
DLSFTU402		P2	2.5P					1 2 4 5	
DLSFTU482	No.4-48	P1	2.5P					1 2 4 5	
DLSFTU483		P2	2.5P					1 2 4 5	
DLSFTU403	No.5-40	P1	2.5P	46	11	18	4	1 2 4 5	
DLSFTU404		P2	2.5P					1 2 4 5	
DLSFTU441	No.5-44	P1	2.5P					1 2 4 5	
DLSFTU442		P2	2.5P					1 2 4 5	
DLSFTU322	No.6-32	P2	2.5P	48	13	20	4	1 2 4 5	
DLSFTU323		P3	2.5P					1 2 4 5	
DLSFTU405	No.6-40	P2	2.5P					1 2 4 5	
DLSFTU406		P3	2.5P					1 2 4 5	
DLSFTU324	No.8-32	P2	2.5P	52	13	21	5	1 2 4 5	
DLSFTU362	No.8-36	P2	2.5P					1 2 4 5	
DLSFTU242	No.10-24	P2	2.5P	60	16	24	5.5	1 2 4 5	
DLSFTU325	No.10-32	P2	2.5P					1 2 4 5	
DLSFTU243	No.12-24	P2	2.5P	60	17	25	5.5	1 2 4 5	
DLSFTU282	No.12-28	P2	2.5P					1 2 4 5	

Ordering code: Product code Selection of materials Surface treatment TYPE
For example: DLSFTU801 - CPM - TIN - 1



For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing



C17

Product code 型号规格	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度 (mm)	Thread length (l) 螺纹长度 (mm)	Second section length (l) 二节长度 (mm)	Shank diameter (d) 柄径 (mm)	TYPE 规格
DLLS-SFT101	M1	0.25	P1	2.5P	70	5.5	—	3	1 5
DLLS-SFT121	M1.2	0.25	P1	2.5P	70	5.5	—	3	1 5
DLLS-SFT141	M1.4	0.3	P1	2.5P	80	7	—	3	1 5
DLLS-SFT161	M1.6	0.35	P1	2.5P	80	8	—	3	1 5
DLLS-SFT171	M1.7	0.35	P1	2.5P	80	8	—	3	1 5
DLLS-SFT181	M1.8	0.35	P1	2.5P	80	8	—	3	1 5
DLLS-SFT203	M2	0.4	P2	2.5P	80	9.5	15	3	1 5
DLLS-SFT204			P2	2.5P	100				1 5
DLLS-SFT233	M2.3	0.4	P2	2.5P	80	9.5	15	3	1 5
DLLS-SFT234			P2	2.5P	100				1 5
DLLS-SFT254	M2.5	0.45	P2	2.5P	80	9.5	16	3	1 5
DLLS-SFT255			P2	2.5P	100				1 5
DLLS-SFT256			P2	2.5P	120				1 5
DLLS-SFT264	M2.6	0.45	P2	2.5P	80	9.5	16	3	1 5
DLLS-SFT265			P2	2.5P	100				1 5
DLLS-SFT266			P2	2.5P	120				1 5
DLLS-SFT304	M3	0.5	P2	2.5P	80	11	18	4	1 5
DLLS-SFT305			P2	2.5P	100				1 5
DLLS-SFT306			P2	2.5P	120				1 5
DLLS-SFT354	M3.5	0.6	P2	2.5P	80	13	20	4	1 5
DLLS-SFT355			P2	2.5P	100				1 5
DLLS-SFT356			P2	2.5P	120				1 5
DLLS-SFT401	M4	0.7	P2	2.5P	80	13	20	5	1 5
DLLS-SFT402			P2	2.5P	100				1 5
DLLS-SFT403			P2	2.5P	120				1 5
DLLS-SFT501	M5	0.8	P2	2.5P	100	16	24	5.5	1 5
DLLS-SFT502			P2	2.5P	120				1 5
DLLS-SFT601	M6	1	P2	2.5P	100	19	29	6	1 5
DLLS-SFT602			P2	2.5P	120				1 5
DLLS-SFT603			P2	2.5P	150				1 5
DLLS-SFT801	M8	1.25	P2	2.5P	100	22	37	6.2	1 5
DLLS-SFT802			P2	2.5P	120				1 5
DLLS-SFT803			P2	2.5P	150				1 5
DLLS-SFT804		1	P2	2.5P	100				1 5
DLLS-SFT805			P2	2.5P	120				1 5
DLLS-SFT806			P2	2.5P	150				1 5
DLLS-SFT1001	M10	1.5	P2	2.5P	100	24	41	7	1 5
DLLS-SFT1002			P2	2.5P	120				1 5
DLLS-SFT1003			P2	2.5P	150				1 5
DLLS-SFT1004			P2	2.5P	200				1 5
DLLS-SFT1005	M10	1.25	P2	2.5P	100	24	41	7	1 5
DLLS-SFT1006			P2	2.5P	120				1 5
DLLS-SFT1007			P2	2.5P	150				1 5
DLLS-SFT1008			P2	2.5P	200				1 5
DLLS-SFT1009	M10	1	P2	2.5P	100	24	41	7	1 5
DLLS-SFT1010			P2	2.5P	120				1 5
DLLS-SFT1011			P2	2.5P	150				1 5

Ordering rule → Product code → Selection of materials → Surface treatment → TYPE

For example: DLLS-SFT101 - CPM - TiN - 1

LONG SHANK

长柄型

C18

Product code 商品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Second section length (l) 二節長 (l)	Shank diameter (d) 柄徑(d)	TYPE 形狀	
DLLS-SFT1201	M12	1.75	P1	2.5P	100	29	48	8.5	1	5
DLLS-SFT1202			P1	2.5P	120				1	5
DLLS-SFT1203			P1	2.5P	150				1	5
DLLS-SFT1204			P1	2.5P	200				1	5
DLLS-SFT1205	M12	1.5	P1	2.5P	100	29	48	8.5	1	5
DLLS-SFT1206			P1	2.5P	120				1	5
DLLS-SFT1207			P2	2.5P	150				1	5
DLLS-SFT1208			P2	2.5P	200				1	5
DLLS-SFT1209	M12	1.25	P2	2.5P	100	29	48	8.5	1	5
DLLS-SFT1210			P2	2.5P	120				1	5
DLLS-SFT1211			P2	2.5P	150				1	5
DLLS-SFT1212			P2	2.5P	200				1	5
DLLS-SFT1213	M12	1	P2	2.5P	100	29	48	8.5	1	5
DLLS-SFT1214			P2	2.5P	120				1	5
DLLS-SFT1215			P2	2.5P	150				1	5

Ordering rule
訂購規則

Product code
產品編號

Selection of materials
材料選擇

Surface treatment
表面處理

TYPE
形狀

For example: DLLS-SFT1201 - CPM - TIN - 1

INSERT SCREW THREAD TAP

螺旋槽丝锥
SPIRAL FLUTED TAP SERIES

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

TIN

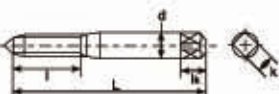
TICN

DLC

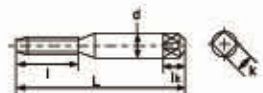
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

对于铝合金、镁合金、铜合金的大量高精度加工，可实现无屑塑性变形，可稳定连续加工。

TYPE1



TYPE5



C19

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (h) 二节长	Shank diameter (d) 柄部直径	TYPE 类型	
DLST-SFT201	M2	0.4	P1	2.5P	42	9.5	15	3	1	5
DLST-SFT302	M3	0.5	P2	2.5P	48	13	20	4	1	5
DLST-SFT402	M4	0.7	P2	2.5P	60	16	24	5.5	1	5
DLST-SFT502	M5	0.8	P2	2.5P	62	19	29	6	1	5
DLST-SFT602	M6	1	P2	2.5P	65	19	33	6.2	1	5
DLST-SFT803	M8	1.25	P3	2.5P	75	24	41	7	1	5
DLST-SFT1003	M10	1.5	P3	2.5P	82	29	48	8.5	1	5
DLST-SFT1004	M10	1.25	P3	2.5P	82	29	48	8.5	1	5
DLST-SFT1203	M12	1.75	P3	2.5P	90	30	48	10.5	1	5

INSERT SCREW THREAD TAP WITH LONG SHANK

长柄螺旋槽丝锥

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

TIN

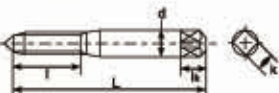
TICN

DLC

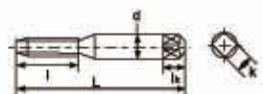
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

对于铝合金、镁合金、铜合金的大量高精度加工，可实现无屑塑性变形，可稳定连续加工。

TYPE1



TYPE5



Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (h) 二节长	Shank diameter (d) 柄部直径	TYPE 类型	
DLLST-SFT201	M2	0.4	P1	2.5P	80	9.5	15	3	1	5
DLLST-SFT302	M3	0.5	P2	2.5P	100	13	20	4	1	5
DLLST-SFT402	M4	0.7	P2	2.5P	100	16	24	5.5	1	5
DLLST-SFT502	M5	0.8	P2	2.5P	100	19	29	6	1	5
DLLST-SFT602	M6	1	P2	2.5P	100	19	33	6.2	1	5
DLLST-SFT603	M6	1	P2	2.5P	150	19	33	6.2	1	5
DLLST-SFT803	M8	1.25	P3	2.5P	150	24	41	7	1	5
DLLST-SFT1003	M10	1.5	P3	2.5P	150	29	48	8.5	1	5
DLLST-SFT1004	M10	1.25	P3	2.5P	150	29	48	8.5	1	5
DLLST-SFT1203	M12	1.75	P3	2.5P	150	30	48	10.5	1	5

Ordering rule
订购规则

For example: DLLST-SFT201- CPM - TIN - 1

METRIC COARSE THREAD

产品系列

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

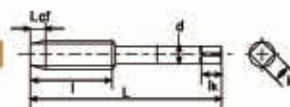
TICN

DLC

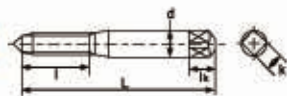
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝合金、镁合金、铜合金的大量高精度加工、塑性变形无屑加工、稳定连续加工。

TYPE8



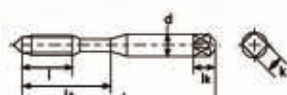
TYPE1



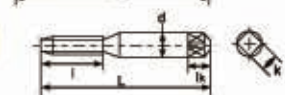
TYPE4



TYPE2



TYPE5



C20

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度 (mm)	Thread length (l) 螺纹长度 (mm)	Second section length (l) 第二段长度 (mm)	Shank diameter (d) 柄部直径 (mm)	TYPE 类型	
DLPOT101	M1	0.25	P1	2.5P	30	7	—	3	1	5
DLPOT111	M1.1		P1	2.5P	32	8	—	3	1	5
DLPOT122	M1.2		P2	2.5P	32	8	—	3	1	5
DLPOT142	M1.4		P2	2.5P	34	9	—	3	1	5
DLPOT162	M1.6	0.35	P2	2.5P	36	10	—	3	1	5
DLPOT171	M1.7		P1	2.5P		11			1	5
DLPOT172	M1.7		P2	2.5P					1	5
DLPOT182	M1.8		P2	2.5P					1	5
DLPOT201	M2	0.4	P1	2.5P	40	12	—	3	1	2 4 5
DLPOT202			P2	2.5P					1	2 4 5
DLPOT203			P3	2.5P					1	2 4 5
DLPOT222	M2.2	0.45	P2	2.5P	42	13	—	3	1	2 4 5
DLPOT231	M2.3	0.4	P1	2.5P					1	2 4 5
DLPOT232			P2	2.5P					1	2 4 5
DLPOT233			P3	2.5P					1	2 4 5
DLPOT251	M2.5	0.45	P1	2.5P	44	14	—	3	1	2 4 5
DLPOT252			P2	2.5P					1	2 4 5
DLPOT253			P3	2.5P					1	2 4 5
DLPOT261	M2.6	0.45	P1	2.5P	44	14	—	3	1	2 4 5
DLPOT262			P2	2.5P					1	2 4 5
DLPOT263			P3	2.5P					1	2 4 5
DLPOT264			P4	2.5P					1	2 4 5
DLPOT302	M3	0.5	P2	2.5P	46	11	19	4	1	2 4 5
DLPOT303			P3	2.5P					1	2 4 5
DLPOT304			P4	2.5P					1	2 4 5
DLPOT351	M3.5	0.6	P1	2.5P	48	13	20	4	1	2 4 5
DLPOT352			P2	2.5P					1	2 4 5
DLPOT402	M4	0.7	P2	2.5P	52	13	21	5	1	2 4 5
DLPOT403			P3	2.5P					1	2 4 5
DLPOT404			P4	2.5P					1	2 4 5
DLPOT502			P2	2.5P					1	2 4 5
DLPOT503	M5	0.8	P3	2.5P	60	16	24	5.5	1	2 4 5
DLPOT504			P4	2.5P					1	2 4 5
DLPOT602			M6	1	P2	2.5P	62	19	29	6
DLPOT603	P3	2.5P			1	2 4 5				
DLPOT604	P4	2.5P			1	2 4 5				
DLPOT702	M7	1	P2	2.5P	65	22	33	6.2	1	2 4 8
DLPOT703		0.5	P2	2.5P					1	2 4 8
DLPOT802	M8	1.25	P2	2.5P	70	22	37	6.2	1	2 4 8
DLPOT803			P3	2.5P					1	2 4 8
DLPOT804			P4	2.5P					1	2 4 8
DLPOT902			M9	1.25	P2	2.5P	72	22	38	7
DLPOT1002	M10	1.5	P2	2.5P	75	24	41	7	1	2 4 8
DLPOT1003			P3	2.5P					1	2 4 8
DLPOT1004			P4	2.5P					1	2 4 8
DLPOT1102	M11	1.5	P2	2.5P	80	25	48	8	1	2 4 8
DLPOT1202	M12	1.75	P2	2.5P	82	29	48	8.5	1	2 4 8
DLPOT1203			P3	2.5P					1	2 4 8
DLPOT1204			P4	2.5P					1	2 4 8

Ordering rule: Product code Selection of materials Surface treatment TYPE
For example: DLPOT101 - CPM - TIN - 1

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

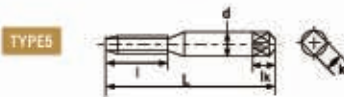
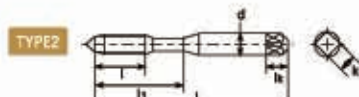
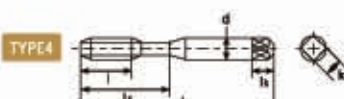
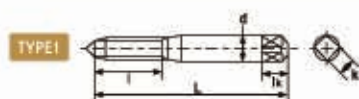
H

TIN

TICN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing



C21

Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切屑錐長度	Overall length (L) 總長度	Thread length (l) 螺紋長度	Second section length (l) 第二段長度	Shank diameter (d) 柄部直徑	TYPE 型號
DLPOT101	M1	0.2	P1	2.5P	32	5	—	3	1 5
DLPOT111	M1.1	0.2	P1	2.5P	32	5	—	3	1 5
DLPOT121	M1.2	0.2	P1	2.5P	32	5	—	3	1 5
DLPOT141	M1.4	0.2	P1	2.5P	34	5	—	3	1 5
DLPOT162	M1.6	0.2	P2	2.5P	36	6	—	3	1 5
DLPOT172	M1.7	0.2	P2	2.5P	36	6	—	3	1 5
DLPOT182	M1.8	0.2	P2	2.5P	36	6	—	3	1 5
DLPOT202	M2	0.25	P2	2.5P	42	7	15	3	1 2 4 5
DLPOT222	M2.2	0.25	P2	2.5P	42	7	15	3	1 2 4 5
DLPOT232	M2.3	0.25	P2	2.5P	42	7	15	3	1 2 4 5
DLPOT252	M2.5	0.35	P2	2.5P	44	8	16	3	1 2 4 5
DLPOT262	M2.6	0.35	P2	2.5P	44	8	16	3	1 2 4 5
DLPOT302	M3	0.35	P2	2.5P	46	9.5	18	4	1 2 4 5
DLPOT352	M3.5	0.35	P2	2.5P	48	9.5	20	4	1 2 4 5
DLPOT402	M4	0.5	P2	2.5P	52	9.5	20	5	1 2 4 5
DLPOT503	M5	0.5	P2	2.5P	60	11	22	5.5	1 2 4 5
DLPOT602	M6	0.75	P2	2.5P	62	12	24	6	1 2 4 5
DLPOT702	M7	0.75	P2	2.5P	65	13	26	6.2	1 2 4 5
DLPOT803	M8	1.0	P3	2.5P	70	18	—	6.2	1 2 4 5
DLPOT903	M9	1.0	P3	2.5P	72	19	—	7	1 2 4 5
DLPOT1003	M10	1.25	P3	2.5P	75	19	—	7	1 2 4 5
DLPOT1113	M11	1.25	P3	2.5P	80	23	—	8	1 2 4 5
DLPOT1203	M12	1.25	P3	2.5P	82	23	—	8.5	1 2 4 5

Ordering code
For example: DLPOT101 - CPM - TIN - 1

UNIFIED THREAD

UNIFIED THREAD

Selection of materials
材料選擇

HSSEX

HSSV

CPM

Surface treatment
表面處理

N

H

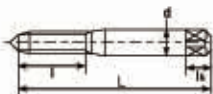
TIN

TICN

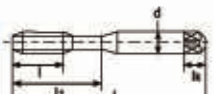
DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
用於鋁合金、鎂合金、銅合金的大批量高精度加工，無切屑塑性變形，可實現穩定連續加工。

TYPE1



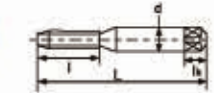
TYPE4



TYPE2



TYPE5



Product code 產品編號	Specification 規格	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長 (mm)	Thread length (l) 螺紋長度 (mm)	Second section length (l) 二重長度 (mm)	Shank diameter (d) 柄徑 (mm)	TYPE 型號	
DLPOTU801	No.0-80	P1	2.5P	36	8	—	3	1	5
DLPOTU641	No.1-64	P1	2.5P					1	5
DLPOTU721	No.1-72	P1	2.5P					1	5
DLPOTU561	No.2-56	P1	2.5P	42	9.5	15	3	1	2 4 5
DLPOTU642	No.2-64	P1	2.5P					1	2 4 5
DLPOTU481	No.3-48	P1	2.5P	44	9.5	16	3	1	2 4 5
DLPOTU562	No.3-56	P1	2.5P					1	2 4 5
DLPOTU401	No.4-40	P1	2.5P	44	9.5	16	3	1	2 4 5
DLPOTU402		P2	2.5P					1	2 4 5
DLPOTU482		P1	2.5P					1	2 4 5
DLPOTU483	No.4-48	P2	2.5P	46	11	18	4	1	2 4 5
DLPOTU403		P1	2.5P					1	2 4 5
DLPOTU404	No.5-40	P2	2.5P	46	11	18	4	1	2 4 5
DLPOTU441		P1	2.5P					1	2 4 5
DLPOTU442	No.5-44	P2	2.5P	48	13	20	4	1	2 4 5
DLPOTU322		P2	2.5P					1	2 4 5
DLPOTU323	No.6-32	P3	2.5P	48	13	20	4	1	2 4 5
DLPOTU405		P2	2.5P					1	2 4 5
DLPOTU406	No.6-40	P3	2.5P	52	13	21	5	1	2 4 5
DLPOTU324		P2	2.5P					1	2 4 5
DLPOTU362	No.8-36	P2	2.5P	60	16	24	5.5	1	2 4 5
DLPOTU242	No.10-24	P2	2.5P					1	2 4 5
DLPOTU325	No.10-32	P2	2.5P	60	17	25	5.5	1	2 4 5
DLPOTU243	No.12-24	P2	2.5P					1	2 4 5
DLPOTU282	No.12-28	P2	2.5P					1	2 4 5

Ordering rule 訂購規則
For example: DLPOTU801- CPM - TIN - 1

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

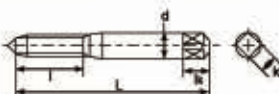
TiN

TiCN

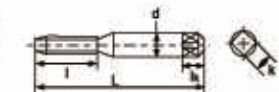
DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
对于铝合金、镁合金、铜合金的大量高精度加工，可实现无屑塑性变形，可稳定连续加工。

