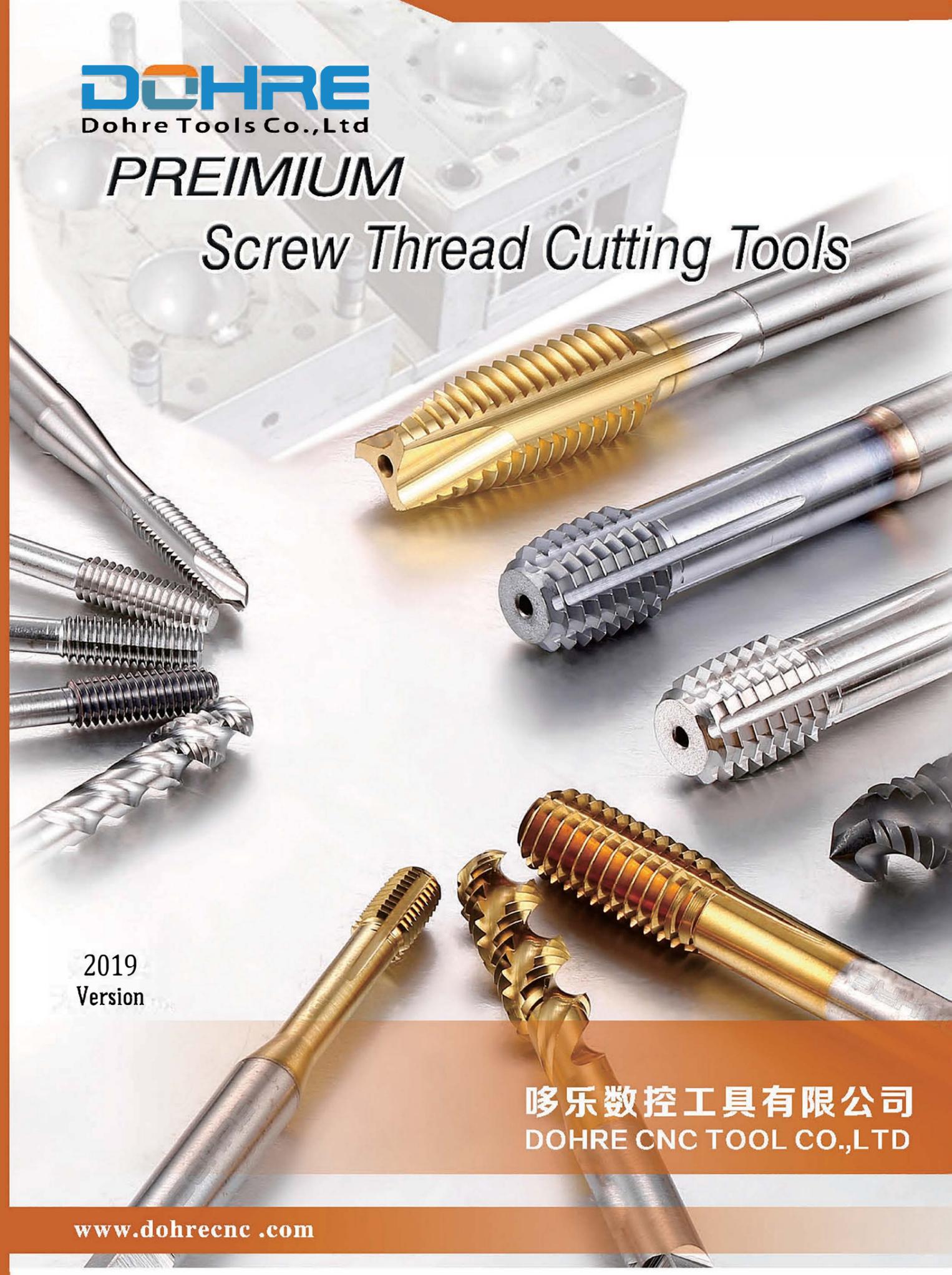




PREMIUM

Screw Thread Cutting Tools



2019
Version

哆乐数控工具有限公司
DOHRE CNC TOOL CO.,LTD

Introduction

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 condident to meet your needs with good quality products, competitive prices and fast services.

簡介

哆樂數控工具有限公司是CNC切削刀具專業制造銷售商和技術服務商，主要面向全世界各工業城市的數控機床使用企業，提供高品質，高性價比，短交貨期的切削工具和全方位的技术支持。

哆樂數控工具有限公司一直倡導誠信、務實、創新、高效率的經營理念，引進德國最先進的CNC五軸磨床設備和CNC五軸全自動測量設，CNC螺紋磨床領先磨刀技術，公司現有進口磨床20台，採用國內外最優質的棒材，從而形成了優質、高效、先進的生產制造系統，所生產的高品質CNC鎢鋼銑刀、鎢鋼絲攻，非標絲攻、成型刀具，CNC高精度刀柄，高精度筒夾，和全方位切削刀具設計方案。在國內外受到眾多使用者的好評。帶着最優質的產品，最有競爭力的價格和最快捷的服務，哆樂將以完全的自信來滿足您的需求。

MEMO

A series of horizontal dashed lines for writing, located on the right side of the page.

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

采用德國制 μ m級（精密刀具設定與測量設備）快速測量刀具，是螺紋精度測量的一大利器



钨钢丝锥

高速
高精 切削

高精度产品切削最佳选择
是您工作新利器！新选择！

全新哆乐钨钢丝锥

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！

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！

PICTURE INDEX

THREAD FORMING TAP SERIES

擠壓絲錐

<p>METRIC COARSE THREAD 公制粗紋</p>		<p>C01</p>
<p>UNIFIED THREAD 美制粗紋</p>		<p>C03</p>
<p>METRIC FINE THREAD 公制細牙粗紋</p>		<p>C05</p>
<p>LONG SHANK 長柄型</p>		<p>C06</p>
<p>SHORT THREADD 短線紋型</p>		<p>C08</p>
<p>SHORT CHAMFER 短倒角錐型</p>		<p>C09</p>
<p>LONG CHAMFER 長倒角錐型</p>		<p>C10</p>

SPIRAL FLUTED TAP SERIES

螺旋槽絲錐

<p>METRIC COARSE THREAD 公制粗紋</p>		<p>C11</p>
<p>LEFT HAND 左螺紋</p>		<p>C12</p>
<p>METRIC FINE THREAD 公制細牙螺紋</p>		<p>C13</p>
<p>UNIFIED THREADE 美制粗紋</p>		<p>C14</p>
<p>LONG SHANK 長柄型</p>		<p>C15</p>
<p>INSERT SCREW THREAD TP 螺套絲錐</p>		<p>C17</p>
<p>SPIRAL GROOVE LONG HANDLE A SCREW TAP 長柄螺套絲錐</p>		<p>C17</p>

PICTURE INDEX

SPIRAL POINTED TAP SERIES

刃傾角絲錐

<p>METRIC COARSE THREAD 公制螺紋</p>		<p>C18</p>
<p>METRIC FINE THREAD 公制細牙螺紋</p>		<p>C19</p>
<p>UNIFIED THREAD 美制螺紋</p>		<p>C20</p>
<p>LONG SHANK 長柄型</p>		<p>C21</p>
<p>INSERT SCREW THREAD TP 螺套絲錐</p>		<p>C23</p>
<p>SPIRAL GROOVE LONG HANDLE A SCREW TAP 長柄溝槽絲錐</p>		<p>C23</p>
<p>LEFT HAND 左螺紋</p>		<p>C24</p>

STRAIGHT FLUTED TAP SERIES

直槽絲錐

<p>METRIC COARSE THREAD 公制螺紋</p>		<p>C25</p>
<p>UNIFIED THREADE 美制螺紋</p>		<p>C26</p>
<p>LEFT HAND 左螺紋</p>		<p>C27</p>
<p>LONG SHANK 長柄型</p>		<p>C28</p>
<p>METRIC FINE THREAD 公制細牙螺紋</p>		<p>C30</p>
<p>INSERT SCREW THREAD TP 螺套絲錐</p>		<p>C31</p>
<p>SPIRAL GROOVE LONG HANDLE A SCREW TAP 長柄溝槽絲錐</p>		<p>C31</p>

PICTURE INDEX

STRAIGHT FLUTED TAP SERIES

直槽絲錐

NUT TAPS(METRIC THREAD)

螺母絲錐 (公制)



C32

SPIRAL FLUTED TAP COMBINED WITH DRILL

鑽攻一體式螺旋槽絲錐

SPIRAL FLUTED TAP COMBINED WITH DRILL

鑽攻一體式螺旋槽絲錐



C33

SOLID CARBIDE THREAD FORMING TAP SERIES

硬質合金擠壓絲錐

METRIC COARSE THREAD

公制粗紋

C34

LONG SHANK

長柄型



C36

UNIFIED THREAD

美制細紋



C37

SOLID CARBIDE SPIRAL FLUTED TAP SERIES

硬質合金螺旋槽絲錐

SOLID CARBIDE SPIRAL FLUTED TAP

硬質合金螺旋槽絲錐



C39

SOLID CARBIDE SPIRAL FLUTED TAP WITH INTERNAL COOLANT SUPPLY

硬質合金帶內冷卻孔螺旋槽絲錐



C40

UNIFIED THREAD

美制細紋



C40

LONG SHANK

長柄型



C41

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

硬質合金螺旋槽平行管螺紋絲錐



C42

LONG SHANK CARBIDE PARALLEL PIPE THREAD TAP WITH SPIRAL FLUTE

硬質合金螺旋槽長柄平行管螺紋絲錐

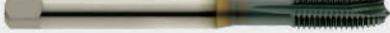


C42

PICTURE INDEX

SOLID CARBIDE SPIRAL POINTED TAP SERIES

硬質合金刃傾角絲錐

<p>SOLID CARBIDE SPIRAL POINTED TAP 硬質合金刃傾角絲錐</p>		<p>C43</p>
<p>LONG SHANK SOLID CARBIDE SPIRAL POINTED TAP 硬質合金長柄刃傾角絲錐</p>		<p>C44</p>
<p>GENERAL APPLICATION UNIFIED THREAD FORM 一般用美制螺紋刃傾角絲錐</p>		<p>C45</p>

STRAIGHT FLUTED CARBIDE TAP SERIES

硬質合金直槽絲錐

<p>METRIC COARSE THREAD 公制螺紋</p>		<p>C46</p>
<p>LONG SHANK 長柄型</p>		<p>C48</p>
<p>LONG SHANK TAPER PIPE THREAD TAP WITH STRAIGHT FLUTE 硬質合金長柄直槽錐管螺紋絲錐</p>		<p>C49</p>
<p>STRAIGHT FLUTED CARBIDE PARALLEL PIPE THREAD TAP 硬質合金直槽平行管螺紋</p>		<p>C49</p>
<p>LONG SHANK CARBIDE PARALLEL PIPE THREAD TAP STRAIGHT FLUTE 硬質合金長柄直槽平行管螺紋</p>		<p>C49</p>

METRIC COARSE THREAD

挤压丝锥
THREAD FORMING TAP SERIES

公司网址

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

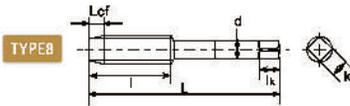
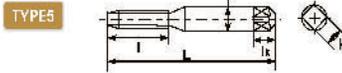
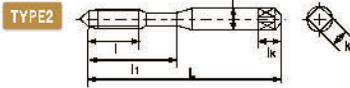
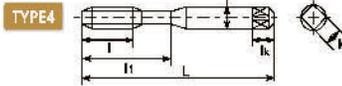
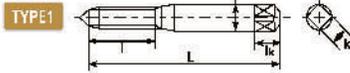
TIN

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、铜合金大量高精度加工，塑性变形无切屑，可实现稳定连续加工。



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) 螺攻长(l)	Second section length (l1) 二部长度 (l1)	Shank diameter (d) 柄径(d)	TYPE 形状
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	M1.8	0.35	RH6	4P	36	6	-	3	1
DL1173562			RH6	2P					5
DL1183544			RH4	4P					1
DL1183542			RH4	2P					5
DL1183554	M2	0.4	RH5	4P	40	9.5	-	3	1
DL1183552			RH5	2P					5
DL1204044			RH4	4P					1
DL1204042			RH4	2P					5
DL1204054	M2.3	0.4	RH5	4P	42	9.5	-	3	1
DL1204052			RH5	2P					5
DL1204064			RH6	4P					1
DL1204062			RH6	2P					5
DL1234044	M2.5	0.45	RH4	4P	44	9.5	-	3	1
DL1234042			RH4	2P					5
DL1234054			RH5	4P					1
DL1234052			RH5	2P					5
DL1234064	M2.5	0.45	RH6	4P	44	9.5	-	3	1
DL1234062			RH6	2P					5
DL1254544			RH4	4P					1
DL1254542			RH4	2P					5
DL1254554	M2.5	0.45	RH5	4P	44	9.5	-	3	1
DL1254552			RH5	2P					5
DL1254564			RH6	4P					1
DL1254562			RH6	2P					5

Ordering rules
订购规则

Product code
产品编号

Selection of materials
材料选择

Surface treatment
表面处理

TYPE
形状

For example: DL1102534 - CPM - TIN - 1

DOHRE
Dohre Tools Co., Ltd

www.dohrecnc.com

C01

METRIC COARSE THREAD

公制螺紋

Product code 產品編號	Specification 規格	Pitch 螺距	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 (f) 二節長 (f)	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	M3	0.5	RH6	2P	46	9	12	4	5
DL1305054			RH5	4P					2
DL1305052	RH5	2P	4						
DL1356054	M3.5	0.6	RH5	4P	48	9	12	4	2
DL1356052			RH5	2P					4
DL1407064	M4	0.7	RH6	4P	52	10	14	5	2
DL1407062			RH6	2P					4
DL1508064	M5	0.8	RH6	4P	60	11	22	5.5	2
DL1508062			RH6	2P					4
DL1601074	M6	1	RH7	4P	62	12	24	6	2
DL1601072			RH7	2P					4
DL1701064	M7	1	RH6	4P	65	13	26	6.2	8
DL1701062			RH6	2P					8
DL18012574	M8	1.25	RH7	4P	70	18	-	6.2	8
DL18012572			RH7	2P					8
DL110015074	M10	1.5	RH7	4P	75	19	-	7	8
DL110015072			RH7	2P					8
DL112017584	M12	1.75	RH8	4P	82	23	-	8.5	8
DL112017582			RH8	2P					8

系列简介

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

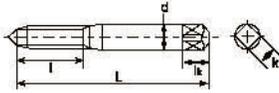
TIN

TICN

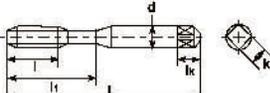
DLC

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、无屑塑性变形，能够实现稳定连续加工。

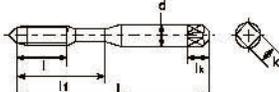
TYPE1



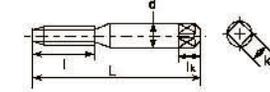
TYPE4



TYPE2



TYPE5



Product code 产品规格	Specification 规格	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 (f) 二阶段长(f)	Shank diameter (d) 柄径(d)	TYPE 形款
DL2008034	No.0-80	RH3	4P	36	6	-	3	1
DL2008032		RH3	2P					5
DL2008044		RH4	4P					1
DL2008042	No.1-64	RH4	2P	36	6	-	3	5
DL2016434		RH3	4P					1
DL2016432		RH3	2P					5
DL2046444	No.1-72	RH4	4P	36	6	-	3	1
DL2016442		RH4	2P					5
DL2017234		RH3	4P					1
DL2017232	No.1-72	RH3	2P	36	6	-	3	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	No.2-64	RH5	2P	42	9.5	-	3	5
DL2026444		RH4	4P					1
DL2026442		RH4	2P					5
DL2026454	No.2-64	RH5	4P	42	9.5	-	3	1
DL2026452		RH5	2P					5
DL2034844		No.3-48	RH4					4P
DL2034842	RH4		2P	5				
DL2034884	RH5		4P	1				
DL2034852	No.3-56	RH5	2P	44	14	-	3	5
DL2035644		RH4	4P					1
DL2035642		RH4	2P					5
DL2035654	No.3-56	RH5	4P	44	14	-	3	1
DL2035652		RH5	2P					5
DL2044054		No.4-40	RH5					4P
DL2044052	RH5		2P	1				
DL2044064	RH6		4P	5				
DL2044062	No.4-48	RH6	2P	44	15	-	3	5
DL2044854		RH5	4P					2
DL2044852		RH5	2P					4
DL2044864	No.4-48	RH6	4P	44	15	-	3	2
DL2044862		RH6	2P					4
DL2054054		No.5-40	RH5					4P
DL2054052	RH5		2P	4				
DL2054064	RH6		4P	2				
DL2054062	No.5-44	RH6	2P	46	9	18	4	4
DL2054454		RH5	4P					2
DL2054452		RH5	2P					4
DL2054464	No.5-44	RH6	4P	46	9	18	4	2
DL2054462		RH6	2P					4
DL2063254		No.6-32	RH5					4P
DL2063252	RH5		2P	4				
DL2063264	RH6		4P	2				
DL2063262	No.6-40	RH6	2P	48	9	18	4	4
DL2064054		RH5	4P					2
DL2064052		RH5	2P					4
DL2064064	No.6-40	RH6	4P	48	9	18	4	2
DL2064062		RH6	2P					4
DL2064062		RH6	2P					4

