

1. ねじ下穴ドリル径表 / Recommended Tap Drill Sizes

■メートルねじ用 / For Metric Threads

単位 / Unit: mm

呼び Nominal size	ドリル径 Drill Size	D _i	
		Max.	Min.
M1 ×0.25	0.75	(0.785)	(0.729)
M1 ×0.2	0.80	(0.821)	(0.783)
M1.1×0.25	0.85	(0.885)	(0.829)
M1.1×0.2	0.90	(0.921)	(0.883)
M1.2×0.25	0.95	(0.985)	(0.929)
M1.2×0.2	1.00	(1.021)	(0.983)
M1.4×0.3	1.10	(1.142)	(1.075)
M1.4×0.2	1.20	(1.221)	(1.183)
M1.6×0.35	1.25	1.321	1.221
M1.6×0.2	1.40	(1.421)	(1.383)
※M1.7×0.35	1.35	1.421	1.321
※M1.7×0.2	1.50	1.521	1.483
M1.8×0.35	1.45	1.521	1.421
M1.8×0.2	1.60	(1.621)	(1.583)
M2 ×0.4	1.60	1.679	1.567
M2 ×0.25	1.75	(1.785)	(1.729)
M2.2×0.45	1.75	1.838	1.713
M2.2×0.25	1.95	(1.985)	(1.929)
※M2.3×0.4	1.90	1.979	1.867
※M2.3×0.25	2.05	2.085	2.029
M2.5×0.45	2.1	2.138	2.013
M2.5×0.35	2.2	2.221	2.121
※M2.6×0.45	2.2	2.238	2.113
※M2.6×0.35	2.2	2.321	2.221
M3 ×0.5	2.5	2.599	2.459
M3 ×0.35	2.7	2.721	2.621
M3.5×0.6	2.9	3.010	2.850
M3.5×0.35	3.2	3.221	3.121
M4 ×0.7	3.3	3.422	3.242
M4 ×0.5	3.5	3.599	3.459
M4.5×0.75	3.8	3.878	3.688
M4.5×0.5	4.0	4.099	3.959
M5 ×0.8	4.2	4.334	4.134
M5 ×0.5	4.5	4.599	4.459
M6 ×1	5.0	5.153	4.917
M6 ×0.75	5.3	5.378	5.188
※M6 ×0.5	5.5	5.599	5.459
M7 ×1	6.0	6.153	5.917
M7 ×0.75	6.3	6.378	6.188
※M7 ×0.5	6.5	6.599	6.459
M8 ×1.25	6.8	6.912	6.647
M8 ×1	7.0	7.153	6.917

呼び Nominal size	ドリル径 Drill Size	D _i	
		Max.	Min.
M 8×0.75	7.3	7.378	7.188
※M 8×0.5	7.5	7.599	7.459
M 9×1.25	7.8	7.912	7.647
M 9×1	8.0	8.153	7.917
M 9×0.75	8.3	8.378	8.188
M10×1.5	8.5	8.676	8.376
M10×1.25	8.8	8.912	8.647
M10×1	9.0	9.153	8.917
M10×0.75	9.3	9.378	9.188
※M10×0.5	9.5	9.599	9.459
M11×1.5	9.5	9.676	9.376
M11×1	10.0	10.153	9.917
M11×0.75	10.3	10.378	10.188
※M11×0.5	10.5	10.599	10.459
M12×1.75	10.3	10.441	10.106
M12×1.5	10.5	10.676	10.376
M12×1.25	10.8	10.912	10.647
M12×1	11.0	11.153	10.917
※M12×0.5	11.5	11.599	11.459
M14×2	12.0	12.210	11.835
M14×1.5	12.5	12.676	12.376
M14×1	13.0	13.153	12.917
M15×1.5	13.5	13.676	13.376
M15×1	14.0	14.153	13.917
M16×2	14.0	14.210	13.835
M16×1.5	14.5	14.676	14.376
M16×1	15.0	15.153	14.917
M17×1.5	15.5	15.676	15.376
M17×1	16.0	16.153	15.917
M18×2.5	15.5	15.744	15.294
M18×2	16.0	16.210	15.835
M18×1.5	16.5	16.676	16.376
M18×1	17.0	17.153	16.917
M20×2.5	17.5	17.744	17.294
M20×2	18.0	18.210	17.835
M20×1.5	18.5	18.676	18.376
M20×1	19.0	19.153	18.917
M22×2.5	19.5	19.744	19.294
M22×2	20.0	20.210	19.835
M22×1.5	20.5	20.676	20.376
M22×1	21.0	21.153	20.917
M24×3	21.0	21.252	20.752

