

钻头与 STI 攻丝参数表

TANGLESS & TANGED WIRE INSERTS | REFERENCE EDITION

本表用于无尾及有尾钢丝螺套的孔加工参考；须使用与螺套匹配的 STI 丝锥，不可直接替代为普通内螺纹丝锥。参考尺寸须与秩成确认图纸、工具和母材匹配后使用，并非秩成供货或认证声明。
Reference hole-preparation data for tangless and tanged wire inserts. Use matching STI taps. Confirm compatibility with ZCOIL drawings, tooling and parent material; this is not a ZCOIL qualification or supply specification.

D 表示公称螺纹直径；1D 至 3D 是螺套安装长度档位。F 为最小钻孔深度，H 为最小攻丝深度；两者不可互换。Plug 与 Bottoming 表示原资料的两类丝锥，不等于通孔和盲孔分类。
D is nominal thread diameter; 1D to 3D identify installed insert length. F is minimum drilling depth; H is minimum tapping depth. Plug and Bottoming are tap types, not through-hole / blind-hole categories.

公制尺寸为 mm，英制尺寸为 in。钻头列保留原规格：# 为美制编号，字母为字母钻，分数为英寸；公制 M2 的 #44 (0.0860) 中括号值同样为英寸。标明 mm 的钻头规格按毫米读取。
Metric dimensions: mm. Unified dimensions: in. Drill designations retain source units: # drills, letter drills and fractions use inch sizing. The M2 drill #44 (0.0860) is also in inches. Explicit mm drill labels remain metric.

沉孔 M 的角度为 120 ° ±5 °。3B / 2B 与 4H / 5H 为原表分列的螺纹等级，不可合并使用。攻丝后小径与建议钻头直径是不同字段。
Countersink M: 120 degrees +/-5 degrees. Keep 3B / 2B and 4H / 5H limits separate. Suggested drill diameter is not the after-tapping minor diameter.

原资料指出，公称规格不大于 5/16 in 或 M8 的 Plug 丝锥，F 已计入长度为丝锥公称直径一半的前端顶尖；Bottoming 丝锥去除了螺纹端顶尖。应以实际工具几何复核深度。
Source notes: for Plug taps at 5/16 in / M8 and smaller, F allows for a male center equal to half the nominal tap diameter. Bottoming taps have the thread-end male center removed. Verify actual tool geometry.

规格后的 [1]、[2] 为原表脚注号，不属于螺距。英制 [1] 及公制攻丝 [1] 对应标准钻头与 NASM33537 / MA1567 小径要求存在轻微差异的说明；公制钻孔 [2] 保留原编号，不自行重释。
[1] / [2] after a thread are source footnote markers, not pitch digits. Unified [1] and metric tapping [1] flag standard drills differing slightly from referenced minor-diameter requirements. Metric drilling [2] is retained as supplied.

通孔须核对母材厚度、工具穿出空间及有效螺纹；有尾螺套还须安排断柄和取出尾柄。盲孔须独立核对余量。表中深度不能直接作为通孔板厚。
For through holes, verify material thickness, tool exit and effective thread. Tanged inserts also require tang break-off and recovery. Check blind-hole clearance separately; F and H are not plate thickness.

异常单元格：公制钻孔 M39X4 / Bottom F 2.5D 原值为 1135.00，本版以 CHECK 代替，待核实，不提供推算替代值。--- 表示原资料未列值；未列规格不作插值或外推。
CHECK: source M39X4 / Bottom F 2.5D reads 1135.00 and is withheld pending verification. --- means not listed. Do not interpolate missing dimensions.

本版按用户提供的 Drill-Tap.pdf（Rev. 03/26）整理，数值为第三方参考数据，未完成秩成产品适配验证。整理版本 ZC-DT-20261001-R1；无对外引流链接。
Compiled from the user-supplied Drill-Tap.pdf, Rev. 03/26. Third-party reference data; ZCOIL product compatibility is not verified. Document ZC-DT-20261001-R1.