TYPE1



TYPE5



C23

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长度(l)	Second section length (l') 二节段长度(l')	Shank diameter (d) 柄径(d)	Type 类型
DLLS-POT101	M1	0.25	P1	2.5P	70	5.5	—	3	1 5
DLLS-POT121	M1.2	0.25	P1	2.5P	70	5.5	—	3	1 5
DLLS-POT141	M1.4	0.3	P1	2.5P	80	7	—	3	1 5
DLLS-POT161	M1.6	0.35	P1	2.5P	80	8	—	3	1 5
DLLS-POT171	M1.7	0.35	P1	2.5P	80	8	—	3	1 5
DLLS-POT181	M1.8	0.35	P1	2.5P	80	8	—	3	1 5
DLLS-POT203	M2	0.4	P2	2.5P	80	9.5	15	3	1 5
DLLS-POT204	M2	0.4	P2	2.5P	100	9.5	15	3	1 5
DLLS-POT233	M2.3	0.4	P2	2.5P	80	9.5	15	3	1 5
DLLS-POT234	M2.3	0.4	P2	2.5P	100	9.5	15	3	1 5
DLLS-POT254	M2.5	0.45	P2	2.5P	80	9.5	16	3	1 5
DLLS-POT255	M2.5	0.45	P2	2.5P	100	9.5	16	3	1 5
DLLS-POT256	M2.5	0.45	P2	2.5P	120	9.5	16	3	1 5
DLLS-POT264	M2.6	0.45	P2	2.5P	80	9.5	16	3	1 5
DLLS-POT265	M2.6	0.45	P2	2.5P	100	9.5	16	3	1 5
DLLS-POT266	M2.6	0.45	P2	2.5P	120	9.5	16	3	1 5
DLLS-POT304	M3	0.5	P2	2.5P	80	11	18	4	1 5
DLLS-POT305	M3	0.5	P2	2.5P	100	11	18	4	1 5
DLLS-POT306	M3	0.5	P2	2.5P	120	11	18	4	1 5
DLLS-POT354	M3.5	0.6	P2	2.5P	80	13	20	4	1 5
DLLS-POT355	M3.5	0.6	P2	2.5P	100	13	20	4	1 5
DLLS-POT356	M3.5	0.6	P2	2.5P	120	13	20	4	1 5
DLLS-POT401	M4	0.7	P2	2.5P	80	13	20	5	1 5
DLLS-POT402	M4	0.7	P2	2.5P	100	13	20	5	1 5
DLLS-POT403	M4	0.7	P2	2.5P	120	13	20	5	1 5
DLLS-POT501	M5	0.8	P2	2.5P	100	16	24	5.5	1 5
DLLS-POT502	M5	0.8	P2	2.5P	120	16	24	5.5	1 5
DLLS-POT601	M6	1	P2	2.5P	100	19	29	6	1 5
DLLS-POT602	M6	1	P2	2.5P	120	19	29	6	1 5
DLLS-POT603	M6	1	P2	2.5P	150	19	29	6	1 5
DLLS-POT801	M8	1.25	P2	2.5P	100	22	37	6.2	1 5
DLLS-POT802	M8	1.25	P2	2.5P	120	22	37	6.2	1 5
DLLS-POT803	M8	1.25	P2	2.5P	150	22	37	6.2	1 5
DLLS-POT804	M8	1	P2	2.5P	100	22	37	6.2	1 5
DLLS-POT805	M8	1	P2	2.5P	120	22	37	6.2	1 5
DLLS-POT806	M8	1	P2	2.5P	150	22	37	6.2	1 5
DLLS-POT1001	M10	1.5	P2	2.5P	100	24	41	7	1 5
DLLS-POT1002	M10	1.5	P2	2.5P	120	24	41	7	1 5
DLLS-POT1003	M10	1.5	P2	2.5P	150	24	41	7	1 5
DLLS-POT1004	M10	1.5	P2	2.5P	200	24	41	7	1 5
DLLS-POT1005	M10	1.25	P2	2.5P	100	24	41	7	1 5
DLLS-POT1006	M10	1.25	P2	2.5P	120	24	41	7	1 5
DLLS-POT1007	M10	1.25	P2	2.5P	150	24	41	7	1 5
DLLS-POT1008	M10	1.25	P2	2.5P	200	24	41	7	1 5
DLLS-POT1009	M10	1	P2	2.5P	100	24	41	7	1 5
DLLS-POT1010	M10	1	P2	2.5P	120	24	41	7	1 5
DLLS-POT1011	M10	1	P2	2.5P	150	24	41	7	1 5

Ordering code 订购代码

Product code 商品编号

Selection of materials 材料选择

Surface treatment 表面处理

TYPE

For example: DLLS-POT101- CPM - TiN - 1

LONG SHANK

长柄型

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥高度	Overall length (L) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (l) 二节长(l)	Shank diameter (d) 柄径(d)	TYPE 形式	
DLLS-POT1201	M12	1.75	P1	2.5P	100	29	48	8.5	1	5
DLLS-POT1202			P1	2.5P	120				1	5
DLLS-POT1203			P1	2.5P	150				1	5
DLLS-POT1204			P1	2.5P	200				1	5
DLLS-POT1205	M12	1.5	P1	2.5P	100	29	48	8.5	1	5
DLLS-POT1206			P1	2.5P	120				1	5
DLLS-POT1207			P2	2.5P	150				1	5
DLLS-POT1208			P2	2.5P	200				1	5
DLLS-POT1209	M12	1.25	P2	2.5P	100	29	48	8.5	1	5
DLLS-POT1210			P2	2.5P	120				1	5
DLLS-POT1211			P2	2.5P	150				1	5
DLLS-POT1212			P2	2.5P	200				1	5
DLLS-POT1213	M12	1	P2	2.5P	100	29	48	8.5	1	5
DLLS-POT1214			P2	2.5P	120				1	5
DLLS-POT1215			P2	2.5P	150				1	5

C24

Ordering rule
订购规则

Product code
商品编号

Selection of materials
材料选择

Surface treatment
表面处理

TYPE
形式

For example: DLLS-POT1201- CPM - TIN - 1

INSERT SCREW THREAD TAP

刃傾角絲錐
SPIRAL POINTED TAP SERIES

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

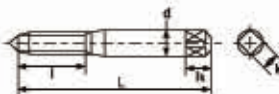
TICN

DLC

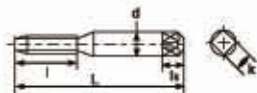
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝合金、镁合金、铜合金的大量高精度加工，能实现无屑加工，能实现稳定连续加工。

TYPE1



TYPE5



C25

Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l0)	Shank diameter (d)	TYPE	
DLST-POT201	M2	0.4	P1	2.5P	42	9.5	15	3	1	5
DLST-POT302	M3	0.5	P2	2.5P	48	13	20	4	1	5
DLST-POT402	M4	0.7	P2	2.5P	60	16	24	5.5	1	5
DLST-POT502	M5	0.8	P2	2.5P	62	19	29	6	1	5
DLST-POT602	M6	1	P2	2.5P	65	19	33	6.2	1	5
DLST-POT803	M8	1.25	P3	2.5P	75	24	41	7	1	5
DLST-POT1003	M10	1.5	P3	2.5P	82	29	48	8.5	1	5
DLST-POT1004	M10	1.25	P3	2.5P	82	29	48	8.5	1	5
DLST-POT1203	M12	1.75	P3	2.5P	90	30	48	10.5	1	5

INSERT SCREW THREAD TAP WITH LONG SHANK

长柄螺旋丝錐

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

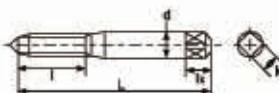
TICN

DLC

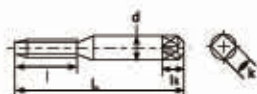
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝合金、镁合金、铜合金的大量高精度加工，能实现无屑加工，能实现稳定连续加工。

TYPE1



TYPE5



Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l0)	Shank diameter (d)	TYPE	
DLLS-POT201	M2	0.4	P1	2.5P	80	9.5	15	3	1	5
DLLS-POT302	M3	0.5	P2	2.5P	100	13	20	4	1	5
DLLS-POT402	M4	0.7	P2	2.5P	100	16	24	5.5	1	5
DLLS-POT502	M5	0.8	P2	2.5P	100	19	29	6	1	5
DLLS-POT602	M6	1	P2	2.5P	100	19	33	6.2	1	5
DLLS-POT603	M6	1	P2	2.5P	150	19	33	6.2	1	5
DLLS-POT803	M8	1.25	P3	2.5P	150	24	41	7	1	5
DLLS-POT1003	M10	1.5	P3	2.5P	150	29	48	8.5	1	5
DLLS-POT1004	M10	1.25	P3	2.5P	150	29	48	8.5	1	5
DLLS-POT1203	M12	1.75	P3	2.5P	150	30	48	10.5	1	5

Ordering rules

For example: DLST-POT201- CPM - TIN - 1

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

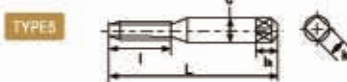
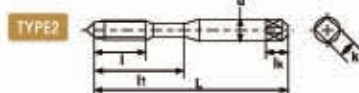
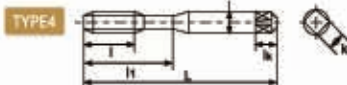
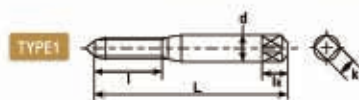
H

TIN

TICN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing



Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (h)	Shank diameter (d)	TYPE		
DLLH-POT101	M1	0.25	P1	2.5P	32	5.5	—	3	1	5	
DLLH-POT111	M1.1	0.25	P1	2.5P	32	5.5	—	3	1	5	
DLLH-POT121	M1.2	0.25	P1	2.5P	32	5.5	—	3	1	5	
DLLH-POT141	M1.4	0.3	P1	2.5P	34	7	—	3	1	5	
DLLH-POT161	M1.6	0.35	P1	2.5P	36	8	—	3	1	5	
DLLH-POT172	M1.7	0.35	P2	2.5P	36	8	—	3	1	5	
DLLH-POT182	M1.8	0.35	P2	2.5P	36	8	—	3	1	5	
DLLH-POT202	M2	0.4	P2	2.5P	42	9.5	15	3	1	2	5
DLLH-POT203			P3	2.5P					1	2	5
DLLH-POT222	M2.2	0.45	P2	2.5P	44	9.5	16	3	1	2	4
DLLH-POT232	M2.3	0.4	P2	2.5P					1	2	4
DLLH-POT252	M2.5	0.45	P2	2.5P	44	9.5	16	3	1	2	4
DLLH-POT253			P3	2.5P					1	2	4
DLLH-POT262	M2.6	0.45	P2	2.5P	44	9.5	16	3	1	2	4
DLLH-POT263			P3	2.5P					1	2	4
DLLH-POT302	M3	0.5	P2	2.5P	46	11	18	4	1	2	4
DLLH-POT303			P3	2.5P					1	2	4
DLLH-POT352	M3.5	0.6	P2	2.5P	48	13	20	4	1	2	4
DLLH-POT353			P3	2.5P					1	2	4
DLLH-POT402	M4	0.7	P2	2.5P	52	13	20	5	1	2	4
DLLH-POT403			P3	2.5P					1	2	4
DLLH-POT502	M5	0.8	P2	2.5P	60	16	24	5.5	1	2	4
DLLH-POT602	M6	1	P2	2.5P	62	19	29	6	1	2	4
DLLH-POT802	M8	1.25	P3	2.5P	70	22	37	6.2	1	2	4
DLLH-POT1003	M10	1.5	P3	2.5P	75	24	41	7	1	2	4
DLLH-POT1203	M12	1.75	P3	2.5P	82	29	48	8.5	1	2	4

Ordering rules: Product code Selection of materials Surface treatment TYPE
For example: DLLG-POT101- CPM - TIN - 1

METRIC COARSE THREAD

直槽丝锥
STRAIGHT FLUTE TAP SERIES

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

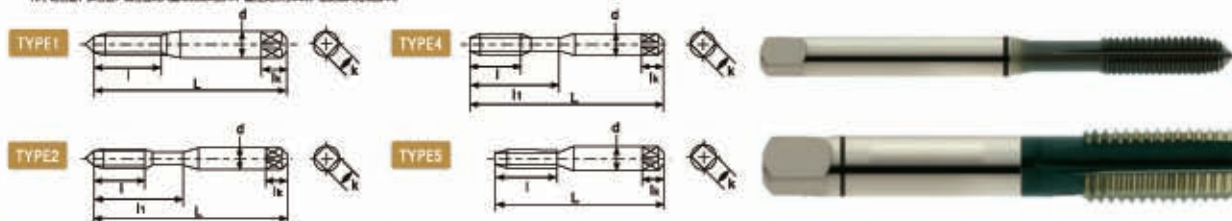
H

TIN

TICN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
对于铝合金、镁合金、铜合金，大量高精度加工，塑性变形无屑，可稳定连续加工



C27

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (l) 第二段长度	Shank diameter (d) 柄部直径	TYPE 类型			
DLHT101	M1	0.25	P1	4P	30	7	—	3	1	5		
DLHT111	M1.1		P1	4P	32	8	—	3	1	5		
DLHT122	M1.2		P2	4P	32	8	—	3	1	5		
DLHT142	M1.4	0.3	P2	4P	34	9	—	3	1	5		
DLHT162	M1.6	0.35	P2	4P	36	10	—	3	1	5		
DLHT171	M1.7		P1	4P		11			1	5		
DLHT172	M1.7		P2	4P					1	5		
DLHT182	M1.8		P2	4P					1	5		
DLHT201	M2	0.4	P1	4P	40	12	—	3	1	2	4	5
DLHT202			P2	4P					1	2	4	5
DLHT203			P3	4P					1	2	4	5
DLHT222	M2.2	0.45	P1	4P	42	13	—	3	1	2	4	5
DLHT231	M2.3	0.4	P1	4P					1	2	4	5
DLHT232			P2	4P					1	2	4	5
DLHT233			P3	4P					1	2	4	5
DLHT251	M2.5	0.45	P1	4P	44	14	—	3	1	2	4	5
DLHT252			P2	4P					1	2	4	5
DLHT253			P3	4P					1	2	4	5
DLHT261	M2.6	0.45	P1	4P	44	14	—	3	1	2	4	5
DLHT262			P2	4P					1	2	4	5
DLHT263			P3	4P					1	2	4	5
DLHT264			P4	4P					1	2	4	5
DLHT302	M3	0.5	P2	4P	46	11	19	4	1	2	4	5
DLHT303			P3	4P					1	2	4	5
DLHT304			P4	4P					1	2	4	5
DLHT351	M3.5	0.6	P1	4P	48	13	20	4	1	2	4	5
DLHT352			P2	4P					1	2	4	5
DLHT402	M4	0.7	P2	4P	52	13	21	5	1	2	4	5
DLHT403			P3	4P					1	2	4	5
DLHT404			P4	4P					1	2	4	5
DLHT502	M5	0.8	P2	4P	60	16	24	5.5	1	2	4	5
DLHT503			P3	4P					1	2	4	5
DLHT504			P4	4P					1	2	4	5
DLHT602	M6	1	P2	4P	62	19	29	6	1	2	4	5
DLHT603			P3	4P					1	2	4	5
DLHT604			P4	4P					1	2	4	5
DLHT702	M7	1	P2	4P	65	22	33	6.2	1	2	4	5
DLHT703		0.5	P2	4P					1	2	4	5
DLHT802	M8	1.25	P2	4P	70	22	37	6.2	1	2	4	5
DLHT803			P3	4P					1	2	4	5
DLHT804			P4	4P					1	2	4	5
DLHT902	M9	1.25	P2	4P	72	22	38	7	1	2	4	5
DLHT1002	M10	1.5	P2	4P	75	24	41	7	1	2	4	5
DLHT1003			P3	4P					1	2	4	5
DLHT1004			P4	4P					1	2	4	5
DLHT1102	M11	1.5	P2	4P	80	25	48	8	1	2	4	5
DLHT1202	M12	1.75	P2	4P	82	29	48	8.5	1	2	4	5
DLHT1203			P3	4P					1	2	4	5
DLHT1204			P4	4P					1	2	4	5

Ordering rules
订购规则

Product code
商品编号

Selection of materials
材料选择

Surface treatment
表面处理

TYPE
类型

For example:
例如:

DLHT101 - CPM - TIN - 1

UNIFIED THREAD

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

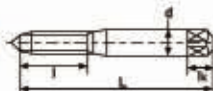
TICN

DLC

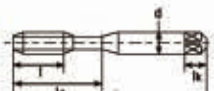
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

对于铝、镁、铜合金的大量高精度加工，可实现无屑塑性变形，可稳定连续加工。

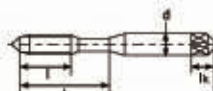
TYPE1



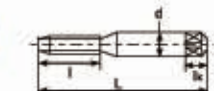
TYPE4



TYPE2



TYPE5



Product code 商品编号	Specification 规格	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (l) 第二段长度	Shank diameter (d) 柄部直径	TYPE 规格	
DLHTU801	No.0-80	P1	4P	36	8	-	3	1	5
DLHTU641	No.1-64	P1	4P					1	5
DLHTU721	No.1-72	P1	4P					1	5
DLHTU561	No.2-56	P1	4P	42	9.5	15	3	1	2
DLHTU642	No.2-64	P1	4P					2	4
DLHTU481	No.3-48	P1	4P	44	9.5	16	3	1	2
DLHTU562	No.3-56	P1	4P					2	4
DLHTU401	No.4-40	P1	4P	44	9.5	16	3	1	2
DLHTU402		P2	4P					2	4
DLHTU482	No.4-48	P1	4P					1	2
DLHTU483		P2	4P					2	4
DLHTU403	No.5-40	P1	4P	46	11	18	4	1	2
DLHTU404		P2	4P					2	4
DLHTU441	No.5-44	P1	4P					1	2
DLHTU442		P2	4P	48	13	20	4	2	4
DLHTU322	No.6-32	P2	4P					1	2
DLHTU323		P3	4P					2	4
DLHTU405	No.6-40	P2	4P					1	2
DLHTU406		P3	4P	52	13	21	5	2	4
DLHTU324	No.8-32	P2	4P					1	2
DLHTU362	No.8-36	P2	4P					2	4
DLHTU242	No.10-24	P2	4P	60	16	24	5.5	1	2
DLHTU325	No.10-32	P2	4P					2	4
DLHTU243	No.12-24	P2	4P	60	17	25	5.5	1	2
DLHTU282	No.12-28	P2	4P					2	4

Ordering rules: Product code Selection of materials Surface treatment Type
For example: DLHTU801 - CPM - TIN - 1

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

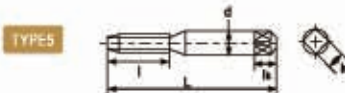
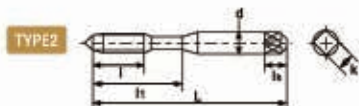
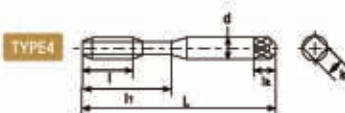
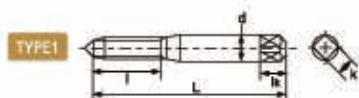
TIN

TICN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝合金、镁合金、铜合金的大量高精度加工，可实现无屑塑性变形，可稳定连续加工。



C29

Product code 产品规格	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长度(l)	Second section length (l) 二段长度(l)	Shank diameter (d) 柄部直径(d)	TYPE 类型	
DLLH-HT101	M1	0.25	P1	4P	32	5.5	—	3	1	5
DLLH-HT111	M1.1	0.25	P1	4P	32	5.5	—	3	1	5
DLLH-HT121	M1.2	0.25	P1	4P	32	5.5	—	3	1	5
DLLH-HT141	M1.4	0.3	P1	4P	34	7	—	3	1	5
DLLH-HT161	M1.6	0.35	P1	4P	36	8	—	3	1	5
DLLH-HT172	M1.7	0.35	P2	4P	36	8	—	3	1	5
DLLH-HT182	M1.8	0.35	P2	4P	36	8	—	3	1	5
DLLH-HT202	M2	0.4	P2	4P	42	9.5	15	3	1	2 5
DLLH-HT203			P3	4P					1	2 5
DLLH-HT222	M2.2	0.45	P2	4P	44	9.5	16	3	1 2 4 5	
DLLH-HT232	M2.3	0.4	P2	4P					1 2 4 5	
DLLH-HT252	M2.5	0.45	P2	4P	44	9.5	16	3	1 2 4 5	
DLLH-HT253			P3	4P					1 2 4 5	
DLLH-HT262	M2.6	0.45	P2	4P	44	9.5	16	3	1 2 4 5	
DLLH-HT263			P3	4P					1 2 4 5	
DLLH-HT302	M3	0.5	P2	4P	46	11	18	4	1 2 4 5	
DLLH-HT303			P3	4P					1 2 4 5	
DLLH-HT352	M3.5	0.6	P2	4P	48	13	20	4	1 2 4 5	
DLLH-HT353			P3	4P					1 2 4 5	
DLLH-HT402	M4	0.7	P2	4P	52	13	20	5	1 2 4 5	
DLLH-HT403			P3	4P					1 2 4 5	
DLLH-HT502	M5	0.8	P2	4P	60	16	24	5.5	1 2 4 5	
DLLH-HT602	M6	1	P2	4P	62	19	29	6	1 2 4 5	
DLLH-HT802	M8	1.25	P3	4P	70	22	37	6.2	1 2 4 5	
DLLH-HT1003	M10	1.5	P3	4P	75	24	41	7	1 2 4 5	
DLLH-HT1203	M12	1.75	P3	4P	82	29	48	8.5	1 2 4 5	

Ordering rules
订购规则

For example: DLLH-HT101 - CPM - TIN - 1

LONG SHANK

Selection of materials
材料選擇

HSSEX

HSSV

CPM

Surface treatment
表面處理

N

H

TIN

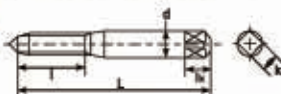
TICN

DLC

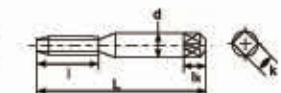
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

