

# 盛上げタップ (タフレット) の下穴径表

## Drill Hole for Forming Taps (TAFLET)

### メートルねじの下穴径とタフレット精度番号

Hole sizes for Metric threads and tap limit of TAFLET

呼 び Nominal size	ピッチ pitch	2級用 精度番号 Limit for Class 2	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
			100%	90%	80%	70%
M1	0.25	4	0.86	0.87	0.89	0.90
	0.2	3	0.89	0.90	0.91	0.92
M1.1	0.25	4	0.96	0.97	0.99	1.00
	0.2	3	0.99	1.00	1.01	1.02
M1.2	0.25	4	1.06	1.07	1.09	1.10
	0.2	3	1.09	1.10	1.11	1.12
M1.4	0.3	4	1.23	1.25	1.26	1.28
	0.2	3	1.29	1.30	1.31	1.32
M1.6	0.35	4	1.40	1.42	1.44	1.46
	0.2	3	1.49	1.50	1.51	1.52
M1.7	0.35	4	1.50	1.52	1.54	1.56
	0.2	4	1.59	1.60	1.61	1.62
M1.8	0.35	4	1.60	1.62	1.64	1.66
	0.2	3	1.69	1.70	1.71	1.72
M2	0.4	4	1.77	1.80	1.82	1.84
	0.25	4	1.86	1.87	1.89	1.91
M2.2	0.45	4	1.94	1.97	2.00	2.02
	0.25	4	2.06	2.07	2.09	2.10
M2.3	0.4	4	2.07	2.10	2.12	2.14
	0.25	4	2.16	2.17	2.19	2.20
M2.5	0.45	4	2.24	2.27	2.30	2.32
	0.35	4	2.30	2.32	2.34	2.36
M2.6	0.45	4	2.34	2.37	2.40	2.42
	0.35	5	2.40	2.42	2.44	2.46
M3	0.6	5	2.66	2.69	2.73	2.76
	0.5	5	2.72	2.74	2.77	2.80
	0.35	5	2.80	2.82	2.84	2.86
M3.5	0.6	5	3.16	3.19	3.23	3.26
	0.35	5	3.30	3.32	3.34	3.36
M4	0.75	6	3.57	3.62	3.66	3.70
	0.7	6	3.60	3.64	3.68	3.72
	0.5	6	3.72	3.74	3.77	3.80
M4.5	0.75	6	4.07	4.12	4.16	4.20
	0.5	6	4.22	4.24	4.27	4.30
M5	0.9	6	4.49	4.54	4.59	4.64
	0.8	6	4.55	4.59	4.64	4.68
	0.5	6	4.72	4.74	4.77	4.80
M5.5	0.9	6	4.99	5.04	5.09	5.14
	0.5	6	5.22	5.24	5.27	5.30
M6	1	7	5.43	5.49	5.55	5.60
	0.75	6	5.57	5.62	5.66	5.70
	0.5	6	5.72	5.74	5.77	5.80
M7	1	7	6.43	6.49	6.55	6.60
	0.75	6	6.57	6.62	6.66	6.70
	0.5	6	6.72	6.74	6.77	6.80
M8	1.25	7	7.29	7.36	7.43	7.50
	1	7	7.43	7.49	7.55	7.60
	0.75	7	7.57	7.62	7.66	7.70
	0.5	6	7.72	7.74	7.77	7.80

