

盛上げタップ(タフレット)の下穴径表 Drill Hole for Forming Taps (TAFLET)

ユニファイねじの下穴径とタフレット精度番号

Hole sizes for Unified threads and tap limit of TAFLET

呼び Nominal size	2B級用 精度番号 Limit for Class 2B	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
No. 1-64 UNC	4	1.63	1.65	1.67	1.70
No. 2-56	4	1.93	1.95	1.98	2.00
No. 3-48	4	2.21	2.24	2.27	2.30
No. 4-40 UNC	5	2.49	2.52	2.56	2.59
No. 5-40	5	2.82	2.85	2.89	2.92
No. 6-32	5	3.05	3.10	3.14	3.19
No. 8-32 UNC	6	3.72	3.76	3.81	3.85
No.10-24	6	4.23	4.29	4.35	4.41
No.12-24	6	4.89	4.95	5.01	5.07
1/4-20 UNC	6	5.63	5.70	5.77	5.85
5/16-18	7	7.14	7.22	7.30	7.38
3/8-16	7	8.62	8.71	8.80	8.89
7/16-14 UNC	8	10.08	10.19	10.29	10.39
1/2-13	8	11.59	11.70	11.81	11.92
5/8-12	10	13.09	13.21	13.33	13.45
5/8-11 UNC	11	14.55	14.68	14.81	14.94
3/4-10	12	17.61	17.75	17.90	18.04

呼び Nominal size	2B級用 精度番号 Limit for Class 2B	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
No. 0-80 UNF	3	1.34	1.36	1.38	1.40
No. 1-72	4	1.65	1.67	1.69	1.71
No. 2-64	4	1.96	1.98	2.00	2.03
No. 3-56 UNF	4	2.26	2.28	2.31	2.34
No. 4-48	5	2.54	2.57	2.60	2.63
No. 5-44	5	2.85	2.88	2.91	2.95
No. 6-40 UNF	5	3.15	3.18	3.22	3.25
No. 8-36	6	3.77	3.81	3.85	3.89
No.10-32	6	4.38	4.42	4.47	4.51
No.12-28 UNF	6	4.97	5.02	5.07	5.13
1/4-28	6	5.84	5.89	5.94	5.99
5/16-24	7	7.34	7.40	7.46	7.52
3/8-24 UNF	7	8.92	8.98	9.04	9.10
7/16-20	8	10.39	10.46	10.54	10.61
1/2-20	8	11.98	12.05	12.12	12.20
5/8-18 UNF	9	13.49	13.57	13.65	13.73
5/8-18	9	15.06	15.14	15.22	15.30
3/4-16	10	18.15	18.24	18.33	18.42
7/8-14	11	21.20	21.30	21.40	21.50

ミシンねじの下穴径とタフレット精度番号

Hole sizes for sewing machine threads and tap limit of TAFLET

呼び Nominal size	ピッチ pitch	2級用 精度番号 Limit for Class 2	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)				
			100%	90%	80%	70%	
SM 3/32	56	4	-	2.10	2.13	2.17	
SM 1/8	48	5	-	2.85	2.89	2.92	
	44	5	-	2.82	2.86	2.90	
	40	5	-	2.79	2.83	2.87	
SM 5/64	40	5	-	3.18	3.23	3.27	
SM 1/64	40	6	-	3.98	4.02	4.06	
	32	6	-	3.88	3.93	3.99	
SM 3/16	40	6	-	4.37	4.42	4.46	
	32	6	-	4.28	4.33	4.38	
	28	6	-	4.21	4.27	4.33	
	24	6	-	4.11	4.19	4.26	
SM 19/64	32	6	-	4.67	4.73	4.78	
SM 7/32	32	6	-	5.07	5.12	5.18	
SM 15/64	28	6	-	5.40	5.46	5.52	
SM 1/4	40	6	-	5.96	6.00	6.05	
	28	6	-	5.79	5.86	5.92	
	24	6	-	5.70	5.77	5.85	
	20	7	-	6.59	6.65	6.71	
SM 5/32	20	7	-	6.37	6.45	6.54	
	SM 1/16	28	7	-	7.38	7.44	7.51
		24	7	-	7.29	7.36	7.43
SM 11/32	18	7	-	7.07	7.17	7.27	
	SM 3/8	28	7	-	8.18	8.24	8.30
		28	7	-	8.97	9.03	9.09
SM 7/16	18	8	-	8.66	8.75	8.85	
	28	8	-	10.56	10.62	10.68	
SM 1/2	16	8	-	10.14	10.25	10.36	
	28	8	-	12.14	12.21	12.27	
	20	8	-	11.92	12.01	12.10	
SM 9/16	12	9	-	11.40	11.55	11.69	
	20	9	-	13.51	13.60	13.68	

[注]

1. 下穴径は試し加工の上決めてください。この表の寸法は参考寸法です。
2. 精度番号はめねじ公差の80%を目標に決めてあります。

Note:

1. Determine hole diameter by tapping test. The dimensions in this table are for reference only.
2. Tap limit is determined with 80% of the tolerance at the internal thread as an aim.

TECHNICAL DATA & STANDARDS
技術解説・各種資料

盛上げタップ(タフレット)の下穴径表
Drill Hole for Forming Taps (TAFLET)

盛上げタップ(タフレット)の下穴径表

Drill Hole for Forming Taps (TAFLET)

ワイトねじの下穴径とタフレット精度番号

Hole sizes for Whitworth threads and tap limit of TAFLET

呼 び Nominal size	2級用 精度番号 Limit for Class 2	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
W 1/16 - 60	4	-	1.35	1.38	1.40
3/32 - 48	4	-	2.09	2.12	2.15
1/8 - 40	5	-	2.82	2.86	2.90
W 5/32 - 32	6	-	3.53	3.58	3.62
3/16 - 24	6	-	4.17	4.24	4.30
7/32 - 24	6	-	4.97	5.03	5.10
W 1/4 - 20	6	-	5.64	5.72	5.80
5/16 - 18	7	-	7.15	7.24	7.33
3/8 - 16	8	-	8.64	8.74	8.84
W 7/16 - 14	8	-	10.10	10.21	10.33
1/2 - 12	9	-	11.52	11.65	11.78
9/16 - 12	9	-	13.11	13.24	13.37
W 5/8 - 11	9	-	14.59	14.73	14.87
3/4 - 10	9	-	17.63	17.79	17.95

管用平行ねじの下穴径とタフレット精度番号

Hole sizes for parallel pipe taps and tap limit of TAFLET

呼 び Nominal size	A級用 精度番号 Limit for Class A	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
G(PF) 1/8 - 28	6	9.17	9.22	9.28	9.33
1/4 - 19	8	12.33	12.41	12.49	12.58
3/8 - 19	8	15.83	15.92	16.00	16.08
1/2 - 19	9	19.83	19.94	20.06	20.17

[注]

1. 下穴径は試し加工の上決めてください。この表の寸法は参考寸法です。
2. 精度番号はめねじ公差の80%を目標に決めてあります。

Note:

1. Determine hole diameter by tapping test. The dimensions in this table are for reference only.
2. Tap limit is determined with 80% of the tolerance at the internal thread as an aim.