



2015 A

2015 A

FENGYI 锋宜® 刀具

硬质合金螺纹刀具 Carbide Precision Threading Tools

硬质合金螺纹刀具 Carbide Precision Threading Tools



成都锋宜精密工具制造有限公司

CHENGDU FENGYI PRECISION TOOLS MANUFACTURE CO.,LTD

地址：成都市成华区龙潭都市集中工业发展区成佳路2号

销售服务热线：028-84723613

028-84723285

028-84215372-8004

技术服务热线：028-84215372-8001

销售部企业QQ：2851383350 2851383351 2851383353

2851383354 2851383369

传真：028-84722814

邮编：610052

网址：www.fengyitool.com

E-mail:plg@fengyitool.com

ADD:Longtan Industry Zone,Chenghua District,Chengdu,Sichuan Province,China.

Tel:

+862884215371

+862884723613

+862884723285

Fax:

+862884722814

P.C:610052

web:www.fengyitool.com

E-mail:plg@fengyitool.com

阿里巴巴国际站

Alibaba English International Website

<http://fengyitool.en.alibaba.com/>

阿里巴巴中国站

Alibaba Chinese Website

<http://fengyitool.1688.com/>



官方微信



官方微博

FENGYI 锋宜® 刀具

公司概况

COMPANY PROFILE

成都锋宜精密工具制造有限公司创建于1997年。多年来对螺纹刀具、石油管螺纹刀具、数控可转位刀具、轴承刀具及非标成型刀具进行不断的研究开发，行成了规模化的专业生产能力，走过了以螺纹刀具为主要发展方向，并配套生产数控刀具及其它成型刀具的独具特色的成长之路，并逐步得到了市场认可。产品质量稳定，达到了国际先进水平。2006年4月顺利通过了ISO9001：2000质量管理体系认证，2010年被认定为高新技术企业。

公司位于四川省成都市龙潭都市工业集中发展区，占地10亩。毗邻成都大熊猫繁育基地，地理位置优越、环境优美。现拥有员工140人，各种精密加工检测设备100多套。包括引进瑞士Ewag Compact line, 德国Deckel S22E, 德国Walter BASIC高精度五轴数控工具磨床、英国进口的全自动刀片钝化设备以及国产的周边磨床。年产各种螺纹及梳刀片二百多万片。是国内可转位螺纹车削刀片，可转位螺纹铣削刀片，整体硬质合金螺纹铣刀，石油管螺纹刀片的最大供应商。是国内螺纹刀具品种规格最全的供应商。是少有的能完全独立配套生产刀杆及配件的螺纹刀具生产商。公司奉行以提供专业化，全方位的技术服务为特色的经营模式，深受新老客户的欢迎。

在严酷的市场竞争形式下，我们将发挥自强不息，奋发有为的创业精神；发扬“一心专注，精心磨砺”的工作作风。以国际优秀螺纹刀具为目标，不断研发新产品，提高产品质量，创硬质合金螺纹刀具优质品牌，以满足国内外用户的需求。相信通过我们的努力，定能成为你良好的合作伙伴。

Chengdu Fengyi Precision Tool Manufacture Co.,Ltd has been founded since 1997. The company has constantly devoted to the research and development of metric, British, and American system thread tools, oil pipe thread tools, NC cutting tools and tool holders, bearing cutting tools and special profile tools. Fengyi has built up its capacity for specialized mass production, and concentrates on thread tool development with complimentary development of NC tools and other profile tools. Its product quality and performance have ensured international market standards and presence. The company was awarded ISO9001:2000 certificate in 2006 and Hi-Tech enterprise certificate in 2010.

Fengyi is located in the Longtan Industrial Zone of Chengdu, Sichuan. Situated in natural geographical surrounding, adjacent to the Chengdu Giant Panda Breeding Centre, Fengyi occupies 6700 square meters, employs 140 employees, and owns more than 100 sets of precision machining and test equipment including CNC 5 axes grinding machines Compact Line from Ewag company in Switzerland and BASIC from Walter company and SE22 from Deckel company in Germany. Recently, more high-tech equipments have been brought in to strengthen Fengyi's production lines, such as honing machine from Vapormatt in England and all-automatic peripheral grinding machine from domestic China, etc. The company produces more than two million inserts yearly, and is China's largest suppliers for metric/British/American system thread turning inserts ,milling inserts , solid carbide thread mills and oil pipe thread inserts . Fengyi uniquely offers a full product line of whole kinds of thread inserts, tool holders and accessories, and supplies its customers with full technical support.

In a competitive market environment, Fengyi applies its pioneering spirit, self-discipline, and determination and relentlessly pursue perfection in order to achieve its goal: excellence in the field of thread tools manufacture. Fengyi is constantly developing innovative products and improving product quality to meet customer demand and expectations. We are certain that Fengyi will be a satisfying business partner, and we look forward to doing business with you.



CONTENT

目录







A	螺纹车削刀具	
	THREADING TURNING TOOLS	2
	螺纹车削刀片 Threading Turning Inserts	3-41
	螺纹车削刀杆 Threading Turning Toolholders	42-49
	螺纹刀具套装 Threading Kit	50
B	铣削螺纹刀具	
	THREADING MILLING TOOLS	51
	H系列螺纹铣削刀具 H Line Threading Milling Tools	52-71
	W系列螺纹铣削刀具 W Line Threading Milling Tools	72-86
	整体硬质合金螺纹铣刀 Solid Carbide Threading Mills	87-117
C	石油管螺纹刀具	
	THREADING TOOLS FOR OIL PIPES	118
	石油管螺纹刀片 Threading Inserts for Oil Pipes	119-145
	石油管螺纹刀杆 Toolholders for Oil Pipes	146-196
D	技术资料	
	TECHNICAL INFORMATION	197-220

螺纹车削刀具 THREADING TURNING TOOLS



螺纹车削刀具 THREADING TURNING TOOLS

可转位螺纹车刀刀片型号说明 Threading Turning Insert Ordering Code System

1、刀片尺寸 Insert Size		2、刀片形式 Insert Style		3、刀片类型 Type of Insert		4、螺纹旋向 RH/LH Insert	
L(mm)	D			E 外螺纹 External		R 右旋螺纹 Right Hand Insert	
06	5/32"			N 内螺纹 Internal		L 左旋螺纹 Left Hand Insert	
08	3/16" (φ5)	标准型 Standard	X型 X Style				
11	1/4"						
16	3/8"			E	N		
22	1/2"						
27	5/8"						
		U型 U Style	立装型 V Style				

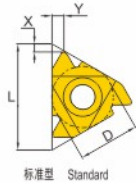
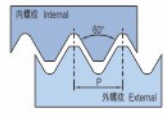
16		E	R	1.5	ISO		
16	X	E	R	1.5	ISO		
22		N	R	1.5	ISO	3	M
27	V	N	R	3.0	ISO		
27	U	E		8.0	TR		
1	2	3	4	5	6	7	8

5、螺距 Pitch		6、螺纹标准 Thread Standard		7、齿数 (对梳齿型M) No. of Teeth (for Multitooth Style)	
完全形 Full Profile Pitch Range		60° —— 60° 通用型螺纹 Partial profile 60° 55° —— 55° 通用型螺纹 Partial profile 55° ISO —— ISO 标准型螺纹 ISO Metric		2 3 5 6 8	
mm	TPI	UN —— 60° 美制统一标准型螺纹 American UN UNJ —— 60° 美制航空航天螺纹 Aviation thread W —— 55° 英国惠氏螺纹 Whitworth for BSW BSP NPT —— 60° 美国标准锥管螺纹 NPT NPTF —— 60° 美国干密封管螺纹 NPTF BSPT —— 55° 英制标准锥管螺纹 British Standard Pipe Thread		8、梳齿的刀片型式 Insert Style of Multitooth	
0.5~6	48~4	ACME —— 美制29° 梯形螺纹 American ACME STACME —— 美制29° 短齿梯形螺纹 American Stub ACME TR —— 30° 标准梯形螺纹 Trapez DIN 103 ABUT —— 美制锯齿形螺纹 American Buttress BBUT —— 英制锯齿形螺纹 British Buttress RD —— 消防食品机械圆螺纹 Round DIN 405 RD20400 —— 消防食品机械圆螺纹 Round DIN 20400 APIRD —— API 圆螺纹 API Round Casing & Tubing BUT —— API 扁梯扣螺纹 API Buttress Casing Pg —— Pg 螺纹			
局部面载顶形 Partial Profile Pitch Range				M	
A	0.5~1.5 48~16				
AG	0.5~3.0 48~8				
G	1.75~3.0 14~8				
N	3.5~5.0 7~5				
Q	5.5~6.0 4.5~4				
V	6.0~10 4~2.5				

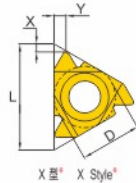


60° 通用型螺纹刀片 Partial Profile 60°

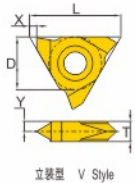
外螺纹 External



标准型 Standard



X 型* X Style*



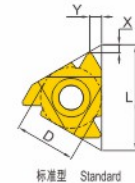
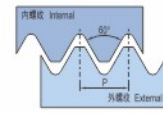
立装型 V Style

	内接圆直径D	加工螺距范围 Pitch		刀片型号 Ordering Code		刀片尺寸 Dimension			
		mm	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	0.5-1.5	48-16	11ER A60	11EL A60	11	0.80	0.90	3.20
				16ER A60	16EL A60	16	0.80	0.90	3.65
	3/8"	0.5-3.0	48-8	16ER AG60	16EL AG60	16	1.20	1.70	3.65
				16ER G60	16EL G60	16	1.20	1.70	3.65
	1/2"	3.5-5.0	7-5	22ER N60	22EL N60	22	1.70	2.50	4.76
				27ER Q60	27EL Q60	27	2.10	3.10	6.35
X 型* X style	3/8"	0.5-1.5	48-16	16XER A60	16XEL A60	16	0.80	0.90	4.30
				16XER AG60	16XEL AG60	16	1.20	1.70	4.30
	1/2"	3.5-5.0	7-5	22XER N60	22XEL N60	22	1.70	2.50	5.90
	5/8"	6.0-10	4-2.5	27XER V60	27VEL V60	27	0.6	5.2	10.0

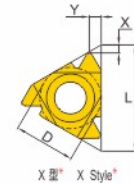
* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.

60° 通用型螺纹刀片 Partial Profile 60°

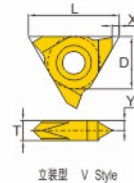
内螺纹 Internal



标准型 Standard



X 型* X Style*



立装型 V Style

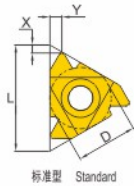
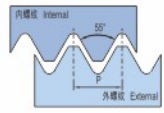
	内接圆直径D	加工螺距范围 Pitch		刀片型号 Ordering Code		刀片尺寸 Dimension				
		mm	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
标准型 Standard	5/32"	0.5-1.25	48-20	06NR A60	06NL A60	6	0.6	0.6	1.90	
	3/16"	0.5-1.5	48-16	08NR A60	08NL A60	8	0.6	0.7	2.20	
	1/4"	0.5-1.5	48-16	11NR A60	11NL A60	11	0.8	0.9	3.20	
				16NR A60	16NL A60	16	0.8	0.9	3.65	
	3/8"	0.5-3.0	48-8	16NR AG60	16NL AG60	16	1.2	1.7	3.65	
				16NR G60	16NL G60	16	1.2	1.7	3.65	
	1/2"	3.5-5.0	7-5	22NR N60	22NL N60	22	1.7	2.5	4.76	
	5/8"	5.5-6.0	4.5-4	27NR Q60	27NL Q60	27	1.8	2.7	6.35	
	X 型* X style	1/4"	0.5-1.5	48-16	11XNR A60	11XNL A60	11	0.8	0.9	3.39
					16XNR A60	16XNL A60	16	0.8	0.9	4.30
		3/8"	0.5-3.0	48-8	16XNR AG60	16XNL AG60	16	1.2	1.7	4.30
					16XNR G60	16XNL G60	16	1.2	1.7	4.30
1/2"		3.5-5.0	7-5	22XNR N60	22XNL N60	22	1.7	2.5	5.90	
立装型 V style	5/8"	6.0-10	4-2.5	27VNR V60	27VNL V60	27	0.6	5.2	8.70	

* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.

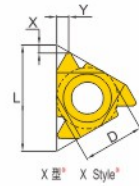


55° 通用型螺纹刀片 Partial Profile 55°

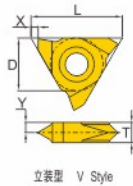
外螺纹 External



标准型 Standard



X型* X Style*



立装型 V Style

标准型 Standard



X型 X style



立装型 V style

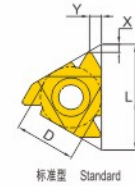
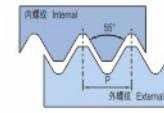


	内接圆直径D	加工螺距范围 Pitch		刀片型号 Ordering Code		刀片尺寸 Dimension			
		mm	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	0.5~1.5	48~16	11ER A55	11EL A55	11	0.8	0.9	3.20
		0.5~1.5	48~16	16ER A55	16EL A55	16	0.8	0.9	3.65
	3/8"	0.5~3.0	48~8	16ER AG55	16EL AG55	16	1.2	1.7	3.65
		1.75~3.0	14~8	16ER G55	16EL G55	16	1.2	1.7	3.65
	1/2"	3.5~5.0	7~5	22ER N55	22EL N55	22	1.7	2.5	4.76
	5/8"	5.5~6.0	4.5~4	27ER Q55	27EL Q55	27	2.0	2.9	6.35
X型 X style	3/8"	0.5~1.5	48~16	16XER A55	16XEL A55	16	0.8	0.9	4.30
		0.5~3.0	48~8	16XER AG55	16XEL AG55	16	1.2	1.7	4.30
	1/2"	1.75~3.0	14~8	16XER G55	16XEL G55	16	1.2	1.7	4.30
		3.5~5.0	7~5	22XER N55	22XEL N55	22	1.7	2.5	5.90
	5/8"	6.0~9	4~2.5	27XER V55	27VEL V55	27	1	4.3	8.70

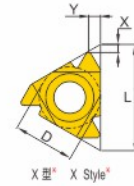
- * 可装在Sandvik Coromat刀杆上
- * Can be fixed in the toolholders of Sandvik Coromat.

55° 通用型螺纹刀片 Partial Profile 55°

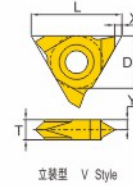
内螺纹 Internal



标准型 Standard



X型* X Style*



立装型 V Style

标准型 Standard



X型 X style



立装型 V style

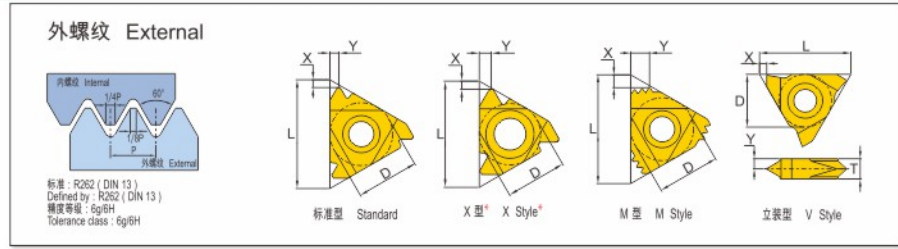


	内接圆直径D	加工螺距范围 Pitch		刀片型号 Ordering Code		刀片尺寸 Dimension				
		mm	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
标准型 Standard	5/32"	0.5~1.25	48~20	06NR A55	06NL A55	6	0.6	0.6	1.90	
		0.5~1.5	48~16	08NR A55	08NL A55	8	0.6	0.7	2.20	
	1/4"	0.5~1.5	48~16	11NR A55	11NL A55	11	0.8	0.9	3.20	
		0.5~1.5	48~16	16NR A55	16NL A55	16	0.8	0.9	3.65	
	3/8"	0.5~3.0	48~8	16NR AG55	16NL AG55	16	1.2	1.7	3.65	
		1.75~3.0	14~8	16NR G55	16NL G55	16	1.2	1.7	3.65	
	1/2"	3.5~5.0	7~5	22NR N55	22NL N55	22	1.7	2.5	4.76	
	5/8"	5.5~6.0	4.5~4	27NR Q55	27NL Q55	27	1.8	2.7	6.35	
	X型 X style	1/4"	0.5~1.25	48~16	11XNR A55	11XNL A55	11	0.8	0.9	3.39
			0.5~1.5	48~16	16XNR A55	16XNL A55	16	0.8	0.9	4.30
		3/8"	0.5~3.0	48~8	16XNR AG55	16XNL AG55	16	1.2	1.7	4.30
			1.75~3.0	14~8	16XNR G55	16XNL G55	16	1.2	1.7	4.30
1/2"		3.5~5.0	7~5	22XNR N55	22XNL N55	22	1.7	2.5	5.90	
5/8"		6.0~9	4~2.5	27XNR V55	27XNL V55	27	1.0	4.3	8.70	
立装型 V style	5/32"	0.5~1.25	48~20	06NR A55	06NL A55	6	0.6	0.6	1.90	
		0.5~1.5	48~16	08NR A55	08NL A55	8	0.6	0.7	2.20	
	1/4"	0.5~1.5	48~16	11NR A55	11NL A55	11	0.8	0.9	3.20	
		0.5~1.5	48~16	16NR A55	16NL A55	16	0.8	0.9	3.65	
	3/8"	0.5~3.0	48~8	16NR AG55	16NL AG55	16	1.2	1.7	3.65	
		1.75~3.0	14~8	16NR G55	16NL G55	16	1.2	1.7	3.65	
1/2"	3.5~5.0	7~5	22NR N55	22NL N55	22	1.7	2.5	4.76		
5/8"	5.5~6.0	4.5~4	27NR Q55	27NL Q55	27	1.8	2.7	6.35		

- * 可装在Sandvik Coromat刀杆上
- * Can be fixed in the toolholders of Sandvik Coromat.



ISO标准型螺纹刀片 ISO Metric Full Profile



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
1/4"	0.5	11ER0.50 ISO	11EL0.50 ISO	11	0.6	0.6	3.20
	0.75	11ER0.75 ISO	11EL0.75 ISO	11	0.6	0.6	3.20
	1	11ER1.00 ISO	11EL1.00 ISO	11	0.7	0.7	3.20
	1.25	11ER1.25 ISO	11EL1.25 ISO	11	0.8	0.9	3.20
	1.5	11ER1.50 ISO	11EL1.50 ISO	11	0.8	1.0	3.20
	1.75	11ER1.75 ISO	11EL1.75 ISO	11	0.8	1.1	3.20
	0.5	16ER0.50 ISO	16EL0.50 ISO	16	0.6	0.6	3.65
	0.75	16ER0.75 ISO	16EL0.75 ISO	16	0.6	0.6	3.65
	1	16ER1.00 ISO	16EL1.00 ISO	16	0.7	0.7	3.65
	1.25	16ER1.25 ISO	16EL1.25 ISO	16	0.8	0.9	3.65
3/8"	1.5	16ER1.50 ISO	16EL1.50 ISO	16	0.8	1.0	3.65
	1.75	16ER1.75 ISO	16EL1.75 ISO	16	0.9	1.2	3.65
	2	16ER2.00 ISO	16EL2.00 ISO	16	1.0	1.3	3.65
	2.5	16ER2.50 ISO	16EL2.50 ISO	16	1.1	1.5	3.65
	3	16ER3.00 ISO	16EL3.00 ISO	16	1.2	1.6	3.65
1/2"	3.5	22ER3.50 ISO	22EL3.50 ISO	22	1.6	2.3	4.76
	4	22ER4.00 ISO	22EL4.00 ISO	22	1.6	2.3	4.76
	4.5	22ER4.50 ISO	22EL4.50 ISO	22	1.7	2.4	4.76
	5	22ER5.00 ISO	22EL5.00 ISO	22	1.7	2.5	4.76
5/8"	5.5	27ER5.50 ISO	27EL5.50 ISO	27.5	1.9	2.7	6.35
	6	27ER6.00 ISO	27EL6.00 ISO	27.5	2.0	2.9	6.35
3/8"	0.5	16XER0.50 ISO	16XEL0.50 ISO	16	0.6	0.6	4.30
	0.75	16XER0.75 ISO	16XEL0.75 ISO	16	0.6	0.6	4.30
	1	16XER1.00 ISO	16XEL1.00 ISO	16	0.7	0.7	4.30
	1.25	16XER1.25 ISO	16XEL1.25 ISO	16	0.8	0.9	4.30
	1.5	16XER1.50 ISO	16XEL1.50 ISO	16	0.8	1.0	4.30
	1.75	16XER1.75 ISO	16XEL1.75 ISO	16	0.9	1.2	4.30
	2	16XER2.00 ISO	16XEL2.00 ISO	16	1.0	1.3	4.30
	2.5	16XER2.50 ISO	16XEL2.50 ISO	16	1.1	1.5	4.30
	3	16XER3.00 ISO	16XEL3.00 ISO	16	1.2	1.6	4.30

* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.

