TAPS JIS

Taps JIS 丝锥

- Roll Taps
- SP & PO machine taps
- Metric, UNC & UNF standard thread forms

– 挤压
– SP螺旋及PO先端
– 公制粗牙,美制UNC及UNF牙

Taps Finder

suttontools

ISO及VDI应用材料代号

ISO	VDI	Material Group 工件材料类别	Sutton 应用材料代号	
P	A	Steel 钢件	N	UNI
M	R	Stainless Steel 不锈钢	VA	
K	F	Cast Iron 铸铁	GG	
N	N	Non-Ferrous Metals, Aluminiums & Coppers 有色金属	Al W	
S	S	Titaniums & Super Alloys 钛合金及超级合金	Ti	Ni
H	H	Hard Materials (≥ 45 HRC) 淬火钢(≥ 45 HRC)	H	

^ VDI 3323 material groups can also be determined by referring to the material cross reference listing in the application guide at the back of this catalogue.

^ VDI 3323 工件材料类别明细可查阅产品目录最后部份技术篇的工件材料分类表.

	挤压		直槽(盲孔及通孔用)		先端–通孔用			螺旋–盲孔用				
	FOR THREAD FORMING		FOR TAPPING BLIND & THROUGH HOLES		FOR TAPPING THROUGH HOLES			FOR TAPPING BLIND HOLES				
Page 页 M	7	8	14	14	9	9	10	11	11	12	12	13
UNC	15	16			17	17		18	18			
UNF	19				20	20		21	21			
Catalogue Code 产品号 M	T514/T515	T520/T521	T294/T295	T296/T297	T499	T500	T548	T503/T606	T504/T607	T690	T570/T611	T577
UNC	T526/T527	T662/T663			T615	T616		T618	T619			
UNF	T539				T621	T622		T625	T626			
Material 材质	HSS Co.8 含8%钴高速钢		SPM 含钴粉末钢	VHM 硬质合金	HSSE 钒钼高速钢			HSSE 钒钼高速钢				PM-HSS Co 粉末冶金含钴高速钢
Surface Finish 表面处理	TiN 氮化钛		TiCN 碳氮化钛		Brt 无处理	Blu 氧化处理		Brt 无处理	Blu 氧化处理			Brt 无处理
Sutton Designation 神盾工具代号	N		XH	VH	N		VA	N		VA	VADH	H
Tapping Depth 有效攻牙深度	≤ 3xØ		≤ 1.5xØ		≤ 3xØ			≤ 2.5xØ		≤ 3xØ		≤ 1.5xØ

ISO	VDI^ 3323	Material 工件材料		Condition 材料状态	HB 硬度	N/mm²												
P	1	Steel - Non-alloy, cast & free cutting 钢件–非合金及易切削	~ 0.15 %C	A	125	440	●	●			●	●	●	●	●	●	●	
	2		~ 0.45 %C	A	190	640	●	●			●	●	●	●	●	●	●	
	3			QT	250	840	○	○			○	●	○	○	●	○	○	○
	4		~ 0.75 %C	A	270	910	○	○			○	●	○	○	●	○	○	○
	5			QT	300	1010			○	○		○			○			○
	6	Steel - Low alloy & cast < 5% of alloying elements 钢件–低合金钢		A	180	610	○	○			●	●	●	●	●	●	●	
	7			QT	275	930			○		○	●	○	○	●	○	○	○
	8			QT	300	1010			○	○		○			○			●
	9			QT	350	1180			●	○								●
	10	Steel - High alloy, cast & tool 高合金钢及工具钢		A	200	680			○	○	○	●		○	●			○
	11			HT	325	1100			●	○								●
	12	Steel - Corrosion resistant & cast 钢件–耐酸钢	Ferritic / Martensitic	A	200	680	○	○				○	○		○	○	○	○
	13		Martensitic	QT	240	810			●	○								○
M	14.1	Stainless Steel 不锈钢	Austenitic	A	180	610	●	●				○	●		○	●	●	
	14.2		Duplex		250	840	●	●				○	●		○	●	●	
	14.3		Precipitation Hardening		250	840							○		○	○	○	○
K	15	Cast Iron - Grey (GG) 灰铸铁	Ferritic / Pearlitic		180	610					○	○		○	○			○
	16		Pearlitic		260	880			○	○				○	○			○
	17	Cast Iron - Nodular (GGG) 球墨铸铁	Ferritic		160	570					○	○		○	○			●
	18		Pearlitic		250	840			○	○				○	○			○
	19	Cast Iron - Malleable 可锻铸铁	Ferritic		130	460					○	○		○	○			●
	20		Pearlitic		230	780			○		○	○		○	○			○
N	21	Aluminum & Magnesium - wrought alloy 锻造铝合金	Non Heat Treatable		60	210	●	●			●			●				
	22		Heat Treatable	AH	100	360	●	●			●			●				
	23	Aluminum & Magnesium - cast alloy ≤12% Si 压铸铝 ≤12% Si	Non Heat Treatable		75	270	○	○			○			○				
	24		Heat Treatable	AH	90	320	○	○			○			○				
	25	Al & Mg-cast alloy 压铸铝 >12% Si	Non Heat Treatable		130	460												○
	26	Copper & Cu alloys (Brass/Bronze) 铜及铜合金	Free cutting, Pb > 1%		110	390	●	●			○			○				
	27		Brass (CuZn, CuSnZn)		90	320	○	○	○	○	○			○				○
	28		Bronze (CuSn)		100	360	○	○										
	29	Non-metallic - Thermosetting & fiber-reinforced plastics																
	30	Non-metallic - Hard rubber, wood etc.																
S	31	High temp. alloys 耐热合金	Fe based	A	200	680												
	32			AH	280	950												
	33		Ni / Co based	A	250	840												
	34			AH	350	1180												
	35			C	320	1080												
	36	Titanium & Ti alloys 钛合金	CP Titanium		400 MPa													
	37.1		Alpha alloys		860 MPa													
	37.2		Alpha / Beta alloys	A	960 MPa													
	37.3			AH	1170 MPa													
	37.4		Beta alloys	A	830 MPa													
	37.5			AH	1400 MPa													
H	38.1	Hardened steel 淬火钢		HT	45 HRC				●	●								○
	38.2			HT	55 HRC					●								
	39.1			HT	58 HRC					●								
	39.2			HT	62 HRC					●								
	40	Cast Iron 硬铸铁	Chilled	C	400	1350												○
	41			HT	55 HRC					●								

Condition (材料状态): **A** (Annealed) (正火), **AH** (Age Hardened) (时效硬化), **C** (Cast) (铸件), **HT** (Hardened & Tempered) (淬火及回火), **QT** (Quenched & Tempered) (调质及回火).

