

内螺纹底孔表 (Drill size for tapping)

SM 针车螺纹

Screw Threads for Sewing Machines

(单位 : mm)

Tap size	Drillsize	(Max)	%
1/16 - 80	1.25	1.281	75
5/64 - 64	1.55	1.592	78
3/32	- 100	2.10	75
	- 56	1.90	
1/8	- 44	2.50	80
		2.50	
9/64 - 40	2.90	2.948	80
11/64	3.70	3.742	
3/16	- 32	3.90	75
	- 28	3.80	
7/32 - 32	4.70	4.774	
15/64 - 28	5.00	5.055	
SM 1/4	- 40	5.60	75
	- 28	5.40	
	- 24	5.20	5.266
9/32	- 28	6.20	75
	- 20	5.80	
	- 28	6.90	7.05
5/16	- 24	6.80	80
	- 18	6.30	
3/8	- 28	8.50	75
	- 18	8.00	
7/16	- 28	10.10	75
	- 16	9.30	
1/2	- 28	11.70	75
	- 20	11.30	
	- 12	10.30	83

英制螺纹

Whitworth Coarse Screw Threads

(单位 : mm)

Tap size	zore A	%	zore B	%
1/4 - 20	5.10	75	5	80
5/16 - 18	6.60		6.5	
3/8 - 16	8.00			
7/16 - 14	9.40		9.3	
1/2 - 12	10.70		10.5	
9/16 - 12	12.30		12	
5/8 - 11	13.70		13.5	
3/4 - 10	16.70		16.5	
7/8 - 9	19.50		19.3	
1" - 8	22.40		22	
1"1/8 - 7	25.00	80	24.8	85
	1"1/4		28.30	
1"3/8 - 6	30.50		30.3	
1"1/2 - 5	33.80		33.5	
1"5/8 - 4	36.00		35.7	
1"3/4 - 4	39.20		39	
1"7/8 - 3	41.80		41.5	
2" - 2	45.00		44.7	