

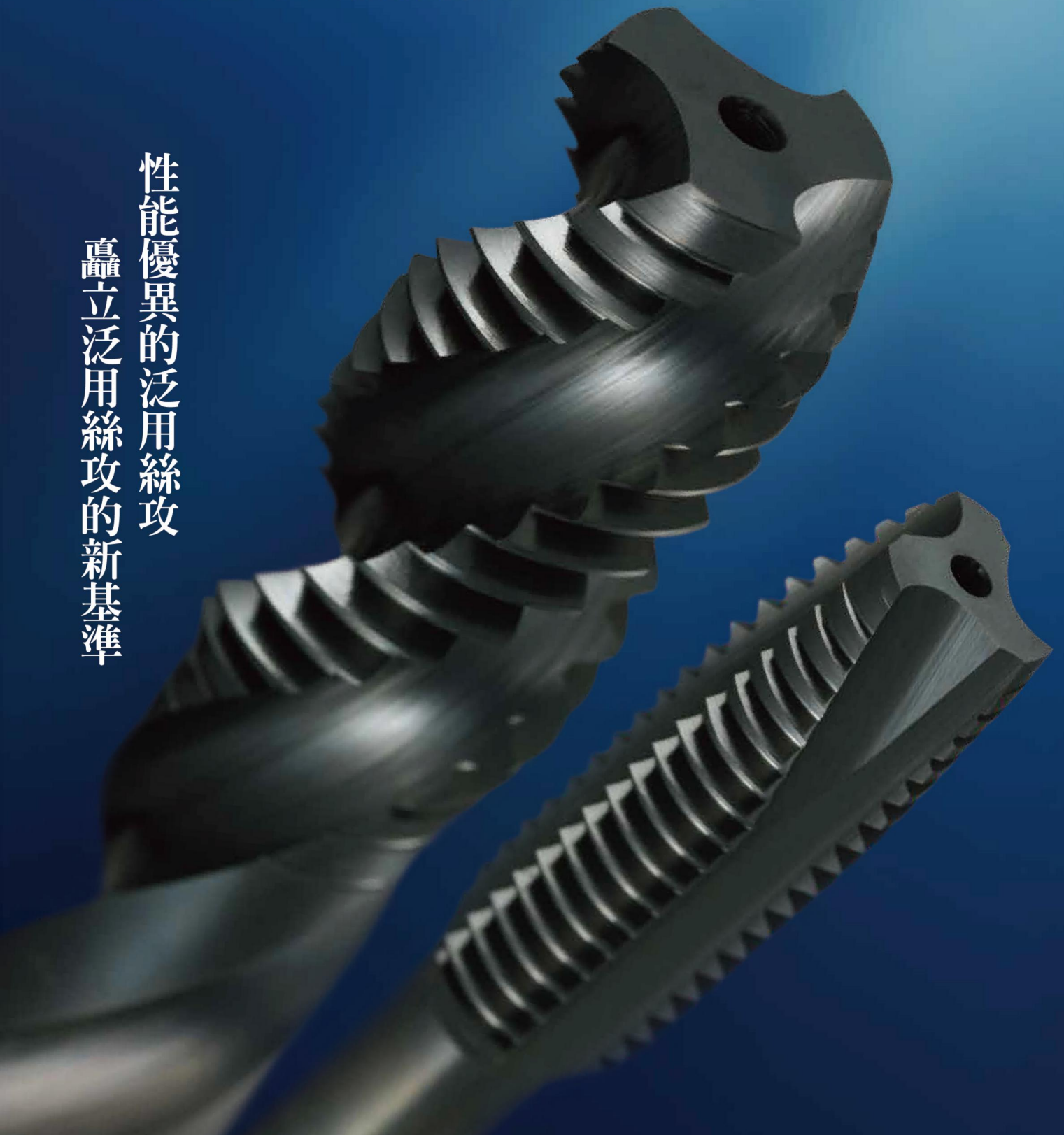
NACHI

ST SERIES

NEW

從原材料、熱處理、到加工製造 承襲我公司SG、Hyper Z絲攻的技術。
在泛用加工的領域中 實現卓越的穩定性及長壽命。

性能優異的泛用絲攻
矗立泛用絲攻的新基準



ST SERIES **NEW**

性能優異的泛用絲攻。 矗立泛用絲攻的新基準。

Acquire the good performance in spite of multipurpose Tap
This is new standard of multi tap