公制钻孔参数 · 粗牙

Metric drilling / Metric Coarse | Unit: mm | Source p.3

螺纹规格	铝材钻头	钢材钻头	Plug F 1D	Plug F 1.5D	Plug F 2D	Plug F 2.5D	Plug F 3D	Bottom F 1D	Bottom F 1.5D	Bottom F 2D	Bottom F 2.5D	Bottom F 3D
M2X0.4	#44 (0.0860)	#44 (0.0860)	5.40	6.40	7.40	8.40	9.40	3.60	4.60	5.60	6.60	7.60
M2.2X0.45	2.30	2.35	6.00	7.10	8.20	9.30	10.40	4.00	5.10	6.20	7.30	8.40
M2.5X0.45	2.70	2.70	6.45	7.70	8.95	10.20	11.45	4.30	5.55	6.80	8.05	9.30
M3X0.5	3.15	3.20	7.50	9.00	10.50	12.00	13.50	5.00	6.50	8.00	9.50	11.00
M3.5X0.6	3.70	3.70	8.85	10.60	12.35	14.10	15.85	5.90	7.65	9.40	11.15	12.90
M4X0.7	4.20	4.25	10.20	12.20	14.20	16.20	18.20	6.80	8.80	10.80	12.80	14.80
M5X0.8	5.20	5.30	12.30	14.80	17.30	19.80	22.30	8.20	10.70	13.20	15.70	18.20
M6X1	6.25	6.30	15.00	18.00	21.00	24.00	27.00	10.00	13.00	16.00	19.00	22.00
M7X1	7.25	7.30	16.50	20.00	23.50	27.00	30.50	11.00	14.50	18.00	21.50	25.00
M8X1.25	8.30	8.40	19.50	23.50	27.50	31.50	35.50	13.00	17.00	21.00	25.00	29.00
M10X1.5	10.50	10.50	19.00	24.00	29.00	34.00	39.00	16.00	21.00	26.00	31.00	36.00
M12X1.75	12.50	12.50	22.50	28.50	34.50	40.50	46.50	19.00	25.00	31.00	37.00	43.00
M14X2	14.50	14.50	26.00	33.00	40.00	47.00	54.00	22.00	29.00	36.00	43.00	50.00
M16X2	16.50	16.50	28.00	36.00	44.00	52.00	60.00	24.00	32.00	40.00	48.00	56.00
M18X2.5	47/64	47/64	33.00	42.00	51.00	60.00	69.00	28.00	37.00	46.00	55.00	64.00
M20X2.5	13/16	13/16	35.00	45.00	55.00	65.00	75.00	30.00	40.00	50.00	60.00	70.00
M22X2.5	57/64	57/64	37.00	48.00	59.00	70.00	81.00	32.00	43.00	54.00	65.00	76.00
M24X3	25.00	25.00	42.00	54.00	66.00	78.00	90.00	36.00	48.00	60.00	72.00	84.00
M27X3	28.00	28.00	45.00	58.50	72.00	85.50	99.00	39.00	52.50	66.00	79.50	93.00
M30X3.5	31.00	31.00	51.00	66.00	81.00	96.00	111.00	44.00	59.00	74.00	89.00	104.00
M33X3.5	34.00	34.00	54.00	70.50	87.00	103.50	120.00	47.00	63.50	80.00	96.50	113.00
M36X4	37.00	37.00	60.00	78.00	96.00	114.00	132.00	52.00	70.00	88.00	106.00	124.00
M39X4	40.00	40.00	63.00	82.50	102.00	121.50	141.00	55.00	74.50	94.00	CHECK	133.00

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[]为原脚注。 钻头编号、字母及分数为英制规格；详见第1页。CHECK：原值 1135.00 异常，暂不采用。

