

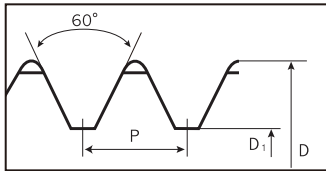
## 나사산 예비 가공 홀 직경 - 탭가공 / 스레드 밀링

### UNF ASME B1.1에 따른 미세 나사산

D 직경 Diameter	D <sub>1</sub>		
	min (mm)	max (mm)	드릴 직경 Drill Dia. (mm)
0-80 UNF	1.181	1.306	1.25
1-72 UNF	1.473	1.613	1.55
2-64 UNF	1.755	1.913	1.85
3-56 UNF	2.024	2.197	2.15
4-48 UNF	2.271	2.459	2.40
5-44 UNF	2.550	2.741	2.70
6-40 UNF	2.819	3.023	2.95
8-36 UNF	3.404	3.607	3.50
10-32 UNF	3.962	4.166	4.10
12-28 UNF	4.496	4.724	4.60
1/4-28 UNF	5.367	5.580	5.50
5/16-24 UNF	6.792	7.038	6.90
3/8-24 UNF	8.379	8.626	8.50
7/16-20 UNF	9.738	10.030	9.90
1/2-20 UNF	11.326	11.618	11.50
9/16-18 UNF	12.761	13.084	12.90
5/8-18 UNF	14.348	14.671	14.50
3/4-16 UNF	17.330	17.689	17.50
7/8-14 UNF	20.262	20.663	20.40
1-12 UNF	23.109	23.569	23.25
1 1/8-12 UNF	26.284	26.744	26.50
1 1/4-12 UNF	29.459	29.919	29.50
1 3/8-12 UNF	32.634	33.094	33.00
1 1/2-12 UNF	35.809	36.269	36.10

### UNEF

D 직경 Diameter	D <sub>1</sub>		
	min (mm)	max (mm)	드릴 직경 Drill Dia. (mm)
No.12-32 UNEF	4.826	4.623	4.70
1/4-32 UNEF	5.689	5.487	5.60
5/16-32	7.264	7.087	7.10
3/8-32	8.864	8.662	8.70
7/16-28	10.337	10.135	10.20
1/2-28	11.938	11.710	11.80
9/16-24	13.385	13.132	13.20
5/8-24	14.986	14.732	14.80
3/4-20	17.957	17.679	17.80
7/8-20	21.132	20.854	21.00
1-20	24.307	24.029	24.10
1 1/8-18	27.381	27.051	27.20
1 1/4-18	30.556	30.226	30.30
1 3/8-18	33.731	33.401	33.50
1 1/2-18	36.906	36.576	36.70
1 5/8-18	40.081	39.751	39.80



MJ, UNJC, UNJF 도면

### UNJC ASME B1.15 및 ISO 3161에 따른 보통 나사산

D 직경 Diameter	D <sub>1</sub>		
	min (mm)	max (mm)	드릴 직경 Drill Dia. (mm)
1-64 UNJC	1.467	1.570	1.50
2-56 UNJC	1.742	1.860	1.80
3-48 UNJC	1.999	2.137	2.05
4-40 UNJC	2.226	2.391	2.30
5-40 UNJC	2.556	2.721	2.65
6-32 UNJC	2.732	2.938	2.80
8-32 UNJC	3.393	3.599	3.50
10-24 UNJC	3.795	4.064	3.90
12-24 UNJC	4.455	4.704	4.60
1/4-20 UNJC	5.113	5.387	5.20
5/16-18 UNJC	6.563	6.833	6.70
3/8-16 UNJC	7.978	8.255	8.10
7/16-14 UNJC	9.344	9.637	9.50
1/2-13 UNJC	10.796	11.093	10.90
9/16-12 UNJC	12.226	12.480	12.30
5/8-11 UNJC	13.625	13.902	13.70
3/4-10 UNJC	16.575	16.880	16.75

### MJ DIN ISO 5855에 따른 표준 나사산

D 직경 Diameter	피치 Pitch	D <sub>1</sub>		
		min (mm)	max (mm)	드릴 직경 Drill Dia. (mm)
MJ3	0.5	2.513	2.653	2.6
MJ4	0.7	3.318	3.498	3.4
MJ5	0.8	4.221	4.421	4.3
MJ6	1	5.026	5.215	5.1
MJ8	1.25	6.782	6.994	6.9
MJ10	1.5	8.539	8.779	8.7
MJ12	1.75	10.295	10.563	10.5
MJ16	2	14.051	14.351	14.3

### UNJF ASME B1.15 및 ISO 3161에 따른 미세 나사산

D 직경 Diameter	D <sub>1</sub>		
	min (mm)	max (mm)	드릴 직경 Drill Dia. (mm)
0-80 UNJF	1.215	1.297	1.25
1-72 UNJF	1.510	1.602	1.55
2-64 UNJF	1.797	1.900	1.85
3-56 UNJF	2.073	2.191	2.10
4-48 UNJF	2.329	2.467	2.40
5-44 UNJF	2.613	2.763	2.70
6-40 UNJF	2.886	3.051	2.95
8-36 UNJF	3.479	3.662	3.60
10-32 UNJF	4.053	4.253	4.15
12-28 UNJF	4.602	4.815	4.70
1/4-28 UNJF	5.466	5.662	5.60
5/16-24 UNJF	6.907	7.110	7.00
3/8-24 UNJF	8.494	8.680	8.60
7/16-20 UNJF	9.875	10.083	10.00
1/2-20 UNJF	11.463	11.660	11.50
9/16-18 UNJF	12.913	13.123	13.00
5/8-18 UNJF	14.500	14.702	14.50