Ordering rules 产品规格 Selection of materials 表面处理 TYPE
For example: DL2008034 - CPM - TIN - 1

UNIFIED THREAD

美制螺紋

Product code 商品編號	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 形狀
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 rules → Product code → Selection of materials → Surface treatment → TYPE
 For example: DL2083264 - CPM - TIN - 2

METRIC FINE THREAD

挤压丝锥
THREAD FORMING TAP SERIES

公制细牙丝锥

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

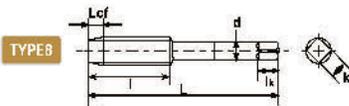
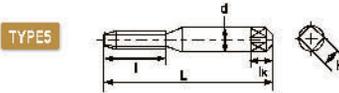
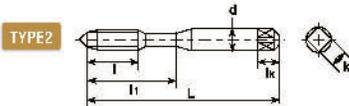
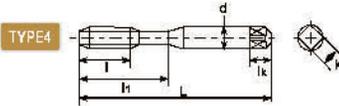
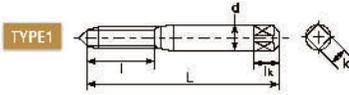
H

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
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，能够实现稳定连续加工。



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(L)	Thread length (l) 螺纹长(l)	Second section length (l1) 二节长(l1)	Shank diameter (d) 柄径(d)	TYPE 形状
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

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

For example: DL3102034 - CPM - TIN - 1

DOHRE
Dohre Tools Co., Ltd

www.dohrecnc.com

LONG SHANK

长柄型

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

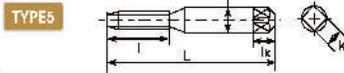
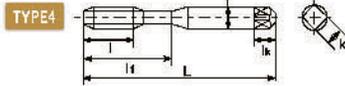
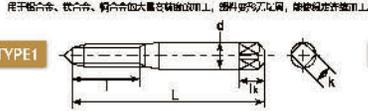
H

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



Product code 商品编号	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(L)	Thread length (l) 螺纹长(l)	Second section length (k) 二段长(k)	Shank diameter (d) 柄径(d)	TYPE 形状
DL4102534	M1	0.25	RH3	4P	60	5.5	-	3	1 4 5
DL4102532			RH3	2P					1 4 5
DL4122534	M1.2	0.25	RH3	4P	60	5.5	-	3	1 4 5
DL4122532			RH3	2P					1 4 5
DL143044	M1.4	0.3	RH4	4P	60	6	-	3	1 4 5
DL143042			RH4	2P					1 4 5
DL4163544	M1.6	0.35	RH4	4P	60	6	-	3	1 4 5
DL4163542			RH4	2P					1 4 5
DL4173544	M1.7	0.35	RH4	4P	60	6	-	3	1 4 5
DL4173542			RH4	2P					1 4 5
DL4204044	M2	0.4	RH4	4P	80	9.5	-	3	1 4 5
DL4204042			RH4	2P					1 4 5
DL4234044	M2.3	0.4	RH4	4P	80	9.5	-	3	1 4 5
DL4234042			RH4	2P					1 4 5
DL4254544	M2.5	0.45	RH4	4P	80	9.5	-	3	1 4 5
DL4254542			RH4	2P					1 4 5
DL4264544	M2.6	0.45	RH4	4P	80	9.5	-	3	1 4 5
DL4264542			RH4	2P					1 4 5
DL43050541	M3	0.5	RH5	4P	80	9	12	4	1 4 5
DL43050521			RH5	2P					1 4 5
DL43050542			RH5	4P	120				1 4 5
DL43050522			RH5	2P	1 4 5				
DL43560441	M3.5	0.6	RH4	4P	80	9	12	4	1 4 5
DL43560421			RH4	2P					1 4 5
DL43560442			RH4	4P	120				1 4 5
DL43560422			RH4	2P	1 4 5				
DL44070641	M4	0.7	RH6	4P	80	10	14	5	1 4 5
DL44070621			RH6	2P					1 4 5
DL44070642			RH6	4P	120				1 4 5
DL44070622			RH6	2P	1 4 5				
DL45080641	M5	0.8	RH6	4P	100	11	22	5.5	1 4 5
DL45080621			RH6	2P					1 4 5
DL45080642			RH6	4P	120				1 4 5
DL45080622			RH6	2P	1 4 5				
DL460100741	M6	1	RH7	4P	100	12	24	6	1 4 5
DL460100721			RH7	2P					1 4 5
DL460100742			RH7	4P	150				1 4 5
DL460100722			RH7	2P	1 4 5				
DL480125741	M8	1.25	RH7	4P	100	18	-	6.2	1 4 5
DL480125721			RH7	2P					1 4 5
DL480125742			RH7	4P	150				1 4 5
DL480125722			RH7	2P	1 4 5				
DL480100741	M8	1	RH7	4P	100	18	-	6.2	1 4 5
DL480100721			RH7	2P					1 4 5
DL480100742			RH7	4P	150				1 4 5
DL480100722			RH7	2P	1 4 5				
DL4100150741	M10	1.5	RH7	4P	100	19	-	7	1 4 5
DL4100150721			RH7	2P					1 4 5
DL4100150742			RH7	4P	150				1 4 5
DL4122150722			RH7	2P	1 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
形状

For example: DL4102534 - CPM - TIN - 4

Product code 商品编号	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 (l1) 二部长 (l1)	Shank diameter (d) 柄径(d)	TYPE 形状
DL4100125741	M10	1.25	RH7	4P	100	19	-	7	4
DL4100125721			RH7	2P	150				4
DL4100125742			RH7	4P					4
DL4100125722			RH7	2P					4
DL4100100741	M10	1	RH7	4P	100	19	-	7	4
DL4100100721			RH7	2P	150				4
DL4100100742			RH7	4P					4
DL4100100722			RH7	2P					4
DL4120175841	M12	1.75	RH8	4P	150	23	-	8.5	4
DL4120175821			RH8	2P	200				4
DL4120175842			RH8	4P					4
DL4120175822			RH8	2P					4
DL4120150741	M12	1.5	RH7	4P	150	23	-	8.5	4
DL4120150721			RH7	2P	200				4
DL4120150742			RH7	4P					4
DL4120150722			RH7	2P					4
DL4120125741	M12	1.25	RH7	4P	150	23	-	8.5	4
DL4120175721			RH7	2P	200				4
DL4120125742			RH7	4P					4
DL4120125722			RH7	2P					4
DL4120100741	M12	1	RH7	4P	150	23	-	8.5	4
DL4120100721			RH7	2P	200				4
DL4120100742			RH7	4P					4
DL4120100722			RH7	2P					4



Ordering rules → Product code → Selection of materials → Surface treatment → TYPE
 For example: DL4100415741- CPM - TIN - 4

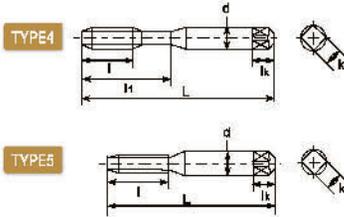
SHORT THREAD

短螺紋

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、銅合金的大量高精度加工，無切屑塑性變形，穩定連續加工。



Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Flute coating length 溝槽鍍層長度	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)	Four corners size (K) 四角尺寸(K)	Four corners (lK) 四角長(lK)	Convex number 凸數	TYPE 形狀
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			RH4	2P								5
DL5204052	M2	0.4	RH5	2P	40	8	-	3	2.5	5	4	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								1
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 rules (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: DL5102542 - CPM - TIN - 5

SHORT CHAMFER

挤压丝锥
THREAD FORMING TAP SERIES

短切屑推型

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

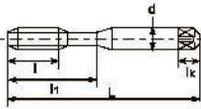
TiN

TiCN

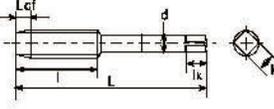
DLC

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，塑性变形无切屑，能够实现稳定连续加工。

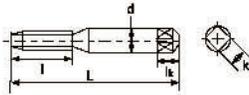
TYPE4



TYPE6



TYPE5



Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Extension cone length 倒锥锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长度(l)	Second section length (l1) 二节长(l1)	Shank diameter (d) 柄径(d)	TYPE 形状
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

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
形状

For example: DL6102541 - CPM - TiN - 5

DOHRE
Dohre Tools Co., Ltd

www.dohrecnc.com

LONG CHAMFER

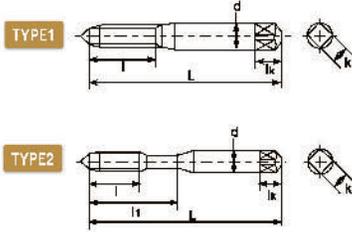
长径丝锥

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

适用于铝、镁、铜合金等高精度加工，可实现稳定连续加工，无屑塑性变形。



Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Extrusion cone length 排屑锥长度	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 形状
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	M1.8	0.35	RH6	6P	36	6	-	3	1
DL7183546			RH4	6P					1
DL7183556	RH5	6P	1						
DL7204046	M2	0.4	RH4	6P	40	8	-	3	1
DL7204056			RH5	6P					1
DL7204066	M2.2	0.45	RH6	6P	40	9.5	-	3	1
DL7224546			RH4	6P					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 rules → Product code → Selection of materials → Surface treatment → TYPE
For example: DL7102546 - CPM - TIN - 1

METRIC COARSE THREAD

螺旋槽丝锥
SPIRAL FLUTED TAP SERIES

公英制

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

TiN

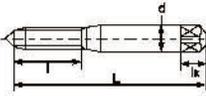
TiCN

DLC

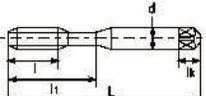
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

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

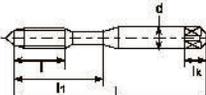
TYPE1



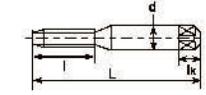
TYPE4



TYPE2



TYPE5



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(l)	Second section length (l1) 二部长(l1)	Shank diameter (d) 柄径(d)	TYPE 形状
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	0.3	P2	2.5P	32	5.5	-	3	1 5
DLSFT142	M1.4		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	0.6	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
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
DLSFT603			P3	2.5P	1 2 4 5				
DLSFT604			P4	2.5P	1 2 4 5				
DLSFT702			M7	1	P2	2.5P			
DLSFT703	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
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
DLSFT1202	P2	2.5P			1 2 4 5				
DLSFT1203	M12	1.75	P3	2.5P	82	29	48	8.5	1 2 4 5
DLSFT1204			P4	2.5P					1 2 4 5

Ordering rules
订购规则

Product code
产品规格

Selection of materials
材料选择

Surface treatment
表面处理

TYPE
形状

For example: DLDFSFT101 - CPM - TiN - 1

DOHRE
Dohre Tools Co., Ltd

www.dohrecnc.com

LEFT HAND

左鑽攻

Selection of materials
選料

HSSEX

HSSV

CPM

Surface treatment
表面處理

N

H

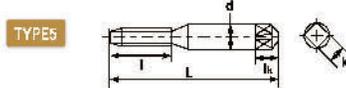
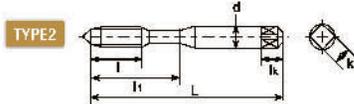
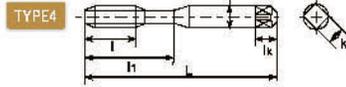
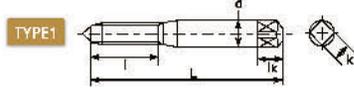
TIN

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

适用于铝、镁、铜合金大量高精度加工、无屑塑性变形、稳定连续加工。



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(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
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

公制细牙丝锥

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N
氮化涂层

H
镀钛涂层

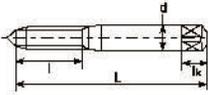
TIN
镀锡涂层

TICN
TiCN涂层

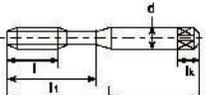
DLC
DLC涂层

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、铜合金的大批量精密加工，塑料变形无切屑，能够实现连续加工。

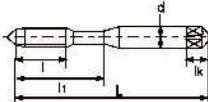
TYPE1



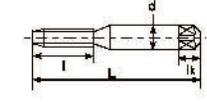
TYPE4



TYPE2



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) 全长(L)	Thread length (l) 螺距长(l)	Second end length (k) 二阶长(k)	Shank diameter (d) 柄径(d)	TYPE 形状
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 rules: Product code Selection of materials Surface treatment TYPE
For example: DLSFTT101 - CPM - TIN - 1

UNIFIED THREAD

买钻头就

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

TIN

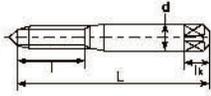
TICN

DLC

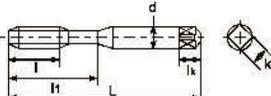
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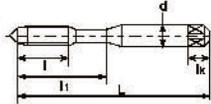
TYPE1



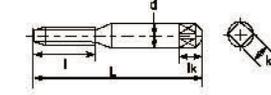
TYPE4



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) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (l1) 二段长(l1)	Shank diameter (d) 柄径(d)	TYPE 形状			
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	No.4-40	P2	2.5P					1	2	4	5
DLSFTU482	No.4-48	P1	2.5P	46	11	18	4	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	48	13	20	4	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	48	13	20	4	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

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

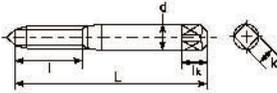
TiN

TiCN

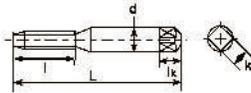
DLC

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，塑性变形无切屑，可实现稳定的连续加工。

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) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (k) 二部长(k)	Shank diameter (d) 柄径(d)	TYPE 形式
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				
DLLS-SFT233	M2.3	0.4	P2	2.5P	80	9.5	15	3	1 5
DLLS-SFT234			P2	2.5P	100				
DLLS-SFT254			P2	2.5P	80				
DLLS-SFT255	M2.5	0.45	P2	2.5P	100	9.5	16	3	1 5
DLLS-SFT256			P2	2.5P	120				
DLLS-SFT264	M2.6	0.45	P2	2.5P	80	9.5	16	3	1 5
DLLS-SFT265			P2	2.5P	100				
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				
DLLS-SFT306			P2	2.5P	120				
DLLS-SFT354	M3.5	0.6	P2	2.5P	80	13	20	4	1 5
DLLS-SFT355			P2	2.5P	100				
DLLS-SFT356			P2	2.5P	120				
DLLS-SFT401	M4	0.7	P2	2.5P	80	13	20	5	1 5
DLLS-SFT402			P2	2.5P	100				
DLLS-SFT403			P2	2.5P	120				
DLLS-SFT501	M5	0.8	P2	2.5P	100	16	24	5.5	1 5
DLLS-SFT502			P2	2.5P	120				
DLLS-SFT601	M6	1	P2	2.5P	100	19	29	6	1 5
DLLS-SFT602			P2	2.5P	120				
DLLS-SFT603			P2	2.5P	150				
DLLS-SFT801	M8	1.25	P2	2.5P	100	22	37	6.2	1 5
DLLS-SFT802			P2	2.5P	120				
DLLS-SFT803			P2	2.5P	150				
DLLS-SFT804			P2	2.5P	100				
DLLS-SFT805			P2	2.5P	120				
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				
DLLS-SFT1003			P2	2.5P	150				
DLLS-SFT1004			P2	2.5P	200				
DLLS-SFT1005			P2	2.5P	100				
DLLS-SFT1006	M10	1.25	P2	2.5P	120	24	41	7	1 5
DLLS-SFT1007			P2	2.5P	150				
DLLS-SFT1008			P2	2.5P	200				
DLLS-SFT1009	M10	1	P2	2.5P	100	24	41	7	1 5
DLLS-SFT1010			P2	2.5P	120				
DLLS-SFT1011			P2	2.5P	150				