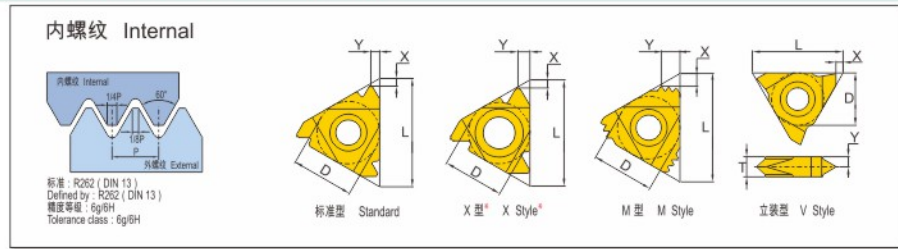
ISO标准型螺纹刀片(续) ISO Metric Full Profile (con't)

内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension				
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
1/2"	3.5	22XER3.50 ISO	22XEL3.50 ISO	22	1.6	2.3	5.90	
	4	22XER4.00 ISO	22XEL4.00 ISO	22	1.6	2.3	5.90	
	4.5	22XER4.50 ISO	22XEL4.50 ISO	22	1.7	2.4	5.90	
	5	22XER5.00 ISO	22XEL5.00 ISO	22	1.7	2.5	5.90	
	0.50	16VER0.50 ISO	16VEL0.50 ISO	16	1.1	3.0	3.65	
3/8"	0.75	16VER0.75 ISO	16VEL0.75 ISO	16	1.1	3.0	3.65	
	1.00	16VER1.00 ISO	16VEL1.00 ISO	16	1.1	2.9	3.65	
	1.25	16VER1.25 ISO	16VEL1.25 ISO	16	1.1	2.7	3.65	
	1.50	16VER1.50 ISO	16VEL1.50 ISO	16	1.1	2.6	3.65	
	1.75	16VER1.75 ISO	16VEL1.75 ISO	16	1.1	2.5	3.65	
	2.00	16VER2.00 ISO	16VEL2.00 ISO	16	1.1	2.3	3.65	
	2.50	16VER2.50 ISO	16VEL2.50 ISO	16	1.1	2.1	3.65	
	3.00	16VER3.00 ISO	16VEL3.00 ISO	16	1.1	2.0	3.65	
	5/8"	6.00	27VER6.00 ISO	27VEL6.00 ISO	27	1.0	3.3	6.35
		8.00	27VER8.00 ISO	27VEL8.00 ISO	27	1.0	4.3	8.70
10.00		27VER10.00 ISO	27VEL10.00 ISO	27	1.0	5.2	10.00	
3/8"	1.00	16ER1.0 ISO3M		16	1.7	2.6	3.65	
	1.50	16ER1.5 ISO2M		16	1.6	2.4	3.65	
	1.50	22ER1.5 ISO3M		22	2.4	3.8	4.76	
	2.00	22ER2.0 ISO2M		22	2.0	3.0	4.76	
	2.00	22ER2.0 ISO3M		22	3.1	4.9	4.76	
5/8"	3.00	27ER3.0 ISO2M		27	2.7	4.3	6.35	





ISO标准型螺纹刀片 ISO Metric Full Profile



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
5/32"	0.50	06NR0.50 ISO	06NL0.50 ISO	6	0.9	0.5	1.90
	0.75	06NR0.75 ISO	06NL0.75 ISO	6	0.8	0.5	1.90
	1.00	06NR1.00 ISO	06NL1.00 ISO	6	0.7	0.6	1.90
	1.25	06NR1.25 ISO	06NL1.25 ISO	6	0.6	0.6	1.90
	0.50	08NR0.50 ISO	08NL0.50 ISO	8	0.6	0.5	2.20
3/16"	0.75	08NR0.75 ISO	08NL0.75 ISO	8	0.6	0.5	2.20
	1.00	08NR1.00 ISO	08NL1.00 ISO	8	0.6	0.6	2.20
	1.25	08NR1.25 ISO	08NL1.25 ISO	8	0.6	0.7	2.20
	1.50	08NR1.50 ISO	08NL1.50 ISO	8	0.6	0.7	2.20
	1.75	08NR1.75 ISO	08NL1.75 ISO	8	0.6	0.8	2.20
1/4"	0.50	11NR0.50 ISO	11NL0.50 ISO	11	0.6	0.6	3.20
	0.75	11NR0.75 ISO	11NL0.75 ISO	11	0.6	0.6	3.20
	1.00	11NR1.00 ISO	11NL1.00 ISO	11	0.6	0.7	3.20
	1.25	11NR1.25 ISO	11NL1.25 ISO	11	0.8	0.9	3.20
	1.50	11NR1.50 ISO	11NL1.50 ISO	11	0.8	1.0	3.20
	1.75	11NR1.75 ISO	11NL1.75 ISO	11	0.9	1.1	3.20
	2.00	11NR2.00 ISO	11NL2.00 ISO	11	1.0	1.3	3.20
	0.50	16NR0.50 ISO	16NL0.50 ISO	16	0.6	0.6	3.65
	0.75	16NR0.75 ISO	16NL0.75 ISO	16	0.6	0.6	3.65
	1.00	16NR1.00 ISO	16NL1.00 ISO	16	0.6	0.7	3.65
3/8"	1.25	16NR1.25 ISO	16NL1.25 ISO	16	0.8	0.9	3.65
	1.50	16NR1.50 ISO	16NL1.50 ISO	16	0.8	1.0	3.65
	1.75	16NR1.75 ISO	16NL1.75 ISO	16	0.9	1.2	3.65
	2.00	16NR2.00 ISO	16NL2.00 ISO	16	1.0	1.3	3.65
	2.50	16NR2.50 ISO	16NL2.50 ISO	16	1.1	1.5	3.65
1/2"	3.00	16NR3.00 ISO	16NL3.00 ISO	16	1.1	1.5	3.65
	3.50	22NR3.50 ISO	22NL3.50 ISO	22	1.6	2.3	4.76
	4.00	22NR4.00 ISO	22NL4.00 ISO	22	1.6	2.3	4.76
	4.50	22NR4.50 ISO	22NL4.50 ISO	22	1.6	2.4	4.76
	5.00	22NR5.00 ISO	22NL5.00 ISO	22	1.6	2.5	4.76
5/8"	5.50	27NR5.50 ISO	27NL5.50 ISO	27	1.9	2.7	6.35
	6.00	27NR6.00 ISO	27NL6.00 ISO	27	2.0	2.9	6.35

标准型 Standard



ISO标准型螺纹刀片(续) ISO Metric Full Profile(con't)

内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
1/4"	0.50	11XNR0.50 ISO	11XNL0.50 ISO	11	0.6	0.6	3.39
	0.75	11XNR0.75 ISO	11XNL0.75 ISO	11	0.6	0.6	3.39
	1.00	11XNR1.00 ISO	11XNL1.00 ISO	11	0.6	0.7	3.39
	1.25	11XNR1.25 ISO	11XNL1.25 ISO	11	0.8	0.9	3.39
	1.50	11XNR1.50 ISO	11XNL1.50 ISO	11	0.8	1.0	3.39
3/8"	1.75	11XNR1.75 ISO	11XNL1.75 ISO	11	0.9	1.1	3.39
	2.00	11XNR2.00 ISO	11XNL2.00 ISO	11	1.0	1.3	3.39
	0.50	16XNR0.50 ISO	16XNL0.50 ISO	16	0.6	0.6	4.30
	0.75	16XNR0.75 ISO	16XNL0.75 ISO	16	0.6	0.6	4.30
	1.00	16XNR1.00 ISO	16XNL1.00 ISO	16	0.6	0.7	4.30
1/2"	1.25	16XNR1.25 ISO	16XNL1.25 ISO	16	0.8	0.9	4.30
	1.50	16XNR1.50 ISO	16XNL1.50 ISO	16	0.8	1.0	4.30
	1.75	16XNR1.75 ISO	16XNL1.75 ISO	16	0.9	1.2	4.30
	2.00	16XNR2.00 ISO	16XNL2.00 ISO	16	1.0	1.3	4.30
	2.50	16XNR2.50 ISO	16XNL2.50 ISO	16	1.1	1.5	4.30
5/8"	3.00	16XNR3.00 ISO	16XNL3.00 ISO	16	1.1	1.5	4.30
	3.50	22XNR3.50 ISO	22XNL3.50 ISO	22	1.6	2.3	5.90
	4.00	22XNR4.00 ISO	22XNL4.00 ISO	22	1.6	2.3	5.90
	4.50	22XNR4.50 ISO	22XNL4.50 ISO	22	1.6	2.4	5.90
	5.00	22XNR5.00 ISO	22XNL5.00 ISO	22	1.6	2.5	5.90
3/8"	0.50	16VNR0.50 ISO	16VNL0.50 ISO	16	1.1	3.00	3.65
	0.75	16VNR0.75 ISO	16VNL0.75 ISO	16	1.1	3.00	3.65
	1.00	16VNR1.00 ISO	16VNL1.00 ISO	16	1.1	2.90	3.65
	1.25	16VNR1.25 ISO	16VNL1.25 ISO	16	1.1	2.70	3.65
	1.50	16VNR1.50 ISO	16VNL1.50 ISO	16	1.1	2.60	3.65
	1.75	16VNR1.75 ISO	16VNL1.75 ISO	16	1.1	2.45	3.65
	2.00	16VNR2.00 ISO	16VNL2.00 ISO	16	1.1	2.30	3.65
	2.50	16VNR2.50 ISO	16VNL2.50 ISO	16	1.1	2.10	3.65
	3.00	16VNR3.00 ISO	16VNL3.00 ISO	16	1.1	2.00	3.65
	6.00	27VNR6.00 ISO	27VNL6.00 ISO	27	1.0	3.30	6.35
5/8"	8.00	27VNR8.00 ISO	27VNL8.00 ISO	27	1.0	4.30	8.70
	10.00	27VNR10.00 ISO	27VNL10.00 ISO	27	1.0	5.20	10.00
	1.00	16NR1.0 ISO3M		16	1.8	2.60	3.65
3/8"	1.50	16NR1.5 ISO2M		16	1.6	2.40	3.65
	1.50	22NR1.5 ISO3M		22	2.5	3.80	4.76
1/2"	2.00	22NR2.0 ISO2M		22	2.1	3.10	4.76
	2.00	22NR2.0 ISO3M		22	3.2	5.10	4.76
5/8"	3.00	27NR3.0 ISO2M		27	3.0	4.60	6.35

X型 X style



V型 V style



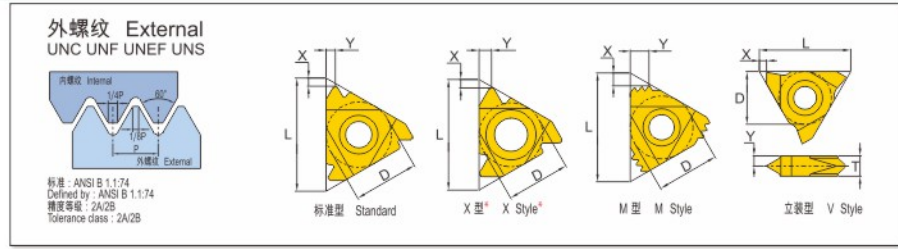
M型 M style



* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.



UN-60° 美制统一标准螺纹刀片 UN-60° American UN Full Profile



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
1/4"	TPI						
	32	11ER32 UN	11EL32 UN	11	0.6	0.6	3.20
	28	11ER28 UN	11EL28 UN	11	0.6	0.7	3.20
	24	11ER24 UN	11EL24 UN	11	0.7	0.8	3.20
	20	11ER20 UN	11EL20 UN	11	0.8	0.9	3.20
	18	11ER18 UN	11EL18 UN	11	0.8	1.0	3.20
	16	11ER16 UN	11EL16 UN	11	0.9	1.1	3.20
	32	16ER32 UN	16EL32 UN	16	0.6	0.6	3.65
	28	16ER28 UN	16EL28 UN	16	0.6	0.7	3.65
	24	16ER24 UN	16EL24 UN	16	0.7	0.8	3.65
3/8"	20	16ER20 UN	16EL20 UN	16	0.8	0.9	3.65
	18	16ER18 UN	16EL18 UN	16	0.8	1.0	3.65
	16	16ER16 UN	16EL16 UN	16	0.9	1.1	3.65
	14	16ER14 UN	16EL14 UN	16	1.0	1.2	3.65
	13	16ER13 UN	16EL13 UN	16	1.1	1.3	3.65
	12	16ER12 UN	16EL12 UN	16	1.1	1.4	3.65
	11.5	16ER11.5 UN	16EL11.5 UN	16	1.1	1.4	3.65
	11	16ER11 UN	16EL11 UN	16	1.1	1.5	3.65
	10	16ER10 UN	16EL10 UN	16	1.1	1.5	3.65
	9	16ER9 UN	16EL9 UN	16	1.2	1.7	3.65
1/2"	8	16ER8 UN	16EL8 UN	16	1.2	2.0	3.65
	7	22ER7 UN	22EL7 UN	22	1.6	2.3	4.76
	6	22ER6 UN	22EL6 UN	22	1.6	2.3	4.76
	5	22ER5 UN	22EL5 UN	22	1.7	2.5	4.76
5/8"	4.5	27ER4.5 UN	27EL4.5 UN	27	1.9	2.7	6.35
	4	27ER4 UN	27EL4 UN	27	2.1	3.0	6.35

标准型 Standard

UN-60° 美制统一标准螺纹刀片(续) UN-60° American UN Full Profile(cont)

内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	32	16XER32 UN	16XEL32 UN	16	0.6	0.6	4.30
	28	16XER28 UN	16XEL28 UN	16	0.6	0.7	4.30
	24	16XER24 UN	16XEL24 UN	16	0.7	0.8	4.30
	20	16XER20 UN	16XEL20 UN	16	0.8	0.9	4.30
	18	16XER18 UN	16XEL18 UN	16	0.8	1.0	4.30
	16	16XER16 UN	16XEL16 UN	16	0.9	1.1	4.30
	14	16XER14 UN	16XEL14 UN	16	1.0	1.2	4.30
	13	16XER13 UN	16XEL13 UN	16	1.1	1.3	4.30
	12	16XER12 UN	16XEL12 UN	16	1.1	1.4	4.30
	11.5	16XER11.5 UN	16XEL11.5 UN	16	1.1	1.4	4.30
	11	16XER11 UN	16XEL11 UN	16	1.1	1.5	4.30
	10	16XER10 UN	16XEL10 UN	16	1.1	1.5	4.30
	9	16XER9 UN	16XEL9 UN	16	1.2	1.7	4.30
	8	16XER8 UN	16XEL8 UN	16	1.2	2.0	4.30
	3/8"	32	16VER32 UN	16VEL32 UN	16	1.1	3.0
28		16VER28 UN	16VEL28 UN	16	1.1	3.0	3.65
24		16VER24 UN	16VEL24 UN	16	1.1	2.9	3.65
20		16VER20 UN	16VEL20 UN	16	1.1	2.7	3.65
18		16VER18 UN	16VEL18 UN	16	1.1	2.6	3.65
16		16VER16 UN	16VEL16 UN	16	1.1	2.5	3.65
14		16VER14 UN	16VEL14 UN	16	1.1	2.4	3.65
12		16VER12 UN	16VEL12 UN	16	1.1	2.2	3.65
10		16VER10 UN	16VEL10 UN	16	1.1	2.1	3.65
8		16VER8 UN	16VEL8 UN	16	1.1	2.0	3.65
1/2"	7	22VER7 UN	22VEL7 UN	22	1.1	2.5	4.76
3/8"	16	16ER16UN2M		16	1.7	2.5	3.65
	16	22ER16UN3M		22	2.6	4.1	4.76
1/2"	12	22ER16UN2M		22	2.1	3.2	4.76
	12	22ER16UN3M		22	3.4	5.3	4.76
5/8"	8	27ER8UN2M		27	3.2	5.0	6.35

X型 X Style

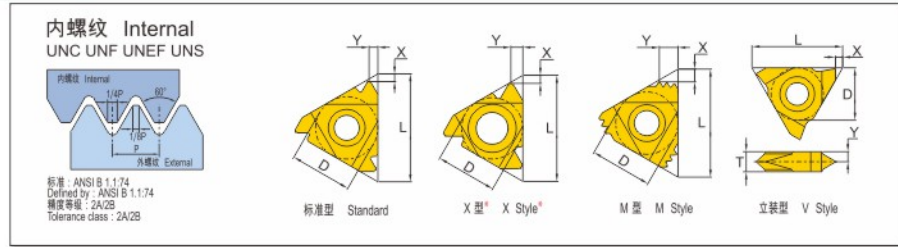
V型 V Style

M型 M Style

* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.



UN-60° 美制统一标准螺纹刀片 UN-60° American UN Full Profile



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
5/32"	TPI						
	32	06NR32 UN	06NL32 UN	6	0.8	0.5	1.90
	28	06NR28 UN	06NL28 UN	6	0.8	0.6	1.90
	24	06NR24 UN	06NL24 UN	6	0.7	0.6	1.90
	20	06NR20 UN	06NL20 UN	6	0.6	0.6	1.90
3/16"	18	06NR18 UN	06NL18 UN	6	0.6	0.7	1.90
	32	08NR32 UN	08NL32 UN	8	0.6	0.5	2.20
	28	08NR28 UN	08NL28 UN	8	0.6	0.6	2.20
	24	08NR24 UN	08NL24 UN	8	0.6	0.6	2.20
	20	08NR20 UN	08NL20 UN	8	0.6	0.7	2.20
1/4"	18	08NR18 UN	08NL18 UN	8	0.6	0.7	2.20
	16	08NR16 UN	08NL16 UN	8	0.6	0.7	2.20
	14	08NR14 UN	08NL14 UN	8	0.6	0.8	2.20
	32	11NR32 UN	11NL32 UN	11	0.6	0.6	3.20
	28	11NR28 UN	11NL28 UN	11	0.6	0.7	3.20
3/8"	24	11NR24 UN	11NL24 UN	11	0.7	0.8	3.20
	20	11NR20 UN	11NL20 UN	11	0.8	0.9	3.20
	18	11NR18 UN	11NL18 UN	11	0.8	1.0	3.20
	16	11NR16 UN	11NL16 UN	11	0.9	1.1	3.20
	32	16NR32 UN	16NL32 UN	16	0.6	0.6	3.65
	28	16NR28 UN	16NL28 UN	16	0.6	0.7	3.65
	24	16NR24 UN	16NL24 UN	16	0.7	0.8	3.65
	20	16NR20 UN	16NL20 UN	16	0.8	0.9	3.65
	18	16NR18 UN	16NL18 UN	16	0.8	1.0	3.65
	16	16NR16 UN	16NL16 UN	16	0.9	1.1	3.65
3/8"	14	16NR14 UN	16NL14 UN	16	1.0	1.2	3.65
	13	16NR13 UN	16NL13 UN	16	1.0	1.3	3.65
	12	16NR12 UN	16NL12 UN	16	1.1	1.4	3.65
	11	16NR11 UN	16NL11 UN	16	1.1	1.5	3.65
	10	16NR10 UN	16NL10 UN	16	1.1	1.5	3.65
	9	16NR9 UN	16NL9 UN	16	1.2	1.7	3.65
	8	16NR8 UN	16NL8 UN	16	1.2	2.0	3.65

标准型 Standard



UN-60° 美制统一标准螺纹刀片(续) UN-60° American UN Full Profile(cont)

内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
1/2"	7	22NR7 UN	22NL7 UN	22	1.6	2.3	4.76
	6	22NR6 UN	22NL6 UN	22	1.6	2.3	4.76
	5	22NR5 UN	22NL5 UN	22	1.7	2.5	4.76
5/8"	4.5	27NR4.5 UN	27NL4.5 UN	27	1.9	2.7	6.35
	4	27NR4 UN	27NL4 UN	27	2.1	3.0	6.35
1/4"	32	11XNR32 UN	11XNL32 UN	11	0.6	0.6	3.39
	28	11XNR28 UN	11XNL28 UN	11	0.6	0.7	3.39
	24	11XNR24 UN	11XNL24 UN	11	0.7	0.8	3.39
	20	11XNR20 UN	11XNL20 UN	11	0.8	0.9	3.39
	18	11XNR18 UN	11XNL18 UN	11	0.8	1.0	3.39
	16	11XNR16 UN	11XNL16 UN	11	0.9	1.1	3.39
	32	16XNR32 UN	16XNL32 UN	16	0.6	0.6	4.30
	28	16XNR28 UN	16XNL28 UN	16	0.6	0.7	4.30
	24	16XNR24 UN	16XNL24 UN	16	0.7	0.8	4.30
	20	16XNR20 UN	16XNL20 UN	16	0.8	0.9	4.30
3/8"	18	16XNR18 UN	16XNL18 UN	16	0.8	1.0	4.30
	16	16XNR16 UN	16XNL16 UN	16	0.9	1.1	4.30
	14	16XNR14 UN	16XNL14 UN	16	1.0	1.2	4.30
	13	16XNR13 UN	16XNL13 UN	16	1.0	1.3	4.30
	12	16XNR12 UN	16XNL12 UN	16	1.1	1.4	4.30
	11	16XNR11 UN	16XNL11 UN	16	1.1	1.5	4.30
	10	16XNR10 UN	16XNL10 UN	16	1.1	1.5	4.30
	9	16XNR9 UN	16XNL9 UN	16	1.2	1.7	4.30
	8	16XNR8 UN	16XNL8 UN	16	1.2	2.0	4.30
	5/8"	4	27VNR4 UN	27VNL4 UN	27	1.0	3.3
3		27VNR3 UN	27VNL3 UN	27	1.0	4.3	8.70
3/8"	16	16NR16UN2M		16	1.7	2.4	3.65
	16	22NR16UN3M		22	2.5	4.0	4.76
1/2"	12	22NR16UN2M		22	2.1	3.2	4.76
	12	22NR16UN3M		22	3.3	5.2	4.76
5/8"	8	27NR8UN2M		27	3.0	4.8	6.35

X型* X Style*



立装型 V Style



快装型 M Style

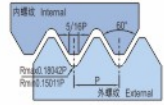


* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.