適用於鋁合金、鎂合金、銅合金的大量高精度加工，無屑塑性變形，可實現穩定連續加工。

TYPE1



TYPE5



Product code 產品型號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切屑錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Second section length (l) 二節長(l)	Shank diameter (d) 柄徑(d)	TYPE 型號	
DLLS-HT101	M1	0.25	P1	2.5P	70	5.5	—	3	1	5
DLLS-HT121	M1.2	0.25	P1	2.5P	70	5.5	—	3	1	5
DLLS-HT141	M1.4	0.3	P1	2.5P	80	7	—	3	1	5
DLLS-HT161	M1.6	0.35	P1	2.5P	80	8	—	3	1	5
DLLS-HT171	M1.7	0.35	P1	2.5P	80	8	—	3	1	5
DLLS-HT181	M1.8	0.35	P1	2.5P	80	8	—	3	1	5
DLLS-HT203	M2	0.4	P2	2.5P	80	9.5	15	3	1	5
DLLS-HT204			P2	2.5P	100				1	5
DLLS-HT233	M2.3	0.4	P2	2.5P	80	9.5	15	3	1	5
DLLS-HT234			P2	2.5P	100				1	5
DLLS-HT254			P2	2.5P	80				1	5
DLLS-HT255	M2.5	0.45	P2	2.5P	100	9.5	16	3	1	5
DLLS-HT256			P2	2.5P	120				1	5
DLLS-HT264			P2	2.5P	80				1	5
DLLS-HT265	M2.6	0.45	P2	2.5P	100	9.5	16	3	1	5
DLLS-HT266			P2	2.5P	120				1	5
DLLS-HT304			P2	2.5P	80				1	5
DLLS-HT305	M3	0.5	P2	2.5P	100	11	18	4	1	5
DLLS-HT306			P2	2.5P	120				1	5
DLLS-HT354			P2	2.5P	80				1	5
DLLS-HT355	M3.5	0.6	P2	2.5P	100	13	20	4	1	5
DLLS-HT356			P2	2.5P	120				1	5
DLLS-HT401			P2	2.5P	80				1	5
DLLS-HT402	M4	0.7	P2	2.5P	100	13	20	5	1	5
DLLS-HT403			P2	2.5P	120				1	5
DLLS-HT501			P2	2.5P	100				1	5
DLLS-HT502	M5	0.8	P2	2.5P	120	16	24	5.5	1	5
DLLS-HT601			P2	2.5P	100				1	5
DLLS-HT602	M6	1	P2	2.5P	120	19	29	6	1	5
DLLS-HT603			P2	2.5P	150				1	5
DLLS-HT801			P2	2.5P	100				1	5
DLLS-HT802	M8	1.25	P2	2.5P	120				1	5
DLLS-HT803			P2	2.5P	150				1	5
DLLS-HT804			P2	2.5P	100	22	37	6.2	1	5
DLLS-HT805		1	P2	2.5P	120				1	5
DLLS-HT806			P2	2.5P	150				1	5
DLLS-HT1001			P2	2.5P	100				1	5
DLLS-HT1002	M10	1.5	P2	2.5P	120	24	41	7	1	5
DLLS-HT1003			P2	2.5P	150				1	5
DLLS-HT1004			P2	2.5P	200				1	5
DLLS-HT1005			P2	2.5P	100				1	5
DLLS-HT1006	M10	1.25	P2	2.5P	120	24	41	7	1	5
DLLS-HT1007			P2	2.5P	150				1	5
DLLS-HT1008			P2	2.5P	200				1	5
DLLS-HT1009			P2	2.5P	100				1	5
DLLS-HT1010	M10	1	P2	2.5P	120	24	41	7	1	5
DLLS-HT1011			P2	2.5P	150				1	5

Ordering rules 訂購規則

Product code 產品型號

Selection of materials 材料選擇

CPM

Surface treatment 表面處理

TIN

TYPE

For example: DLLS-HT101- CPM - TIN - 1

Product code 产品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (l') 二节长 (l')	Shank diameter (d) 柄径(d)	TYPE 形式	
DLLS-HT1201	M12	1.75	P1	2.5P	100	29	48	8.5	1	5
DLLS-HT1202			P1	2.5P	120				1	5
DLLS-HT1203			P1	2.5P	150				1	5
DLLS-HT1204			P1	2.5P	200				1	5
DLLS-HT1205	M12	1.5	P1	2.5P	100	29	48	8.5	1	5
DLLS-HT1206			P1	2.5P	120				1	5
DLLS-HT1207			P2	2.5P	150				1	5
DLLS-HT1208			P2	2.5P	200				1	5
DLLS-HT1209	M12	1.25	P2	2.5P	100	29	48	8.5	1	5
DLLS-HT1210			P2	2.5P	120				1	5
DLLS-HT1211			P2	2.5P	150				1	5
DLLS-HT1212			P2	2.5P	200				1	5
DLLS-HT1213	M12	1	P2	2.5P	100	29	48	8.5	1	5
DLLS-HT1214			P2	2.5P	120				1	5
DLLS-HT1215			P2	2.5P	150				1	5



C31

Ordering rule
订购规则

Product code
产品编号

Selection of material
材料选择

Surface treatment
表面处理

TYPE
形式

For example: DLLS-HT1201- CPM - TIN - 1

METRIC FINE THREAD

公制細牙螺絲

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

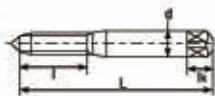
TICN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

对于铝合金、镁合金、铜合金大量高精度加工，可实现无屑塑性变形，可稳定连续加工。

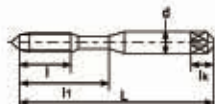
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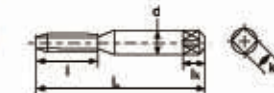
TYPE4



TYPE2



TYPE5



Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切屑錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長度(l)	Second section length (l) 二節長度(l)	Shank diameter (d) 柄徑(d)	TYPE 類型				
DLHTT101	M1	0.2	P1	2.5P	32	5	—	3	1	5			
DLHTT111	M1.1	0.2	P1	2.5P	32	5	—	3	1	5			
DLHTT121	M1.2	0.2	P1	2.5P	32	5	—	3	1	5			
DLHTT141	M1.4	0.2	P1	2.5P	34	5	—	3	1	5			
DLHTT162	M1.6	0.2	P2	2.5P	36	6	—	3	1	5			
DLHTT172	M1.7	0.2	P2	2.5P	36	6	—	3	1	5			
DLHTT182	M1.8	0.2	P2	2.5P	36	6	—	3	1	5			
DLHTT202	M2	0.25	P2	2.5P	42	7	15	3	1	2	4	5	
DLHTT222	M2.2	0.25	P2	2.5P	42	7	15	3	1	2	4	5	
DLHTT232	M2.3	0.25	P2	2.5P	42	7	15	3	1	2	4	5	
DLHTT252	M2.5	0.35	P2	2.5P	44	8	16	3	1	2	4	5	
DLHTT262	M2.6	0.35	P2	2.5P	44	8	16	3	1	2	4	5	
DLHTT302	M3	0.35	P2	2.5P	46	9.5	18	4	1	2	4	5	
DLHTT352	M3.5	0.35	P2	2.5P	48	9.5	20	4	1	2	4	5	
DLHTT402	M4	0.5	P2	2.5P	52	9.5	20	5	1	2	4	5	
DLHTT503	M5	0.5	P2	2.5P	60	11	22	5.5	1	2	4	5	
DLHTT602	M6	0.75	P2	2.5P	62	12	24	6	1	2	4	5	
DLHTT702	M7	0.75	P2	2.5P	65	13	26	6.2	1	2	4	5	
DLHTT803	M8	1.0	P3	2.5P	70	18	—	6.2	1	2	4	5	
DLHTT903	M9	1.0	P3	2.5P	72	19	—	7	1	2	4	5	
DLHTT1003	M10	1.25	P3	2.5P	75	19	—	7	1	2	4	5	
DLHTT1113	M11	1.25	P3	2.5P	80	23	—	8	1	2	4	5	
DLHTT1203	M12	1.25	P3	2.5P	82	23	—	8.5	1	2	4	5	

Ordering rules
For example: DLHTT101 - CPM - TIN - 1

INSERT SCREW THREAD TAP

直槽丝锥
STRAIGHT FLUTE TAP SERIES

Selection of materials

HSSEX

HSSV

CPM

Surface treatment

N

H

TIN

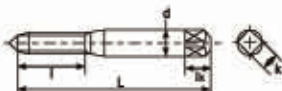
TICN

DLC

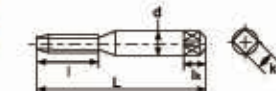
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝合金、镁合金、铜合金的大批量精密加工，能实现无屑加工，能实现稳定连续加工。

TYPE1



TYPE5



C33

Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l0)	Shank diameter (d)	TYPE
DLST-HT201	M2	0.4	P1	2.5P	42	9.5	15	3	1 5
DLST-HT302	M3	0.5	P2	2.5P	48	13	20	4	1 5
DLST-HT402	M4	0.7	P2	2.5P	60	16	24	5.5	1 5
DLST-HT502	M5	0.8	P2	2.5P	62	19	29	6	1 5
DLST-HT602	M6	1	P2	2.5P	65	19	33	6.2	1 5
DLST-HT803	M8	1.25	P3	2.5P	75	24	41	7	1 5
DLST-HT1003	M10	1.5	P3	2.5P	82	29	48	8.5	1 5
DLST-HT1004	M10	1.25	P3	2.5P	82	29	48	8.5	1 5
DLST-HT1203	M12	1.75	P3	2.5P	90	30	48	10.5	1 5

INSERT SCREW THREAD TAP WITH LONG SHANK

长柄直槽丝锥

Selection of materials

HSSEX

CPM

Surface treatment

N

H

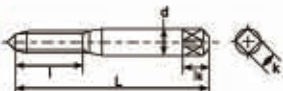
TIN

TICN

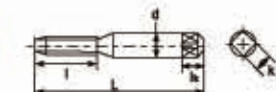
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于铝合金、镁合金、铜合金的大批量精密加工，能实现无屑加工，能实现稳定连续加工。

TYPE1



TYPE5



Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l0)	Shank diameter (d)	TYPE
DLLST-HT201	M2	0.4	P1	2.5P	80	9.5	15	3	1 5
DLLST-HT302	M3	0.5	P2	2.5P	100	13	20	4	1 5
DLLST-HT402	M4	0.7	P2	2.5P	100	16	24	5.5	1 5
DLLST-HT502	M5	0.8	P2	2.5P	100	19	29	6	1 5
DLLST-HT602	M6	1	P2	2.5P	100	19	33	6.2	1 5
DLLST-HT603	M6	1	P2	2.5P	150	19	33	6.2	1 5
DLLST-HT803	M8	1.25	P3	2.5P	150	24	41	7	1 5
DLLST-HT1003	M10	1.5	P3	2.5P	150	29	48	8.5	1 5
DLLST-HT1004	M10	1.25	P3	2.5P	150	29	48	8.5	1 5
DLLST-HT1203	M12	1.75	P3	2.5P	150	30	48	10.5	1 5

Ordering rule: Product code Selection of materials Surface treatment TYPE
For example: DLST-HT201- CPM - TIN - 1

NUT TAPS (METRIC THREAD)

螺母丝攻 (公制)

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

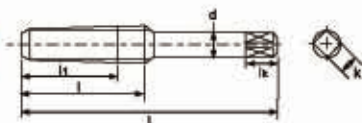
TiN

TiCN

DLC

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
对于铝、镁、铜合金及大量高精度加工、塑性变形无屑加工、稳定连续加工。

TYPE6



Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Overall length (L) 总长度 (mm)	Thread length (l) 螺纹长度 (mm)	Second section length (l) 第二段长度 (mm)	Shank diameter (d) 柄径 (mm)	Channel number 沟数	TYPE 型号
DLNT202	M2	0.4	P2	50	14	10.5	1.4	3	6
DLNT232	M2.3	0.4	P2	50	14	10.5	1.6	3	6
DLNT252	M2.5	0.45	P2	50	15	11	2	3	6
DLNT262	M2.6	0.45	P2	50	15	11	2	3	6
DLNT302	M3	0.5	P2	60	20	15	2.1	3	6
DLNT352	M3.5	0.6	P2	60	20	15	2.6	3	6
DLNT402	M4	0.7	P2	80	25	18	2.8	3	6
DLNT403	M4	0.5	P2	80	18	14	2.8	3	6
DLNT452	M4.5	0.75	P2	80	25	18	3.3	3	6
DLNT502	M5	0.8	P2	100	30	23	3.6	3	6
DLNT503	M5	0.5	P2	100	20	15	3.6	3	6
DLNT602	M6	1	P2	120	35	26	4.5	3	6
DLNT603	M6	0.75	P2	120	28	21	4.5	3	6
DLNT604	M6	0.5	P2	120	28	21	4.5	3	6
DLNT702	M7	1	P2	130	35	26	5.5	3	6
DLNT802	M8	1.25	P2	140	40	30	6.2	3	6
DLNT803	M8	1	P2	140	38	28	6.2	3	6
DLNT804	M8	0.75	P2	120	30	23	6.2	3	6
DLNT902	M9	1.25	P2	150	45	34	7.2	3	6
DLNT1002	M10	1.5	P2	160	50	38	7.8	3	6
DLNT1003	M10	1.25	P2	160	48	36	7.8	3	6
DLNT1004	M10	1	P2	140	38	28	7.8	3	6
DLNT1102	M11	1.5	P2	165	55	41	8.8	3	6
DLNT1202	M12	1.75	P2	170	60	45	9	3	6
DLNT1203	M12	1.5	P2	170	58	43	9	3	6
DLNT1204	M12	1.25	P2	170	48	36	9	3	6
DLNT1205	M12	1	P2	140	40	30	9	3	6

Ordering code: Product code Selection of materials Surface treatment TYPE
For example: DLNT202 - CPM - TiN - 6

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

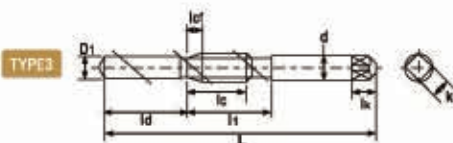
TiN

TiCN

DLC

Apex drill can be tapping before the bottom hole processing, improve processing efficiency. Special purpose.

尖部钻头可在加工底孔前进行攻丝加工，提高加工效率。特殊用途。



C35

Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长(L)	Bit length Ld 钻头长度	Thread length (Lc) 螺纹长度(Lc)	Outer diameter length D1 外径长度(D1)	Shank diameter (d) 柄径(d)	TYPE 类型				
DLDR-SFT101	M1	0.25	P1	2.5P	32	3	3	0.75	3	3				
DLDR-SFT111	M1.1	0.25	P1	2.5P	32	3	3	0.85	3	3				
DLDR-SFT121	M1.2	0.25	P1	2.5P	32	3	3	0.95	3	3				
DLDR-SFT141	M1.4	0.3	P1	2.5P	34	5	3	1.10	3	3				
DLDR-SFT161	M1.6	0.35	P1	2.5P	36	5	3	1.25	3	3				
DLDR-SFT171	M1.7	0.35	P1	2.5P	36	5	3	1.35	3	3				
DLDR-SFT172			P2	2.5P						3				
DLDR-SFT173			P3	2.5P						3				
DLDR-SFT181	M1.8	0.35	P1	2.5P	36	5	3	1.45	3	3				
DLDR-SFT201	M2	0.4	P1	2.5P	42	7	3.5	1.6	3	3				
DLDR-SFT202			P2	2.5P						3				
DLDR-SFT203			P3	2.5P						3				
DLDR-SFT204	M2.2	0.45	P4	2.5P	42	7	3.5	1.75	3	3				
DLDR-SFT221			P1	2.5P						3				
DLDR-SFT222			P2	2.5P						3				
DLDR-SFT223	M2.3	0.4	P3	2.5P	42	7	3.5	1.9	3	3				
DLDR-SFT224			P4	2.5P						3				
DLDR-SFT231			M2.5	0.45	P1	2.5P	44	7	3.5	2.05	3	3		
DLDR-SFT232	P2	2.5P			3									
DLDR-SFT233	P3	2.5P			3									
DLDR-SFT234	M2.6	0.45	P4	2.5P	44	8	3.5	2.15	3	3				
DLDR-SFT251			P1	2.5P						8	3.5			3
DLDR-SFT252			P2	2.5P										3
DLDR-SFT253	M3	0.5	P3	2.5P	46	11	4	2.5	4	3				
DLDR-SFT254			P4	2.5P						3				
DLDR-SFT261			M3.5	0.6	P1	2.5P	48	11	4	2.9	4	3		
DLDR-SFT262	P2	2.5P			3									
DLDR-SFT263	P3	2.5P			52	13						5	3.3	5
DLDR-SFT264	P4	2.5P	3											
DLDR-SFT301	M4	0.7	P1	2.5P	52	13	5	3.3	5	3				
DLDR-SFT302			P2	2.5P						3				
DLDR-SFT303			P3	2.5P						76	16	5.6	4.2	5.5
DLDR-SFT304	M5	0.8	P4	2.5P	3									
DLDR-SFT351			M6	1	P1	2.5P	81	19	7	5	6	3		
DLDR-SFT352	P2	2.5P			3									
DLDR-SFT353	M8	1.25			P3	2.5P	92	22	8.5	6.75	6.2	3		
DLDR-SFT354			P4	2.5P	3									
DLDR-SFT402			M10	1.5	P1	2.5P	99	24	10.5	8.5	7	3		
DLDR-SFT403	P2	2.5P			3									
DLDR-SFT404	M12	1.75			P3	2.5P	111	29	12	10.25	8.5	3		
DLDR-SFT405			P4	2.5P	3									
DLDR-SFT503			M12	1.75	P1	2.5P	111	29	12	10.25	8.5	3		
DLDR-SFT603	P2	2.5P			3									
DLDR-SFT803	M12	1.75			P3	2.5P	111	29	12	10.25	8.5	3		
DLDR-SFT1003			P4	2.5P	3									
DLDR-SFT1203			M12	1.75	P1	2.5P	111	29	12	10.25	8.5	3		
	P2	2.5P			3									

Ordering rule: Product code Selection of materials Surface treatment TYPE
For example: DLDR-SFT101- CPM - TiN - 3

METRIC THREAD

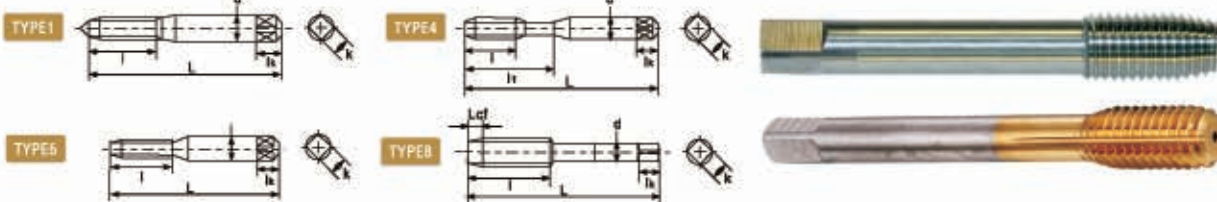
公制螺絲

Selection of materials → CARBIDE

Surface treatment → TIN T1CN TIALIN

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

对于铝合金、镁合金、铜合金的大量高精度加工、塑性变形无屑加工，可实现稳定的连续加工。



Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長 (mm)	Thread length (l) 螺紋長 (mm)	Second section length (l) 二重長 (mm)	Shank diameter (d) 柄徑 (mm)	TYPE 種類
DL8102534	M1	0.25	RH3	4P	30	7	-	3	1
DL8102532			RH3	2P					5
DL8102544			RH4	4P					1
DL8102542			RH4	2P					5
DL8122534	M1.2	0.25	RH3	4P	32	8	-	3	1
DL8122532			RH3	2P					5
DL8122544			RH4	4P					1
DL8122543			RH4	2P					5
DL8143034	M1.4	0.3	RH3	4P	34	9	-	3	1
DL8143032			RH3	2P					5
DL8143044			RH4	4P					1
DL8143042			RH4	2P					5
DL8163044	M1.6	0.35	RH4	4P	36	10	-	3	1
DL8163042			RH4	2P					5
DL8163054			RH5	4P					1
DL8163052			RH5	2P					5
DL8173544	M1.7	0.35	RH4	4P	36	11	-	3	1
DL8173542			RH4	2P					5
DL8173554			RH5	4P					1
DL8173552			RH5	2P					5
DL8173664			RH6	4P					1
DL8173662			RH6	2P					5
DL8183544	M1.8	0.35	RH4	4P	36	11	-	3	1
DL8183542			RH4	2P					5
DL8183554			RH5	4P					1
DL8183552			RH5	2P					5
DL8204044	M2	0.4	RH4	4P	40	12	-	3	1
DL8204042			RH4	2P					5
DL8204054			RH5	4P					1
DL8204052			RH5	2P					5
DL8204064			RH6	4P					1
DL8204062			RH6	2P					5
DL8234044	M2.3	0.4	RH4	4P	42	13	-	3	1
DL8234042			RH4	2P					5
DL8234054			RH5	4P					1
DL8234052			RH5	2P					5
DL8234064			RH6	4P					1
DL8234062			RH6	2P					5
DL8254544	M2.5	0.45	RH4	4P	44	14	-	3	1
DL8254542			RH4	2P					5
DL8254554			RH5	4P					1
DL8254552			RH5	2P					5
DL8254564			RH6	4P					1
DL8254562			RH6	2P					5
DL8264544	M2.6	0.45	RH4	4P	44	14	-	3	1
DL8264542			RH4	2P					5
DL8264554			RH5	4P					1
DL8264552			RH5	2P					5
DL8264564			RH6	4P					1
DL8264562			RH6	2P					5
DL8305054	M3	0.5	RH5	4P	46	9	18	4	1
DL8305052			RH5	2P					4

