

金屬加工時螺紋底孔直徑參考

The diameter of the thread bottom hole during metal machining as reference

◆ 公制普通螺紋

Metric general screw thread

螺紋代號 Symbol of thread	鑽頭直徑 Drill bit Dia.	
	ASP60A	Carbide
M1.0*0.25	0.75	0.75
M1.1*0.25	0.85	0.85
M1.2*0.25	0.95	0.95
M1.4*0.3	1.10	1.10
M1.6*0.35	1.25	1.30
M1.7*0.35	1.35	1.40
M1.8*0.35	1.45	1.50
M2.0*0.4	1.60	1.65
M2.2*0.45	1.75	1.80
M2.3*0.4	1.90	1.95
M2.5*0.45	2.10	2.15
M2.6*0.45	2.15	2.20
M3.0*0.5	2.50	2.55
M3.5*0.6	2.90	2.95
M4.0*0.7	3.3	3.4
M4.5*0.75	3.8	3.9
M5.0*0.8	4.2	4.3
M6.0*1.0	5.0	5.1
M7.0*1.0	6.0	6.1
M8.0*1.25	6.8	6.9
M9.0*1.25	7.8	7.9
M10.0*1.5	8.5	8.7
M11.0*1.5	9.5	9.7
M12.0*1.75	10.3	10.5
M14.0*2.0	12.0	12.2
M16.0*2.0	14.0	14.2
M18.0*2.5	15.5	15.7
M20.0*2.5	17.5	17.7
M22.0*2.5	19.5	19.7
M24.0*3.0	21.0	—
M27.0*3.0	24.0	—
M30.0*3.5	26.5	—
M33.0*3.5	29.5	—
M36.0*4.0	32.0	—
M39.0*4.0	35.0	—
M42.0*4.5	37.5	—
M45.0*4.5	40.5	—
M48.0*5.0	43.0	—

◆ 公制細牙螺紋

Metric fine thread

螺紋代號 Symbol of thread	鑽頭直徑 Drill bit Dia.	
	ASP60A	Carbide
M1.0*0.2	0.80	0.80
M1.1*0.2	0.90	0.90
M1.2*0.2	1.00	1.00
M1.4*0.2	1.20	1.20
M1.6*0.2	1.40	1.40
M1.8*0.2	1.60	1.60
M2.0*0.25	1.75	1.75
M2.2*0.25	1.95	2.00
M2.5*0.35	2.20	2.20
M3.0*0.35	2.70	2.70
M3.5*0.35	3.20	3.20
M4.0*0.5	3.50	3.55
M4.5*0.5	4.00	4.05
M5.0*0.5	4.50	4.55
M5.5*0.5	5.00	5.05
M6.0*0.75	5.30	5.35
M7.0*0.75	6.30	6.35
M8.0*1.0	7.00	7.10
M8.0*0.75	7.30	7.35
M9.0*1.0	8.00	8.10
M9.0*0.75	8.30	8.35
M10.0*1.25	8.80	8.90
M10.0*1.0	9.00	9.10
M10.0*0.75	9.30	9.35
M11.0*1.0	10.0	10.1
M11.0*0.75	10.3	10.3
M12.0*1.5	10.5	10.7
M12.0*1.25	10.8	10.9
M12.0*1.0	11.0	11.1
M14.0*1.5	12.5	12.7
M14.0*1.0	13.0	13.1
M15.0*1.5	13.5	13.7
M15.0*1.0	14.0	14.1
M16.0*1.5	14.5	14.7
M16.0*1.0	15.0	15.1
M17.0*1.5	15.5	15.7
M17.0*1.0	16.0	16.1
M18.0*2.0	16.0	16.3
M18.0*1.5	16.5	16.7
M18.0*1.0	17.0	17.1
M20*2.0	18.0	18.3
M20*1.5	18.5	18.7
M20*1.0	19.0	19.1
M22*2.0	20.0	—
M22*1.5	20.5	—
M22*1.0	21.0	—
M24*2.0	22.0	—

