



IT擠壓絲攻系列

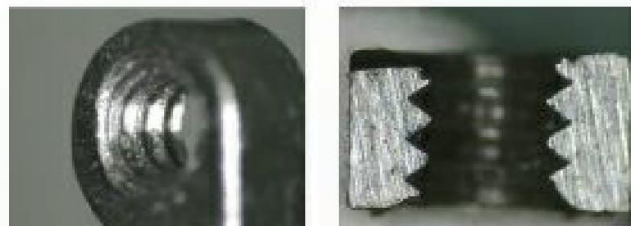
IT FORMING TAPS SERIES

無切屑！螺紋順暢！
輕鬆達成高精度螺紋
No Chips! Smooth Thread Curve!
Easy to produce High Accuracy Thread



特點

- A. 被切削材廣泛，從鈦合金、不銹鋼、炭素鋼、合金鋼、一般構造用鋼到非鐵系合金均適用。
- B. 攻牙時不產生切屑，平滑曲線之螺牙造形，可使加工面更精細及獲得正確之螺紋精度。
- C. 表面以多層膜處理，有極佳的耐磨性及反熔著性。
- D. 藉由精密儀器來測量，有效控制精度，生產品質高且穩定的絲攻。



M1 x 0.25 SR4-P 攻牙後之牙形



規格 Size	精度 SR	倒牙 LC	全長 L1	牙長 L2	柄徑 ds
M 1 x 0.25	4 5	1C、B、P	31	4	3.0
M 1.2 x 0.25	4 5	1C、B、P	31	4.5	3.0
M 1.4 x 0.3	4 5	1C、B、P	34	5.5	3.0
M 1.6 x 0.35	4 5	1C、B、P	36	7	3.0
M 1.7 x 0.35	4 5	1C、B、P	36	8	3.0
M 2 x 0.4	4 5 6 7	1C、B、P	40	11	3.0

FEATURES

- A. The IT forming taps are widely applied for various materials, such as titanium alloy, stainless steels, carbon steels, alloy steels, general structural steels and non-ferrous metals.
- B. No chips generated during tapping. The smooth curve design of thread structure create finger surface and increased accuracy of thread.
- C. Multi-layers surface treatment makes IT forming taps excellent in wear-resistance and anti-welding.
- D. Sophisticated inspection instruments are employed for controlling tap accuracy, quality and consistency.

1. 精度欄中 是2級或6H孔推薦使用精度
2. 使用同樣精度之絲攻所加工後的母螺紋精度，會依被切削材的種類不同而有所差異
3. 倒牙P：4牙，適用於通孔。倒牙B：2牙，適用於盲孔。倒牙1C：1牙，適用於盲孔。
4. 倒牙部可依實際需求及下孔徑進行設計生產。
The recommended tap limit in the blue column corresponds to JIS class 2 or ISO 6H internal thread standards.
The limit of female thread will be different depends on the materials of workpieces.
Chamfer P: 4 threads, for through holes.
Chamfer B: 2 threads, for blind holes. Chamfer 1C: 1 thread, for blind holes.
The chamfer can be designed specially depends on using demand and drill hole sizes.

螺帽絲攻系列 NUT TAPS SERIES



規格 M2~M45
SIZE M2-M45

特點

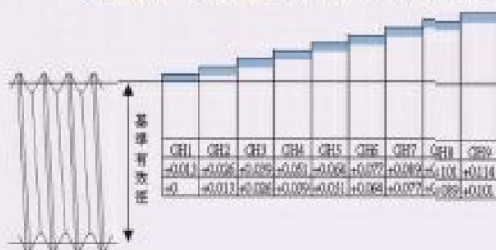
- A. 螺帽絲攻主要為螺帽之攻牙加工用，對螺帽之加工特性、精度及壽命要求等均予個別設計製作。
- B. 主要分：黑鐵專用螺帽絲攻、白鐵專用螺帽絲攻。
- C. 專攻於四角、六角、法蘭等標準螺帽、尼龍螺帽、圓螺帽、薄螺帽、加長型螺帽暨特殊螺帽等加工用。

FEATURES

- A. Nut taps are designed for thread machining of nuts. They are carefully designed to enhance nut machining characteristics, accuracy and service life.
- B. Choice of nut taps: steel machining and stainless steel machining nut taps.
- C. Especially ideal for standard nuts including square, hexagonal and flanged nuts. Also ideal for nylon, round, thin, long and special nuts.