C36

Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Second section length (l') 二節長(l')	Shank diameter (d) 柄徑(d)	TYPE 形式
DL8356034	M3.5	0.6	RH3	4P	48	9	18	4	1
DL8356032			RH3	2P					4
DL8356054			RH5	4P					1
DL8356052			RH5	2P					4
DL8407044	M4	0.7	RH4	4P	52	10	20	5	1
DL8407042			RH4	2P					4
DL8407064			RH6	4P					1
DL8407062			RH6	2P					4
DL8508054	M5	0.8	RH4	4P	60	11	22	5.5	1
DL8508052			RH4	2P					4
DL8508064			RH6	4P					1
DL8508062			RH6	2P					4
DL86010074	M6	1	RH7	4P	62	12	24	6	1
DL86010072			RH7	2P					4
DL87010064	M7	1	RH6	4P	65	13	26	6.2	1
DL87010062			RH6	2P					4
DL88012574	M8	1.25	RH7	4P	70	18	-	6.2	8
DL88012572			RH7	2P					8
DL88010074	M8	1	RH7	4P	70	18	-	6.2	8
DL88010072			RH7	2P					8
DL810015074	M10	1.5	RH7	4P	75	19	-	7	8
DL810015072			RH7	2P					8
DL810012574	M10	1.25	RH7	4P	75	19	-	7	8
DL810012572			RH7	2P					8
DL810010074	M10	1	RH7	4P	75	19	-	7	8
DL810010072			RH7	2P					8
DL812017584	M12	1.75	RH7	4P					8
DL812017582			RH7	2P					8
DL812015074	M12	1.5	RH7	4P	82	23	-	8.5	8
DL812015072			RH7	2P					8
DL812012574	M12	1.25	RH7	4P					8
DL812012572			RH7	2P					8
DL812010074	M12	1	RH7	4P					8
DL812010072			RH7	2P					8
DL8140200104	M14	2	RH10	4P	88	25	-	10.5	8
DL8140200102			RH10	2P					8
DL8160200104	M16	2	RH10	4P	95	27	-	12.5	8
DL8160200102			RH10	2P					8
DL8180250114	M18	2.5	RH11	4P	100	29	-	14	8
DL8180250112			RH11	2P					8
DL8200250114	M20	2.5	RH11	4P	105	30	-	15	8
DL8200250112			RH11	2P					8



Drawing rule: **ISO** → Product code: **DL8356034** → Selection of material: **CARBIDE** → Surface treatment: **TIN** → TYPE: **1**
 For example: DL8356034 - CARBIDE - TIN - 1

LONG SHANK

Selection of materials

CARBIDE

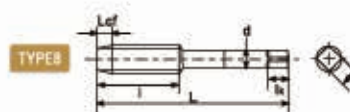
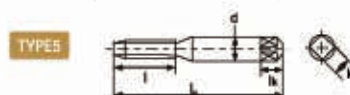
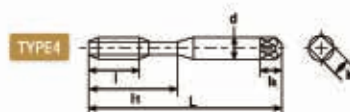
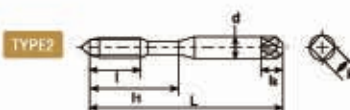
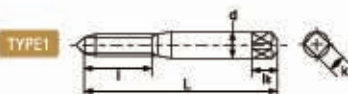
Surface treatment

TIN

TICN

TIALIN

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing



Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l')	Shank diameter (d)	TYPE
DL9102534	M1.0	0.25	RH3	4P	60	3.5	-	3	1
DL9102532			RH3	2P					5
DL912544	M1.2	0.25	RH4	4P	60	3.5	-	3	1
DL912542			RH4	2P					5
DL9143044	M1.4	0.3	RH4	4P	60	4.5	-	3	1
DL9143042			RH4	2P					5
DL9163544	M1.6	0.35	RH4	4P	60	5	-	3	1
DL9163542			RH4	2P					5
DL9204044	M2.0	0.4	RH4	4P	80	8	-	3	1
DL9204042			RH4	2P					5
DL9254544	M2.5	0.45	RH4	4P	80	9.5	-	3	1
DL9254542			RH4	2P					5
DL9305054	M3	0.5	RH5	4P	100	11	19	4	2
DL9305052			RH5	2P					4
DL9407064	M4	0.7	RH6	4P	100	13	21	5	2
DL9407062			RH6	2P					4
DL9508074	M5	0.8	RH7	4P	100	16	24	5.5	2
DL9508072			RH7	2P					4
DL96010074	M6	1	RH7	4P	100	19	29	6	2
DL96010072			RH7	2P					4
DL98012574	M8	1.25	RH7	4P	150	22	-	6.2	8
DL98012572			RH7	2P					8
DL910015074	M10	1.5	RH7	4P	150	24	-	7	8
DL910015072			RH7	2P					8
DL910012574		1.25	RH7	4P					8
DL910012572			RH7	2P					8
DL912017584	M12	1.75	RH8	4P	150	29	-	8.5	8
DL912017582			RH8	2P					8
DL912015074		1.5	RH7	4P					8
DL912015072			RH7	2P					8
DL912012574		1.25	RH7	4P					8
DL912012572			RH7	2P					8
DL9140200104	M14	2	RH10	4P	150	30	-	10.5	8
DL9140200102			RH10	2P					8
DL9160200104	M16	2	RH10	4P	200	32	-	12.5	8
DL9160200102			RH10	2P					8
DL9180250114	M18	2.5	RH11	4P	200	37	-	14	8
DL9180250112			RH11	2P					8
DL9200250114	M20	2.5	RH11	4P	200	37	-	15	8
DL9200250112			RH11	2P					8

Drawing rules → Product code → Selection of materials → Surface treatment → TYPE

For example: DL9102534 - CARBIDE - TIN - 1

Selection of materials

CARBIDE

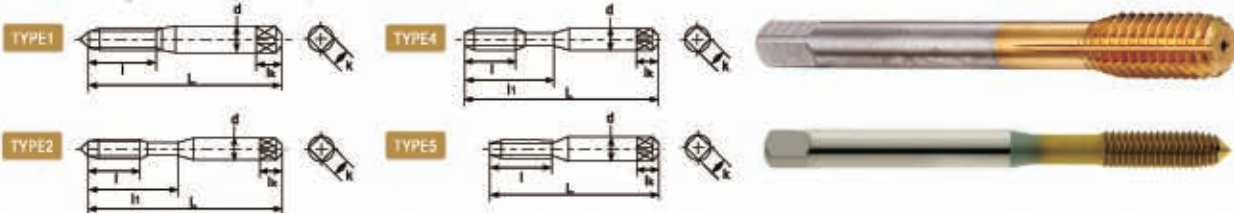
Surface treatment

TIN

TICN

TIALIN

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
对于铝、镁、铜合金，经过大量高精度加工，可实现无屑塑性变形，可稳定连续加工。



C39

Product code 商品规格	Specification 规格	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长 (mm)	Thread length (l) 螺纹长度 (mm)	Second section length (h) 第二锥段长度 (mm)	Shank diameter (d) 柄部直径 (mm)	TYPE 类型
DL1008034	No.0-80	RH3	4P	36	7	-	3	1
DL1008032		RH3	2P					5
DL1008054		RH5	4P					1
DL1008052		RH5	2P					5
DL1016434	No.1-64	RH3	4P	36	8	-	3	1
DL1016432		RH3	2P					5
DL1016454		RH5	4P					1
DL1016452		RH5	2P					5
DL1017234	No.1-72	RH3	4P	36	8	-	3	1
DL1017232		RH3	2P					5
DL1017254		RH5	4P					1
DL1017252		RH5	2P					5
DL1025644	No.2-56	RH4	4P	42	9	-	3	1
DL1025642		RH4	2P					5
DL1025664		RH6	4P					1
DL1025642		RH6	2P					5
DL1026434	No.2-64	RH3	4P	42	9	-	3	1
DL1026432		RH3	2P					5
DL1026454		RH5	4P					1
DL1026452		RH5	2P					5
DL1034844	No.3-48	RH4	4P	44	10	-	3	1
DL1034842		RH4	2P					5
DL1034864		RH6	4P					1
DL1034862		RH6	2P					5
DL1035644	No.3-56	RH4	4P	44	10	-	3	1
DL1035642		RH4	2P					5
DL1035664		RH6	4P					1
DL1035662		RH6	2P					5
DL1044054	No.4-40	RH5	4P	44	10	-	3	2
DL1044052		RH5	2P					4
DL1044074		RH7	4P					2
DL1044072		RH7	2P					4
DL1044844	No.4-48	RH4	4P	44	10	-	3	2
DL1044842		RH4	2P					4
DL1044864		RH6	4P					2
DL1044862		RH6	2P					4
DL1054054	No.5-40	RH5	4P	46	9	18	4	2
DL1054052		RH5	2P					4
DL1054074		RH7	4P					2
DL1054072		RH7	2P					4
DL1054454	No.5-44	RH5	4P	46	9	18	4	2
DL1054452		RH5	2P					4
DL1054474		RH7	4P					2
DL1054472		RH7	2P					4
DL1063254	No.6-32	RH5	4P	48	9	18	4	2
DL1063252		RH5	2P					4
DL1063274		RH7	4P					2
DL1063272		RH7	2P					4
DL1064054	No.6-40	RH5	4P	48	9	18	4	2
DL1064052		RH5	2P					4
DL1064074		RH7	4P					2
DL1064072		RH7	2P					4

UNIFIED THREAD

美制螺紋

C40

Product code 產品編號	Specification 規格	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Second section length (l1) 二節長 (l1)	Shank diameter (d) 柄徑(d)	TYPE 型號
DL1083254	No.8-32	RH5	4P	52	10	20	5	2
DL1083252		RH5	2P					4
DL1083274		RH7	4P					2
DL1083272		RH7	2P					4
DL1083654	No.8-36	RH5	4P	52	10	20	5	2
DL1083652		RH5	2P					4
DL1083674		RH7	4P					2
DL1083672		RH7	2P					4
DL10102464	No.10-24	RH6	4P	60	11	22	5.5	2
DL10102462		RH6	2P					4
DL10102484		RH8	4P					2
DL10102482		RH8	2P					4
DL10103254	No.10-32	RH5	4P	60	11	22	5.5	2
DL10103252		RH5	2P					4
DL10103274		RH7	4P					2
DL10103272		RH7	2P					4
DL10122464	No.12-24	RH6	4P	60	11	22	5.5	2
DL10122462		RH6	2P					4
DL10122484		RH8	4P					2
DL10122482		RH8	2P					4
DL10122854	No.12-28	RH5	4P	60	11	22	5.5	2
DL10122852		RH5	2P					4
DL10122874		RH7	4P					2
DL10122872		RH7	2P					4
DL10142064	No.1/4-20	RH6	4P	62	14	24	6	2
DL10142062		RH6	2P					4
DL10142084		RH8	4P					2
DL10142082		RH8	2P					4
DL10142854	No.1/4-28	RH5	4P	62	14	24	6	2
DL10142852		RH5	2P					4
DL10142874		RH7	4P					2
DL10142872		RH7	2P					4

Ordering rule
訂購規則

Product code
產品編號

Selection of material
材料選擇

Surface treatment
表面處理

TYPE
型號

For example: DL1083254 - CARBIDE - TIN - 2

SOLID CARBIDE SPIRAL FLUTED TAP SERIES

硬质合金螺旋槽丝锥
SOLID CARBIDE SPIRAL FLUTED TAP SERIES

Selection of materials
材料选择

CARBIDE
硬质合金

Surface treatment
表面处理

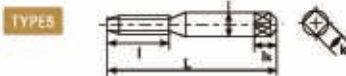
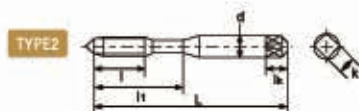
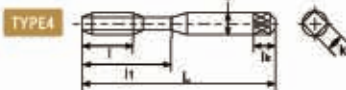
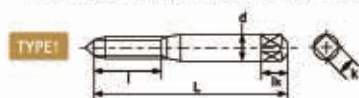
TIN
镀锡

TICN
氮化钛

TIALIN
氮化钛

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

对于铝合金、镁合金、铜合金的大量高精度加工，可实现无屑塑性变形，可稳定连续加工。



C41

Product code 产品规格	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长度(l)	Second section length (l) 二段长度(l)	Shank diameter (d) 柄径(d)	TYPE 类型
DLOT-SFT101	M1.0	0.25	P1	2.5P	32	5.5	-	3	1 2 4 5
DLOT-SFT121	M1.2	0.25	P1	2.5P	32	5.5	-	3	1 2 4 5
DLOT-SFT141	M1.4	0.30	P1	2.5P	34	7	-	3	1 2 4 5
DLOT-SFT161	M1.6	0.35	P1	2.5P	36	8	-	3	1 2 4 5
DLOT-SFT202	M2	0.4	P2	2.5P	42	9.5	15	3	1 2 4 5
DLOT-SFT203	M2	0.4	P2	1.5P	42	9.5	15	3	1 2 4 5
DLOT-SFT252	M2.5	0.45	P2	2.5P	44	9.5	16	3	1 2 4 5
DLOT-SFT253	M2.5	0.45	P2	1.5P	44	9.5	16	3	1 2 4 5
DLOT-SFT302	M3	0.5	P2	2.5P	46	11	19	4	1 2 4 5
DLOT-SFT303	M3	0.5	P2	1.5P	46	11	19	4	1 2 4 5
DLOT-SFT402	M4	0.7	P2	2.5P	52	13	21	5	1 2 4 5
DLOT-SFT403	M4	0.7	P2	1.5P	52	13	21	5	1 2 4 5
DLOT-SFT502	M5	0.8	P2	2.5P	60	16	24	5.5	1 2 4 5
DLOT-SFT503	M5	0.8	P2	1.5P	60	16	24	5.5	1 2 4 5
DLOT-SFT602	M6	1	P2	2.5P	62	19	29	6	1 2 4 5
DLOT-SFT603	M6	1	P2	1.5P	62	19	29	6	1 2 4 5
DLOT-SFT803	M8	1.25	P3	2.5P	70	22	-	6.2	1 2 4 5
DLOT-SFT804	M8	1.25	P3	1.5P	70	22	-	6.2	1 2 4 5
DLOT-SFT1003	M10	1.5	P3	2.5P	75	24	-	7	1 2 4 5
DLOT-SFT1004	M10	1.5	P3	1.5P	75	24	-	7	1 2 4 5
DLOT-SFT1005	M10	1.25	P3	2.5P	75	24	-	7	1 2 4 5
DLOT-SFT1006	M10	1.25	P3	1.5P	75	24	-	7	1 2 4 5
DLOT-SFT1204	M12	1.75	P4	2.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1205	M12	1.75	P4	1.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1206	M12	1.5	P3	2.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1207	M12	1.5	P3	1.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1208	M12	1.25	P3	2.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1209	M12	1.25	P3	1.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1404	M14	2	P4	2.5P	88	25	-	10.5	1 2 4 5
DLOT-SFT1405	M14	2	P4	1.5P	88	25	-	10.5	1 2 4 5
DLOT-SFT1604	M16	2	P4	2.5P	95	27	-	12.5	1 2 4 5
DLOT-SFT1605	M16	2	P4	1.5P	95	27	-	12.5	1 2 4 5
DLOT-SFT1804	M18	2.5	P4	2.5P	100	29	-	14	1 2 4 5
DLOT-SFT1805	M18	2.5	p4	1.5P	100	29	-	14	1 2 4 5
DLOT-SFT2004	M20	2.5	P4	2.5P	105	30	-	15	1 2 4 5
DLOT-SFT2005	M20	2.5	p4	1.5P	105	30	-	15	1 2 4 5

Drilling code → Product code → Selection of materials → Surface treatment → TYPE
For example: DLOT-SFT101- CARBIDE • TIN • 1

SOLID CARBIDE SPIRAL FLUTED TAP WITH INTERNAL COOLANT SUPPLY

高精密合金材料加工用高速鋼鑽頭

Selection of materials
材料選擇

CARBIDE
氮化鈣

Surface treatment
表面處理

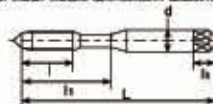
TIN
鍍錫

TICN
氮化鈦

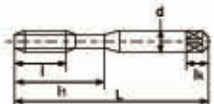
TIALIN
氮化鋁

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
用於鋁合金、鎂合金、銅合金的大量高精度加工，無切屑塑性變形，可實現穩定連續加工。

TYPE2



TYPE4



C42

Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 總長(L)	Thread length (l) 螺紋長(l)	Second section length (l) 二節長度(l)	Shank diameter (d) 柄徑(d)	TYPE 類型	
DLOTO-SFT602	M6	1	P2	1.5P	62	19	29	6	2	4
DLOTO-SFT803	M8	1.25	P3	1.5P	70	22	—	6.2	2	4
DLOTO-SFT1003	M10	1.5	P3	1.5P	75	23	—	7	2	4
DLOTO-SFT1004	M10	1.25	P3	1.5P	75	23	—	7	2	4
DLOTO-SFT1203	M12	1.75	P3	1.5P	82	25	—	8.5	2	4
DLOTO-SFT1204	M12	1.25	P3	1.5P	82	25	—	8.5	2	4
DLOTO-SFT1404	M14	2	P4	1.5P	88	25	—	10.5	2	4
DLOTO-SFT1604	M16	2	P4	1.5P	95	27	—	12.5	2	4
DLOTO-SFT1804	M18	2.5	P4	1.5P	100	29	—	14	2	4
DLOTO-SFT2004	M20	2.5	P4	1.5P	105	30	—	15	2	4

UNIFIED THREAD

美制螺紋

Selection of materials
材料選擇

CARBIDE
氮化鈣

Surface treatment
表面處理

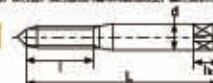
TIN
鍍錫

TICN
氮化鈦

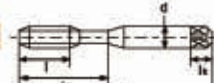
TIALIN
氮化鋁

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
用於鋁合金、鎂合金、銅合金的大量高精度加工，無切屑塑性變形，可實現穩定連續加工。

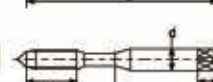
TYPE1



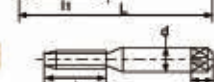
TYPE4



TYPE2



TYPE5

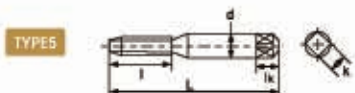
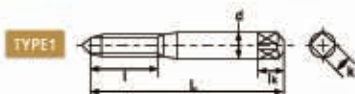


Product code 產品編號	Specification 規格	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 總長(L)	Thread length (l) 螺紋長(l)	Second section length (l) 二節長度(l)	Shank diameter (d) 柄徑(d)	TYPE 類型	
DLOT-SFTU801	No.0-80	P1	2.5P	36	8	—	3	1	5
DLOT-SFTU641	No.1-64	P1	2.5P					1	5
DLOT-SFTU721	No.1-72	P1	2.5P					1	5
DLOT-SFTU561	No.2-56	P1	2.5P	42	9.5	15	3	1	2
DLOT-SFTU642	No.2-64	P1	2.5P					4	5
DLOT-SFTU481	No.3-48	P1	2.5P	44	9.5	16	3	1	2
DLOT-SFTU562	No.3-56	P1	2.5P					4	5
DLOT-SFTU401	No.4-40	P1	2.5P	44	9.5	16	3	1	2
DLOT-SFTU402		P2	2.5P					4	5
DLOT-SFTU482	No.4-48	P1	2.5P	44	9.5	16	3	1	2
DLOT-SFTU483		P2	2.5P					4	5
DLOT-SFTU403	No.5-40	P1	2.5P	46	11	18	4	1	2
DLOT-SFTU404		P2	2.5P					4	5
DLOT-SFTU441	No.5-44	P1	2.5P	46	11	18	4	1	2
DLOT-SFTU442		P2	2.5P					4	5
DLOT-SFTU322	No.6-32	P2	2.5P	48	13	20	4	1	2
DLOT-SFTU323		P3	2.5P					4	5
DLOT-SFTU405	No.6-40	P2	2.5P	48	13	20	4	1	2
DLOT-SFTU406		P3	2.5P					4	5
DLOT-SFTU324	No.8-32	P2	2.5P	52	13	21	5	1	2
DLOT-SFTU362	No.8-36	P2	2.5P					4	5
DLOT-SFTU242	No.10-24	P2	2.5P	60	16	24	5.5	1	2
DLOT-SFTU325	No.10-32	P2	2.5P					4	5
DLOT-SFTU243	No.12-24	P2	2.5P	60	17	25	5.5	1	2
DLOT-SFTU282	No.12-28	P2	2.5P					4	5

Selection of materials → CARBIDE

Surface treatment → TIN → TiCN → TiAlN

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
对于铝、镁、铜合金大批量精密加工，连续切削，稳定连续加工。