公制钻孔参数 · 细牙

Metric drilling / Metric Fine | Unit: mm | Source p.3

螺纹规格	铝材钻头	钢材钻头	Plug F 1D	Plug F 1.5D	Plug F 2D	Plug F 2.5D	Plug F 3D	Bottom F 1D	Bottom F 1.5D	Bottom F 2D	Bottom F 2.5D	Bottom F 3D
M8X1	8.25	8.30	18.00	22.00	26.00	30.00	34.00	12.00	16.00	20.00	24.00	28.00
M10X1	10.25	10.25	16.00	21.00	26.00	31.00	36.00	14.00	19.00	24.00	29.00	34.00
M10X1.25 [2]	10.25	10.25	17.50	22.50	27.50	32.50	37.50	15.00	20.00	25.00	30.00	35.00
M12X1.25 [2]	12.25	12.25	19.50	25.50	31.50	37.50	43.50	17.00	23.00	29.00	35.00	41.00
M12X1.5 [2]	12.25	12.50	21.00	27.00	33.00	39.00	45.00	18.00	24.00	30.00	36.00	42.00
M14X1.5 [2]	14.25	14.50	23.00	30.00	37.00	44.00	51.00	20.00	27.00	34.00	41.00	48.00
M16X1.5 [2]	16.25	16.50	25.00	33.00	41.00	49.00	57.00	22.00	30.00	38.00	46.00	54.00
M18X1.5 [2]	18.25	18.50	27.00	36.00	45.00	54.00	63.00	24.00	33.00	42.00	51.00	60.00
M20X1.5 [2]	20.25	20.50	29.00	39.00	49.00	59.00	69.00	26.00	36.00	46.00	56.00	66.00
M22X1.5 [2]	22.25	22.50	31.00	42.00	53.00	64.00	75.00	28.00	39.00	50.00	61.00	72.00
M18X2	18.50	18.50	30.00	39.00	48.00	57.00	66.00	26.00	35.00	44.00	53.00	62.00
M20X2	20.50	20.50	32.00	42.00	52.00	62.00	72.00	28.00	38.00	48.00	58.00	68.00
M22X2	22.50	22.50	34.00	45.00	56.00	67.00	78.00	30.00	41.00	52.00	63.00	74.00
M24X2	24.50	24.50	36.00	48.00	60.00	72.00	84.00	32.00	44.00	56.00	68.00	80.00
M27X2	27.50	27.50	39.00	52.50	66.00	79.50	93.00	35.00	48.50	62.00	75.50	89.00
M30X2	30.50	30.50	42.00	57.00	72.00	87.00	102.00	38.00	53.00	68.00	83.00	98.00
M33X2	33.50	33.50	45.00	61.50	78.00	94.50	111.00	41.00	57.50	74.00	90.50	107.00
M39X2	39.50	39.50	51.00	70.50	90.00	109.00	129.00	47.00	66.50	86.00	105.50	125.00
M36X3	37.00	37.00	54.00	72.00	90.00	108.00	126.00	48.00	66.00	84.00	102.00	120.00
M39X3	40.00	40.00	57.00	76.50	96.00	115.50	135.00	51.00	70.50	90.00	109.50	129.00

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[]为原脚注。 钻头编号、字母及分数为英制规格；详见第 1 页。

公制 STI 攻丝参数 · 粗牙

Metric STI tapping / Metric Coarse | Unit: mm | Source p.5

螺纹规格	小径 Min	小径 Max	沉孔 M Min	沉孔 M Max	中径 Min	中径 Max 4H	中径 Max 5H	H 1D	H 1.5D	H 2D	H 2.5D	H 3D	丝锥大径 Max
M2X0.4	2.087	2.199	2.30	2.70	2.260	2.295	2.310	2.4	3.4	4.4	5.4	6.4	2.581
M2.2X0.45	2.297	2.422	2.60	3.00	2.492	2.532	2.547	2.7	3.8	4.9	6.0	7.1	2.845
M2.5X0.45	2.597	2.722	2.90	3.40	2.792	2.832	2.847	3.0	4.2	5.5	6.7	8.0	3.147
M3X0.5	3.108	3.248	3.40	4.00	3.325	3.367	3.384	3.5	5.0	6.5	8.0	9.5	3.716
M3.5X0.6	3.630	3.790	4.10	4.70	3.890	3.940	3.959	4.1	5.9	7.6	9.4	11.1	4.354
M4X0.7	4.152	4.332	4.70	5.30	4.455	4.509	4.529	4.7	6.7	8.7	10.7	12.7	5.006
M5X0.8	5.174	5.374	5.80	6.40	5.520	5.577	5.597	5.8	8.3	10.8	13.3	15.8	6.142
M6X1	6.217	6.407	7.10	7.70	6.650	6.719	6.742	7.0	10.0	13.0	16.0	19.0	7.422
M7X1	7.217	7.407	8.10	8.70	7.650	7.719	7.742	8.0	11.5	15.0	18.5	22.0	8.423
M8X1.25	8.271	8.483	9.50	10.10	8.812	8.886	8.911	9.3	13.3	17.3	21.3	25.3	9.787
M10X1.5	10.324	10.560	11.80	12.40	10.974	11.061	11.089	11.5	16.5	21.5	26.5	31.5	12.131
M12X1.75 [1]	12.379	12.644	14.20	14.80	13.137	13.236	13.271	13.8	19.8	25.8	31.8	37.8	14.478
M14X2	14.433	14.733	16.50	17.10	15.299	15.406	15.444	16.0	23.0	30.0	37.0	44.0	16.822
M16X2	16.433	16.733	18.50	19.10	17.299	17.406	17.444	18.0	26.0	34.0	42.0	50.0	18.821
M18X2.5	18.541	18.896	21.20	21.80	19.624	19.738	19.778	20.5	29.5	38.5	47.5	56.5	21.514
M20X2.5	20.541	20.896	23.20	23.80	21.624	21.738	21.778	22.5	32.5	42.5	52.5	62.5	23.513
M22X2.5	22.541	22.896	25.20	25.80	23.624	23.738	23.778	24.5	35.5	46.5	57.5	68.5	25.512
M24X3	24.649	25.049	27.90	28.50	25.948	26.093	26.135	27.0	39.0	51.0	63.0	75.0	28.237
M27X3	27.649	28.049	30.90	31.50	28.948	29.093	29.135	30.0	43.5	57.0	70.5	84.0	31.238

