



螺纹攻牙钻孔径和滚造径对照表

公制粗螺纹			
规格	标准径	2级牙钻孔径	
		最大	最小
M1.0*0.25	0.75	0.785	0.729
M1.1*0.25	0.85	0.885	0.829
M1.2*0.25	0.95	0.985	0.929
M1.4*0.3	1.10	1.142	1.075
M1.6*0.35	1.25	1.321	1.221
M1.7*0.35	1.35	1.421	1.321
M1.8*0.35	1.45	1.521	1.421
M2.0*0.4	1.60	1.679	1.567
M2.2*0.45	1.75	1.838	1.713
M2.3*0.4	1.90	1.979	1.867
M2.5*0.45	2.10	2.138	2.013
M2.6*0.45	2.20	2.238	2.113
M3.0*0.5	2.50	2.599	2.459
M3.0*0.6	2.40	2.440	2.280
M3.5*0.6	2.90	3.010	2.850
M4.0*0.7	3.30	3.422	3.242
M4.0*0.75	3.25	3.326	3.106
M4.5*0.75	3.80	3.878	3.688
M5.0*0.8	4.20	4.334	4.134
M5.0*0.9	4.10	4.170	3.930
M6.0*1.0	5.00	5.153	4.917
M7.0*1.0	6.00	6.153	5.917
M8.0*1.25	6.80	6.912	6.647
M9.0*1.25	7.80	7.912	7.647
M10*1.5	8.50	8.676	8.376
M11*1.5	9.50	9.676	9.376
M12*1.75	10.30	10.441	10.106
M14*2.0	12.00	12.210	11.835
M16*2.0	14.00	14.210	13.835
M18*2.5	15.50	15.744	15.294
M20*2.5	17.50	17.744	17.294
M22*2.5	19.50	19.744	19.294
M24*3.0	21.00	21.252	20.752
M27*3.0	24.00	24.252	23.752
M30*3.5	26.50	26.771	26.211

公制细螺纹			
规格	标准径	2级牙钻孔径	
		最大	最小
M1.0*0.2	0.80	0.821	0.783
M1.1*0.2	0.90	0.921	0.883
M1.2*0.2	1.00	1.021	0.983
M1.4*0.2	1.20	1.221	1.183
M1.6*0.2	1.40	1.421	1.383
M1.7*0.2	1.45	1.500	1.460
M1.8*0.2	1.60	1.621	1.583
M2.0*0.25	1.75	1.785	1.729
M2.2*0.25	1.95	1.985	1.929
M2.3*0.25	2.05	2.061	2.001
M2.5*0.35	2.20	2.221	2.121
M2.6*0.35	2.20	2.246	2.186
M3.0*0.35	2.70	2.721	2.621
M3.5*0.35	3.20	3.221	3.121
M4.0*0.5	3.50	3.599	3.459
M4.5*0.5	4.00	4.099	3.959
M5.0*0.5	4.50	4.599	4.459
M5.5*0.5	5.00	5.099	4.959
M6.0*0.75	5.30	5.378	5.188
M6.0*0.5	5.50	5.550	5.400
M7.0*0.75	6.30	6.378	6.188
M7.0*0.5	6.50	6.550	6.400
M8.0*1.0	7.00	7.153	6.917
M8.0*0.75	7.30	7.378	7.188
M8.0*0.5	7.50	7.520	7.400
M9.0*1.0	8.00	8.153	7.917
M9.0*0.75	8.30	8.378	8.188
M10*1.25	8.80	8.912	8.467
M10*1.0	9.00	9.153	8.917
M10*0.75	9.30	9.378	9.188
M10*0.5	9.50	9.520	9.400
M11*1.0	10.00	10.153	9.917
M11*0.75	10.30	10.378	10.188
M12*1.5	10.50	10.676	10.376
M12*1.25	10.80	10.912	10.647