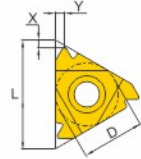


UNJ美制航空航天机械螺纹刀片 UNJ Aviation Thread

外螺纹 External
UNJC UNJF UNJEF UNJS



标准: MIL-S-8879C
Defined by: MIL-S-8879C
精度等级: 3A/3B
Tolerance class: 3A/3B



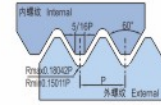
标准型 Standard

内径圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
1/4"	TPI						
	28	11ER28 UNJ	11EL28 UNJ	11	0.7	0.7	3.20
	24	11ER24 UNJ	11EL24 UNJ	11	0.7	0.8	3.20
	20	11ER20 UNJ	11EL20 UNJ	11	0.8	0.9	3.20
	18	11ER18 UNJ	11EL18 UNJ	11	0.8	1.0	3.20
	16	11ER16 UNJ	11EL16 UNJ	11	0.9	1.1	3.20
3/8"	14	11ER14 UNJ	11EL14 UNJ	11	1.0	1.2	3.20
	28	16ER28 UNJ	16EL28 UNJ	16	0.7	0.7	3.65
	24	16ER24 UNJ	16EL24 UNJ	16	0.7	0.8	3.65
	20	16ER20 UNJ	16EL20 UNJ	16	0.8	0.9	3.65
	18	16ER18 UNJ	16EL18 UNJ	16	0.8	1.0	3.65
	16	16ER16 UNJ	16EL16 UNJ	16	0.9	1.1	3.65
1/2"	14	16ER14 UNJ	16EL14 UNJ	16	1.0	1.2	3.65
	13	16ER13 UNJ	16EL13 UNJ	16	1.0	1.3	3.65
	12	16ER12 UNJ	16EL12 UNJ	16	1.1	1.3	3.65
	11	16ER11 UNJ	16EL11 UNJ	16	1.2	1.5	3.65
	10	16ER10 UNJ	16EL10 UNJ	16	1.2	1.5	3.65
	9	16ER9 UNJ	16EL9 UNJ	16	1.3	1.7	3.65
5/8"	8	16ER8 UNJ	16EL8 UNJ	16	1.2	1.6	3.65
	7	22ER7 UNJ	22EL7 UNJ	22	1.7	2.3	4.76
	6	22ER6 UNJ	22EL6 UNJ	22	1.6	2.3	4.76
5/8"	5	22ER5 UNJ	22EL5 UNJ	22	1.8	2.5	4.76
	4.5	27ER4.5 UNJ	27EL4.5 UNJ	27	2.0	2.7	6.35
	4	27ER4 UNJ	27EL4 UNJ	27	2.2	3.0	6.35

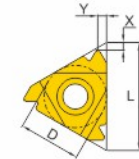
标准型 Standard

UNJ美制航空航天机械螺纹刀片 UNJ Aviation Thread

内螺纹 Internal
UNJC UNJF UNJEF UNJS



标准: MIL-S-8879C
Defined by: MIL-S-8879C
精度等级: 3A/3B
Tolerance class: 3A/3B



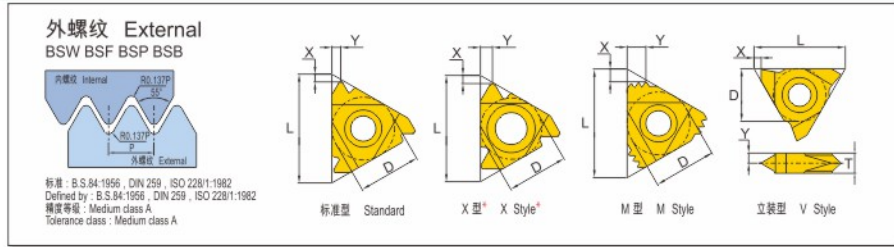
标准型 Standard

内径圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
1/4"	TPI						
	28	11NR28 UNJ	11NL28 UNJ	11	0.7	0.7	3.20
	24	11NR24 UNJ	11NL24 UNJ	11	0.7	0.8	3.20
	20	11NR20 UNJ	11NL20 UNJ	11	0.8	0.9	3.20
	18	11NR18 UNJ	11NL18 UNJ	11	0.8	1.0	3.20
	16	11NR16 UNJ	11NL16 UNJ	11	0.9	1.1	3.20
3/8"	14	11NR14 UNJ	11NL14 UNJ	11	1.0	1.2	3.20
	28	16NR28 UNJ	16NL28 UNJ	16	0.7	0.7	3.65
	24	16NR24 UNJ	16NL24 UNJ	16	0.7	0.8	3.65
	20	16NR20 UNJ	16NL20 UNJ	16	0.8	0.9	3.65
	18	16NR18 UNJ	16NL18 UNJ	16	0.8	1.0	3.65
	16	16NR16 UNJ	16NL16 UNJ	16	0.9	1.1	3.65
1/2"	14	16NR14 UNJ	16NL14 UNJ	16	1.0	1.2	3.65
	13	16NR13 UNJ	16NL13 UNJ	16	1.0	1.3	3.65
	12	16NR12 UNJ	16NL12 UNJ	16	1.1	1.3	3.65
	11	16NR11 UNJ	16NL11 UNJ	16	1.2	1.5	3.65
	10	16NR10 UNJ	16NL10 UNJ	16	1.2	1.5	3.65
	9	16NR9 UNJ	16NL9 UNJ	16	1.3	1.7	3.65
5/8"	8	16NR8 UNJ	16NL8 UNJ	16	1.2	1.6	3.65
	7	22NR7 UNJ	22NL7 UNJ	22	1.7	2.3	4.76
	6	22NR6 UNJ	22NL6 UNJ	22	1.6	2.3	4.76
5/8"	5	22NR5 UNJ	22NL5 UNJ	22	1.8	2.5	4.76
	4.5	27NR4.5 UNJ	27NL4.5 UNJ	27	2.0	2.7	6.35
	4	27NR4 UNJ	27NL4 UNJ	27	2.2	3.0	6.35

标准型 Standard



W-55° 英国惠氏螺纹刀片 W-55° Whitworth Full Profile



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
1/4"	TPI						
	28	11ER28 W	11EL28 W	11	0.6	0.7	3.20
	26	11ER26 W	11EL26 W	11	0.7	0.8	3.20
	20	11ER20 W	11EL20 W	11	0.8	0.9	3.20
	19	11ER19 W	11EL19 W	11	0.8	1.0	3.20
	18	11ER18 W	11EL18 W	11	0.8	1.0	3.20
	16	11ER16 W	11EL16 W	11	0.9	1.1	3.20
	14	11ER14 W	11EL14 W	11	1.0	1.2	3.20
	28	16ER28 W	16EL28 W	16	0.6	0.7	3.65
	26	16ER26 W	16EL26 W	16	0.7	0.8	3.65
	20	16ER20 W	16EL20 W	16	0.8	0.9	3.65
	19	16ER19 W	16EL19 W	16	0.8	1.0	3.65
	18	16ER18 W	16EL18 W	16	0.8	0.9	3.65
	16	16ER16 W	16EL16 W	16	0.9	1.1	3.65
3/8"	14	16ER14 W	16EL14 W	16	1.0	1.2	3.65
	12	16ER12 W	16EL12 W	16	1.1	1.4	3.65
	11	16ER11 W	16EL11 W	16	1.1	1.5	3.65
	10	16ER10 W	16EL10 W	16	1.1	1.5	3.65
	9	16ER9 W	16EL9 W	16	1.2	1.5	3.65
	8	16ER8 W	16EL8 W	16	1.2	1.7	3.65
1/2"	7	22ER7 W	22EL7 W	22	1.6	2.3	4.76
	6	22ER6 W	22EL6 W	22	1.6	2.3	4.76
	5	22ER5 W	22EL5 W	22	1.7	2.4	4.76
5/8"	4.5	27ER4.5 W	27EL4.5 W	27	1.8	2.6	6.35
	4	27ER4 W	27EL4 W	27	2.0	2.9	6.35

标准型 Standard

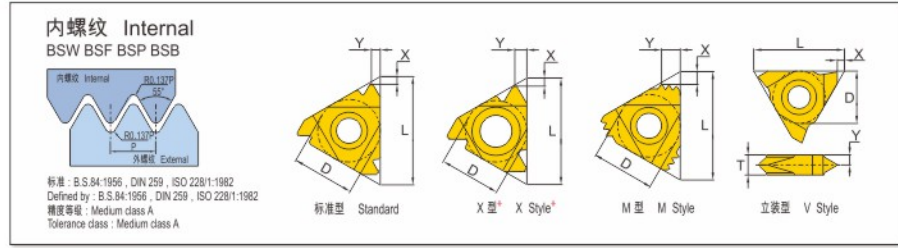
W-55° 英国惠氏螺纹刀片(续) W-55° Whitworth Full Profile(con't)

内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	28	16XER28 W	16XEL28 W	16	0.6	0.7	4.30
	26	16XER26 W	16XEL26 W	16	0.7	0.8	4.30
	20	16XER20 W	16XEL20 W	16	0.8	0.9	4.30
	19	16XER19 W	16XEL19 W	16	0.8	1.0	4.30
	18	16XER18 W	16XEL18 W	16	0.8	0.9	4.30
	16	16XER16 W	16XEL16 W	16	0.9	1.1	4.30
	14	16XER14 W	16XEL14 W	16	1.0	1.2	4.30
	12	16XER12 W	16XEL12 W	16	1.1	1.4	4.30
	11	16XER11 W	16XEL11 W	16	1.1	1.5	4.30
	10	16XER10 W	16XEL10 W	16	1.1	1.5	4.30
	9	16XER9 W	16XEL9 W	16	1.2	1.5	4.30
	8	16XER8 W	16XEL8 W	16	1.2	1.7	4.30
	19	16VER19 W	16VEL19 W	16	1.1	2.7	3.65
	18	16VER18 W	16VEL18 W	16	1.1	2.6	3.65
3/8"	16	16VER16 W	16VEL16 W	16	1.1	2.6	3.65
	14	16VER14 W	16VEL14 W	16	1.1	2.4	3.65
	12	16VER12 W	16VEL12 W	16	1.1	2.4	3.65
	11	16VER11 W	16VEL11 W	16	1.1	2.1	3.65
	4	27VER4 W	27VEL4 W	27	1.0	3.3	6.35
	3	27VER3 W	27VEL3 W	27	1.0	4.3	8.70
3/8"	2.5	27VER2.5 W	27VEL2.5 W	27	1.0	5.2	10.0
	14	16ER14W2M		16	1.9	2.8	3.65
	14	22ER14W3M		22	2.9	4.6	4.76
1/2"	11	22ER11W2M		22	2.3	3.5	4.76

* 可装在Sandvik coromat刀杆上
* Can be fixed in the toolholders of Sandvik coromat.



W-55° 英国惠氏螺纹刀片 W-55° Whitworth Full Profile



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension				
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
5/32"	26	06NR26 W	06NL26 W	6	0.7	0.6	1.90	
		06NR22 W	06NL22 W	6	0.6	0.6	1.90	
	20	06NR20 W	06NL20 W	6	0.6	0.7	1.90	
		06NR18 W	06NL18 W	6	0.6	0.7	1.90	
	3/16"	28	08NR28 W	08NL28 W	8	0.6	0.6	2.20
			08NR24 W	08NL24 W	8	0.6	0.6	2.20
20		08NR20 W	08NL20 W	8	0.6	0.7	2.20	
		08NR19 W	08NL19 W	8	0.6	0.7	2.20	
1/4"	18	08NR18 W	08NL18 W	8	0.6	0.7	2.20	
		08NR16 W	08NL16 W	8	0.6	0.7	2.20	
	28	11NR28 W	11NL28 W	11	0.6	0.6	3.20	
		26	11NR26 W	11NL26 W	11	0.6	0.7	3.20
	3/8"	20	11NR20 W	11NL20 W	11	0.7	0.9	3.20
			19	11NR19 W	11NL19 W	11	0.8	1
18		11NR18 W	11NL18 W	11	0.8	1	3.20	
		16	11NR16 W	11NL16 W	11	0.9	1.1	3.20
3/8"	14	11NR14 W	11NL14 W	11	1.0	1.2	3.20	
		28	16NR28 W	16NL28 W	16	0.6	0.7	3.65
	26	16NR26 W	16NL26 W	16	0.7	0.8	3.65	
		20	16NR20 W	16NL20 W	16	0.8	0.9	3.65
	19	16NR19 W	16NL19 W	16	0.8	1	3.65	
		18	16NR18 W	16NL18 W	16	0.8	1	3.65
	16	16NR16 W	16NL16 W	16	0.9	1.1	3.65	
		14	16NR14 W	16NL14 W	16	1.0	1.2	3.65
	12	16NR12 W	16NL12 W	16	1.1	1.4	3.65	
		11	16NR11 W	16NL11 W	16	1.1	1.5	3.65
	10	16NR10 W	16NL10 W	16	1.1	1.5	3.65	
		9	16NR9 W	16NL9 W	16	1.2	1.5	3.65
8	16NR8 W	16NL8 W	16	1.2	1.7	3.65		

标准型 Standard



W-55° 英国惠氏螺纹刀片(续) W-55° Whitworth Full Profile(cont)

内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension				
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
1/2"	7	22NR7 W	22NL7 W	22	1.6	2.3	4.76	
		6	22NR6 W	22NL6 W	22	1.6	2.3	4.76
		5	22NR5 W	22NL5 W	22	1.7	2.4	4.76
5/8"	4.5	27XNR4.5 W	27NL4.5 W	27	1.8	2.6	6.35	
		4	27XNR4 W	27NL4 W	27	2.0	2.9	6.35
	28	11XNR28 W	11XNL28 W	11	0.6	0.6	3.39	
		26	11XNR26 W	11XNL26 W	11	0.6	0.7	3.39
1/4"	20	11XNR20 W	11XNL20 W	11	0.7	0.9	3.39	
		19	11XNR19 W	11XNL19 W	11	0.8	1.0	3.39
	18	11XNR18 W	11XNL18 W	11	0.8	1.0	3.39	
		16	11XNR16 W	11XNL16 W	11	0.9	1.1	3.39
	3/8"	14	11XNR14 W	11XNL14 W	11	1.0	1.2	3.39
			28	16XNR28 W	16XNL28 W	16	0.6	0.7
26		16XNR26 W	16XNL26 W	16	0.7	0.8	4.30	
		20	16XNR20 W	16XNL20 W	16	0.8	0.9	4.30
5/8"	19	16XNR19 W	16XNL19 W	16	0.8	1.0	4.30	
		18	16XNR18 W	16XNL18 W	16	0.8	1.0	4.30
	16	16XNR16 W	16XNL16 W	16	0.9	1.1	4.30	
		14	16XNR14 W	16XNL14 W	16	1.0	1.2	4.30
	12	16XNR12 W	16XNL12 W	16	1.1	1.4	4.30	
		11	16XNR11 W	16XNL11 W	16	1.1	1.5	4.30
	10	16XNR10 W	16XNL10 W	16	1.1	1.5	4.30	
		9	16XNR9 W	16XNL9 W	16	1.2	1.5	4.30
	8	16XNR8 W	16XNL8 W	16	1.2	1.7	4.30	
		4	27VNR4 W	27VNL4 W	27	1.0	3.3	6.35
3/8"	3	27VNR3 W	27VNL3 W	27	1.0	4.3	8.70	
		2.5	27VNR2.5 W	27VNL2.5 W	27	1.0	5.2	10.0
3/8"	14	16NR14W2M		16	1.9	2.8	3.65	
		14	22NR14W3M		22	2.9	4.6	4.76
		11	22NR11W2M		22	2.3	3.5	4.76

* X 型 X style

立装型 V style

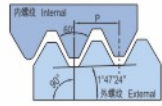
M 型 M style

- * 可装在Sandvik Coromat刀杆上
- * Can be fixed in the toolholders of Sandvik Coromat.

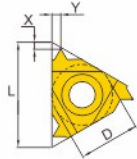


NPTF美制干密封锥管螺纹刀片 NPTF(Dry seal)

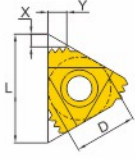
外螺纹 External



标准: ANSI B1.20.3-1976
Defined by: ANSI B1.20.3-1976
精度等级: 标准 NPTF
Tolerance class: Standard NPTF



标准型 Standard

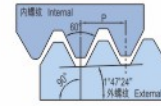


M型 M Style

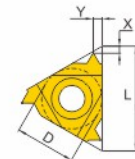
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	TPI						
		27	11ER27 NPTF	11EL27 NPTF	11	0.7	0.8	3.20
		18	11ER18 NPTF	11EL18 NPTF	11	0.8	1.0	3.20
		14	11ER14 NPTF	11EL14 NPTF	11	0.8	1.0	3.20
		27	16ER27 NPTF	16EL27 NPTF	16	0.7	0.8	3.65
		18	16ER18 NPTF	16EL18 NPTF	16	0.8	1.0	3.65
梳齿型 M Style	3/8"	14	16ER14 NPTF	16EL14 NPTF	16	0.9	1.2	3.65
		11.5	16ER11.5 NPTF	16EL11.5 NPTF	16	1.1	1.5	3.65
		8	16ER8 NPTF	16EL8 NPTF	16	1.3	1.8	3.65
梳齿型 M Style	1/2"	11.5	22ER11.5 NPTF2M		22	3.4	2.2	4.76

NPTF美制干密封锥管螺纹刀片 NPTF(Dry seal)

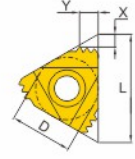
内螺纹 Internal



标准: ANSI B1.20.3-1976
Defined by: ANSI B1.20.3-1976
精度等级: 标准 NPTF
Tolerance class: Standard NPTF



标准型 Standard



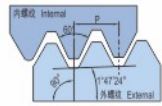
M型 M Style

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension				
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
标准型 Standard	5/32"	27	06NR27 NPTF	06NL27 NPTF	6	0.7	0.6	1.90	
		3/16"	27	08NR27 NPTF	08NL27 NPTF	8	0.6	0.6	2.20
			18	08NR18 NPTF	08NL18 NPTF	8	0.6	0.6	2.20
		1/4"	27	11NR27 NPTF	11NL27 NPTF	11	0.7	0.8	3.20
			18	11NR18 NPTF	11NL18 NPTF	11	0.8	1.0	3.20
			14	11NR14 NPTF	11NL14 NPTF	11	0.8	1.0	3.20
27	16NR27 NPTF		16NL27 NPTF	16	0.7	0.8	3.65		
3/8"	18	16NR18 NPTF	16NL18 NPTF	16	0.8	1.0	3.65		
	14	16NR14 NPTF	16NL14 NPTF	16	0.9	1.2	3.65		
	11.5	16NR11.5 NPTF	16NL11.5 NPTF	16	1.1	1.5	3.65		
梳齿型 M Style	1/2"	8	16NR8 NPTF	16NL8 NPTF	16	1.3	1.8	3.65	
		11.5	22NR11.5 NPTF2M		22	3.4	2.2	4.76	
梳齿型 M Style	5/8"	11.5	27NR11.5 NPTF3M		27	3.5	2.2	6.35	

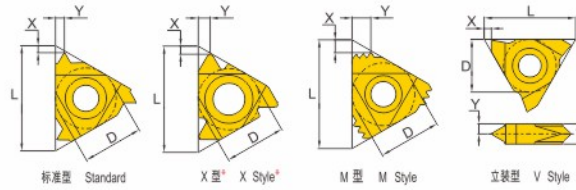


NPT-60° 美国标准锥管螺纹刀片 NPT-60° National Pipe Threads

外螺纹 External



标准: USAS B2.1:1968
Defined by: USAS B2.1:1968
精度等级: Standard NPT
Tolerance class: Standard NPT

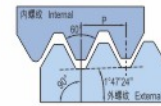


	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	TPI						
		27	11ER27 NPT	11EL27 NPT	11	0.7	0.8	3.20
		18	11ER18 NPT	11EL18 NPT	11	0.8	1.0	3.20
	3/8"	14	11ER14 NPT	11EL14 NPT	11	0.8	1.0	3.20
		27	16ER27 NPT	16EL27 NPT	16	0.7	0.8	3.65
		18	16ER18 NPT	16EL18 NPT	16	0.8	1.0	3.65
14		16ER14 NPT	16EL14 NPT	16	0.8	1.0	3.65	
11.5		16ER11.5 NPT	16EL11.5 NPT	16	1.1	1.5	3.65	
8		16ER8 NPT	16EL8 NPT	16	1.2	1.8	3.65	
X型 X Style	3/8"	27	16XER27 NPT	16XEL27 NPT	16	0.7	0.8	4.30
		18	16XER18 NPT	16XEL18 NPT	16	0.8	1.0	4.30
		14	16XER14 NPT	16XEL14 NPT	16	0.8	1.0	4.30
	3/8"	11.5	16XER11.5 NPT	16XEL11.5 NPT	16	1.1	1.5	4.30
		8	16XER8 NPT	16XEL8 NPT	16	1.2	1.8	4.30
立装型 V Style	3/8"	27	16VER27 NPT	16VEL27 NPT	16	1.1	2.9	3.65
		18	16VER18 NPT	16VEL18 NPT	16	1.1	2.6	3.65
		14	16VER14 NPT	16VEL14 NPT	16	1.1	2.3	3.65
		11.5	16VER11.5 NPT	16VEL11.5 NPT	16	1.1	2.1	3.65
梳齿型 M Style	1/2"	11.5	22ER11.5 NPT2M		22	3.4	2.2	4.76
		11.5	27ER11.5 NPT3M		27	3.5	5.6	6.35
	5/8"	8	27ER8 NPT2M		27	2.9	4.7	6.35

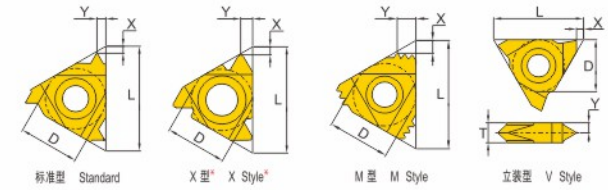
* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.

NPT-60° 美国标准锥管螺纹刀片 NPT-60° National Pipe Threads

内螺纹 Internal



标准: USAS B2.1:1968
Defined by: USAS B2.1:1968
精度等级: Standard NPT
Tolerance class: Standard NPT



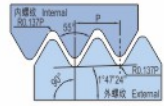
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	5/32"	TPI						
		27	06NR27 NPT	06NL27 NPT	6	0.6	0.6	1.90
	3/16"	27	08NR27 NPT	08NL27 NPT	8	0.6	0.6	2.20
		18	08NR18 NPT	08NL18 NPT	8	0.6	0.6	2.20
	1/4"	27	11NR27 NPT	11NL27 NPT	11	0.7	0.8	3.20
		18	11NR18 NPT	11NL18 NPT	11	0.8	1.0	3.20
14		11NR14 NPT	11NL14 NPT	11	0.8	1.0	3.20	
27		16NR27 NPT	16NL27 NPT	16	0.7	0.8	3.65	
3/8"	18	16NR18 NPT	16NL18 NPT	16	0.8	1.0	3.65	
	14	16NR14 NPT	16NL14 NPT	16	0.8	1.0	3.65	
	11.5	16NR11.5 NPT	16NL11.5 NPT	16	1.1	1.5	3.65	
	8	16NR8 NPT	16NL8 NPT	16	1.2	1.8	3.65	
X型 X Style	1/4"	27	11XNR27 NPT	11XNL27 NPT	11	0.7	0.8	3.39
		14	11XNR14 NPT	11XNL14 NPT	11	0.8	1.0	3.39
	3/8"	27	16XNR27 NPT	16XNL27 NPT	16	0.7	0.8	4.30
		18	16XNR18 NPT	16XNL18 NPT	16	0.8	1.0	4.30
梳齿型 M Style	1/4"	14	16XNR14 NPT	16XNL14 NPT	16	0.8	1.0	4.30
		11.5	16XNR11.5 NPT	16XNL11.5 NPT	16	1.1	1.5	4.30
		8	16XNR8 NPT	16XNL8 NPT	16	1.2	1.8	4.30
	5/8"	11.5	22NR11.5 NPT2M		22	3.4	2.2	4.76
		11.5	27NR11.5 NPT3M		27	3.5	5.6	6.35
		8	27NR8 NPT2M		27	2.9	4.7	6.35

* 可装在Sandvik Coromat刀杆上
* Can be fixed in the toolholders of Sandvik Coromat.