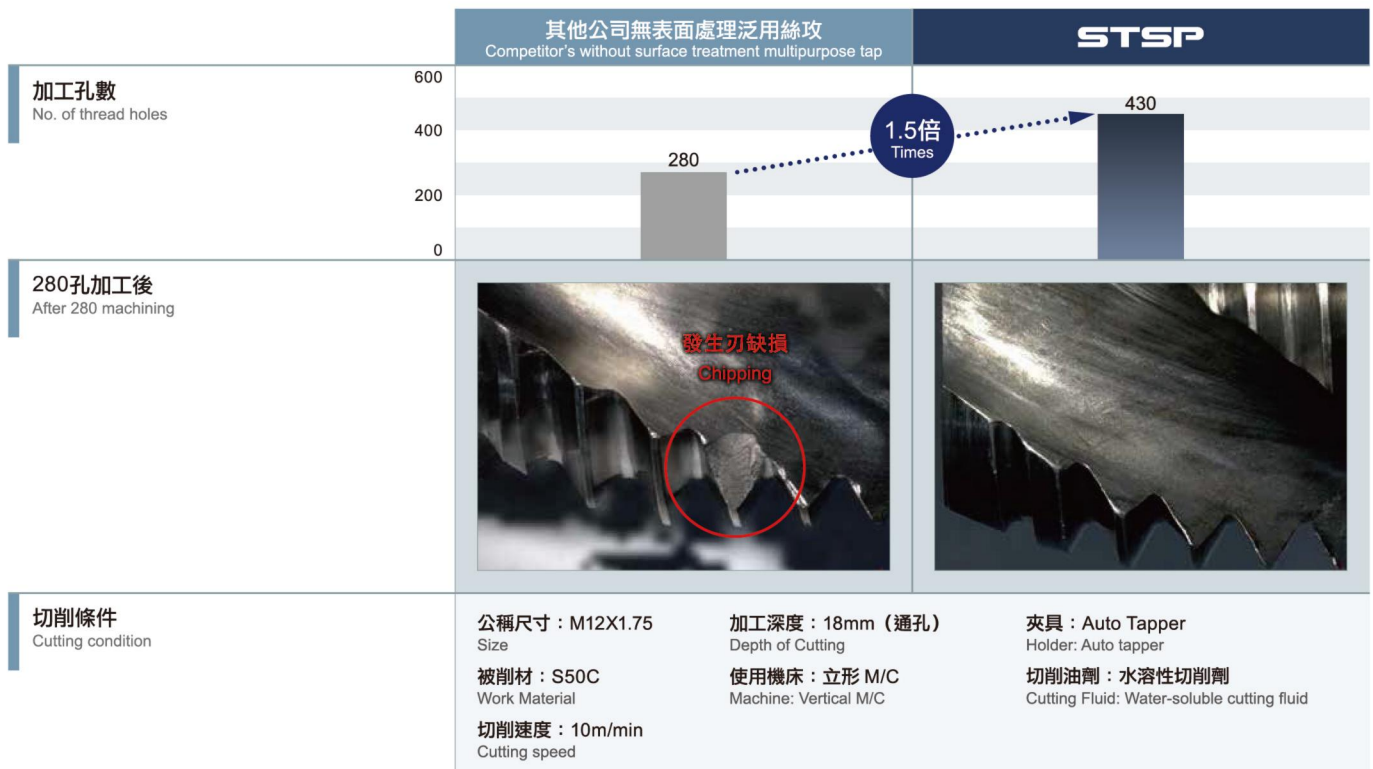
- 從原材料, 熱處理, 到加工製造 承襲我公司SG絲攻, Hyper Z絲攻系列的技術
- 重視泛用性的最合適化形狀設計
- 適用各種加工設備・夾具・被加工材料, 變化少的穩定加工
- 卓越的長壽命

- From materials to heat treatment and manufacturing, our SG tap, Hyper Z tap technology was inherited
- Optimized design for multipurpose usage
- Not influenced by equipment, stable tapping, less fluctuation of quality
- Long tool life



