

# 絲攻尺寸表 (JIS) Tapping Size Table

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公制 Metric System	英制 (U) English System	英制 (W) English System	直徑 Dia. Ø	四角 Quadrangle
M3		W 1/8	4	3.22
M4 M4.5		W 5/32	5	4
M5 M5.5		W 3/16	5.5	4.5
M6	U 1/4	W 1/4	6	4.5
	U 5/16	W 5/16	6.1	5
M8 M7			6.2	5
M10 M9	U 3/8	W 3/8	7	5.5
M11	U 7/16	W 7/16	8	6
M12			8.5	6.5
	U 1/2	W 1/2	9	7
M14 M15	U 9/16	W 9/16	10.5	8
	U 5/8	W 5/8	12	9
M16			12.5	10
M17			13	10
M18	U 3/4	W 3/4	14	11
M20			15	12
M22	U 7/8	W 7/8	17	13
M24 M25			19	15
M27 M26	U 1	W 1	20	15
M28			21	17
	U 1 1/8	W 1 1/8	22	17
M30			23	17
M32	U 1 1/4	W 1 1/4	24	19
M33			25	19
M35 M34	U 1 3/8	W 1 3/8	26	21
M36 M36			28	21
M39 M40	U 1 1/2	W 1 1/2	30	23
M42		W 1 5/8	32	26
M45	U 1 3/4	W 1 3/4	35	26
M48		W 1 7/8	38	29

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PT/NPT	PS/NPS	PF/NPF	直徑 Dia. Ø	四角 Quadrangle
1/8	1/8	1/8	8	6
1/4	1/4	1/4	11	9
3/8	3/8	3/8	14	11
1/2	1/2	1/2	18	14
		5/8	19	15
3/4		3/4	23	17
		7/8	24	19
1	1	1	26	21
	1 1/8	1 1/8	28	21
1 1/4	1 1/4	1 1/4	32	26
1 3/8	1 3/8	1 3/8	35	26
1 1/2	1 1/2	1 1/2	38	29

## 公制粗螺紋

Unit : mm

規格	2級牙鑽孔徑		標準徑
	Max.	Min.	
M1.0 * 0.25	0.785	0.729	0.75
M1.1 * 0.25	0.885	0.829	0.85
M1.2 * 0.25	0.985	0.985	0.95
M1.4 * 0.3	1.142	1.075	1.10
M1.6 * 0.35	1.321	1.221	1.25
M1.7 * 0.35	1.421	1.321	1.35
M1.8 * 0.35	1.521	1.421	1.45
M2.0 * 0.4	1.679	1.567	1.60
M2.2 * 0.45	1.838	1.713	1.75
M2.3 * 0.4	1.979	1.867	1.90
M2.5 * 0.45	2.138	2.013	2.10
M2.6 * 0.45	2.238	2.113	2.20
M3.0 * 0.5	2.599	2.459	2.50
M3.0 * 0.6	2.440	2.280	2.40
M3.5 * 0.6	3.010	2.850	2.90
M4.0 * 0.7	3.422	3.242	3.30
M4.0 * 0.75	3.326	3.106	3.25
M4.5 * 0.75	3.878	3.688	3.80
M5.0 * 0.8	4.334	4.134	4.20
M5.0 * 0.9	4.170	3.930	4.10
M6.0 * 1.0	5.153	4.917	5.00
M7.0 * 1.0	6.153	5.917	6.00
M8.0 * 1.25	6.912	6.647	6.80
M9.0 * 1.25	7.912	7.647	7.80
M10 * 1.5	8.676	8.376	8.50
M11 * 1.5	9.676	9.376	9.50
M12 * 1.75	10.441	10.106	10.30
M14 * 2.0	12.210	11.835	12.00
M16 * 2.0	14.210	13.835	14.00
M18 * 2.5	15.744	15.294	15.50
M20 * 2.5	17.744	17.294	17.50
M22 * 2.5	19.744	19.294	19.50
M24 * 3.0	21.252	20.752	21.00
M27 * 3.0	24.252	23.752	24.00
M30 * 3.5	26.771	26.211	26.50