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-SFT101 - CPM - TiN - 1

LONG SHANK

长柄型

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 (f) 二節長 (f)	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	M12	1.5	P1	2.5P	200	29	48	8.5	1 5
DLLS-SFT1205			P1	2.5P	100				1 5
DLLS-SFT1206			P1	2.5P	120				1 5
DLLS-SFT1207	M12	1.25	P2	2.5P	150	29	48	8.5	1 5
DLLS-SFT1208			P2	2.5P	200				1 5
DLLS-SFT1209			P2	2.5P	100				1 5
DLLS-SFT1210	M12	1	P2	2.5P	120	29	48	8.5	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 商品編號 → 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

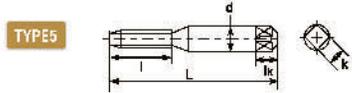
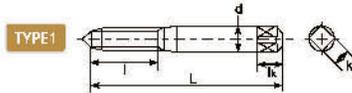
螺旋槽丝锥
SPIRAL FLUTED TAP SERIES

螺旋槽丝锥

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，塑性变形无切屑，能稳定连续加工。



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(l)	Second section length (l) 二阶长(l1)	Shank diameter (d) 柄径(d)	TYPE 形状	
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

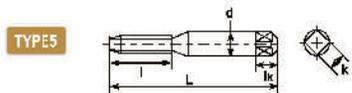
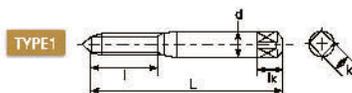
INSERT SCREW THREAD TAP WITH LONG SHANK

长柄螺旋槽丝锥

Selection of materials → 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，塑性变形无切屑，能稳定连续加工。



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(l)	Second section length (l) 二阶长(l1)	Shank diameter (d) 柄径(d)	TYPE 形状	
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-SFT803	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 rules → Product code Selection of materials Surface treatment TYPE
For example: DLSF-SFT201- CPM - TIN - 1

DOHRE
Dohre Tools Co., Ltd

www.dohrecnc.com

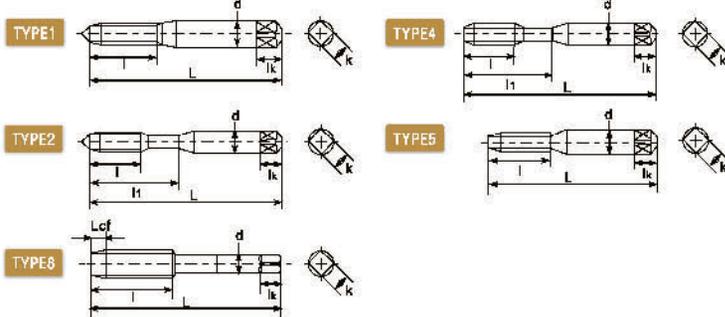
METRIC COARSE THREAD

公制粗紋

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、銅合金大量高精度加工，無屑塑性加工，能穩定連續加工。



Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting core length 切削芯長度	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
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	0.35	P2	2.5P	34	9	-	3	1 5
DLPOT162	M1.6		P2	2.5P	36	10	-	3	1 5
DLPOT171	M1.7		P1	2.5P		11	-		3
DLPOT172	M1.7	0.4	P2	2.5P	40	12	-	3	1 5
DLPOT182	M1.8		P2	2.5P					1 5
DLPOT201	M2		P1	2.5P					1 2 4 5
DLPOT202	M2	0.45	P2	2.5P	42	13	-	3	1 2 4 5
DLPOT203			P3	2.5P					1 2 4 5
DLPOT222			M2.2	P2					2.5P
DLPOT231	M2.3	0.4	P1	2.5P	44	14	-	3	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			P2	2.5P					1 2 4 5
DLPOT603	M6	1	P3	2.5P	62	19	29	6	1 2 4 5
DLPOT604			P4	2.5P					1 2 4 5
DLPOT702	M7	0.5	P2	2.5P	65	22	33	6.2	1 2 4 8
DLPOT703			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	1 2 4 8
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

METRIC FINE THREAD

公制細牙螺紋

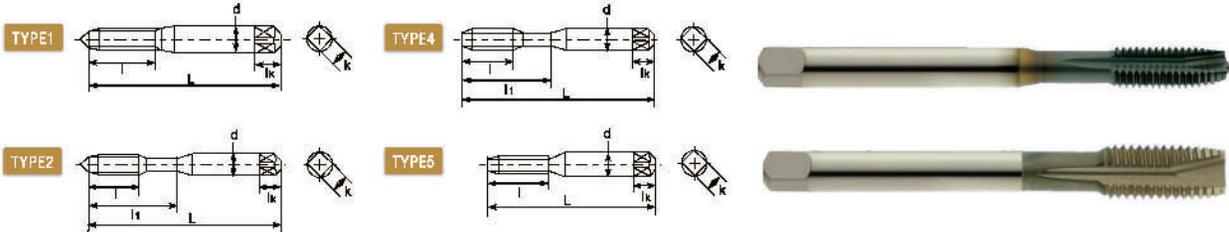
刃傾角螺絲

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、铜合金大量高精度加工，塑性变形无切屑，能实现连续加工。



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 (l1) 二節長(l1)	Shank diameter (d) 柄徑(d)	TYPE 形狀
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 rule → Product code Selection of materials Surface treatment TYPE
For example: DLPOT101 - CPM - TIN - 1

UNIFIED THREAD

统一螺纹

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

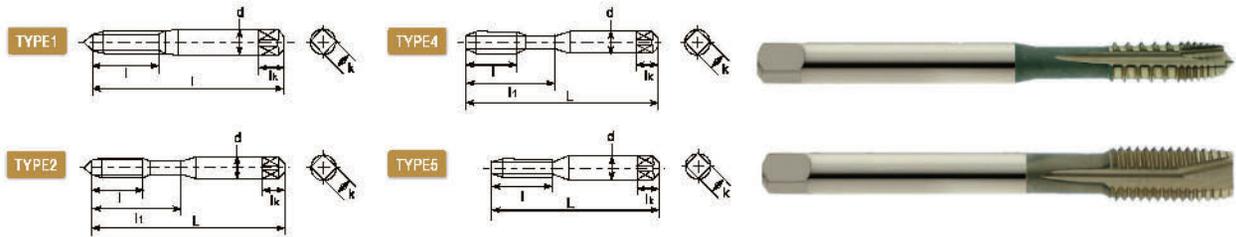
TIN

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，塑料变形无切屑，能够实现稳定的连续加工。



Product code 产品编号	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(l)	Second section length (l1) 二阶长(l1)	Shank diameter (d) 柄径(d)	TYPE 形式
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					1 2 4 5
DLPOTU562	No.3-56	P1	2.5P	44	9.5	16	3	1 2 4 5
DLPOTU401	No.4-40	P1	2.5P					1 2 4 5
DLPOTU402	No.4-48	P2	2.5P					1 2 4 5
DLPOTU482		P1	2.5P	1 2 4 5				
DLPOTU483	No.5-40	P2	2.5P	46	11	18	4	1 2 4 5
DLPOTU403		P1	2.5P					1 2 4 5
DLPOTU404		P2	2.5P					1 2 4 5
DLPOTU441	No.5-44	P1	2.5P	48	13	20	4	1 2 4 5
DLPOTU442		P2	2.5P					1 2 4 5
DLPOTU322	No.6-32	P2	2.5P					52
DLPOTU323		P3	2.5P	1 2 4 5				
DLPOTU405		No.6-40	P2	2.5P	1 2 4 5			
DLPOTU406	P3		2.5P	1 2 4 5				
DLPOTU324	No.8-32	P2	2.5P	60	16	24	5.5	1 2 4 5
DLPOTU362	No.8-36	P2	2.5P					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
订购规则

Product code
产品编号

Selection of materials
材料选择

Surface treatment
表面处理

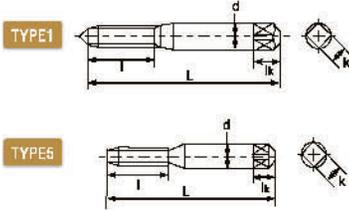
TYPE
形式

For example: DLPOTU801- 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
 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，能够稳定连续加工。



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(l)	Second section length (l') 二节长 (l')	Shank diameter (d) 柄径(d)	Type 形状	
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			P2	2.5P	100				1	5
DLLS-POT233	M2.3	0.4	P2	2.5P	80	9.5	15	3	1	5
DLLS-POT234			P2	2.5P	100				1	5
DLLS-POT254	M2.5	0.45	P2	2.5P	80	9.5	16	3	1	5
DLLS-POT255			P2	2.5P	100				1	5
DLLS-POT256			P2	2.5P	120				1	5
DLLS-POT264	M2.6	0.45	P2	2.5P	80	9.5	16	3	1	5
DLLS-POT265			P2	2.5P	100				1	5
DLLS-POT266			P2	2.5P	120				1	5
DLLS-POT304	M3	0.5	P2	2.5P	80	11	18	4	1	5
DLLS-POT305			P2	2.5P	100				1	5
DLLS-POT306			P2	2.5P	120				1	5
DLLS-POT354	M3.5	0.6	P2	2.5P	80	13	20	4	1	5
DLLS-POT355			P2	2.5P	100				1	5
DLLS-POT356			P2	2.5P	120				1	5
DLLS-POT401	M4	0.7	P2	2.5P	80	13	20	5	1	5
DLLS-POT402			P2	2.5P	100				1	5
DLLS-POT403			P2	2.5P	120				1	5
DLLS-POT501	M5	0.8	P2	2.5P	100	16	24	5.5	1	5
DLLS-POT502			P2	2.5P	120				1	5
DLLS-POT601	M6	1	P2	2.5P	100	19	29	6	1	5
DLLS-POT602			P2	2.5P	120				1	5
DLLS-POT603			P2	2.5P	150				1	5
DLLS-POT801	M8	1.25	P2	2.5P	100	22	37	6.2	1	5
DLLS-POT802			P2	2.5P	120				1	5
DLLS-POT803			P2	2.5P	150				1	5
DLLS-POT804		1	P2	2.5P	100				1	5
DLLS-POT805			P2	2.5P	120				1	5
DLLS-POT806	P2	2.5P	150	1	5					
DLLS-POT1001	M10	1.5	P2	2.5P	100	24	41	7	1	5
DLLS-POT1002			P2	2.5P	120				1	5
DLLS-POT1003			P2	2.5P	150				1	5
DLLS-POT1004			P2	2.5P	200				1	5
DLLS-POT1005	M10	1.25	P2	2.5P	100	24	41	7	1	5
DLLS-POT1006			P2	2.5P	120				1	5
DLLS-POT1007			P2	2.5P	150				1	5
DLLS-POT1008	M10	1	P2	2.5P	200	24	41	7	1	5
DLLS-POT1009			P2	2.5P	100				1	5
DLLS-POT1010			P2	2.5P	120				1	5
DLLS-POT1011			P2	2.5P	150				1	5

Ordering rule → Product code Selection of materials Surface treatment TYPE
 For example: DLLS-POT101- CPM - TiN - 1

LONG SHANK

长柄型

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 (l1) 二節長(l1)	Shank diameter (d) 柄徑(d)	TYPE 形狀
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	M12	1.5	P1	2.5P	200	29	48	8.5	1 5
DLLS-POT1205			P1	2.5P	100				1 5
DLLS-POT1206			P1	2.5P	120				1 5
DLLS-POT1207	M12	1.25	P2	2.5P	150	29	48	8.5	1 5
DLLS-POT1208			P2	2.5P	200				1 5
DLLS-POT1209			P2	2.5P	100				1 b
DLLS-POT1210	M12	1	P2	2.5P	120	29	48	8.5	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

INSERT SCREW THREAD TAP

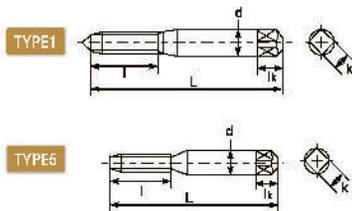
鑿齒絲錐

刀傾角絲錐
SPIRAL POINTED TAP SERIES

Selection of materials 選擇材料 → 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
用于鋁合金、鎂合金、銅合金的大量高精度加工，變形無切屑，能穩定連續加工。



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 (l1) 二節長(l1)	Shank diameter (d) 柄徑(d)	TYPE 型號	
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

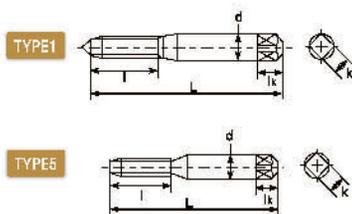
INSERT SCREW THREAD TAP WITH LONG SHANK

長柄鑿齒絲錐

Selection of materials 選擇材料 → 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
用于鋁合金、鎂合金、銅合金的大量高精度加工，變形無切屑，能穩定連續加工。



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 (l1) 二節長(l1)	Shank diameter (d) 柄徑(d)	TYPE 型號	
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 訂貨規則 → Product code 商品編號 Selection of materials 選擇材料 Surface treatment 表面處理 TYPE 型號
For example: DLST-POT201- CPM - TiN - 1

DOHRE
Dohre Tools Co., Ltd

www.dohrecnc.com

LEFT HAND

左轉攻

Selection of materials
選材分類

HSSEX

HSSV

CPM

Surface treatment
表面處理

N

H

TiN

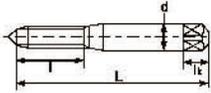
TiCN

DLC

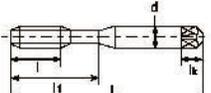
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

用于鋁合金、鎂合金、銅合金的大量高精度加工，無屑或少屑加工，能穩定連續加工。

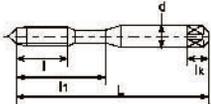
TYPE1



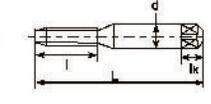
TYPE4



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
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 5
DLLH-POT232	M2.3	0.4	P2	2.5P					1 2 4 5
DLLH-POT252	M2.5	0.45	P2	2.5P					1 2 4 5
DLLH-POT253			P3	2.5P	1 2 4 5				
DLLH-POT262	M2.6	0.45	P2	2.5P	44	9.5	16	3	1 2 4 5
DLLH-POT263			P3	2.5P					1 2 4 5
DLLH-POT302	M3	0.5	P2	2.5P	46	11	18	4	1 2 4 5
DLLH-POT303			P3	2.5P					1 2 4 5
DLLH-POT352	M3.5	0.6	P2	2.5P	48	13	20	4	1 2 4 5
DLLH-POT353			P3	2.5P					1 2 4 5
DLLH-POT402	M4	0.7	P2	2.5P	52	13	20	5	1 2 4 5
DLLH-POT403			P3	2.5P					1 2 4 5
DLLH-POT502	M5	0.8	P2	2.5P	60	16	24	5.5	1 2 4 5
DLLH-POT602	M6	1	P2	2.5P	62	19	29	6	1 2 4 5
DLLH-POT802	M8	1.25	P3	2.5P	70	22	37	6.2	1 2 4 5
DLLH-POT1003	M10	1.5	P3	2.5P	75	24	41	7	1 2 4 5
DLLH-POT1203	M12	1.75	P3	2.5P	82	29	48	8.5	1 2 4 5

Ordering rule
訂購規則

Product code
產品編號

Selection of materials
選材分類

Surface treatment
表面處理

TYPE
形狀

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

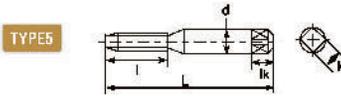
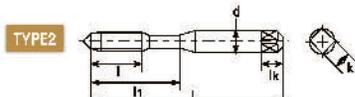
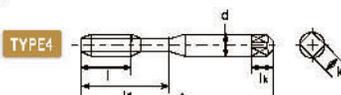
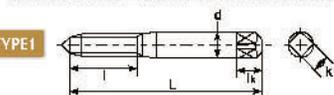
H