呼び Nominal size	ドリル径 Drill Size	D _i	
		Max.	Min.
M24×2	22.0	22.210	21.835
M24×1.5	22.5	22.676	22.376
M24×1	23.0	23.153	22.917
M25×2	23.0	23.210	22.835
M25×1.5	23.5	23.676	23.376
M25×1	24.0	24.153	23.917
M26×1.5	24.5	24.676	24.376
M27×3	24.0	24.252	23.752
M27×2	25.0	25.210	24.835
M27×1.5	25.5	25.676	25.376
M27×1	26.0	26.153	25.917
M28×2	26.0	26.210	25.835
M28×1.5	26.5	26.676	26.376
M28×1	27.0	27.153	26.917
M30×3.5	26.5	26.771	26.211
M30×3	27.0	27.252	26.752
M30×2	28.0	28.210	27.835
M30×1.5	28.5	28.676	28.376
M30×1	29.0	29.153	28.917
M32×2	30.0	30.210	29.835
M32×1.5	30.5	30.676	30.376
M33×3.5	29.5	29.771	29.211
M33×3	30.0	30.252	29.752
M33×2	31.0	31.210	30.835
M33×1.5	31.5	31.676	31.376
M35×1.5	33.5	33.676	33.376
M36×4	32.0	32.270	31.670
M36×3	33.0	33.252	32.752
M36×2	34.0	34.210	33.835
M36×1.5	34.5	34.676	34.376
M38×1.5	36.5	36.676	36.376
M39×4	35.0	35.270	34.670
M39×3	36.0	36.252	35.752
M39×2	37.0	37.210	36.835
M39×1.5	37.5	37.676	37.376
M40×3	37.0	37.252	36.752
M40×2	38.0	38.210	37.835
M40×1.5	38.5	38.676	38.376
M42×4.5	37.5	37.799	37.129
M42×4	38.0	38.270	37.670
M42×3	39.0	39.252	38.752
M42×2	40.0	40.210	39.835

・D_i: JIS 6H(2級)めねじ内径を表します。()内の数値は、並目ねじは5H(2級)、細目ねじは4H・5H(1級)を記載してあります。
 ・呼び※印のものはJISより削除されています。
 ・The recommended tap drill sizes indicated above are for JIS 6H (Class 2) Metric Threads.
 ・D_i: Minor diameter of JIS 6H (Class 2) internal thread. The Minor diameters D_i shown in () are of 5H (Class 2) for coarse threads and of 4H・5H (Class 1) for fine threads.
 ・※Marked sizes have been eliminated from JIS.

単位 / Unit : mm

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
M42×1.5	40.5	40.676	40.376
M45×4.5	40.5	40.799	40.129
M45×4	41.0	41.270	40.670
M45×3	42.0	42.252	41.752
M45×2	43.0	43.210	42.835
M45×1.5	43.5	43.676	43.376
M48×5	43.0	43.297	42.587
M48×4	44.0	44.270	43.670
M48×3	45.0	45.252	44.752
M48×2	46.0	46.210	45.835
M48×1.5	46.5	46.676	46.376
M50×3	47.0	47.252	46.752
M50×2	48.0	48.210	47.835
M50×1.5	48.5	48.676	48.376
M52×5	47.0	47.297	46.587
M52×4	48.0	48.270	47.670
M52×3	49.0	49.252	48.752
M52×2	50.0	50.210	49.835
M52×1.5	50.5	50.676	50.376
M55×4	51.0	51.270	50.670
M55×3	52.0	52.252	51.752
M55×2	53.0	53.210	52.835
M55×1.5	53.5	53.676	53.376
M56×5.5	50.5	50.796	50.046
M56×4	52.0	52.270	51.670
M56×3	53.0	53.252	52.752
M56×2	54.0	54.210	53.835
M56×1.5	54.5	54.676	54.376
M58×4	54.0	54.270	53.670
M58×3	55.0	55.252	54.752
M58×2	56.0	56.210	55.835
M58×1.5	56.5	56.676	56.376
M60×5.5	54.5	54.796	54.046
M60×4	56.0	56.270	55.670
M60×3	57.0	57.252	56.752
M60×2	58.0	58.210	57.835
M60×1.5	58.5	58.676	58.376
M62×4	58.0	58.270	57.670
M62×3	59.0	59.252	58.752
M62×2	60.0	60.210	59.835
M62×1.5	60.5	60.676	60.376
M64×6	58.0	58.305	57.505

