

NACHI

ST SERIES

NEW

材料から熱処理、製造まで、SG、Hyper Z タップの技術を継承。
汎用領域で卓越した安定性と長寿命を実現。

汎用タップにて、この性能。
汎用タップの新たな基準へ。



ST SERIES **NEW**

汎用タップにて、この性能。
汎用タップの新たな基準へ。

Acquire the good performance in spite of multipurpose Tap
This is new standard of multi tap

- 材料から熱処理、製造まで、
当社既存タップシリーズのSGタップ、Hyper Z タップの技術を継承
- 汎用性を重視した最適形状の設計
- 加工設備、ツーリング、被削材を選ばない、バラつきの少ない安定加工
- 卓越した長寿命

- From materials to heat treatment and manufacturing, our SG tap, Hyper Z tap technology was inherited
- Optimized design for multipurpose usage
- Not influenced by equipment, stable tapping, less fluctuation of quality
- Long tool life



長寿命化

Long tool life



他社品に比べ、2倍を超える工具寿命を発揮

It has twice the tool life compared with competitor's tap



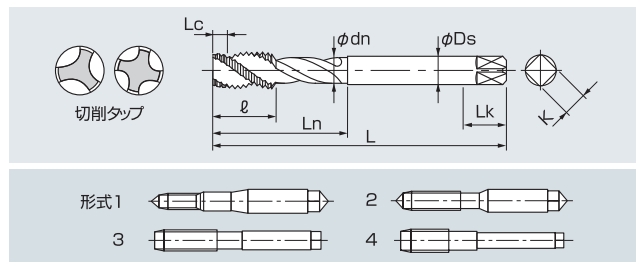
他社品を超える工具寿命と安定加工を実現

ST Tap realizes tool life and stable processing than competitor's tap



STスパイラルタップ

ST Spiral Tap



LIST 6866 オーダ方法 Order **STSP** 記号 Code No.