C43

Product code 产品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 总长度	Thread length (l) 螺纹长度	Second section length (l') 第二段长度	Shank diameter (d) 柄部直径	TYPE 类型
DLOT-LS-SFT202	M2.0	0.4	P2	2.5P	100	9	—	3	1 5
DLOT-LS-SFT252	M2.5	0.45	P2	2.5P	150	9	—	3	1 5
DLOT-LS-SFT302	M3	0.5	P2	2.5P	100	11	19	4	1 5
DLOT-LS-SFT303			P2	2.5P	150				1 5
DLOT-LS-SFT402	M4	0.7	P2	2.5P	100	13	21	5	1 5
DLOT-LS-SFT403			P2	2.5P	150				1 5
DLOT-LS-SFT502	M5	0.8	P2	2.5P	100	16	24	5.5	1 5
DLOT-LS-SFT503			P2	2.5P	150				1 5
DLOT-LS-SFT602	M6	1	P2	2.5P	100	19	29	6	1 5
DLOT-LS-SFT603			P2	2.5P	150				1 5
DLOT-LS-SFT803	M8	1.25	P3	2.5P	100	22	37	6.2	1 5
DLOT-LS-SFT804			P3	2.5P	150				1 5
DLOT-LS-SFT1003		1.5	P3	2.5P	100				1 5
DLOT-LS-SFT1004	M10		P3	2.5P	150	24	41	7	1 5
DLOT-LS-SFT1005		1.25	P3	2.5P	100				1 5
DLOT-LS-SFT1006			P3	2.5P	150				1 5
DLOT-LS-SFT1203	M12	1.75	P3	2.5P	150				1 5
DLOT-LS-SFT1204			P3	2.5P	200				1 5
DLOT-LS-SFT1205	M12	1.5	P3	2.5P	150	29	48	8.5	1 5
DLOT-LS-SFT1206			P3	2.5P	200				1 5
DLOT-LS-SFT1207	M12	1.25	P3	2.5P	150				1 5
DLOT-LS-SFT1208			P3	2.5P	200				1 5
DLOT-LS-SFT1403	M14	2	P3	2.5P	150				1 5
DLOT-LS-SFT1404			P3	2.5P	200	30	48	10.5	1 5
DLOT-LS-SFT1405	M14	1.5	P3	2.5P	150				1 5
DLOT-LS-SFT1406			P3	2.5P	200				1 5
DLOT-LS-SFT1603	M16	2	P3	2.5P	150				1 5
DLOT-LS-SFT1604			P3	2.5P	200	32	52	12.5	1 5
DLOT-LS-SFT1605	M16	1.5	P3	2.5P	150				1 5
DLOT-LS-SFT1606			P3	2.5P	200				1 5
DLOT-LS-SFT1803	M18	2.5	P3	2.5P	150				1 5
DLOT-LS-SFT1804			P3	2.5P	200	37	55	14	1 5
DLOT-LS-SFT1805	M18	1.5	P3	2.5P	150				1 5
DLOT-LS-SFT1806			P3	2.5P	200				1 5
DLOT-LS-SFT2003	M20	2.5	P3	2.5P	150				1 5
DLOT-LS-SFT2004			P3	2.5P	200	37	58	15	1 5
DLOT-LS-SFT2005	M20	1.5	P3	2.5P	150				1 5
DLOT-LS-SFT2006			P3	2.5P	200				1 5
DLOT-LS-SFT2204	M22	2.5	P4	2.5P	150				1 5
DLOT-LS-SFT2205			P4	2.5P	200	38	63	17	1 5
DLOT-LS-SFT2206	M22	1.5	P3	2.5P	150				1 5
DLOT-LS-SFT2207			P3	2.5P	200				1 5
DLOT-LS-SFT2404	M24	3	P4	2.5P	150				1 5
DLOT-LS-SFT2405			P4	2.5P	200	45	66	19	1 5
DLOT-LS-SFT2408	M24	1.5	P3	2.5P	150				1 5
DLOT-LS-SFT2409			P3	2.5P	200				1 5

Drawing note → Product code → Selection of materials → Surface treatment → TYPE
For example: DLOT-LS-SFT202- CARBIDE - TIN - 1

CARBIDE PARALLEL PIPE THREAD TAP WITH SPIRAL FLUTE

硬质合金螺旋槽平行管螺纹丝锥

Selection of materials

材料选择

CARBIDE

硬质合金

Surface treatment

表面处理

TIN

镀锡

TICN

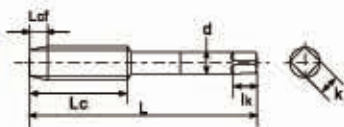
氮化钛

TIALIN

氮化铝

Taper pipe thread machining, suitable for blind and prone to blocking thread processing chip
锥管螺纹加工, 适合于盲孔及容易产生切屑堵塞的加工。

TYPE8



Product code 产品规格	Specification 规格	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (Lc) 螺纹长(Lc)	Shank diameter (d) 柄径(d)	TYPE 规格
DLSFT-PF182	1/8-28	P2	2.5P	55	19	8	8
DLSFT-PF142	1/4-19	P2	2.5P	62	28	11	8
DLSFT-PF382	3/8-19	P2	2.5P	65	28	14	8
DLSFT-PF122	1/2-14	P2	2.5P	80	35	18	8
DLSFT-PF342	3/4-14	P2	2.5P	85	35	23	8
DLSFT-PF1002	1-11	P2	2.5P	95	45	26	8
DLSFT-PF1142	1 1/4-11	P2	2.5P	105	45	32	8
DLSFT-PF1122	1 1/2-11	P2	2.5P	110	45	38	8

LONG SHANK CARBIDE PARALLEL PIPE THREAD TAP WITH SPIRAL FLUTE

硬质合金螺旋槽长柄平行管螺纹丝锥

Selection of materials

材料选择

CARBIDE

硬质合金

Surface treatment

表面处理

TIN

镀锡

TICN

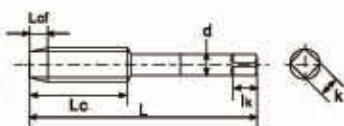
氮化钛

TIALIN

氮化铝

Taper pipe thread machining, suitable for blind and prone to blocking thread processing chip
锥管螺纹加工, 适合于盲孔及容易产生切屑堵塞的加工。

TYPE8



Product code 产品规格	Specification 规格	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (Lc) 螺纹长(Lc)	Shank diameter (d) 柄径(d)	Type 规格
DLSFTS-PT182	1/8-28	P2	2.5P	120	19	8	8
DLSFTS-PT142	1/4-19	P2	2.5P	120	28	11	8
DLSFTS-PT382	3/8-19	P2	2.5P	120	28	14	8
DLSFTS-PT122	1/2-14	P2	2.5P	150	35	18	8
DLSFTS-PT342	3/4-14	P2	2.5P	150	35	23	8
DLSFTS-PT1002	1-11	P2	2.5P	150	45	26	8

Drawing rule: Product code Selection of materials Surface treatment TYPE
For example: DLSFT-PF182 - CARBIDE - TIN - 8

SOLID CARBIDE SPIRAL POINTED TAP

硬質合金刀頭螺旋絲鑽
SOLID CARBIDE SPIRAL FLUTED TAP SERIES

Selection of materials
材料選擇

CARBIDE
硬質合金

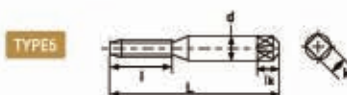
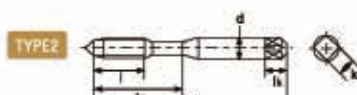
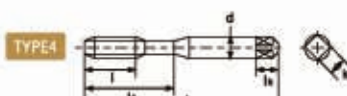
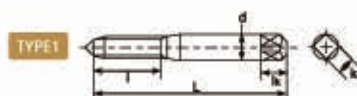
Surface treatment
表面處理

TIN
鍍錫

TICN
氮化鈦

TIALIN
氮化鋁

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
對於鋁合金、鎂合金、銅合金大量高精度加工，無切屑塑性變形，可實現穩定連續加工。



C45

Product code 產品代碼	Specifications 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長 (mm)	Thread length (l) 螺紋長度 (mm)	Second section length (l) 二重螺紋 (mm)	Shank diameter (d) 柄徑 (mm)	TYPE 類型
DLOT-POT101	M1.0	0.25	P1	5P	32	5.5	—	3	1 2 4 5
DLOT-POT121	M1.2	0.25	P1	5P	32	5.5	—	3	1 2 4 5
DLOT-POT141	M1.4	0.30	P1	5P	34	7	—	3	1 2 4 5
DLOT-POT161	M1.6	0.35	P1	5P	36	8	—	3	1 2 4 5
DLOT-POT202	M2.0	0.40	P2	5P	42	9	15	3	1 2 4 5
DLOT-POT252	M2.5	0.45	P2	5P	44	9	16	3	1 2 4 5
DLOT-POT302	M3	0.5	P2	5P	46	11	19	4	1 2 4 5
DLOT-POT303			P3	5P					1 2 4 5
DLOT-POT352	M3.5	0.6	P2	5P	48	13	20	4	1 2 4 5
DLOT-POT353			P3	5P					1 2 4 5
DLOT-POT402	M4	0.7	P2	5P	52	13	21	5	1 2 4 5
DLOT-POT403			P3	5P					1 2 4 5
DLOT-POT502	M5	0.8	P2	5P	60	16	24	5.5	1 2 4 5
DLOT-POT503			P3	5P					1 2 4 5
DLOT-POT602	M6	1	P2	5P	62	19	29	6	1 2 4 5
DLOT-POT603			P3	5P					1 2 4 5
DLOT-POT803	M8	1.25	P3	5P	70	22	37	6.2	1 2 4 5
DLOT-POT804			P4	5P					1 2 4 5
DLOT-POT805		1.5	P3	5P	70				1 2 4 5
DLOT-POT806			P4	5P					1 2 4 5
DLOT-POT1003	M10	1.5	P3	5P	75				1 2 4 5
DLOT-POT1004			P4	5P					1 2 4 5
DLOT-POT1005	M10	1.25	P3	5P	75	24	41	7	1 2 4 5
DLOT-POT1006			P4	5P					1 2 4 5
DLOT-POT1007	M10	1	P3	5P	75				1 2 4 5
DLOT-POT1008			P4	5P					1 2 4 5
DLOT-POT1204	M12	1.75	P4	5P	82	29	48	8.5	1 2 4 5
DLOT-POT1205			P5	5P					1 2 4 5
DLOT-POT1206	M12	1.5	P3	5P	82	29	48	8.5	1 2 4 5
DLOT-POT1207			P4	5P					1 2 4 5
DLOT-POT1208	M12	1.25	P4	5P					1 2 4 5
DLOT-POT1209			P5	5P					1 2 4 5
DLOT-POT1210	M12	1	P3	5P	82	29	48	8.5	1 2 4 5
DLOT-POT1211			P4	5P					1 2 4 5
DLOT-POT1404	M14	2	P4	5P	88	30	48	10.5	1 2 4 5
DLOT-POT1405		1.5	P3	5P					1 2 4 5
DLOT-POT1604	M16	2	P4	5P	96	32	52	12.5	1 2 4 5
DLOT-POT1605		1.5	P3	5P					1 2 4 5
DLOT-POT1804	M18	2.5	P4	5P	100	37	55	14	1 2 4 5
DLOT-POT1805		1.5	P4	5P					1 2 4 5
DLOT-POT2004	M20	2.5	P4	5P	105		58	15	1 2 4 5
DLOT-POT2005		1.5	P4	5P					1 2 4 5
DLOT-POT2204	M22	2.5	P4	5P	115	38	63	17	1 2 4 5
DLOT-POT2205		1.5	P4	5P					1 2 4 5
DLOT-POT2404	M24	3	P4	5P	120	45	66	19	1 2 4 5
DLOT-POT2405		1.5	P4	5P					1 2 4 5

Ordering rule 產品代碼 Selection of materials 表面處理 TYPE

For example: DLOT-POT101- CARBIDE - TIN - 1

CARBIDE

TIALIN

TIALIN

[illegible]

For example: DLOT-LPOT202- CARBIDE - TIN - 1

GENERAL APPLICATION UNIFIED THREAD FORM SOLID CARBIDE SPIRAL FLUTED TAP SERIES

硬質合金刀頭用絲錐

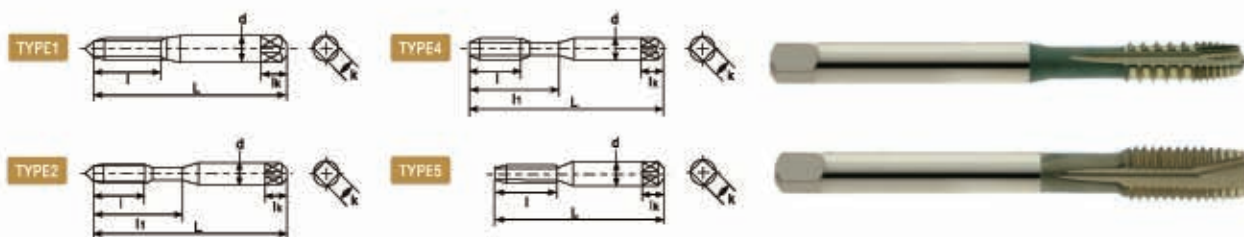
一般用途硬質合金刀頭用絲錐

Selection of materials → CARBIDE

Surface treatment → TIN → TICN → TIALIN

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

對於鋁合金、鎂合金、銅合金大量高精度加工，無切屑塑性變形，可實現穩定連續加工。



C47

Product code 產品型號	Specifications 規格	Accuracy class 精度等級	Cutting cone length 切屑錐長度	Overall length (L) 總長度 (mm)	Thread length (l) 螺紋長度 (mm)	Second section length (l) 第二段長度 (mm)	Shank diameter (d) 柄部直徑 (mm)	TYPE 分類	
DLOT-POTU801	No.0-80	P1	2.5P	36	8	-	3	1	5
DLOT-POTU641	No.1-64	P1	2.5P					1	5
DLOT-POTU721	No.1-72	P1	2.5P					1	5
DLOT-POTU561	No.2-56	P1	2.5P	42	9.5	15	3	1	2
DLOT-POTU642	No.2-64	P1	2.5P					1	2
DLOT-POTU481	No.3-48	P1	2.5P	44	9.5	16	3	1	2
DLOT-POTU562	No.3-56	P1	2.5P					1	2
DLOT-POTU401	No.4-40	P1	2.5P	44	9.5	16	3	1	2
DLOT-POTU402		P2	2.5P					1	2
DLOT-POTU482		P1	2.5P					1	2
DLOT-POTU483	No.4-48	P2	2.5P	46	11	18	4	1	2
DLOT-POTU403	No.5-40	P1	2.5P					1	2
DLOT-POTU404		P2	2.5P					1	2
DLOT-POTU441	No.5-44	P1	2.5P					1	2
DLOT-POTU442		P2	2.5P					1	2
DLOT-POTU322	No.6-32	P2	2.5P	48	13	20	4	1	2
DLOT-POTU323		P3	2.5P					1	2
DLOT-POTU405	No.6-40	P2	2.5P					1	2
DLOT-POTU406		P3	2.5P	52	13	21	5	1	2
DLOT-POTU324	No.8-32	P2	2.5P					1	2
DLOT-POTU362	No.8-36	P2	2.5P	60	16	24	5.5	1	2
DLOT-POTU242	No.10-24	P2	2.5P					1	2
DLOT-POTU325	No.10-32	P2	2.5P	60	17	25	5.5	1	2
DLOT-POTU243	No.12-24	P2	2.5P					1	2
DLOT-POTU282	No.12-28	P2	2.5P					1	2

Drawing rules → Product code → Selection of materials → Surface treatment → TYPE
For example: DLOT-POTU801- CARBIDE - TIN - 1

METRIC THREAD

Selection of materials

CARBIDE

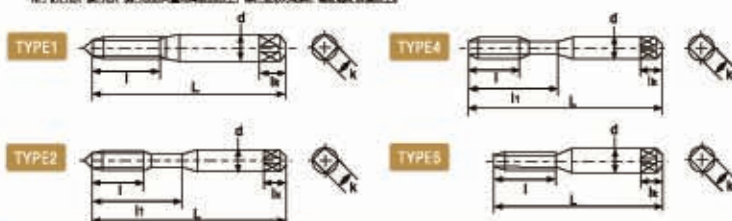
Surface treatment

TIN

TICN

TIALIN

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing



Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Shank diameter (d)	TYPE	
DLOTT101	M1.0	0.25	P1	3P	30	5.5	3	1	5
DLOTT121	M1.2	0.25	P1	3P	32	5.5	3	1	5
DLOTT143		0.3	P2	3P	34	9	3	1	5
DLOTT141			P2	1.5P				1	5
DLOTT163	M1.6	0.35	P3	3P	36	9	3	1	5
DLOTT161			P3	1.5P				1	5
DLOTT173	M1.7	0.35	P3	3P	36	11	3	1	5
DLOTT171			P3	1.5P				1	5
DLOTT183	M1.8	0.35	P3	3P	36	11	3	1	5
DLOTT181			P3	1.5P				1	5
DLOTT203	M2	0.4	P3	3P	40	12	3	1 2 4 5	
DLOTT201			P3	1.5P				1 2 4 5	
DLOTT233	M2.3	0.4	P3	3P	42	13	3	1 2 4 5	
DLOTT231			P3	1.5P				1 2 4 5	
DLOTT253	M2.5	0.45	P3	3P	44	14	3	1 2 4 5	
DLOTT251			P3	1.5P				1 2 4 5	
DLOTT263	M2.6	0.45	P3	3P	44	14	3	1 2 4 5	
DLOTT261			P3	1.5P				1 2 4 5	
DLOTT303	M3	0.5	P3	3P	46	11	4	1 2 4 5	
DLOTT301			P3	1.5P				1 2 4 5	
DLOTT403	M4	0.7	P3	3P	52	13	4	1 2 4 5	
DLOTT401			P3	1.5P				1 2 4 5	
DLOTT503	M5	0.8	P3	3P	60	16	5.5	1 2 4 5	
DLOTT501			P3	1.5P				1 2 4 5	
DLOTT603	M6	1	P3	3P	62	19	6	1 2 4 5	
DLOTT601			P3	1.5P				1 2 4 5	
DLOTT803		1.25	P4	3P				1 2 4 5	
DLOTT801	M8		P4	1.5P	70	22	6.2	1 2 4 5	
DLOTT804		1	P3	3P				1 2 4 5	
DLOTT805			P3	1.5P				1 2 4 5	
DLOTT1003		1.5	P4	3P		24		4 5	
DLOTT1001			P4	1.5P	75		7	4 5	
DLOTT1002	M10	1.25	P4	3P		20		4 5	
DLOTT1004			P4	1.5P				4 5	
DLOTT1005		1	P3	3P	75	20	7	4 5	
DLOTT1006			P3	1.5P				4 5	
DLOTT1203		1.75	P5	3P				4 5	
DLOTT1201			P5	1.5P	82	29	8.5	4 5	
DLOTT1204		1.5	P4	3P				4 5	
DLOTT1205			P4	1.5P				4 5	
DLOTT1206		1.25	P4	3P				4 5	
DLOTT1207			P4	1.5P	80	24	8.5	4 5	
DLOTT1208		1	P3	3P				4 5	
DLOTT1209			P3	1.5P				4 5	
DLOTT1403		2	P4	3P				4 5	
DLOTT1401			P4	1.5P	88	29	10.5	4 5	
DLOTT1404		1.5	P4	3P				4 5	
DLOTT1405			P4	1.5P		22		4 5	
DLOTT1603		2	P5	3P				4 5	
DLOTT1601			P5	1.5P	95	29	12.5	4 5	
DLOTT1604		1.5	P4	3P				4 5	
DLOTT1605			P4	1.5P				4 5	

Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Shank diameter (d) 柄徑(d)	TYPE 型號	
DLOTT1803	M18	2.5	P5	3P	100	35	14	4	5
DLOTT1801			P5	1.5P				4	5
DLOTT1804		1.5	P4	3P	95	29	14	4	5
DLOTT1805			P4	1.5P				4	5
DLOTT2003	M20	2.5	P5	3P	105	35	15	4	5
DLOTT2001			P5	1.5P				4	5
DLOTT2004		1.5	P4	3P	95	29	15	4	5
DLOTT2005			P4	1.5P				4	5
DLOTT2203	M22	2.5	P5	3P	115	35	17	4	5
DLOTT2201			P5	1.5P				4	5
DLOTT2204		1.5	P4	3P	95	29	17	4	5
DLOTT2205			P4	1.5P				4	5
DLOTT2403	M24	3	P5	3P	120	35	19	4	5
DLOTT2401			P5	1.5P				4	5
DLOTT2404		1.5	P4	3P	95	29	19	4	5
DLOTT2405			P4	1.5P				4	5



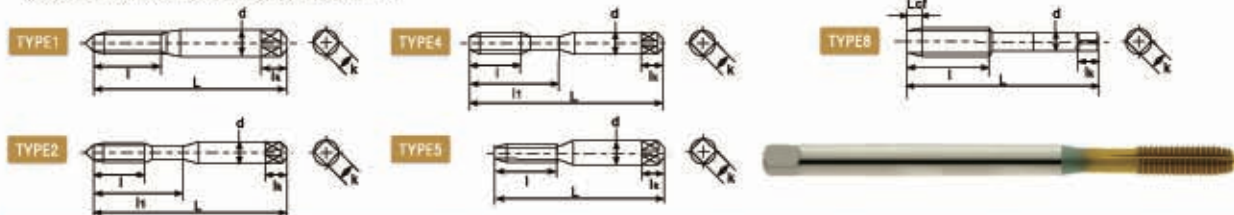
C49

Drawing code
圖號
 Product code
產品編號
 Selection of material
材料選擇
 Surface treatment
表面處理
 TYPE
型號
 For example: DLOTT1803 - CARBIDE - TIN - 4