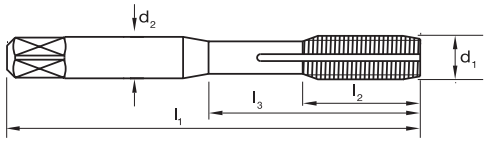
● Optimal 非常适合 ○ Effective 适合

JIS Taps Metric, Forming, Single Coolant Groove

suttontools

- For cold forming of threads in materials with good flow characteristics
  N-Suitable for material with >10% elongation
- P lead for through holes
- B lead for blind holes
- Depths up to approximately. 3 x d_1

- 用于延展性良好的材料
  N–适合延展率>10%的材料
- P型通孔用
- B型盲孔用
- 加工深度可达 3 x d_1



Catalogue Code 目录代码	T514	T515
Discount Group 折扣组	D0614	D0614
Material 材料	HSS Co.8	HSS Co.8
Surface Finish 表面处理	*TiN 氮化钛*	*TiN 氮化钛*
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构	1 Coolant Groove M3+	1 Coolant Groove M3+
Lead 倒锥牙	4 x P	2 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔径 Tap hole min/max	Item # (货号)	Item # (货号)
	P Lead (P 型＝4牙倒锥)												
0100	M 1	x 0.25	GH4	1	30	7	-	3.0	2.5	4	0.90 - 0.92	T514 0100	
0120	M 1.2	x 0.25	GH4	1	32	7	-	3.0	2.5	4	1.10 - 1.12	T514 0120	
0160	M 1.6	x 0.35	GH4	1	36	10	-	3.0	2.5	4	1.44 - 1.47	T514 0160	
0200	M 2	x 0.4	GH4	1	40	12	-	3.0	2.5	4	1.81 - 1.84	T514 0200	
0205	M 2	x 0.4	GH5	1	40	12	-	3.0	2.5	4	1.82 - 1.85	T514 0205	
0265	M 2.6	x 0.45	GH5	1	44	14	-	3.0	2.5	4	2.37 - 2.44		
0300	M 3	x 0.5	GH5	2	46	9	18	4.0	3.2	4	2.76 - 2.81	T514 0300	
0356	M 3.5	x 0.6	GH6	2	48	9	18	4.0	3.2	4	3.21 - 3.26		
0400	M 4	x 0.7	GH6	2	52	10	20	5.0	4.0	4	3.65 - 3.71	T514 0400	
0500	M 5	x 0.8	GH6	2	60	11	22	5.5	4.5	4	4.59 - 4.66	T514 0500	
0600	M 6	x 1	GH7	2	62	12	24	6.0	4.5	4	5.49 - 5.57	T514 0600	
0800	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34 - 7.44	T514 0800	
1000	M 10	x 1.5	GH7	3	75	19	-	7.0	5.5	6	9.18 - 9.31	T514 1000	
	B Lead (B型＝2牙倒锥)												
0100	M 1	x 0.25	GH4	1	30	7	-	3.0	2.5	4	0.90 - 0.92		T515 0100
0120	M 1.2	x 0.25	GH4	1	32	7	-	3.0	2.5	4	1.10 - 1.12		T515 0120
0140	M 1.4	x 0.3	GH4	1	34	7	-	3.0	2.5	4	1.27 - 1.29		T515 0140
0160	M 1.6	x 0.35	GH4	1	36	10	-	3.0	2.5	4	1.44 - 1.47		T515 0160
0200	M 2	x 0.4	GH4	1	40	12	-	3.0	2.5	4	1.81 - 1.84		T515 0200
0300	M 3	x 0.5	GH5	5	46	9	18	4.0	3.2	4	2.76 - 2.81		T515 0300
0400	M 4	x 0.7	GH6	5	52	10	20	5.0	4.0	4	3.65 - 3.71		T515 0400
0500	M 5	x 0.8	GH6	5	60	11	22	5.5	4.5	4	4.59 - 4.66		T515 0500
0600	M 6	x 1	GH7	5	62	12	24	6.0	4.5	4	5.49 - 5.57		T515 0600
0800	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34 - 7.44		T515 0800
1000	M 10	x 1.5	GH7	3	75	19	-	7.0	5.5	6	9.18 - 9.31		T515 1000

ISO	P												M			K						N									S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T514	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																		
T515	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																		

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

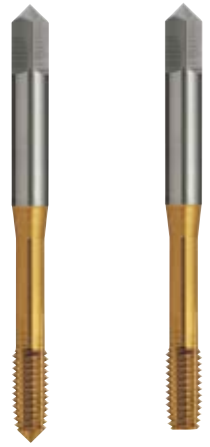
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps Metric, Forming, Multi Coolant Groove

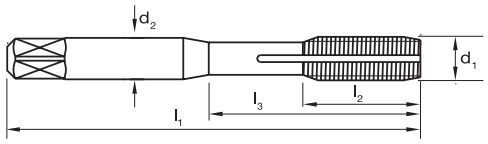
suttontools

- For cold forming of threads in materials with good flow characteristics
- Suitable for material with >10% elongation
- P lead for through holes
- B lead for blind holes
- Depths up to approximately. 3 x d_1

