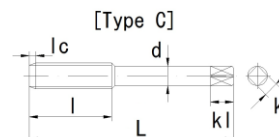
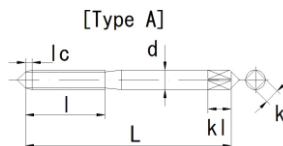


ミリねじ J形スパイラルタップ JIS Spiral Fluted Tap (Metric)



- ①食付き長さ：2.5山 (Chamfer Length 2.5p)
 ②溝形状：35° 右ねじ用 (Type of flute: 35° right spiral flute)
 ③材質：HSSE (Material) ④表面処理：ホモまたは無処理 (Surface: OX or Bright)

1. 止まり穴用。(For Blind Holes)
 2. 切りくずが、コイルのようにカールして排出される被削材に適します。(Suitable for the materials where chips come out continuously in coil shape)

表2 MJ SFT

Table 2

*F：溝数。(Number of flutes)／HL：HL精度。(Hayasaka original thread limit)

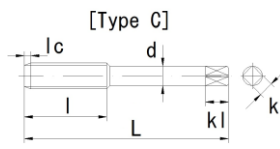
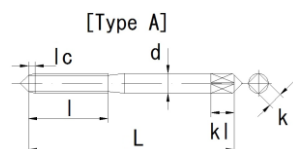
(Unit: mm)

SIZE		OX	Bright	L	l	d	K	kl	Type	F	HL
Dia	Pitch	CODE	CODE								
M2	× 0.4	32456	01348	40	15	3.0	2.5	5	A	2	1
M2.3	× 0.4	32457	01349	42	15	3.0	2.5	5	A	2	1
M2.5	× 0.45	32458	01350	44	16	3.0	2.5	5	A	2	1
M2.6	× 0.45	32459	01351	44	16	3.0	2.5	5	A	2	1
M3	× 0.5	33126	01352	46	18	4.0	3.2	6	A	3	2
M3	× 0.6	33127	01353	46	18	4.0	3.2	6	A	3	1
M3.5	× 0.6	33128	01354	48	18	4.0	3.2	6	A	3	2
M4	× 0.7	32476	01356	52	20	5.0	4.0	7	A	3	2
M4	× 0.75	33039	01357	52	20	5.0	4.0	7	A	3	2
M4.5	× 0.75	33040	01358	55	20	5.0	4.0	7	A	3	2
M5	× 0.8	32384	01360	60	22	5.5	4.5	7	A	3	2
M5	× 0.9	33041	01361	60	22	5.5	4.5	7	A	3	2
M5.5	× 0.9	33042	01363	60	22	5.5	4.5	7	A	3	2
M5.5	× 0.75	33043	01362	60	22	5.5	4.5	7	A	3	2
M6	× 1	33134	01365	62	24	6.0	4.5	7	A	3	2
M6	× 0.75	33044	01364	62	20	6.0	4.5	7	A	3	2
M7	× 1	32477	01367	65	26	6.2	5.0	8	C	3	2
M7	× 0.75	33008	01366	62	20	6.2	5.0	8	C	3	2
M8	× 1.25	32382	01370	70	30	6.2	5.0	8	C	3	2
M8	× 1	32479	01369	70	30	6.2	5.0	8	C	3	2
M8	× 0.75	32478	01368	62	20	6.2	5.0	8	C	3	2
M9	× 1.25	32480	01373	72	30	7.0	5.5	8	C	3	2
M9	× 1	33045	01372	70	30	7.0	5.5	8	C	3	2
M9	× 0.75	33009	01371	62	20	7.0	5.5	8	C	3	2
M10	× 1.5	32381	01377	75	32	7.0	5.5	8	C	3	2
M10	× 1.25	32461	01376	75	32	7.0	5.5	8	C	3	2
M10	× 1	32460	01375	70	30	7.0	5.5	8	C	3	2
M10	× 0.75	32584	01374	62	20	7.0	5.5	8	C	3	2
M11	× 1.5	33010	01382	80	38	8.0	6.0	9	C	3	2
M11	× 1.25	33011	01381	80	38	8.0	6.0	9	C	3	2
M11	× 1	33012	01380	70	30	8.0	6.0	9	C	3	2
M11	× 0.75	33013	01379	62	20	8.0	6.0	9	C	3	2
M12	× 1.75	32465	01388	82	38	8.5	6.5	9	C	3	2
M12	× 1.5	32464	01387	82	38	8.5	6.5	9	C	3	2
M12	× 1.25	32463	01386	80	38	8.5	6.5	9	C	3	2
M12	× 1	33046	01385	70	30	8.5	6.5	9	C	3	2
M12	× 0.75	33014	01384	70	30	8.5	6.5	9	C	3	2
M12	× 0.5	33015	01383	55	15	8.5	6.5	9	C	3	2
M13	× 1.75	33016	01391	88	42	9.5	7.0	10	C	3	2
M13	× 1.5	33017	01390	85	42	9.5	7.0	10	C	3	2
M13	× 1	32466	01389	70	30	9.5	7.0	10	C	3	2
M14	× 2	32467	01397	88	42	10.5	8.0	11	C	3	2
M14	× 1.5	33018	01396	88	42	10.5	8.0	11	C	3	2
M14	× 1.25	33019	01395	88	38	10.5	8.0	11	C	3	2
M14	× 1	33020	01394	70	30	10.5	8.0	11	C	3	2
M14	× 0.75	33021	01393	70	30	10.5	8.0	11	C	3	2
M14	× 0.5	33022	01392	58	15	10.5	8.0	11	C	3	2
M15	× 2	33023	01400	90	42	10.5	8.0	11	C	3	2
M15	× 1.5	33024	01399	90	42	10.5	8.0	11	C	3	2
M15	× 1	33025	01398	70	30	10.5	8.0	11	C	3	2