螺紋代號 Symbol of thread	鑽頭直徑 Drill bit Dia.	
	ASP60A	Carbide
M24*1.5	22.5	—
M24*1.0	23.0	—
M25*2.0	23.0	—
M25*1.5	23.5	—
M25*1.0	24.0	—
M26*1.5	24.5	—
M27*2.0	25.0	—
M27*1.5	25.5	—
M27*1.0	26.0	—
M28*2.0	26.0	—
M28*1.5	26.5	—
M28*1.0	27.0	—
M30*3.0	27.0	—
M30*2.0	28.0	—
M30*1.5	28.5	—
M30*1.0	29.0	—
M32*2.0	30.0	—
M32*1.5	30.5	—
M33*3.0	30.0	—
M33*2.0	31.0	—
M33*1.5	31.5	—
M35*1.5	33.5	—
M36*3.0	33.0	—
M36*2.0	34.0	—
M36*1.5	34.5	—
M38*1.5	36.5	—
M39*3.0	36.0	—
M39*2.0	37.0	—
M39*1.5	37.5	—
M40*3.0	37.0	—
M40*2.0	38.0	—
M40*1.5	38.5	—
M42*4.0	38.0	—
M42*3.0	39.0	—
M42*2.0	40.0	—
M42*1.5	40.5	—
M45*4.0	41.0	—
M45*3.0	42.0	—
M45*2.0	43.0	—
M45*1.5	43.5	—
M48*4.0	44.0	—
M48*3.0	45.0	—
M48*2.0	46.0	—
M48*1.5	46.5	—
M50*3.0	47.0	—
M50*2.0	48.0	—
M50*1.5	48.5	—

螺紋代號 Symbol of thread	鑽頭直徑 Drill bit Dia.	
	ASP60A	Carbide
No.1-64UNC	1.55	—
No.2-56UNC	1.80	—
No.3-48UNC	2.10	—
No.4-40UNC	2.30	—
No.5-40UNC	2.60	—
No.6-32UNC	2.80	—
No.8-32UNC	3.40	—
No.10-24UNC	3.90	—
No.12-24UNC	4.50	—
1/4-20UNC	5.10	—
5/16-18UNC	6.60	—
3/8-16UNC	8.00	—
7/16-14UNC	9.40	—
1/2-13UNC	10.80	—
9/16-12UNC	12.20	—
5/8-11UNC	13.60	—
3/4-10UNC	16.50	—
7/8-9UNC	19.50	—
1-8UNC	22.20	—
1 1/8-7UNC	25.00	—

螺紋代號 Symbol of thread	鑽頭直徑 Drill bit Dia.	
	ASP60A	Carbide
No.0-80UNF	1.25	—
No.1-72UNF	1.55	—
No.2-64UNF	1.85	—
No.3-56UNF	2.10	—
No.4-48UNF	2.40	—
No.5-44UNF	2.70	—
No.6-40UNF	2.90	—
No.8-36UNF	3.50	—
No.10-32UNF	4.10	—
No.12-28UNF	4.60	—
1/4-28UNF	5.50	—
5/16-24UNF	6.90	—
3/8-24UNF	8.50	—
7/16-20UNF	9.90	—
1/2-20UNF	11.50	—
9/16-18UNF	12.90	—
5/8-18UNF	14.50	—
3/4-16UNF	17.50	—
7/8-14UNF	20.50	—
1-12UNF	23.20	—

注：使用此表鑽孔時，據加工條件不同，所鑽孔的尺寸精度有所變化，可以測量實際加工後孔徑尺寸與精度，若底孔不適合則需改變鑽頭直徑。
 Remark: When drilling holes according to this table, the size precision of drilled holes will change depending on machining conditions. Hole diameter and precision can be measured after actual machining. If the bottom hole is not appropriate, drill bit diameter shall be changed.