

OH精度 OH LIMIT

OSG的专用丝锥，在满足螺纹精度的前提下，为了使操作者能够根据不同加工条件而选择丝锥精度，采用了独特的阶梯精度方式，即OH精度。

OSG applies a unique system of tap pitch diameter limits. We call it the OH Limit System. Using the step method, you can select the best tap pitch diameter limits to match your work conditions.

OH精度 OH LIMIT

几乎所有研磨丝锥都适应此精度。该精度具有JIS2级等同或同等以上的精度，根据螺距将丝锥中径按下划分。
Most of OSG's ground finished taps use this limit system. The limits are calculated as follows.

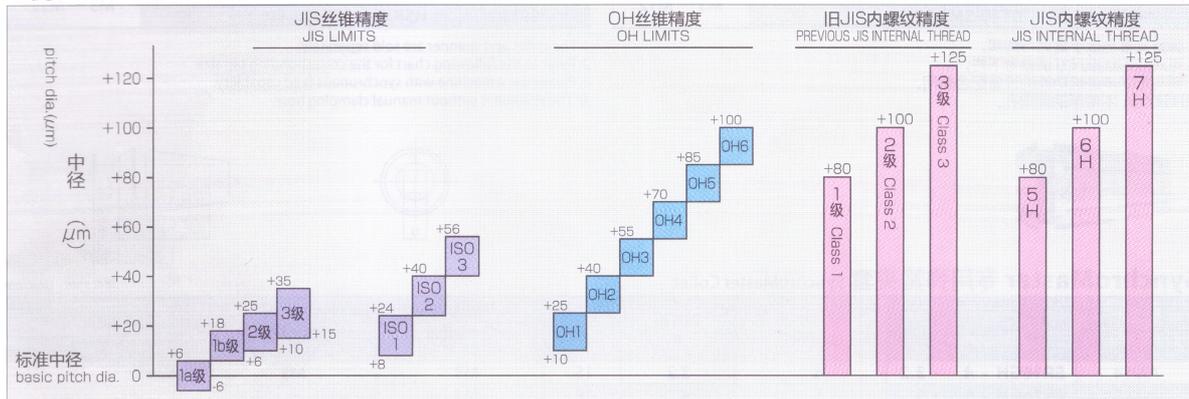
1. $P \leq 0.6$ (40牙以上) $P \leq 0.6$ (T.P.I. ≥ 40)

上公差: $0.010 + 0.015 \times n$ upper limit: $0.010 + 0.015 \times n$
下公差: 上公差 - 0.015 lower limit: (upper limit) - 0.015
单位: mm Unit: mm (n=OH号) (n=OH number)

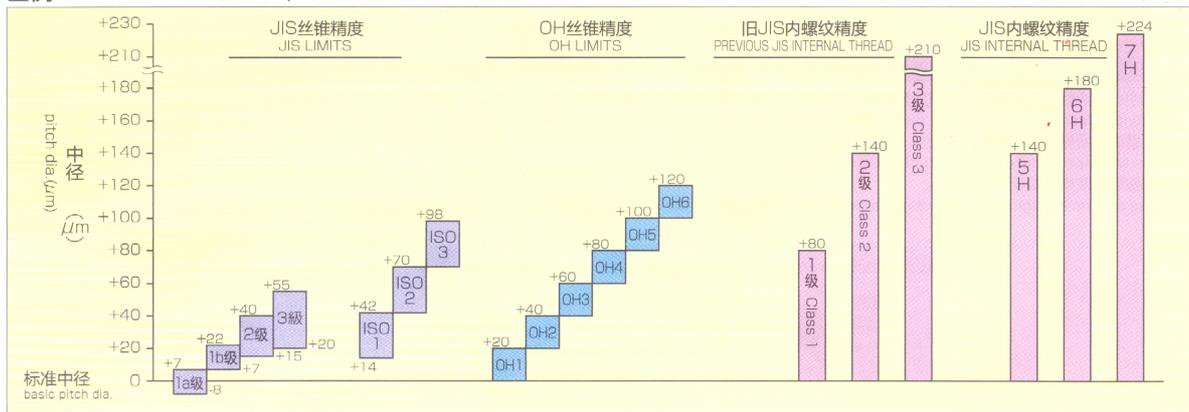
2. $P \geq 0.7$ (36牙以下) $P \geq 0.7$ (T.P.I. ≤ 36)

上公差: $0.020 \times n$ upper limit: $0.020 \times n$
下公差: 上公差 - 0.020 lower limit: (upper limit) - 0.020
单位: mm Unit: mm (n=OH号) (n=OH number)