公制细螺纹			
规格	标准径	2级牙钻孔径	
		最大	最小
M12*1.0	11.00	11.153	10.917
M12*0.5	11.50	11.520	11.400
M14*1.5	12.50	12.676	12.376
M14*1.0	13.00	13.153	12.917
M15*1.5	13.50	13.676	13.376
M15*1.0	14.00	14.153	13.917
M16*1.5	14.50	14.676	14.376
M16*1.0	15.00	15.153	14.917
M17*1.5	15.50	15.676	15.376
M17*1.0	16.00	16.153	15.917
M18*2.0	16.00	16.210	15.835
M18*1.5	16.50	16.676	16.376
M18*1.0	17.00	17.153	16.917
M20*2.0	18.00	18.210	17.835
M20*1.5	18.50	18.676	18.376
M20*1.0	19.00	19.153	18.917
M22*2.0	20.00	20.210	19.835
M22*1.5	20.50	20.676	20.376
M22*1.0	21.00	21.153	20.917
M24*2.0	22.00	22.210	21.835
M24*1.5	22.50	22.676	22.376
M24*1.0	23.00	23.153	22.917
M25*2.0	23.00	23.210	22.835
M25*1.5	23.50	23.676	23.376
M25*1.0	24.00	24.153	23.917
M26*1.5	24.50	24.676	24.376
M27*2.0	25.00	25.210	24.835
M27*1.5	25.50	25.676	25.376
M27*1.0	26.00	26.153	25.917
M28*2.0	26.00	26.210	25.835
M28*1.5	26.50	26.676	26.376
M28*1.0	27.00	27.153	26.917
M30*3.0	27.00	27.252	26.752
M30*2.0	28.00	28.210	27.835
M30*1.5	28.50	28.676	28.376
M30*1.0	29.00	29.153	28.917
M32*2.0	30.00	30.210	29.835
M32*1.5	30.50	30.676	30.376
M33*3.0	30.00	30.252	29.752
M33*2.0	31.00	31.210	30.835
M33*1.5	31.50	31.676	31.376
M35*1.5	33.50	33.676	33.376
M36*3.0	33.00	33.252	32.752
M36*2.0	34.00	34.210	33.835
M36*1.5	34.50	34.676	34.376

美制细螺纹			
规格 (UNF)	标准径	2级牙钻孔径	
		最大	最小
(螺丝牙外径)			
No. 0-80 (1.524)	1.25	1.305	1.182
No. 1-72 (1.854)	1.55	1.612	1.474
No. 2-64 (2.184)	1.85	1.912	1.756
No. 3-56 (2.515)	2.10	2.197	2.025
No. 4-48 (2.845)	2.40	2.458	2.271
No. 5-44 (3.175)	2.70	2.740	2.551
No. 6-40 (3.505)	2.90	3.022	2.820
No. 8-36 (4.166)	3.50	3.606	3.404
No. 10-32 (4.826)	4.10	4.165	3.963
No. 12-28 (5.846)	4.60	4.724	4.496
1/4 - 28	5.50	5.588	5.360
5/16 - 24	6.90	7.035	6.782
3/8 - 24	8.50	8.636	8.382
7/16 - 20	9.90	10.033	9.729
1/2 - 20	11.50	11.607	11.329
9/16 - 18	12.90	13.081	12.751
5/8 - 18	14.50	14.681	14.351
3/4 - 16	17.50	17.678	17.323
7/8 - 14	20.50	20.675	20.270
1 - 12	23.20	23.571	23.114
1-1/8 - 12	26.50	26.746	26.289
1-1/4 - 12	29.50	29.921	29.464
1-3/8 - 12	32.80	33.096	32.639
1-1/2 - 12	36.0	36.271	35.814

公制挤压丝攻钻孔径			
规格	精度等级		
	G4-G6	G7-G8	G9
M1.0*0.25	0.86	0.88	
M1.1*0.25	0.96	0.98	
M1.2*0.25	1.06	1.08	
M1.4*0.3	1.24	1.25	
M1.6*0.35	1.41	1.43	
M1.7*0.35	1.51	1.53	
M1.8*0.35	1.61	1.63	
M2*0.4	1.78	1.80	
M2.2*0.45	1.95	1.98	
M2.3*0.4	2.08	2.10	
M2.5*0.45	2.25	2.28	
M2.6*0.45	2.35	2.38	
M3.0*0.5	2.73	2.75	
M3.5*0.6	3.17	3.20	
M4.0*0.7	3.62	3.65	3.69
M5.0*0.8	4.56	4.60	4.64
M6.0*1.0	5.45	5.50	5.55
M7.0*1.0	6.45	6.50	6.55
M8.0*1.25	7.31	7.38	7.44
M10*1.5	9.18	9.25	9.32
M10*1.25	9.31	9.38	9.44
M12*1.75	11.04	11.12	11.21
M12*1.25	11.31	11.38	11.44