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



Product code 商品规格	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(l)	Second section length (l) 二阶长(l)	Shank diameter (d) 柄径(d)	TYPE 形式			
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					1	5		
DLHT172	M1.7		P2	4P					1	5		
DLHT182	M1.8	0.4	P2	4P	40	12	-	3	1	5		
DLHT201	M2		P1	4P					1	2	4	5
DLHT202			P2	4P					1	2	4	5
DLHT203	M2.2	0.45	P3	4P	42	13	-	3	1	2	4	5
DLHT222			P1	4P					1	2	4	5
DLHT231			P1	4P					1	2	4	5
DLHT232	M2.3	0.4	P2	4P	44	14	-	3	1	2	4	5
DLHT233			P3	4P					1	2	4	5
DLHT251			P1	4P					1	2	4	5
DLHT252	M2.5	0.45	P2	4P	44	14	-	3	1	2	4	5
DLHT253			P3	4P					1	2	4	5
DLHT261			P1	4P					1	2	4	5
DLHT262	M2.6	0.45	P2	4P	44	14	-	3	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
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			P2	4P					1	2	4	5
DLHT403	M4	0.7	P3	4P	52	13	21	5	1	2	4	5
DLHT404			P4	4P					1	2	4	5
DLHT502			P2	4P					1	2	4	5
DLHT503	M5	0.8	P3	4P	60	16	24	5.5	1	2	4	5
DLHT504			P4	4P					1	2	4	5
DLHT602			M6	1					P2	4P	62	19
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			P2	4P					1	2	4	5
DLHT802			P2	4P					1	2	4	5
DLHT803	M8	1.25	P3	4P	70	22	37	6.2	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 → Product code Selection of materials Surface treatment TYPE

For example: DLHT101 - CPM - TIN - 1

DOHRE
Dohre Tools Co., Ltd

www.dohrecnc.com

UNIFIED THREAD

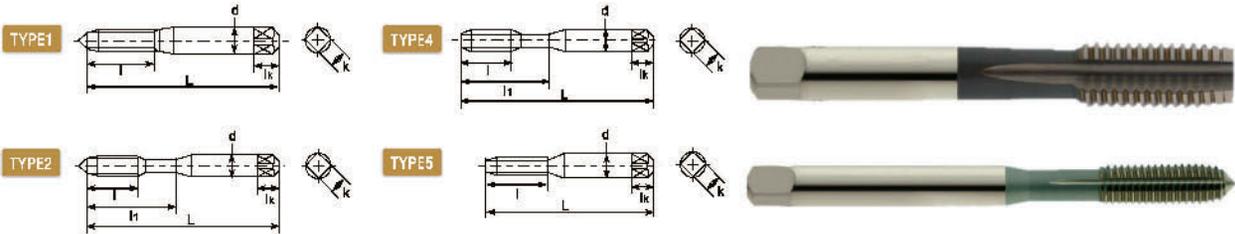
尖錐鑽紋

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加工，塑料变形无切屑，能够实现稳定连续加工。



Product code 商品編號	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 形狀
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 4 5
DLHTU642	No.2-64	P1	4P					1 2 4 5
DLHTU481	No.3-48	P1	4P	44	9.5	16	3	1 2 4 5
DLHTU562	No.3-56	P1	4P					1 2 4 5
DLHTU401	No.4-40	P1	4P	44	9.5	16	3	1 2 4 5
DLHTU402		P2	4P					1 2 4 5
DLHTU482	No.4-48	P1	4P					1 2 4 5
DLHTU483		P2	4P					1 2 4 5
DLHTU403	No.5-40	P1	4P	46	11	18	4	1 2 4 5
DLHTU404	P2	4P	1 2 4 5					
DLHTU441	No.5-44	P1	4P					1 2 4 5
DLHTU442		P2	4P	1 2 4 5				
DLHTU322	No.6-32	P2	4P	48	13	20	4	1 2 4 5
DLHTU323		P3	4P					1 2 4 5
DLHTU405	No.6-40	P2	4P					1 2 4 5
DLHTU406		P3	4P					1 2 4 5
DLHTU324	No.8-32	P2	4P	52	13	21	5	1 2 4 5
DLHTU362	No.8-36	P2	4P					1 2 4 5
DLHTU242	No.10-24	P2	4P					1 2 4 5
DLHTU325	No.10-32	P2	4P	60	16	24	5.5	1 2 4 5
DLHTU243	No.12-24	P2	4P					1 2 4 5
DLHTU282	No.12-28	P2	4P	60	17	25	5.5	1 2 4 5

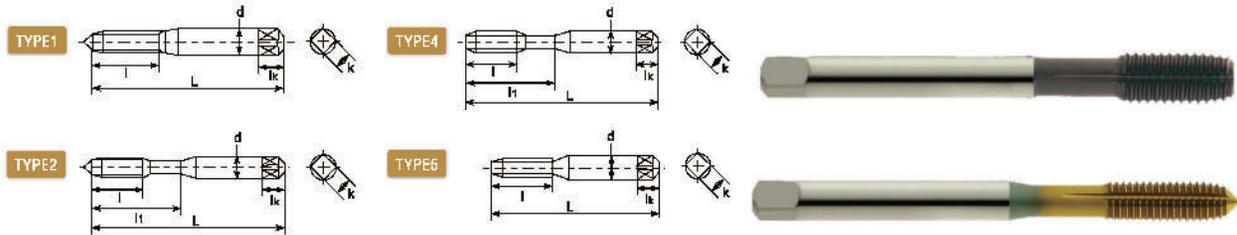
Ordering rules → Product code Selection of materials Surface treatment TYPE
For example: DLHTU801 - CPM - TIN - 1

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

用于铝合金、镁合金、铜合金大量高精度加工、无屑塑性变形、稳定连续加工。



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		
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 rule 訂購規則 → Product code 商品編號 → Selection of materials 材料選擇 → Surface treatment 表面處理 → TYPE 形狀
For example: DLLH-HT101 - CPM - TiN - 1

LONG SHANK

长柄型

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N
氮化涂层

H
氧化涂层

TIN
锡涂层

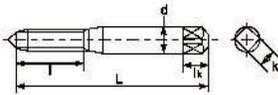
TICN
氮化钛涂层

DLC
类金刚石涂层

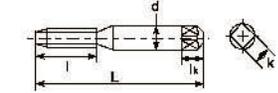
For aluminum alloy, magnesium alloy, copper alloy, a large number of high precision machining, plastic deformation without chip, can make stable continuous processing

适用于铝合金、镁合金、铜合金的大量高精度加工，塑料变形无切屑，能够实现稳定的连续加工。

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) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (l1) 二节长(l1)	Shank diameter (d) 柄径(d)	TYPE 形状
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			P2	2.5P	100				1 5
DLLS-HT256	M2.5	0.45	P2	2.5P	120	9.5	16	3	1 5
DLLS-HT264			P2	2.5P	80				1 5
DLLS-HT265			P2	2.5P	100				1 5
DLLS-HT266	M2.6	0.45	P2	2.5P	120	9.5	16	3	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	M4	0.7	P2	2.5P	80	13	20	5	1 5
DLLS-HT402			P2	2.5P	100				1 5
DLLS-HT403			P2	2.5P	120				1 5
DLLS-HT501	M5	0.8	P2	2.5P	100	16	24	5.5	1 5
DLLS-HT502			P2	2.5P	120				1 5
DLLS-HT601	M6	1	P2	2.5P	100	19	29	6	1 5
DLLS-HT602			P2	2.5P	120				1 5
DLLS-HT603			P2	2.5P	150				1 5
DLLS-HT801	M8	1.25	P2	2.5P	100	22	37	6.2	1 5
DLLS-HT802			P2	2.5P	120				1 5
DLLS-HT803		1	P2	2.5P	150				1 5
DLLS-HT804			P2	2.5P	100				1 5
DLLS-HT805			P2	2.5P	120				1 5
DLLS-HT806	P2	2.5P	150	1 5					
DLLS-HT1001	M10	1.5	P2	2.5P	100	24	41	7	1 5
DLLS-HT1002			P2	2.5P	120				1 5
DLLS-HT1003			P2	2.5P	150				1 5
DLLS-HT1004			P2	2.5P	200				1 5
DLLS-HT1005	M10	1.25	P2	2.5P	100	24	41	7	1 5
DLLS-HT1006			P2	2.5P	120				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
订购规则

Product code
商品编号

Selection of materials
材料选择

Surface treatment
表面处理

TYPE
形状

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

Product code 商品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切削錐高度	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-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



Ordering rule 訂貨規則 → Product code 商品編號 → Selection of materials 材料選擇 → Surface treatment 表面處理 → TYPE 形狀
For example: DLLS-HT1201- CPM - TIN - 1

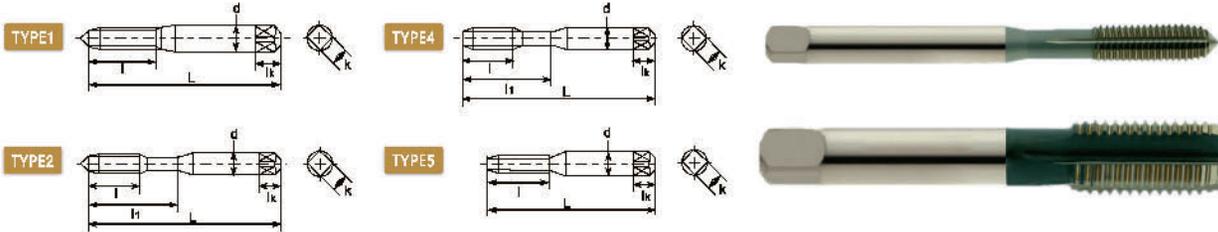
METRIC FINE THREAD

公制細牙鑽攻

Selection of materials
 選擇材料 → 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、銅合金大量高精度加工，易於變形無屑，能穩定連續加工。



Product code 產品編號	Specification 規格	Pitch 螺距	Accuracy class 精度等級	Cutting cone length 切齒錐長度	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		
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

INSERT SCREW THREAD TAP

直槽丝锥
STRAIGHT FLUTE TAP SERIES

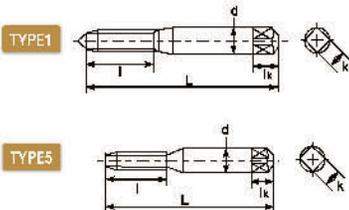
Selection of materials
选材材料

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、镁、铜合金大量精密加工，塑性变形无切屑，能稳定连续加工。



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(l)	Second section length (l) 二节长(l')	Shank diameter (d) 柄径(d)	TYPE 形状
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

长柄螺套丝锥

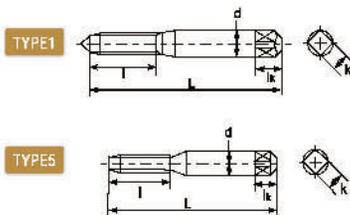
Selection of materials
选材材料

HSSEX CPM

Surface treatment
表面处理

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、镁、铜合金大量精密加工，塑性变形无切屑，能稳定连续加工。



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(l)	Second section length (l) 二节长(l')	Shank diameter (d) 柄径(d)	TYPE 形状
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 rules
订购规则

Product code
商品编号

Selection of materials
选材材料

Surface treatment
表面处理

TYPE
形状

For example: DLST-HT201- CPM - TiN - 1

NUT TAPS (METRIC THREAD)

螺母丝锥(公制)

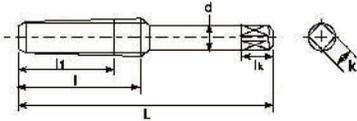
Selection of materials
 选择材料 → HSSEX HSSV CPM

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，塑料成型无切屑，能够实现稳定的连续加工。

TYPE6



Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Overall length (L) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (l1) 二节长(l1)	Shank diameter (d) 柄径(d)	Channel number 沟数	TYPE 形状
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 rule
 订购规则 → Product code
 商品编号 Selection of materials
 选择材料 Surface treatment
 表面处理 TYPE
 形状
 For example: DLNT202 - CPM - TIN - 6

钻攻一体式螺旋槽丝锥

Selection of materials
材料选择

HSSEX

HSSV

CPM

Surface treatment
表面处理

N

H

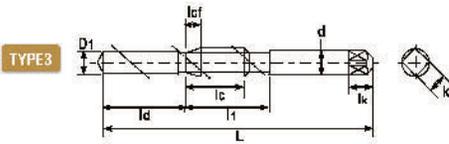
TIN

TICN

DLC

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

尖部钻头可进行双底孔加工，提高加工效率。特殊用途。



Product code 商品代码	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)	Bit length l1 钻头长度	Thread length (lc) 螺纹长度(lc)	Outer diameter (D1) 外径(D1)	Shank diameter (d) 柄径(d)	TYPE 形状
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			P1	2.5P						3
DLDR-SFT202	M2	0.4	P2	2.5P	42	7	3.5	1.6	3	3
DLDR-SFT203			P3	2.5P						3
DLDR-SFT204			P4	2.5P						3
DLDR-SFT221			P1	2.5P						3
DLDR-SFT222	M2.2	0.45	P2	2.5P	42	7	3.5	1.75	3	3
DLDR-SFT223			P3	2.5P						3
DLDR-SFT224			P4	2.5P						3
DLDR-SFT231			P1	2.5P						3
DLDR-SFT232	M2.3	0.4	P2	2.5P	42	7	3.5	1.9	3	3
DLDR-SFT233			P3	2.5P						3
DLDR-SFT234			P4	2.5P						3
DLDR-SFT251			P1	2.5P						3
DLDR-SFT252	M2.5	0.45	P2	2.5P	44	7	3.5	2.05	3	3
DLDR-SFT253			P3	2.5P						3
DLDR-SFT254			P4	2.5P						3
DLDR-SFT261			P1	2.5P						3
DLDR-SFT262	M2.6	0.45	P2	2.5P	44	8	3.5	2.15	3	3
DLDR-SFT263			P3	2.5P						3
DLDR-SFT264			P4	2.5P						3
DLDR-SFT301			P1	2.5P						3
DLDR-SFT302	M3	0.5	P2	2.5P	46	11	4	2.5	4	3
DLDR-SFT303			P3	2.5P						3
DLDR-SFT304			P4	2.5P						3
DLDR-SFT351			P1	2.5P						3
DLDR-SFT352	M3.5	0.6	P2	2.5P	48	11	4	2.9	4	3
DLDR-SFT353			P3	2.5P						3
DLDR-SFT354			P4	2.5P						3
DLDR-SFT402			P2	2.5P						3
DLDR-SFT403	M4	0.7	P3	2.5P	52	13	5	3.3	5	3
DLDR-SFT404			P4	2.5P						3
DLDR-SFT405			P5	2.5P						3
DLDR-SFT503			M5	0.8						P3
DLDR-SFT603	M6	1	P3	2.5P	81	19	7	5	6	3
DLDR-SFT803	M8	1.25	P3	2.5P	92	22	8.5	6.75	6.2	3
DLDR-SFT1003	M10	1.5	P3	2.5P	99	24	10.5	8.5	7	3
DLDR-SFT1203	M12	1.75	P3	2.5P	111	29	12	10.25	8.5	3

Ordering rules
订购规则

Product code
商品代码

Selection of materials
材料选择

Surface treatment
表面处理

TYPE
形状

For example: DLDR-SFT101- CPM - TIN - 3

METRIC THREAD

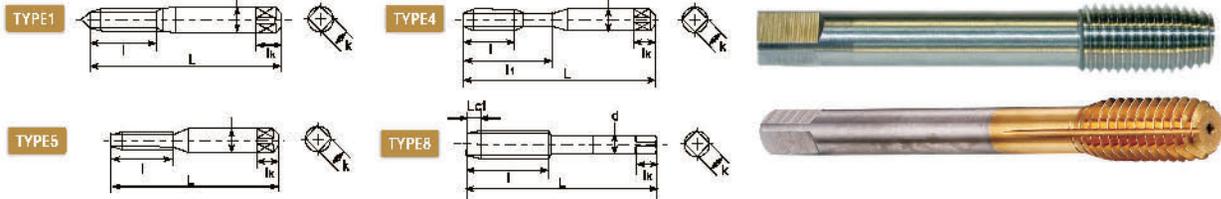
公制螺紋

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

(对于铝合金、镁合金、铜合金的大量高精度加工, 塑性变形无切屑, 能够实现连续加工)



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) 二重長(l)	Shank diameter (d) 柄徑(d)	TYPE 型號						
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						

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 形狀
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	82	23	-	8.5	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	82	23	-	8.5	8
DL812012572			RH7	2P					8
DL812010074	M12	1	RH7	4P	82	23	-	8.5	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