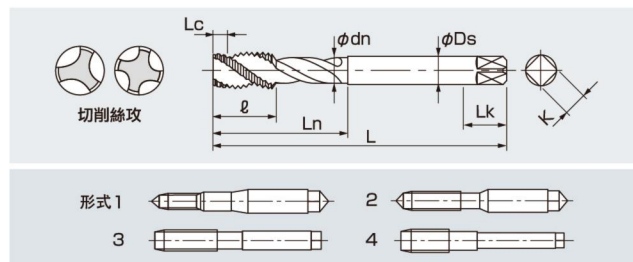
加工壽命長

Long tool life



ST 螺旋絲攻

ST Spiral Tap



LIST 6866 訂貨方法 Order STSP 商品型號 Code 單位 (Unit) : mm

商品型號 Code No.	公稱尺寸 Thread Size	等級 TAP Limit	咬合(P) Lc (P)	全長 L	螺牙長 ℓ	槽數 Flutes	柄徑 Ds	頸部長 Ln	頸徑 dn	形式 Type	庫存 Stock
2M0.4R	M2×0.4	REG P1	2.5	40	9.0	3	3.0	15	2.1*	1	●
2M0.4R+1		REG+1 P2									
2.5M0.45R	M2.5×0.45	REG P1	2.5	44	10.0	3	3.0	16	2.7*	1	●
2.5M0.45R+1		REG+1 P2									
2.6M0.45R	M2.6×0.45	REG P1	2.5	44	10.0	3	3.0	16	2.7*	1	●
2.6M0.45R+1		REG+1 P2									
3M0.5R	M3×0.5	REG P2	2.5	46	5.0	3	4.0	18	2.4	2	●
3M0.5R+1		REG+1 P3									
3.5M0.6R	M3.5×0.6	REG P2	2.5	48	6.0	3	4.0	18	2.8	2	●
3.5M0.6R+1		REG+1 P3									
4M0.7R	M4×0.7	REG P2	2.5	52	7.0	3	5.0	20	3.1	2	●
4M0.7R+1		REG+1 P3									
5M0.8R	M5×0.8	REG P2	2.5	60	8.0	3	5.5	22	4.0	2	●
5M0.8R+1		REG+1 P3									
6M1R	M6×1	REG P2	2.5	62	12.0	3	6.0	29	4.75	2	●
6M1R+1		REG+1 P3									
6M0.75R	M6×0.75	REG P2	2.5	62	9.2	3	6.0	29	5.05	2	●
6M0.75R+1		REG+1 P3									
7M1R	M7×1	REG P2	2.5	65	12.0	3	6.2	29	5.75	3	●
7M1R+1		REG+1 P3									
8M1.25R	M8×1.25	REG P3	2.5	70	15.4	3	6.2	33	6.55	4	●
8M1.25R+1		REG+1 P4									
8M1R	M8×1	REG P2	2.5	70	12.4	3	6.2	27	6.75	4	●
8M1R+1		REG+1 P3									
8M1R+2		REG+2 P4									
10M1.5R	M10×1.5	REG P3	2.5	75	18.9	3	7.0	37	8.25	4	●
10M1.5R+1		REG+1 P4									
10M1.25R	M10×1.25	REG P3	2.5	75	15.7	3	7.0	33	8.55	4	●
10M1.25R+1		REG+1 P4									
10M1R	M10×1	REG P2	2.5	75	12.4	3	7.0	27	8.75	4	●
10M1R+1		REG+1 P3									
10M1R+2		REG+2 P4									
12M1.75R	M12×1.75	REG P3	2.5	82	22.4	3	8.5	42	9.95	4	●
12M1.75R+1		REG+1 P4									
12M1.5R	M12×1.5	REG P3	2.5	82	20.9	3	8.5	40	10.25	4	●
12M1.5R+1		REG+1 P4									
12M1.25R	M12×1.25	REG P3	2.5	82	17.2	3	8.5	35	10.55	4	●
12M1.25R+1		REG+1 P4									
14M2R	M14×2	REG P2	2.5	88	25.9	3	10.5	46	11.65	4	●
14M2R+2		REG+2 P4									
14M1.5R	M14×1.5	REG P2	2.5	88	20.9	3	10.5	40	12.25	4	●
14M1.5R+2		REG+2 P4									
16M2R	M16×2	REG P2	2.5	95	25.9	3	12.5	49	13.65	4	●
16M2R+2		REG+2 P4									
16M1.5R	M16×1.5	REG P2	2.5	95	20.9	3	12.5	40	14.25	4	●
16M1.5R+2		REG+2 P4									
18M2.5R	M18×2.5	REG P3	2.5	100	32.6	4	14.0	55	15.15	4	●
18M2.5R+2		REG+2 P5									
18M1.5R	M18×1.5	REG P2	2.5	100	20.9	4	14.0	40	16.25	4	●
18M1.5R+2		REG+2 P4									
20M2.5R	M20×2.5	REG P3	2.5	105	32.6	4	15.0	55	17.15	4	●
20M2.5R+2		REG+2 P5									
20M1.5R	M20×1.5	REG P2	2.5	105	20.9	4	15.0	40	18.25	4	●
20M1.5R+2		REG+2 P4									
22M2.5R	M22×2.5	REG P3	2.5	115	32.6	4	17.0	55	19.15	4	●
22M2.5R+2		REG+2 P5									
22M1.5R	M22×1.5	REG P2	2.5	115	20.9	4	17.0	40	20.25	4	●
22M1.5R+2		REG+2 P4									
24M3R	M24×3	REG P3	2.5	120	38.8	4	19.0	63	20.65	4	●
24M3R+2		REG+2 P5									
24M1.5R	M24×1.5	REG P2	2.5	120	22.4	4	19.0	50	22.25	4	●
24M1.5R+2		REG+2 P4									