– 用于延展性良好的材料
– 适合延展率>10%的材料
– P型通孔用
– B型盲孔用
– 加工深度可达 3 x d_1



JIS | 60° M | P 4P | B 2P



	T520	T521
Catalogue Code 目录代码	T520	T521
Discount Group 折扣组	D0614	D0614
Material 材料	HSS Co.8	HSS Co.8
Surface Finish 表面处理	TiN 氮化钛	TiN 氮化钛
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构	Multi Coolant Groove	Multi Coolant Groove
Lead 倒锥牙	4 x P	2 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔径 Tap hole min/max	Item # (货号) T520	Item # (货号) T521
P Lead (P 型＝4牙倒锥)													
0300	M 3	x 0.5	GH5	2	46	9	18	4.0	3.2	4	2.76 - 2.81	T520 0300	
0400	M 4	x 0.7	GH6	2	52	10	20	5.0	4.0	4	3.65 - 3.71	T520 0400	
0500	M 5	x 0.8	GH6	2	60	11	22	5.5	4.5	4	4.59 - 4.69	T520 0500	
0600	M 6	x 1	GH7	2	62	12	24	6.0	4.5	4	5.49 - 5.57	T520 0600	
0800	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.33 - 7.44	T520 0800	
1000	M 10	x 1	GH7	3	75	19	-	7.0	5.5	6	9.18 - 9.30	T520 1000	
B Lead (B型＝2牙倒锥)													
0300	M 3	x 0.5	GH5	5	46	9	18	4.0	3.2	4	2.76 - 2.81		T521 0300
0400	M 4	x 0.7	GH6	5	52	10	20	5.0	4.0	4	3.65 - 3.71		T521 0400
0500	M 5	x 0.8	GH6	5	60	11	22	5.5	4.5	4	4.59 - 4.66		T521 0500
0600	M 6	x 1	GH7	5	62	12	24	6.0	4.5	4	5.49 - 5.57		T521 0600
0800	M 8	x 1.25	GH7	3	70	18	-	6.2	5.0	6	7.34 - 7.44		T521 0800
1000	M 10	x 1.5	GH7	3	75	19	-	7.0	5.5	6	9.18 - 9.30		T521 1000

ISO	P												M			K						N									S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T520	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																		
T521	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																		

P Steel 钢件 | M Stainless Steel 不锈钢 | K Cast Iron 铸铁 | N Non-Ferrous Metals 有色金属 | S Titanium & Super Alloys 钛合金及超级合金 | H Hard Materials 淬火钢 | ● Optimal 非常适合 ○ Effective 适合

* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

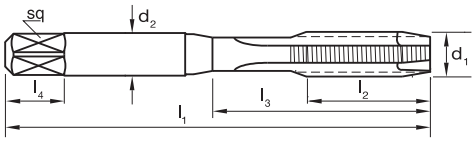
JIS Taps Metric, Gun, N (Spiral Point)

suttontools

- General purpose use
- Suitable for materials up to 1000 N/mm²
- Through holes
- Depths up to 3 x d_1

- 一般用途
- 适合 ≤ 1000 N/mm² 的材料
- 通孔用
- 加工深度 ≤3 x d_1

JIS 60° M



Catalogue Code 目录代码	T499	T500
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE	HSSE
Surface Finish 表面处理	*Brt 无处理*	*Blu 氧化处理*
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构		
Lead 倒锥牙	5 x P	5 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔钻 drill Ø	Item # (货号) T499	Item # (货号) T500
0100	M 1	x 0.25	P1	1	30	7	-	3.0	2.5	2	0.75	T499 0100	•
0110	M 1.1	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.85	T499 0110	•
0120	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T499 0120	•
0140	M 1.4	x 0.3	P1	1	34	9	-	3.0	2.5	2	1.1	T499 0140	•
0160	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T499 0160	•
0170	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T499 0170	•
0180	M 1.8	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.45	T499 0180	•
0200	M 2	x 0.4	P2	1	40	12	-	3.0	2.5	2	1.60	T499 0200	T500 0200
0220	M 2.2	x 0.45	P2	1	42	13	-	3.0	2.5	2	1.75	T499 0220	•
0230	M 2.3	x 0.4	P2	1	42	13	-	3.0	2.5	2	1.9	T499 0230	•
0250	M 2.5	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.05	T499 0250	T500 0250
0260	M 2.6	x 0.45	P2	1	44	14	-	3.0	2.5	2	2.15	T499 0260	T500 0260
0300	M 3	x 0.5	P2	2	46	11	19	4.0	3.2	3	2.5	T499 0300	T500 0300
0350	M 3.5	x 0.6	P2	2	48	13	20	4.0	3.2	3	2.9	T499 0350	T500 0350
0400	M 4	x 0.7	P2	2	52	13	21	5.0	4.0	3	3.3	T499 0400	T500 0400
0500	M 5	x 0.8	P2	2	60	16	24	5.5	4.5	3	4.2	T499 0500	T500 0500
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T499 0600	T500 0600
0700	M 7	x 1	P2	3	65	22	-	6.2	5.0	3	6.0	T499 0700	•
0800	M 8	x 1.25	P3	3	70	22	-	6.2	5.0	3	6.8	T499 0800	T500 0800
1006	MF 10	x 1.25	P3	3	75	24	-	7.0	5.5	3	8.8	T499 1006	T500 1006
1000	M 10	x 1.5	P3	3	75	24	-	7.0	5.5	3	8.5	T499 1000	T500 1000
1200	M 12	x 1.75	P4	3	82	29	-	8.5	6.5	3	10.2	T499 1200	T500 1200
1400	M 14	x 2	P4	3	88	30	-	10.5	8.0	3	12.0	T499 1400	•
1600	M 16	x 2	P4	3	95	32	-	12.5	10.0	4	14.0	T499 1600	T500 1600
1800	M 18	x 2.5	P4	3	100	37	-	14.0	11.0	4	15.5	T499 1800	•
2000	M 20	x 2.5	P4	3	105	37	-	15.0	12.0	4	17.5	T499 2000	T500 2000
2200	M 22	x 2.5	P4	3	115	38	-	17.0	13.0	4	19.5	T499 2200	•
2400	M 24	x 3	P4	3	120	45	-	19.0	15.0	4	21.0	T499 2400	T500 2400

ISO	P													M			K						N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T499	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T500	●	●	●	●	○	●	●	○		●		○		○	○		○		○		○	○																											

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

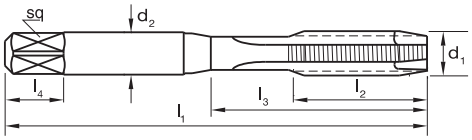
• Available on request as special manufacture. Subject to lead time. • 可定制.
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如果需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps Metric, Gun, VA (Spiral Point)

suttontools

- Use in stainless steels and high strength steels
- Suitable for materials up to 850 N/mm²
- Through holes
- Depths up to 3 x d_1

– 针对不锈钢及高韧性材料
– 适合 ≤ 850 N/mm² 的材料
– 通孔用
– 加工深度 ≤3 x d_1



Catalogue Code 目录代码	T548
Discount Group 折扣组	D0602
Material 材料	HSSE
Surface Finish 表面处理	*Blu 氧化处理*
Sutton Designation 神盾工具代号	VA
Geometry 几何结构	Special Relief
Lead 倒锥牙	4 x P