単位 (Unit):mm

| 記号 Code No. | 呼び Thread Size | 等級 TAP Limit | 食付(P) Lc (P) | 全長 L | ねじ長 ℓ | 溝数 Flutes | シャンク径 Ds | 首下長さ Ln | 首径 dn | 形式 Type | 在庫 Stock | 参考価格(円) Price (¥) |
|----------------|-------------------|-----------------|-----------------|---------|----------|--------------|-------------|------------|----------|------------|-------------|----------------------|
| 2MO.4R | M2×0.4 | REG P1 | 2.5 | 40 | 9.0 | 3 | 3.0 | 15 | 2.1* | 1 | ● | 1,870 |
| 2MO.4R+1 | | REG+1 P2 | | | | | | | | | | 1,870 |
| 2.5MO.45R | M2.5×0.45 | REG P1 | 2.5 | 44 | 10.0 | 3 | 3.0 | 16 | 2.7* | 1 | ● | 1,470 |
| 2.5MO.45R+1 | | REG+1 P2 | | | | | | | | | | 1,470 |
| 2.6MO.45R | M2.6×0.45 | REG P1 | 2.5 | 44 | 10.0 | 3 | 3.0 | 16 | 2.7* | 1 | ● | 1,310 |
| 2.6MO.45R+1 | | REG+1 P2 | | | | | | | | | | 1,310 |
| 3MO.5R | M3×0.5 | REG P2 | 2.5 | 46 | 5.0 | 3 | 4.0 | 18 | 2.4 | 2 | ● | 1,050 |
| 3MO.5R+1 | | REG+1 P3 | | | | | | | | | | 1,050 |
| 3.5MO.6R | M3.5×0.6 | REG P2 | 2.5 | 48 | 6.0 | 3 | 4.0 | 18 | 2.8 | 2 | ● | 1,130 |
| 3.5MO.6R+1 | | REG+1 P3 | | | | | | | | | | 1,130 |
| 4MO.7R | M4×0.7 | REG P2 | 2.5 | 52 | 7.0 | 3 | 5.0 | 20 | 3.1 | 2 | ● | 1,000 |
| 4MO.7R+1 | | REG+1 P3 | | | | | | | | | | 1,000 |
| 5MO.8R | M5×0.8 | REG P2 | 2.5 | 60 | 8.0 | 3 | 5.5 | 22 | 4.0 | 2 | ● | 1,030 |
| 5MO.8R+1 | | REG+1 P3 | | | | | | | | | | 1,030 |
| 6M1R | M6×1 | REG P2 | 2.5 | 62 | 12.0 | 3 | 6.0 | 29 | 4.75 | 2 | ● | 1,100 |
| 6M1R+1 | | REG+1 P3 | | | | | | | | | | 1,100 |
| 6MO.75R | M6×0.75 | REG P2 | 2.5 | 62 | 9.2 | 3 | 6.0 | 29 | 5.05 | 2 | ● | 1,490 |
| 6MO.75R+1 | | REG+1 P3 | | | | | | | | | | 1,490 |
| 7M1R | M7×1 | REG P2 | 2.5 | 65 | 12.0 | 3 | 6.2 | 29 | 5.75 | 3 | ● | 1,460 |
| 7M1R+1 | | REG+1 P3 | | | | | | | | | | 1,460 |
| 8M1.25R | M8×1.25 | REG P3 | 2.5 | 70 | 15.4 | 3 | 6.2 | 33 | 6.55 | 4 | ● | 1,610 |
| 8M1.25R+1 | | REG+1 P4 | | | | | | | | | | 1,610 |
| 8M1R | M8×1 | REG P2 | 2.5 | 70 | 12.4 | 3 | 6.2 | 27 | 6.75 | 4 | ● | 2,010 |
| 8M1R+1 | | REG+1 P3 | | | | | | | | | | 2,010 |
| 8M1R+2 | REG+2 P4 | 2,010 | | | | | | | | | | |
| 10M1.5R | M10×1.5 | REG P3 | 2.5 | 75 | 18.9 | 3 | 7.0 | 37 | 8.25 | 4 | ● | 2,030 |
| 10M1.5R+1 | | REG+1 P4 | | | | | | | | | | 2,030 |
| 10M1.25R | M10×1.25 | REG P3 | 2.5 | 75 | 15.7 | 3 | 7.0 | 33 | 8.55 | 4 | ● | 2,030 |
| 10M1.25R+1 | | REG+1 P4 | | | | | | | | | | 2,030 |