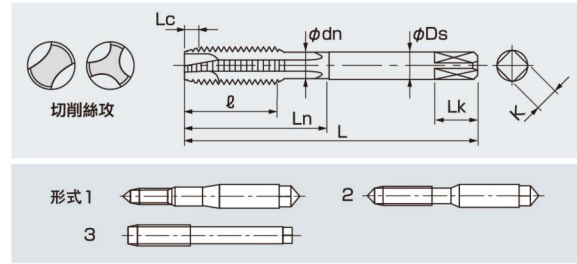
*: 表示公稱尺寸 < 頸徑。牙孔深度長過螺牙長時, 有折損的危險。● 型式1~2 為尖頭形狀

*: Thread Size < Neck diameter (dn) When depth of cutting a female thread is deep, if putting the screw length or more in length, there is a risk of breakage.

● Type 1~2 with External Centre

ST 先端絲攻

ST Point Tap



LIST 6868

訂貨方法 Order

STSP

商品型號 Code

單位 (Unit) : mm

商品型號 Code No.	公稱尺寸 Thread Size	等級 TAP Limit		咬合(P) Lc (P)	全長 L	螺牙長 ℓ	槽數 Flutes	柄徑 Ds	頸部長 Ln	頸徑 dn	形式 Type	庫存 Stock
2M0.4R	M2×0.4	REG	P1	5	40	9.0	2	3.0	15	2.1*	1	●
2M0.4R+1		REG+1	P2									
2.5M0.45R	M2.5×0.45	REG	P2	5	44	10.0	2	3.0	16	2.7*	1	●
2.5M0.45R+1		REG+1	P3									
2.6M0.45R	M2.6×0.45	REG	P2	5	44	10.0	2	3.0	16	2.7*	1	●
2.6M0.45R+1		REG+1	P3									
3M0.5R	M3×0.5	REG	P2	5	46	11.0	3	4.0	18	2.4	2	●
3M0.5R+1		REG+1	P3									
3.5M0.6R	M3.5×0.6	REG	P2	5	48	13.0	3	4.0	18	2.8	2	●
3.5M0.6R+1		REG+1	P3									
4M0.7R	M4×0.7	REG	P2	5	52	13.0	3	5.0	20	3.1	2	●
4M0.7R+1		REG+1	P3									
5M0.8R	M5×0.8	REG	P2	5	60	16.0	3	5.5	22	4.0	2	●
5M0.8R+1		REG+1	P3									
6M1R	M6×1	REG	P2	5	62	17.0	3	6.0	28	4.8	2	●
6M1R+1		REG+1	P3									
6M0.75R	M6×0.75	REG	P2	5	62	14.0	3	6.0	28	4.8	2	●
6M0.75R+1		REG+1	P3									
7M1R	M7×1	REG	P2	5	65	17.0	3	6.2	-	-	3	●
7M1R+1		REG+1	P3									
8M1.25R	M8×1.25	REG	P3	5	70	22.0	3	6.2	-	-	3	●
8M1.25R+1		REG+1	P4									
8M1R	M8×1	REG	P2	5	70	17.0	3	6.2	-	-	3	●
8M1R+1		REG+1	P3									
8M1R+2		REG+2	P4									