SIZE		OX	Bright	L	l	d	K	Kl	Type	F	HL
Dia	Pitch	CODE	CODE								
M16	× 2	32469	01406	95	45	12.5	10.0	13	C	3	2
M16	× 1.5	32468	01405	95	45	12.5	10.0	13	C	3	2
M16	× 1.25	33026	01404	95	45	12.5	10.0	13	C	3	2
M16	× 1	33027	01403	75	35	12.5	10.0	13	C	3	2
M16	× 0.75	33028	01402	75	35	12.5	10.0	13	C	3	2
M16	× 0.5	33029	01401	60	15	12.5	10.0	13	C	3	2
M18	× 2.5	32481	01410	100	48	14.0	11.0	14	C	4	3
M18	× 2	33031	01409	95	45	14.0	11.0	14	C	4	3
M18	× 1.5	33032	01408	95	45	14.0	11.0	14	C	4	2
M18	× 1	33033	01407	80	30	14.0	11.0	14	C	4	2
M19	× 2.5	33034	01414	105	50	14.0	11.0	14	C	4	3
M19	× 2	33035	01413	95	45	14.0	11.0	14	C	4	2
M19	× 1.5	33036	01412	95	45	14.0	11.0	14	C	4	2
M19	× 1	33048	01411	80	30	14.0	11.0	14	C	4	2
M20	× 2.5	32482	01418	105	50	15.0	12.0	15	D	4	3
M20	× 2	33049	01417	95	45	15.0	12.0	15	C	4	3
M20	× 1.5	33050	01416	95	45	15.0	12.0	15	C	4	2
M20	× 1	33051	01415	80	30	15.0	12.0	15	C	4	2
M22	× 2.5	33140	01422	115	55	17.0	13.0	16	C	4	3
M22	× 2	33053	01421	95	45	17.0	13.0	16	C	4	3
M22	× 1.5	33054	01420	95	45	17.0	13.0	16	C	4	2
M22	× 1	33055	01419	85	30	17.0	13.0	16	C	4	2
M24	× 3	33144	01427	120	58	19.0	15.0	18	C	4	3
M24	× 2	33056	01425	95	45	19.0	15.0	18	C	4	3
M24	× 1.5	33057	01424	95	45	19.0	15.0	18	C	4	2
M24	× 1	33058	01423	90	30	19.0	15.0	18	C	4	2
M25	× 3	33059	00084	130	62	19.0	15.0	18	C	4	3
M25	× 2	33060	00083	95	45	19.0	15.0	18	C	4	3
M25	× 1.5	33061	00082	95	45	19.0	15.0	18	C	4	2
M25	× 1	33062	00081	95	30	19.0	15.0	18	C	4	2
M26	× 3	33063	00088	130	62	20.0	15.0	18	C	4	3
M26	× 2	33064	00087	95	45	20.0	15.0	18	C	4	3
M26	× 1.5	33065	00086	95	45	20.0	15.0	18	C	4	2
M26	× 1	33066	00085	95	30	20.0	15.0	18	C	4	2
M27	× 3	32441	00092	130	62	20.0	15.0	18	D	4	3
M27	× 2	33067	00091	95	45	20.0	15.0	18	C	4	3
M27	× 1.5	32438	00090	95	45	20.0	15.0	18	C	4	2
M27	× 1	33068	00089	95	30	20.0	15.0	18	C	4	2
M28	3	33069	00096	135	65	21.0	17.0	20	C	4	3
M28	2	33070	00095	105	45	21.0	17.0	20	C	4	3
M28	1.5	33071	00094	105	45	21.0	17.0	20	C	4	2
M28	1	33072	00093	105	30	21.0	17.0	20	C	4	2
M30	× 3.5	33164	00101	135	65	23.0	17.0	20	C	4	3
M30	× 3	33074	00100	135	65	23.0	17.0	20	C	4	3
M30	× 2.5	33075	32629	130	62	23.0	17.0	20	C	4	JIS2
M30	× 2	33076	00099	105	45	23.0	17.0	20	C	4	3
M30	× 1.5	33077	00098	105	45	23.0	17.0	20	C	4	2
M30	× 1	33078	00097	105	30	23.0	17.0	20	C	4	2
M32	× 3	33079	00105	145	70	24.0	19.0	22	C	4	JIS2
M32	× 2.5	33080	32630	130	62	24.0	19.0	22	C	4	JIS2
M32	× 2	32698	00104	105	45	24.0	19.0	22	C	4	JIS2
M32	× 1.5	33081	00103	105	45	24.0	19.0	22	C	4	JIS2
M32	× 1	33082	00102	105	30	24.0	19.0	22	C	4	JIS2
M33	× 3.5	33175	00110	145	70	25.0	19.0	22	C	4	JIS2
M33	× 3	33084	00109	145	70	25.0	19.0	22	C	4	JIS2
M33	× 2	33085	00108	110	45	25.0	19.0	22	C	4	JIS2
M33	× 1.5	33086	00107	110	45	25.0	19.0	22	C	4	JIS2
M33	× 1	33087	00106	110	30	25.0	19.0	22	C	4	JIS2
M34	× 2	33088	00112	110	45	26.0	21.0	24	C	4	JIS2
M34	× 1.5	33089	00111	110	45	26.0	21.0	24	C	4	JIS2
M35	× 2	33090	00114	110	45	26.0	21.0	24	C	4	JIS2
M35	× 1.5	33091	00113	110	45	26.0	21.0	24	C	4	JIS2
M36	× 4	33184	00119	155	75	28.0	21.0	24	C	4	JIS2
M36	× 3	33093	00118	155	75	28.0	21.0	24	C	4	JIS2
M36	× 2	33094	00117	110	45	28.0	21.0	24	C	4	JIS2
M36	× 1.5	33095	00116	110	45	28.0	21.0	24	C	4	JIS2
M36	× 1	33096	00115	110	30	28.0	21.0	24	C	4	JIS2