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[] 为原脚注。沉孔角度 120 ° ±5 ° ；小径指攻丝后尺寸。

公制 STI 攻丝参数 · 细牙

Metric STI tapping / Metric Fine | Unit: mm | Source p.5

螺纹规格	小径 Min	小径 Max	沉孔 M Min	沉孔 M Max	中径 Min	中径 Max 4H	中径 Max 5H	H 1D	H 1.5D	H 2D	H 2.5D	H 3D	丝锥大径 Max
M8X1	8.217	8.407	9.10	9.70	8.650	8.719	8.742	9.0	13.0	17.0	21.0	25.0	9.423
M10X1	10.217	10.407	11.10	11.70	10.650	10.719	10.742	11.0	16.0	21.0	26.0	31.0	11.422
M10X1.25 [1]	10.271	10.483	11.50	12.10	10.812	10.886	10.911	11.3	16.3	21.3	26.3	31.3	11.788
M12X1.25 [1]	12.271	12.483	13.50	14.10	12.812	12.898	12.926	13.3	19.3	25.3	31.3	37.3	13.787
M12X1.5 [1]	12.324	12.560	13.80	14.40	12.974	13.067	13.099	13.5	19.5	25.5	31.5	37.5	14.133
M14X1.5 [1]	14.324	14.560	15.80	16.40	14.974	15.067	15.099	15.5	22.5	29.5	36.5	43.5	16.131
M16X1.5 [1]	16.324	16.560	17.80	18.40	16.974	17.067	17.099	17.5	25.5	33.5	41.5	49.5	18.131
M18X1.5 [1]	18.324	18.560	19.80	20.40	18.974	19.067	19.099	19.5	28.5	37.5	46.5	55.5	20.132
M20X1.5 [1]	20.324	20.560	21.80	22.40	20.974	21.067	21.099	21.5	31.5	41.50	51.5	61.5	22.131
M22X1.5 [1]	22.324	22.560	23.80	24.40	22.974	23.067	23.099	23.5	34.5	45.50	56.5	67.5	24.130
M18X2	18.433	18.733	20.50	21.10	19.299	19.406	19.444	20.0	29.0	38.0	47.0	56.0	20.823
M20X2	20.433	20.733	22.50	23.10	21.299	21.406	21.444	22.0	32.0	42.0	52.0	62.0	22.822
M22X2	22.433	22.733	24.50	25.10	23.299	23.406	23.444	24.0	35.0	46.0	57.0	68.0	24.823
M24X2	24.433	24.733	26.50	27.10	25.299	25.414	25.454	26.0	38.0	50.0	62.0	74.0	26.820
M27X2	27.433	27.733	29.50	30.10	28.299	28.414	28.455	29.0	42.5	56.0	69.5	83.0	29.822
M30X2	30.433	30.733	32.50	33.10	31.299	31.414	31.454	32.0	47.0	62.0	77.0	92.0	32.822
M33X2	33.433	33.733	35.50	36.10	34.299	34.414	34.454	35.0	51.5	68.0	84.5	101.0	35.822
M39X2	39.433	39.733	41.50	42.10	40.299	40.414	40.454	41.0	60.5	80.0	99.5	119.0	41.821
M36X3	36.649	37.049	39.90	40.50	37.948	38.093	38.135	39.0	57.0	75.0	93.0	111.0	40.236
M39X3	39.649	40.049	42.90	43.50	40.948	41.093	41.135	42.0	61.5	81.0	100.5	120.0	43.236