10M1.5R	M10×1.5	REG	P3	5	75	27.0	3	7.0	-	-	3	●
10M1.5R+1		REG+1	P4									
10M1.25R	M10×1.25	REG	P3	5	75	22.0	3	7.0	-	-	3	●
10M1.25R+1		REG+1	P4									
10M1R	M10×1	REG	P2	5	75	17.0	3	7.0	-	-	3	●
10M1R+1		REG+1	P3									
10M1R+2		REG+2	P4									
12M1.75R	M12×1.75	REG	P4	5	82	32.0	3	8.5	-	-	3	●
12M1.75R+1		REG+1	P5									
12M1.5R	M12×1.5	REG	P3	5	82	28.0	3	8.5	-	-	3	●
12M1.5R+1		REG+1	P4									
12M1.25R	M12×1.25	REG	P4	5	82	23.0	3	8.5	-	-	3	●
12M1.25R+1		REG+1	P5									
14M2R	M14×2	REG	P4	5	88	32.0	3	10.5	-	-	3	●
14M2R+1		REG+1	P5									
14M1.5R	M14×1.5	REG	P3	5	88	28.0	3	10.5	-	-	3	●
14M1.5R+1		REG+1	P4									
16M2R	M16×2	REG	P4	5	95	32.0	3	12.5	-	-	3	●
16M2R+1		REG+1	P5									
16M1.5R	M16×1.5	REG	P3	5	95	28.0	3	12.5	-	-	3	●
16M1.5R+1		REG+1	P4									
18M2.5R	M18×2.5	REG	P4	5	100	37.5	3	14.0	-	-	3	●
18M2.5R+1		REG+1	P5									
18M1.5R	M18×1.5	REG	P4	5	100	28.0	3	14.0	-	-	3	●
18M1.5R+1		REG+1	P5									
20M2.5R	M20×2.5	REG	P4	5	105	37.5	3	15.0	-	-	3	●
20M2.5R+1		REG+1	P5									
20M1.5R	M20×1.5	REG	P4	5	105	28.0	3	15.0	-	-	3	●
20M1.5R+1		REG+1	P5									
22M2.5R	M22×2.5	REG	P4	5	115	37.5	3	17.0	-	-	3	●
22M2.5R+1		REG+1	P5									
22M1.5R	M22×1.5	REG	P4	5	115	28.0	3	17.0	-	-	3	●
22M1.5R+1		REG+1	P5									
24M3R	M24×3	REG	P4	5	120	45.0	3	19.0	-	-	3	●
24M3R+1		REG+1	P5									
24M1.5R	M24×1.5	REG	P4	5	120	31.0	3	19.0	-	-	3	●
24M1.5R+1		REG+1	P5									