- 製造規格：M2~M45
- 分成黑鐵用及白鐵用螺帽絲攻
黑鐵用螺帽絲攻 牙數：26T
倒牙數：19T
白鐵用螺帽絲攻 牙數：30T
倒牙數：22T
- 備有符合2級或6H孔使用精度。加大精度，請另詢
- Size：M2~M45
- Nut tap applications are divided into normal steel and stainless steel.
Thread number for normal steel：26T
Chamfer：19T
Thread number for stainless steel：30T
Chamfer：22T
- Choice of tap limits that meet JIS class2 and ISO 6H internal thread standards. Contact us when higher limit is required.

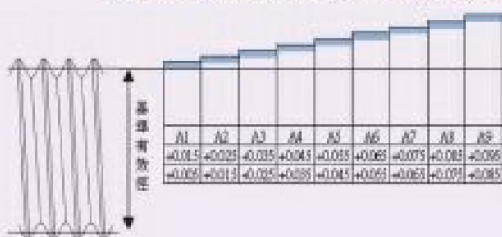
黑鐵用 - GH精度 For Normal Steel - "GH" Accuracy



上限值：0.0127*n
下限值：上限值-0.0127
單位：mm(n=GH番號)

Upper limit: 0.0127*n
Lower limit: upper limit - 0.01
Unit: mm (n = GH number)

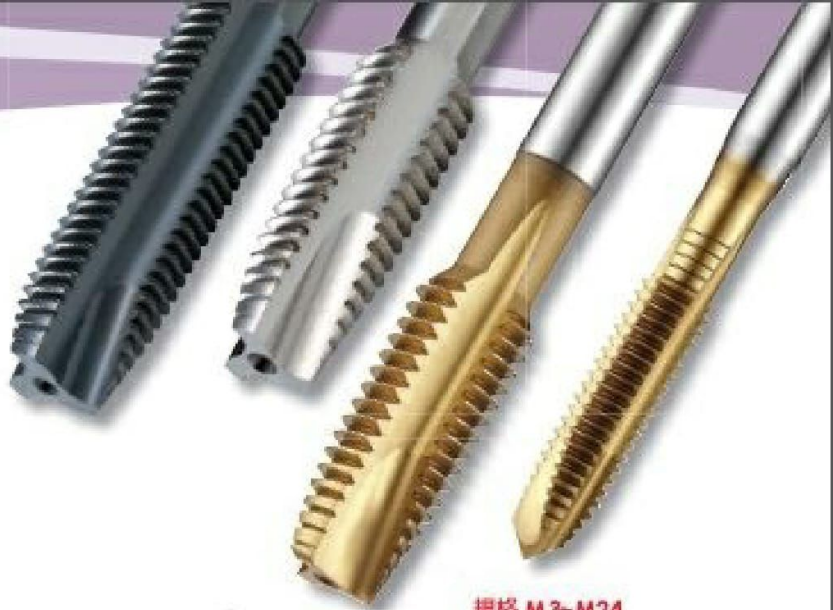
白鐵用 - A精度 For Stainless Steel - "A" Accuracy



上限值：0.01*n+0.005
下限值：上限值-0.01
單位：mm(n=A番號)

Upper limit: 0.01*n + 0.005
Lower limit: upper limit - 0.01
Unit: mm (n = A number)

先端絲攻系列 SPIRAL POINT TAPS



規格 M3~M24
SIZE M3~M24

■ 特點

- A. 先端絲攻因前端切削部採用最理想之溝形設計，不但強度足。且刃口鋒利，使用於通孔之攻牙作業時，針對碳鋼、合金鋼及非鐵金屬等被削材，切削屑會為捲狀連續形且確實從前方排出，因排屑容易，能使絲攻扭力小精度穩定，讓絲攻有更好的耐久性，因而有更好的壽命。
- B. 使用高韌性及耐磨損性佳之高鈮高速鋼材質。
- C. 倒牙長度為 5 牙，牙部精度採用 SP 精度，相當於 JIS 2 級之規格品及超大精度之成品。

■ FEATURES

- A. The front cutting portion of the spiral point tap is designed with superior flutes which features great strength and sharp edge. When performing through-hole tapping on carbon steels, alloy steels and non-ferrous metals, curled chips will continuously exhaust from the front end. With easy chip evacuation, the tap requires less torque while featuring high accuracy and stability. Another benefits are better durability and longer service life.
- B. The taps are manufactured from high speed steel with high vanadium content for maximum durability as well as maximum wear-resistance.
- C. Chamfer length is 5 threads. Thread accuracy complies with SP accuracy, that is equal to JIS class 2 products and extra high accuracy products.