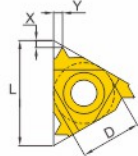


BSPT-55° 英国标准锥管螺纹刀片 BSPT-55° British Standard Pipe Full Profile

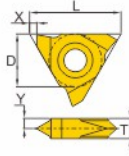
外螺纹 External



标准: B.S.21:1985
Defined by: B.S.21:1985
精度等级: Standard BSPT
Tolerance class: Standard BSPT



标准型 Standard

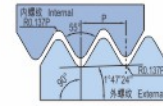


立铣型 V Style

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	28	11ER28 BSPT	11EL28 BSPT	11	0.6	0.6	3.20
			11ER19 BSPT	11EL19 BSPT	11	0.8	0.9	3.20
			11ER14 BSPT	11EL14 BSPT	11	0.9	1.0	3.20
	3/8"	28	16ER28 BSPT	16EL28 BSPT	16	0.6	0.6	3.65
			16ER19 BSPT	16EL19 BSPT	16	0.8	0.9	3.65
			16ER14 BSPT	16EL14 BSPT	16	1.0	1.2	3.65
3/8"	11	16ER11 BSPT	16EL11 BSPT	16	1.1	1.5	3.65	
		16VER28 BSPT	16VEL28 BSPT	16	1.1	3.0	3.65	
		16VER19 BSPT	16VEL19 BSPT	16	1.1	2.7	3.65	
V Style	3/8"	14	16VER14 BSPT	16VEL14 BSPT	16	1.1	2.4	3.65
			16VER11 BSPT	16VEL11 BSPT	16	1.1	2.1	3.65

BSPT-55° 英国标准锥管螺纹刀片 BSPT-55° British Standard Pipe Full Profile

内螺纹 Internal



标准: B.S.21:1985
Defined by: B.S.21:1985
精度等级: Standard BSPT
Tolerance class: Standard BSPT



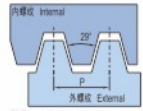
标准型 Standard

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	5/32"	28	06NR28 BSPT	06NL28 BSPT	6	0.7	0.6	1.90
			08NR28 BSPT	08NL28 BSPT	8	0.6	0.6	2.20
	3/16"	28	08NR19 BSPT	08NL19 BSPT	8	0.6	0.6	2.20
			11NR28 BSPT	11NL28 BSPT	11	0.6	0.8	3.20
	1/4"	19	11NR19 BSPT	11NL19 BSPT	11	0.8	0.9	3.20
			11NR14 BSPT	11NL14 BSPT	11	0.9	1.0	3.20
3/8"	28	16NR28 BSPT	16NL28 BSPT	16	0.6	0.6	3.65	
		16NR19 BSPT	16NL19 BSPT	16	0.8	0.9	3.65	
		16NR14 BSPT	16NL14 BSPT	16	1.0	1.2	3.65	
		11	16NR11 BSPT	16NL11 BSPT	16	1.1	1.5	3.65

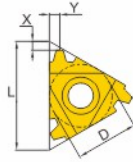


ACME-29° 美制ACME梯形螺纹刀片 American ACME

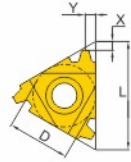
标准型 Standard



标准: ANSI B 1.5:1988
Defined by: ANSI B 1.5:1988
精度等级: 3G
Tolerance class: 3G



标准型 Standard

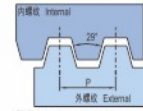


标准型 Standard

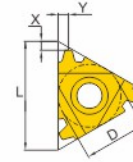
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension				
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
外 螺 纹 External	3/8"	16	16ER16 ACME	16EL16 ACME	16	1.0	1.1	3.65	
			14	16ER14 ACME	16EL14 ACME	16	1.0	1.2	3.65
			12	16ER12 ACME	16EL12 ACME	16	1.1	1.2	3.65
			10	16ER10 ACME	16EL10 ACME	16	1.3	1.3	3.65
	1/2"	8	16ER8 ACME	16EL8 ACME	16	1.4	1.5	3.65	
			6	22ER6 ACME	22EL6 ACME	22	1.8	2.1	4.76
			5	22ER5 ACME	22EL5 ACME	22	2.0	2.3	4.76
			4	27ER4 ACME	27EL4 ACME	27	2.4	2.7	6.35
内 螺 纹 Internal	3/8"	16	16NR16 ACME	16NL16 ACME	16	1.0	1.1	3.65	
			14	16NR14 ACME	16NL14 ACME	16	1.0	1.2	3.65
			12	16NR12 ACME	16NL12 ACME	16	1.1	1.2	3.65
			10	16NR10 ACME	16NL10 ACME	16	1.3	1.3	3.65
	1/2"	8	16NRR ACME	16NLR ACME	16	1.4	1.5	3.65	
			6	22NR6 ACME	22NL6 ACME	22	1.8	2.1	4.76
			5	22NR5 ACME	22NL5 ACME	22	2.0	2.3	4.76
			4	27NR4 ACME	27NL4 ACME	27	2.4	2.7	6.35

STACME-29° 美制ACME梯形螺纹刀片 Stub ACME

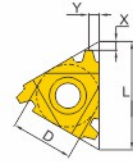
标准型 Standard



标准: ANSI B 1.8:1988
Defined by: ANSI B 1.8:1988
精度等级: 2G
Tolerance class: 2G



标准型 Standard



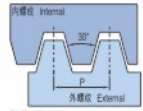
标准型 Standard

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension						
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T			
外 螺 纹 External	3/8"	16	16ER16 STACME	16EL16 STACME	16	1.0	1.1	3.65			
			14	16ER14 STACME	16EL14 STACME	16	1.1	1.1	3.65		
			12	16ER12 STACME	16EL12 STACME	16	1.2	1.2	3.65		
			10	16ER10 STACME	16EL10 STACME	16	1.2	1.3	3.65		
	1/2"	8	16ER8 STACME	16EL8 STACME	16	1.4	1.5	3.65			
			6	16ER6 STACME	16EL6 STACME	16	1.7	1.8	3.65		
			5	22ER5 STACME	22EL5 STACME	22	2.1	2.3	4.76		
			4	27ER4 STACME	27EL4 STACME	27	2.3	2.4	6.35		
5/8"	3	27ER3 STACME	27EL3 STACME	27	2.9	2.9	6.35				
		内 螺 纹 Internal	3/8"	16	16NR16 STACME	16NL16 STACME	16	1.0	1.1	3.65	
					14	16NR14 STACME	16NL14 STACME	16	1.1	1.1	3.65
					12	16NR12 STACME	16NL12 STACME	16	1.2	1.2	3.65
10	16NR10 STACME				16NL10 STACME	16	1.2	1.3	3.65		
1/2"	8		16NR8 STACME	16NL8 STACME	16	1.4	1.5	3.65			
			6	16NR6 STACME	16NL6 STACME	16	1.7	1.8	3.65		
			5	22NR5 STACME	22NL5 STACME	22	2.1	2.3	4.76		
			4	27NR4 STACME	27NL4 STACME	27	2.3	2.4	6.35		
5/8"	3	27NR3 STACME	27NL3 STACME	27	2.9	2.9	6.35				

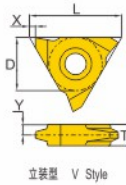
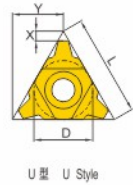
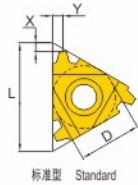


TR-30° 标准梯形螺纹刀片 Trapeze

外螺纹 External



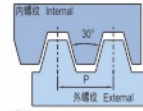
标准: DIN 103
Defined by: DIN 103
精度等级: 7e/7H
Tolerance class: 7e/7H



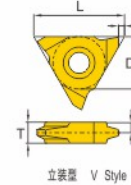
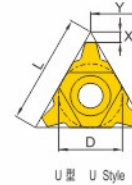
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	3/8"	1.5	16ER1.5 TR	16EL1.5 TR	16	1.0	1.1	3.65
		2.0	16ER2.0 TR	16EL2.0 TR	16	1.1	1.3	3.65
		3.0	16ER3.0 TR	16EL3.0 TR	16	1.3	1.5	3.65
	1/2"	4.0	22ER4.0 TR	22EL4.0 TR	22	1.7	1.9	4.76
		5.0	22ER5.0 TR	22EL5.0 TR	22	2.1	2.5	4.76
		6.0	27ER6.0 TR	27EL6.0 TR	27	2.2	2.6	6.35
5/8"	7.0	27ER7.0 TR	27EL7.0 TR	27	2.3	2.7	6.35	
	7.0	27ER7.0 TR	27EL7.0 TR	27	2.3	2.7	6.35	
右旋型 V Style	5/8"	6.0	27VER6.0 TR	27VEL6.0 TR	27	1.0	3.3	6.35
		7.0	27VER7.0 TR	27VEL7.0 TR	27	1.0	3.3	6.35
		8.0	27VER8.0 TR	27VEL8.0 TR	27	1.0	3.3	6.35
		9.0	27VER9.0 TR	27VEL9.0 TR	27	1.0	4.3	8.70
		10.0	27VER10.0 TR	27VEL10.0 TR	27	1.0	4.3	8.70
		12.0	27VER12.0 TR	27VEL12.0 TR	27	1.0	5.2	10.0
U型 U Style	5/8"	8.0	27UER8.0 TR		27	2.6	13.7	6.35
		9.0	27UE9.0 TR		27	3.0	13.7	6.35

TR-30° 标准梯形螺纹刀片 Trapeze

内螺纹 Internal



标准: DIN 103
Defined by: DIN 103
精度等级: 7e/7H
Tolerance class: 7e/7H

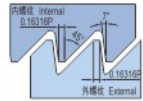


	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	3/8"	1.5	16NR1.5 TR	16NL1.5 TR	16	1.0	1.1	3.65
		2.0	16NR2.0 TR	16NL2.0 TR	16	1.1	1.3	3.65
		3.0	16NR3.0 TR	16NL3.0 TR	16	1.3	1.5	3.65
	1/2"	4.0	22NR4.0 TR	22NL4.0 TR	22	1.7	1.9	4.76
		5.0	22NR5.0 TR	22NL5.0 TR	22	2.1	2.5	4.76
		6.0	27NR6.0 TR	27NL6.0 TR	27	2.2	2.6	6.35
5/8"	7.0	27NR7.0 TR	27NL7.0 TR	27	2.3	2.7	6.35	
	7.0	27NR7.0 TR	27NL7.0 TR	27	2.3	2.7	6.35	
右旋型 V Style	5/8"	6.0	27VNR6.0 TR	27VNL6.0 TR	27	1.0	3.3	6.35
		7.0	27VNR7.0 TR	27VNL7.0 TR	27	1.0	3.3	6.35
		8.0	27VNR8.0 TR	27VNL8.0 TR	27	1.0	3.3	6.35
		9.0	27VNR9.0 TR	27VNL9.0 TR	27	1.0	4.3	8.70
		10.0	27VNR10.0 TR	27VNL10.0 TR	27	1.0	4.3	8.70
		12.0	27VNR12.0 TR	27VNL12.0 TR	27	1.0	5.2	10.0
U型 U Style	5/8"	8.0	27UNR8.0 TR		27	2.6	13.7	6.35
		9.0	27UNR9.0 TR		27	3.0	13.7	6.35

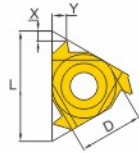


ABUT美制锯齿形螺纹刀片 American Buttress

外螺纹 External



标准: ANSI B 1.9.1973
Defined by: ANSI B 1.9.1973
精度等级: Class 2
Tolerance class: Class 2



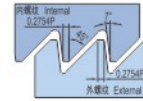
标准型 Standard



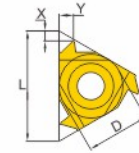
标准型 Standard	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
	1/4"	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand				
			11ER20 ABUT	11EL20 ABUT	11	1.0	1.4	3.20
		16	11ER16 ABUT	11EL16 ABUT	11	1.3	1.9	3.20
	3/8"	20	16ER20 ABUT	16EL20 ABUT	16	1.0	1.4	3.65
		16	16ER16 ABUT	16EL16 ABUT	16	1.3	1.9	3.65
		12	16ER12 ABUT	16EL12 ABUT	16	1.4	2.0	3.65
1/2"	10	16ER10 ABUT	16EL10 ABUT	16	1.5	2.3	3.65	
	8	22ER8 ABUT	22EL8 ABUT	22	2.0	3.2	4.76	
	6	22ER6 ABUT	22EL6 ABUT	22	2.2	3.5	4.76	

BBUT英制锯齿形螺纹刀片 British Buttress

外螺纹 External



标准: B.S.1657-1950
Defined by: B.S.1657-1950
精度等级: Medium Class
Tolerance class: Medium Class

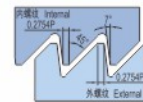


标准型 Standard



标准型 Standard	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
	3/8"	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand				
			16	16ER16 BBUT	16EL16 BBUT	16	1.1	1.6
		12	16ER12 BBUT	16EL12 BBUT	16	1.4	2.1	3.65
	1/2"	10	16ER10 BBUT	16EL10 BBUT	16	1.4	2.2	3.65
		8	16ER8 BBUT	16EL8 BBUT	16	1.6	2.5	3.65
		8	22ER8 BBUT	22EL8 BBUT	22	1.6	2.5	4.76

内螺纹 Internal



标准: B.S.1657-1950
Defined by: B.S.1657-1950
精度等级: Medium Class
Tolerance class: Medium Class



标准型 Standard

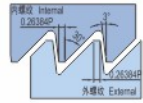


标准型 Standard	内接圆直径D	加工螺距范围 Pitch	刀片型号 Designation		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
	3/8"	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand				
			16	16NR16 BBUT	16NL16 BBUT	16	1.1	1.6
		12	16NR12 BBUT	16NL12 BBUT	16	1.4	2.1	3.65
	1/2"	10	16NR10 BBUT	16NL10 BBUT	16	1.4	2.2	3.65
		8	16NR8 BBUT	16NL8 BBUT	16	1.6	2.5	3.65
		8	22NR8 BBUT	22NL8 BBUT	22	1.6	2.5	4.76

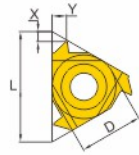


SAGE制制锯齿形螺纹刀片 Sagengewinde

外螺纹 External



标准: DIN 513
Defined by: DIN 513
精度等级: Medium Class
Tolerance class: Medium Class



标准型 Standard

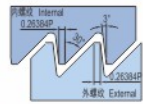


标准型
Standard



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	2.0	16ER2.0 SAGE	16EL2.0 SAGE	16	1.47	2.08	3.65
	2.0	22ER2.0 SAGE	22EL2.0 SAGE	22	1.47	2.08	4.76
1/2"	3.0	22ER3.0 SAGE	22EL3.0 SAGE	22	1.79	2.60	4.76
	4.0	27ER4.0 SAGE	27EL4.0 SAGE	27	1.93	3.20	6.35

内螺纹 Internal



标准: DIN 513
Defined by: DIN 513
精度等级: Medium Class
Tolerance class: Medium Class



标准型 Standard



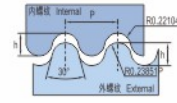
标准型
Standard



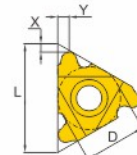
内接圆直径D	加工螺距范围 Pitch	刀片型号 Designation		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	2.0	16NR2.0 SAGE	16NL2.0 SAGE	16	1.52	2.20	3.65
	3.0	22NR3.0 SAGE	22NL3.0 SAGE	22	1.66	2.90	4.76
5/8"	4.0	27NR4.0 SAGE	27NL4.0 SAGE	27	2.12	3.20	6.35

RD消防食品机械螺纹刀片 Round DIN 405

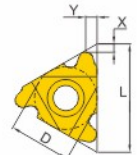
标准型 Standard



标准: DIN 405
Defined by: DIN 405
精度等级: 7h/7H
Tolerance class: 7h/7H



标准型 Standard



标准型 Standard

外螺纹
External



内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	h _{min} T
3/8"	10	16ER10 RD	16EL10 RD	16	1.1	1.2	1.27 3.65
	8	16ER8 RD	16EL8 RD	16	1.3	1.4	1.59 3.65
	6	16ER6 RD	16EL6 RD	16	1.5	1.7	2.12 3.65
1/2"	6	22ER6 RD	22EL6 RD	22	1.5	1.7	2.12 4.76
	4	22ER4 RD	22EL4 RD	22	1.7	2.3	3.18 4.76
5/8"	4	27ER4 RD	27EL4 RD	27	1.7	2.3	3.18 6.35
	10	16NR10 RD	16NL10 RD	16	1.1	1.2	1.27 3.65
3/8"	8	16NR8 RD	16NL8 RD	16	1.3	1.4	1.59 3.65
	6	16NR6 RD	16NL6 RD	16	1.5	1.7	2.12 3.65
	4	22NR4 RD	22NL4 RD	22	1.7	2.3	3.18 4.76
5/8"	4	27NR4 RD	27NL4 RD	27	1.7	2.3	3.18 6.35

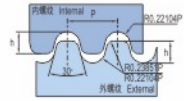
内螺纹
Internal



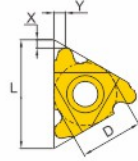


RD消防食品机械螺纹刀片 Round 20400

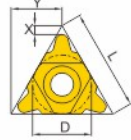
外螺纹 External



标准: DIN 20400
Defined by: DIN 20400
精度等级: Standard
Tolerance class: Standard



标准型 Standard

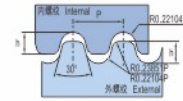


U型 U Style

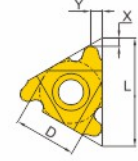
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension						
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	h _{min}	T		
标准型 Standard	1/2"	3.0	22ER3.0 RD	22EL3.0 RD	22	1.28	1.70	1.65	4.76		
			4.0	22ER4.0 RD	22EL4.0 RD	22	1.60	2.20	2.20	4.76	
			5.0	22ER5.0 RD	22EL5.0 RD	22	1.36	1.75	2.75	4.76	
			6.0	22ER6.0 RD	22EL6.0 RD	22	1.70	2.10	3.30	4.76	
U型 U Style	5/8"	8.0	27UEN8.0 RD		27	2.95	13.5	4.40	6.35		

RD消防食品机械螺纹刀片 Round 20400

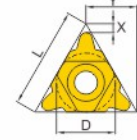
内螺纹 Internal



标准: DIN 20400
Defined by: DIN 20400
精度等级: Standard
Tolerance class: Standard



标准型 Standard

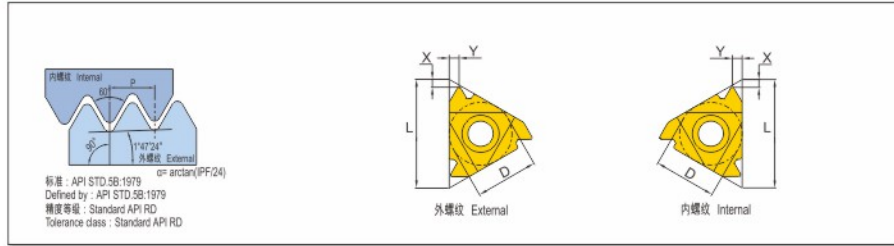


U型 U Style

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension						
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	h _{min}	T		
标准型 Standard	1/2"	3.0	22NR3.0 RD	22NL3.0 RD	22	1.32	1.70	1.65	4.76		
			4.0	22NR4.0 RD	22NL4.0 RD	22	1.64	2.20	2.20	4.76	
			5.0	22NR5.0 RD	22NL5.0 RD	22	1.41	1.75	2.75	4.76	
			6.0	22NR6.0 RD	22NL6.0 RD	22	1.75	2.10	3.30	4.76	
U型 U Style	5/8"	8.0	27UEN8.0 RD		27	2.95	13.50	4.40	6.35		

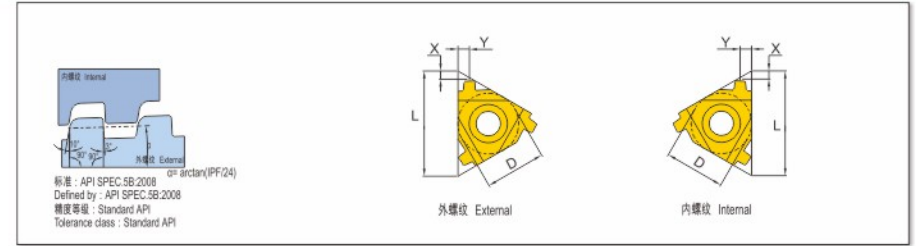


石油管API圆螺纹刀片 API Round Casing & Tubing



	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand		L	X	Y	T
外螺纹 External	3/8"	TPI	16ER10 APIRD		16	1.2	1.4	3.65
			16ER8 APIRD		16	1.3	1.5	3.65
内螺纹 Internal	3/8"	10	16NR10 APIRD		16	1.2	1.4	3.65
		8	16NR8 APIRD		16	1.3	1.5	3.65

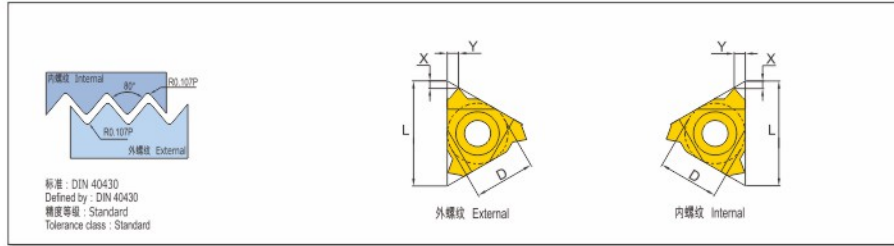
石油管API偏梯型螺纹刀片 API Buttress Casing



	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand		L	X	Y	T
外螺纹 External	1/2"	TPI	22ERS BUT		22	3.1	1.9	4.76
内螺纹 Internal	1/2"	5	22NRS BUT		22	2.8	1.9	4.76



Pg 螺纹刀片 Pg



标准: DIN 40430
Defined by: DIN 40430
精度等级: Standard
Tolerance class: Standard

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension				
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T	
外螺纹 External	1/4"	20	Pg7	11ER20 Pg	11EL20 Pg	11	0.8	0.9	3.20
		18	Pg9/11/13.5/16	11ER18 Pg	11EL18 Pg	11	0.8	1.0	3.20
		16	Pg21/29/36/42/48	11ER16 Pg	11EL16 Pg	11	0.9	1.1	3.20
	3/8"	20	Pg7	16ER20 Pg	16EL20 Pg	16	0.8	0.9	3.65
		18	Pg9/11/13.5/16	16ER18 Pg	16EL18 Pg	16	0.8	1.0	3.65
		16	Pg21/29/36/42/48	16ER16 Pg	16EL16 Pg	16	0.9	1.1	3.65
内螺纹 Internal	1/4"	20	Pg7	11NR20 Pg	11NL20 Pg	11	0.8	0.9	3.20
		18	Pg9/11/13.5/16	11NR18 Pg	11NL18 Pg	11	0.8	1.0	3.20
		16	Pg21/29/36/42/48	11NR16 Pg	11NL16 Pg	11	0.9	1.1	3.20
	3/8"	20	Pg7	16NR20 Pg	16NL20 Pg	16	0.8	0.9	3.65
		18	Pg9/11/13.5/16	16NR18 Pg	16NL18 Pg	16	0.8	1.0	3.65
		16	Pg21/29/36/42/48	16NR16 Pg	16NL16 Pg	16	0.8	1.1	3.65