呼 び Nominal size	ピッチ pitch	2級用 精度番号 Limit for Class 2	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
			100%	90%	80%	70%
M9	1.25	7	8.29	8.36	8.43	8.50
	1	7	8.43	8.49	8.55	8.60
	0.75	7	8.57	8.62	8.66	8.70
M10	0.5	6	8.72	8.74	8.77	8.80
	1.5	7	9.15	9.23	9.32	9.40
M11	1.25	7	9.29	9.36	9.43	9.50
	1	7	9.43	9.49	9.55	9.60
	0.75	7	9.57	9.62	9.66	9.70
M12	0.5	6	9.72	9.74	9.77	9.80
	1.5	10	10.15	10.23	10.32	10.40
	1	8	10.43	10.49	10.55	10.60
M13	0.75	8	10.57	10.62	10.66	10.70
	1.75	8	11.01	11.11	11.21	11.31
	1.5	8	11.15	11.23	11.32	11.40
M14	1.25	8	11.29	11.36	11.43	11.50
	1	8	11.43	11.49	11.55	11.60
	2	10	12.87	12.98	13.09	13.21
M15	1.5	9	13.15	13.23	13.32	13.40
	1.25	8	13.29	13.36	13.43	13.50
	1	8	13.43	13.49	13.55	13.60
M16	1.5	9	14.15	14.23	14.32	14.40
	1	8	14.43	14.49	14.55	14.60
	2	10	14.87	14.98	15.09	15.21
M17	1.5	9	15.15	15.23	15.32	15.40
	1	8	15.43	15.49	15.55	15.60
	1.5	11	16.15	16.23	16.32	16.40
M18	1	9	16.43	16.49	16.55	16.60
	2.5	11	16.58	16.72	16.87	17.01
	2	11	16.87	16.98	17.09	17.21
M19	1.5	10	17.15	17.23	17.32	17.40
	1	9	17.43	17.49	17.55	17.60
	2.5	11	18.58	18.72	18.87	19.01
M20	2	11	18.87	18.98	19.09	19.21
	1.5	10	19.15	19.23	19.32	19.40
	1	9	19.43	19.49	19.55	19.60
M21	2.5	11	20.58	20.72	20.87	21.01
	2	11	20.87	20.98	21.09	21.21
	1.5	10	21.15	21.23	21.32	21.40
M22	1	9	21.43	21.49	21.55	21.60
	2	11	22.87	22.98	23.09	23.21
	1.5	10	23.15	23.23	23.32	23.40
M23	1	9	23.43	23.49	23.55	23.60

[注]

1. 下穴径は試し加工の上決めてください。この表の寸法は参考寸法です。
2. 精度番号はめねじ公差の80%を目標に決めてあります。

Note:

1. Determine hole diameter by tapping test. The dimensions in this table are for reference only.
2. Tap limit is determined with 80% of the tolerance at the internal thread as an aim.

# 盛上げタップ(タフレット)の下穴径表 Drill Hole for Forming Taps (TAFLET)

## ユニファイねじの下穴径とタフレット精度番号

Hole sizes for Unified threads and tap limit of TAFLET

呼び Nominal size	2B級用 精度番号 Limit for Class 2B	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
No. 1-64 UNC	4	1.63	1.65	1.67	1.70
No. 2-56	4	1.93	1.95	1.98	2.00
No. 3-48	4	2.21	2.24	2.27	2.30
No. 4-40 UNC	5	2.49	2.52	2.56	2.59
No. 5-40	5	2.82	2.85	2.89	2.92
No. 6-32	5	3.05	3.10	3.14	3.19
No. 8-32 UNC	6	3.72	3.76	3.81	3.85
No.10-24	6	4.23	4.29	4.35	4.41
No.12-24	6	4.89	4.95	5.01	5.07
1/4-20 UNC	6	5.63	5.70	5.77	5.85
5/16-18	7	7.14	7.22	7.30	7.38
3/8-16	7	8.62	8.71	8.80	8.89
7/16-14 UNC	8	10.08	10.19	10.29	10.39
1/2-13	8	11.59	11.70	11.81	11.92
9/16-12	10	13.09	13.21	13.33	13.45
5/8-11 UNC	11	14.55	14.68	14.81	14.94
3/4-10	12	17.61	17.75	17.90	18.04

呼び Nominal size	2B級用 精度番号 Limit for Class 2B	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
No. 0-80 UNF	3	1.34	1.36	1.38	1.40
No. 1-72	4	1.65	1.67	1.69	1.71
No. 2-64	4	1.96	1.98	2.00	2.03
No. 3-56 UNF	4	2.26	2.28	2.31	2.34
No. 4-48	5	2.54	2.57	2.60	2.63
No. 5-44	5	2.85	2.88	2.91	2.95
No. 6-40 UNF	5	3.15	3.18	3.22	3.25
No. 8-36	6	3.77	3.81	3.85	3.89
No.10-32	6	4.38	4.42	4.47	4.51
No.12-28 UNF	6	4.97	5.02	5.07	5.13
1/4-28	6	5.84	5.89	5.94	5.99
5/16-24	7	7.34	7.40	7.46	7.52
3/8-24 UNF	7	8.92	8.98	9.04	9.10
7/16-20	8	10.39	10.46	10.54	10.61
1/2-20	8	11.98	12.05	12.12	12.20
9/16-18 UNF	9	13.49	13.57	13.65	13.73
5/8-18	9	15.06	15.14	15.22	15.30
3/4-16	10	18.15	18.24	18.33	18.42
7/8-14	11	21.20	21.30	21.40	21.50