SIZE			OX	Bright	L	l	d	K	Kl	Type	F	HL
Dia		Pitch	CODE	CODE								
M37	×	1.5	33097	00121	115	45	28.0	21.0	24	C	4	JIS2
M37	×	1	33098	00120	115	30	28.0	21.0	24	C	4	JIS2
M39	×	4	33191	00126	165	80	30.0	23.0	26	C	4	JIS2
M39	×	3	33100	00125	165	80	30.0	23.0	26	C	4	JIS2
M39	×	2	33101	00124	115	45	30.0	23.0	26	C	4	JIS2
M39	×	1.5	33102	00123	115	45	30.0	23.0	26	C	4	JIS2
M39	×	1	33103	00122	115	30	30.0	23.0	26	C	4	JIS2
M40	×	3	33104	00130	165	80	30.0	23.0	26	C	4	JIS2
M40	×	2	33105	00129	115	45	30.0	23.0	26	C	4	JIS2
M40	×	1.5	33106	00128	115	45	30.0	23.0	26	C	4	JIS2
M40	×	1	33107	00127	115	30	30.0	23.0	26	C	4	JIS2
M42	×	4.5	33200	00136	175	85	32.0	26.0	30	C	4	JIS2
M42	×	4	33109	00135	175	80	32.0	26.0	30	C	4	JIS2
M42	×	3	33110	00134	175	80	32.0	26.0	30	C	4	JIS2
M42	×	2	33111	00133	120	45	32.0	26.0	30	C	4	JIS2
M42	×	1.5	33112	00132	120	45	32.0	26.0	30	C	4	JIS2
M42	×	1	33113	00131	120	30	32.0	26.0	30	C	4	JIS2
M45	×	4.5	33206	00142	180	85	35.0	26.0	30	C	4	JIS2
M45	×	4	33115	00141	180	80	35.0	26.0	30	C	4	JIS2
M45	×	3	33116	00140	180	80	35.0	26.0	30	C	4	JIS2
M45	×	2	33117	00139	120	45	35.0	26.0	30	C	4	JIS2
M45	×	1.5	33118	00138	120	45	35.0	26.0	30	C	4	JIS2
M45	×	1	33119	00137	120	30	35.0	26.0	30	C	4	JIS2
M46	×	1.5	33120	00143	125	45	35.0	26.0	30	C	4	JIS2
M48	×	5	33213	00149	185	90	38.0	29.0	32	C	4	JIS2
M48	×	4	33122	00148	180	80	38.0	29.0	32	C	4	JIS2
M48	×	3	33123	00147	180	80	38.0	29.0	32	C	4	JIS2
M48	×	2	33124	00146	125	45	38.0	29.0	32	C	4	JIS2
M48	×	1.5	33125	00145	125	45	38.0	29.0	32	C	4	JIS2