尺寸参考 螺距 精度 样式 底孔钻

Size Ref.	d_1	Pitch	Limit	Style*	l_1	l_2	l_3	d_2	sq	z	drill Ø	Item # (货号)
0200	M 2	x 0.4	P2	1	40	12	-	3.0	2.5	2	1.6	T548 0200
0300	M 3	x 0.5	P3	2	46	11	19	4.0	3.2	3	2.5	T548 0300
0400	M 4	x 0.7	P3	2	52	13	21	5.0	4.0	3	3.3	T548 0400
0500	M 5	x 0.8	P3	2	60	16	24	5.5	4.5	3	4.2	T548 0500
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T548 0600
0800	M 8	x 1.25	P3	3	70	22		6.2	5.0	3	6.8	T548 0800
1000	M 10	x 1.5	P3	3	75	24		7.0	5.5	3	8.5	T548 1000
1200	M 12	x 1.75	P3	3	82	29		8.5	6.5	3	10.2	T548 1200
1600	M 16	x 2	P4	3	95	32		12.5	10.0	4	14.0	T548 1600
2000	M 20	x 2.5	P4	3	105	37		15.0	12.0	4	17.5	T548 2000

ISO	P													M			K						N										S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T548	●	●	○	○		●	○					○		●	●	○																																	

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

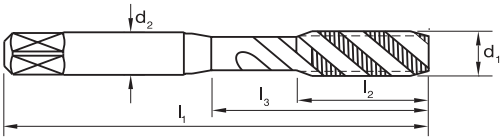
JIS Taps Metric, Spiral Flute, R40 N

suttontools

- General purpose use
- Suitable for materials up to 1000 N/mm²
- Blind holes
- Depths up to 2.5 x d_1

- 一般用途
- 适合 ≤ 1000 N/mm² 的材料
- 盲孔用
- 加工深度 ≤ 2.5 x d_1

JIS 60° M



Catalogue Code 目录代码	T503	T504
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE	HSSE
Surface Finish 表面处理	*Brt 无处理*	*Blu 氧化处理*
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构	R40	R40
Lead 倒锥牙	2.5 x P	2.5 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔钻 drill Ø	Item # (货号)	Item # (货号)
	With Point 尖头												
0120	M 1.2	x 0.25	P1	1	32	8	-	3.0	2.5	2	0.95	T503 0120	•
0140	M 1.4	x 0.3	P1	1	34	9	-	3.0	2.5	2	1.1	T503 0140	•
0160	M 1.6	x 0.35	P1	1	36	10	-	3.0	2.5	2	1.25	T503 0160	•
0170	M 1.7	x 0.35	P1	1	36	11	-	3.0	2.5	2	1.35	T503 0170	•
0200	M 2	x 0.4	P2	1	40	12	15	3.0	2.5	2	1.60	T503 0200	T504 0200
0250	M 2.5	x 0.45	P2	1	44	14	16	3.0	2.5	2	2.05	T503 0250	T504 0250
0260	M 2.6	x 0.45	P2	1	44	14	16	3.0	2.5	2	2.15	T503 0260	T504 0260
0300	M 3	x 0.5	P2	2	46	11	18	4.0	3.2	3	2.5	T503 0300	T504 0300
0350	M 3.5	x 0.6	P1	2	48	13	20	4.0	3.2	3	2.9	T503 0350	T504 0350
0400	M 4	x 0.7	P2	2	52	13	20	5.0	4.0	3	3.3	T503 0400	T504 0400
0500	M 5	x 0.8	P2	2	60	16	25	5.5	4.5	3	4.2	T503 0500	T504 0500
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T503 0600	T504 0600
	Without Point 平头											T606	T607
0700	M 7	x 1	P2	3	65	22	-	6.2	5.0	3	6.0	T606 0700	•
0800	M 8	x 1.25	P2	3	70	22	-	6.2	5.0	3	6.8	T606 0800	T607 0800
1006	MF 10	x 1.25	P2	3	75	24	-	7.0	5.5	3	8.5	T606 1006	T607 1006
1000	M 10	x 1.5	P2	3	75	24	-	7.0	5.5	3	8.8	T606 1000	T607 1000
1200	M 12	x 1.75	P2	3	82	29	-	8.5	6.5	3	10.2	T606 1200	T607 1200
1400	M 14	x 2	P2	3	88	30	-	10.5	8.0	3	12.0	T606 1400	•
1600	M 16	x 2	P2	3	95	32	-	12.5	10.0	4	14.0	T606 1600	T607 1600
1800	M 18	x 2.5	P3	3	100	37	-	14.0	11.0	4	15.5	T606 1800	•
2000	M 20	x 2.5	P3	3	105	37	-	15.0	12.0	4	17.5	T606 2000	T607 2000
2200	M 22	x 2.5	P3	3	115	38	-	17.0	13.0	4	19.5	T606 2200	•
2400	M 24	x 3	P3	3	120	45	-	19.0	15.0	4	21.0	T606 2400	T607 2400

ISO	P													M			K						N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T503	●	●	○	○		●	○			○							○	○	○	○	○	○	●	●	○	○		○	○																				
T504	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○																											
T606	●	●	○	○		●	○			○							○	○	○	○	○	○	●	●	○	○		○	○																				
T607	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○																											

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

• Available on request as special manufacture. Subject to lead time. • 可定制.

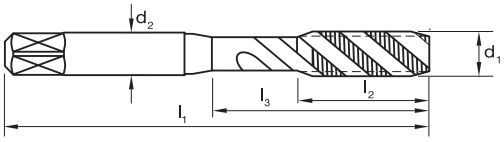
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps Metric, Spiral Flute, R45 VA/VA DH

suttontools

- Standard thread length for better guidance properties
- Use in stainless steels and high strength steels up to 850N/mm²
- Blind holes
- Depths up to approximately. 3 x d_1
- VA for conventional tapping machines
- VA DH for synchronous tapping in machine operations

– T690 标准长牙设计,有较佳的校正能力
– 针对不锈钢及高韧性材料 ≤ 850 N/mm²
– 盲孔用
– 加工深度 ≤ 3 x d_1
– VA 亦可用于传统的攻牙机
– VADH系列只适用于稳定的进给方式