螺旋絲攻

先端絲攻



倒牙數
先端絲攻：5牙
螺旋絲攻：2.5牙

螺旋絲攻系列 SPIRAL FLUTE TAPS



規格 M3~M24
SIZE M3~M24

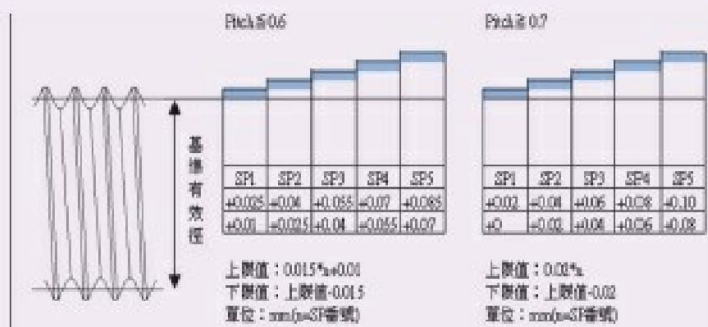
■ 特點

- A. 螺旋絲攻針對盲孔之攻牙作業，溝槽之螺旋角，形狀經過特殊設計，最適合的螺旋角能使切削屑安定的從孔內向外順利排出，而溝槽形狀能使切削屑變得細小而捲曲，針對碳鋼、合金鋼及非鐵金屬等被削材，具有優異之耐久性且能獲得良好的精度，因而有更佳之壽命。
- B. 使用高韌性及耐磨損性能之高鈮高速鋼材質。
- C. 盲孔用之倒牙長度為 2.5 牙，牙部精度採用 SP 精度，相當於 JIS 2 級之規格品及超大精度之成品。

■ FEATURES

- A. To suit the blind hole tapping operations, the helical angle and shape of flute on a spiral flute tap have been specially designed. The optimal helical angle design allows chips to be smoothly exhausted from the hole. The flute shape will enable chips to become fine and curled. For tapping on workpieces, such as carbon steels, alloy steels and non-ferrous metals, the series of taps features outstanding durability, high accuracy and longer service life.
- B. The taps are manufactured from high speed steel with high vanadium content for maximum durability as well as maximum wear-resistance.
- C. Chamfer length for blind hole is 2.5 threads. Thread accuracy complies with SP accuracy that is equal to JIS class 2 products and extra high accuracy products.

切削絲攻 – SP精度 For Spial Taps - "SP" Accuracy



擠壓絲攻系列 FORMING TAPS SERIES

螺紋強度提升30%，耐力佳，扭力大

Thread Strength 30%  UP,
Increased Durability And Torque.

- 製造規格：M0.5~M36
- 倒牙部份備有B、P，另可依照需求接受訂製
P：通孔用 倒牙4牙 B：盲孔用 倒牙2牙
- 備有符合2級或6H孔使用精度。加大精度，請另詢
- 擠壓絲攻精度(SR)計算方式
上限值： $0.0127 * n$ 下限值：上限值-0.0127
- 攻牙時無切屑產生
- 內螺紋之加工面為壓造面，外觀光滑美麗
- 材料纖維連續沒切斷，螺紋強度約增加30%精度安定
- 因心部徑大，故耐力、扭力強度大，絲攻壽命較長不易折斷
- Size: M0.5~M36
- There are Band P types of chamfer to select and custom design is also available.
P: For through hole. Chamfer: 4 threads.
B: For blind hole. Chamfer: 2 threads.
- Choice of tap limits that meet JIS class2 and ISO 6H internal thread standards. Contact us when higher limit is required.
- Calculation Formula for forming tap limit:
Upper limit: $0.0127 * n$
Lower limit: upper limit-0.0127
Unit:mm(n=SR number)