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[] 为原脚注。沉孔角度 120 ° ±5 ° ；小径指攻丝后尺寸。

英制钻孔参数 · 粗牙

Unified drilling / Unified Coarse | Unit: in | Source p.2

螺纹规格	铝材钻头	钢材钻头	Plug F 1D	Plug F 1.5D	Plug F 2D	Plug F 2.5D	Plug F 3D	Bottom F 1D	Bottom F 1.5D	Bottom F 2D	Bottom F 2.5D	Bottom F 3D
1-64	#47 (.0785)	#46 (.0810)	0.203	0.240	0.276	0.313	0.349	0.136	0.172	0.209	0.245	0.282
2-56	3/32 (.0938)	#41 (.0960)	0.236	0.279	0.322	0.365	0.408	0.157	0.200	0.243	0.286	0.329
3-48	#36 (.1065)	7/64 (.1094)	0.273	0.323	0.372	0.422	0.471	0.182	0.232	0.281	0.331	0.380
4-40	#31 (.1200)	#31 (.1200)	0.318	0.374	0.430	0.486	0.542	0.212	0.268	0.324	0.380	0.436
5-40	3.4mm (.1339)	#29 (.1360)	0.338	0.400	0.462	0.525	0.588	0.225	0.288	0.350	0.412	0.475
6-32	#26 (.1470)	#25 (.1495)	0.394	0.464	0.532	0.602	0.670	0.263	0.332	0.401	0.470	0.539
8-32	#17 (.1730)	#16 (.1770)	0.434	0.516	0.598	0.680	0.762	0.289	0.371	0.453	0.535	0.617
10-24	13/64 (.2031)	#5 (.2055)	0.535	0.630	0.725	0.820	0.915	0.357	0.452	0.547	0.642	0.737
12-24	#1 (.2280)	#1 (.2280)	0.574	0.682	0.790	0.898	1.006	0.383	0.491	0.599	0.707	0.815
1/4-20	H (.2660)	H (.2660)	0.675	0.800	0.925	1.050	1.175	0.450	0.575	0.700	0.825	0.950
5/16-18	Q (.3320)	Q (.3320)	0.801	0.957	1.113	1.269	1.425	0.534	0.690	0.846	1.002	1.158
3/8-16	X (.3970)	X (.3970)	0.750	0.938	1.125	1.312	1.500	0.625	0.812	1.000	1.188	1.375
7/16-14	29/64 (.4531)	29/64 (.4531)	0.867	1.086	1.305	1.524	1.743	0.724	0.943	1.162	1.381	1.600
1/2-13 [1]	33/64 (.5156)	17/32 (.5312)	0.962	1.212	1.462	1.712	1.962	0.808	1.058	1.308	1.558	1.808
9/16-12 [1]	37/64 (.5781)	19/32 (.5938)	1.062	1.343	1.624	1.905	2.186	0.895	1.176	1.457	1.738	2.019
5/8-11	21/32 (.6562)	21/32 (.6562)	1.170	1.483	1.795	2.108	2.420	0.989	1.301	1.614	1.926	2.239
3/4-10	25/32 (.7812)	25/32 (.7812)	1.350	1.725	2.100	2.475	2.850	1.150	1.525	1.900	2.275	2.650
7/8-9	29/32 (.9062)	29/32 (.9062)	1.542	1.979	2.417	2.854	3.292	1.319	1.757	2.194	2.632	3.069
1-8	1-1/32 (1.0312)	1-1/32 (1.0312)	1.750	2.250	2.750	3.250	3.750	1.500	2.000	2.500	3.000	3.500
1-1/8-7	1-11/64 (1.1719)	1-11/64 (1.1719)	1.982	2.545	3.107	3.670	4.232	1.696	2.259	2.821	3.384	3.946
1-1/4-7	1-19/64 (1.2969)	1-19/64 (1.2969)	2.107	2.732	3.357	3.982	4.607	1.821	2.446	3.071	3.696	4.321
1-3/8-6	1-27/64 (1.4219)	1-27/64 (1.4219)	2.375	3.062	3.750	4.437	5.125	2.042	2.729	3.417	4.104	4.792
1-1/2-6	1-35/64 (1.5469)	1-35/64 (1.5469)	2.500	3.250	4.000	4.750	5.500	2.167	2.917	3.667	4.417	5.167