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
M64×4	60.0	60.270	59.670
M64×3	61.0	61.252	60.752
M64×2	62.0	62.210	61.835
M64×1.5	62.5	62.676	62.376
M65×4	61.0	61.270	60.670
M65×3	62.0	62.252	61.752
M65×2	63.0	63.210	62.835
M65×1.5	63.5	63.676	63.376
M68×6	62.0	62.305	61.505
M68×4	64.0	64.270	63.670
M68×3	65.0	65.252	64.752
M68×2	66.0	66.210	65.835
M68×1.5	66.5	66.676	66.376
M70×6	64.0	64.305	63.505
M70×4	66.0	66.270	65.670
M70×3	67.0	67.252	66.752
M70×2	68.0	68.210	67.835
M70×1.5	68.5	68.676	68.376
M72×6	66.0	66.305	65.505
M72×4	68.0	68.270	67.670
M72×3	69.0	69.252	68.752
M72×2	70.0	70.210	69.835
M72×1.5	70.5	70.676	70.376
M75×4	71.0	71.270	70.670
M75×3	72.0	72.252	71.752
M75×2	73.0	73.210	72.835
M75×1.5	73.5	73.676	73.376
M76×6	70.0	70.305	69.505
M76×4	72.0	72.270	71.670
M76×3	73.0	73.252	72.752
M76×2	74.0	74.210	73.835
M76×1.5	74.5	74.676	74.376
M78×2	76.0	76.210	75.835
M80×6	74.0	74.305	73.505
M80×4	76.0	76.270	75.670
M80×3	77.0	77.252	76.752
M80×2	78.0	78.210	77.835
M80×1.5	78.5	78.676	78.376
M82×2	80.0	80.210	79.835
M85×6	79.0	79.305	78.505
M85×4	81.0	81.270	80.670
M85×3	82.0	82.252	81.752

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
M 85×2	83.0	83.210	82.835
M 90×6	84.0	84.305	83.505
M 90×4	86.0	86.270	85.670
M 90×3	87.0	87.252	86.752
M 90×2	88.0	88.210	87.835
M 95×6	89.0	89.305	88.505
M 95×4	91.0	91.270	90.670
M 95×3	92.0	92.252	91.752
M 95×2	93.0	93.210	92.835
M100×6	94.0	94.305	93.505
M100×4	96.0	96.270	95.670
M100×3	97.0	97.252	96.752
M100×2	98.0	98.210	97.835

- D₁: JIS 6H (2級) めねじ内径を表します。
- 呼び※印のものはJISより削除されています。
- The recommended tap drill sizes indicated above are for JIS 6H (Class 2) Metric Threads.
- D₁: Minor diameter of JIS 6H (Class 2) internal thread.
- ※: Marked sizes have been eliminated from JIS.