通用型立装螺纹刀片 Partial Profile V Style Inserts

	刀片型号 Ordering Code	加工螺距范围 Pitch	刀尖圆弧半径
		mm	Re
60°通用螺纹刀片 Partial Profile 60°	MTTR/L 436001	1.0-1.75	R0.1
	MTTR/L 436002	2.0-2.5	R0.2
	MTTR/L 436003	3.0-3.5	R0.3
	MTTR/L 436004	4.0-4.5	R0.4
55°通用螺纹刀片 Partial Profile 55°	MTTR/L 435501	1.0-1.75	R0.1
	MTTR/L 435502	2.0-2.5	R0.2
	MTTR/L 435503	3.0-3.5	R0.3
	MTTR/L 435504	4.0-4.5	R0.4

旋风螺纹铣刀片 Partial Profile Thread Whirling Milling Inserts

	刀片尺寸 Dimension	刀片型号 Ordering Code
		60°通用螺纹刀片 Partial Profile 60°
	60°通用螺纹刀片 Partial Profile 60°	SV1604
	60°通用螺纹刀片 Partial Profile 60°	SV0903



可转位螺纹车刀刀柄型号说明 Threading Turning Toolholder Ordering Code System

螺纹刀片加紧方式

S — 螺钉偏心压紧 Screw on
 C — 上压板压紧 Top Clamping
 SC — 螺钉偏心压紧 + 上压板压紧 Screw On & Top Clamping
 T — 刚性上压式 T — Holder

V — 立装型 V Style

U — U型 U Style

E — 外螺纹 External

N — 内螺纹 Internal

R — 右手刀 Right Hand

L — 左手刀 Left Hand

外螺纹 — 刀尖高度 Cutting Height

内螺纹 — 用00表示 Internal "00"

S **V** **E** **R** **20** **20** **K** **16** **9**

外 — 刀柄宽度 Shank Width For External
 内 — 刀柄直径 Diameter Of Shank For Internal

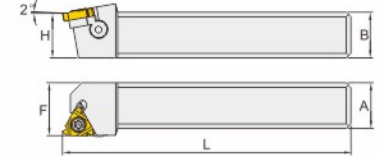
刀具长度 Length Of Toolholder
 H — 100 M — 150 Q — 180 S — 250 U — 350
 K — 125 P — 170 R — 200 T — 300 V — 400

螺纹刀片代号 Insert Dimension		
代号 Code	刀片内切圆 D	刀片边长mm Insert Edge Length
06	3.97(5/12")	6
08	5.00(3/16")	8
11	6.35(1/4")	11
16	9.53(3/8")	16
22	12.70(1/2")	22
27	15.88(5/8")	27

特殊用途 For Special

外螺纹刀杆 External Threading Toolholders

标准型 Standard



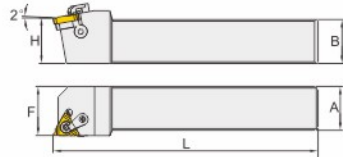
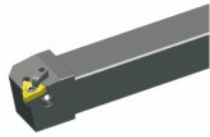
订货号 Order No.		尺寸 Dimensions (mm)											
右刀 Right	左刀 Left	H	A	B	L	F	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	刀垫 Anvil 右 R 左 L	刀垫螺钉 Anvil Screw	扳手 Wrench	
SER 0808H06	SEL 0808H06	8	8	8	100	11	06ER/L□□□□	M2.2×6.3	T07				
SER 0808H08	SEL 0808H08	8	8	8	100	11	08ER/L□□□□	M2.5×6.5	T07				
SER 0808H11	SEL 0808H11	8	8	8	100	11	11ER□□□□ 11EL□□□□	M3×7.2	T08				
SER 1010H11	SEL 1010H11	10	10	10	100	11							
SER 1212H11	SEL 1212H11	12	12	12	100	12							
SER 1616H16	SEL 1616H16	16	16	16	100	20							
SER 2020K16	SEL 2020K16	20	20	20	125	25	16ER□□□□ 16EL□□□□	M3.5×12	T15	Y16E Y16N	M3×5	S2.5	
SER 2525M16	SEL 2525M16	25	25	25	150	32							
SER 3225P16	SEL 3225P16	32	32	32	170	32							
SER 3232P16	SEL 3232P16	32	32	32	170	40							
SER 2525M22	SEL 2525M22	25	25	25	150	32	22ER□□□□ 22EL□□□□	M4×14	T15	Y22E Y22N	M3×5	S2.5	
SER 3232P22	SEL 3232P22	32	32	32	170	40							
SER 2525M27	SEL 2525M27	25	25	25	150	35							
SER 3232P27	SEL 3232P27	32	32	32	170	40	27ER□□□□ 27EL□□□□	M6×16	T20	Y27E Y27N	M3×5	S2.5	
SER 4040R27	SEL 4040R27	40	40	40	200	40							
SER 5050S27	SEL 5050S27	50	50	50	250	40							

* 刀杆带1.5°螺旋角。如需其它螺旋角，可以更换刀垫或订制其它相应螺旋角的刀杆。
 * All tool holders have a 1.5° helix angle. Other helix angle anvils or tool holders with other helix angle can be available.



外螺纹刀杆 External Threading Toolholders

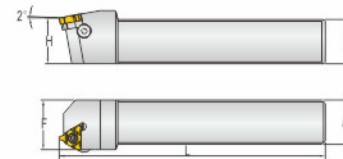
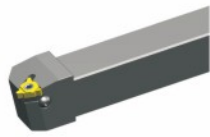
标准型 (带压板)
Standard with a clamp



订货号 Order No.		尺寸 Dimensions (mm)											
右刀 Right	左刀 Left	H	A	B	L	F	刀片 Insert	勾头压板 Clamp	梅花扳手 Torx Key	双头螺钉 Screw	刀垫 Anvil 右 R 左 L	刀垫螺钉 Anvil Screw	扳手 Wrench
CER 2020K16	CEL 2020K16	20	20	20	125	25	16ER0000 16EL0000	CL-20	T15	XNS-48	Y16E Y16N	M3×5	1/8 S2.5
CER 2525M16	CEL 2525M16	25	25	25	150	30							
CER 3232P16	CEL 3232P16	32	32	32	170	37							
CER 2525M22	CEL 2525M22	25	25	25	150	30	22ER0000 22EL0000	CL-12	T15	XNS-510	Y22E Y22N	M3×5	5/32 S2.5
CER 3232P22	CEL 3232P22	32	32	32	170	37							
CER 4040R22	CEL 4040R22	40	40	40	200	45							

- * 刀杆带1.5°螺旋升角。如需其它螺旋升角，可以更换刀垫或订制其它相应螺旋升角的刀杆。
- * All tool holders have a 1.5° helix angle. Other helix angle anvils or tool holders with other helix angle can be available.

U - 型
U - Style

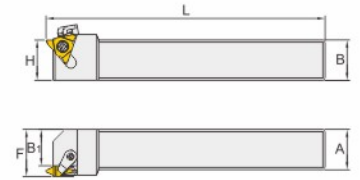
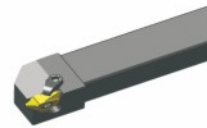


订货号 Order No.		尺寸 Dimensions (mm)											
右刀 Right	左刀 Left	H	A	B	L	F	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	刀垫 Anvil	刀垫螺钉 Anvil Screw	扳手 Wrench	
SUER 3232P22	SUEL 3232P22	32	32	32	170	37	22UE0000	M4×14	T15	Y22U	M3×5	S2.5	
SUER 4040R22	SUEL 4040R22	40	40	40	200	45							
SUER 3232P27	SUEL 3232P27	32	32	32	170	37							
SUER 4040R27	SUEL 4040R27	40	40	40	200	45	27UE0000	M6×16	T20	Y27U	M3×5	S2.5	
SUER 5050S27	SUEL 5050S27	50	50	50	250	55							

- * 刀杆带1.5°螺旋升角。如需其它螺旋升角，可以更换刀垫或订制其它相应螺旋升角的刀杆。
- * All tool holders have a 1.5° helix angle. Other helix angle anvils or tool holders with other helix angle can be available.

外螺纹刀杆 External Threading Toolholders

立装型
V - Style



订货号 Order No.		尺寸 Dimensions (mm)													
右刀 Right	左刀 Left	H	A	B	L	F	B1	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	勾头压板 Clamp	双头螺钉 Anvil Screw	扳手 Wrench		
SCVER3232P27-6	SCVEL3232P27-6	32	32	32	170	32	26	27VER0000 27VEL0000	M6×16	T20	CL-12	XNS-510	5/32		
SCVER3232P27-8	SCVEL3232P27-8	32	32	32	170	34	26								
SCVER3232P27-10	SCVEL3232P27-10	32	32	32	170	36	26								
SCVER4040R27-6	SCVEL4040R27-6	40	40	40	200	40	34								
SCVER4040R27-8	SCVEL4040R27-8	40	40	40	200	42	34								
SCVER4040R27-10	SCVEL4040R27-10	40	40	40	200	44	34								

- * 刀杆带1.5°螺旋升角。
- * All tool holders have a 1.5° helix angle.

立装型 (专用于MTTR系列刀片)
V - Style (Only for MTTR threading inserts)



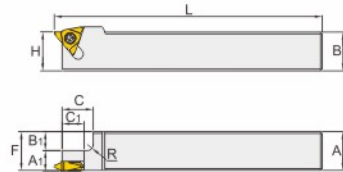
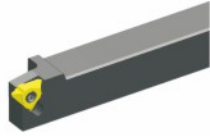
订货号 Order No.		尺寸 Dimensions (mm)											
右刀 Right	左刀 Left	H	A	B	L	F	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	压板 Clamp	弹簧 Spring	扳手 Wrench	
MTHR2525M4	MTHL2525M4	25	25	25	150	30	MTTR430000	M6×16	T15	MTK1R MTK1L	MES3	S4	
MTHR3232P4	MTHL3232P4	32	32	32	170	37							
MTHR4040R4	MTHL4040R4	40	40	40	200	45							

- * 刀杆带1.5°螺旋升角。
- * All tool holders have a 1.5° helix angle.



外螺纹刀杆 External Threading Toolholders

狭窄部位用螺纹刀
Slim Throat



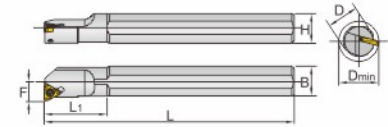
订货号 Order No.		尺寸 Dimensions (mm)										刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key
右刀 Right	左刀 Left	H	A	B	L	F	B ₁	C	C ₁	R	A ₁			
SER1010H16S	SEL1010H16S	14	10	10	100	10	6.4	14.5	11.5	3	7	16VER□□□□ 16VEL□□□□	M3.5×12	T15
SER1212H16S	SEL1212H16S	14	12	12	100	12	8.4	14.5	11.5	3	7			
SER1616H16S	SEL1616H16S	16	16	16	100	16	12.4	14.5	11.5	3	7			
SER2020K16S	SEL2020K16S	20	20	20	125	20	16.4	16.5	11.5	3	7			
SER2525M16S	SEL2525M16S	25	25	25	150	25	21.4	16.5	11.5	3	7			
SER3232P16S	SEL3232P16S	32	32	32	170	32	28.4	16.5	11.5	3	7			
SER4040R16S	SEL4040R16S	40	40	40	200	40	36.4	16.5	11.5	3	7			

* 刀杆带1.5°螺旋升角。

* All tool holders have a 1.5° helix angle.

内螺纹刀杆 Internal Threading Toolholders

标准型
Standard



订货号 Order No.		尺寸 Dimensions (mm)								刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	刀垫Anvil 右 R 左 L		刀垫螺钉 Anvil Screw	扳手 Wrench
右刀 Right	左刀 Left	D	F	L	H	D _{min}	B	L ₁								
SNR 0006H06	SNL 0006H06	6	3.3	100	5.8	7	6.0	10	06NR/L□□□□	M2.2×6.5	T07					
SNR 0008H08	SNL 0008H08	8	4.6	100	7.4	9	7.6	15	08NR/L□□□□	M2.5×6.5	T07					
SNR 0010H11	SNL 0010H11	10	7.2	100	9	12	9.5	25	11NR/L□□□□	M3×7.2	T08					
SNR 0012H11	SNL 0012H11	12	9	125	11	16	11.5	32	11NR/L□□□□	M3×7.2	T08					
SNR 0016M16	SNL 0016M16	16	12	150	15	20	15.5	32	16NR/L□□□□	M3.5×12	T15	Y16N	Y16E			
SNR 0020Q16	SNL 0020Q16	20	14	180	18	25	19.0	40	16NR/L□□□□	M3.5×12	T15	Y16N	Y16E			
SNR 0025R16	SNL 0025R16	25	17.5	200	23	30	24.0	50	16NR/L□□□□	M3.5×12	T15	Y16N	Y16E			
SNR 0032S16	SNL 0032S16	32	22	250	30	38	31.0	55	16NR/L□□□□	M3.5×12	T15	Y16N	Y16E		M3×5	S2.5
SNR 0032S22	SNL 0032S22	32	22	250	30	38	31.0	55	22NR/L□□□□	M4×12	T15	Y22N	Y22E			
SNR 0032S27	SNL 0032S27	32	22.6	250	30	40	31.0	55	27NR/L□□□□	M6×16	T20	Y27N	Y27E			
SNR 0040T27	SNL 0040T27	40	26.6	300	38	48	39.0	60	27NR/L□□□□	M6×16	T20	Y27N	Y27E			

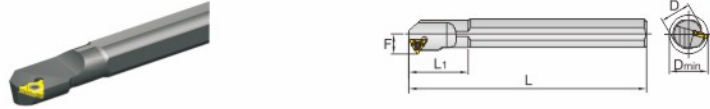
* 刀杆带1.5°螺旋升角。如需其它螺旋升角，可更换刀垫或订制其它相应螺旋升角的刀杆。

* All tool holders have a 1.5° helix angle. Other helix angle anvils or tool holders with other helix angle can be available.



内螺纹刀杆 Internal Threading Toolholders

U - 型
U - Style

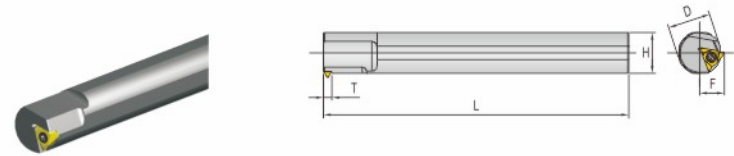


订货号 Order No.		尺寸 Dimensions (mm)										
右刀 Right	左刀 Left	D	F	L	D _{min}	L ₁	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	刀垫 Anvil	刀垫螺钉 Anvil Screw	扳手 Wrench
SUNR 0032S22	SUNL 0032S22	32	25.5	250	42	60	22UN□□□□	M4×14	T15	Y22U	M3×5	S2.5
SUNR 0040T22	SUNL 0040T22	40	29.5	300	51	60						
SUNR 0032S27	SUNL 0032S27	32	24.7	250	42	60	27UN□□□□	M6×16	T20	Y27U	M3×5	S2.5
SUNR 0040T27	SUNL 0040T27	40	29.4	300	53	60						
SUNR 0050U27	SUNL 0050U27	50	34.3	350	63	75						
SUNR 0060V27	SUNL 0060V27	60	39.3	400	74	75						

- * 刀杆带1.5°螺旋升角。如需其它螺旋升角，可以更换刀垫或订制其它相应螺旋升角的刀杆。
- * All tool holders have a 1.5° helix angle. Other helix angle anvils or tool holders with other helix angle can be available.

内螺纹刀杆 Internal Threading Toolholders

V-型
V-Style



订货号 Order No.		尺寸 Dimensions (mm)							
右刀 Right	左刀 Left	D	F	L	H	T	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key
SVNR0040T27-6	SVNL0040T27-6	40	28.4	300	38	6	27VNR/L□□□□	M6×16	T20
SVNR0040T27-8	SVNL0040T27-8	40	28.4	300	38	8		M6×20	
SVNR0040T27-10	SVNL0040T27-10	40	28.4	300	38	10		M6×20	
SVNR0050U27-6	SVNL0050U27-6	50	33.4	350	48	6		M6×16	
SVNR0050U27-8	SVNL0050U27-8	50	33.4	350	48	8		M6×20	
SVNR0050U27-10	SVNL0050U27-10	50	33.4	350	48	10		M6×20	
SVNR0060V27-6	SVNL0060V27-6	60	38.4	400	58	6		M6×16	
SVNR0060V27-8	SVNL0060V27-8	60	38.4	400	58	8		M6×20	
SVNR0060V27-10	SVNL0060V27-10	60	38.4	400	58	10		M6×20	

- * 刀杆带1.5°螺旋升角。
- * All tool holders have a 1.5° helix angle.



标准螺纹刀具套装 (Threading Kit)

标准螺纹刀具套装可以加工数量小但品种不同螺距的螺纹。
Threading Kits are versatile solution for users that cut a variety of thread types in limited quantity and do not want to sacrifice thread quality.

ISO标准外螺纹套装

ISO External KIT Ordering

订货号: KEG
Order NO: KEG

右刀 Right 左刀 Left

刀片 INSERTS

16ER A60	M20
16ER G60	M20
16ER 0.75 ISO	M20
16ER 1.0 ISO	M20
16ER 1.25 ISO	M20
16ER 1.5 ISO	M20
16ER 1.75 ISO	M20
16ER 2.0 ISO	M20
16ER 2.5 ISO	M20
16ER 3.0 ISO	M20

刀杆 TOOLHOLDER

SER 2020 K16

扳手 Wrench

T15

紧固螺钉 Screw

M3.5×12

ISO标准内螺纹套装

ISO Internal KIT Ordering

订货号: KNG
Order NO: KNG

右刀 Right 左刀 Left

刀片 INSERTS

16NR A60	M20
16NR G60	M20
16NR 0.75 ISO	M20
16NR 1.0 ISO	M20
16NR 1.25 ISO	M20
16NR 1.5 ISO	M20
16NR 1.75 ISO	M20
16NR 2.0 ISO	M20
16NR 2.5 ISO	M20
16NR 3.0 ISO	M20

刀杆 TOOLHOLDER

SNR 0020 P16

扳手 Wrench

T15

紧固螺钉 Screw

M3.5×12



如需25mm的刀杆, 请在订货号中加入“25”, 例如: KNG-25.

If larger Toolholder with 25mm shank is desired, add to the Kit number-25.
For example: KNG-25.

螺纹铣削刀具 THREADING MILLING TOOLS

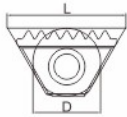
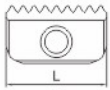




H系列螺纹铣刀片型号说明 H Line Threading Milling Insert Ordering code System

1、刀片尺寸 Insert Size

12 — L = 12mm	6.0 — D = 6.0mm	L = 10.4mm
14 — L = 14mm	2 — D = 1/4"	L = 11mm
21 — L = 21mm	3 — D = 3/8"	L = 16mm
30 — L = 30mm	3B — D = 3/8" B	L = 22mm
40 — L = 40mm	4 — D = 1/2"	L = 22mm
	5 — D = 5/8"	L = 27mm
	6B — D = 3/4" B	L = 38.5mm



2、加工类型 Type of inserts

- E — 外螺纹 External
- N — 内螺纹 Internal
- — 对两面刃刀片，一面做外螺纹，另一面做内螺纹。
One edge for internal, other edge for external.
- EN — 内外刀片通用
The Same Insert for External or Internal

21

1

E

2

1.50

3

ISO

4

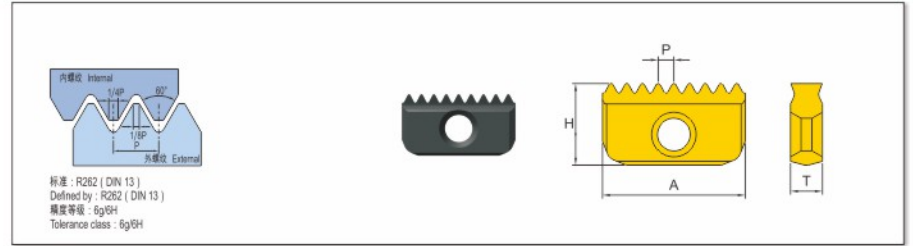
3、螺纹 Pitch

完全形 mm	Full Profile TPI
0.5~6	48~4
局部面截顶形 mm	Partial Profile TPI
A 0.5~1.5	48~16
AG 0.5~3.0	48~8
G 1.75~3.0	14~8
N 3.5~5.0	7~5
Q 5.5~6.0	4.5~4
V 6.0~10	4~2.5

4、螺纹标准 Standard

- ISO — ISO 标准型螺纹 ISO Metric
- UN — 60° 美制统一标准型螺纹 American UN
- W — 55° 英国惠氏螺纹 Whitworth for BSW BSP
- NPT — 60° 美国标准锥管螺纹 NPT
- NPTF — 60° 美制干密封螺纹 NPTF
- BSPT — 55° 英制标准锥管螺纹 British Standard Pipe Thread

ISO标准型螺纹铣刀片 ISO Metric Full Profile



加工螺距 Pitch mm	刀片尺寸 Insert Size				
	A=12mm	A=14mm	A=21mm	A=30mm	A=40mm
0.5	外 Ext				
	内 Int	*12N0.5 ISO	14N0.5 ISO		
0.75	外 Ext		14E0.75 ISO		
	内 Int	*12N0.75 ISO	14N0.75 ISO		
1	外 Ext		14E1.0 ISO	21E1.0 ISO	
	内 Int	*12N1.0 ISO	14N1.0 ISO	21N1.0 ISO	
1.25	外 Ext		14E1.25 ISO		
	内 Int	*12N1.25 ISO	14N1.25 ISO		
1.5	外 Ext		14E1.5 ISO	21E1.5 ISO	30E1.5 ISO
	内 Int	*12N1.5 ISO	14N1.5 ISO	21N1.5 ISO	30N1.5 ISO
1.75	外 Ext		14E1.75 ISO		
	内 Int		14N1.75 ISO	21N1.75 ISO	
2	外 Ext		14E2.0 ISO	21E2.0 ISO	30E2.0 ISO
	内 Int		14N2.0 ISO	21N2.0 ISO	30N2.0 ISO
2.5	外 Ext		14E2.5 ISO	21E2.5 ISO	
	内 Int		14N2.5 ISO	21N2.5 ISO	
3	外 Ext			21E3.0 ISO	30E3.0 ISO
	内 Int			21N3.0 ISO	30N3.0 ISO
3.5	外 Ext				30E3.5 ISO
	内 Int			21N3.5 ISO	30N3.5 ISO
4	外 Ext				30E4.0 ISO
	内 Int				30N4.0 ISO
4.5	外 Ext				
	内 Int				30N4.5 ISO
5	外 Ext				40E5.0 ISO
	内 Int				40N5.0 ISO
5.5	外 Ext				
	内 Int				40N5.5 ISO
6.0	外 Ext				40E6.0 ISO
	内 Int				40N6.0 ISO
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

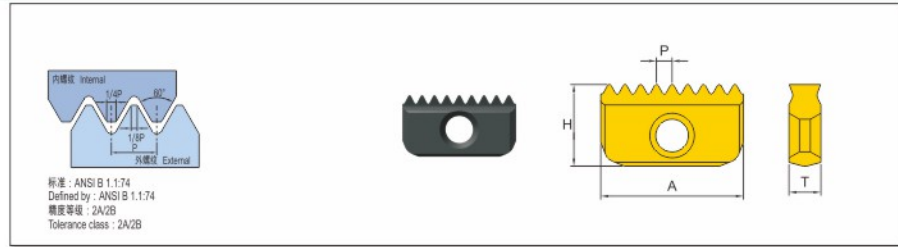
* 带"*"的刀片只有单面刃。

* Insert with one cutting edge.