Catalogue Code 目录代码	T690	T570
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE	HSSE
Surface Finish 表面处理	*Blu* 氧化处理	*Blu* 氧化处理
Sutton Designation 神盾工具代号	VA	VADH
Geometry 几何结构	R45	R45
Lead 倒锥牙	2.5 x P	2.5 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔钻 drill Ø	Item # (货号) T690	Item # (货号) T570
	With Point 尖头												
0300	**M 3**	x 0.5	P2	2	46	11	19	4.0	3.2	3	2.5	T690 0300	
0400	**M 4**	x 0.7	P2	2	52	13	21	5.0	4.0	3	3.3	T690 0400	
0500	**M 5**	x 0.8	P2	2	60	16	24	5.5	4.5	3	4.2	T690 0500	
0600	**M 6**	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T690 0600	
	Without Point 平头												
0800	**M 8**	x 1.25	P2	3	70	22	-	6.2	5.0	3	6.8	T690 0800	
	With Point 尖头												
0300	**M 3**	x 0.5	P2	2	46	5	19	4.0	3.2	3	2.5		T570 0300
0400	**M 4**	x 0.7	P2	2	52	7	21	5.0	4.0	3	3.3		T570 0400
0500	**M 5**	x 0.8	P2	2	60	8	24	5.5	4.5	3	4.2		T570 0500
0600	**M 6**	x 1	P2	2	62	10	28	6.0	4.5	3	5.0		T570 0600
	Without Point 平头												**T611**
0800	**M 8**	x 1.25	P3	3	70	13		6.2	5.0	3	6.8		T611 0800
1000	**M 10**	x 1.5	P3	3	75	15		7.0	5.5	3	8.5		T611 1000
1200	**M 12**	x 1.75	P3	3	82	17.5		8.5	6.5	3	10.2		T611 1200
1400	**M 14**	x 2	P3	3	88	20		10.5	8.0	3	12.0		T611 1400
1600	**M 16**	x 2	P3	3	95	20		12.5	10.0	4	14.0		T611 1600

ISO	P												M			K						N										S										H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T690	●	●	○	○		●	○					○		●	●	○																																
T570	●	●	○	○		●	○					○		●	●	○																																
T611	●	●	○	○		●	○					○		●	●	○																																

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

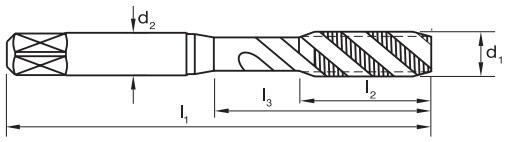
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps Metric, Spiral Flute, R15 H

suttontools

- Suitable for harder short chipping materials up to 45 HRc
- Blind holes
- Depths up to 1.5 x d_1

– 针对中高硬钢 ≤ 45HRc
– 盲孔用
– 加工深度 ≤ 1.5 x d_1



Catalogue Code 目录代码	T577
Discount Group 折扣组	D0602
Material 材料	PM-HSS Co
Surface Finish 表面处理	*Brt 无处理*
Sutton Designation 神盾工具代号	H
Geometry 几何结构	R15 Low Relief
Lead 倒锥牙	3 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔钻 drill Ø	Item #（货号）
0300	M 3	x 0.5	P3	2	46	11	19	4.0	3.2	3	2.5	T577 0300
0400	M 4	x 0.7	P3	2	52	13	21	5.0	4.0	3	3.3	T577 0400
0500	M 5	x 0.8	P3	2	60	16	24	5.5	4.5	3	4.2	T577 0500
0600	M 6	x 1	P2	2	62	19	28	6.0	4.5	3	5.0	T577 0600

ISO	P												M			K						N									S										H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T577			○	○	○		○	●	●	○	●	○	○			○	○	○	●	○	●	○					○		○															○				○	

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

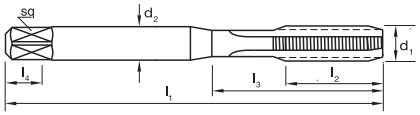
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如果需要查看详细的样式细节请参考产品目录后页的技术信息部分.

Taps Metric, Straight Flute, XH & VH

suttontools

- XH, use in hardened steels 42-52 HRc
- VH, use in hardened steels 50-60 HRc
- Through & blind holes
- Depths up to approximately. 1.5 x d_1

– XH，针对42–52HRc淬火钢
– VH，针对50–60HRc淬火钢
– 通孔及盲孔用
– 加工深度 ≤ 1.5 x d_1



Catalogue Code 目录代码	T294	T295	T296	T297
Discount Group 折扣组	D0408	D0408	D0414	D0414
Material 材料	SPM 含钴粉末钢	SPM 含钴粉末钢	VHM 硬质合金	VHM 硬质合金
Surface Finish 表面处理	TiCN 碳氮化钛	TiCN 碳氮化钛	TiCN 碳氮化钛	TiCN 碳氮化钛
Sutton Designation 神盾工具代号	XH	XH	VH	VH
Geometry 几何结构	Special Relief	Special Relief	Special Relief	Special Relief
Lead 倒锥牙	3 x P	5 x P	Form C / 3 x P	Form D / 5 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	drill Ø	Item #（货号）	Item #（货号）	Item #（货号）	Item #（货号）
0500	M 5	x 0.8	6HX	2	60	16	24	6.0	4.9	4	4.3	T294 0500	T295 0500		
0600	M 6	x 1	6HX	2	62	19	28	6.0	4.9	4	5.1	T294 0600	T295 0600		
0800	M 8	x 1.25	6HX	3	70	22	-	6.0	4.9	5	6.9	T294 0800	T295 0800		
1000	M 10	x 1.5	6HX	3	75	24	-	7.0	5.5	5	8.6	T294 1000	T295 1000		
1200	M 12	x 1.75	6HX	3	82	29	-	9.0	7.0	5	10.3	T294 1200	T295 1200		
1600	M 16	x 2	6HX	3	95	32	-	12.0	9.0	5	14.1	T294 1600	T295 1600		
2000	M 20	x 2.5	6HX	3	105	37	-	16.0	12.0	5	17.7	T294 2000	T295 2000		
	DIN371														
0300	M 3	x 0.5	6HX	2	56	11	18	3.5	2.7	4	2.55			T296 0300	T297 0300
0400	M 4	x 0.7	6HX	2	63	13	21	4.5	3.4	4	3.4			T296 0400	T297 0400
0500	M 5	x 0.8	6HX	2	70	16	25	6.0	4.9	4	4.3			T296 0500	T297 0500
0600	M 6	x 1	6HX	2	80	19	30	6.0	4.9	5	5.1			T296 0600	T297 0600
0800	M 8	x 1.25	6HX	3	90	22	35	8.0	6.2	5	6.9			T296 0800	T297 0800
1000	M 10	x 1.5	6HX	3	100	24	39	10.0	8.0	5	8.6			T296 1000	T297 1000
	DIN376														
1200	M 12	x 1.75	6HX	3	110	28	-	9.0	7.0	5	10.3			T296 1200	T297 1200
1600	M 16	x 2	6HX	3	110	32	-	12.0	9.0	6	14.1			T296 1600	T297 1600
2000	M 20	x 2.5	6HX	3	140	34	-	16.0	12.0	6	17.7			T296 2000	T297 2000