## 公制細螺紋

Unit : mm

規格	2級牙鑽孔徑		標準徑
	Max.	Min.	
M1.0 * 0.2	0.821	0.783	0.80
M1.1 * 0.2	0.921	0.883	0.90
M1.2 * 0.2	1.021	0.983	1.00
M1.4 * 0.2	1.221	1.183	1.20
M1.6 * 0.2	1.421	1.383	1.40
M1.7 * 0.2	1.500	1.460	1.45
M1.8 * 0.2	1.621	1.583	1.60
M2.0 * 0.25	1.785	1.729	1.75
M2.2 * 0.25	1.985	1.929	1.95
M2.3 * 0.25	2.061	2.001	2.05
M2.5 * 0.35	2.221	2.121	2.20
M2.6 * 0.35	2.246	2.186	2.20
M3.0 * 0.35	2.721	2.621	2.70
M3.5 * 0.35	3.221	3.121	3.20
M4.0 * 0.5	3.599	3.459	3.50
M4.5 * 0.5	4.099	3.959	4.00
M5.0 * 0.5	4.599	4.459	4.50
M5.5 * 0.5	5.099	4.959	5.00
M6.0 * 0.75	5.378	5.188	5.30
M6.0 * 0.5	5.550	5.400	5.50
M7.0 * 0.75	6.378	6.188	6.30
M7.0 * 0.5	6.550	6.400	6.50
M17 * 1.0	16.153	15.917	16.00
M18 * 2.0	16.210	15.835	16.00
M18 * 1.5	16.676	16.376	16.50
M18 * 1.0	17.153	16.917	17.00
M20 * 2.0	18.210	17.835	18.00
M20 * 1.5	18.676	18.376	18.50
M20 * 1.0	19.153	18.917	19.00
M22 * 2.0	20.210	19.835	20.00
M22 * 1.5	20.676	20.376	20.50
M22 * 1.0	21.153	20.917	21.00
M24 * 2.0	22.210	21.835	22.00
M24 * 1.5	22.676	22.376	22.50
M24 * 1.0	23.153	22.917	23.00
M25 * 2.0	23.210	22.835	23.00
M25 * 1.5	23.676	23.376	23.50
M25 * 1.0	24.153	23.917	24.00
M26 * 1.5	24.676	24.376	24.50
M27 * 2.0	25.210	24.835	25.00
M27 * 1.5	25.676	25.376	25.50
M27 * 1.0	26.153	25.917	26.00
M28 * 2.0	26.210	25.835	26.00
M28 * 1.5	26.676	26.376	26.50
M28 * 1.0	27.153	26.917	27.00
M30 * 3.0	27.252	26.752	27.00
M30 * 2.0	28.210	27.835	28.00
M30 * 1.5	28.676	28.376	28.50
M30 * 1.0	29.153	28.917	29.00
M32 * 2.0	30.210	29.835	30.00
M32 * 1.5	30.676	30.376	30.50
M33 * 3.0	30.252	29.752	30.00
M33 * 2.0	31.210	30.835	31.00
M33 * 1.5	31.676	31.376	31.50
M35 * 1.5	33.676	33.376	33.50
M36 * 3.0	33.252	32.752	33.00
M36 * 2.0	34.210	33.835	34.00
M36 * 1.5	34.676	34.376	34.50

美制特細螺紋			
Unit : mm			
規格	2級牙鑽孔徑		標準徑
	Max.	Min.	
NO.12 - 32	4.826	4.623	4.70
1/4 - 32	5.690	5.486	5.60
5/16 - 32	7.264	7.087	7.10
3/8 - 32	8.865	8.661	8.70
7/16 - 28	10.338	10.135	10.20
1/2 - 28	11.938	11.709	11.80
9/16 - 24	13.386	13.132	13.20
5/8 - 24	14.986	14.732	14.80
3/4 - 20	17.958	17.678	17.80
7/8 - 20	21.133	20.853	21.00
1 - 20	24.308	24.028	24.00

美制粗螺紋			
Unit : mm			
規格 (UNC)	2級牙鑽孔徑		標準徑
	Max.	Min.	
NO.1 - 64 (1.854)	1.582	1.425	1.55
NO.2 - 56 (2.184)	1.871	1.695	1.80
NO.3 - 48 (2.515)	2.146	1.941	2.10
NO.4 - 40 (2.845)	2.385	2.157	2.30
NO.5 - 40 (3.175)	2.697	2.487	2.60
NO.6 - 32 (3.505)	2.895	2.642	2.80
NO.8 - 32 (4.166)	3.53	3.302	3.40
NO.10 - 24 (4.826)	3.962	3.683	3.90
NO.12 - 24 (5.486)	4.597	4.344	4.50
1/4 - 20	5.257	4.979	5.10
5/16 - 18	6.731	6.401	6.60
3/8 - 16	8.153	7.798	8.00
7/16 - 14	9.55	9.144	9.40
1/2 - 13	11.023	10.592	10.80
9/16 - 12	12.446	11.989	12.20
5/8 - 11	12.868	13.386	13.60
3/4 - 10	18.840	16.307	16.50
7/8 - 9	19.761	19.177	19.50
1	22.606	21.971	22.20
1 1/8 - 7	25.349	24.638	25.00
1 1/4 - 7	28.524	27.813	28.20
1 3/8 - 6	31.115	30.353	30.80
1 1/2 - 6	34.290	33.528	34.00
1 3/4 - 5	39.827	38.964	39.50
2 - 4 1/2	45.593	44.679	45.20