Selection of materials → CARBIDE

Surface treatment → TIN T1CN TIALIN

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing



Product code 製品番号	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐長	Overall length (L) 全長	Thread length (l) 螺紋長	Shank diameter (d) 軸径	TYPE 型式			
DLLS-OTT202	M2.0	0.4	P2	3P	80	9	3	1	2	4	5
DLLS-OTT252	M2.5	0.45	P3	3P	80	9	3	1	2	4	5
DLLS-OTT303	M3	0.5	P2	3P	100	18	4	1	2	4	5
DLLS-OTT301			P3	1.5P				1	2	4	5
DLLS-OTT403	M4	0.7	P3	3P	100	20	5	1	2	4	5
DLLS-OTT401			P3	1.5P				1	2	4	5
DLLS-OTT503	M5	0.8	P3	3P	100	22	5.5	1	2	4	5
DLLS-OTT501			P3	1.5P				1	2	4	5
DLLS-OTT603	M6	1	P3	3P	100	24	6	1	2	4	5
DLLS-OTT601			P3	1.5P				1	2	4	5
DLLS-OTT803	M8	1.25	P4	3P	150	22	6.2	8			
DLLS-OTT801			P4	1.5P				8			
DLLS-OTT804		1	P3	3P	150	22	6.2	8			
DLLS-OTT805			P3	1.5P				8			
DLLS-OTT1003	M10	1.5	P4	3P	150	24	7	8			
DLLS-OTT1001			P4	1.5P				8			
DLLS-OTT1004		1.25	P4	3P	150			8			
DLLS-OTT1005			P4	1.5P				8			
DLLS-OTT1006		1	P3	3P	150			8			
DLLS-OTT1007			P3	1.5P				8			
DLLS-OTT1203	M12	1.75	P4	3P	150	29	8.5	8			
DLLS-OTT1201			P4	1.5P				8			
DLLS-OTT1204		1.5	P4	3P	150			8			
DLLS-OTT1205			P4	1.5P				8			
DLLS-OTT1206		1.25	P4	3P	150			8			
DLLS-OTT1207			P4	1.5P				8			
DLLS-OTT1208		1	P3	3P	150			8			
DLLS-OTT1209			P3	1.5P				8			
DLLS-OTT1403	M14	2	P4	3P	150	29	10.5	8			
DLLS-OTT1401			P4	1.5P				8			
DLLS-OTT1404		1.5	P4	3P	150	22		8			
DLLS-OTT1405			P4	1.5P				8			
DLLS-OTT1603	M16	2	P5	3P	150	29	12.5	8			
DLLS-OTT1601			P5	1.5P				8			
DLLS-OTT1604		1.5	P4	3P	150	29		8			
DLLS-OTT1605			P4	1.5P				8			
DLLS-OTT1803	M18	2.5	P5	3P	150	35	14	8			
DLLS-OTT1801			P5	1.5P				8			
DLLS-OTT1804		1.5	P4	3P	150	29		8			
DLLS-OTT1805			P4	1.5P				8			
DLLS-OTT2003	M20	2.5	P5	3P	150	35	15	8			
DLLS-OTT2001			P5	1.5P				8			
DLLS-OTT2004		1.5	P4	3P	150	29		8			
DLLS-OTT2005			P4	1.5P				8			
DLLS-OTT2203	M22	2.5	P5	3P	150	35	17	8			
DLLS-OTT2201			P5	1.5P				8			
DLLS-OTT2204		1.5	P4	3P	150	29		8			
DLLS-OTT2205			P4	1.5P				8			
DLLS-OTT2403	M24	3	P5	3P	150	35	19	8			
DLLS-OTT2401			P5	1.5P				8			
DLLS-OTT2404		1.5	P4	3P	150	29		8			
DLLS-OTT2405			P4	1.5P				8			

LONG SHANK TAPER PIPE THREAD TAP WITH STRAIGHT FLUTE

硬質合金刀頭鉗絲鑽
STRAIGHT FLUTED CARBIDE TAP SERIES

Selection of materials
材料選擇

CARBIDE
鉍

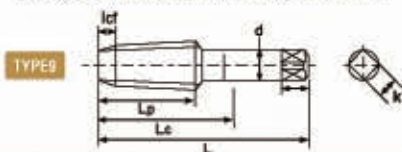
Surface treatment
表面處理

TIN
鍍錫

TICN
氮化鈦

TIALIN
氮化鋁

For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing
用于鋁合金、鎂合金、銅合金大量高精度加工，能實現無屑塑性變形，能實現穩定連續加工。



C51

Product code 產品編號	Specification 規格	Accuracy class 精度等級	Cutting cone length 切屑錐長度	Overall length (L) 全長(L)	Thread length (Lc) 螺紋長(Lc)	Second section length (Lp) 二重長(Lp)	Shank diameter (d) 柄徑(d)	TYPE 型號
DLOT-LS-PT181	1/8-28	P2	2.5P	100	19	13	8	9
DLOT-LS-PT182		P2	2.5P	150				9
DLOT-LS-PT141	1/4-19	P2	2.5P	100	28	21	11	9
DLOT-LS-PT142		P2	2.5P	150				9
DLOT-LS-PT381	3/8-19	P2	2.5P	100	28	21	14	9
DLOT-LS-PT382		P2	2.5P	150				9
DLOT-LS-PT121	1/2-14	P2	2.5P	150	35	25	18	9
DLOT-LS-PT341	3/4-14	P2	2.5P	150	35	25	23	9
DLOT-LS-PT1001	1-11	P2	2.5P	150	45	32	26	9

STRAIGHT FLUTED CARBIDE PARALLEL PIPE THREAD TAP

硬質合金直柄平行管鉗絲

Selection of materials
材料選擇

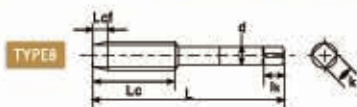
CARBIDE
鉍

Surface treatment
表面處理

TIN
鍍錫

TICN
氮化鈦

TIALIN
氮化鋁



Product code 產品編號	Specifications 規格	Accuracy class 精度等級	Cutting cone length 切屑錐長度	Overall length L 全長L	Thread length Lc 螺紋長Lc	Shank diameter d 柄徑d	TYPE 型號
DLOT-SPT181	1/8-28	P2	3P	55	19	8	8
DLOT-SPT141	1/4-19	P2	3P	62	28	11	8
DLOT-SPT381	3/8-19	P2	3P	65	28	14	8
DLOT-SPT121	1/2-14	P2	3P	80	35	18	8
DLOT-SPT341	3/4-14	P2	3P	85	35	23	8
DLOT-SPT1001	1-11	P2	3P	95	45	26	8

LONG SHANK CARBIDE PARALLEL PIPE THREAD TAP STRAIGHT FLUTE

硬質合金長柄鉗絲平行管鉗絲

Selection of materials
材料選擇

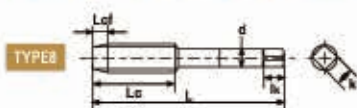
CARBIDE
鉍

Surface treatment
表面處理

TIN
鍍錫

TICN
氮化鈦

TIALIN
氮化鋁



Product code 產品編號	Specifications 規格	Accuracy class 精度等級	Cutting cone length 切屑錐長度	Overall length L 全長L	Thread length Lc 螺紋長Lc	Shank diameter d 柄徑d	TYPE 型號
DLOT-LS-SPT181	1/8-28	P2	3P	100	19	8	8
DLOT-LS-SPT182		P2	3P	150			8
DLOT-LS-SPT141	1/4-19	P2	3P	100	28	11	8
DLOT-LS-SPT142		P2	3P	150			8
DLOT-LS-SPT381	3/8-19	P2	3P	100	28	14	8
DLOT-LS-SPT382		P2	3P	150			8
DLOT-LS-SPT121	1/2-14	P2	3P	150	35	18	8
DLOT-LS-SPT341	3/4-14	P2	3P	150	35	23	8
DLOT-LS-SPT1001	1-11	P2	3P	150	45	26	8

ACCURACY OF P

P 精度

$P < 0.6$ (40牙以上)

上公差: $0.010 + 0.015 \times n$

下公差: 上公差 - 0.015

单位: mm Unit: mm ($n = P$ 号) (P number)

$P < 0.6$ (T.P.I. > 40)

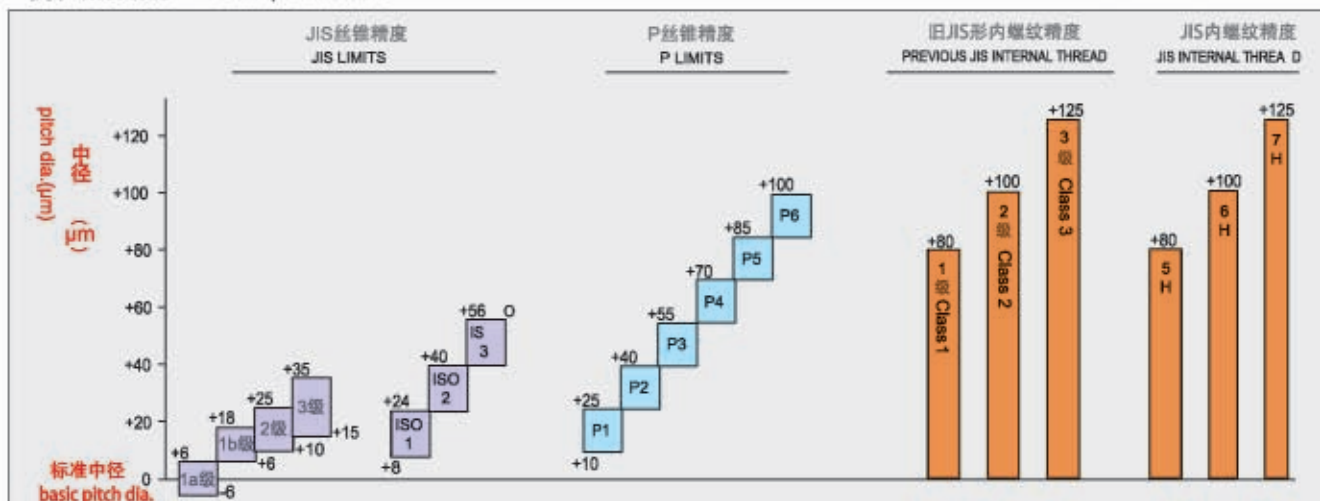
upper limit: $0.010 + 0.015 \times n$

lower limit: (upper limit) - 0.015

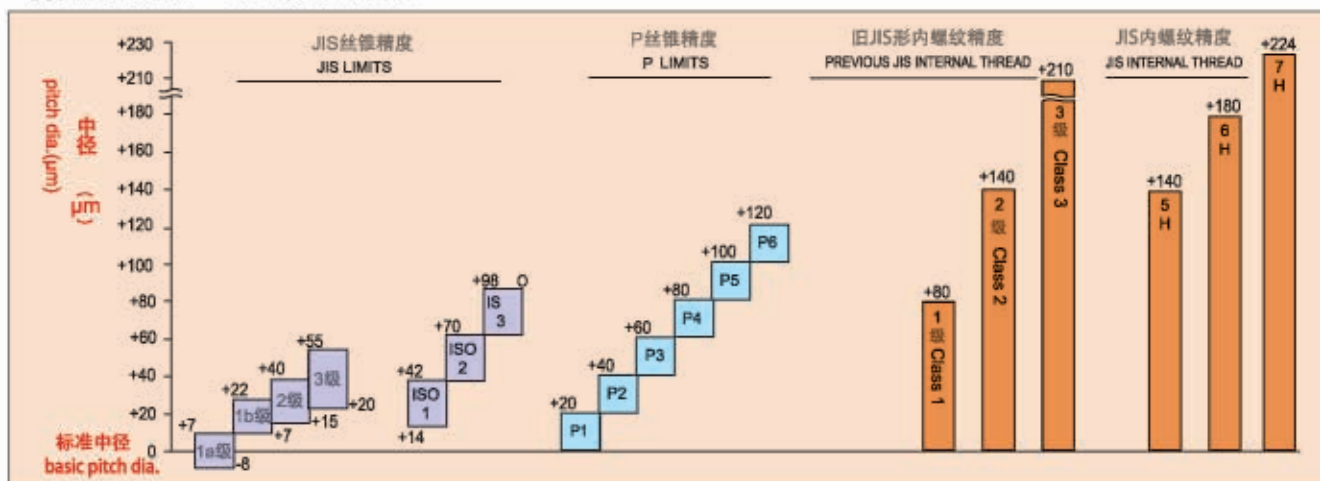
Almost all cutting tap has adapted some accuracy, the accuracy has to or higher than that JIS2 level equal accuracy according to the pitch will tap in size according to the following partition.

几乎所有的切削丝锥都适应此精度, 该精度具有JIS2级或以上的精度, 根据螺距将丝锥中径按以下划分。

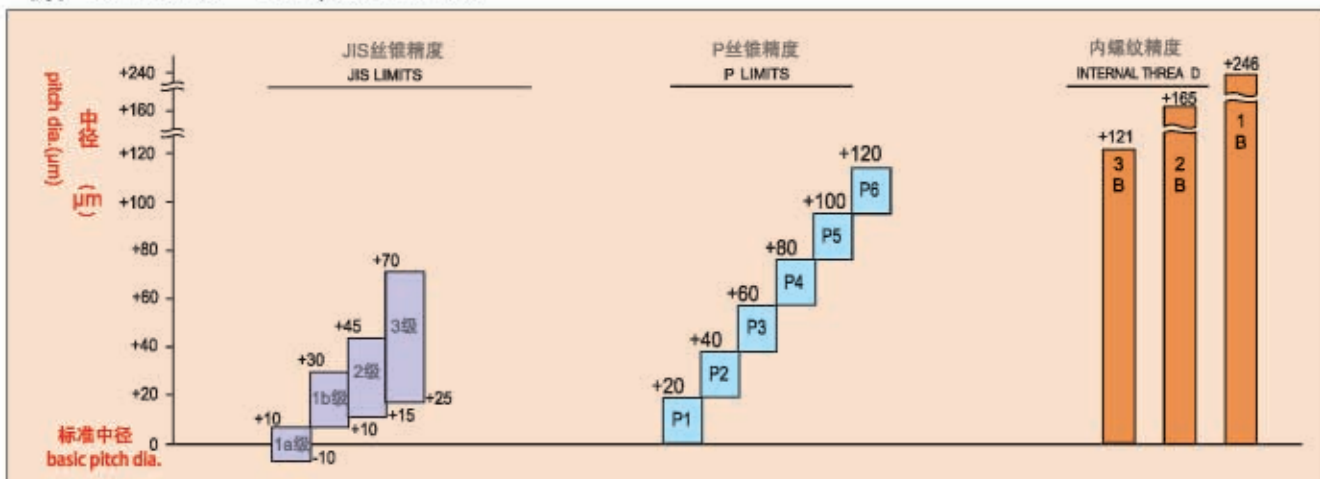
例: M3X0.5 Example: M3X0.5



例: M10X1.5 Example: M10X1.5



例: 1/2-13UNC Example: 1/2-13UNC



ACCURACY OF RH

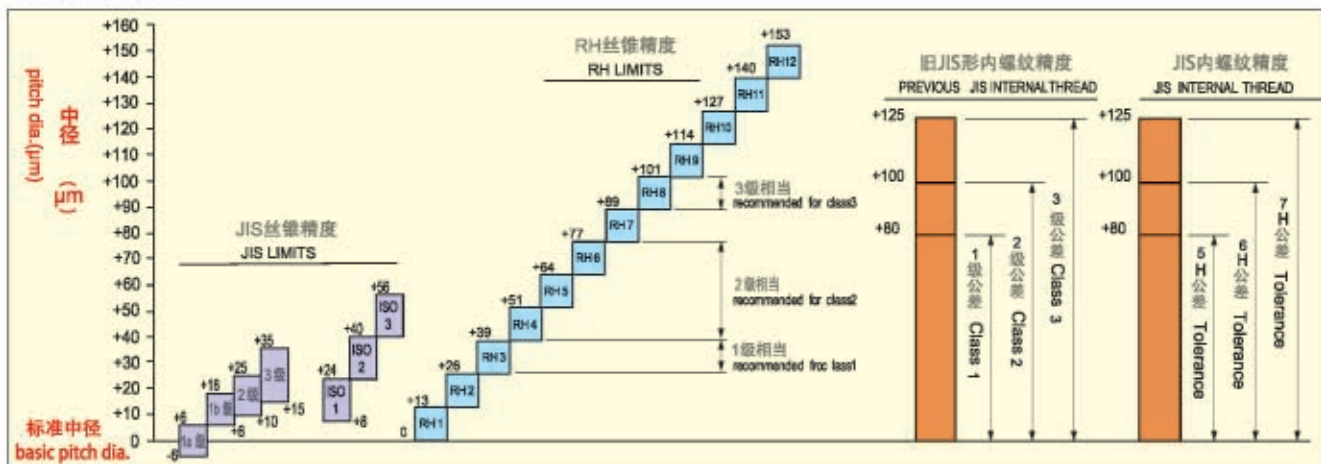
RH精度

上公差: $0.0127 \times n$ upper limit: $0.0127 \times n$
 下公差: 上公差 - 0.0127 lower limit: $0.0127 \times n - 0.0127$
 单位:mm Unit:mm (n=PH号)(n=RH number)

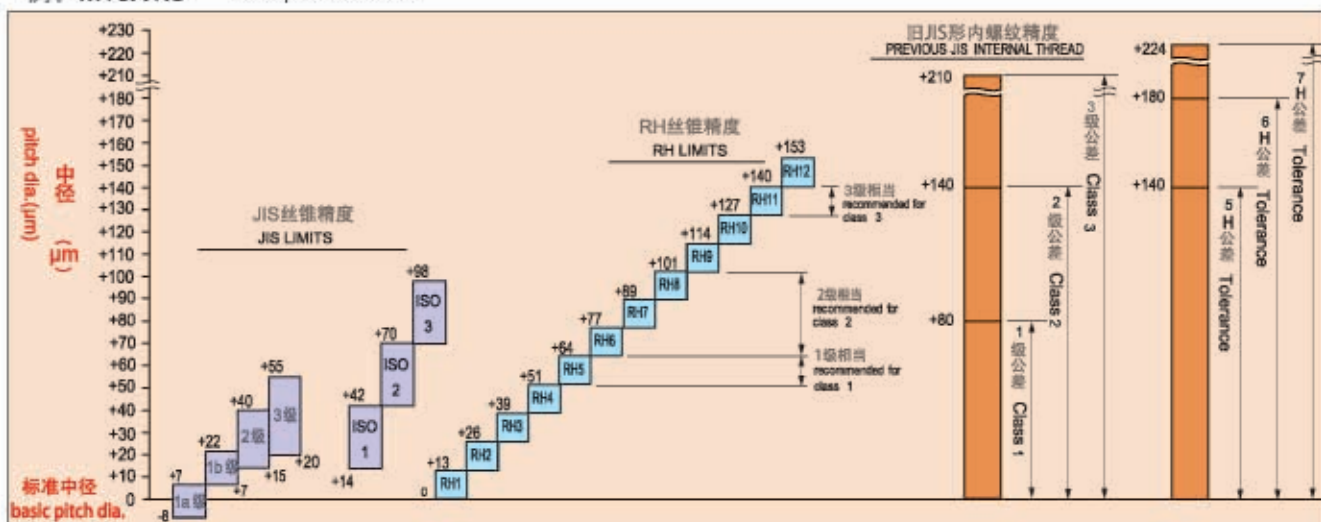
例: M3 × 0.5 Example: M3 × 0.5

Extrusion tap the plastic deformation principle to machining internal thread, the bottom manages a cutting tap more stringent and precision tap also requires more stringent. Adopted a tolerance of $12.7\mu\text{m}$

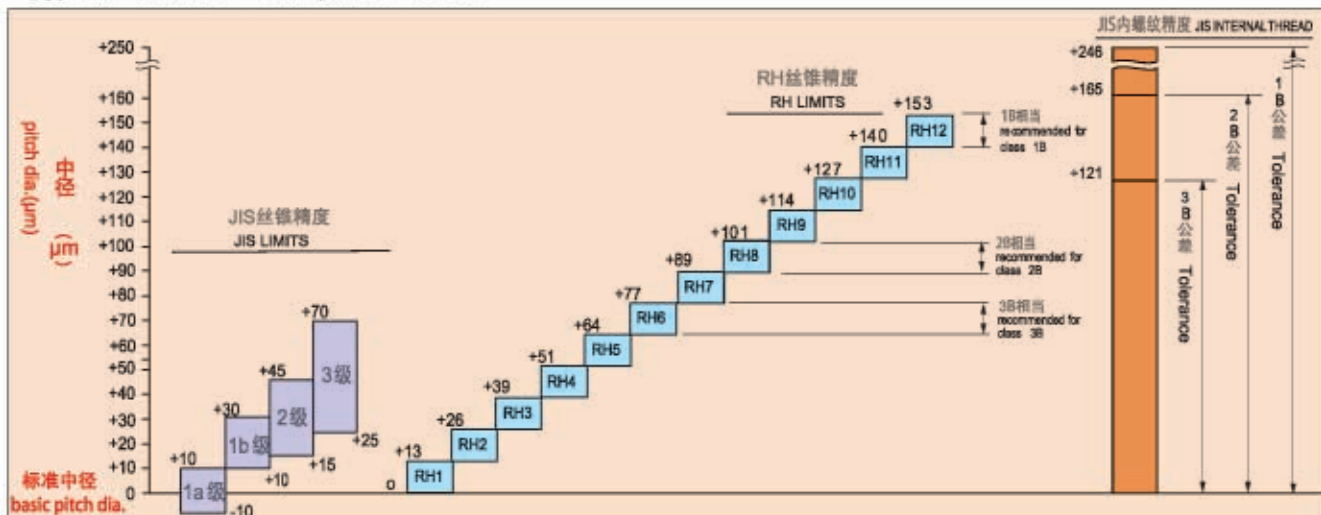
挤压丝锥利用塑性变形原理来加工内螺纹, 其底孔管理较切削丝锥更为严格, 因而丝锥精度也要求更为严格。采用了公差为 $12.7\mu\text{m}$ 。



例: M10X1.5 Example: M10X1.5



例: 1/2-13UNC Example: 1/2-13UNC



RECOMMENDED TAPPING SPEEDS AND LUBRICANTS

切削速度和切削液

- ◆ The selected cutting speed must be taken into account when the tap material, type, number of teeth and bottom shape, processing materials and cutting fluids processing conditions. Also cutting fluid with lubrication, cooling, anti sticking knife three, tapping is a complex processing, will choose the appropriate cutting.