ISO	P												M			K						N										S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T294					○		○	○	●	○	●		●					○		○		○							○																●					
T295					○		○	○	●	○	●		●					○		○		○							○																●					
T296					○			○	○	○	○		○					○		○									○																●	●	●	●		●
T297					○			○	○	○	○		○					○		○									○																●	●	●	●		●

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

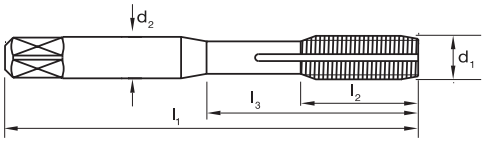
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分。

JIS Taps UNC, Forming, Single Coolant Groove

suttontools

- For cold forming of threads in materials with good flow characteristics
- Suitable for material with >10% elongation
- Through or blind holes
- Depths up to approximately. 3 x d_1

– 用于延展性良好的材料
– 适合延展率>10%的材料
– 通孔及盲孔用
– 加工深度 ≤ 3 x d_1



Catalogue Code 目录代码	T526	T527
Discount Group 折扣组	D0614	D0614
Material 材料	HSS Co.8	HSS Co.8
Surface Finish 表面处理	TiN 氮化钛	TiN 氮化钛
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构	1 Coolant Groove #4+	1 Coolant Groove #4+
Lead 倒锥牙	4P	2P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔径 Tap hole min/max	Item #（货号） T526	Item #（货号） T527
	P Lead（P 型＝4牙倒锥）												
0284	#4	40	GH5	2	44	11	16	3.0	2.5	4	2.52 - 2.60	T526 0284	
0318	#5	40	GH5	2	46	9	16	4.0	3.2	4	2.86 - 2.93	T526 0318	
0351	#6	32	GH6	2	48	9	18	4.0	3.2	4	3.11 - 3.19	T526 0351	
0417	#8	32	GH6	2	52	10	20	5.0	4.0	4	3.77 - 3.85	T526 0417	
0483	#10	24	GH6	2	60	11	22	5.5	4.5	4	4.27 - 4.38	T526 0483	
0635	1/4	20	GH7	2	62	14	24	6.0	4.5	4	5.67 - 5.80	T526 0635	
0794	5/16	18	GH7	3	70	22	-	6.1	5.0	6	7.18 - 7.32	T526 0794	
	B Lead（B型＝2牙倒锥）												
0284	#4	40	GH5	5	44	11	16	3.0	2.5	4	2.52 - 2.60		T527 0284
0318	#5	40	GH5	5	46	9	16	4.0	3.2	4	2.86 - 2.93		T527 0318
0351	#6	32	GH6	5	48	9	18	4.0	3.2	4	3.11 - 3.19		T527 0351
0417	#8	32	GH6	5	52	10	20	5.0	4.0	4	3.76 - 3.85		T527 0417
0483	#10	24	GH6	5	60	11	22	5.5	4.5	4	4.27 - 4.38		T527 0483
0635	1/4	20	GH7	5	62	14	24	6.0	4.5	4	5.68 - 5.80		T527 0635
0794	5/16	18	GH7	3	70	22	-	6.1	5.0	6	7.18 - 7.32		T527 0794

ISO	P												M			K						N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T526	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																			
T527	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																			

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

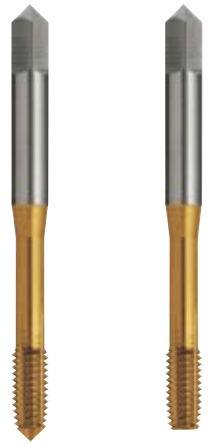
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如果需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps UNC, Forming, Multi Coolant Groove

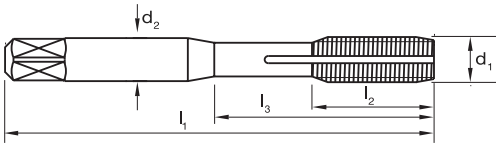
suttontools

- For cold forming of threads in materials with good flow characteristics
- Suitable for material with >10% elongation
- Through or blind holes
- Depths up to approximately. 3 x d_1

– 用于延展性良好的材料
– 适合延展率>10%的材料
– 通孔及盲孔用
– 加工深度 ≤ 3 x d_1



JIS | 60° UNC | P 4P | B 2P



	T662	T663
Catalogue Code 目录代码	T662	T663
Discount Group 折扣组	D0614	D0614
Material 材料	HSS Co.8	HSS Co.8
Surface Finish 表面处理	TiN 氮化钛	TiN 氮化钛
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构	Multi Coolant Groove	Multi Coolant Groove
Lead 倒锥牙	4P	2P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔径 Tap hole min/max	Item # (货号)	Item # (货号)
P Lead (P 型=4牙倒锥)													
0351	#6	32	GH6	2	48	9	18	4.0	3.2	4	3.11 - 3.19	T662 0351	
0417	#8	32	GH6	2	52	10	20	5.0	4.0	4	3.77 - 3.85	T662 0417	
0483	#10	24	GH6	2	60	11	22	5.5	4.5	4	4.27 - 4.38	T662 0483	
0549	#12	24	GH6	2	62	11	25	6.0	4.5	4	4.93 - 5.04	T662 0549	
0635	1/4	20	GH7	2	62	14	24	6.0	4.5	4	5.67 - 5.80	T662 0635	
B Lead (B型=2牙倒锥)													
0351	#6	32	GH6	5	48	9	18	4.0	3.2	4	3.11 - 3.19		T663 0351
0417	#8	32	GH6	5	52	10	20	5.0	4.0	4	3.77 - 3.85		T663 0417
0483	#10	24	GH6	5	60	11	22	5.5	4.5	4	4.27 - 4.38		T663 0483
0549	#12	24	GH6	5	62	11	25	6.0	4.5	4	4.93 - 5.04		T663 0549
0635	1/4	20	GH7	5	62	14	24	6.0	4.5	4	5.67 - 5.80		T663 0635

ISO	P												M			K						N									S													H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T662	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																			
T663	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																			