美制細螺紋			
Unit : mm			
規格 (UNC)	2級牙鑽孔徑		標準徑
	Max.	Min.	
NO.0 - 80 (1.524)	1.305	1.182	1.25
NO.1 - 72 (1.854)	1.612	1.474	1.55
NO.2 - 64 (2.184)	1.912	1.756	1.85
NO.3 - 56 (2.515)	2.197	2.025	2.10
NO.4 - 48 (2.845)	2.458	2.271	2.40
NO.5 - 44 (3.175)	2.740	2.551	2.70
NO.6 - 40 (3.505)	3.022	2.820	2.90
NO.8 - 36 (4.166)	3.606	3.404	3.50
NO.10 - 32 (4.826)	4.165	3.963	4.10
NO.12 - 28 (5.846)	4.724	4.496	4.60
1/4 - 28	5.588	5.360	5.50
5/16 - 24	7.035	6.782	6.90
3/8 - 24	8.636	8.382	8.50
7/16 - 20	10.03	9.729	9.90
1/2 - 20	11.607	11.329	11.50
9/16 - 18	13.081	12.751	12.90
5/8 - 18	14.681	14.351	14.50
3/4 - 16	17.678	17.323	17.50
7/8 - 14	20.675	20.270	20.50
1 - 12	23.571	23.114	23.20
1 1/8 - 12	26.746	26.289	26.50
1 1/4 - 12	29.921	29.464	29.50
1 3/8 - 12	33.096	32.639	32.80
1 1/2 - 12	36.271	35.814	36.00

美制管用螺紋							Unit : mm
規格	下孔徑				NPSC		
	NPT						
	使用鉸刀		無使用鉸刀				
	mm	inch	mm	inch	mm	inch	
1/16 - 27	5.94	0.234	6.15	0.242	6.35	0.250	
1/8 - 27	8.33	0.328	8.43	0.332	8.74	0.344	
1/4 - 18	10.72	0.422	11.13	0.438	11.13	0.438	
3/8 - 18	14.27	0.562	14.27	0.562	14.68	0.578	
1/2 - 14	17.48	0.688	17.86	0.703	18.26	0.719	
3/4 - 14	22.63	0.891	23.01	0.906	23.42	0.922	
1 - 11 1/2	28.58	1.125	28.98	1.141	29.36	1.156	
1 1/4 - 11 1/2	37.31	1.469	37.69	1.484	38.10	1.500	
1 1/2 - 11 1/2	43.26	1.703	43.66	1.719	44.45	1.750	
2 - 11 1/2	55.17	2.172	55.58	2.188	56.36	2.219	
2 1/2 - 8	65.48	2.578	66.27	2.609	67.46	2.656	

美用乾式氣密管用螺紋							Unit : mm
規格	下孔徑				NPSF		
	NPTF						
	使用鉸刀		無使用鉸刀				
	mm	inch	mm	inch	mm	inch	
1/16 - 27	5.94	0.234	6.15	0.242	6.25	0.246	
1/8 - 27	8.33	0.328	8.43	0.332	8.61	0.339	
1/4 - 18	10.72	0.422	11.13	0.438	11.13	0.438	
3/8 - 18	14.27	0.562	14.27	0.562	14.68	0.578	
1/2 - 14	17.48	0.688	17.86	0.703	17.86	0.703	
3/4 - 14	22.63	0.891	23.01	0.906	23.42	0.922	
1 - 11 1/2	28.58	1.125	28.98	1.141	29.36	1.156	
1 1/4 - 11 1/2	37.31	1.469	37.69	1.484			
1 1/2 - 11 1/2	43.26	1.703	43.66	1.719			
2 - 11 1/2	55.17	2.172	55.58	2.188			
2 1/2 - 8	65.48	2.578	66.27	2.609			

<b>英制牙用</b>			
			Unit : mm
規格	2級牙鑽孔徑 D <sub>1</sub>		標準徑
	Max.	Min.	
W 1/8 - 40	( 2.591 )	( 2.362 )	2.55
W 3/16 - 24	( 3.744 )	( 3.406 )	3.70
W 1/4 - 20	5.204	4.914	5.10
W 5/16 - 18	6.670	6.340	6.60
W 3/8 - 16	8.113	7.733	8.00
W 7/16 - 14	9.508	9.048	9.40
W 1/2 - 12	10.830	10.310	10.7
W 9/16 - 12	12.418	11.898	12.3
W 5/8 - 11	13.817	13.257	13.7
W 3/4 - 10	16.778	16.178	16.6
W 7/8 - 9	19.691	19.031	19.5
W 1 - 8	22.514	21.814	22.3

- ◆ D<sub>1</sub> : JIS 2級表示為內螺紋內徑。
- ◆ 英制螺紋因由JIS而被削除。