LONG SHANK

长柄型

Selection of materials
材料选择

CARBIDE
硬质合金

Surface treatment
表面处理

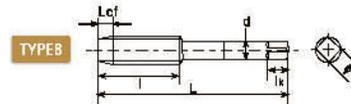
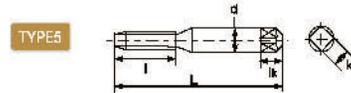
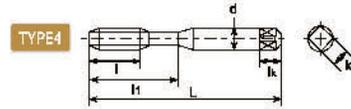
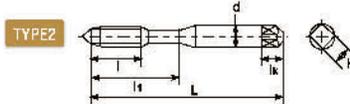
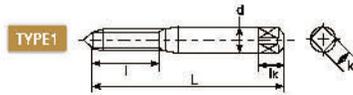
TIN
镀锡

TICN
镀氮化钛

TIALN
镀氮化钛

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

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，稳定连续加工。



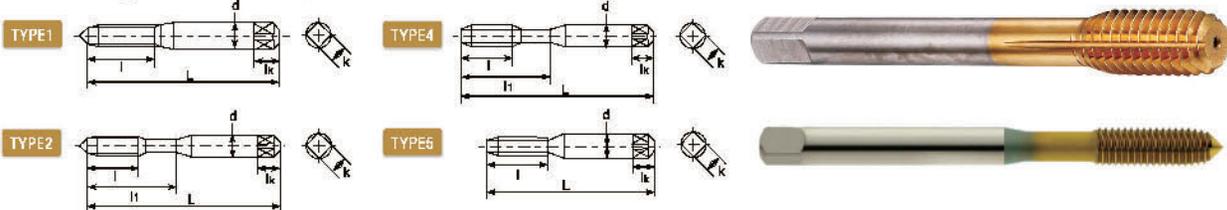
Product code 商品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (l) 螺纹长(l)	Second section length (l) 二阶长度(l)	Shank diameter (d) 柄径(d)	TYPE 款式
DL9102534	M1.0	0.25	RH3	4P	60	3.5	-	3	1
DL9102532			RH3	2P					5
DL912544	M1.2	0.25	RH4	4P	60	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		1.75	RH8	4P					8
DL912017582			RH8	2P					8
DL912015074	M12	1.5	RH7	4P	150	29	-	8.5	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

实物图

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
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, 可实现稳定连续加工。



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(l)	Second section length (l1) 二部头(l1)	Shank diameter (d) 柄径(d)	TYPE 形状
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
DL1026432	No.2-64	RH3	2P	42	9	-	3	5
DL1026454		RH5	4P					1
DL1026452		RH5	2P					5
DL1034844		RH4	4P					1
DL1034842	No.3-48	RH4	2P	44	10	-	3	5
DL1034864		RH6	4P					1
DL1034862		RH6	2P					5
DL1035644		RH4	4P					1
DL1035642	No.3-56	RH4	2P	44	10	-	3	5
DL1035664		RH6	4P					1
DL1035662		RH6	2P					5
DL1044054		RH5	4P					2
DL1044052	No.4-40	RH5	2P	44	10	-	3	4
DL1044074		RH7	4P					2
DL1044072		RH7	2P					4
DL1044844		RH4	4P					2
DL1044842	No.4-48	RH4	2P	44	10	-	3	4
DL1044864		RH6	4P					2
DL1044862		RH6	2P					4
DL1054054		No.5-40	RH5					4P
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

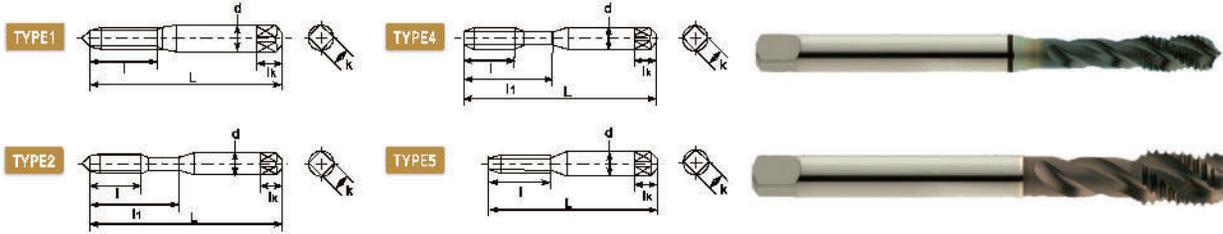
美制螺紋

Product code 商品編號	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 (l) 二節長(l)	Shank diameter (d) 柄徑(d)	TYPE 形狀
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

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



Product code	Specification	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l1)	Shank diameter (d)	TYPE
商品編號	規格	螺距	精度等級	切削錐長度	全長(L)	螺紋長(l)	二節長(l1)	柄徑(d)	形狀
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			P2	1.5P					1 2 4 5
DLOT-SFT252	M2.5	0.45	P2	2.5P	44	9.5	16	3	1 2 4 5
DLOT-SFT253			P2	1.5P					1 2 4 5
DLOT-SFT302	M3	0.5	P2	2.5P	46	11	19	4	1 2 4 5
DLOT-SFT303			P2	1.5P					1 2 4 5
DLOT-SFT402	M4	0.7	P2	2.5P	52	13	21	5	1 2 4 5
DLOT-SFT403			P2	1.5P					1 2 4 5
DLOT-SFT502	M5	0.8	P2	2.5P	60	16	24	5.5	1 2 4 5
DLOT-SFT503			P2	1.5P					1 2 4 5
DLOT-SFT602	M6	1	P2	2.5P	62	19	29	6	1 2 4 5
DLOT-SFT603			P2	1.5P					1 2 4 5
DLOT-SFT803	M8	1.25	P3	2.5P	70	22	-	6.2	1 2 4 5
DLOT-SFT804			P3	1.5P					1 2 4 5
DLOT-SFT1003	M10	1.5	P3	2.5P	75	24	-	7	1 2 4 5
DLOT-SFT1004			P3	1.5P					1 2 4 5
DLOT-SFT1005			P3	2.5P					1 2 4 5
DLOT-SFT1006	M12	1.25	P3	1.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1204			P4	2.5P					1 2 4 5
DLOT-SFT1205	M12	1.75	P4	1.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1206			P3	2.5P					1 2 4 5
DLOT-SFT1207	M12	1.5	P3	1.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1208			P3	2.5P					1 2 4 5
DLOT-SFT1209	M12	1.25	P3	1.5P	82	29	-	8.5	1 2 4 5
DLOT-SFT1404			P3	2.5P					1 2 4 5
DLOT-SFT1405	M14	2	P4	2.5P	88	25	-	10.5	1 2 4 5
DLOT-SFT1604			P4	1.5P					1 2 4 5
DLOT-SFT1605	M16	2	P4	2.5P	95	27	-	12.5	1 2 4 5
DLOT-SFT1804			P4	1.5P					1 2 4 5
DLOT-SFT1805	M18	2.5	P4	2.5P	100	29	-	14	1 2 4 5
DLOT-SFT2004			p4	1.5P					1 2 4 5
DLOT-SFT2005	M20	2.5	P4	2.5P	105	30	-	15	1 2 4 5
DLOT-SFT2005			p4	1.5P					1 2 4 5

SOLID CARBIDE SPIRAL FLUTED TAP WITH INTERNAL COOLANT SUPPLY

硬質合金帶內冷卻孔螺旋鑽

Selection of materials
選用材料 → CARBIDE
硬質合金

Surface treatment
表面處理 → TIN
氮化處理 / TiCN
氮化鈦處理 / TiALIN
氮化鋁處理

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，無屑加工，無積屑加工。



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 (l1) 二節長(l1)	Shank diameter (d) 柄徑(d)	TYPE 形狀	
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

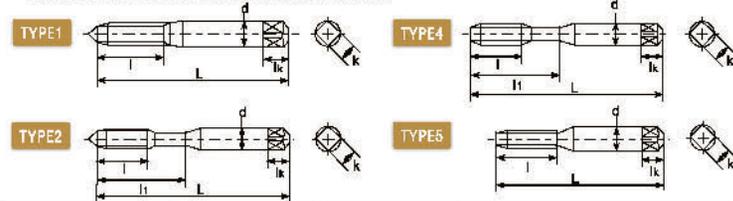
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美制螺紋

Selection of materials
選用材料 → CARBIDE
硬質合金

Surface treatment
表面處理 → TIN
氮化處理 / TiCN
氮化鈦處理 / TiALIN
氮化鋁處理

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，無屑加工，無積屑加工。

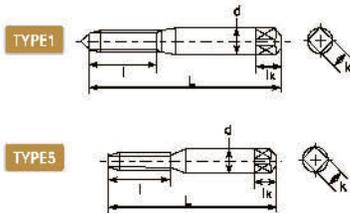


Product code 商品編號	Specification 規格	Accuracy class 精度等級	Cutting cone length 切削錐長度	Overall length (L) 全長(L)	Thread length (l) 螺紋長(l)	Second section length (l1) 二節長(l1)	Shank diameter (d) 柄徑(d)	TYPE 形狀			
DLOT-SFTU801	No.0-80	P1	2.5P	36	8	-	3	1	5		
DLOT-SFTU641	No.1-64	P1	2.5P					1	5		
DLOT-SFTU721	No.1-72	P1	2.5P	42	9.5	15	3	1	5		
DLOT-SFTU561	No.2-56	P1	2.5P					1	2	4	5
DLOT-SFTU642	No.2-64	P1	2.5P	44	9.5	16	3	1	2	4	5
DLOT-SFTU481	No.3-48	P1	2.5P					1	2	4	5
DLOT-SFTU562	No.3-56	P1	2.5P	44	9.5	16	3	1	2	4	5
DLOT-SFTU401	No.4-40	P1	2.5P					1	2	4	5
DLOT-SFTU402	No.4-40	P2	2.5P	46	11	18	4	1	2	4	5
DLOT-SFTU482	No.4-48	P1	2.5P					1	2	4	5
DLOT-SFTU483	No.4-48	P2	2.5P	48	13	20	4	1	2	4	5
DLOT-SFTU403	No.5-40	P1	2.5P					1	2	4	5
DLOT-SFTU404	No.5-40	P2	2.5P	52	13	21	5	1	2	4	5
DLOT-SFTU441	No.5-44	P1	2.5P					1	2	4	5
DLOT-SFTU442	No.5-44	P2	2.5P	60	16	24	5.5	1	2	4	5
DLOT-SFTU322	No.6-32	P2	2.5P					1	2	4	5
DLOT-SFTU323	No.6-32	P3	2.5P	60	17	25	5.5	1	2	4	5
DLOT-SFTU405	No.6-40	P2	2.5P					1	2	4	5
DLOT-SFTU406	No.6-40	P3	2.5P	60	17	25	5.5	1	2	4	5
DLOT-SFTU324	No.8-32	P2	2.5P					1	2	4	5
DLOT-SFTU362	No.8-36	P2	2.5P	60	17	25	5.5	1	2	4	5
DLOT-SFTU242	No.10-24	P2	2.5P					1	2	4	5
DLOT-SFTU325	No.10-32	P2	2.5P	60	17	25	5.5	1	2	4	5
DLOT-SFTU243	No.12-24	P2	2.5P					1	2	4	5
DLOT-SFTU282	No.12-28	P2	2.5P	1	2	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
用于铝、镁、铜合金的精密切削加工，可实现无屑加工，稳定连续加工。



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(l)	Second section length (l) 二阶长(l)	Shank diameter (d) 柄径(d)	TYPE 形式			
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	M10	1.5	P3	2.5P	100	24	41	7	1 5			
DLOT-LS-SFT1004			P3	2.5P	150				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	29	48	8.5	1 5			
DLOT-LS-SFT1204			P3	2.5P	200				1 5			
DLOT-LS-SFT1205	M12	1.5	P3	2.5P	150				1 5			
DLOT-LS-SFT1206			P3	2.5P	200				1 5			
DLOT-LS-SFT1207	M12	1.25	P3	2.5P	150	30	48	10.5	1 5			
DLOT-LS-SFT1208			P3	2.5P	200				1 5			
DLOT-LS-SFT1403	M14	2	P3	2.5P	150				32	52	12.5	1 5
DLOT-LS-SFT1404			P3	2.5P	200							1 5
DLOT-LS-SFT1405	M14	1.5	P3	2.5P	150	37	55	14				1 5
DLOT-LS-SFT1406			P3	2.5P	200							1 5
DLOT-LS-SFT1603	M16	2	P3	2.5P	150				37	58	15	1 5
DLOT-LS-SFT1604			P3	2.5P	200							1 5
DLOT-LS-SFT1605	M16	1.5	P3	2.5P	150	38	63	17				1 5
DLOT-LS-SFT1606			P3	2.5P	200							1 5
DLOT-LS-SFT1803	M18	2.5	P3	2.5P	150				45	66	19	1 5
DLOT-LS-SFT1804			P3	2.5P	200							1 5
DLOT-LS-SFT1805	M18	1.5	P3	2.5P	150	45	66	19				1 5
DLOT-LS-SFT1806			P3	2.5P	200							1 5
DLOT-LS-SFT2003	M20	2.5	P3	2.5P	150				45	66	19	1 5
DLOT-LS-SFT2004			P3	2.5P	200							1 5
DLOT-LS-SFT2005	M20	1.5	P3	2.5P	150	45	66	19				1 5
DLOT-LS-SFT2006			P3	2.5P	200							1 5
DLOT-LS-SFT2204	M22	2.5	P4	2.5P	150				45	66	19	1 5
DLOT-LS-SFT2205			P4	2.5P	200							1 5
DLOT-LS-SFT2206	M22	1.5	P3	2.5P	150	45	66	19				1 5
DLOT-LS-SFT2207			P3	2.5P	200							1 5
DLOT-LS-SFT2404	M24	3	P4	2.5P	150				45	66	19	1 5
DLOT-LS-SFT2405			P4	2.5P	200							1 5
DLOT-LS-SFT2408	M24	1.5	P3	2.5P	150	45	66	19				1 5
DLOT-LS-SFT2409			P3	2.5P	200							1 5

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
选材规格

CARBIDE
硬质合金

Surface treatment
表面处理

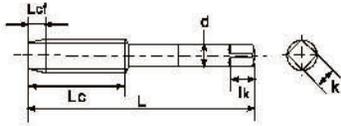
TIN
无涂层

TICN
TiCN涂层

TIALIN
TiAlN涂层

Taper pipe thread machining, suitable for blind and prone to blocking thread processing chip
管锥螺纹加工, 适合于盲孔及容易产生堵塞的螺纹加工。

TYPE8



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 (Lc) 螺纹长(Lc)	Shank diameter (d) 柄径(d)	TYPE 形状
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
选材规格

CARBIDE
硬质合金

Surface treatment
表面处理

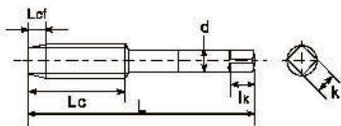
TIN
无涂层

TICN
TiCN涂层

TIALIN
TiAlN涂层

Taper pipe thread machining, suitable for blind and prone to blocking thread processing chip
管锥螺纹加工, 适合于盲孔及容易产生堵塞的螺纹加工。

TYPE8

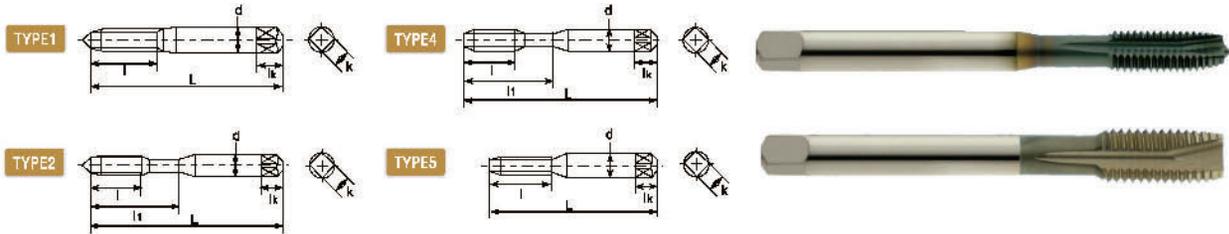


Product code 商品编号	Specification 规格	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length (Lc) 螺纹长(Lc)	Shank diameter (d) 柄径(d)	Type 形状
DLSFTS-PT182	1/8-28	P2	2.5P	120	19	8	8
DLSFTS-PT142	1/4-19	P2	2.5P	120	28	11	8
DLSFTS-PT382	3/8-19	P2	2.5P	120	28	14	8
DLSFTS-PT122	1/2-14	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