P Steel 钢件 | M Stainless Steel 不锈钢 | K Cast Iron 铸铁 | N Non-Ferrous Metals 有色金属 | S Titanium & Super Alloys 钛合金及超级合金 | H Hard Materials 淬火钢

● Optimal 非常适合 ○ Effective 适合

* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

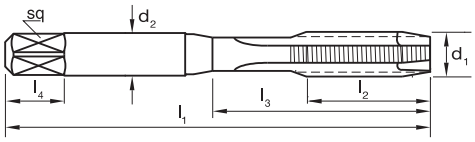
JIS Taps UNC, Gun, N (Spiral Point)

suttontools

- General purpose use
- Suitable for materials up to 1000 N/mm²
- Through holes
- Depths up to 3 x d_1

– 一般用途
– 适合 ≤ 1000 N/mm² 的材料
– 通孔用
– 加工深度 ≤3 x d_1

JIS 60° UNC



Catalogue Code 目录代码	T615	T616
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE	HSSE
Surface Finish 表面处理	*Brt 无处理*	*Blu 氧化处理*
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构		
Lead 倒锥牙	5 x P	5 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔钻 drill Ø	Item # (货号)	Item # (货号)
0218	#2	56	2B	1	42	10	-	3.0	2.5	2	1.80	T615 0218	T616 0218
0284	#4	40	2B	2	44	11	16	3.0	2.5	2	2.30	T615 0284	T616 0284
0318	#5	40	2B	2	46	11	16	4.0	3.2	3	2.60	T615 0318	T616 0318
0351	#6	32	2B	2	48	13	20	4.0	3.2	3	2.80	T615 0351	T616 0351
0417	#8	32	2B	2	52	13	20	5.0	4.0	3	3.4	T615 0417	T616 0417
0483	#10	24	2B	2	60	16	22	5.5	4.5	3	3.9	T615 0483	T616 0483
0635	1/4	20	2B	2	62	19	30	6.0	4.5	3	5.1	T615 0635	T616 0635
0794	5/16	18	2B	3	70	22	-	6.1	5.0	3	6.6	T615 0794	T616 0794
0953	3/8	16	2B	3	75	24	-	7.0	5.5	3	8.0	T615 0953	T616 0953
1111	7/16	14	2B	3	80	29	-	8.0	6.0	3	9.4	T615 1111	T616 1111
1270	1/2	13	2B	3	85	29	-	9.0	7.0	3	10.8	T615 1270	T616 1270
1588	5/8	11	2B	3	95	32	-	12.5	10.0	4	13.5	T615 1588	T616 1588
1905	3/4	10	2B	3	105	37	-	14.0	11.0	4	16.5	T615 1905	
2223	7/8	9	2B	3	115	38	-	17.0	13.0	4	19.5	T615 2223	
2540	1	8	2B	3	120	45	-	20.0	15.0	4	22.5	T615 2540	

ISO	P													M			K						N									S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T615	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																			
T616	●	●	●	●	○	●	●	○		●		○		○	○		○		○		○	○																										

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

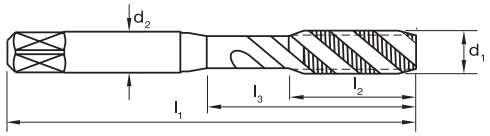
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如果需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps UNC, Spiral Flute, R40 N

suttontools

- General purpose use, materials up to approximately. 1000 N/mm² – 一般用途,适合 ≤ 1000 N/mm² 的材料
- Blind holes – 盲孔用
- Suitable for machine operations – 适合机用
- Depths up to approximately. 2.5 x d_1 – 加工深度 ≤2.5 x d_1

JIS 60° UNC



Catalogue Code 目录代码	T618	T619
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE	HSSE
Surface Finish 表面处理	*Brt 无处理*	*Blu 氧化处理*
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构	R40	R40
Lead 倒锥牙	2.5 x P	2.5 x P

尺寸参考 螺距 精度 样式 底孔钻

Size Ref.	d_1	Pitch	Limit	Style*	l_1	l_2	l_3	d_2	sq	z	drill Ø	Item # (货号)	Item # (货号)
0218	#2	56	2B	1	42	14	-	3.0	2.5	2	1.80	T618 0218	T619 0218
0284	#4	40	2B	2	44	11	16	3.0	2.5	2	2.30	T618 0284	T619 0284
0351	#6	32	2B	2	48	13	18	4.0	3.2	3	2.80	T618 0351	T619 0351
0417	#8	32	2B	2	52	13	20	5.0	4.0	3	3.4	T618 0417	T619 0417
0483	#10	24	2B	2	60	16	22	5.5	4.5	3	3.9	T618 0483	T619 0483
0635	1/4	20	2B	2	62	19	30	6.0	4.5	3	5.1	T618 0635	T619 0635
0794	5/16	18	2B	3	70	22	-	6.1	5.0	3	6.6	T618 0794	T619 0794
0953	3/8	16	2B	3	75	24	-	7.0	5.5	3	8.0	T618 0953	T619 0953
1111	7/16	14	2B	3	80	29	-	8.0	6.0	3	9.4	T618 1111	T619 1111
1270	1/2	13	2B	3	85	29	-	9.0	7.0	3	10.8	T618 1270	T619 1270
1588	5/8	11	2B	3	95	32	-	12.5	10.0	4	13.5	T618 1588	T619 1588
1905	3/4	10	2B	3	105	37	-	14.0	11.0	4	16.5	T618 1905	T619 1905
2540	1	8	2B	3	120	45	-	20.0	15.0	4	22.5	T618 2540	T619 2540

ISO	P													M			K						N										S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T618	●	●	○	○		●	○			○							○	○	○	○	○	○	●	●	○	○		○	○																				
T619	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○																											

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

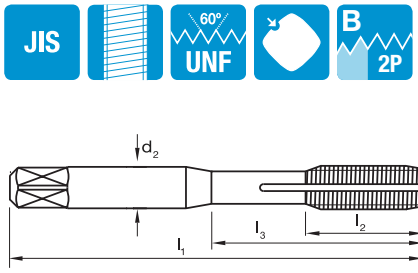
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps UNF, Forming, Single Coolant Groove

suttontools

- For cold forming of threads in materials with good flow characteristics
- Suitable for material with >10% elongation
- Through or blind holes
- Depths up to approximately. 3 x d_1