螺纹铣削刀具 THREADING MILLING TOOLS

UN-60° 美制统一标准螺纹铣刀片 UN-60° American UN Full Profile

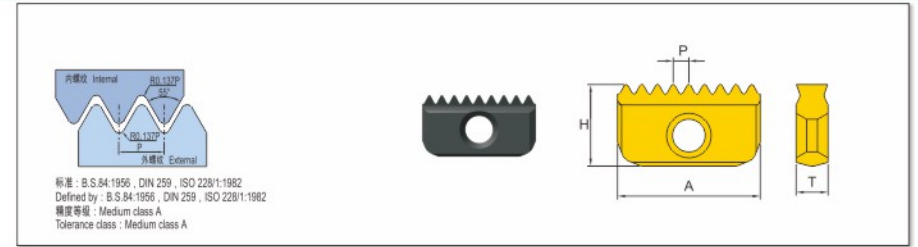


加工螺距 Pitch		刀片尺寸 Insert Size				
TPI		A=12mm	A=14mm	A=21mm	A=30mm	A=40mm
32	外 Ext		14E32 UN			
	内 Int	*12N32 UN	14N32 UN			
28	外 Ext		14E28 UN			
	内 Int	*12N28 UN	14N28 UN			
27	外 Ext					
	内 Int		14N27 UN			
24	外 Ext		14E24 UN	21E24 UN		
	内 Int	*12N24 UN	14N24 UN	21N24 UN		
20	外 Ext		14E20 UN	21E20 UN	30E20 UN	
	内 Int	*12N20 UN	14N20 UN	21N20 UN	30N20 UN	
18	外 Ext		14E18 UN	21E18 UN	20E18 UN	
	内 Int	*12N18 UN	14N18 UN	21N18 UN	30N18 UN	
16	外 Ext		14E16 UN	21E16 UN	30E16 UN	40E16 UN
	内 Int	*12N16 UN	14N16 UN	21N16 UN	30N16 UN	40N16 UN
14	外 Ext		14E14 UN	21E14 UN	30E14 UN	40E14 UN
	内 Int		14N14 UN	21N14 UN	30N14 UN	40N14 UN
12	外 Ext		14E12 UN	21E12 UN	30E12 UN	40E12 UN
	内 Int		14N12 UN	21N12 UN	30N12 UN	40N12 UN
10	外 Ext			21E10 UN	30E10 UN	40E10 UN
	内 Int			21N10 UN	30N10 UN	40N10 UN
8	外 Ext				30E8 UN	40E8 UN
	内 Int			21N8 UN	30N8 UN	40N8 UN
6	外 Ext				30E6 UN	40E6 UN
	内 Int				30N6 UN	40N6 UN
4.5	外 Ext					40N4.5 UN
	内 Int					
4	外 Ext					
	内 Int					40N4 UN
H		6.3	7.5	12	16	20
T		2.9	3.1	4.7	5.5	6.3

- * 带“*”的刀片只有单面刃。
- * Insert with one cutting edge.

螺纹铣削刀具 THREADING MILLING TOOLS

W-55° 英国惠氏螺纹铣刀片 W-55° Whitworth Full Profile



加工螺距范围 Pitch		刀片尺寸 Insert Size				
TPI		A=12mm	A=14mm	A=21mm	A=30mm	A=40mm
24			14EN24W			
20			14EN20W	21EN20W		
19		*12E19W, *12N19W	14EN19W	21EN19W		
16			14EN16W	21EN16W	30EN16W	
14			14EN14W	21EN14W	30EN14W	
11				21EN11W	30EN11W	40EN11W
8						40EN8W

- * 带“*”的刀片只有单面刃。
- * Insert with one cutting edge.

NPTF 美制干密封锥管螺纹铣刀片 NPTF(Dry seal)



加工螺距 Pitch		刀片尺寸 Insert Size				
TPI		A=12mm	A=14mm	A=21mm	A=30mm	A=40mm
18		*12E18NPTF, *12N18NPTF	14 - 18NPTF			
14			14 - 14NPTF	21 - 14NPTF		
11.5				21 - 11.5NPT	30 - 11.5NPTF	40 - 11.5NPTF
8					30 - 8NPTF	40 - 8NPTF

- * 带“*”的刀片只有单面刃。
- * Insert with one cutting edge.



螺纹铣削刀具 THREADING MILLING TOOLS

NPT-60° 美国标准锥管螺纹铣刀片 NPT-60° National Pipe Threads



加工螺距 Pitch	刀片尺寸 Insert Size				
TPI	A=12mm	A=14mm	A=21mm	A=30mm	A=40mm
18	*12E18NPT, *12N18NPT	14 - 18NPT			
14		14 - 14NPT	21 - 14NPT		
11.5			21 - 11.5NPT	30 - 11.5NPT	40 - 11.5NPT
8				30 - 8NPT	40 - 8NPT

- *带“*”的刀片只有单面刃。
- * Insert with one cutting edge.

BSPT-55° 英国标准锥管螺纹铣刀片 BSPT-55° British Standard Pipe Full Profile

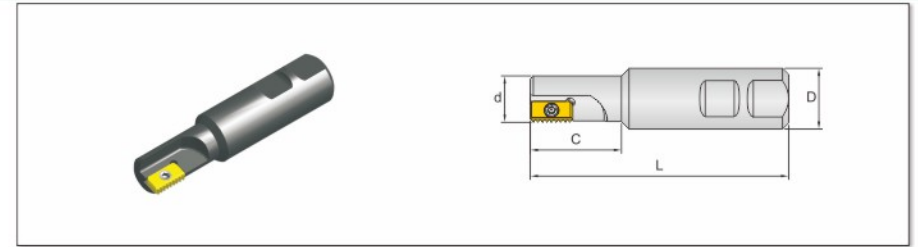


加工螺距范围 Pitch	刀片尺寸 Insert Size				
TPI	A=12mm	A=14mm	A=21mm	A=30mm	A=40mm
19	*12 E19BSPT, *12 N19BSPT	14 - 14BSPT			
14		14 - 14BSPT	21 - 14BSPT		
11			21 - 11BSPT	30 - 11PSPT	40 - 11BSPT

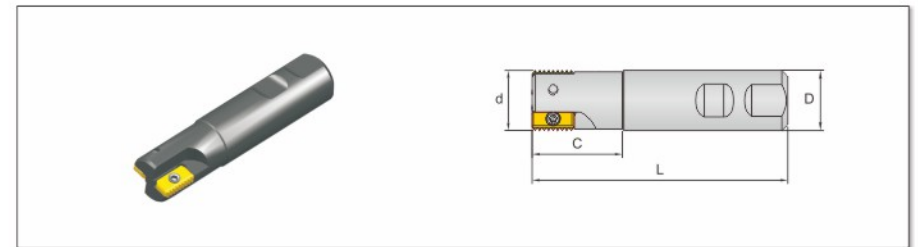
- *带“*”的刀片只有单面刃。
- * Insert with one cutting edge.

螺纹铣削刀具 THREADING MILLING TOOLS

螺纹铣刀杆 Threading Milling Toolholders



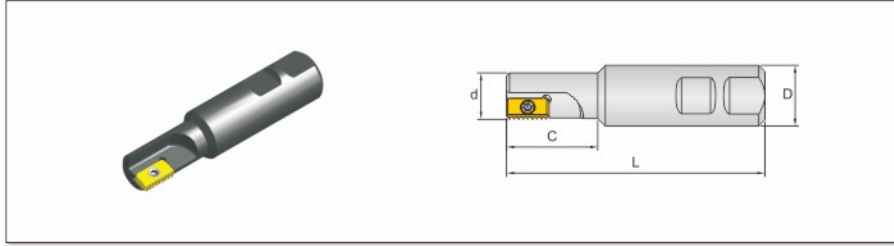
订货号 Order No.	尺寸 Dimensions (mm)				齿数 Teeth	螺距 Pitch	刀片 Insert	螺钉 Screw	梅花扳手 Torx Key
	d	D	C	L	Z _t	mm	TPI		
ST90-25R1T21-A20L125	25	20	30	125	1	1~3.5	7~24	21□□□	M3.5×8 T15
ST90-31R1T30-A25L150	31	25	50	150	1	1.5~5.0	6~20	30□□□	M4×0.5×11 T15
ST90-38R1T30-A32L150	38	32	50	150	1	1.5~5.0	6~20	30□□□	M4×0.5×11 T20
ST90-48R1T40-A40L210	48	40	78	210	1	1.5~6.0	4~16	40□□□	M5×11 T20



订货号 Order No.	尺寸 Dimensions (mm)				齿数 Teeth	螺距 Pitch	刀片 Insert	螺钉 Screw	梅花扳手 Torx Key
	d	D	C	L	Z _t	mm	TPI		
ST90-20R2T14-B20	20	20	41	96	2	0.5~2.5	10~32	14□□□	M3×8 T08
ST90-30R2T21-B25	30	25	52	113	2	1~3.5	7~24	21□□□	M3.5×12 T15
ST90-40R2T30-B32	40	32	70	135	2	1.5~5.0	6~20	30□□□	M4×12 T20
ST90-50R2T40-B40	50	40	78	153	2	1.5~6.0	4~16	40□□□	M5×12 T20

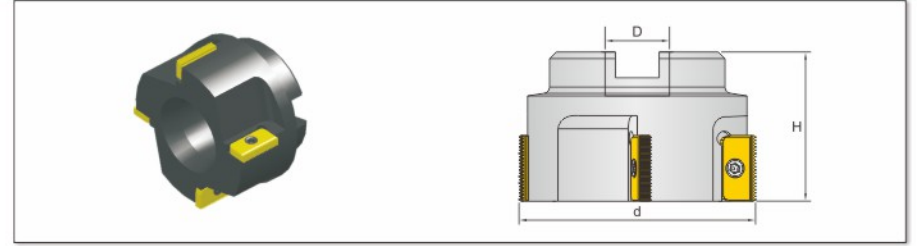


螺纹铣刀杆 Threading Milling Toolholders



订货号 Order No.	尺寸 Dimensions (mm)				齿数 Teeth	螺距 Pitch		刀片 Insert	螺钉 Screw	梅花扳手 Torx Key
	d	D	C	L		Zt	mm			
ST90-9.5R1T12-B20	9.5	20	14	85	1	0.5~1.5	16~32	12000	M2.5×7.5	T08
ST90-9.9R1T12-B20	9.9	20	16	85	1	0.5~1.5	16~32	12000	M2.5×7.5	T08
ST90-12R1T14-B20	12	20	20	85	1	0.5~2.5	10~32	14000	M3×7.5	T08
ST90-14.5R1T14-B20	14.5	20	25	85	1	0.5~2.5	10~32	14000	M3×7.5	T08
ST90-17R1T14-B20	17	20	30	85	1	0.5~2.5	10~32	14000	M3×7.5	T08
ST90-18R1T21-B20	18	20	30	85	1	1~3.5	7~24	21000	M3.5×8	T15
ST90-21R1T21-B20	21	20	40	94	1	1~3.5	7~24	21000	M3.5×8	T15
ST90-29R1T30-B25	29	25	50	110	1	1.5~5.0	6~20	30000	M4×0.5×11	T20
ST90-48R1T40-B40	48	40	78	153	1	1.5~6.0	4~16	40000	M5×11	T20

螺纹铣刀杆 Threading Milling Toolholders

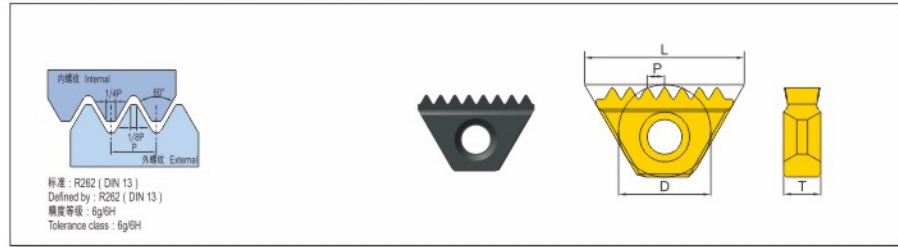


订货号 Order No.	尺寸 Dimensions (mm)			齿数 Teeth	螺距 Pitch		刀片 Insert	螺钉 Screw	梅花扳手 Torx Key
	d	D	L		Zt	mm			
ST90-63RST21-P22	63	22	50	5	1~3.5	7~24	21000	M3.5×7.5	T15
ST90-63RAT30-P22	63	22	50	4	1.5~5.0	6~20	30000	M4×1×11	T20
ST90-80RAT30-P27	80	27	55	4	1.5~5.0	6~20	30000	M4×1×11	T20
ST90-100RAT30-S22	100	32	60	4	1.5~5.0	6~20	30000	M4×1×11	T20
ST90-80RAT40-P27	80	27	65	4	1.5~6.0	4~16	40000	M4×1×11	T20
ST90-100RAT40-S32	100	32	70	4	1.5~6.0	4~16	40000	M4×1×11	T20



螺纹铣削刀具 THREADING MILLING TOOLS

ISO 标准型螺纹铣刀片 ISO Metric Full Profile

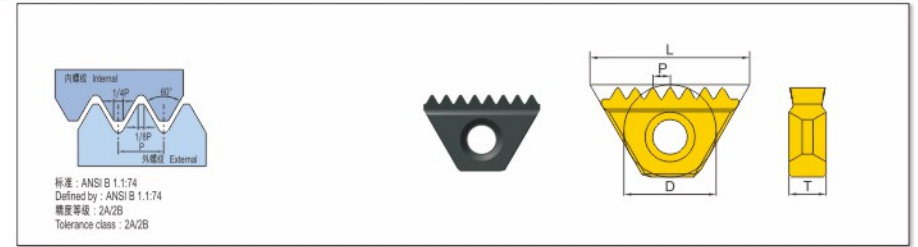


加工螺距 Pitch		刀片尺寸 Insert Size					
mm		L=10.4mm D=6.0mm	L=11mm D=1/4"	L=16mm D=3/8"	L=22mm D=3/8"	L=27mm D=5/8"	L=38.5mm D=3/4"
0.5	外 Ext						
	内 Int	*6.0N0.5 ISO	2N0.5 ISO	3N0.5 ISO			
0.75	外 Ext		2E0.75 ISO	3E0.75 ISO			
	内 Int	*6.0N0.75 ISO	2N0.75 ISO	3N0.75 ISO			
1	外 Ext		2E1.0 ISO	3E1.0 ISO	3BE1.0 ISO	5E1.0 ISO	
	内 Int	*6.0N1.0 ISO	2N1.0 ISO	3N1.0 ISO	3BN1.0 ISO	5N1.0 ISO	
1.25	外 Ext		2E1.25 ISO	3E1.25 ISO	3BE1.25 ISO	5E1.25 ISO	
	内 Int	*6.0N1.25 ISO	2N1.25 ISO	3N1.25 ISO	3BN1.25 ISO	5N1.25 ISO	
1.5	外 Ext		2E1.5 ISO	3E1.5 ISO	3BE1.5 ISO	5E1.5 ISO	6BE1.5 ISO
	内 Int	*6.0N1.5 ISO	2N1.5 ISO	3N1.5 ISO	3BN1.5 ISO	5N1.5 ISO	6BN1.5 ISO
1.75	外 Ext			3E1.75 ISO	3BE1.75 ISO	5E1.75 ISO	
	内 Int			3N1.75 ISO	3BN1.75 ISO	5N1.75 ISO	
2	外 Ext			3E2.0 ISO	3BE2.0 ISO	5E2.0 ISO	6BE2.0 ISO
	内 Int			3N2.0 ISO	3BN2.0 ISO	5N2.0 ISO	6BN2.0 ISO
2.5	外 Ext					5E2.5 ISO	6BE2.5 ISO
	内 Int					5N2.5 ISO	6BN2.5 ISO
3	外 Ext					5E3.0 ISO	6BE3.0 ISO
	内 Int					5N3.0 ISO	6BN3.0 ISO
3.5	外 Ext					5E3.5 ISO	
	内 Int					5N3.5 ISO	
4	外 Ext					5E4.0 ISO	6BE4.0 ISO
	内 Int					5N4.0 ISO	6BN4.0 ISO
4.5	外 Ext					5E4.5 ISO	6BE4.5 ISO
	内 Int					5N4.5 ISO	6BN4.5 ISO
5	外 Ext						6BE5.0 ISO
	内 Int						6BN5.0 ISO
5.5	外 Ext						6BE5.5 ISO
	内 Int						6BN5.5 ISO
6	外 Ext						6BE6.0 ISO
	内 Int						6BN6.0 ISO

- * 带"*"的刀片只有单面刃。
- * Insert with one cutting edge.

螺纹铣削刀具 THREADING MILLING TOOLS

UN-60° 美制统一标准螺纹铣刀片 UN-60° American UN Full Profile



加工螺距 Pitch		刀片尺寸 Insert Size					
TPI		L=10.4mm D=6.0mm	L=11mm D=1/4"	L=16mm D=3/8"	L=22mm D=3/8"	L=27mm D=5/8"	L=38.5mm D=3/4"
48	外 Ext						
	内 Int		2N48 UN				
40	外 Ext						
	内 Int		2N40 UN	3N40 UN			
32	外 Ext						
	内 Int	*6.0N32 UN	2N32 UN	3N32 UN			
28	外 Ext			2E28 UN	3E28 UN		
	内 Int	*6.0N28 UN	2N28 UN	3N28 UN			
27	外 Ext			2E27 UN	3E27 UN		
	内 Int			2N27 UN	3N27 UN		
26	外 Ext				3E26 UN		
	内 Int				3N26 UN		
24	外 Ext		2E24 UN	3E24 UN	3BE24 UN	5E24 UN	
	内 Int	*6.0N24 UN	2N24 UN	3N24 UN	3BN24 UN	5N24 UN	
20	外 Ext		2E20 UN	3E20 UN	3BE20 UN	5E20 UN	
	内 Int	*6.0N20 UN	2N20 UN	3N20 UN	3BN20 UN	5N20 UN	
18	外 Ext		2E18 UN	3E18 UN	3BE18 UN	5E18 UN	
	内 Int	*6.0N18 UN	2N18 UN	3N18 UN	3BN18 UN	5N18 UN	
16	外 Ext		2E16 UN	3E16 UN	3BE16 UN	5E16 UN	
	内 Int	*6.0N16 UN	2N16 UN	3N16 UN	3BN16 UN	5N16 UN	
14	外 Ext		2E14 UN	3E14 UN	3BE14 UN	5E14 UN	
	内 Int		2N14 UN	3N14 UN	3BN14 UN	5N14 UN	
13	外 Ext			3E13 UN	3BE13 UN	5E13 UN	
	内 Int			3N13 UN	3BN13 UN	5N13 UN	
12	外 Ext			3E12 UN	3BE12 UN	5E12 UN	
	内 Int			3N12 UN	3BN12 UN	5N12 UN	
11.5	外 Ext			3E11.5 UN		5E11.5 UN	
	内 Int			3N11.5 UN		5N11.5 UN	

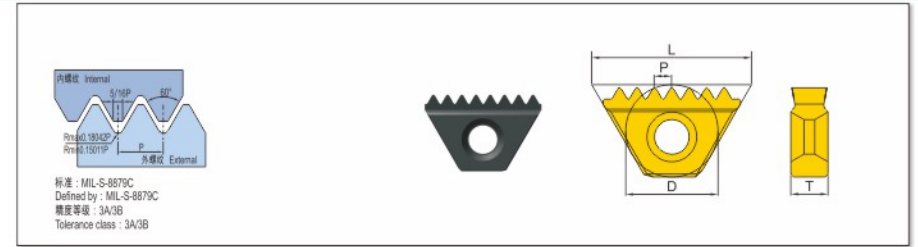
- * 带"*"的刀片只有单面刃。
- * Insert with one cutting edge.