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



Product code	Specifications	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l1)	Shank diameter (d)	TYPE
產品編號	規格	螺距	精度等級	切削錐長度	全長(L)	螺紋長(l)	二節長(l1)	柄徑(d)	形狀
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	M8	1.5	P3	5P	70	22	37	6.2	1 2 4 5
DLOT-POT806			P4	5P					1 2 4 5
DLOT-POT1003	M10	1.5	P3	5P	75	24	41	7	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	24	41	7	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-POT1208	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	82	29	48	8.5	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			P3	5P					1 2 4 5
DLOT-POT1604	M16	1.5	P4	5P	95	32	52	12.5	1 2 4 5
DLOT-POT1605			P3	5P					1 2 4 5
DLOT-POT1804	M18	2.5	P4	5P	100	37	55	14	1 2 4 5
DLOT-POT1805			P4	5P					1 2 4 5
DLOT-POT2004	M20	1.5	P4	5P	105	38	58	15	1 2 4 5
DLOT-POT2005			P4	5P					1 2 4 5
DLOT-POT2204	M22	2.5	P4	5P	115	38	63	17	1 2 4 5
DLOT-POT2205			P4	5P					1 2 4 5
DLOT-POT2404	M24	3	P4	5P	120	45	66	19	1 2 4 5
DLOT-POT2405			P4	5P					1 2 4 5

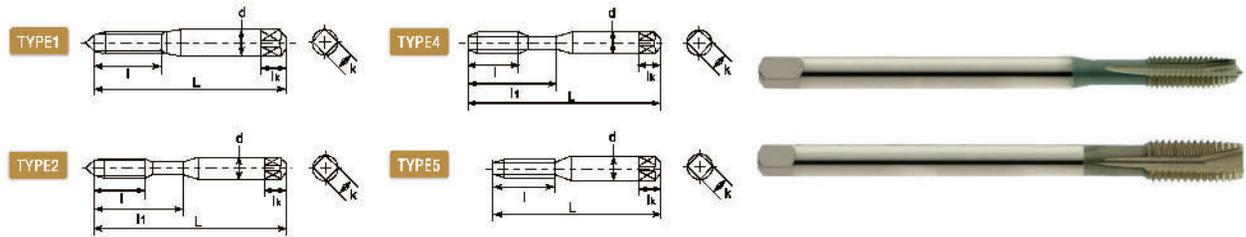
LONG SHANK SOLID CARBIDE SPIRAL POINTED TAP

硬質合金長柄打螺絲絲錐

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

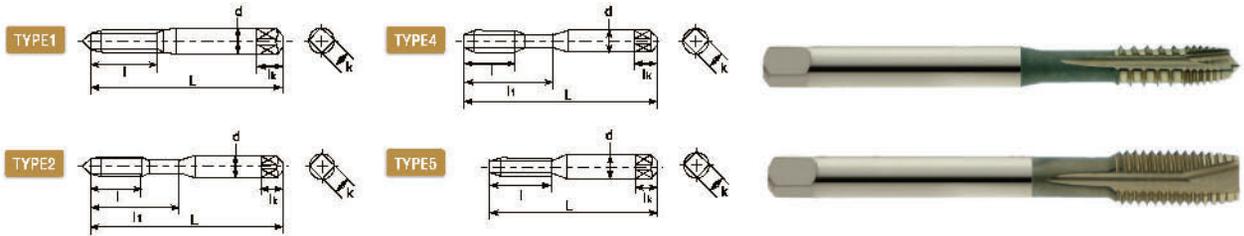


Product code	Specifications	Pitch	Accuracy class	Cutting cone length	Overall length (L)	Thread length (l)	Second section length (l')	Shank diameter (d)	TYPE
產品編號	規格	螺距	精度等級	切削錐長度	全長(L)	螺紋長(l)	第二段長(l')	柄徑(d)	形狀
DLOT-LPOT202	M2.0	0.4	P2	5P	60	9.5	-	3	1 2
DLOT-LPOT252	M2.5	0.45	P2	5P	60	9.5	-	3	1 2
DLOT-LPOT302	M3	0.5	P2	5P	80	11	16	4	1 2
DLOT-LPOT402	M4	0.7	P2	5P	80	13	21	5	1 2
DLOT-LPOT502	M5	0.8	P2	5P	100	16	24	5.5	1 2
DLOT-LPOT602	M6	1	P2	5P	100	19	29	6	1 2 4
DLOT-LPOT603			P2	5P	150				1 2 4
DLOT-LPOT803	M8	1.25	P3	5P	100	22	37	6.2	4 5
DLOT-LPOT804			P3	5P	150				4 5
DLOT-LPOT1003	M10	1.5	P3	5P	150	24	41	7	4 5
DLOT-LPOT1004		1.25	P3	5P					4 5
DLOT-LPOT1204	M12	1.75	P4	5P	150	29	48	8.5	4 5
DLOT-LPOT1205		1.5	P3	5P					4 5
DLOT-LPOT1206		1.25	P4	5P					4 5
DLOT-LPOT1404	M14	2	P4	5P	150	30	48	10.5	4 5
DLOT-LPOT1405		1.5	P3	5P					4 5
DLOT-LPOT1604	M16	2	P4	5P	150	32	52	12.5	4 5
DLOT-LPOT1605		1.5	P3	5P					4 5
DLOT-LPOT1804	M18	2.5	P4	5P	150	37	55	14	4 5
DLOT-LPOT1805		1.5	P4	5P					4 5
DLOT-LPOT2004	M20	2.5	P4	5P	150	37	58	15	4 5
DLOT-LPOT2005		1.5	P4	5P					4 5
DLOT-LPOT2204	M22	2.5	P4	5P	200	38	63	17	4 5
DLOT-LPOT2205		1.5	P4	5P					4 5
DLOT-LPOT2404	M24	3	P4	5P	200	45	66	19	4 5
DLOT-LPOT2405		1.5	P4	5P					4 5

Selection of materials → CARBIDE
材料选择 → 硬质合金

Surface treatment → TIN TiCN TiAlN
表面处理 → 镀锡 氮化钛 氮化钛铝

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，稳定连续加工。



Product code 商品编号	Specifications 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(l)	Second section length (l1) 二重径 (l1)	Shank diameter (d) 柄径(d)	TYPE 形状
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	No.4-48	P1	2.5P	46	11	18	4	1 2
DLOT-POTU483		P2	2.5P					1 2
DLOT-POTU403	No.5-40	P1	2.5P	48	13	20	4	1 2
DLOT-POTU404		P2	2.5P					1 2
DLOT-POTU441		P1	2.5P					1 2
DLOT-POTU442	No.5-44	P2	2.5P	52	13	21	5	1 2
DLOT-POTU406		P3	2.5P					1 2
DLOT-POTU322	No.6-32	P2	2.5P	60	16	24	5.5	1 2 4 5
DLOT-POTU323		P3	2.5P					1 2 4 5
DLOT-POTU405	No.6-40	P2	2.5P	60	17	25	5.5	1 2 4 5
DLOT-POTU406		P3	2.5P					1 2 4 5
DLOT-POTU324	No.8-32	P2	2.5P	60	16	24	5.5	1 2 4 5
DLOT-POTU362	No.8-36	P2	2.5P					1 2 4 5
DLOT-POTU242	No.10-24	P2	2.5P	60	16	24	5.5	1 2 4 5
DLOT-POTU325	No.10-32	P2	2.5P					1 2 4 5
DLOT-POTU243	No.12-24	P2	2.5P	60	17	25	5.5	1 2 4 5
DLOT-POTU282	No.12-28	P2	2.5P					1 2 4 5

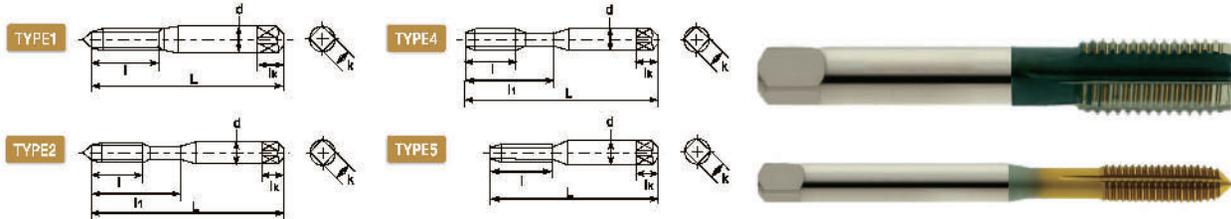
METRIC THREAD

公制螺紋

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
 用于铝、镁、铜合金大量高精度加工、无屑连续加工、稳定连续加工。



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)	Shank diameter (d) 柄徑(d)	TYPE 形狀
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			P3	3P	36	11	3	1 5
DLOTT181	M1.8	0.35	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			P3	3P	44	14	3	1 2 4 5
DLOTT261	M2.6	0.45	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			P4	3P	70	22	6.2	1 2 4 5
DLOTT801	M8	1.25	P4	1.5P				1 2 4 5
DLOTT804			P3	3P				1 2 4 5
DLOTT805		1	P3	1.5P				1 2 4 5
DLOTT1003		1.5	P4	3P	75	24	7	4 5
DLOTT1001			P4	1.5P				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	82	29	8.5	4 5
DLOTT1201			P5	1.5P				4 5
DLOTT1204		1.5	P4	3P				4 5
DLOTT1205			P4	1.5P				4 5
DLOTT1206	M12	1.25	P4	3P	80	24	8.5	4 5
DLOTT1207			P4	1.5P				4 5
DLOTT1208		1	P3	3P				4 5
DLOTT1209			P3	1.5P				4 5
DLOTT1403		2	P4	3P	88	29	10.5	4 5
DLOTT1401	M14	1.5	P4	1.5P		22		4 5
DLOTT1404			P4	3P				4 5
DLOTT1405			P4	1.5P				4 5
DLOTT1603		2	P5	3P	95	29	12.5	4 5
DLOTT1601	M16	1.5	P5	1.5P				4 5
DLOTT1604			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 形狀	
DLOTT1803	M18	2.5	P5	3P	100	35	14	4	5
DLOTT1801			P5	1.5P				4	5
DLOTT1804	M18	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	M20	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	M22	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	M24	1.5	P4	3P	95	29	19	4	5
DLOTT2405			P4	1.5P				4	5



LONG SHANK

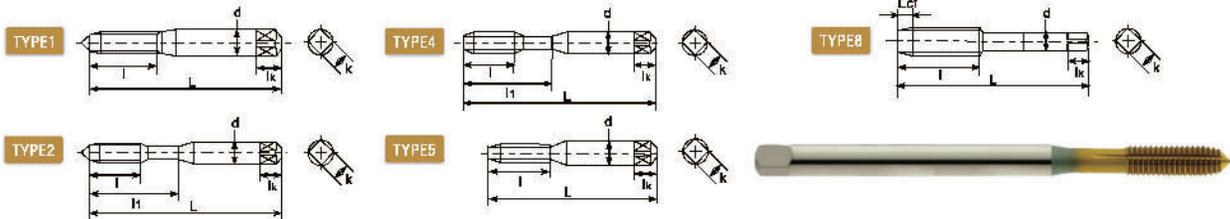
长柄型

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

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，能进行稳定的连续加工。



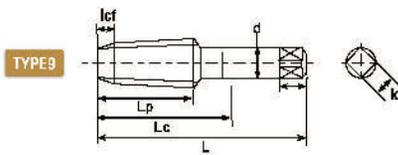
Product code 产品编号	Specification 规格	Pitch 螺距	Accuracy class 精度等级	Cutting cone length 切削锥长度	Overall length (L) 全长(L)	Thread length(l) 螺距点(l)	Shank diameter (d) 柄径(d)	TYPE 形状			
								1	2	4	5
DLLS-OTT202	M2.0	0.4	P2	3P	80	9	3	1	2	4	5
DLLS-OTT252	M2.5	0.45	P3	3P	80	9	3	1	2	4	5
DLLS-OTT303	M3	0.5	P2	3P	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			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			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			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			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			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			8			
DLLS-OTT2405			P4	1.5P				8			

硬质合金长柄直槽锥管螺纹丝锥

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



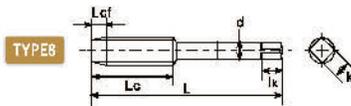
Product code	Specification	Accuracy class	Cutting cone length	Overall length (L)	Thread length (Lc)	Second section length (Lp)	Shank diameter (d)	TYPE
DLOT-LS-PT181	1/8-28	P2	2.5P	100	19	13	8	9
DLOT-LS-PT182		P2	2.5P	150				9
DLOT-LS-PT141	1/4-19	P2	2.5P	100	28	21	11	9
DLOT-LS-PT142		P2	2.5P	150				9
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

硬质合金直柄平行管螺纹

Selection of materials → CARBIDE

Surface treatment → TIN, TiCN, TiAlN



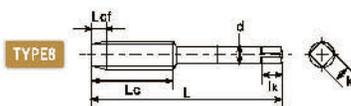
Product code	Specifications	Accuracy class	Cutting cone length	Overall length L	Thread length Lc	Shank diameter d	TYPE
DLOT-SPT181	1/8-28	P2	3P	55	19	8	8
DLOT-SPT141	1/4-19	P2	3P	62	28	11	8
DLOT-SPT381	3/8-19	P2	3P	65	28	14	8
DLOT-SPT121	1/2-14	P2	3P	80	35	18	8
DLOT-SPT341	3/4-14	P2	3P	85	35	23	8
DLOT-SPT1001	1-11	P2	3P	95	45	26	8

LONG SHANK CARBIDE PARALLEL PIPE THREAD TAP STRAIGHT FLUTE

硬质合金长柄直槽平行管螺纹

Selection of materials → CARBIDE

Surface treatment → TIN, TiCN, TiAlN



Product code	Specifications	Accuracy class	Cutting cone length	Overall length L	Thread length Lc	Shank diameter d	TYPE
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

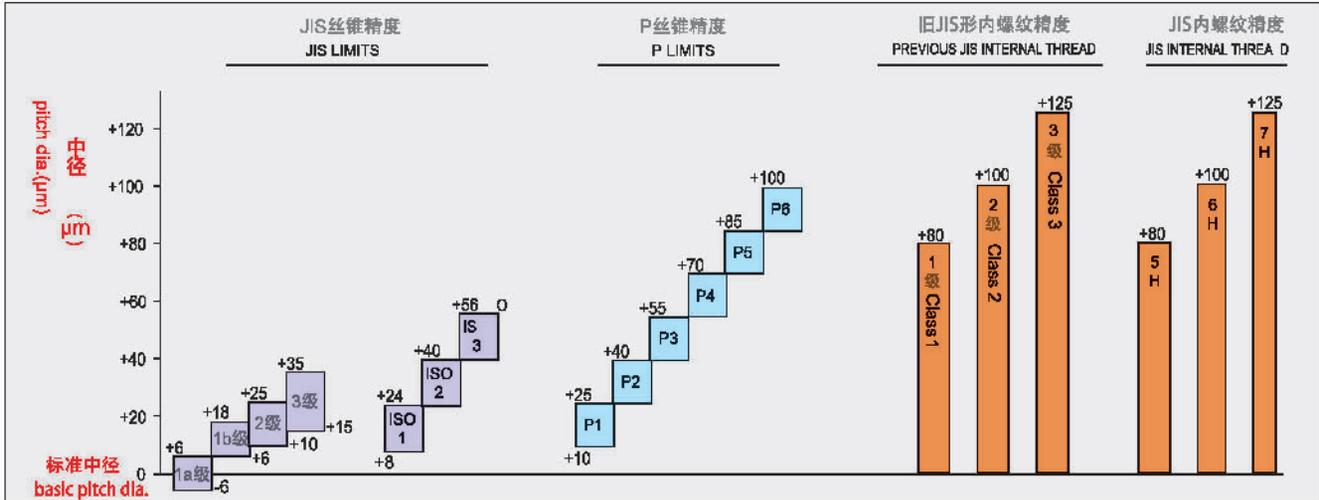
P 精度

P < 0.6 (40牙以上) P < 0.6 (T.P.I. > 40)
 上公差: 0.010 + 0.015 × n upper limit: 0.010 + 0.015 × n
 下公差: 上公差 - 0.015 lower limit: (upper limit) - 0.015
 单位: mm Unit: mm (n = P号) (P number)

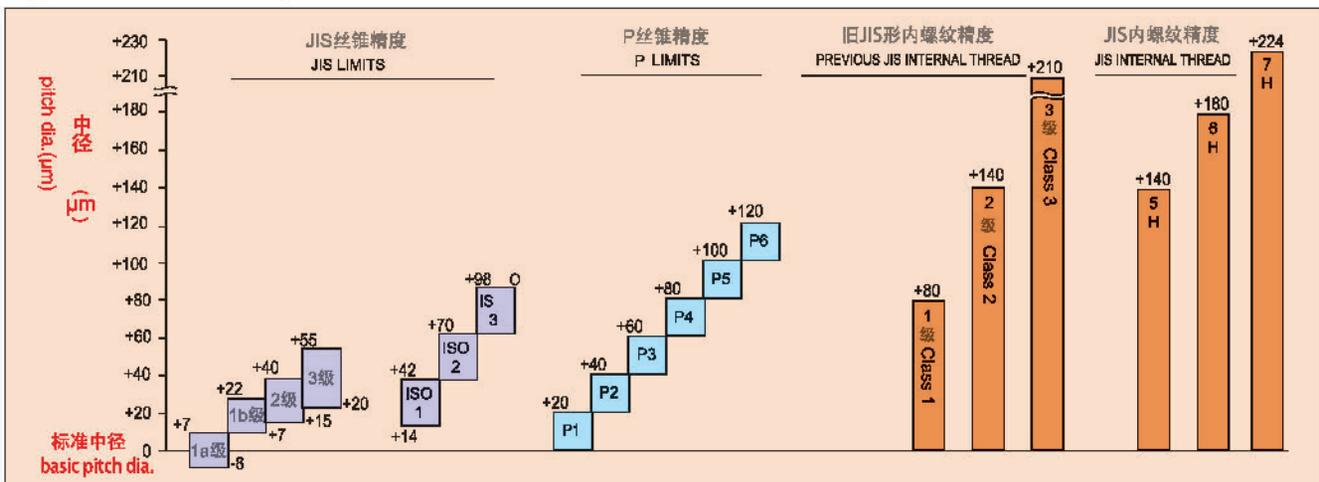
Almost all cutting tap has adapted some accuracy, the accuracy has to or higher than that JIS2 level equal accuracy according to the pitch will tap in size according to the following partition.