| 10M1R | M10×1 | REG P2 | 2.5 | 75 | 12.4 | 3 | 7.0 | 27 | 8.75 | 4 | ● | 2,550 |
| 10M1R+1 | | REG+1 P3 | | | | | | | | | | 2,550 |
| 10M1R+2 | REG+2 P4 | 2,550 | | | | | | | | | | |
| 12M1.75R | M12×1.75 | REG P3 | 2.5 | 82 | 22.4 | 3 | 8.5 | 42 | 9.95 | 4 | ● | 2,820 |
| 12M1.75R+1 | | REG+1 P4 | | | | | | | | | | 2,820 |
| 12M1.5R | M12×1.5 | REG P3 | 2.5 | 82 | 20.9 | 3 | 8.5 | 40 | 10.25 | 4 | ● | 2,820 |
| 12M1.5R+1 | | REG+1 P4 | | | | | | | | | | 2,820 |
| 12M1.25R | M12×1.25 | REG P3 | 2.5 | 82 | 17.2 | 3 | 8.5 | 35 | 10.55 | 4 | ● | 2,820 |
| 12M1.25R+1 | | REG+1 P4 | | | | | | | | | | 2,820 |
| 14M2R | M14×2 | REG P2 | 2.5 | 88 | 25.9 | 3 | 10.5 | 46 | 11.65 | 4 | ● | 3,840 |
| 14M2R+2 | | REG+2 P4 | | | | | | | | | | 3,840 |
| 14M1.5R | M14×1.5 | REG P2 | 2.5 | 88 | 20.9 | 3 | 10.5 | 40 | 12.25 | 4 | ● | 3,840 |
| 14M1.5R+2 | | REG+2 P4 | | | | | | | | | | 3,840 |
| 16M2R | M16×2 | REG P2 | 2.5 | 95 | 25.9 | 3 | 12.5 | 49 | 13.65 | 4 | ● | 5,120 |
| 16M2R+2 | | REG+2 P4 | | | | | | | | | | 5,120 |
| 16M1.5R | M16×1.5 | REG P2 | 2.5 | 95 | 20.9 | 3 | 12.5 | 40 | 14.25 | 4 | ● | 5,120 |
| 16M1.5R+2 | | REG+2 P4 | | | | | | | | | | 5,120 |
| 18M2.5R | M18×2.5 | REG P3 | 2.5 | 100 | 32.6 | 4 | 14.0 | 55 | 15.15 | 4 | ● | 7,000 |
| 18M2.5R+2 | | REG+2 P5 | | | | | | | | | | 7,000 |
| 18M1.5R | M18×1.5 | REG P2 | 2.5 | 100 | 20.9 | 4 | 14.0 | 40 | 16.25 | 4 | ● | 7,000 |
| 18M1.5R+2 | | REG+2 P4 | | | | | | | | | | 7,000 |
| 20M2.5R | M20×2.5 | REG P3 | 2.5 | 105 | 32.6 | 4 | 15.0 | 55 | 17.15 | 4 | ● | 9,080 |
| 20M2.5R+2 | | REG+2 P5 | | | | | | | | | | 9,080 |
| 20M1.5R | M20×1.5 | REG P2 | 2.5 | 105 | 20.9 | 4 | 15.0 | 40 | 18.25 | 4 | ● | 9,080 |
| 20M1.5R+2 | | REG+2 P4 | | | | | | | | | | 9,080 |
| 22M2.5R | M22×2.5 | REG P3 | 2.5 | 115 | 32.6 | 4 | 17.0 | 55 | 19.15 | 4 | ● | 11,800 |
| 22M2.5R+2 | | REG+2 P5 | | | | | | | | | | 11,800 |
| 22M1.5R | M22×1.5 | REG P2 | 2.5 | 115 | 20.9 | 4 | 17.0 | 40 | 20.25 | 4 | ● | 11,800 |
| 22M1.5R+2 | | REG+2 P4 | | | | | | | | | | 11,800 |
| 24M3R | M24×3 | REG P3 | 2.5 | 120 | 38.8 | 4 | 19.0 | 63 | 20.65 | 4 | ● | 14,700 |
| 24M3R+2 | | REG+2 P5 | | | | | | | | | | 14,700 |
| 24M1.5R | M24×1.5 | REG P2 | 2.5 | 120 | 22.4 | 4 | 19.0 | 50 | 22.25 | 4 | ● | 14,700 |
| 24M1.5R+2 | | REG+2 P4 | | | | | | | | | | 14,700 |