选定切削速度时必须考虑丝锥的材质、种类、牙数、底孔形状、加工材料及切削液等加工条件。另外切削液具有润滑、冷却、抗粘刀3种作用。攻丝加工是一种复杂加工，必须选择适当的切削速度。

Processing materials 加工材料	Cutting speed 切削速度 (m/min)							Cutting fluid 切削液			
	Single flute tap 直槽丝锥	Double flute tap 双槽丝锥	Edge slot tap 开槽丝锥	Carbide tap 硬质合金丝锥	Extract tap 浮孔丝锥	High speed synchronous tap 高速同步丝锥	Flute tap 管状丝锥	Dry 干切	Water solubility 可溶性切削液	Emulsion 乳化液	Dry 干切
低合金钢 CO.25%以下	8~13	8~13	15~25	-	8~13	27~32	3~6	◎	○	△	△
中合金钢 CO.25~0.45%	7~12	7~12	10~15	-	7~10	27~32	3~6	◎	○	△	△
高合金钢 CO.45%以上	6~9	6~9	8~13	-	5~8	22~27	2~5	◎	○	△	△
合金钢 SCM	7~12	7~12	10~15	-	5~8	22~27	2~5	◎	△	△	△
调质钢 25~45HRC	3~5	3~5	4~6	-	-	-	2~5	◎	△	-	-
不锈钢 SUS	4~7	5~8	8~13	-	5~10	-	3~6	◎	○	-	-
不锈钢 SUS630 SCS631	3~5	3~5	4~6	-	-	-	2~5	◎	-	-	-
工具钢 SKD	6~9	6~9	7~10	-	-	-	2~5	◎	-	-	-
铸钢 SC	6~11	6~11	10~15	-	-	17~22	2~5	◎	○	-	-
铸铁 FC	10~15	-	-	10~20	-	-	2~5	◎	○	○	○
球墨铸铁 FCD	7~12	7~12	10~20	10~20	-	-	4~8	◎	○	○	-
铜 Cu	6~9	6~11	7~12	10~20	7~12	27~32	2~5	○	○	-	-
黄铜、黄铜铸件 Bs.BsC	10~15	10~20	15~25	15~25	7~12	27~32	5~10	○	○	○	○
青铜、青铜铸件 PB.PBC	6~11	6~11	10~20	10~20	7~12	-	6~11	○	○	-	-
变形铝合金 AL	10~20	10~20	15~25	-	10~20	100~300	5~10	◎	○	△	-
铝合金铸件 AC.ADC	10~15	10~15	15~20	10~20	10~15	80~300	10~15	◎	○	△	-
镁合金 MC	7~12	7~12	10~15	10~20	-	-	10~15	◎	○	○	-
铸铝件 ZDC	7~12	7~12	10~15	10~20	7~12	27~100	10~15	◎	○	△	-
热硬塑料	10~20	-	-	15~25	-	-	5~10	-	○	○	○
热可塑性塑料	10~20	10~15	10~20	10~20	-	27~32	5~10	-	○	○	○

1. The table is a general selection criteria, and is changed according to the use conditions

1. 此表为一般性的选定基准，根据使用条件有所变更。

2. The use of other reference table when other taps.

2. 选择时参照各用途 丝锥 选定基准表。

3. Quenched and tempered steel (cutting speed for CPM series tap).

3. 调质钢 (内为CPM系列丝锥的切削速度)。

◎ 最适 ○ 适用 △ 可使用 - 不可使用

CUTTING CONDITION BENCHMARK TABLE

切削条件基准表

C55

◆ MC 螺纹铣刀(PNGT)

Processing materials 加工材料	Cutting speed 切削速度 (m/min)	Feed quantity 进给量 (mm/rev)
低碳素钢 SS400 S25C	20 ~ 30	0.01 ~ 0.05
中碳素钢 S30C S50C	10 ~ 20	0.01 ~ 0.05
合金钢 SCr, SCM, SNC	8 ~ 12	0.01 ~ 0.05
不锈钢 SUS	10 ~ 15	0.01 ~ 0.05
铸钢 SC	10 ~ 20	0.02 ~ 0.1
铸铁 FC	20 ~ 50	0.02 ~ 0.1
球墨铸铁 FCD	20 ~ 30	0.02 ~ 0.1
铝合金 A****	40 ~ 55	0.02 ~ 0.08
铝合金铸件 <Si13%	50 ~ 100	0.02 ~ 0.1
铝合金铸件 ≥si13%	50 ~ 100	0.02 ~ 0.1
铜、铜铸件 20% ≤ Si < 25%	50 ~ 80	0.02 ~ 0.1
铜、铜铸件 C1***, CuC	50 ~ 80	0.02 ~ 0.05
黄铜、黄铜铸件 Bs, BsC	50 ~ 100	0.02 ~ 0.05
青铜、青铜铸件 PB, PBC	30 ~ 60	0.02 ~ 0.05
镁合金 MC	50 ~ 80	0.02 ~ 0.1
锌铸件 ZDC	50 ~ 80	0.02 ~ 0.1
热可塑性塑料	50 ~ 80	0.02 ~ 0.1

◆ HY-PRO 螺纹铣刀(HY-PRO P)

Processing materials 加工材料	Cutting speed 切削速度 (m/min)	Feed quantity 进给量 (mm/rev)
低碳素钢 SS400 S25C	100 ~ 210	0.05 ~ 0.3
中碳素钢 S30C S50C	100 ~ 180	0.05 ~ 0.25
合金钢 SCr, SCM, SNC	70 ~ 160	0.05 ~ 0.25
不锈钢 SUS	70 ~ 170	0.05 ~ 0.15
铸钢 SC	100 ~ 170	0.05 ~ 0.1
铸铁 FC	60 ~ 130	0.02 ~ 0.08
球墨铸铁 FCD	60 ~ 130	0.05 ~ 0.15
铝合金 A****	100 ~ 250	0.1 ~ 0.4
铝合金铸件 <Si13%	150 ~ 400	0.05 ~ 0.3
铝合金铸件 ≥si13%	80 ~ 150	0.1 ~ 0.3
铜、铜铸件 C1***, CuC	120 ~ 210	0.1 ~ 0.3
黄铜、黄铜铸件 Bs, BsC	120 ~ 210	0.1 ~ 0.3
青铜、青铜铸件 PB, PBC	120 ~ 210	0.05 ~ 0.25
镁合金 MC	150 ~ 400	0.05 ~ 0.3
锌铸件 ZDC	150 ~ 400	0.05 ~ 0.3
热可塑性塑料	150 ~ 400	0.05 ~ 0.3

◆ 硬质合金螺纹铣刀 (OT-PNGT)

Processing materials 加工材料	Cutting speed 切削速度 (m/min)	Feed quantity 进给量 (mm/rev)
低碳素钢 SS400 S25C	40 ~ 60	0.01 ~ 0.09
中碳素钢 S30C S50C	30 ~ 50	0.01 ~ 0.04
合金钢 SCr, SCM, SNC	15 ~ 30	0.01 ~ 0.03
不锈钢 SUS	20 ~ 40	0.01 ~ 0.06
铸钢 SC	30 ~ 50	0.02 ~ 0.07
铸铁 FC	40 ~ 75	0.02 ~ 0.08
球墨铸铁 FCD	40 ~ 50	0.02 ~ 0.08
铝合金 A****	40 ~ 55	0.02 ~ 0.08
铝合金铸件 <Si13%	50 ~ 100	0.02 ~ 0.1
铝合金铸件 ≥si13%	50 ~ 100	0.02 ~ 0.08
铜、铜铸件 C1***, CuC	50 ~ 100	0.02 ~ 0.08
黄铜、黄铜铸件 Bs, BsC	50 ~ 100	0.02 ~ 0.08
青铜、青铜铸件 PB, PBC	50 ~ 100	0.02 ~ 0.08
镁合金 MC	50 ~ 100	0.02 ~ 0.1
锌铸件 ZDC	50 ~ 100	0.02 ~ 0.1
热可塑性塑料	50 ~ 100	0.02 ~ 0.1

◆ 螺旋槽硬质合金螺纹铣刀(WX-PNC, OT-SFT-PNGT)

Processing materials 加工材料	Cutting speed 切削速度 (m/min)	Feed quantity 进给量 (mm/rev)
低碳素钢 SS400 S25C	50 ~ 75	0.01 ~ 0.11
中碳素钢 S30C S50C	40 ~ 70	0.01 ~ 0.11
合金钢 SCr, SCM, SNC	15 ~ 30	0.01 ~ 0.03
不锈钢 SUS	20 ~ 40	0.01 ~ 0.06
铸钢 SC	40 ~ 65	0.02 ~ 0.09
铸铁 FC	50 ~ 100	0.03 ~ 0.1
球墨铸铁 FCD	50 ~ 65	0.03 ~ 0.1
铝合金 A****	50 ~ 70	0.03 ~ 0.1
铝合金铸件 <Si13%	65 ~ 140	0.03 ~ 0.13
铝合金铸件 ≥si13%	65 ~ 130	0.03 ~ 0.1
铜、铜铸件 C1***, CuC	65 ~ 130	0.03 ~ 0.1
黄铜、黄铜铸件 Bs, BsC	65 ~ 130	0.03 ~ 0.1
青铜、青铜铸件 PB, PBC	65 ~ 130	0.03 ~ 0.1
镁合金 MC	65 ~ 130	0.03 ~ 0.13
锌铸件 ZDC	65 ~ 130	0.03 ~ 0.13
热可塑性塑料	65 ~ 130	0.03 ~ 0.13
耐热合金	镁合金	20 ~ 60 0.01 ~ 0.03
	Ti-6Al-4V	20 ~ 60 0.02 ~ 0.06

◆ 超级螺纹铣刀(DR-PNAC · DR -PNAC)

Processing materials 加工材料		Internal thread 内螺纹		Blit 钻头	
		Cutting speed 切削速度 (m/min)	Feed quantity 进给量 (mm/rev)	Cutting speed 切削速度 (m/min)	Feed quantity 进给量 (mm/rev)
铸铁 FC		50 ~ 120	0.02 ~ 0.04	0.1 ~ 0.2	
球墨铸铁 FCD		50 ~ 100	0.02 ~ 0.04	0.1 ~ 0.2	
铝合金 A****		80 ~ 200	0.02 ~ 0.05	0.1 ~ 0.2	
铝合金铸件 <Si13%		80 ~ 200	0.02 ~ 0.05	0.1 ~ 0.2	
铝合金铸件 ≥si13%		80 ~ 200	0.02 ~ 0.04	0.05 ~ 0.1	
镁合金铸件 MC		80 ~ 200	0.02 ~ 0.05	0.1 ~ 0.2	
锌铸件 ZDC		80 ~ 200	0.02 ~ 0.05	0.1 ~ 0.2	
热可塑性塑料		80 ~ 200	0.02 ~ 0.05	0.1 ~ 0.2	

1. this cutting condition is the choice of water soluble cutting fluid.
2. when the magnesium alloy is processed, it is not available for the water soluble cutting fluid.
3. According to the rigidity of the workpiece, the machine and the clamping sleeve, etc., are adjusted for cutting conditions.
4. to process a high accuracy of the internal thread, in the tool when the clip to minimize the time.
5. adjustment of the screw cutting process, the mechanical performance of the case, will cause internal thread. At this point, please change the cutting conditions or adjust the high performance of the processing machinery.
6. when the cutting of the drill is easy to wrap the milling cutter, use the step type.

1. 此切削条件基准是在选用水溶性切削液的情况下。
2. 镁合金加工时，不可用水溶性切削液。
3. 根据工件的刚性，机械和夹具等刚性调整切削条件。
4. 为加工出高精度的内螺纹，在工具安装时尽量减少晃动。
5. 调整螺旋切削加工时，机械性能不良的情况下，会引起内螺纹不良。此时，请改切削条件或者高速高性能的加工机械。
6. 当钻头的切削容易缠绕铣刀时，请使用台阶式加工。

- ◆ 底孔径是影响攻丝加工的重要因素之一。

外螺纹和螺纹的有效嵌合高度与标准牙形高的比称为嵌合率。

The Drill Hole diameter(or Thread Overlap Ratio) substantially affects tapping operations.

Cf. Thread Overlap Ratio=percentage of thread overlap(a)to basic overlap(h)

嵌合率 Formula

C56

$$\text{嵌合率} = \frac{(\text{外螺纹大径的基准尺寸}) - (\text{底孔径})}{2 \times (\text{标准牙形高度})} \times 100$$

$$\text{Percentage of thread engagement} = \frac{(\text{basic major dia. of external thread}) - (\text{drill hole dia.})}{2 \times (\text{basic height of thread engagement})} \times 100$$

- ◆ 在加工内螺纹底孔之前必须考虑到这个嵌合率

内螺纹小径和底孔直径相等。如果定下了螺距P、外螺纹大径d、嵌合率，那么底孔径（公制螺纹、美制统一螺纹）可由外螺纹标准牙高0.541266P。

Because the minor dia. of the internal thread is equal to the Drill Hole diameter, the Drill diameter is calculated using the following formula (Metric and Unified Threads)

底孔径（公制螺纹、美制螺纹）Drill Hole diameter

$$\text{底孔径} = d - 2 \times (0.541266P) \times \left(\frac{\text{嵌合率}}{100} \right)$$

$$\text{Drill Hole diameter} = d - 2 \times (0.541266P) \times \left(\frac{\text{Percentage of thread engagement}}{100} \right)$$

求出

d: 外螺纹大径 d: Major diameter of External thread (mm)
P: 螺距 P: Pitch (mm)

图1 嵌合率

当外螺纹呈标准牙形时

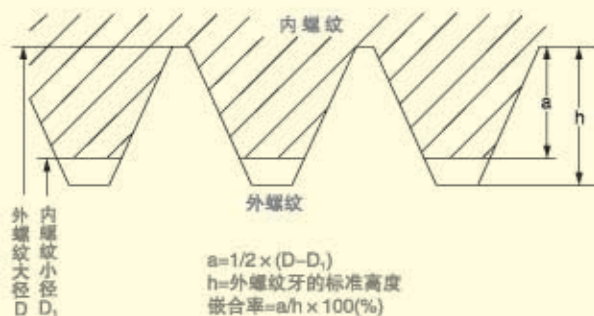
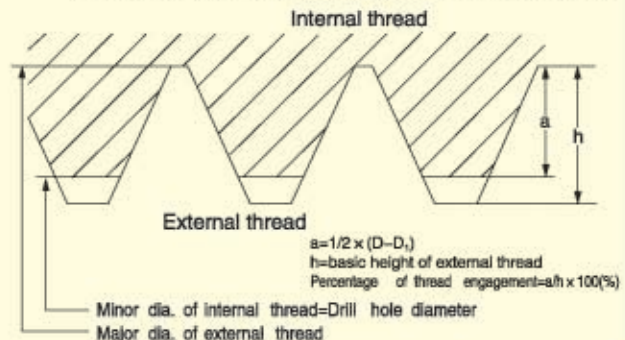


Figure1 Percentage of thread engagement

When external thread profile is equal to basic profile



CUTTING TAP TAP DIAMETER TABLE (METRIC THREAD)

切削丝锥螺纹底孔直径表 (公制螺纹)

Unit: mm

单位: mm

Thread 螺纹尺寸	Size 底孔直径	Recommended bottom aperture 推荐底孔	Minimum bottom aperture 最小底孔	Maximum bottom aperture 最大底孔		
				JIS level JIS级	4H级	5H级
M1×0.25	0.75	0.73	0.78	0.77	0.78	—
1×0.2	0.8	0.79	—	0.82	—	—
1.1×0.25	0.85	0.83	0.88	0.87	0.88	—
1.1×0.2	0.9	0.89	—	0.92	—	—
1.2×0.25	0.95	0.93	0.98	0.97	0.98	—
1.2×0.2	1	0.99	—	1.02	—	—
1.4×0.3	1.1	1.08	1.14	1.12	1.14	1.16
1.4×0.2	1.2	1.19	—	1.22	—	—
1.6×0.35	1.25	1.23	1.32	1.28	1.3	1.32
1.6×0.2	1.4	1.39	—	1.42	—	—
1.7×0.3	1.4	—	—	—	—	—
1.7×0.25	1.45	—	—	—	—	—
1.7×0.2	1.5	—	—	—	—	—
1.8×0.35	1.45	1.43	1.52	1.48	1.5	1.52
1.8×0.2	1.6	1.59	—	1.62	—	—
2×0.4	1.6	1.57	1.67	1.63	1.65	1.67
2×0.25	1.75	1.73	—	1.77	—	—
2.2×0.45	1.75	1.72	1.83	1.79	1.81	1.83
2.2×0.25	1.95	1.93	—	1.97	—	—
2.3×0.4	1.9	—	—	—	—	—
2.3×0.35	1.95	—	—	—	—	—
2.3×0.25	2.05	—	—	—	—	—
2.5×0.45	2.05	2.02	2.13	2.09	2.11	2.13
2.5×0.35	2.15	2.13	2.22	2.18	2.2	2.22
2.6×0.45	2.15	—	—	—	—	—
2.6×0.35	2.25	—	—	—	—	—
3×0.5	2.5	2.46	2.59	2.54	2.57	2.59
3×0.35	2.65	2.63	2.27	2.68	2.7	2.72
3.5×0.6	2.9	2.85	3.01	2.95	2.97	3.01
3.5×0.35	3.15	3.13	3.22	3.18	3.2	3.22
4×0.7	3.3	3.25	3.42	3.35	3.38	3.42
4×0.5	3.5	3.46	3.59	3.54	3.57	3.59
4.5×0.75	3.75	3.69	3.87	3.8	3.83	3.87
4.5×0.5	4	3.96	4.09	4.04	4.07	4.09
5×0.9	4.1	—	—	—	—	—
5×0.8	4.2	4.14	4.33	4.25	4.29	4.33
5×0.5	4.5	4.46	4.59	4.54	4.57	4.59
5.5×0.9	4.6	—	—	—	—	—
5.5×0.75	4.75	—	—	—	—	—
5.5×0.5	5	4.96	5.09	5.04	5.07	5.09
6×1	5	4.92	5.15	5.06	5.1	5.15
6×0.75	5.25	5.19	5.37	5.3	5.33	5.37
6×0.5	5.5	—	—	—	—	—
7×1	6	5.92	6.15	6.06	6.1	6.15
7×0.75	6.25	6.19	6.37	6.3	6.33	6.37
7×0.5	6.5	—	—	—	—	—
8×1.25	6.75	6.65	6.91	6.81	6.85	6.91
8×1	7	6.92	7.15	7.06	7.1	7.15
8×0.75	7.25	7.19	7.37	7.3	7.33	7.37
8×0.5	7.5	—	—	—	—	—
9×1.25	7.75	7.65	7.91	7.81	7.85	7.91
9×1	8	7.92	8.15	8.06	8.1	8.15
9×0.75	8.25	8.19	8.37	8.3	8.33	8.37
9×0.5	8.5	—	—	—	—	—
10×1.5	8.5	8.38	8.67	8.56	8.61	8.67
10×1.25	8.75	8.65	8.91	8.81	8.85	8.91
10×1	9	8.92	9.15	9.06	9.1	9.15
10×0.75	9.25	9.19	9.37	9.3	9.33	9.37
10×0.5	9.5	—	—	—	—	—
11×1.5	9.5	9.38	9.67	9.56	9.61	9.67
11×1	10	9.92	10.15	10.06	10.1	10.15
11×0.75	10.25	10.19	10.37	10.3	10.33	10.37
11×0.5	10.5	—	—	—	—	—
12×1.75	10.25	10.11	10.44	10.31	10.37	10.44
12×1.5	10.5	10.38	10.67	10.56	10.61	10.67
12×1.25	10.75	10.65	10.91	10.81	10.85	10.91
12×1	11	10.92	11.15	11.06	11.1	11.15
12×0.75	11.25	—	—	—	—	—
12×0.5	11.5	—	—	—	—	—