ウィットねじ スパイラルタップ Spiral Fluted Tap (Whitworth)



- ①食付き長さ：2.5山 (Chamfer Length 2.5p)
- ②溝形状：35° 右旋 1山 (Type of flute: 35° right spiral flute)
- ③材質：HSSE (Material)
- ④表面処理：ホモまたは無処理 (Surface: OX or Bright)

表9 W SFT

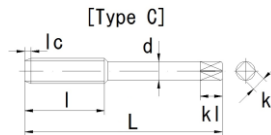
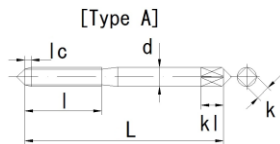
Table 9

*F：溝数。(Number of flutes)／JC：JIS規格。(JIS class of the thread limit)

(Unit: mm)

SIZE				OX	Bright	L	l	d	K	Kl	Type	F	JC
				CODE	CODE								
W	1/16	-	60	33314	03118	40	9.0	3.0	2.5	5.0	A		
	1/8	-	40	33315	03119	46	18.0	4.0	3.2	6.0	A	3	2
	5/32	-	32	33316	03120	52	20.0	5.0	4.0	7.0	A	3	2
	3/16	-	24	32383	03121	60	22.0	5.5	4.5	7.0	A	3	2
	7/32	-	24	33317	03122	60	22.0	5.5	4.5	7.0	A	3	2
	1/4	-	20	33318	03123	62	24.0	6.0	4.5	7.0	A	3	2
	5/16	-	18	32380	03124	70	30.0	6.1	5.0	8.0	C	3	2
	3/8	-	16	32484	03125	75	35.0	7.0	5.5	8.0	C	3	2
	7/16	-	14	33319	02702	80	38.0	8.0	6.0	9.0	C	3	2
	1/2	-	12	32449	02703	85	42.0	9.0	7.0	10.0	C	3	2
	9/16	-	12	33320	02704	90	42.0	10.5	8.0	11.0	C	3	2
	5/8	-	11	33321	02705	95	45.0	12.0	9.0	12.0	C	3	2
	3/4	-	10	33322	02706	105	50.0	14.0	11	14.0	C	4	2
	7/8	-	9	33323	02707	115	55.0	17.0	13	16.0	C	4	2
	1"	-	8	33324	02708	125	60.0	20.0	15	18.0	C	4	2
	1"1/8	-	7	32450	02709	135	65.0	22.0	17	20.0	C	4	2
	1"1/4	-	7	33325	02710	145	70.0	24.0	19	22.0	C	4	2
	1"3/8	-	6	33326	02711	155	75.0	26.0	21	24.0	C	4	2
	1"1/2	-	6	33327	02712	160	78.0	30.0	23	26.0	C	4	2
	1"5/8	-	5	33328	02713	170	82.0	32.0	26.0	30.0	C		
	1"3/4	-	5	33329	02714	175	85.0	35.0	26.0	30.0	C		
	1"7/8	-	4.1/2	33330	02715	185	90.0	38.0	29.0	32.0	C		
	2"	-	4.1/2	33331	02716	195	92.0	40.0	32.0	35.0	C		

ユニファイ並目ねじ スパイラルタップ Spiral Fluted Tap (Unified Coarse)