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[]为原脚注。钻头编号、字母及分数为英制规格；详见第1页。

英制钻孔参数 · 细牙

Unified drilling / Unified Fine | Unit: in | Source p.2

螺纹规格	铝材钻头	钢材钻头	Plug F 1D	Plug F 1.5D	Plug F 2D	Plug F 2.5D	Plug F 3D	Bottom F 1D	Bottom F 1.5D	Bottom F 2D	Bottom F 2.5D	Bottom F 3D
0-80	#52 (.0635)	#52 (.0635)	0.165	0.195	0.225	---	---	0.110	0.140	0.170	---	---
3-56	#37 (.1040)	#36 (.1065)	0.256	0.305	0.355	0.404	0.454	0.170	0.220	0.269	0.319	0.368
4-48	3mm (.1181)	#31 (.1200)	0.293	0.349	0.405	0.461	0.517	0.195	0.251	0.307	0.363	0.419
6-40	#26 (.1470)	#25 (.1495)	0.357	0.426	0.495	0.564	0.633	0.238	0.307	0.376	0.445	0.514
8-36	#17 (.1730)	#16 (.1770)	0.413	0.495	0.577	0.659	0.741	0.275	0.357	0.439	0.521	0.603
10-32	#7 (.2010)	13/64 (.2031)	0.472	0.568	0.662	0.758	0.852	0.315	0.410	0.505	0.600	0.695
1/4-28	G (.2610)	6.7mm (.2638)	0.589	0.714	0.839	0.964	1.089	0.393	0.518	0.643	0.768	0.893
5/16-24	21/64 (.3281)	21/64 (.3281)	0.718	0.874	1.030	1.186	1.342	0.479	0.635	0.791	0.947	1.103
3/8-24	25/64 (.3906)	25/64 (.3906)	0.625	0.812	1.000	1.187	1.375	0.542	0.729	0.917	1.104	1.292
7/16-20	29/64 (.4531)	29/64 (.4531)	0.738	0.957	1.176	1.395	1.614	0.638	0.857	1.076	1.295	1.514
1/2-20	33/64 (.5156)	33/64 (.5156)	0.800	1.050	1.300	1.550	1.800	0.700	0.950	1.200	1.450	1.700
9/16-18	37/64 (.5781)	37/64 (.5781)	0.895	1.176	1.457	1.738	2.019	0.784	1.065	1.346	1.627	1.908
5/8-18	41/64 (.6406)	41/64 (.6406)	0.958	1.271	1.583	1.896	2.208	0.847	1.160	1.472	1.785	2.097
3/4-16	49/64 (.7656)	49/64 (.7656)	1.125	1.500	1.875	2.250	2.625	1.000	1.375	1.750	2.125	2.500
7/8-14	57/64 (.8906)	57/64 (.8906)	1.304	1.741	2.179	2.616	3.054	1.161	1.598	2.036	2.473	2.911
1-12	1-1/64 (1.0156)	1-1/32 (1.0312)	1.500	2.000	2.500	3.000	3.500	1.333	1.833	2.333	2.833	3.333
1-1/8-12 [1]	1-9/64 (1.1406)	1-5/32 (1.1562)	1.625	2.187	2.750	3.312	3.875	1.458	2.021	2.583	3.146	3.708
1-1/4-12 [1]	1-17/64 (1.2656)	1-9/32 (1.2812)	1.750	2.375	3.000	3.625	4.250	1.583	2.208	2.833	3.458	4.083
1-3/8-12 [1]	1-25/64 (1.3906)	1-13/32 (1.4062)	1.875	2.562	3.250	3.937	4.625	1.708	2.396	3.083	3.771	4.458
1-1/2-12 [1]	1-33/64 (1.5156)	1-17/32 (1.5312)	2.000	2.750	3.500	4.250	5.000	1.833	2.583	3.333	4.083	4.833

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[]为原脚注。 钻头编号、字母及分数为英制规格；详见第 1 页。