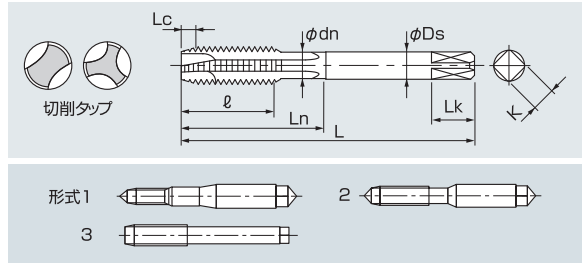
* 呼び径<首径です。めねじ加工深さが深い場合、ねじ長以上入れると折損の危険があります。

* Thread Size < Neck diameter (dn) When depth of cutting a female thread is deep, if putting the screw length or more in length, there is a risk of breakage.

● 形式1~2は突出しセンター ● Type 1~2 with External Centre

STポイントタップ

ST Point Tap



LIST 6868 オーダ方法 Order STPO 商品 Code No.

単位 (Unit):mm

| 記号 Code No. | 呼び Thread Size | 等級 TAP Limit | 食付(P) Lc (P) | 全長 L | ねじ長 ℓ | 溝数 Flutes | シャンク径 Ds | 首下長さ Ln | 首径 dn | 形式 Type | 在庫 Stock | 参考価格(円) Price (¥) |
|----------------|-------------------|-----------------|-----------------|---------|----------|--------------|-------------|------------|----------|------------|-------------|----------------------|
| 2MO.4R | M2×0.4 | REG P1 | 5 | 40 | 9.0 | 2 | 3.0 | 15 | 2.1* | 1 | ● | 1,940 |
| 2MO.4R+1 | M2×0.4 | REG+1 P2 | | | | | | | | | | 1,940 |
| 2.5MO.45R | M2.5×0.45 | REG P2 | 5 | 44 | 10.0 | 2 | 3.0 | 16 | 2.7* | 1 | ● | 1,530 |
| 2.5MO.45R+1 | M2.5×0.45 | REG+1 P3 | | | | | | | | | | 1,530 |
| 2.6MO.45R | M2.6×0.45 | REG P2 | 5 | 44 | 10.0 | 2 | 3.0 | 16 | 2.7* | 1 | ● | 1,350 |
| 2.6MO.45R+1 | M2.6×0.45 | REG+1 P3 | | | | | | | | | | 1,350 |
| 3MO.5R | M3×0.5 | REG P2 | 5 | 46 | 11.0 | 3 | 4.0 | 18 | 2.4 | 2 | ● | 1,080 |
| 3MO.5R+1 | M3×0.5 | REG+1 P3 | | | | | | | | | | 1,080 |
| 3.5MO.6R | M3.5×0.6 | REG P2 | 5 | 48 | 13.0 | 3 | 4.0 | 18 | 2.8 | 2 | ● | 1,170 |
| 3.5MO.6R+1 | M3.5×0.6 | REG+1 P3 | | | | | | | | | | 1,170 |
| 4MO.7R | M4×0.7 | REG P2 | 5 | 52 | 13.0 | 3 | 5.0 | 20 | 3.1 | 2 | ● | 1,030 |
| 4MO.7R+1 | M4×0.7 | REG+1 P3 | | | | | | | | | | 1,030 |
| 5MO.8R | M5×0.8 | REG P2 | 5 | 60 | 16.0 | 3 | 5.5 | 22 | 4.0 | 2 | ● | 1,070 |
| 5MO.8R+1 | M5×0.8 | REG+1 P3 | | | | | | | | | | 1,070 |
| 6M1R | M6×1 | REG P2 | 5 | 62 | 17.0 | 3 | 6.0 | 28 | 4.8 | 2 | ● | 1,130 |
| 6M1R+1 | M6×1 | REG+1 P3 | | | | | | | | | | 1,130 |
| 6MO.75R | M6×0.75 | REG P2 | 5 | 62 | 14.0 | 3 | 6.0 | 28 | 4.8 | 2 | ● | 1,550 |
| 6MO.75R+1 | M6×0.75 | REG+1 P3 | | | | | | | | | | 1,550 |
| 7M1R | M7×1 | REG P2 | 5 | 65 | 17.0 | 3 | 6.2 | - | - | 3 | ● | 1,460 |
| 7M1R+1 | M7×1 | REG+1 P3 | | | | | | | | | | 1,460 |
| 8M1.25R | M8×1.25 | REG P3 | 5 | 70 | 22.0 | 3 | 6.2 | - | - | 3 | ● | 1,680 |
| 8M1.25R+1 | M8×1.25 | REG+1 P4 | | | | | | | | | | 1,680 |
| 8M1R | M8×1 | REG P2 | 5 | 70 | 17.0 | 3 | 6.2 | - | - | 3 | ● | 2,090 |
| 8M1R+1 | M8×1 | REG+1 P3 | | | | | | | | | | 2,090 |
| 8M1R+2 | M8×1 | REG+2 P4 | | | | | | | | | | 2,090 |
| 10M1.5R | M10×1.5 | REG P3 | 5 | 75 | 27.0 | 3 | 7.0 | - | - | 3 | ● | 2,120 |
