

富士丝攻之HL级精度说明

HTD HL级精度是应用于我们工厂生产丝攻的牙距和直径而制定的, 跟据丝攻的牙距不同, HL级精度分为A和B两种类的。(The HL Limit is applied to most of taps manufactured by us as a system of pitch diameter limits. The HL Limit system has two types, A and B, and they are depending on the pitch of taps.)

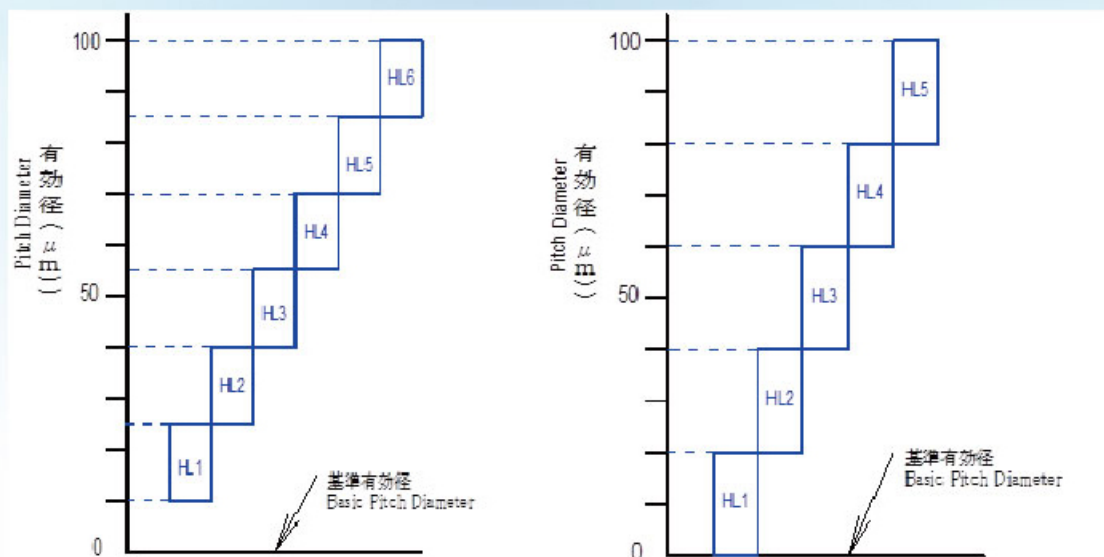


图-1: A Type ($P \leq 0.6$)

图-2: B Type ($P \geq 0.7$)

HL精度与JIS螺纹的精度

— : JIS 2级 — : ISO 2

有效径基准位置 (Basic Pitch Dia.)	公差范围 Tolerance zone (单位 unit: μm)													
	10	20	30	40	50	60	70	80	90	100	110	120	130	140
$P \leq 0.6$	HL1 HL2 HL3 HL4 HL5 HL6													
M 2 × 0.4	[JIS 2级: 10-20] [ISO 2: 20-35]													
M 2.5 × 0.45	[JIS 2级: 10-25] [ISO 2: 25-40]													
M 3 × 0.5	[JIS 2级: 10-30] [ISO 2: 30-45]													
M 3.5 × 0.6	[JIS 2级: 10-35] [ISO 2: 35-50]													
$P \geq 0.7$	HL1 HL2 HL3 HL4 HL5 HL6													
M 4 × 0.7	[JIS 2级: 10-40] [ISO 2: 40-55]													
M 5 × 0.8	[JIS 2级: 10-45] [ISO 2: 45-60]													
M 6 × 1	[JIS 2级: 10-50] [ISO 2: 50-65]													
M 8 × 1.25	[JIS 2级: 10-60] [ISO 2: 60-75]													
M 10 × 1.5	[JIS 2级: 10-70] [ISO 2: 70-85]													
M 12 × 1.75	[JIS 2级: 10-80] [ISO 2: 80-95]													
M 14 × 2	[JIS 2级: 10-90] [ISO 2: 90-105]													
M 16 × 2	[JIS 2级: 10-100] [ISO 2: 100-115]													
M 18 × 2.5	[JIS 2级: 10-110] [ISO 2: 110-125]													
M 20 × 2.5	[JIS 2级: 10-120] [ISO 2: 120-135]													
M 22 × 2.5	[JIS 2级: 10-130] [ISO 2: 130-145]													
M 24 × 3	[JIS 2级: 10-140] [ISO 2: 140-155]													