

螺丝攻牙钻孔直径对照表

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	1.576
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
M3.5×0.6	2.90	3.010	2.850
M4.0×0.7	3.30	3.422	3.242
M4.5×0.75	3.80	3.878	3.688
M5.0×0.8	4.20	4.334	4.134
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
M33×3.5	29.50	29.771	29.211
M36×4.0	32.00	32.270	31.670
M39×4.0	35.00	35.270	34.670

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	11.599	11.459
M14×1.5	12.50	15.676	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
M35×3.0	33.00	33.252	32.752
M36×2.0	34.00	34.210	33.835
M36×1.5	34.50	34.676	34.376

美制挤牙丝攻钻孔径

规格	精度	最大	最小
1 -64UNC	5	1.76	1.68
2 -56	4	2.04	1.96
3 -48	4	2.35	2.25
4 -40	5	2.64	2.54
5 -40	5	2.97	2.87
6 -32	5	3.22	3.11
8 -32	6	3.89	3.78
10 -24	6	4.44	4.30
12 -24	6	5.07	4.96
1/4" -20	7	5.86	5.73
5/16" -18	7	7.38	7.23
3/8" -16	7	8.89	8.72
7/16" -14	8	10.40	10.02
1/2" -13	8	11.92	11.70
0 -80UNF	5	1.45	1.39
1 -72	5	1.77	1.70
2 -64	4	2.06	1.98
3 -56	4	2.37	2.29
4 -48	5	2.68	2.59
5 -44	5	2.99	2.90
6 -40	5	3.29	3.19
8 -36	5	3.91	3.81
10 -32	6	4.53	4.44
12 -28	6	5.13	5.03
1/4" -28	7	6.00	5.91
5/16" -24	7	7.53	7.42
3/8" -24	7	9.10	8.99
7/16" -20	8	10.62	10.48
1/2" -20	8	12.20	12.06

公制挤牙丝攻钻孔径

规格	精度	最大	最小
M1.0×0.25	4	0.92	0.89
M1.2×0.25	4	1.12	1.09
M1.4×0.30	4	1.30	1.26
M1.6×0.35	4	1.47	1.42
M1.7×0.35	4	1.57	1.52
M1.8×0.35	4	1.67	1.62
M2.0×0.40	4	1.84	1.79
M2.2×0.45	5	2.04	1.97
M2.3×0.40	4	2.14	2.09
M2.5×0.45	5	2.34	2.27
M2.6×0.45	5	2.44	2.37
M3.0×0.50	5	2.82	2.75
M3.5×0.60	5	3.27	3.19
M4.0×0.70	6	3.72	3.65
M5.0×0.80	6	4.67	4.59
M6.0×1.0	7	5.59	5.49
M7.0×1.0	7	6.59	6.49
M8.0×1.25	7	7.49	7.36
M10×1.50	7	9.34	9.22
M10×1.25	7	8.49	8.35
M12×1.75	8	11.23	11.09
M12×1.25	9	11.50	11.36

英制螺纹

规格	标准径	钻孔径	
		硬材	软材
W1/8 -40	2.65	2.60	
W5/32 -32	3.25	3.20	
W3/16 -24	3.75	3.70	
W1/4 -20	5.10	5.00	
W5/16 -18	6.60	6.50	
W3/8 -16	8.00	7.90	
W7/16 -14	9.40	9.30	
W1/2 -12	10.70	10.50	
W9/16 -12	12.30	12.00	
W5/8 -11	13.70	13.50	
W3/4 -10	16.70	16.50	
W7/8 -9	19.50	19.30	
W1 -8	22.40	22.00	
W1-1/8 -7	25.00	24.80	
W1-1/4 -7	28.30	28.00	