| 10M1.5R+1 | M10×1.5 | REG+1 P4 | | | | | | | | | | 2,120 |
| 10M1.25R | M10×1.25 | REG P3 | 5 | 75 | 22.0 | 3 | 7.0 | - | - | 3 | ● | 2,120 |
| 10M1.25R+1 | M10×1.25 | REG+1 P4 | | | | | | | | | | 2,120 |
| 10M1R | M10×1 | REG P2 | 5 | 75 | 17.0 | 3 | 7.0 | - | - | 3 | ● | 2,650 |
| 10M1R+1 | M10×1 | REG+1 P3 | | | | | | | | | | 2,650 |
| 10M1R+2 | M10×1 | REG+2 P4 | | | | | | | | | | 2,650 |
| 12M1.75R | M12×1.75 | REG P4 | 5 | 82 | 32.0 | 3 | 8.5 | - | - | 3 | ● | 2,930 |
| 12M1.75R+1 | M12×1.75 | REG+1 P5 | | | | | | | | | | 2,930 |
| 12M1.5R | M12×1.5 | REG P3 | 5 | 82 | 28.0 | 3 | 8.5 | - | - | 3 | ● | 2,930 |
| 12M1.5R+1 | M12×1.5 | REG+1 P4 | | | | | | | | | | 2,930 |
| 12M1.25R | M12×1.25 | REG P4 | 5 | 82 | 23.0 | 3 | 8.5 | - | - | 3 | ● | 2,930 |
| 12M1.25R+1 | M12×1.25 | REG+1 P5 | | | | | | | | | | 2,930 |
| 14M2R | M14×2 | REG P4 | 5 | 88 | 32.0 | 3 | 10.5 | - | - | 3 | ● | 4,080 |
| 14M2R+1 | M14×2 | REG+1 P5 | | | | | | | | | | 4,080 |
| 14M1.5R | M14×1.5 | REG P3 | 5 | 88 | 28.0 | 3 | 10.5 | - | - | 3 | ● | 4,080 |
| 14M1.5R+1 | M14×1.5 | REG+1 P4 | | | | | | | | | | 4,080 |
| 16M2R | M16×2 | REG P4 | 5 | 95 | 32.0 | 3 | 12.5 | - | - | 3 | ● | 5,430 |
| 16M2R+1 | M16×2 | REG+1 P5 | | | | | | | | | | 5,430 |
| 16M1.5R | M16×1.5 | REG P3 | 5 | 95 | 28.0 | 3 | 12.5 | - | - | 3 | ● | 5,430 |
| 16M1.5R+1 | M16×1.5 | REG+1 P4 | | | | | | | | | | 5,430 |
| 18M2.5R | M18×2.5 | REG P4 | 5 | 100 | 37.5 | 3 | 14.0 | - | - | 3 | ● | 7,460 |
| 18M2.5R+1 | M18×2.5 | REG+1 P5 | | | | | | | | | | 7,460 |
| 18M1.5R | M18×1.5 | REG P4 | 5 | 100 | 28.0 | 3 | 14.0 | - | - | 3 | ● | 7,460 |
| 18M1.5R+1 | M18×1.5 | REG+1 P5 | | | | | | | | | | 7,460 |
| 20M2.5R | M20×2.5 | REG P4 | 5 | 105 | 37.5 | 3 | 15.0 | - | - | 3 | ● | 9,660 |
| 20M2.5R+1 | M20×2.5 | REG+1 P5 | | | | | | | | | | 9,660 |
| 20M1.5R | M20×1.5 | REG P4 | 5 | 105 | 28.0 | 3 | 15.0 | - | - | 3 | ● | 9,660 |
| 20M1.5R+1 | M20×1.5 | REG+1 P5 | | | | | | | | | | 9,660 |
| 22M2.5R | M22×2.5 | REG P4 | 5 | 115 | 37.5 | 3 | 17.0 | - | - | 3 | ● | 12,540 |
| 22M2.5R+1 | M22×2.5 | REG+1 P5 | | | | | | | | | | 12,540 |
| 22M1.5R | M22×1.5 | REG P4 | 5 | 115 | 28.0 | 3 | 17.0 | - | - | 3 | ● | 12,540 |
| 22M1.5R+1 | M22×1.5 | REG+1 P5 | | | | | | | | | | 12,540 |
| 24M3R | M24×3 | REG P4 | 5 | 120 | 45.0 | 3 | 19.0 | - | - | 3 | ● | 15,840 |
| 24M3R+1 | M24×3 | REG+1 P5 | | | | | | | | | | 15,840 |
| 24M1.5R | M24×1.5 | REG P4 | 5 | 120 | 31.0 | 3 | 19.0 | - | - | 3 | ● | 15,840 |
| 24M1.5R+1 | M24×1.5 | REG+1 P5 | | | | | | | | | | 15,840 |