Thread 螺纹尺寸	Size 底孔直径	Recommended bottom aperture 推荐底孔	General accuracy 一般精度	Maximum bottom aperture 最大底孔		
				JIS level JIS等级	4H用	5H用
13×1.75	11.25	—	—	—	—	—
13×1.5	11.5	—	—	—	—	—
13×1.25	11.75	—	—	—	—	—
13×1	12	—	—	—	—	—
13×0.75	12.3	—	—	—	—	—
13×0.5	12.5	—	—	—	—	—
14×2	12	11.84	12.21	12	12.1	12.2
14×1.5	12.5	12.38	12.67	12.56	12.61	12.67
14×1	13	12.92	13.15	13.06	13.1	13.15
14×0.75	13.3	—	—	—	—	—
14×0.5	13.5	—	—	—	—	—
15×2	13	—	—	—	—	—
15×1.5	13.5	13.4	13.6	13.5	13.6	13.6
15×1.25	13.8	13.7	13.9	—	—	—
15×1	14	13.95	14.15	14.06	14.1	14.15
15×0.75	14.3	—	—	—	—	—
15×0.5	14.5	—	—	—	—	—
16×2	14	13.9	14.2	14	14.4	14.2
16×1.5	14.5	14.4	14.6	14.5	14.6	14.6
16×1	15	14.95	15.15	15.06	15.1	15.15
17×2	15	—	—	—	—	—
17×1.5	15.5	15.4	15.68	15.5	15.6	15.6
17×1.25	15.8	—	—	—	—	—
17×1	16	15.95	16.15	16.06	16.1	16.15
17×0.75	16.3	—	—	—	—	—
17×0.5	16.5	—	—	—	—	—
18×2.5	15.5	15.3	15.7	15.5	15.6	15.7
18×2	16	15.9	16.2	16	16.1	16.2
18×1.5	16.5	16.4	16.6	16.5	16.6	16.6
18×1	17	16.95	17.15	17.06	17.1	17.15
19×2.5	16.5	—	—	—	—	—
19×2	17	—	—	—	—	—
19×1.5	17.5	—	—	—	—	—
19×1.25	17.8	—	—	—	—	—
19×1	18	—	—	—	—	—
19×0.75	18.3	—	—	—	—	—
19×0.5	18.5	—	—	—	—	—
20×2.5	17.5	17.3	17.7	17.5	17.6	17.7
20×2	18	17.9	18.2	18	18.1	18.2
20×1.5	18.5	18.4	18.6	18.5	18.6	18.6
20×1	19	18.95	19.15	19.06	19.1	19.15
21×2.5	18.5	—	—	—	—	—
21×1.5	19.5	—	—	—	—	—
21×1	20	—	—	—	—	—
22×2.5	19.5	19.3	19.7	19.5	19.6	19.7
22×2	20	19.9	20.2	20	20.1	20.2
22×1.5	20.5	20.4	20.6	20.5	20.6	20.6
22×1	21	20.95	21.15	21.06	21.1	21.15
23×2.5	20.5	—	—	—	—	—
23×2	21	—	—	—	—	—
23×1.5	21.5	—	—	—	—	—
23×1	22	—	—	—	—	—
24×3	21	20.8	21.2	21	21.1	21.2
24×2	22	21.9	22.2	22	22.1	22.2
24×1.5	22.5	22.4	22.6	22.5	22.6	22.6
24×1	23	22.95	23.15	23.06	23.1	23.15
25×3	22	—	—	—	—	—
25×2	23	22.9	23.2	23	23.1	23.2
25×1.5	23.5	23.4	23.6	23.5	23.6	23.6
25×1	24	23.95	24.15	24.06	24.1	24.15
26×3	23	—	—	—	—	—
26×2	24	—	—	—	—	—
26×1.5	24.5	24.4	24.6	24.5	24.6	24.6
27×3	24	23.8	24.2	24	24.1	24.2
27×2.5	24.5	—	—	—	—	—
27×2	25	24.9	25.2	25	25.1	25.2
27×1.5	25.5	25.4	25.6	25.5	25.6	25.6
27×1	26	25.95	26.15	26.06	26.1	26.15
28×3	25	—	—	—	—	—

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CUTTING TAP TAP DIAMETER TABLE (AMERICAN THREAD)

切削丝锥螺纹底孔直径表 (英制螺纹)

Unit: mm

单位: mm

Thread size 螺纹尺寸	Recommended bottom aperture 推荐底孔直径	JIS2B level JIS2B等级	
		Minimal bottom aperture 最小底孔直径	Maximum bottom aperture 最大底孔直径
No.0 x80UNF	1.25	1.19	1.3
1 x64UNC	1.51	1.43	1.58
1 x72UNF	1.55	1.48	1.61
2 x56UNC	1.79	1.7	1.87
2 x64UNF	1.84	1.76	1.91
3 x48UNC	2.05	1.95	2.14
3 x56UNF	2.11	2.03	2.19
4 x40UNC	2.27	2.16	2.38
4 x48UNF	2.37	2.28	2.45
5 x40UNC	2.59	2.49	2.69
5 x44UNF	2.65	2.56	2.74
6 x32UNC	2.77	2.65	2.89
6 x40UNF	2.92	2.82	3.02
8 x32UNC	3.42	3.31	3.53
8 x36UNF	3.51	3.41	3.6
10 x24UNC	3.83	3.69	3.96
10 x32UNF	4.07	3.97	4.16
12 x24UNC	4.47	4.35	4.59
12 x28UNF	4.61	4.5	4.72
1/4x20UNC	5.12	4.98	5.25
1/4x28UNF	5.47	5.36	5.58
1/4x32UNEF	5.59	5.49	5.68
5/16x18UNC	6.57	6.41	6.73
5/16x24UNF	6.91	6.79	7.03
5/16x32UNEF	7.18	7.09	7.26
3/8x16UNC	7.98	7.8	8.15
3/8x20UN	8.3	8.16	8.43
3/8x24UNF	8.51	8.39	8.63
3/8x32UNEF	8.77	8.67	8.86
7/16x14UNC	9.35	9.15	9.55
7/16x20UNF	9.88	9.73	10.03
1/2x13UNC	10.81	10.6	11.02
1/2x20UNF	11.47	11.33	11.6
9/16x12UNC	12.2	11.99	12.4
9/16x18UNF	12.9	12.8	13
5/8x11UNC	13.6	13.4	13.8
5/8x18UNF	14.5	14.4	14.6
5/8x24UNEF	14.9	14.8	14.9

Thread size 螺纹尺寸	Recommended bottom aperture 推荐底孔直径	JIS2B level JIS2B等级	
		Minimal bottom aperture 最小底孔直径	Maximum bottom aperture 最大底孔直径
No. 3/4x10UNC	16.6	16.4	16.8
3/4x16UNF	17.5	17.4	17.6
7/8x9UNC	17.8	17.7	17.9
7/8x9UNC	19.5	19.2	19.7
7/8x14UNF	20.5	20.3	20.6
7/8x20UNEF	21	20.9	21.1
1 x8UNC	22.3	22	22.6
1 x12UNF	23.4	23.2	23.5
1 x14UNS	23.6	-	-
1 1/16x12UN	24.9	24.7	25.1
1 1/8x7UNC	25	24.7	25.3
1 1/8x12UNF	26.5	26.3	26.7
1 1/4x7UNC	28.2	27.9	28.5
1 1/4x8UN	28.7	28.4	28.9
1 1/4x12UNF	29.7	29.5	29.9
1 3/8x6UNC	30.8	30.4	31.1
1 3/8x12UNF	32.9	32.7	33
1 1/2x6UNC	33.9	33.6	34.2
1 1/2x8UN	35	34.7	35.3
1 5/8x5UNS	36.2	-	-
1 3/4x5UNC	39.4	39	39.8
1 3/4x8UN	41.4	41.1	41.6
1 3/4x12UN	42.4	42.2	42.6
2 x4.5UNC	45.1	44.7	45.5
2 x8UN	47.7	47.4	48
2 x12UN	48.8	48.6	48.9
2 1/4x4.5UNC	51.5	51.1	51.9
2 1/2x4UNC	57.1	56.7	57.5
2 1/2x8UN	60.4	60.1	60.7
2 3/4x4UNC	63.5	63	63.9
2 3/4x8UN	66.8	66.5	67
3 x4UNC	69.8	69.3	70.2
3 x8UN	73.1	72.8	73.4
3 1/4x4UNC	76.2	75.7	76.6
3 1/2x8UN	85.8	85.5	86.1
3 3/4x4UNC	88.9	88.4	89.3
4 x4UNC	95.2	94.8	95.6
4 x8UN	98.5	98.2	98.8

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THE EXTRUSION TAP TAP DIAMETER TABLE

挤压丝锥螺纹底孔直径表

Metric thread 公制螺纹		Unit: mm 单位: mm	
Thread size 螺纹尺寸	for JIS class 1 drill hole dia. 1级螺纹底孔直径	for JIS class 2 drill hole dia. 2级螺纹底孔直径	
	RH 转速	Min-Max(Thrust Overlap Ratio%) 最小-最大(进给率%)	RH 转速
M 1×0.25	2	0.87~0.89(100~85)	4
1.1×0.25	2	0.97~0.99(100~85)	4
1.2×0.25	2	1.07~1.09(100~85)	4
1.4×0.3	2	1.244~1.263(100~85)	4
1.6×0.35	2	1.41~1.44(100~80)	4
1.7×0.35	2	1.51~1.54(100~80)	4
1.8×0.35	2	1.61~1.64(100~80)	4
2×0.25	2	1.88~1.89(100~80)	4
2×0.4	2	1.78~1.82(100~80)	4
2.2×0.45	2	1.95~1.99(100~80)	4
2.3×0.4	2	2.08~2.12(100~80)	4
2.5×0.45	2	2.25~2.29(100~80)	4
2.6×0.45	2	2.35~2.39(100~80)	4
3×0.5	3	2.74~2.78(100~80)	5
3.5×0.6	3	3.18~3.21(100~85)	5
4×0.7	4	3.63~3.67(100~85)	6
5×0.8	4	4.57~4.62(100~85)	6
6×1	4	5.45~5.51(100~85)	7
7×1	4	6.45~6.51(100~85)	7
8×1.25	5	7.31~7.38(100~85)	7
8×1	4	7.45~7.51(100~85)	7
10×1.5	5	9.16~9.22(100~85)	7
10×1.25	5	9.31~9.38(100~85)	7
10×1	5	9.46~9.52(100~85)	7
12×1.75	5	11.01~11.08(100~90)	8
12×1.5	5	11.06~11.22(100~90)	7
12×1.25	5	11.31~11.38(100~85)	7
12×1	5	11.46~11.52(100~85)	7
14×2	6	12.83~12.95(100~90)	10
14×1.5	5	13.16~13.22(100~90)	9
16×2	6	14.87~14.95(100~90)	10
16×1.5	5	15.16~15.22(100~90)	9
18×2.5	6	16.57~16.67(100~90)	11
18×1.5	6	17.17~17.23(100~90)	10
20×2.5	6	18.57~18.67(100~90)	11
20×1.5	6	19.17~19.23(100~90)	10

National coarse thread 美制粗牙螺纹		Unit: mm 单位: mm	
Thread size 螺纹尺寸	for JIS class 2B drill hole dia. 2B级螺纹底孔直径	for JIS class 3B drill hole dia. 3B级螺纹底孔直径	
	RH 转速	Min-Max(Thrust Overlap Ratio%) 最小-最大(进给率%)	RH 转速
NO. 1-64UNC	3	1.66~1.7(100~65)	2
NO. 2-56	4	1.96~2.02(100~65)	3
NO. 3-48	4	2.25~2.32(100~65)	3
NO. 4-40	5	2.52~2.6(100~70)	3
NO. 5-40	5	2.86~2.93(100~70)	3
NO. 6-32	5	3.09~3.17(100~75)	3
NO. 8-32	5	3.75~3.83(100~75)	4
NO. 10-24	6	4.26~4.35(100~80)	4
NO. 12-24	6	4.92~5.01(100~80)	4
1/4-20	6	5.66~5.76(100~80)	4
5/16-18	7	7.18~7.29(100~80)	5
3/8-16	7	8.66~8.78(100~80)	5
7/16-14	7	10.11~10.25(100~80)	5
1/2-13	8	11.62~11.78(100~80)	6
9/16-12	10	13.14~13.27(100~85)	8
5/8-11	11	14.62~14.76(100~85)	8
3/4-10	12	17.67~17.88(100~80)	9
7/8-9	12	20.68~20.85(100~85)	9
1-20	13	23.65~23.84(100~85)	10

Metric thread 公制螺纹		Unit: mm 单位: mm	
Thread size 螺纹尺寸	for JIS class 3 drill hole dia. 3级螺纹底孔直径	for JIS class 2 drill hole dia. 2级螺纹底孔直径	
	RH 转速	Min-Max(Thrust Overlap Ratio%) 最小-最大(进给率%)	RH 转速
M 1×0.25	2	0.858~0.879(100~85)	4
1.2×0.25	2	1.058~1.079(100~85)	4
1.4×0.3	2	1.23~1.26(100~85)	4
1.6×0.35	2	1.4~1.44(100~80)	4
1.7×0.35	-	1.5~1.54(100~80)	4
1.8×0.35	2	1.6~1.64(100~80)	4
2×0.4	2	1.77~1.82(100~80)	4
2×0.25	2	1.858~1.887(100~80)	-
2.3×0.4	-	2.07~2.12(100~80)	4
2.5×0.45	3	2.24~2.3(100~80)	5
2.6×0.45	-	2.34~2.4(100~80)	5
3×0.6	3	2.72~2.73(100~80)	5
3×0.5	5	2.72~2.77(100~80)	6
3×0.35	3	2.8~2.84(100~80)	5
3.5×0.6	3	3.16~3.21(100~85)	5
4×0.75	3	3.57~3.64(100~85)	6
4×0.7	6	3.6~3.66(100~85)	7
4×0.5	3	3.71~3.77(100~80)	6
5×0.9	3	4.49~4.59(100~85)	7
5×0.8	3	4.55~4.62(100~85)	8
5×0.5	3	4.72~4.77(100~80)	6
6×1	4	5.43~5.52(100~85)	7
6×0.75	3	5.57~5.64(100~85)	7

Parallel screw thread 英式管用平行螺纹		Unit: mm 单位: mm	
Thread size 螺纹尺寸	RH Limits 进给率	Min-Max(Thrust Overlap Ratio%) 最小-最大(进给率%)	
PF 1/8	6	9.24~9.35(100~80)	
1/4	7	12.41~12.62(100~75)	
3/8	7	15.92~16.12(100~75)	
1/2	8	19.93~20.15(100~80)	
3/4	8	25.41~25.64(100~80)	

National fine thread 美制细牙螺纹		Unit: mm 单位: mm	
Thread size 螺纹尺寸	for JIS class 2B drill hole dia. 2B级螺纹底孔直径	for JIS class 3B drill hole dia. 3B级螺纹底孔直径	
	RH 转速	Min-Max(Thrust Overlap Ratio%) 最小-最大(进给率%)	RH 转速
NO. 0-80UNC	3	1.38~1.41(100~65)	2
NO. 1-72	3	1.68~1.72(100~65)	2
NO. 2-64	3	1.98~2.04(100~65)	2
NO. 3-56	4	2.29~2.35(100~65)	3
NO. 4-48	4	2.57~2.64(100~70)	3
NO. 5-44	5	2.89~2.96(100~70)	3
NO. 6-40	5	3.19~3.26(100~70)	3
NO. 8-36	5	3.8~3.88(100~75)	4
NO. 10-32	5	4.41~4.48(100~80)	4
NO. 12-28	5	5~5.08(100~80)	4
1/4-28	5	5.86~5.93(100~80)	4
5/16-24	6	7.38~7.46(100~80)	5
3/8-24	6	8.96~9.05(100~80)	5
7/16-20	7	10.44~10.54(100~80)	5
1/2-20	7	12.02~12.12(100~80)	5
9/16-18	9	13.55~13.66(100~80)	7
5/8-18	9	15.14~15.25(100~80)	7
3/4-16	10	18.22~18.32(100~85)	7
7/8-14	11	21.27~21.38(100~85)	8
1-12	12	24.28~24.41(100~85)	9

1. on the table bottom vary because of different materials, for reference only.
1. 上表底部数据因材料不同而有所变化, 仅供参考。
2. the bottom diameter will be due to material, hardness, shape and other factors, such as change, please try to process.
2. 底孔直径会因材料、硬度、形状尺寸等因素而变化, 请事先进行试加工。
3. bottom assembly is conducive to life, a little, please a reasonable choice according to the purpose of processing.
3. 底孔装配对寿命是有利的, 请根据实际情况进行合理选择。
4. bottom deformation, deformation will lead to machining problems, please note
4. 底孔变形, 变形会导致加工问题, 请注意。

RECOMMENDED DRILL HOLE SIZE (FOR SCREW THREAD INSERT)

螺紋底孔直徑表(螺紋用)

Metric coarse thread (cutting tap)

公制粗牙螺紋 (切削絲錐)

Unit: mm

單位: mm

Thread size 螺紋尺寸	Drill hole dia. 底孔直徑		Buitable Drill dia. 钻头直徑
	最小尺寸 Min	最大尺寸 Max	
M 2.5×0.45	2.6	2.65	2.6
2.5×0.45	2.7	2.75	2.7
3×0.5	3.12	3.2	3.15
4×0.7	4.17	4.3	4.2
5×0.8	5.16	5.33	5.2
6×1	6.25	6.42	6.3
8×1.25	8.31	8.52	8.4
10×1.5	10.37	10.62	10.5
12×1.75	12.43	12.73	12.5
14×2	14.49	14.83	14.5
16×2	16.49	16.83	16.5
18×2.5	18.58	19.04	19
20×2.5	20.58	21.04	21
22×2.5	22.58	23.04	23
24×3	24.7	25.25	25

Metric fine thread (cutting tap)

公制細牙螺紋 (切削絲錐)

Unit: mm

單位: mm

Thread size 螺紋尺寸	Drill hole dia. 底孔直徑		Buitable Drill dia. 钻头直徑
	最小尺寸 Min	最大尺寸 Max	
M 10×1	10.25	10.42	10.3
10×1.25	10.31	10.52	10.4
12×1.25	12.31	12.52	12.5
12×1.5	12.37	12.62	12.5
14×1.5	14.37	14.62	14.5
16×1.5	16.37	16.62	16.5
18×1.5	18.37	18.62	18.5
20×1.5	20.37	20.62	20.5
20×2	20.47	20.83	20.5
22×1.5	22.37	22.62	22.5
24×1.5	24.37	24.62	24.5
24×2	24.37	24.83	24.5
30×1.5	30.37	30.62	30.5

National coarse thread (cutting tap)

美制粗牙螺紋 (切削絲錐)

Unit: mm

單位: mm

Thread size 螺紋尺寸	Drill hole dia. 底孔直徑		Buitable Drill dia. 钻头直徑
	最小尺寸 Min	最大尺寸 Max	
NO. 2-56UNC	2.29	2.39	2.3
NO. 3-48	2.64	2.74	2.7
NO. 4-40	2.95	3.07	3
NO. 5-40	3.25	3.38	3.3
NO. 6-32	3.66	3.81	3.7
NO. 8-32	4.32	4.47	4.4
NO. 10-24	5.05	5.21	5.1
NO. 12-24	5.61	5.77	5.7
1/4-20	6.63	6.78	6.7
5/16-18	8.33	8.48	8.4
3/8-16	9.91	10.11	10
7/16-14	11.51	11.76	11.5
1/2-13	13.08	13.34	13.1
9/16-12	14.68	14.94	14.7

NF (cutting tap)

美制細牙螺紋 (切削絲錐)

Unit: mm

單位: mm

Thread size 螺紋尺寸	Drill hole dia. 底孔直徑		Buitable Drill dia. 钻头直徑
	最小尺寸 Min	最大尺寸 Max	
NO. 4-48UNC	2.97	3.05	3
NO. 6-40	3.66	3.78	3.7
NO. 8-10	4.32	4.44	4.4
NO. 10-32	4.98	5.13	5
1/4-28	6.53	6.71	6.6
5/16-24	8.2	8.38	8.2
3/8-24	9.78	9.96	9.8
7/16-20	11.43	11.63	11.5
1/2-20	13.03	13.26	13.1
9/16-18	14.66	14.88	14.7
5/8-18	16.26	16.48	16.3
3/4-16	19.43	19.68	19.5
7/8-14	22.61	22.86	22.7
1-12	25.76	26.04	26

Metric thread (extrusionscrew tap)

公制螺紋 (擠壓絲錐)

Unit: mm

單位: mm

Thread size 螺紋尺寸	RH Limits 右側限度	Min-Max(Tensile Overlap Ratio%) 最小-最大(疊合率%)
M 3×0.5	3	3.39~3.43(100~80)
4×0.7	4	4.54~4.58(100~85)
5×0.8	4	5.61~5.65(100~85)
6×1	4	6.75~6.81(100~85)
8×1.25	5	8.93~9.01(100~85)
10×1.5	5	11.11~11.17(100~90)
10×1.25	5	10.93~11.01(100~85)
12×1.75	5	13.28~13.35(100~90)
12×1.5	5	13.11~13.17(100~90)
12×1.25	5	12.93~13.01(100~85)

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