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

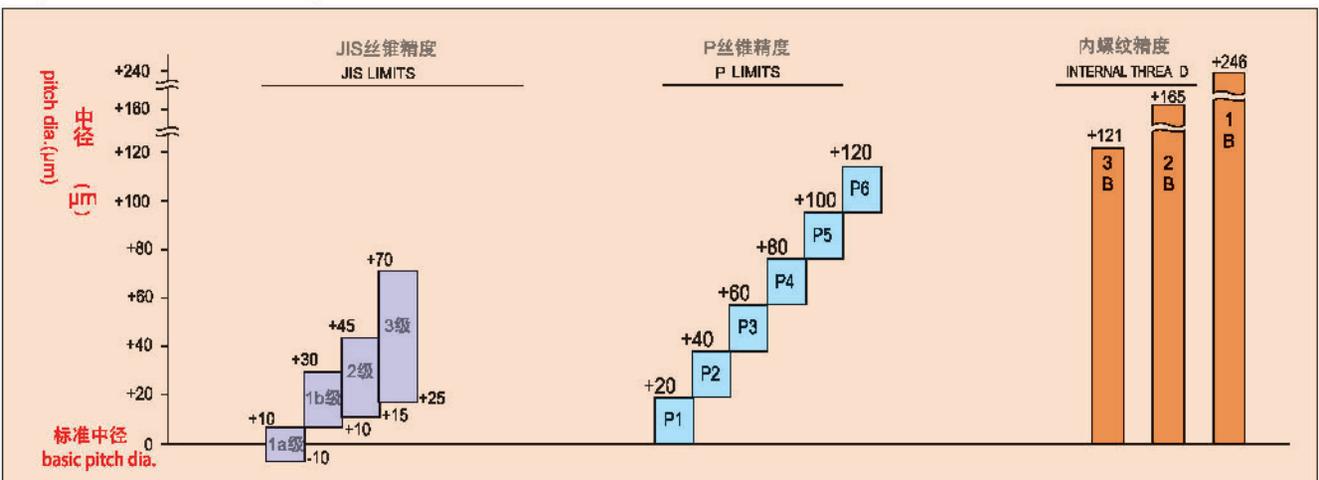
例: M3X0.5 Example: M3X0.5



例: M10X1.5 Example: M10X1.5



例: 1/2-13UNC Example: 1/2-13UNC



ACCURACY OF RH

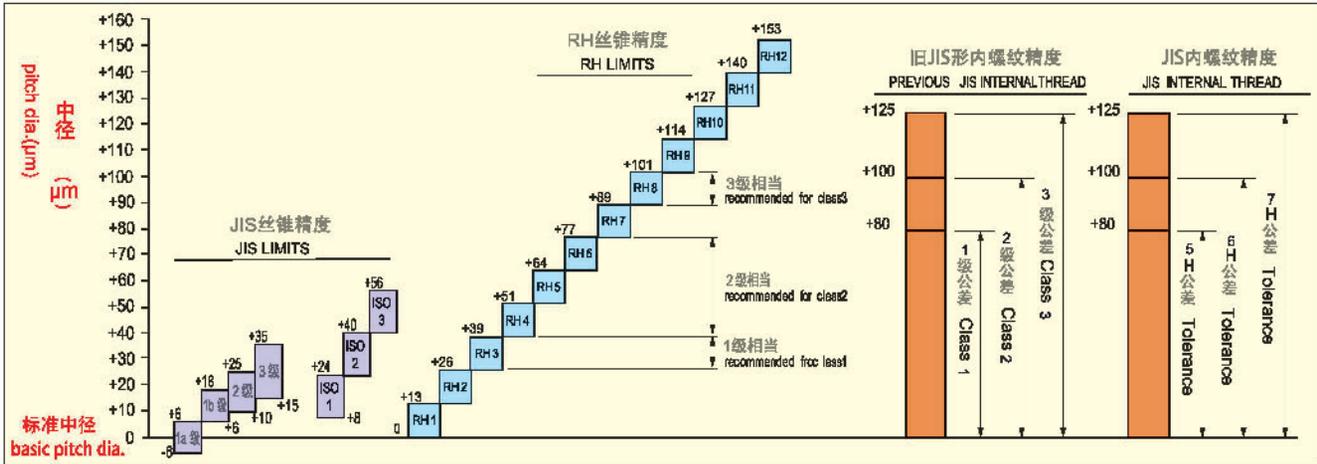
RH 精度

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)

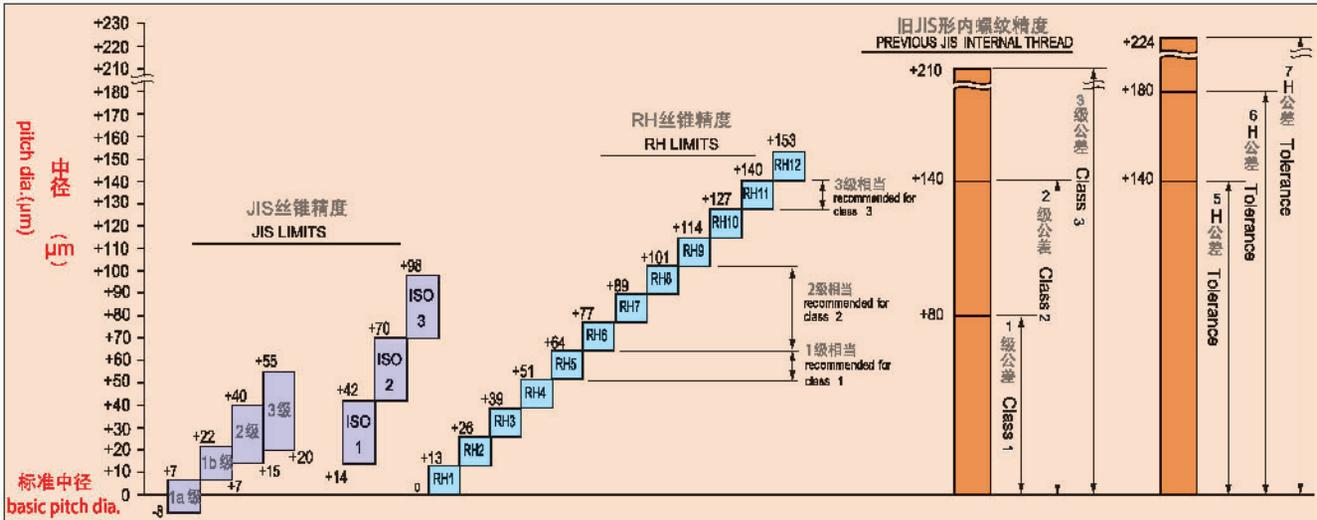
Extrusion tap the plastic deformation principle to machining internal thread, the bottom manages a cutting tap more stringent and precision tap also requires more stringent. Adopted a tolerance of $12.7\mu\text{m}$

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 $12.7\mu\text{m}$.

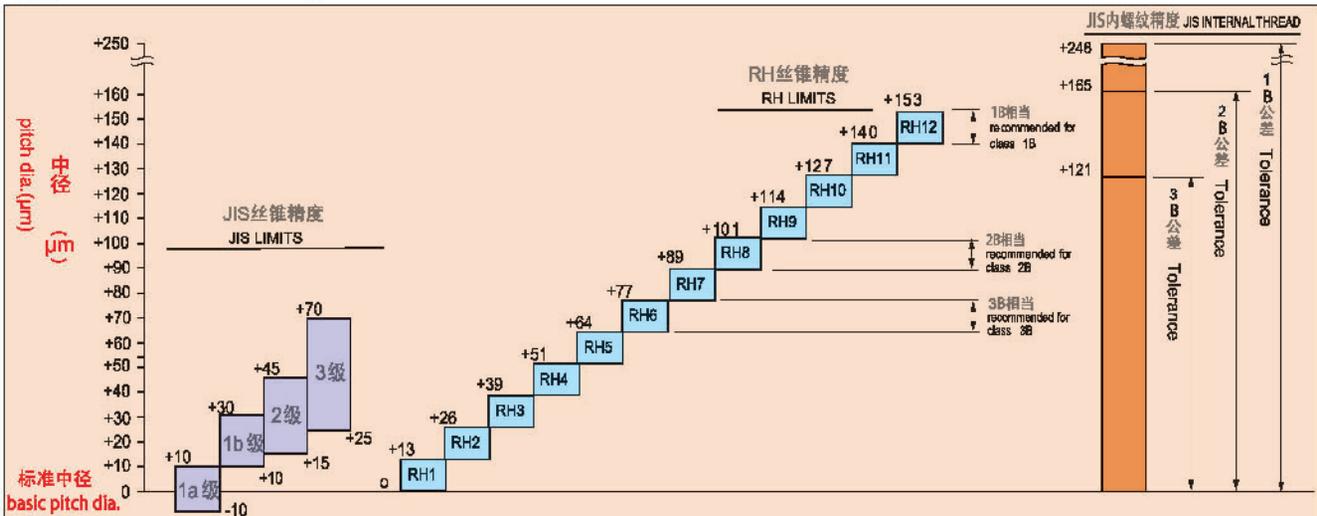
例: M3 x 0.5 Example: M3 x 0.5



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、加工材质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度。

Processing materials 加工材料	Cutting speed 切削速度 (m/min)							Cutting fluid 切削液			
	Straight fluted tap 直槽丝锥	Spiral fluted tap 螺旋槽丝锥	Edge slot taps 刃槽丝锥	Carbide taps 硬质合金丝锥	Extruded Taps 挤压丝锥	High speed synchronous tap 高速同步丝锥	Pipe tap 管攻丝锥	Oily 油性	Water solubility 水溶性 切削液	Semi dry 半干式	Dry 干式
低碳素钢 CO.25%以下	8~13	8~13	15~25	-	8~13	27~32	3~6	◎	○	△	△
中碳素钢 CO.25~0.45%	7~12	7~12	10~15	-	7~10	27~32	3~6	◎	○	△	△
高碳素钢 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	◎	○	○	-
锌铸件 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. 选型时参阅各用途丝锥选型基准表。

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

◆ 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
	≥si13%	50 ~ 100	0.02 ~ 0.1
铝合金铸件	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
	≥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
	≥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
	≥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		Bit 钻头
		Cutting speed 切削速度 (m/min)	Feed quantity 进给量 (mm/rev)	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
	≥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,机械和夹套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。

AT THE BOTTOM OF THE APERTURE

底孔径

- ◆ 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 Overiap Ratio) substantially affects tapping operations.

Cf. Thread Overiap Ratio=percentage of thread overiap(a)to basic overiap(h)

嵌合率 Formula

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

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

- ◆ 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

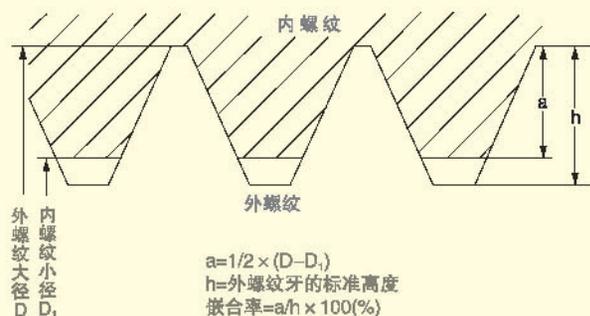
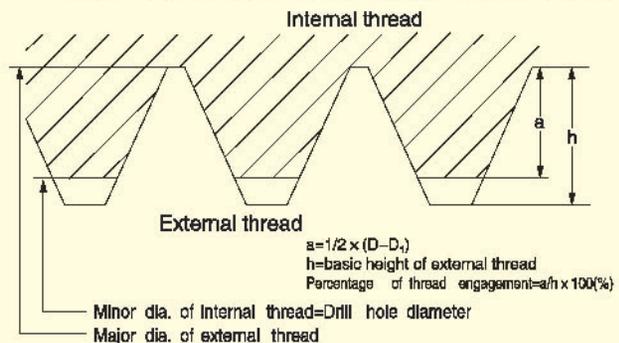


Figure1 Percentage of thread engagement

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 size 螺纹尺寸	Recommended bottom aperture 推荐底孔径	Minimal bottom aperture 最小孔径	Maximum bottom aperture 最大孔径			
			General accuracy 普通级	JIS2 level JIS2级	4H用	5H用
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	2.48	2.59	2.54	2.57	2.59
3×0.35	2.65	2.63	2.77	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	3.48	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	5.08	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	6.08	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	7.08	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 size 螺纹尺寸	Recommended bottom aperture 推荐底孔径	Minimal bottom aperture 最小孔径	Maximum bottom aperture 最大孔径			
			General accuracy 普通级	JIS2 level JIS2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	12.58	12.61	12.67
14×1	13	12.92	13.15	13.08	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	14.08	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	15.08	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	16.08	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	17.08	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	19.08	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	21.08	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	23.08	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	24.08	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	26.08	26.1	26.15
28×3	25	-	-	-	-	-



CUTTING TAP TAP DIAMETER TABLE (AMERICAN THREAD)

切削丝锥螺纹底孔直径表 (美制螺纹)

Unit: mm
单位: mm

Thread size 螺纹尺寸	Recommended bottom aperture 推荐底孔径	JIS2B level JIS2B级用	
		Minimal bottom aperture 最小底孔径	Maximum bottom aperture 最大底孔径
No.0 ×80UNF	1.25	1.19	1.3
1 ×84UNC	1.51	1.43	1.58
1 ×72UNF	1.55	1.48	1.61
2 ×56UNC	1.79	1.7	1.87
2 ×64UNF	1.84	1.76	1.91
3 ×48UNC	2.05	1.95	2.14
3 ×56UNF	2.11	2.03	2.19
4 ×40UNC	2.27	2.16	2.38
4 ×48UNF	2.37	2.28	2.45
5 ×40UNC	2.59	2.49	2.69
5 ×44UNF	2.65	2.56	2.74
6 ×32UNC	2.77	2.65	2.89
6 ×40UNF	2.92	2.82	3.02
8 ×32UNC	3.42	3.31	3.53
8 ×36UNF	3.51	3.41	3.6
10 ×24UNC	3.83	3.69	3.96
10 ×32UNF	4.07	3.97	4.16
12 ×24UNC	4.47	4.35	4.59
12 ×28UNF	4.61	4.5	4.72
1/4×20UNC	5.12	4.98	5.25
1/4×28UNF	5.47	5.36	5.58
1/4×32UNEF	5.59	5.49	5.68
5/16×18UNC	6.57	6.41	6.73
5/16×24UNF	6.91	6.79	7.03
5/16×32UNEF	7.18	7.09	7.26
3/8×18UNC	7.98	7.8	8.15
3/8×20UN	8.3	8.16	8.43
3/8×24UNF	8.51	8.39	8.63
3/8×32UNEF	8.77	8.67	8.86
7/16×14UNC	9.35	9.15	9.55
7/16×20UNF	9.88	9.73	10.03
1/2×13UNC	10.81	10.6	11.02
1/2×20UNF	11.47	11.33	11.6
9/16×12UNC	12.2	11.99	12.4
9/16×18UNF	12.9	12.8	13
5/8×11UNC	13.6	13.4	13.8
5/8×18UNF	14.5	14.4	14.6
5/8×24UNEF	14.9	14.8	14.9