英制电器螺纹

规格	钻孔径
2BA	4.0 - 4.2
3BA	3.4 - 3.6
4BA	3.0 - 3.2
5BA	2.7 - 2.8
6BA	2.4 - 2.5

针车用螺纹

规格	标准径	最大	最小
SM1/16 -80	1.25	1.281	1.211
SM5/64 -64	1.55	1.593	1.513
SM3/32 -56	1.9	1.936	1.841
SM3/32 -100	2.1	2.156	2.081
SM1/8 -32	2.3	(2.393)	(2.233)
SM1/8 -40	2.5	2.551	2.421
SM1/8 -44	2.5	2.605	2.485
SM1/8 -48	2.6	2.657	2.547
SM9/64 -32	2.7	(2.790)	(2.630)
SM9/64 -40	2.9	2.948	2.818
SM11/64 -32	3.5	3.584	3.424
SM11/64 -40	3.7	3.742	3.612
SM3/16 -24	3.6	3.658	3.498
SM3/16 -28	3.8	3.844	3.684
SM3/16 -32	3.9	3.980	3.820
SM3/16 -40	4.05	4.138	4.008
SM7/32 -32	4.7	4.774	4.614
SM15/64 -28	5.0	5.055	4.875
SM1/4 -24	5.2	5.266	5.086
SM1/4 -28	5.4	5.452	5.272
SM1/4 -40	5.6	5.726	5.596
SM9/32 -20	5.7	5.824	5.634
SM9/32 -28	6.2	6.256	6.066
SM5/16 -18	6.3	6.444	6.254
SM5/16 -24	6.8	6.864	6.674
SM5/16 -28	6.9	7.050	6.860
SM11/32 -28	7.7	7.843	7.653
SM3/8 -18	7.9	8.053	7.843
SM3/8 -28	8.5	8.637	8.447
SM7/16 -16	9.3	9.440	9.220
SM7/16 -28	10.1	10.224	10.034
SM1/2 -12	10.3	10.420	10.180
SM1/2 -20	11.3	11.410	11.190
SM1/2 -28	11.7	11.812	11.622
SM9/16 -20	12.9	13.018	12.778

英制管螺纹

PS 规格 新规格(Rp)	标准径	最大	最小
1/16 -28	6.5	6.632	6.490
1/8 -28	8.5	8.637	8.495
1/4 -19	11.4	11.549	11.341
3/8 -19	14.9	15.054	14.846
1/2 -14	18.6	18.773	18.489
3/4 -14	24.0	24.259	23.975
1 -11	30.2	30.472	30.110
1-1/4-11	38.8	39.133	38.771
1-1/2-11	44.7	45.026	44.664
2 -11	56.5	56.837	56.475

PF 规格 新规格(G)	标准径	最大	最小
1/16 -28	6.7	6.483	6.561
1/8 -28	8.7	8.848	8.566
1/4 -19	11.7	11.890	11.445
3/8 -19	15.2	15.395	14.950
1/2 -14	19.0	19.172	18.631
5/8 -14	21.0	21.128	20.587
3/4 -14	24.5	24.658	24.117
7/8 -14	28.2	28.418	27.877
1 -11	30.6	30.931	30.291
1-1/8-11	35.2	35.579	34.939
1-1/4-11	39.2	39.592	38.952
1-1/2-11	45.0	45.485	44.845
1-3/4-11	51.0	51.428	50.788
2 -11	57.0	57.296	56.656

美制管螺纹

规格	钻孔径		
	使用 铰刀时	不用 铰刀时	NPS
1/16 -27	5.94	6.15	6.35
1/8 -27	8.33	8.43	8.74
1/4 -18	10.72	11.13	11.13
3/8 -18	14.27	14.27	14.68
1/2 -14	17.48	17.86	18.26
3/4 -14	22.63	23.01	23.42
1 -11-1/21	28.58	28.98	29.36
1-1/4 -11-1/2	37.31	37.69	38.10
1-1/2 -11-1/2	43.26	43.66	44.45
2 -11-1/2	55.17	55.58	56.36

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	1.50	1.521	1.483
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	2.085	2.029
M2.5×0.35	2.20	2.221	2.121
M2.6×0.35	2.20	2.321	2.221
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	3.559	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	5.599	5.459
M7.0×0.75	6.30	6.378	6.188