英制 STI 攻丝参数 · 粗牙

Unified STI tapping / Unified Coarse | Unit: in | Source p.4

螺纹规格	小径 Min	小径 Max 3B	小径 Max 2B	沉孔 M Min	沉孔 M Max	中径 Min	中径 Max 3B	中径 Max 2B	H 1D	H 1.5D	H 2D	H 2.5D	H 3D	丝锥大径 Max	螺距 P
1-64	0.0764	0.0823	0.0823	0.09	0.11	0.0832	0.0843	0.0850	0.09	0.13	0.16	0.20	0.24	0.0958	0.01563
2-56	0.0899	0.0961	0.0961	0.11	0.13	0.0976	0.0989	0.0996	0.10	0.15	0.19	0.23	0.28	0.1117	0.01786
3-48	0.1036	0.1104	0.1104	0.12	0.14	0.1126	0.1140	0.1148	0.12	0.17	0.22	0.27	0.32	0.1289	0.02083
4-40	0.1175	0.1252	0.1252	0.14	0.17	0.1283	0.1299	0.1308	0.14	0.19	0.25	0.31	0.36	0.1473	0.02500
5-40	0.1305	0.1373	0.1373	0.15	0.18	0.1413	0.1430	0.1438	0.15	0.21	0.28	0.34	0.40	0.1603	0.02500
6-32	0.1448	0.1527	0.1527	0.17	0.20	0.1583	0.1601	0.1611	0.17	0.24	0.31	0.38	0.45	0.1817	0.03125
8-32	0.1708	0.1781	0.1781	0.20	0.23	0.1843	0.1862	0.1872	0.20	0.28	0.36	0.44	0.52	0.2077	0.03125
10-24	0.1990	0.2080	0.2087	0.24	0.27	0.2170	0.2192	0.2203	0.23	0.33	0.42	0.52	0.61	0.2475	0.04167
12-24	0.2250	0.2340	0.2347	0.26	0.29	0.2430	0.2453	0.2464	0.26	0.37	0.47	0.58	0.69	0.2735	0.04167
1/4-20	0.2608	0.2704	0.2723	0.31	0.34	0.2825	0.2851	0.2864	0.30	0.43	0.55	0.68	0.80	0.3187	0.05000
5/16-18	0.3245	0.3342	0.3372	0.38	0.41	0.3486	0.3515	0.3529	0.37	0.53	0.68	0.84	0.99	0.3884	0.05556
3/8-16	0.3885	0.3987	0.4026	0.45	0.48	0.4156	0.4189	0.4203	0.44	0.63	0.81	1.00	1.19	0.4602	0.06250
7/16-14	0.4530	0.4639	0.4688	0.52	0.55	0.4839	0.4875	0.4890	0.51	0.73	0.95	1.17	1.38	0.5343	0.07143
1/2-13 [1]	0.5166	0.5273	0.5335	0.59	0.62	0.5499	0.5537	0.5554	0.58	0.83	1.08	1.33	1.58	0.6042	0.07692
9/16-12 [1]	0.5806	0.5918	0.5986	0.66	0.69	0.6167	0.6208	0.6225	0.65	0.93	1.21	1.49	1.77	0.6751	0.08333
5/8-11	0.6447	0.6564	0.6641	0.73	0.76	0.6841	0.6885	0.6903	0.72	1.03	1.34	1.65	1.97	0.7477	0.09091
3/4-10	0.7716	0.7838	0.7926	0.86	0.89	0.8149	0.8196	0.8216	0.85	1.23	1.60	1.98	2.35	0.8850	0.10000
7/8-9	0.8990	0.9119	0.9218	1.00	1.03	0.9471	0.9522	0.9543	0.99	1.42	1.86	2.30	2.74	1.0247	0.11111
1-8	1.0271	1.0421	1.0521	1.14	1.17	1.0812	1.0898	1.0898	1.13	1.63	2.13	2.63	3.13	1.1681	0.12500
1-1/8-7	1.1559	1.1730	1.1834	1.29	1.32	1.2178	1.2239	1.2262	1.27	1.83	2.39	2.96	3.52	1.3171	0.14286
1-1/4-7	1.2809	1.2980	1.3084	1.41	1.44	1.3428	1.3490	1.3514	1.39	2.02	2.64	3.27	3.89	1.4421	0.14286
1-3/8-6	1.4110	1.4310	1.4416	1.56	1.59	1.4832	1.4900	1.4926	1.54	2.23	2.92	3.60	4.29	1.5982	0.16667
1-1/2-6	1.5360	1.5560	1.5665	1.69	1.72	1.6082	1.6151	1.6177	1.67	2.42	3.17	3.92	4.67	1.7232	0.16667

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[] 为原脚注。沉孔角度 120 ° ±5 ° ；小径指攻丝后尺寸。