* 呼び径<首径です。めねじ加工深さが深い場合、ねじ長以上入れると折損の危険があります。

* Thread Size < Neck diameter (dn) When depth of cutting a female thread is deep, if putting the screw length or more in length, there is a risk of breakage.

● 形式1~2は突出しセンター ● Type 1~2 with External Centre

被削材選定基準表・基準切削条件

Selection Chart according to Work Materials and Standard Cutting Condition

| 被削材 Work Material | 一般構造用鋼 | 低炭素鋼 | 中炭素鋼 | 高炭素鋼 | 合金鋼 | | 高硬度鋼 | ステンレス鋼 | 鋳鉄 | ダクタイル 鋳鉄 | アルミニウム 合金 | |
|--------------------------|---|-----------------------------|--------------------------------|------------------------------|-------------------------|----------|-------------------|---------------------------|--------------------------|-----------------------------|------------------------------|-------|
| | SS Structural Steel | S15C Low Carbon Steel | S40C Medium Carbon Steel | S50C High Carbon Steel | SCM, SCr Alloy Steel | | Hardened Steel | SUS Stainless Steel | FC Cast Iron | FCD Ductile Cast Iron | AC, ADC Aluminum Alloy | |
| | ~200HB | ~200HB | ~200HB | ~200HB | ~200HB | 20~30HRC | 30~40HRC | | | | | |
| STSP | 選定 Selection chart | ○ | ○ | ◎ | ○ | ○ | ○ | — | — | — | ○ | ○ |
| | 切削速度(m/min) Cutting Speed | 5~15 | 5~15 | 5~15 | 5~15 | 5~15 | 5~8 | — | — | — | 5~15 | 10~20 |
| STPO | 選定 Selection chart | ○ | ○ | ◎ | ○ | ○ | ○ | — | — | — | ○ | ○ |
| | 切削速度(m/min) Cutting Speed | 6~20 | 6~20 | 6~20 | 6~20 | 6~20 | 5~10 | — | — | — | 6~20 | 10~20 |
| 推奨切削油剤 Cutting Fluids | 極圧活性型不水溶性 水溶性 Sulfochlorinated Oil Water soluble Oil | | | | | | | | 水溶性 Water soluble Oil | | | |

- 注) 1. 表中の数値は一般的な基準であり、ご使用条件により切削条件を変更してください
 2. 表中の数値はねじ深さ2Dc(ねじの呼び径の2倍)が基準です
 1. These are general cutting condition and may be altered by your conditions.
 2. These conditions are for thread depth of 2xDc.

NACHI

株式会社 不二越

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 工具事業部 Tel:076-423-5100 Fax:076-493-5221 富山市不二越本町1-1-1 〒930-8511

営業拠点

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| 北関東支店 Tel:0276-46-7511 Fax:0276-46-4599 | 中国四国支店 Tel:082-568-7460 Fax:082-568-7465 | ㈱ナチ関西 Tel:06-7178-2200 Fax:06-7178-2201 |
| 信州営業所 Tel:0268-28-7863 Fax:0268-21-1185 | 九州支店 Tel:092-441-2505 Fax:092-471-6600 | |

困ったときのテレホンサービス

☎0120-714-159

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- お求めになる販売店をお探しには最寄りの不二越営業拠点までお問い合わせください。

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