Thread size 螺纹尺寸	Recommended bottom aperture 推荐底孔径	JIS2B level JIS2B级用	
		Minimal bottom aperture 最小底孔径	Maximum bottom aperture 最大底孔径
No. 3/4×10UNC	16.6	16.4	16.8
3/4×18UNF	17.5	17.4	17.6
7/8×9UNC	17.8	17.7	17.9
7/8×9UNC	19.5	19.2	19.7
7/8×14UNF	20.5	20.3	20.6
7/8×20UNEF	21	20.9	21.1
1 ×8UNC	22.3	22	22.6
1 ×12UNF	23.4	23.2	23.5
1 ×14UNS	23.6	-	-
1 1/16×12UN	24.9	24.7	25.1
1 1/8×7UNC	25	24.7	25.3
1 1/8×12UNF	26.5	26.3	26.7
1 1/4×7UNC	28.2	27.9	28.5
1 1/4×8UN	28.7	28.4	28.9
1 1/4×12UNF	29.7	29.5	29.9
1 3/8×6UNC	30.8	30.4	31.1
1 3/8×12UNF	32.9	32.7	33
1 1/2×6UNC	33.9	33.6	34.2
1 1/2×8UN	35	34.7	35.3
1 5/8×5UNS	36.2	-	-
1 3/4×5UNC	39.4	39	39.8
1 3/4×8UN	41.4	41.1	41.6
1 3/4×12UN	42.4	42.2	42.6
2 ×4.5UNC	45.1	44.7	45.5
2 ×8UN	47.7	47.4	48
2 ×12UN	48.8	48.6	48.9
2 1/4×4.5UNC	51.5	51.1	51.9
2 1/2×4UNC	57.1	56.7	57.5
2 1/2×8UN	60.4	60.1	60.7
2 3/4×4UNC	63.5	63	63.9
2 3/4×8UN	66.8	66.5	67
3 ×4UNC	69.8	69.3	70.2
3 ×8UN	73.1	72.8	73.4
3 1/4×4UNC	76.2	75.7	76.6
3 1/2×8UN	85.8	85.5	86.1
3 3/4×4UNC	88.9	88.4	89.3
4 ×4UNC	95.2	94.8	95.6
4 ×8UN	98.5	98.2	98.8

THE EXTRUSION TAP TAP DIAMETER TABLE

挤压丝锥螺纹底孔直径表

Metric thread

公制螺纹

Thread size 螺纹尺寸	for JIS class 1 drill hole dia. 1号钻头用底孔直径				for JIS class 2 drill hole dia. 2号钻头用底孔直径			
	RH	Min-Max(Thread	Overlap Ratio%)		RH	Min-Max(Thread	Overlap Ratio%)	
	精度	最小-最大 (配合率%)			精度	最小-最大 (配合率%)		
M 1 x 0.25	2	0.87 ~ 0.89(100-85)	4	0.9 ~ 0.92(100-80)				
1.1 x 0.25	2	0.97 ~ 0.99(100-85)	4	1 ~ 1.02(100-80)				
1.2 x 0.25	2	1.07 ~ 1.09(100-85)	4	1.1 ~ 1.12(100-80)				
1.4 x 0.3	2	1.244 ~ 1.263(100-85)	4	1.27 ~ 1.294(100-75)				
1.6 x 0.35	2	1.41 ~ 1.44(100-80)	4	1.44 ~ 1.48(100-75)				
1.7 x 0.35	2	1.51 ~ 1.54(100-80)	4	1.54 ~ 1.58(100-75)				
1.8 x 0.35	2	1.61 ~ 1.64(100-80)	4	1.64 ~ 1.68(100-75)				
2 x 0.25	2	1.88 ~ 1.89(100-80)	4	1.9 ~ 1.92(100-75)				
2 x 0.4	2	1.78 ~ 1.82(100-80)	4	1.81 ~ 1.85(100-75)				
2.2 x 0.45	2	1.95 ~ 1.99(100-80)	4	1.98 ~ 2.03(100-75)				
2.3 x 0.4	2	2.08 ~ 2.12(100-80)	4	2.11 ~ 2.15(100-75)				
2.5 x 0.45	2	2.25 ~ 2.29(100-80)	4	2.28 ~ 2.33(100-75)				
2.6 x 0.45	2	2.35 ~ 2.39(100-80)	4	2.38 ~ 2.43(100-75)				
3 x 0.5	3	2.74 ~ 2.78(100-80)	5	2.76 ~ 2.81(100-75)				
3.5 x 0.6	3	3.18 ~ 3.21(100-85)	5	3.2 ~ 3.26(100-75)				
4 x 0.7	4	3.63 ~ 3.67(100-85)	6	3.65 ~ 3.7(100-85)				
5 x 0.8	4	4.57 ~ 4.62(100-85)	6	4.59 ~ 4.66(100-80)				
6 x 1	4	5.45 ~ 5.51(100-85)	7	5.48 ~ 5.57(100-80)				
7 x 1	4	6.45 ~ 6.51(100-85)	7	6.48 ~ 6.57(100-80)				
8 x 1.25	5	7.31 ~ 7.38(100-85)	7	7.34 ~ 7.41(100-85)				
8 x 1	4	7.45 ~ 7.51(100-85)	7	7.48 ~ 7.57(100-80)				
10 x 1.5	5	9.16 ~ 9.22(100-85)	7	9.18 ~ 9.28(100-85)				
10 x 1.25	5	9.31 ~ 9.38(100-85)	7	9.34 ~ 9.41(100-85)				
10 x 1	5	9.46 ~ 9.52(100-85)	7	9.48 ~ 9.57(100-80)				
12 x 1.75	5	11.01 ~ 11.08(100-90)	8	11.05 ~ 11.15(100-85)				
12 x 1.5	5	11.06 ~ 11.22(100-90)	7	11.18 ~ 11.28(100-85)				
12 x 1.25	5	11.31 ~ 11.38(100-85)	7	11.34 ~ 11.41(100-85)				
12 x 1	5	11.46 ~ 11.52(100-85)	7	11.48 ~ 11.57(100-80)				
14 x 2	6	12.83 ~ 12.95(100-90)	10	12.92 ~ 13.04(100-85)				
14 x 1.5	5	13.16 ~ 13.22(100-90)	9	13.21 ~ 13.3(100-85)				
16 x 2	6	14.87 ~ 14.95(100-90)	10	14.92 ~ 15.04(100-85)				
16 x 1.5	5	15.16 ~ 15.22(100-90)	9	15.21 ~ 15.3(100-80)				
18 x 2.5	6	16.57 ~ 16.67(100-90)	11	16.63 ~ 16.78(100-85)				
18 x 1.5	6	17.17 ~ 17.23(100-90)	10	17.22 ~ 17.31(100-85)				
20 x 2.5	6	18.57 ~ 18.67(100-90)	11	18.63 ~ 18.78(100-85)				
20 x 1.5	6	19.17 ~ 19.23(100-90)	10	19.22 ~ 19.31(100-85)				

Unit: mm

单位: mm

Metric thread

公制螺纹

Thread size 螺纹尺寸	for JIS class 3 drill hole dia. 3号钻头用底孔直径				for JIS class 2 drill hole dia. 2号钻头用底孔直径			
	RH	Min-Max(Thread	Overlap Ratio%)		RH	Min-Max(Thread	Overlap Ratio%)	
	精度	最小-最大 (配合率%)			精度	最小-最大 (配合率%)		
M 1 x 0.25	2	0.858 ~ 0.879(100-85)	4	0.858 ~ 0.887(100-80)				
1.2 x 0.25	2	1.058 ~ 1.079(100-85)	4	1.058 ~ 1.087(100-80)				
1.4 x 0.3	2	1.23 ~ 1.26(100-85)	4	1.23 ~ 1.26(100-80)				
1.6 x 0.35	2	1.4 ~ 1.44(100-80)	4	1.4 ~ 1.45(100-75)				
1.7 x 0.35	-	1.5 ~ 1.54(100-80)	4	1.5 ~ 1.55(100-75)				
1.8 x 0.35	2	1.6 ~ 1.64(100-80)	4	1.6 ~ 1.65(100-75)				
2 x 0.4	2	1.77 ~ 1.82(100-80)	4	1.77 ~ 1.82(100-85)				
2 x 0.25	2	1.858 ~ 1.887(100-80)	-	1.858 ~ 1.89(100-75)				
2.3 x 0.4	-	2.07 ~ 2.12(100-80)	4	2.07 ~ 2.13(100-75)				
2.5 x 0.45	3	2.24 ~ 2.3(100-80)	5	2.24 ~ 2.31(100-75)				
2.6 x 0.45	-	2.34 ~ 2.4(100-80)	5	2.34 ~ 2.41(100-75)				
3 x 0.6	3	2.72 ~ 2.73(100-80)	5	2.66 ~ 2.73(100-90)				
3 x 0.5	5	2.72 ~ 2.77(100-80)	6	2.72 ~ 2.78(100-75)				
3 x 0.35	3	2.8 ~ 2.84(100-80)	5	2.8 ~ 2.85(100-75)				
3.5 x 0.6	3	3.16 ~ 3.21(100-85)	5	3.16 ~ 3.25(100-75)				
4 x 0.75	3	3.57 ~ 3.64(100-85)	6	3.57 ~ 3.64(100-85)				
4 x 0.7	6	3.6 ~ 3.66(100-85)	7	3.6 ~ 3.66(100-85)				
4 x 0.5	3	3.71 ~ 3.77(100-80)	6	3.71 ~ 3.79(100-75)				
5 x 0.9	3	4.49 ~ 4.59(100-85)	7	4.49 ~ 4.59(100-85)				
5 x 0.8	3	4.55 ~ 4.62(100-85)	8	4.55 ~ 4.64(100-80)				
5 x 0.5	3	4.72 ~ 4.77(100-80)	6	4.72 ~ 4.79(100-75)				
6 x 1	4	5.43 ~ 5.52(100-85)	7	5.43 ~ 5.55(100-80)				
6 x 0.75	3	5.57 ~ 5.64(100-85)	7	5.57 ~ 5.66(100-80)				

Unit: mm

单位: mm

National coarse thread

美制粗牙螺纹

Thread size 螺纹尺寸	for JIS class 2B drill hole dia. 2B号钻头用底孔直径				for JIS class 3B drill hole dia. 3B号钻头用底孔直径			
	RH	Min-Max(Thread	Overlap Ratio%)		RH	Min-Max(Thread	Overlap Ratio%)	
	精度	最小-最大 (配合率%)			精度	最小-最大 (配合率%)		
NO. 1-64NUC	3	1.66 ~ 1.7(100-65)	2	1.65 ~ 1.69(100-65)				
NO. 2-56	4	1.96 ~ 2.02(100-65)	3	1.95 ~ 2.01(100-65)				
NO. 3-48	4	2.25 ~ 2.32(100-65)	3	2.23 ~ 2.31(100-65)				
NO. 4-40	5	2.52 ~ 2.6(100-70)	3	2.5 ~ 2.58(100-70)				
NO. 5-40	5	2.86 ~ 2.93(100-70)	3	2.83 ~ 2.91(100-70)				
NO. 6-32	5	3.09 ~ 3.17(100-75)	3	3.06 ~ 3.14(100-75)				
NO. 8-32	5	3.75 ~ 3.83(100-75)	4	3.74 ~ 3.82(100-75)				
NO. 10-24	6	4.26 ~ 4.35(100-80)	4	4.24 ~ 4.32(100-80)				
NO. 12-24	6	4.92 ~ 5.01(100-80)	4	4.9 ~ 4.96(100-85)				
1/4-20	6	5.66 ~ 5.76(100-80)	4	5.64 ~ 5.74(100-80)				
5/16-18	7	7.18 ~ 7.29(100-80)	5	7.15 ~ 7.24(100-85)				
3/8-16	7	8.66 ~ 8.78(100-80)	5	8.63 ~ 8.73(100-85)				
7/16-14	7	10.11 ~ 10.25(100-80)	5	10.08 ~ 10.19(100-85)				
1/2-13	8	11.62 ~ 11.78(100-80)	6	11.6 ~ 11.68(100-90)				
9/16-12	10	13.14 ~ 13.27(100-85)	8	13.11 ~ 13.24(100-85)				
5/8-11	11	14.62 ~ 14.76(100-85)	8	14.58 ~ 14.67(100-90)				
3/4-10	12	17.67 ~ 17.88(100-80)	9	17.63 ~ 17.74(100-90)				
7/8-9	12	20.68 ~ 20.85(100-85)	9	20.64 ~ 20.75(100-90)				
1-20	13	23.65 ~ 23.84(100-85)	10	23.61 ~ 23.74(100-90)				

Unit: mm

单位: mm

Parallel screw thread

美式管牙平行螺纹

Unit: mm

单位: mm

Thread size 螺纹尺寸	RH Limits RH精度	Min-Max(Thread	Overlap Ratio%)
		最小-最大 (配合率%)	
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号钻头用底孔直径				for JIS class 3B drill hole dia. 3B号钻头用底孔直径			
	RH	Min-Max(Thread	Overlap Ratio%)		RH	Min-Max(Thread	Overlap Ratio%)	
	精度	最小-最大 (配合率%)			精度	最小-最大 (配合率%)		
NO. 0-80NUC	3	1.38 ~ 1.41(100-65)	2	1.36 ~ 1.4(100-65)				
NO. 1-72	3	1.68 ~ 1.72(100-65)	2	1.67 ~ 1.71(100-65)				
NO. 2-64	3	1.98 ~ 2.04(100-65)	2	1.97 ~ 2.03(100-65)				
NO. 3-56	4	2.29 ~ 2.35(100-65)	3	2.28 ~ 2.34(100-65)				
NO. 4-48	4	2.57 ~ 2.64(100-70)	3	2.56 ~ 2.63(100-70)				
NO. 5-44	5	2.89 ~ 2.96(100-70)	3	2.87 ~ 2.94(100-70)				
NO. 6-40	5	3.19 ~ 3.26(100-70)	3	3.16 ~ 3.22(100-75)				
NO. 8-36	5	3.8 ~ 3.88(100-75)	4	3.79 ~ 3.86(100-75)				
NO. 10-32	5	4.41 ~ 4.48(100-80)	4	4.4 ~ 4.46(100-80)				
NO. 12-28	5	5 ~ 5.08(100-80)	4	4.99 ~ 5.06(100-80)				
1/4-28	5	5.86 ~ 5.93(100-80)	4	5.85 ~ 5.92(100-80)				
5/16-24	6	7.38 ~ 7.46(100-80)	5	7.36 ~ 7.43(100-85)				
3/8-24	6	8.96 ~ 9.05(100-80)	5	8.95 ~ 9.02(100-85)				
7/16-20	7	10.44 ~ 10.54(100-80)	5	10.41 ~ 10.49(100-85)				
1/2-20	7	12.02 ~ 12.12(100-80)	5	12 ~ 12.05(100-90)				
9/16-18	9	13.55 ~ 13.66(100-80)	7	13.53 ~ 13.58(100-90)				
5/8-18	9	15.14 ~ 15.25(100-80)	7	15.11 ~ 15.17(100-90)				
3/4-16	10	18.22 ~ 18.32(100-85)	7	18.18 ~ 18.25(100-90)				
7/8-14	11	21.27 ~ 21.38(100-85)	8	21.23 ~ 21.27(100-95)				
1-12	12	24.28 ~ 24.41(100-85)	9	24.24 ~ 24.32(100-95)				

1. on the table bottom vary because of different materials, for reference only.

1. 上表的底孔尺寸因工件材料不同而变化，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.
3. 底孔尺寸会受到材料、硬度、形状及其他因素的影响，如有变更，请先进行试加工。
4. bottom deformation, dislocation will lead to machining problems, please note
4. 底孔的变形、错位会导致加工问题，请注意。

RECOMMENDED DRILL HOLE SIXA (FOR SCREW THREAD INSERT)

螺紋底孔直徑表(嵌套螺紋用)

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. 2-56NUC	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. 4-48NUC	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 中螺距	Min-Max(Thread Overlap Ratio%)
		最小-最大(嵌合率%)
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)