UN-60° 美制统一标准螺纹铣刀片 (续) UN-60° American UN Full Profile (con't)

加工螺距 Pitch		刀片尺寸 Insert Size					
TPI		L=10.4mm D=6.0mm	L=11mm D=1/4"	L=16mm D=3/8"	L=22mm D=3/8"B	L=27mm D=5/8"	L=38.5mm D=3/4"B
11	外 Ext					5E11 UN	
	内 Int					5N11 UN	
10	外 Ext					5E10 UN	
	内 Int					5N10 UN	
9	外 Ext					5E9 UN	
	内 Int					5N9 UN	
8	外 Ext					5E8 UN	
	内 Int					5N8 UN	
7	外 Ext					5E7 UN	
	内 Int					5N7 UN	
6	外 Ext					5E6 UN	6E6 UN
	内 Int					5N6 UN	6N6 UN
5	外 Ext						6E5 UN
	内 Int						6N5 UN
4.5	外 Ext						6E4.5 UN
	内 Int						6N4.5 UN
4	外 Ext						6E4 UN
	内 Int						6N4 UN

UNJ美制航空航天机械螺纹铣刀片 UNJ Aviation Thread



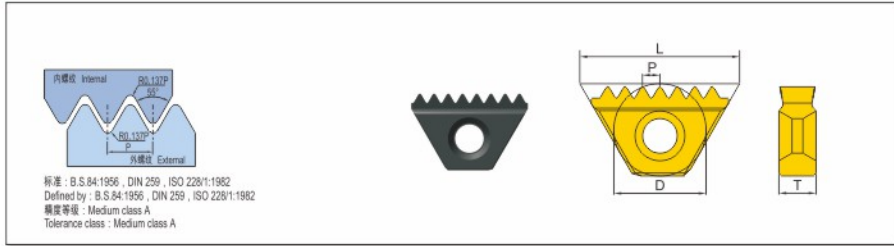
加工螺距 Pitch		刀片尺寸 Insert Size			
TPI		L=10.4mm D=6.0mm	L=11mm D=1/4"	L=16mm D=3/8"	L=27mm D=5/8"
24	外 Ext		2E24 UNJ	3E24 UNJ	
	内 Int	*6.0N24 UNJ	2N24 UNJ	3N24 UNJ	
20	外 Ext		2E20 UNJ	3E20 UNJ	
	内 Int	*6.0N20 UNJ	2N20 UNJ	3N20 UNJ	
18	外 Ext			3E18 UNJ	
	内 Int	*6.0N18 UNJ	2N18 UNJ	3N18 UNJ	
16	外 Ext		2E16 UNJ	3E16 UNJ	5E16 UNJ
	内 Int	*6.0N16 UNJ	2N16 UNJ	3N16 UNJ	5N16 UNJ
14	外 Ext		2E14 UNJ	3E14 UNJ	
	内 Int		2N14 UNJ	3N14 UNJ	
13	外 Ext			3E13 UNJ	
	内 Int				
12	外 Ext			3E12 UNJ	5E12 UNJ
	内 Int			3N12 UNJ	5N12 UNJ
11	外 Ext				5E11 UNJ
	内 Int				5N11 UNJ

- * 带“*”的刀片只有单面刃。
- * Insert with one cutting edge.



螺纹铣削刀具 THREADING MILLING TOOLS

W-55° 英制惠氏螺纹铣刀片 W-55° Whitworth Full Profile

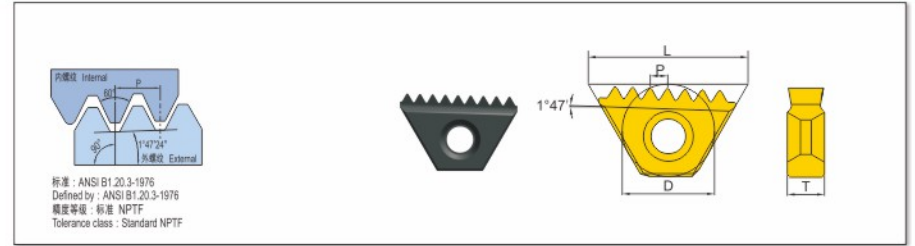


加工螺距 Pitch	刀片尺寸 Insert Size						
TPI	L=10.4mm D=6.0mm	L=11mm D=1/4"	L=16mm D=3/8"	L=22mm D=3/8"B	L=27mm D=5/8"	L=38.5mm D=3/4"B	
28	*6.0EN28 W	2EN28 W					
26	*6.0EN26 W	2EN26 W	3EN26 W				
24	*6.0EN24 W	2EN24 W	3EN24 W	3BEN24 W			
20	*6.0EN20 W	2EN20 W	3EN20 W	3BEN20 W			
19	*6.0EN19 W	2EN19 W	3EN19 W	3BEN19 W			
18			3EN18 W	3BEN18 W			
16			3EN16 W	3BEN16 W	5EN16 W		
14		2EN14 W	3EN14 W	3BEN14 W	5EN14 W		
12			3EN12 W	3BEN12 W	5EN12 W		
11			3EN11 W	3BEN11 W	5EN11 W	6BEN11 W	
10					5EN10 W		
9					5EN9 W		
8					5EN8 W		
7					5EN7 W		
6					5EN6 W	6BEN6 W	
5						6BEN5 W	
4.5						6BEN4.5 W	

- * 带"*"的刀片只有单面刃。
- * Insert with one cutting edge.

螺纹铣削刀具 THREADING MILLING TOOLS

NPTF美制干密封螺纹铣刀片 NPTF(Dry seal)



加工螺距 Pitch	刀片尺寸 Insert Size			
TPI	L=16mm D=3/8"	L=22mm D=3/8"B	L=27mm D=5/8"	L=38.5mm D=3/4"B
14	3-14 NPTF	3B-14 NPTF		
11.5	3-11.5 NPTF	3B-11.5 NPTF	5-11.5 NPTF	6B-11.5 NPTF
8			5-8 NPTF	6B-8 NPTF

BSPT-55° 英国标准锥管螺纹铣刀片 BSPT-55° British Standard pipe full profile

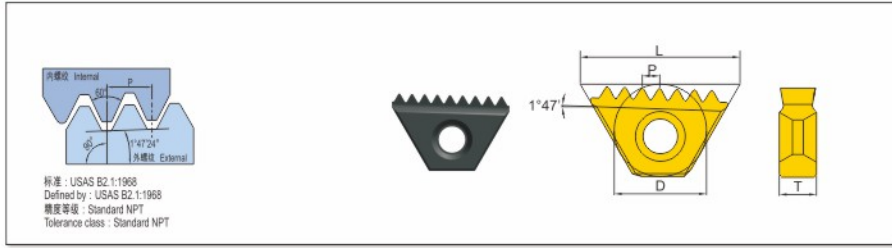


加工螺距 Pitch	刀片尺寸 Insert Size		
TPI	L=11mm D=1/4"	L=16mm D=3/8"	L=27mm D=5/8"
19	2-19 BSPT		
14		3-14 BSPT	
11		3-11 BSPT	5-11 BSPT



螺纹铣削刀具 THREADING MILLING TOOLS

NPT-60° 美国标准锥管螺纹铣刀片 NPT-60° National Pipe Threads

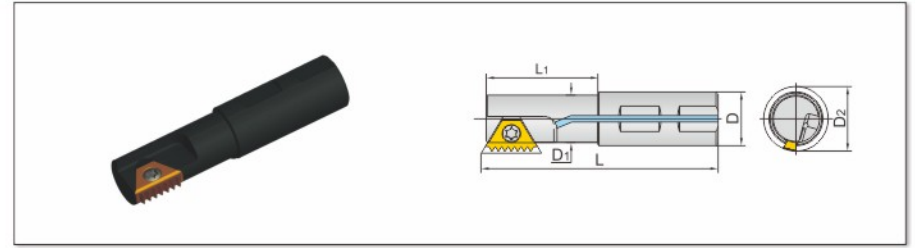


加工螺距 Pitch	刀片尺寸 Insert Size			
	L=16mm D=3/8"	L=22mm D=3/8"B	L=27mm D=5/8"	L=38.5mm D=3/4"B
TPI				
18	*3E18 NPT			
14	3-14 NPT	3B-14 NPT		
11.5	3-11.5 NPT	**3B-11.5 NPT	5-11.5 NPT	6B-11.5 NPT
8			5-8 NPT	6B-8 NPT

- * 带"*"的刀片只有单面刃。
- * Insert with one cutting edge.
- ** 带"**"的只用于左旋螺纹单边刀片。
- ** Insert with one cutting dege , LH only.

螺纹铣削刀具 THREADING MILLING TOOLS

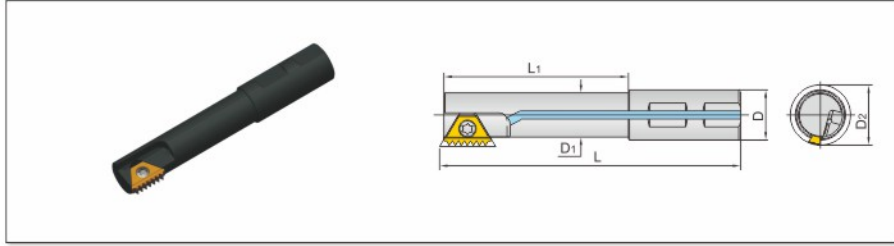
螺纹铣刀杆 Threading Milling Toolholders



订货号 Order No.	尺寸 Dimensions (mm)					刀片 Insert	螺钉 Screw	扳手 Torx key
	L	L1	D	D1	D2			
TMMC12-6.0	69	12	12	6.8	9	6.0□□□	M2.2x0.45x5.0	T07
TMMC20-6.0	84	17	20	6.8	9	2□□□	M2.6x0.45x5.9	T08
TMC12-2	70	12	12	8.9	11.5			
TMC20-2	85	20	20	8.9	11.5	3□□□	UNC5x8.0	T10
TMC16-3	90	22	16	13.6	17			
TMC20-3	95	43	20	16.6	20	3B□□□	UNC5x8.0	T10
BTMC16-3B	79.5	29	16	13.5	17			
BTMC20-3B	81.5	29	20	15.5	19			
BTMC25-3B	92.3	30	25	15.5	19			
BTMWC25-3B	90.8	30	25	18.5	22	5□□□	M5x0.8x15.0	T25
TMC25-5	110	52	25	24	30			
TMC25-5LH	110	52	25	24	30	6B□□□	M7x1.0x15.0	T25
TMC32-5	120	58	32	31	37			
TMC32-6B	115	53	32	27	35	6B□□□	M7x1.0x15.0	T25
TMC40-6B	135	63	40	38	46			

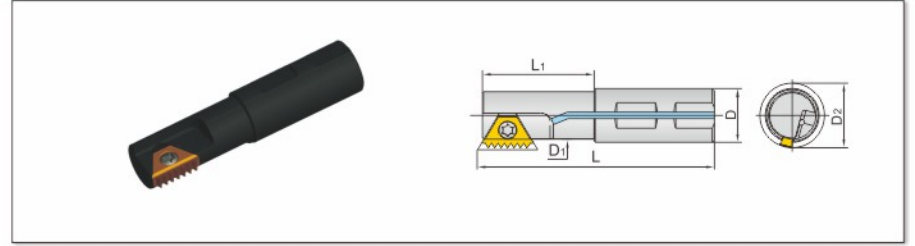


螺纹铣刀杆 Threading Milling Toolholders



订货号 Order No.	尺寸 Dimensions (mm)					刀片 Insert	螺钉 Screw	扳手 Torx key
	L	L ₁	D	D ₁	D ₂			
TMLC25-2	125	17	25	8.9	11.5	2□□□	M2.6x0.45x5.9	T08
TMLC25-3	125	25	25	18.6	22	3□□□	UNC5x8.0	T10
BTMLC25-3	125	63.5	25	18.6	22	38□□□	UNC5x8.0	T10
BTMLC20-3B	96.5	44	20	15.5	19			
BTMLC25-3B	125	63.5	25	18.6	22	5□□□	M5x0.8x15.0	T25
TMLC25-5	150	92	25	24	30			
TMLC32-5	160	98	32	31	37	68□□□	M7x1.0x15.0	T25
TMLC40-6B	165	93	40	38	46			

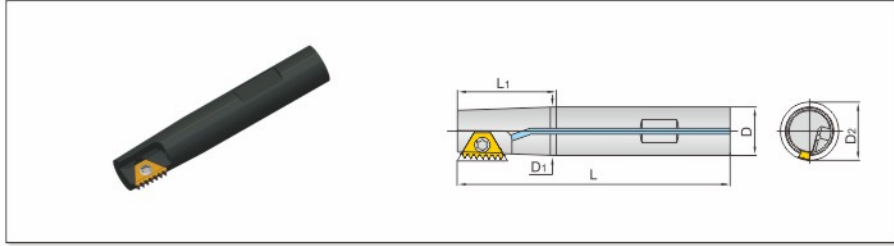
螺纹铣刀杆 Threading Milling Toolholders



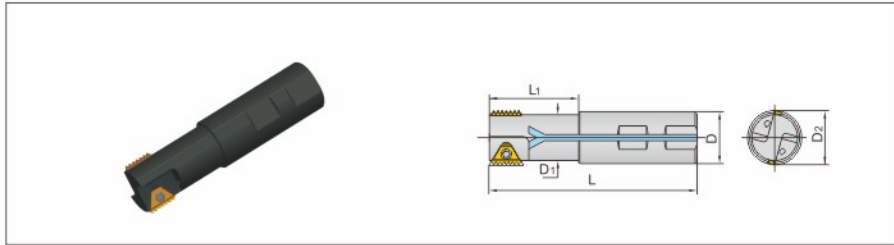
订货号 Order No.	尺寸 Dimensions (mm)					刀片 Insert	螺钉 Screw	扳手 Torx key
	L	L ₁	D	D ₁	D ₂			
TMMC20-6.0 124/003	85	15	20	6.7	9	6.0□□□	M2.2x0.45x5.0	T07
TMC20-2 124/005	77	15.5	20	7.4	10	2□□□	M2.6x0.45x5.9	T08
TMC20-2 124/006	77	15.5	20	9	12			
TMC20-2 124/009	77	15.5	20	7.4	10	3□□□	UNC5x8.0	T10
TMC16-3 124/001	91	20.5	16	12.2	15.5			
TMC25-4 124/002	88	30	25	13.4	18	4□□□	UNC8x11.6	T20
TMC25-4 124/007	98	40	25	16	20			
TMC25-5 124/004	98	40	25	19	25	5□□□	M5x0.8x15.0	T25
TMC25-5 124/008	98	40	25	16.4	22			



螺纹铣刀杆 Threading Milling Toolholders

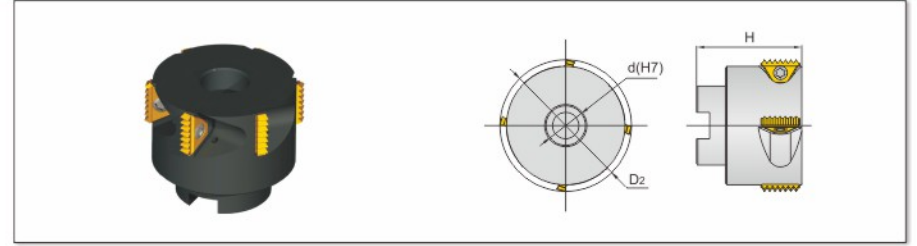


订货号 Order No.		尺寸 Dimensions (mm)							
右刀	左刀	L	L1	D	D1	D2	刀片 Insert	螺钉 Screw	扳手 Torx key
TMNC16-3	TMNC16-3 LH	90	22	16	12.5	15.5	3000	UNC5x8.0	T10
TMNC20-3	TMNC20-3 LH	85	23	20	15	19	38000	UNC5x8.0	T10
BTMNC16-3B	BTMNC16-3B LH	79.5	29	16	13.5	17			
BTMNC20-3B	BTMNC20-3B LH	81.5	29	20	15.5	19			
TMNC32-5	TMNC32-5 LH	120	58	32	31	37			



订货号 Order No.	尺寸 Dimensions (mm)							
	L	L1	D	D1	D2	刀片 Insert	螺钉 Screw	扳手 Torx key
TM2C20-2	85	20	20	14.4	17	2000	M2.6x0.45x5.9	T08
TM2C25-3	100	43	25	22.5	26	3000	UNC5x9.5	T10
BTM2C25-3B	104.2	46	25	22.5	26	38000		
TM2C32-5	120	45	32	36	42	5000	M5x0.8x15.0	T25
TM2C40-6B	137.2	65	40	44	52	68000	M7x1.0x15.0	T25

螺纹铣刀杆 Threading Milling Toolholders



订货号 Order No.	刀片数量 NO. of inserts	尺寸 Dimensions (mm)						
		D2	d (H7)	H	刀片 Insert	螺钉 Screw	扳手 Torx key	刀杆螺钉 older Screw
TMSH-D38-16-2	6	38	16	40	2000	SN2T	HK2T	M8x1.25x35
TMSH-D50-22-2	8	50	22	40	3000	SN3TM	HK3T	M10x1.5x35
TMSH-D50-22-3	6	50	22	40				M10x1.5x35
TMSH-D63-22-3B	6	63	22	40	38000	SNSTM	HK5T	M10x1.5x35
TMSH-D63-22-5	4	63	22	45	5000			M10x1.5x35
TMSH-D63-22-6B	4	63	22	50	68000	SM7T	HK7T	M10x1.5x35
TMSH-D80-27-5	6	80	27	50	5000	SNSTM	KH5T	M12x1.75x40
TMSH-D80-27-6B	5	80	27	50	68000	SM7T	KH7T	M12x1.75x40
TMSH+D100-32-5	7	100	32	55	5000	SNSTM	KH5T	M16x2x40
TMSH-D100-32-6B	6	100	32	55	68000	SM7T	KH7T	M16x2x40
TMSH+D125-40-5	9	125	40	63	5000	SNSTM	KH5T	M20x2.5x50
TMSH-D125-40-6B	8	125	40	63	68000	SM7T	KH7T	M20x2.5x50



螺纹铣削刀具 THREADING MILLING TOOLS

W系列螺纹铣刀片型号说明 W Line Threading Milling Inserts Ordering Code System

W	41	E	3.00	ISO
1	2	3	4	5
1、产品系列 Product line	2、刀片尺寸 Insert size	3、加工类型 Type of Insert	4、螺距 Pitch	
W - 紧凑型系列 W - W line	L = 24mm L = 25mm L = 40mm L = 41mm	E - 外螺纹 External N - 内螺纹 Internal EN - 内外通用螺纹 External + Internal	0.5 - 6.0 mm 32 - 4 TPI	
5、螺纹标准 Standard				
ISO — ISO标准型螺纹 ISO Metric UN — 60° 美制统一标准型螺纹 American UN W — 55° 英国惠氏螺纹 Whitworth for BSW BSP NPT — 60° 美国标准管螺纹 NPT NPTF — 60° 美制干密封螺纹 NPTF BSPT — 55° 英制标准锥管螺纹 British Standard Pipe Thread (BSPT)				

W系列直柄螺纹铣刀杆型号说明 W Line Threading Milling Tool Ordering Code System Holders Standard and Conical

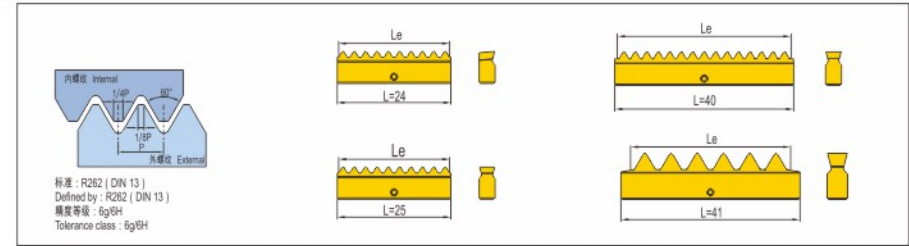
W	S	C	20	15	-	30	24	1
1	2	3	4	5		6	7	8
1、产品系列 Product line	2、刀杆类型 Holder Type	3、内冷却 Cooling	4、刀柄直径 Shank Dia.[mm]	5、切削刃直径 Cutting Dia.[mm]				
W - 紧凑型系列 W - W line	S - 标准型 Standard holder C - 锥度型 Conical holder	C - 冷却孔 Coolant Channel	20 25 32	13.6 - 36				
6、悬长 Tool Overhang[mm]	7、刀片尺寸 Insert size	8、槽数 NO.of Flutes						
26 - 80	24 25 40 41	1 - 5						

W系列套式螺纹铣刀杆型号说明 W Line Threading Shell Mill

W	S	C	D44	22	-	25	6
1	2	3	4	5		6	7
1、产品系列 Product line	2、刀杆类型 Holder Type	3、内冷却 Cooling	4、切削刃直径 Cutting Dia.[mm]	5、内孔直径 Drive Hole Dia.[mm]			
W - 紧凑型系列 W - W line	S - 标准型 Standard holder C - 锥度型 Conical holder	C - 冷却孔 Coolant Channel	36 - 58	16 22 27			
6、刀片尺寸 Insert size	7、槽数 NO.of Flutes						
25 40 41	5 - 8						

螺纹铣削刀具 THREADING MILLING TOOLS

ISO标准型螺纹铣刀片 ISO Metric Full Profile

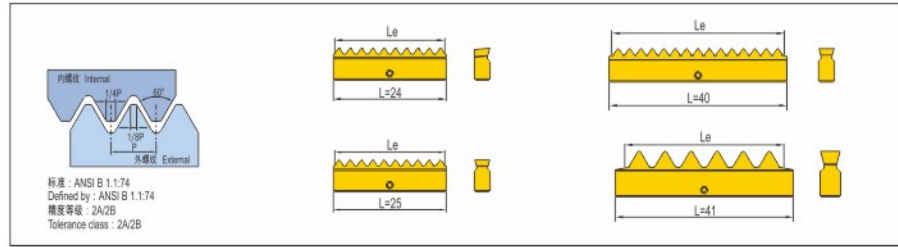


刀片尺寸 Insert Size		螺距 Pitch		订货号 Order No.		刃数	Le	齿数 Teeth	刀杆
L (mm)		mm	外螺纹 External	内螺纹 Internal	Cutting Edge	mm	Zt	Tool holder	
24	24	0.5	W24N0.50 ISO	W24N0.50 ISO	1	24.00	48	WSC_24	
		0.75	W24N0.75 ISO	W24N0.75 ISO	1	24.00	32		
		1	W24N1.00 ISO	W24N1.00 ISO	1	24.00	24		
		1.25	W24N1.25 ISO	W24N1.25 ISO	1	23.75	19		
		1.5	W24N1.50 ISO	W24N1.50 ISO	1	24.00	16		
		1.75	W24N1.75 ISO	W24N1.75 ISO	1	22.75	13		
25	25	2	W24N2.00 ISO	W24N2.00 ISO	1	24.00	12	WSC_25	
		2.5	W24N2.50 ISO	W24N2.50 ISO	1	22.50	9		
		1	W25E1.00 ISO	W25N1.00 ISO	2	24.00	24		
		1.5	W25E1.50 ISO	W25N1.50 ISO	2	24.00	16		
		2	W25E2.00 ISO	W25N2.00 ISO	2	24.00	12		
		2.5	W25E2.50 ISO	W25N2.50 ISO	2	25.00	10		
40	40	3	W25E3.00 ISO	W25N3.00 ISO	2	24.00	8	WSC_40	
		1	W40N1.00 ISO	W40N1.00 ISO	2	39.00	39		
		1.5	W40N1.50 ISO	W40N1.50 ISO	2	39.00	26		
		2	W40N2.00 ISO	W40N2.00 ISO	2	38.00	19		
		2.5	W40N2.50 ISO	W40N2.50 ISO	2	37.50	15		
		3	W40N3.00 ISO	W40N3.00 ISO	2	39.00	13		
41	41	3	W41E3.00 ISO	W41N3.00 ISO	2	39.00	13	WSC_41	
		3.5	W41E3.50 ISO	W41N3.50 ISO	2	38.50	11		
		4	W41E4.00 ISO	W41N4.00 ISO	2	40.00	10		
		4.5	W41E4.50 ISO	W41N4.50 ISO	2	40.50	9		
		5	W41E5.00 ISO	W41N5.00 ISO	2	40.00	8		
		5.5	W41E5.50 ISO	W41N5.50 ISO	2	38.50	7		
6	W41E6.00 ISO	W41N6.00 ISO	2	36.00	6				