- ①食付き長さ：2.5山 (Chamfer Length 2.5p)
- ②溝形状：35° 右ねじ (Type of flute: 35° right spiral flute.)
- ③材質：HSSE (Material)
- ④表面処理：ホモまたは無処理 (Surface: OX or Bright)

表10 UNC SFT

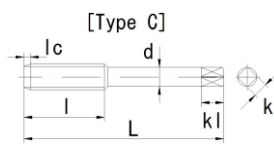
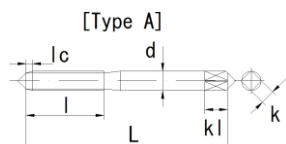
Table 10

*F：溝数。(Number of flutes)／JC：JIS規格。(JIS class of the thread limit)

(Unit: mm)

SIZE			OX	Bright	L	l	d	K	Kl	Type	F	JC
			CODE	CODE								
UNC	No.1	- 64	33332	03278	36	13	3.0	2.5	5.0	A		
	No.2	- 56	33333	03279	42	15	3.0	2.5	5.0	A	2	2
	No.3	- 48	33334	03280	44	16	3.0	2.5	5.0	A		
	No.4	- 40	33335	03281	44	16	3.0	2.5	5.0	A	3	2
	No.5	- 40	33336	03282	46	18	4.0	3.2	6.0	A	3	2
	No.6	- 32	33337	03283	48	18	4.0	3.2	6.0	A	3	2
	No.8	- 32	33338	03284	52	20	5.0	4.0	7.0	A	3	2
	No.10	- 24	33339	03285	60	22	5.5	4.5	7.0	A	3	2
	No.12	- 24	33340	03286	60	22	5.5	4.5	7.0	A	3	2
	1/4	- 20	33341	03288	62	24	6.0	4.5	7.0	A	3	2
	5/16	- 18	33342	03289	70	30	6.1	5.0	8.0	C	3	2
	3/8	- 16	33343	03290	75	35	7.0	5.5	8.0	C	3	2
	7/16	- 14	33344	02867	80	38	8.0	6	9.0	C	3	2
	1/2	- 13	32442	02868	85	42	9.0	7	10.0	C	3	2
	9/16	- 12	33345	02869	90	42	10.5	8	11.0	C	3	2
	5/8	- 11	33346	02870	95	45	12.0	9	12.0	C	3	2
	3/4	- 10	32445	02871	105	50	14.0	11	14.0	C	4	2
	7/8	- 9	32446	02872	115	55	17.0	13	16.0	C	4	2
	1"	- 8	33347	02873	125	60	20.0	15	18.0	C	4	2
	1"1/8	- 7	33348	02874	135	65	22.0	17	20.0	C		
	1"1/4	- 7	33349	02875	145	70	24.0	19	22.0	C		
	1"3/8	- 6	33350	02876	155	75	26.0	21	24.0	C		
	1"1/2	- 6	33351	02877	160	78	30.0	23	26.0	C		
	1"3/4	- 5	33352	02878	175	85	35.0	26	30.0	C		
	2"	- 4.1/2	33353	02879	195	92	40.0	32	35.0	C		

ユニファイ細目ねじ スパイラルタップ Spiral Fluted Tap (Unified Fine)



- ①食付き長さ：2.5山 (Chamfer Length 2.5p)
- ②溝形状：35° 右山 1山 (Type of flute: 35° right spiral flute)
- ③材質：HSSE (Material)
- ④表面処理：ホモまたは無処理 (Surface: OX or Bright)

表11 UNF SFT

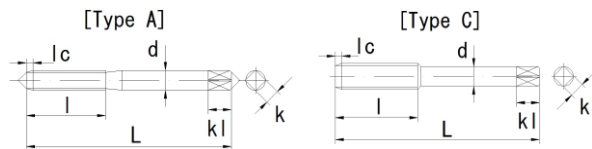
Table 11

*F：溝数。(Number of flutes)／JC：JIS規格。(JIS class of the thread limit)

(Unit: mm)