1. ねじ下穴ドリル径表 / Recommended Tap Drill Sizes

Production data / メーカー目録

■ ユニファイねじ用 / For Unified Threads

単位 / Unit: mm

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
No. 0-80UNF	1.25	1.305	1.182
No. 1-64UNC	1.55	1.582	1.425
No. 1-72UNF	1.55	1.612	1.474
No. 2-56UNC	1.80	1.871	1.695
No. 2-64UNF	1.85	1.912	1.756
No. 3-48UNC	2.1	2.146	1.941
No. 3-56UNF	2.1	2.197	2.025
No. 4-40UNC	2.3	2.385	2.157
No. 4-48UNF	2.4	2.458	2.271
No. 5-40UNC	2.6	2.697	2.487
No. 5-44UNF	2.7	2.740	2.551
No. 6-32UNC	2.8	2.895	2.642
No. 6-40UNF	2.9	3.022	2.820
No. 8-32UNC	3.4	3.530	3.302
No. 8-36UNF	3.5	3.606	3.404
No.10-24UNC	3.9	3.962	3.683
No.10-32UNF	4.1	4.165	3.963
No.12-24UNC	4.5	4.597	4.344
No.12-28UNF	4.6	4.724	4.496
No.12-32UNEF	4.7	4.826	4.623
1/4-20UNC	5.1	5.257	4.979
1/4-28UNF	5.5	5.588	5.360
1/4-32UNEF	5.6	5.689	5.487
5/16-18UNC	6.6	6.731	6.401
5/16-24UNF	6.9	7.035	6.782
5/16-32UNEF	7.1	7.264	7.087
3/8-16UNC	8.0	8.153	7.798
3/8-24UNF	8.5	8.636	8.382
3/8-32UNEF	8.7	8.864	8.662
7/16-14UNC	9.4	9.550	9.144

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
7/16-20UNF	9.9	10.033	9.729
7/16-28UNEF	10.2	10.337	10.135
1/2-13UNC	10.9	11.023	10.592
1/2-20UNF	11.5	11.607	11.329
1/2-28UNEF	11.8	11.938	11.710
9/16-12UNC	12.2	12.446	11.989
9/16-18UNF	12.9	13.081	12.751
9/16-24UNEF	13.2	13.385	13.132
5/8-11UNC	13.6	13.868	13.386
5/8-18UNF	14.5	14.681	14.351
5/8-24UNEF	14.8	14.986	14.732
3/4-10UNC	16.6	16.840	16.307
3/4-16UNF	17.5	17.678	17.323
3/4-20UNEF	17.8	17.957	17.679
7/8-9UNC	19.6	19.761	19.177
7/8-14UNF	20.5	20.675	20.270
7/8-20UNEF	21.0	21.132	20.854
1-8UNC	22.3	22.606	21.971
1-12UNF	23.3	23.571	23.114
1-20UNEF	24.1	24.307	24.029
1 1/8-7UNC	25.0	25.349	24.638
1 1/8-8UN	25.5	25.781	25.146
1 1/8-12UNF	26.5	26.746	26.289
1 1/8-18UNEF	27.2	27.381	27.051
1 1/4-7UNC	28.2	28.524	27.813
1 1/4-8UN	28.5	28.956	28.321
1 1/4-12UNF	29.6	29.921	29.464
1 1/4-18UNEF	30.3	30.556	30.226
1 3/8-6UNC	30.8	31.115	30.353
1 3/8-8UN	31.8	32.131	31.496

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
1 3/8-12UNF	32.8	33.096	32.639
1 3/8-18UNEF	33.5	33.731	33.401
1 1/2-6UNC	34.0	34.290	33.528
1 1/2-8UN	35.0	35.306	34.671
1 1/2-12UNF	36.0	36.271	35.814
1 1/2-18UNEF	36.6	36.880	36.576
1 5/8-8UN	38.1	38.481	37.846
1 5/8-12UN	39.1	39.446	38.989
1 5/8-18UNEF	39.8	40.081	39.751
1 3/4-5UNC	39.5	39.827	38.964
1 3/4-8UN	41.3	41.656	41.021
1 3/4-12UN	42.3	42.621	42.164
2-4 1/2 UNC	45.2	45.593	44.679
2-8UN	47.8	48.006	47.371
2-12UN	48.6	48.971	48.514
2 1/4-8UN	54.0	54.356	53.721
2 1/2-8UN	60.3	60.706	60.071
2 3/4-8UN	66.6	67.056	66.421
3-8UN	73.0	73.406	72.771

- ・ D₁: 2Bめねじ内径を表します。UNC, UNFはJIS, UNEF, UN, UNSの2Bめねじ内径D₁はANSI B1.1によっています。
- ・ The recommended tap drill sizes indicated above are for JIS Class 2B UNC & UNF threads, and ANSI B1.1 Class 2B UNEF, UN & UNS threads.
- ・ D₁: Minor diameter of internal thread.
- ・ For UNC and UNF threads, according to JIS Class 2B;
- ・ For UNEF, UN and UNS threads, according to ANSI B1.1 Class 2B.