英制 STI 攻丝参数 · 细牙

Unified STI tapping / Unified Fine | Unit: in | Source p.4

螺纹规格	小径 Min	小径 Max 3B	小径 Max 2B	沉孔 M Min	沉孔 M Max	中径 Min	中径 Max 3B	中径 Max 2B	H 1D	H 1.5D	H 2D	H 2.5D	H 3D	丝锥大径 Max	螺距 P
0-80	0.0628	0.0665	0.0665	0.07	0.11	0.0681	0.0691	0.0697	0.07	0.10	0.13	---	---	0.0775	0.01250
3-56	0.1029	0.1086	0.1086	0.12	0.14	0.1106	0.1119	0.1126	0.12	0.17	0.22	0.27	0.31	0.1247	0.01786
4-48	0.1166	0.1229	0.1229	0.14	0.17	0.1256	0.1271	0.1279	0.13	0.19	0.24	0.30	0.36	0.1419	0.02083
6-40	0.1435	0.1503	0.1503	0.17	0.20	0.1543	0.1560	0.1569	0.16	0.23	0.30	0.37	0.44	0.1733	0.02500
8-36	0.1701	0.1771	0.1771	0.20	0.23	0.1821	0.1840	0.1849	0.19	0.27	0.36	0.44	0.52	0.2032	0.02778
10-32	0.1968	0.2041	0.2041	0.23	0.26	0.2103	0.2123	0.2133	0.22	0.32	0.41	0.51	0.60	0.2337	0.03125
1/4-28	0.2577	0.2646	0.2661	0.29	0.32	0.2732	0.2754	0.2765	0.29	0.41	0.54	0.66	0.79	0.2995	0.03571
5/16-24	0.3215	0.3288	0.3312	0.36	0.39	0.3395	0.3421	0.3433	0.35	0.51	0.67	0.82	0.98	0.3700	0.04167
3/8-24	0.3840	0.3910	0.3937	0.42	0.45	0.4020	0.4047	0.4059	0.42	0.60	0.79	0.98	1.17	0.4325	0.04167
7/16-20	0.4483	0.4561	0.4598	0.50	0.53	0.4700	0.4731	0.4744	0.49	0.71	0.93	1.14	1.36	0.5062	0.05000
1/2-20	0.5108	0.5186	0.5223	0.56	0.59	0.5325	0.5357	0.5371	0.55	0.80	1.05	1.30	1.55	0.5687	0.05000
9/16-18	0.5745	0.5826	0.5872	0.63	0.66	0.5986	0.6020	0.6035	0.62	0.90	1.18	1.46	1.74	0.6384	0.05556
5/8-18	0.6370	0.6451	0.6497	0.69	0.72	0.6611	0.6646	0.6661	0.68	0.99	1.31	1.62	1.93	0.7009	0.05556
3/4-16	0.7635	0.7720	0.7776	0.82	0.85	0.7906	0.7945	0.7961	0.81	1.19	1.56	1.94	2.31	0.8352	0.06250
7/8-14	0.8905	0.8994	0.9063	0.96	0.99	0.9214	0.9257	0.9274	0.95	1.38	1.82	2.26	2.70	0.9718	0.07143
1-12	1.0181	1.0281	1.0361	1.10	1.13	1.0542	1.0589	1.0608	1.08	1.58	2.08	2.58	3.08	1.1126	0.08333
1-1/8-12 [1]	1.1431	1.1531	1.1611	1.22	1.25	1.1792	1.1841	1.1860	1.21	1.77	2.33	2.90	3.46	1.2376	0.08333
1-1/4-12 [1]	1.2681	1.2781	1.2861	1.35	1.38	1.3042	1.3092	1.3112	1.33	1.96	2.58	3.21	3.83	1.3626	0.08333
1-3/8-12 [1]	1.3931	1.4031	1.4111	1.47	1.50	1.4292	1.4343	1.4364	1.46	2.15	2.83	3.52	4.21	1.4876	0.08333
1-1/2-12 [1]	1.5181	1.5281	1.5361	1.60	1.63	1.5542	1.5595	1.5615	1.58	2.33	3.08	3.83	4.58	1.6126	0.08333

参考版：与确认图纸及工具匹配后使用。D=公称直径；F=最小钻孔深度；H=最小攻丝深度；[]为原脚注。沉孔角度 120 ° ±5 ° ；小径指攻丝后尺寸。