注：挤压丝攻之钻孔径，在上表所列之数值，由于被加工材料之材质、硬度、形状、尺寸等之影响，多少会有所变动，因此于参考上表之同时，亦请增减若干。

美制粗螺纹			
规格 (UNC)	标准径	2级牙钻孔径	
		最大	最小
(螺丝牙外径)			
No. 1-64 (1.854)	1.55	1.582	1.425
No. 2-56 (2.184)	1.80	1.871	1.695
No. 3-48 (2.515)	2.10	2.146	1.941
No. 4-40 (2.845)	2.30	2.385	2.157
No. 5-40 (3.175)	2.60	2.697	2.487
No. 6-32 (3.505)	2.80	2.895	2.642
No. 8-32 (4.166)	3.40	3.530	3.302
No. 10-24 (4.826)	3.90	3.962	3.683
No. 12-24 (5.846)	4.50	4.597	4.344
1/4 - 20	5.10	5.257	4.979
5/16 - 18	6.60	6.731	6.401
3/8 - 16	8.00	8.153	7.798
7/16 - 14	9.40	9.550	9.144
1/2 - 13	10.80	11.023	10.592
9/16 - 12	12.20	12.446	11.989
5/8 - 11	13.60	12.868	13.386
3/4 - 10	16.50	18.840	16.307
7/8 - 9	19.50	19.761	19.177
1 - 8	22.20	22.606	21.971
1-1/8 - 7	25.00	25.349	24.638
1-1/4 - 7	28.20	28.524	27.813
1-3/8 - 6	30.80	31.115	30.353
1-1/2 - 6	34.00	34.290	33.528
1-3/4 - 5	39.50	39.827	38.964
2 - 4-1/2	45.20	45.593	44.679

美制特细螺纹			
规格 (UNEF)	标准径	2级牙钻孔径	
		最大	最小
No. 12 - 32	4.70	4.826	4.623
1/4 - 32	5.60	5.690	5.486
5/16 - 32	7.10	7.264	7.087
3/8 - 32	8.70	8.865	8.661
7/16 - 28	10.20	10.338	10.135
1/2 - 28	11.80	11.938	11.709
9/16 - 24	13.20	13.386	13.132
5/8 - 24	14.80	14.986	14.732
3/4 - 20	17.80	17.958	17.678
7/8 - 20	21.00	21.133	20.853
1 - 20	24.00	24.308	24.028

英制平行管用螺纹PF(G) (单位: mm)			
规格	大径	钻孔径	
		最大	最小
G 1/16	7.72	6.84	6.56
G(PF)1/8	9.73	8.85	8.57
1/4	13.16	11.89	11.45
3/8	16.66	15.40	14.95
1/2	20.96	19.17	18.63
5/8	22.91	21.13	20.59
3/4	26.44	24.66	24.12
7/8	30.20	28.42	27.88
1	33.25	30.93	30.29
1.125	37.90	35.58	34.94
1.25	41.91	39.59	38.95
1.375	44.32	42.01	41.37
1.5	47.80	49.02	45.49
1.625	51.91	50.79	49.67
1.75	53.75	56.66	51.43
2	59.61		57.30

英制管螺纹			
规格	标准径	钻孔径	
		最大	最小
PS 1/16 - 28	6.50	6.632	6.490
PS 1/8 - 28	8.50	8.637	8.495
PS 1/4 - 19	11.40	11.549	11.341
PS 3/8 - 19	15.00	15.054	14.846
PS 1/2 - 14	18.50	18.773	18.489
PS 3/4 - 14	24.00	24.259	23.975
PS 1 - 11	30.20	30.471	30.111
PS 1-1/4 - 11	38.80	39.132	38.772
PS 1-1/2 - 11	44.80	45.025	44.665
PS 2 - 11	56.50	56.836	56.476

英制管螺纹				
规格	标准径		有效牙部之长度(最小)中之母牙牙内径	标准长度(最小)中之母牙牙内径
	使用绞刀时	不用绞刀时		
PT 1/16 - 28	6.10	6.20	6.244	6.384
PT 1/8 - 28	8.10	8.20	8.429	8.388
PT 1/4 - 19	10.70	11.00	10.962	11.174