■ ウィット並目ねじ用 / For Whitworth Coarse Threads

単位 / Unit: mm

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
※ W1/8-40	2.55	(2.591)	(2.362)
※ W3/16-24	3.70	(3.744)	(3.406)
W1/4-20	5.1	5.204	4.914
W5/16-18	6.6	6.670	6.340
W3/8-16	8.0	8.113	7.733
W7/16-14	9.4	9.508	9.048
W1/2-12	10.7	10.830	10.310

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
W 9/16-12	12.3	12.418	11.898
W 5/8-11	13.7	13.817	13.257
W 3/4-10	16.6	16.778	16.178
W 7/8-9	19.5	19.691	19.031
W1-8	22.3	22.514	21.814
W1 1/8-7	24.9	25.229	24.469
W1 1/4-7	28.0	28.404	27.644

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
W1 3/8-6	30.5	30.923	30.123
W1 1/2-6	33.6	34.098	33.298
W1 5/8-5	36.0	36.409	35.529
W1 3/4-5	39.1	39.584	38.704
W1 7/8-4 1/2	41.8	42.227	41.237
W2-4 1/2	45.0	45.402	44.412

- ・ D₁: JIS 2級めねじ内径を表します。
- ・ ウィットねじはJISより削除されています。
- ・ 呼び※印のものはBSWに準じています。
- ・ The recommended tap drill sizes indicated above are for JIS Class 2 Whitworth Threads.
- ・ D₁: Minor diameter of JIS Class 2 internal thread.
- ・ Whitworth Threads have been eliminated from JIS.
- ・ ※: Marked sizes are in accordance with BSW.

■ インサートコイルメートルねじ用 / For Metric Threads Using with Helical Coil Wire Inserts

単位 / Unit : mm

呼び Nominal size	ドリル径 Drill Size	下穴径 / Recommended Hole Size	
		Max.	Min.
M 2.5×0.45	2.6	2.65	2.60
M 2.6×0.45	2.7	2.85	2.77
M 3 ×0.5	3.1	3.20	3.12
M 4 ×0.7	4.2	4.30	4.17
M 5 ×0.8	5.2	5.33	5.16
M 6 ×1	6.3	6.42	6.25
M 8 ×1.25	8.4	8.52	8.31
M10 ×1.5	10.5	10.62	10.37
M10 ×1.25	10.4	10.52	10.31

呼び Nominal size	ドリル径 Drill Size	下穴径 / Recommended Hole Size	
		Max.	Min.
M10×1	10.3	10.42	10.25
M12×1.75	12.6	12.73	12.43
M12×1.5	12.5	12.62	12.37
M12×1.25	12.4	12.52	12.31
M14×2	14.7	14.83	14.49
M14×1.5	14.5	14.62	14.37
M14×1.25	14.4	14.52	14.31
M16×2	16.7	16.83	16.49
M16×1.5	16.5	16.62	16.37

呼び Nominal size	ドリル径 Drill Size	下穴径 / Recommended Hole Size	
		Max.	Min.
M18×2.5	18.9	19.04	18.58
M18×1.5	18.5	18.62	18.37
M20×2.5	20.9	21.04	20.58
M20×1.5	20.5	20.62	20.37
M22×2.5	22.9	23.04	22.58
M22×1.5	22.5	22.62	22.37
M24×3	25.1	25.25	24.70

・この表はインサートコイルメーカーの資料によっています。
 ・ The figures listed above are according to the data provided by helical coil wire insert manufacturers.