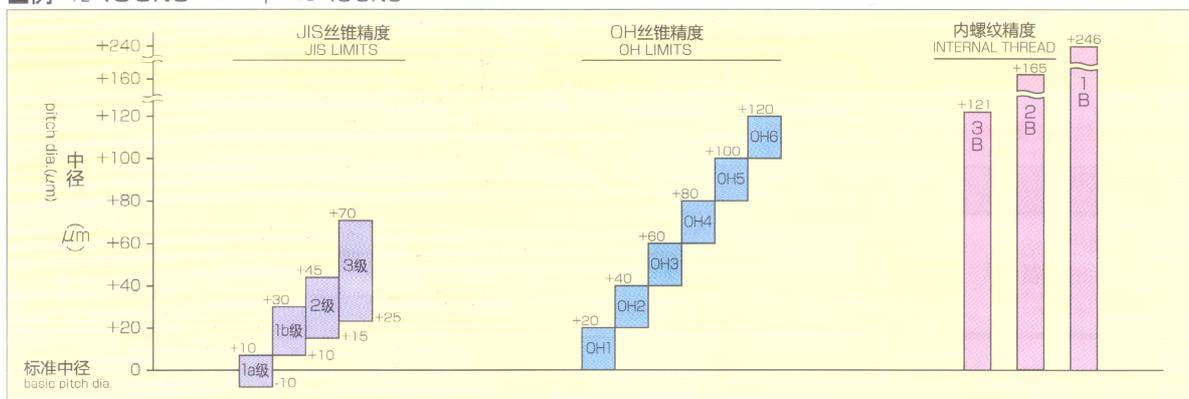
例 M3×0.5 Example M3×0.5



例 M10×1.5 Example M10×1.5



例 1/2-13UNC Example 1/2-13UNC



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ISO丝锥 ISO TAPS
锥形丝锥 CONE TAPS
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加工中心用丝锥 MACHINING CENTER TAP
一体丝锥 DRILL TAP

RH精度 RH LIMIT

OSG的挤压丝锥(NRT 丝锥, HRT 丝锥)利用塑性变形原理来加工内螺纹, OSg's fluteless taps(NRT, HRT)are described by the RH Limit system. The 其底孔管理较切削丝锥更为严格, 因而丝锥精度也要求更为严格。OSG公 limits are established in increments of 12.7μm. 司采用了公差为12.7μm。

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丝锥

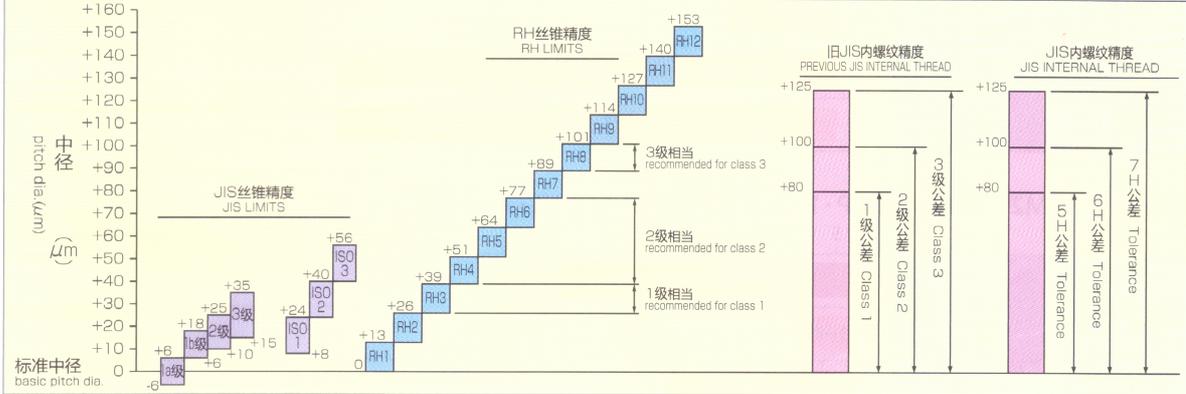
RH 精度 RH LIMIT

上公差: $0.0127 \times n$ upper limit : $0.0127 \times n$

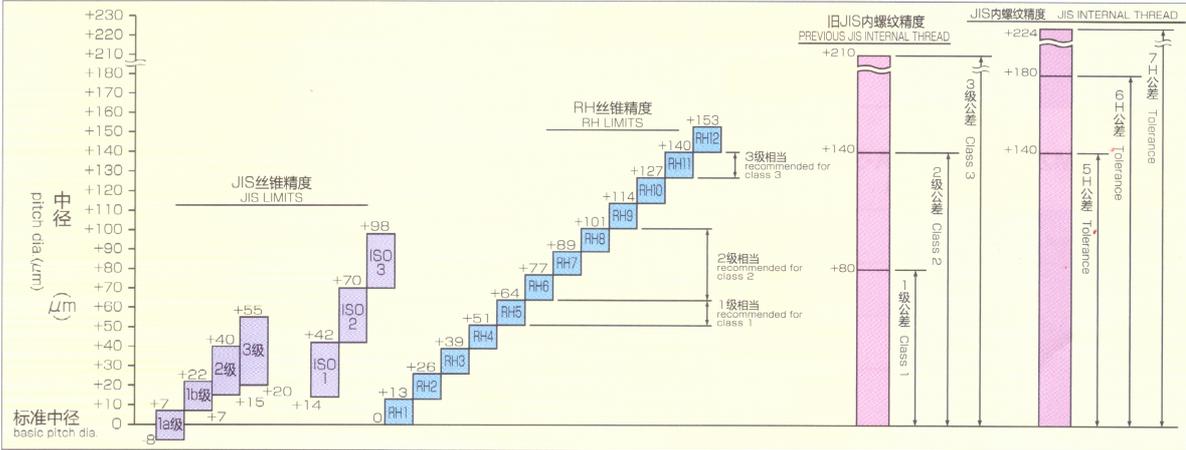
下公差: 上公差 - 0.0127 lower limit : $0.0127 \times n - 0.0127$

单位: mm Unit: mm (n=RH号) (n=RH number)

例 M3×0.5 Example M3×0.5



例 M10×1.5 Example M10×1.5



例 1/2-13UNC Example 1/2-13UNC