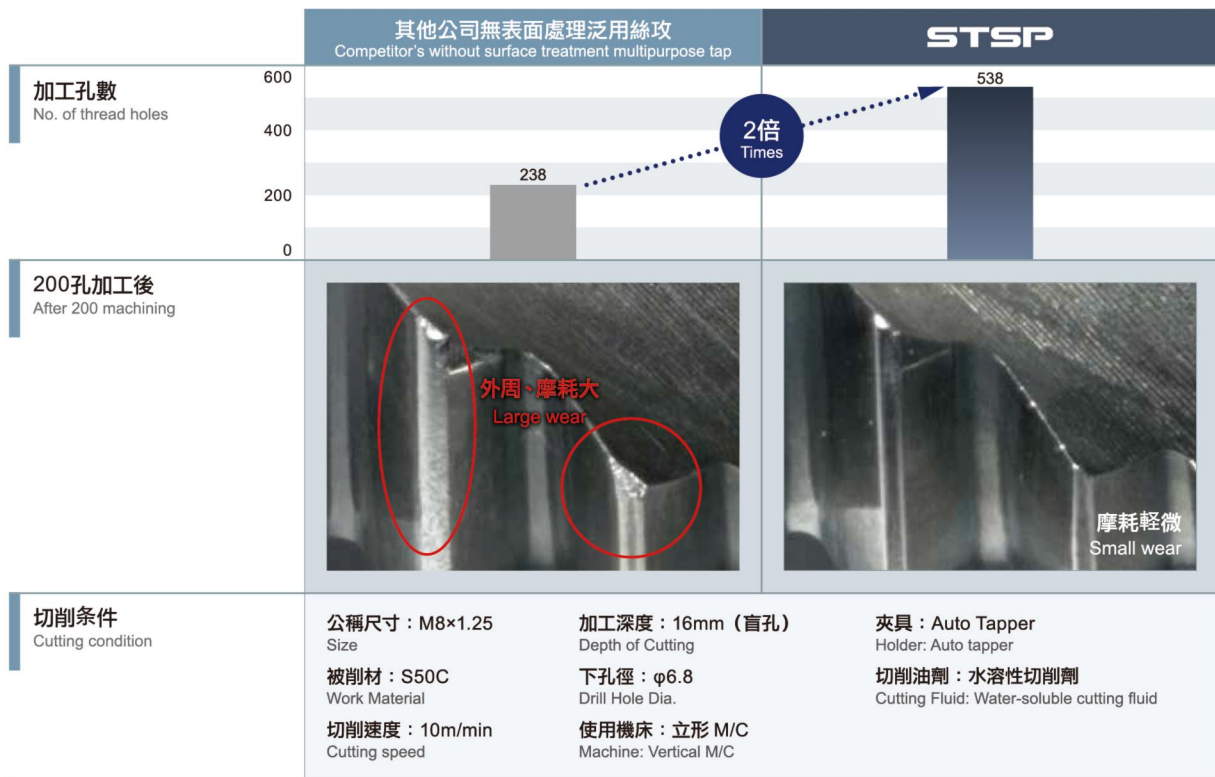
* : 表示公稱尺寸< 頸徑。牙孔深度長過螺牙長時,有折損的危險。●型式1~2 為尖頭形狀

* : Thread Size < Neck diameter (dn) When depth of cutting a female thread is deep, if putting the screw length or more in length, there is a risk of breakage.

● Type 1~2 with External Centre

與其他公司相比, 有超越2倍的加工壽命

It has twice the tool life compared with competitor's tap



超越其他公司的加工壽命, 實現加工穩定化

ST Tap realizes tool life and stable processing than competitor's tap



被削材選定基準表・基準切削條件

Selection Chart according to Work Materials and Standard Cutting Condition

被削材 Work Material		一般結構鋼	低碳素鋼	中炭素鋼	高炭素鋼	合金鋼		高硬度鋼	SUS鋼	鑄鐵	球墨鑄鐵	鋁合金
		SS Structural Steel	S15C Low Carbon Steel	S40C Medium Carbon Steel	S50C High Carbon Steel	SCM,SCr Alloy Steel		Hardened Steel	SUS Stainless Steel	FC Cast Iron	FCD Ductile Cast Iron	AC,ADC Aluminum Alloy
		~200HB	~200HB	~200HB	~200HB	~200HB	20~30HRC	30~40HRC				
STSP	選定 Selection chart	○	○	◎	○	○	○	—	—	—	○	○
	切削速度(m/min) Cutting Speed	5~15	5~15	5~15	5~15	5~15	5~8	—	—	—	5~15	10~20
STPO	選定 Selection chart	○	○	◎	○	○	○	—	—	—	○	○
	切削速度(m/min) Cutting Speed	6~20	6~20	6~20	6~20	6~20	5~10	—	—	—	6~20	10~20
推薦切削油 Cutting Fluids		極壓活性型非水溶性 水溶性 Sulfochlorinated Oil Water soluble Oil								水溶性 Water soluble Oil		

注) 1. 表中數值為一般的參考基準,請依實際狀況調整切削條件。

2. 表中數值為螺牙深2Dc(公稱直徑2倍)的基礎。

1. These are general cutting condition and may be altered by your conditions.

2. These conditions are for thread depth of 2xDc.