■ インサートコイルユニファイねじ用 / For Unified Threads Using with Helical Coil Wire Inserts

単位 / Unit : mm

呼び Nominal size	ドリル径 Drill Size	下穴径 / Recommended Hole Size	
		Max.	Min.
No. 4-40UNC	3.0	3.07	2.95
No. 4-48UNF	3.0	3.05	2.97
No. 5-40UNC	3.3	3.38	3.25
No. 6-32UNC	3.7	3.81	3.66
No. 6-40UNF	3.7	3.78	3.66
No. 8-32UNC	4.4	4.47	4.32
No. 8-36UNF	4.4	4.44	4.32
No.10-24UNC	5.1	5.21	5.05
No.10-32UNF	5.0	5.13	4.98

呼び Nominal size	ドリル径 Drill Size	下穴径 / Recommended Hole Size	
		Max.	Min.
No.12-24UNC	5.7	5.77	5.61
No.12-28UNF	5.7	5.86	5.70
1/ 4-20UNC	6.7	6.78	6.63
1/ 4-28UNF	6.6	6.71	6.53
5/16-18UNC	8.4	8.48	8.33
5/16-24UNF	8.3	8.38	8.20
3/ 8-16UNC	10.0	10.11	9.91
3/ 8-24UNF	9.8	9.96	9.78
7/16-14UNC	11.6	11.76	11.51

呼び Nominal size	ドリル径 Drill Size	下穴径 / Recommended Hole Size	
		Max.	Min.
7/16-20UNF	11.5	11.63	11.43
1/ 2-13UNC	13.1	13.34	13.08
1/ 2-20UNF	13.1	13.26	13.03
5/ 8-11UNC	16.7	16.84	16.59
5/ 8-18UNF	16.3	16.48	16.26
3/ 4-10UNC	19.9	20.09	19.84
3/ 4-16UNF	19.5	19.68	19.43

・この表はインサートコイルメーカーの資料によっています。
 ・ The figures listed above are according to the data provided by helical coil wire insert manufacturers.

■ ミシン用ねじ用 / For Sewing Machine Threads

単位 / Unit : mm

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
SM 1/16- 80	1.25	1.281	1.211
SM 5/64- 64	1.55	1.593	1.513
SM 3/32- 56	1.9	1.936	1.841
SM 3/32-100	2.1	2.156	2.081
※ SM 1/ 8- 32	2.3	(2.393)	(2.233)
SM 1/ 8- 40	2.5	2.551	2.421
SM 1/ 8- 44	2.5	2.605	2.485
SM 1/ 8- 48	2.6	2.657	2.547
※ SM 9/64- 32	2.7	(2.790)	(2.630)
SM 9/64- 40	2.9	2.948	2.818
SM 11/64- 32	3.5	3.584	3.424
SM 11/64- 40	3.7	3.742	3.612

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
SM 3/16-24	3.6	3.658	3.498
SM 3/16-28	3.8	3.844	3.684
SM 3/16-32	3.9	3.980	3.820
SM 3/16-40	4.05	4.138	4.008
SM 7/32-32	4.7	4.774	4.614
SM 15/64-28	5.0	5.055	4.875
SM 1/ 4-24	5.2	5.266	5.086
SM 1/ 4-28	5.4	5.452	5.272
SM 1/ 4-40	5.6	5.726	5.596
SM 9/32-20	5.7	5.824	5.634
SM 9/32-28	6.2	6.256	6.066
SM 5/16-18	6.3	6.444	6.254

呼び Nominal size	ドリル径 Drill Size	D ₁	
		Max.	Min.
SM 5/16-24	6.8	6.864	6.674
SM 5/16-28	6.9	7.050	6.860
SM 11/32-28	7.7	7.843	7.653
SM 3/ 8-18	7.9	8.053	7.843
SM 3/ 8-28	8.5	8.637	8.447
SM 7/16-16	9.3	9.440	9.220
SM 7/16-28	10.1	10.224	10.034
SM 1/ 2-12	10.3	10.420	10.180
SM 1/ 2-20	11.3	11.410	11.190
SM 1/ 2-28	11.7	11.812	11.622
SM 9/16-20	12.9	13.018	12.778

・ D₁: JIS 2級めねじ内径を表します。
 ・ ()内はJIS 2級相当の数値です。
 ・ 呼び※印のものはJISに規定されていません。
 ・ The recommended tap drill sizes indicated above are for JIS Class 2 Sewing Machine Threads.
 ・ D₁: Minor diameter of JIS Class 2 internal thread. The minor diameters D₁ shown in () are equivalent to JIS Class 2 internal threads.
 ・ ※Marked sizes are not specified in JIS.