SIZE				OX	Bright	L	l	d	K	Kl	Type	F	JC
				CODE	CODE								
UNF	No.1	-	72	33354	03330	36	13	3.0	2.5	5.0	A		
	No.2	-	64	33355	03331	42	15	3.0	2.5	5.0	A	2	2
	No.3	-	56	33356	03332	44	16	3.0	2.5	5.0	A		
	No.4	-	48	33357	03333	44	16	3.0	2.5	5.0	A	3	2
	No.5	-	44	33358	03334	46	18	4.0	3.2	6.0	A	3	2
	No.6	-	40	33359	03335	48	18	4.0	3.2	6.0	A	3	2
	No.8	-	36	33360	03336	52	20	5.0	4.0	7.0	A	3	2
	No.10	-	32	33361	03337	60	22	5.5	4.5	7.0	A	3	2
	No.12	-	28	33362	03338	60	22	5.5	4.5	7.0	A	3	2
	1/4	-		33363	03340	62	24	6.0	4.5	7.0	A	3	2
	5/16	-	24	33364	03341	70	30	6.1	5.0	8.0	C	3	2
	3/8	-		32591	03342	75	35	7.0	5.5	8.0	C	3	2
	7/16	-	20	33366	02919	80	38	8.0	6	9.0	C	3	2
	1/2	-		32443	02920	85	42	9.0	7	10.0	C	3	2
	9/16	-	18	33367	02921	90	42	10.5	8	11.0	C	3	2
	5/8	-		33368	02922	95	45	12.0	9	12.0	C	3	2
	3/4	-	16	32444	02923	105	50	14.0	11	14.0	C	4	2
	7/8	-	14	33369	02924	115	55	17.0	13	16.0	C	4	2
	1"	-		33370	02925	125	60	20.0	15	18.0	C	4	2
	1"1/8	-		32447	02926	135	65	22.0	17	20.0	C		
	1"1/4	-		32448	02927	145	70	24.0	19	22.0	C		
	1"3/8	-	12	33371	02928	155	75	26.0	21	24.0	C		
	1"1/2	-		33372	02929	160	78	30.0	23	26.0	C		
	1"3/4	-		33373	32738	175	85	35.0	26	30.0	C		
	2"	-		33374	32740	195	92	40.0	32	35.0	C		

BS規格ウィットねじ スパイラルタップ Spiral Fluted Tap (British Standard Whitworth)



- ①食付き長さ：2.5山 (Chamfer Length 2.5p)
- ②溝形状：35° 右旋1/16 (Type of flute: 35° right spiral flute)
- ③材質：HSSE (Material)
- ④表面処理：ホモまたは無処理 (Surface: OX or Bright)

表12 BSW SFT

Table 12

*F：溝数。(Number of flutes)

(Unit: mm)

SIZE				OX	Bright	L	l	d	K	Kl	Type	F	Z
				CODE	CODE								
BSW	1/16	-	60	33375	03478						A	3	
	3/32	-	48	33376	03479						A		
	1/8	-	40	33377	03480	49	16.0	3.3	2.7	4.5	A	3	3
	5/32	-	32	32475	03481	54	19.0	4.0	3.1	6.5	A	3	3
	3/16	-	24	32472	03482	61	22.0	4.8	3.8	6.5	A	3	3
	7/32	-	24	33378	03483						A	3	3
	1/4	-	20	33379	03484	64	25.0	6.4	5.0	7.0	A	3	3
	5/16	-	18	32473	03485	70	28.0	8.0	6.1	10.3	C	4	3
	3/8	-	16	32474	03486	75	32.0	9.5	7.5	10.3	C	4	3
	7/16	-	14	33380	03063	80	36.5	8.2	6.1	10.5	C	4	3
	1/2	-	12	33381	03064	86	42.0	9.3	7.0	11.0	C	4	3
	9/16	-	12	33382	03065	91	42.0	10.9	8.2	12.7	C	4	3
	5/8	-	11	32439	03066	97	46.0	12.2	9.1	14.0	C	4	3
	3/4	-	10	32440	03067	108	51.0	15.0	11.2	17.5	C	4	3
	7/8	-	9	33384	03068	119	56.5	17.7	13.3	19.0	C	4	3
	1"	-	8	33385	03069	130	63.5	20.3	15.2	20.5	C	4	3
	1"1/8	-	7	33386	03070						C	4	
	1"1/4	-	7	33387	03071						C	4	
	1"3/8	-	6	33388	03072						C	4	
	1"1/2	-	6	33389	03073						C	4	
	1"5/8	-	5	33390	03074						C	4	
	1"3/4	-	5	33391	03075						C	4	
	1"7/8	-	4.1/2	33392	03076						C	4	
	2"	-	4.1/2	33393	03077						C	6	
	2"1/4	-	4	33394	03078						C		
	2"1/2	-	4	33395	03079						C		
	2"3/4	-	4	33396	03080						C		
	3"	-	3.1/2	33397	03081						C		