– 用于延展性良好的材料
– 适合延展率>10%的材料
– 通孔及盲孔用
– 加工深度 ≤ 3 x d_1



Catalogue Code 目录代码	T539
Discount Group 折扣组	D0614
Material 材料	HSS Co.8
Surface Finish 表面处理	TiN 氮化钛
Sutton Designation 神盾工具代号	N
Geometry 几何结构	1 Coolant Groove #4+
Lead 倒锥牙	2P

尺寸参考		螺距	精度	样式							底孔径	
Size Ref.	d_1	Pitch	Limit	Style*	l_1	l_2	l_3	d_2	sq	z	Tap hole min/max	Item #（货号）
	B Lead (B型＝2牙倒锥)											
0284	#4	48	GH5	5	46	11	16	3.0	2.5	4	2.58 - 2.65	T539 0284
0351	#6	40	GH6	5	48	9	18	4.0	3.2	4	3.20 - 3.27	T539 0351
0483	#10	32	GH6	5	60	11	22	5.5	5	4	4.43 - 4.51	T539 0483
0635	1/4	28	GH7	5	62	14	30	6.0	4.5	4	5.93 - 5.98	T539 0635

ISO	P												M			K						N									S											H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T539	●	●	○	○		○						○		●	●								●	●	○	○		●	○	○																		

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

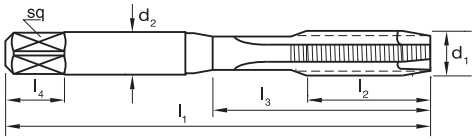
* For style specifications refer to the Technical Information section at the back of this catalogue. * 如果需要查看详细的样式细节请参考产品目录后页的技术信息部分.

JIS Taps UNF, Gun, N (Spiral Point)

suttontools

- General purpose use, materials up to approximately. 1000 N/mm² – 一般用途, 适合 ≤ 1000 N/mm² 的材料
- Through holes – 通孔用
- Suitable for machine operations – 适合机用
- Depths up to approximately. 3 x d_1 – 加工深度 ≤3 x d_1

JIS 60° UNF



Catalogue Code 目录代码	T621	T622
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE	HSSE
Surface Finish 表面处理	*Brt* 无处理	*Blu* 氧化处理
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构		
Lead 倒锥牙	5 x P	5 x P

尺寸参考		螺距	精度	样式							底孔钻		
Size Ref.	d_1	Pitch	Limit	Style*	l_1	l_2	l_3	d_2	sq	z	drill Ø	Item # (货号)	Item # (货号)
0483	#10	32	2B	2	60	16	22	5.5	4.5	3	4.1	T621 0483	T622 0483
0635	1/4	28	2B	2	62	19	30	6.0	4.5	3	5.5	T621 0635	
0794	5/16	24	2B	3	70	22	-	6.1	5.0	3	6.9	T621 0794	
0953	3/8	24	2B	3	75	24	-	7.0	5.5	3	8.5	T621 0953	
1270	1/2	20	2B	3	85	29	-	9.0	7.0	3	11.5	T621 1270	
1588	5/8	18	2B	3	95	32	-	12.5	10.0	4	14.5	T621 1588	
1905	3/4	16	2B	3	105	37	-	14.0	11.0	4	17.5	T621 1905	
2540	1	12	2B	3	120	45	-	20.0	15.0	4	23.3	T621 2540	

ISO	P													M			K						N										S												H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T621	●	●	○	○		●	○			○							○		○		○	○	●	●	○	○		○	○																				
T622	●	●	●	●	○	●	●	○		●		○		○	○		○		○		○	○																										

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

* For style specifications refer to the Technical Information section at the back of this catalogue. * 如需要查看详细的样式细节请参考产品目录后页的技术信息部分.

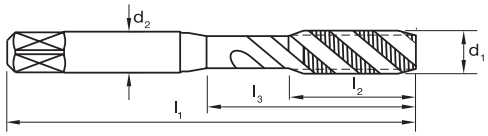
JIS Taps UNF, Spiral Flute, R40 N

suttontools

- General purpose use, materials up to approximately. 1000 N/mm²
- Blind holes
- Suitable for machine operations
- Depths up to approximately. 2.5 x d_1

– 一般用途,适合 ≤ 1000 N/mm² 的材料
– 通孔用
– 适合机用
– 加工深度 ≤2.5 x d_1

JIS 60° UNF



Catalogue Code 目录代码	T625	T626
Discount Group 折扣组	D0602	D0602
Material 材料	HSSE	HSSE
Surface Finish 表面处理	*Brt 无处理*	*Blu 氧化处理*
Sutton Designation 神盾工具代号	N	N
Geometry 几何结构	R40	R40
Lead 倒锥牙	2.5 x P	2.5 x P

尺寸参考 Size Ref.	d_1	螺距 Pitch	精度 Limit	样式 Style*	l_1	l_2	l_3	d_2	sq	z	底孔钻 drill Ø	Item # (货号)	Item # (货号)
0483	#10	32	2B	2	60	16	22	5.5	4.5	3	4.1	T625 0483	T626 0483
0635	1/4	28	2B	2	62	19	30	6.0	4.5	3	5.5	T625 0635	T626 0635
0794	5/16	24	2B	3	70	22	-	6.1	5.0	3	6.9	T625 0794	T626 0794
0953	3/8	24	2B	3	75	24	-	7.0	5.5	3	8.5	T625 0953	T626 0953
1270	1/2	20	2B	3	85	29	-	9.0	7.0	3	11.5	T625 1270	T626 1270
1588	5/8	18	2B	3	95	32	-	12.5	10.0	4	14.5	T625 1588	T626 1588
1905	3/4	16	2B	3	105	37	-	14.0	11.0	4	17.5	T625 1905	T626 1905
2540	1	12	2B	3	120	45	-	20.0	15.0	4	23.3	T625 2540	T626 2540

ISO	P												M			K						N									S										H					
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14.1	14.2	14.3	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37.1	37.2	37.3	37.4	37.5	38.1	38.2	39.1	39.2	40	41
T625	●	●	○	○		●	○			○							○	○	○	○	○	○	●	●	○	○		○	○																			
T626	●	●	●	●	○	●	●	○		●		○		○	○	○	○	○	○	○	○	○																										

P Steel 钢件 M Stainless Steel 不锈钢 K Cast Iron 铸铁 N Non-Ferrous Metals 有色金属 S Titanium & Super Alloys 钛合金及超级合金 H Hard Materials 淬火钢 ● Optimal 非常适合 ○ Effective 适合

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