## ミシンねじの下穴径とタフレット精度番号

Hole sizes for sewing machine threads and tap limit of TAFLET

呼び Nominal size	ピッチ pitch	2級用 精度番号 Limit for Class 2	ひっかり率別下穴径 (mm) Percentage of thread engagement hole diameter (mm)			
			100%	90%	80%	70%
SM 3/32	56	4	-	2.10	2.13	2.17
SM 1/8	48	5	-	2.85	2.89	2.92
	44	5	-	2.82	2.86	2.90
	40	5	-	2.79	2.83	2.87
SM 5/64	40	5	-	3.18	3.23	3.27
SM 1/64	40	6	-	3.98	4.02	4.06
	32	6	-	3.88	3.93	3.99
SM 3/16	40	6	-	4.37	4.42	4.46
	32	6	-	4.28	4.33	4.38
	28	6	-	4.21	4.27	4.33
	24	6	-	4.11	4.19	4.26
SM 19/64	32	6	-	4.67	4.73	4.78
SM 7/32	32	6	-	5.07	5.12	5.18
SM 15/64	28	6	-	5.40	5.46	5.52
SM 1/4	40	6	-	5.96	6.00	6.05
	28	6	-	5.79	5.86	5.92
	24	6	-	5.70	5.77	5.85
	20	7	-	6.59	6.65	6.71
SM 9/32	20	7	-	6.37	6.45	6.54
	28	7	-	7.38	7.44	7.51
	24	7	-	7.29	7.36	7.43
SM 11/32	18	7	-	7.07	7.17	7.27
	28	7	-	8.18	8.24	8.30
	28	7	-	8.97	9.03	9.09
SM 3/8	28	7	-	8.97	9.03	9.09
	18	8	-	8.66	8.75	8.85
SM 7/16	28	8	-	10.56	10.62	10.68
	16	8	-	10.14	10.25	10.36
SM 1/2	28	8	-	12.14	12.21	12.27
	20	8	-	11.92	12.01	12.10
	12	9	-	11.40	11.55	11.69
SM 9/16	20	9	-	13.51	13.60	13.68

[注]

1. 下穴径は試し加工の上決めてください。この表の寸法は参考寸法です。

2. 精度番号はめねじ公差の80%を目標に決めてあります。

Note:

1. Determine hole diameter by tapping test. The dimensions in this table are for reference only.

2. Tap limit is determined with 80% of the tolerance at the internal thread as an aim.

TECHNICAL DATA & STANDARDS  
技術解説・各種資料

盛上げタップ(タフレット)の下穴径表  
Drill Hole for Forming Taps (TAFLET)

# 盛上げタップ(タフレット)の下穴径表

## Drill Hole for Forming Taps (TAFLET)

### ワイトねじの下穴径とタフレット精度番号

Hole sizes for Whitworth threads and tap limit of TAFLET

呼 び Nominal size	2級用 精度番号 Limit for Class 2	ひっかり率別下穴径 (mm)			
		Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
W 1/16 - 60	4	-	1.35	1.38	1.40
3/32 - 48	4	-	2.09	2.12	2.15
1/8 - 40	5	-	2.82	2.86	2.90
W 5/32 - 32	6	-	3.53	3.58	3.62
3/16 - 24	6	-	4.17	4.24	4.30
7/32 - 24	6	-	4.97	5.03	5.10
W 1/4 - 20	6	-	5.64	5.72	5.80
5/16 - 18	7	-	7.15	7.24	7.33
3/8 - 16	8	-	8.64	8.74	8.84
W 7/16 - 14	8	-	10.10	10.21	10.33
1/2 - 12	9	-	11.52	11.65	11.78
9/16 - 12	9	-	13.11	13.24	13.37
W 5/8 - 11	9	-	14.59	14.73	14.87
3/4 - 10	9	-	17.63	17.79	17.95

### 管用平行ねじの下穴径とタフレット精度番号

Hole sizes for parallel pipe taps and tap limit of TAFLET

呼 び Nominal size	A級用 精度番号 Limit for Class A	ひっかり率別下穴径 (mm)			
		Percentage of thread engagement hole diameter (mm)			
		100%	90%	80%	70%
G(PF) 1/8 - 28	6	9.17	9.22	9.28	9.33
1/4 - 19	8	12.33	12.41	12.49	12.58
3/8 - 19	8	15.83	15.92	16.00	16.08
1/2 - 19	9	19.83	19.94	20.06	20.17

[注]

1. 下穴径は試し加工の上決めてください。この表の寸法は参考寸法です。
2. 精度番号はめねじ公差の80%を目標に決めてあります。

Note:

1. Determine hole diameter by tapping test. The dimensions in this table are for reference only.
2. Tap limit is determined with 80% of the tolerance at the internal thread as an aim.