螺纹铣削刀具 THREADING MILLING TOOLS

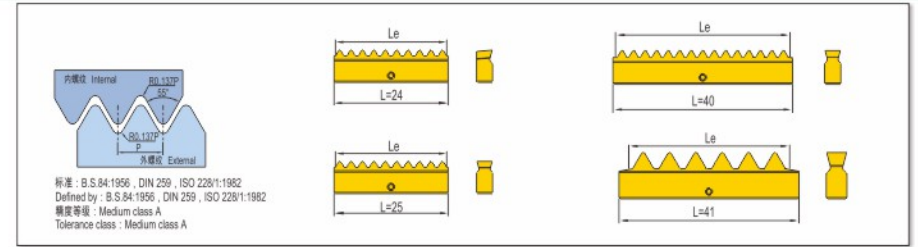
UN-60°美制统一标准螺纹铣刀片 American UN Full Profile



刀片尺寸 Insert Size		螺距 Pitch	订货号 Order No.		刃数	Le	齿数 Teeth	刀杆
L (mm)	TPI	外螺纹 External	内螺纹 Internal	Cutting Edge	mm	Zt	Tool holder	
24	32		W24N32 UN	1	24.61	31	WSC...24	
	28		W24N28 UN	1	24.49	27		
	24		W24N24 UN	1	24.34	23		
	20		W24N20 UN	1	24.13	19		
	18		W24N18 UN	1	23.99	17		
	16		W24N16 UN	1	23.81	15		
	14		W24N14 UN	1	23.59	13		
	12		W24N12 UN	1	23.28	11		
	10		W24N10 UN	1	22.86	9		
	20	W25E20 UN	W25N20 UN	2	24.13	19		WSC...25
18	W25E18 UN	W25N18 UN	2	23.99	17			
16	W25E16 UN	W25N16 UN	2	23.81	15			
14	W25E14 UN	W25N14 UN	2	23.58	13			
12	W25E12 UN	W25N12 UN	2	23.28	11			
10	W25E10 UN	W25N10 UN	2	22.86	9			
9	W25E9 UN	W25N9 UN	2	22.58	8			
8	W25E8 UN	W25N8 UN	2	22.22	7			
20		W40N20 UN	2	39.37	31	WSC...40		
18		W40N18 UN	2	39.51	28			
16		W40N16 UN	2	39.69	25			
14		W40N14 UN	2	39.91	22			
12		W40N12 UN	2	38.10	18			
10		W40N10 UN	2	38.10	15			
9		W40N9 UN	2	39.51	14			
8		W40N8 UN	2	38.10	12			
8	W41E8 UN	W41N8 UN	2	38.10	12		WSC...41	
7	W41E7 UN	W41N7 UN	2	39.91	11			
6	W41E6 UN	W41N6 UN	2	38.10	9			
5	W41E5 UN	W41N5 UN	2	35.56	7			
4.5	W41E4.5 UN	W41N4.5 UN	2	39.51	7			
4	W41E4 UN	W41N4 UN	2	38.10	6			

螺纹铣削刀具 THREADING MILLING TOOLS

W-55° 英国惠氏螺纹铣刀片 W-55° Whitworth Full Profile

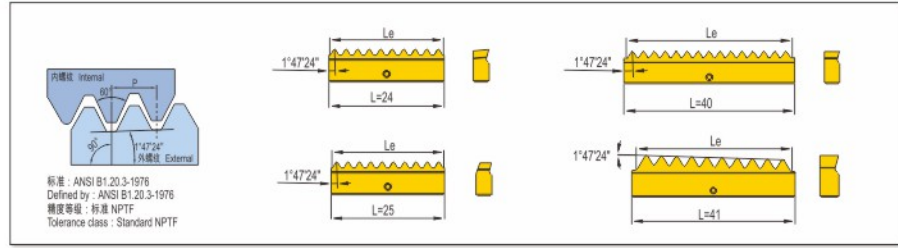


刀片尺寸 Insert Size		螺距 Pitch	订货号 Order No.		刃数	Le	齿数 Teeth	刀杆
L (mm)	TPI	内外螺纹通用 External+Internal	内螺纹 Internal	Cutting Edge	mm	Zt	Tool holder	
24	19	W24EN19 W		1	24.06	18	WSC...24	
	14	W24EN14 W		1	23.59	13		
	12	W24EN12 W		1	23.28	11		
25	16	W25EN16 W		2	23.81	15	WSC...25	
	14	W25EN14 W		2	23.58	13		
	12	W25EN12 W		2	22.28	11		
	11	W25EN11 W		2	23.09	10		
40	16	W40EN16 W		2	39.69	25	WSC...40	
	14	W40EN14 W		2	39.91	22		
	12	W40EN12 W		2	38.10	18		
	11	W40EN11 W		2	39.25	17		
41	8		W41N8 W	2	38.10	12	WSC...41	
	7		W41N7 W	2	39.91	11		
	6		W41N6 W	2	38.10	9		



螺纹铣削刀具 THREADING MILLING TOOLS

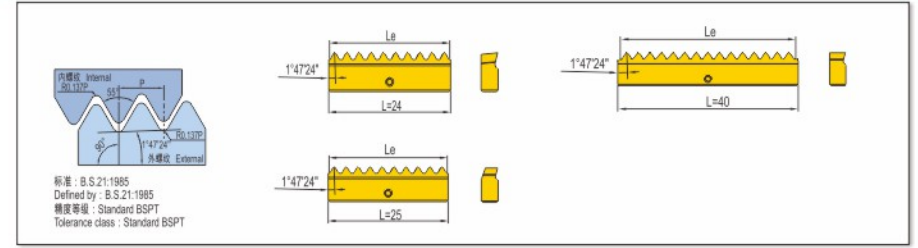
NPTF美制干密封锥管螺纹铣刀片 NPTF



刀片尺寸 Insert Size		螺距 Pitch	订货号 Order No.	刃数	Le	齿数 Teeth	刀杆
L (mm)	TPI	内外螺纹通用 External+Internal	Cutting Edge	mm	Zt	Tool holder	
24	18	W24EN18 NPTF	1	23.99	17	WCC...24	
	14	W25EN14 NPTF	1	23.58	13	WCC...25	
25	11.5	W25EN11.5 NPTF	1	24.30	11	WCC-D36-16-255	
	8	W25EN8 NPTF	1	22.22	7		
40	11.5	W40EN11.5 NPTF	1	37.55	17	WCC-D45-22-406	
	8	W40EN8 NPTF	1	38.10	12		
41	8	W41EN8 NPTF	1	38.10	12	WSC...41	

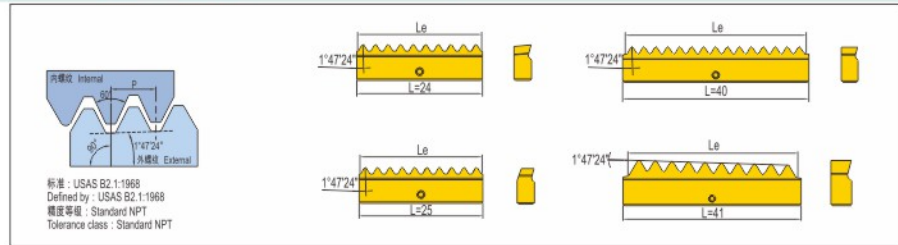
螺纹铣削刀具 THREADING MILLING TOOLS

BSPT-55° 英国标准锥管螺纹铣刀片 BSPT-55° British Standard Pipe Full Thread



刀片尺寸 Insert Size		螺距 Pitch	订货号 Order No.	刃数	Le	齿数 Teeth	刀杆
L (mm)	TPI	内外螺纹通用 External+Internal	Cutting Edge	mm	Zt	Tool holder	
24	19	W24EN19 BSPT	1	24.06	18	WCC-2014-26241	
	14	W25EN14 BSPT	1	23.58	13	WCC...25	
25	11	W25EN11 BSPT	1	23.09	10	WCC-D45-22-406	
	8	W40EN11 BSPT	1	39.25	17		

NPT-60° 美国标准锥度螺纹 NPT-60° National Pipe Threads

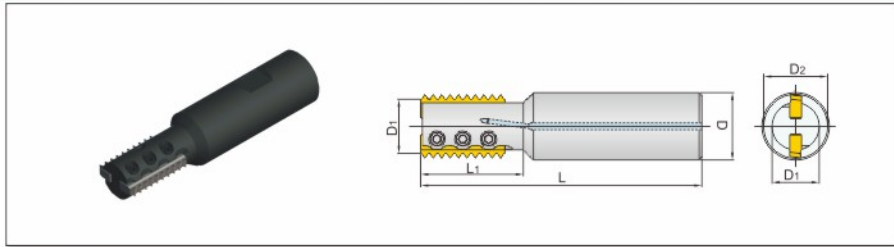


刀片尺寸 Insert Size		螺距 Pitch	订货号 Order No.	刃数	Le	齿数 Teeth	刀杆
L (mm)	TPI	内外螺纹通用 External+Internal	Cutting Edge	mm	Zt	Tool holder	
24	18	W24EN18 NPT	1	23.99	17	WCC...24	
	14	W25EN14 NPT	1	23.58	13	WCC...25	
25	11.5	W25EN11.5 NPT	1	24.30	11	WCC-D36-16-255	
	8	W25EN8 NPT	1	22.22	7		
40	11.5	W40EN11.5 NPT	1	37.55	17	WCC-D45-22-406	
	8	W40EN8 NPT	1	38.10	12		
41	8	W41EN8 NPT	1	38.10	12	WSC...41	



螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸24mm的标准刀杆 Standard Toolholders for Insert Size 24mm



标准螺纹刀杆 WSC - for standard threads

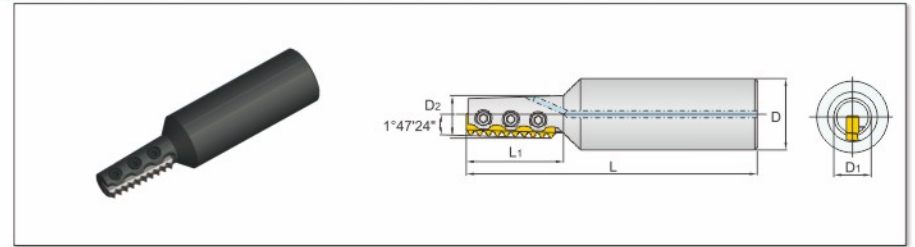
刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
		L	L1	D	D1	D2				
24	WSC 2013-26241	82	26	20	10.7	13.6	1	LS M4×0.7	CS M4×0.7	T08
	WSC 2015-30241	85	30	20	11.9	15.1	1			
	WSC 2016-28242	83	28	20	12.6	16	2			
	WSC 2016-36241	91	36	20	12.6	16	1			

刀杆所适用的标准螺纹 Standard Thread Application by Toolholder

刀杆 Tool holder	D2 mm	最小螺纹直径 Min. Thread ϕ					
		ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
WSC 2013-26241	13.6	M16×2	M14.5×0.5; M15×0.75; M15×1; M15×1.25; M16×1.5; M16×1.75	-	11/16"×12UN; 5/8"×14UNS; 5/8"×16UN; 5/8"×18UNF; 5/8"×20UN; 5/8"×24UNEF; 5/8"×28UN; 5/8"×32UN	11/16"×14 3/4"×12	3/8"×19
WSC 2015-30241	15.1	M18×2.5	M16×0.5; M17×0.75; M17×1; M17×1.25; M17×1.5; M18×1.75; M18×2	3/4"×10	3/4"×12UN; 3/4"×14UNS; 11/16"×16UN; 11/16"×20UN; 11/16"×24UNEF; 11/16"×28UN; 11/16"×32UN	3/4"×12	-
WSC 2016-28242	16	M20×2.5	M17×0.5; M17×0.75; M18×1; M18×1.25; M18×1.5; M18×1.75; M19×2	3/4"×10	3/4"×12UN; 3/4"×14UNS; 3/4"×16UN; 3/4"×18UNS; 3/4"×20UNEF; 11/16"×24UNEF; 11/16"×28UN; 11/16"×32UN	3/4"×12	-
WSC 2016-36241	16	M20×2.5	M17×0.5; M17×0.75; M18×1; M18×1.25; M18×1.5; M18×1.75; M19×2	3/4"×10	3/4"×12UN; 3/4"×14UNS; 3/4"×16UN; 3/4"×18UNS; 3/4"×20UNEF; 11/16"×24UNEF; 11/16"×28UN; 11/16"×32UN	3/4"×12	-

螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸24mm的锥度刀杆 Conical Toolholders for Insert Size 24mm



刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
		L	L1	D	D1	D2				
24	WCC 2014-26241	81	26	20	11.5	13.9	1	LS M4×0.7	CS M4×0.7	T08

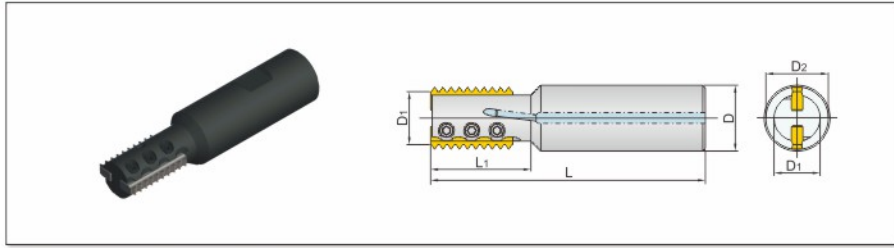
刀杆所适用的锥度螺纹 Conical Thread Application by Toolholder

刀杆 Tool holder	最小螺纹直径 Min. Thread ϕ			
	D2 mm	NPT	NPTF	BSPT
WCC 2014-26241	13.9	3/8"×18	3/8"×18	3/8"×19



螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸25mm的标准刀杆 Standard Toolholders for Insert Size 25mm



标准螺纹刀杆 WSC - for standard threads

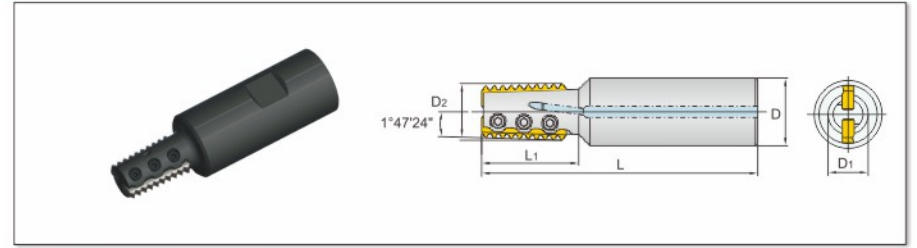
刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes			
mm		L	L ₁	D	D ₁	D ₂	Z	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
25	WSC 2517-26252	85	26	25	14	17	2	LS M4×0.7	CS M4×0.7	T08
	WSC 2517-36252	95	36	25	14	17	2			
	WSC 2519-32252	92	32	25	15	19	2			
	WSC 2519-44252	104	44	25	15	19	2			
	WSC 2520-37253	96	37	25	16.5	20.5	3			
	WSC 2520-44253	103	44	25	16.5	20.5	3			
	WSC 2522-43253	102	43	25	18	22	3			
	WSC 2522-55253	114	55	25	18	22	3			
	WSC 2530-55255	115	55	25	26	30	5			

刀杆所适用的标准螺纹 Standard Thread Application by Toolholder

刀杆 Tool holder	D2 mm	最小螺纹直径 Min.Thread φ						
		ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)	
WSC 2517-26252	17	M20×2.5	M19×1; M19×1.5; M20×2	-	7/8"×10UNS; 13/16"×12UN; 7/8"×14UNF; 3/4"×16UNF; 3/4"×18UNS; 3/4"×20UNEF	7/8"×11; 7/8"×12; 7/8"×14; 7/8"×16	1/2"×14	
WSC 2517-36252								
WSC 2519-32252	19	M22×2.5	M21×1; M21×1.5; M22×2	7/8"×9	7/8"×20UNEF; 7/8"×18UNS; 7/8"×16UN;	7/8"×16; 7/8"×14;	5/8"×14	
WSC 2519-44252								
WSC 2520-37253	20.5	M24×3	M22×1; M23×1.5; M23×2;	1"×8	15/16"×9UN; 1"×10UNS; 15/16"×12UN;	1"×11; 1"×12;	5/8"×14	
WSC 2520-44253								
WSC 2522-43253	22	M27×3	M24×1; M24×1.5; M25×2;	-	1 1/16"×8UN; 1"×9UN; 1"×10UNS; 1"×12UNF;	1"×11; 1"×12;	3/4"×14	
WSC 2522-55253								
WSC 2530-55255	30	-	M32×1; M32×1.5; M33×2; M33×2.5; M34×3	-	1 3/8"×8UN; 1 3/8"×9UN; 1 3/8"×10UN; 1 3/8"×14UNS; 1 5/16"×16UN; 1 5/16"×18UNEF; 1 5/16"×12UN; 1 5/16"×20UN	1 3/8"×11; 1 3/8"×12; 1 3/8"×14; 1 3/8"×16	1"×11	

螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸25mm的锥度刀杆 Conical Toolholders for Insert Size 25mm



锥度螺纹刀杆 WCC - for conical threads

刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes			
mm		L	L ₁	D	D ₁	D ₂	Z	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
25	WCC 2517-26252	85	26	25	14	17	2	LS M4×0.7	CS M4×0.7	T08
	WCC 2522-43253	102	43	25	18	22	3			
	WCC 2528-43254	103	43	25	26	28	4			

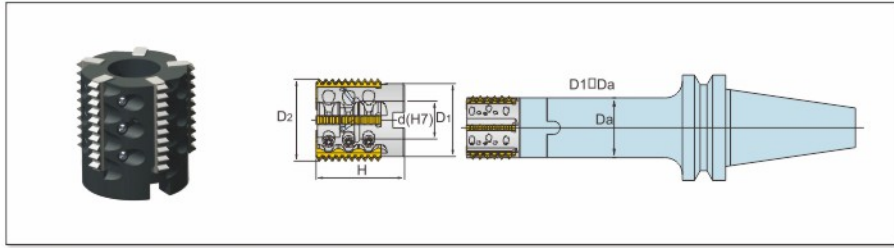
刀杆所适用的锥度螺纹锥度 Conical Thread Application by Toolholder

刀杆 Tool holder	D2 mm	最小螺纹直径 Min.Thread φ			
		NPT	NPTF	BSPT	
WCC 2517-26252	17	1/2"×14; 3/4"×14; 1"×11.5; 1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5	1/2"×14; 3/4"×14; 1"×11.5; 1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5	1/2"×14; 3/4"×14	
WCC 2522-43253	22	3/4"×14; 1"×11.5; 1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5	3/4"×14; 1"×11.5; 1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5	3/4"×14; 1"×11; 1 1/4"×11; 1 1/2"×11; 2"×11; 2 1/2"×11; 3"×11; 4"×11; 5"×11; 6"×11	
WCC 2528-43254	28	1"×11.5; 1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5	1"×11.5; 1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5	1"×11; 1 1/4"×11; 1 1/2"×11; 2"×11; 2 1/2"×11; 3"×11; 4"×11; 5"×11; 6"×11	



螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸25mm的螺纹套式铣刀 Shell Mills for Insert Size 25mm



标准和锥度套式铣刀 Standard and conical shell mills

	刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver	内六角螺钉 Holder Screw
			D1	D2	d(H7)	H					
标准 Standard	25	WSC D36-16-255	32	36	16	33.5	5	LS M4×0.7	CS M4×0.7	T08	M8×1.25×30
		WSC D44-22-256	40	44	22	38	6				M10×1.50×40
		WSC D52-27-258	48	52	27	40	8				M12×1.75×40
锥度 Conical		WCC D36-16-255	32	36	16	33.5	5			M8×1.25×30	

刀杆所适用的标准螺纹 Standard Thread Application by Toolholder

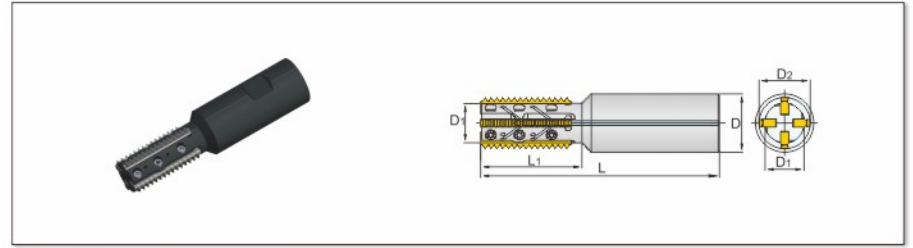
刀杆 Tool holder	最小螺纹直径 Min.Thread φ				
	D2 mm	ISO 细牙 ISO Fine	UN/UNF/UNEF/UNS	BSW	BSP(G)
标准 Standard	WSC D36-16-255	M38×1; M39×1.5; M39×2; M40×3	1 9/16"×12UN; 1 5/8"×14UNS; 1 9/16"×UN; 1 1/2"×18UNEF; 1 1/2"×20UN	1 3/4"×16 1 3/4"×12	1 1/4"×11
	WSC D44-22-256	M48×1; M48×1.5; M48×2; M48×3	1 7/8"×12UN; 1 13/16"×16UN; 1 13/16"×20UN 1 15/16"×8UN; 1 7/8"×10UNS; 1 7/8"×14UNS	2"×16 2"×12	1 1/2"×11
	WSC D52-27-258	M55×1; M55×1.5; M55×2; M56×3	2 1/4"×8UN; 2 1/4"×10UN; 2 1/4"×12UN; 2 1/4"×14UN; 2 1/4"×16UN; 2 1/4"×18UN; 2 1/4"×20UN	2 1/4"×16 2 1/4"×12	2"×11

刀杆所适用的锥度螺纹 Conical Thread Application by Toolholder

刀杆 Tool holder	最小螺纹直径 Min.Thread φ			
	D2 mm	NPT	NPTF	BSPT
锥度 Conical	WCC D36-16-255	1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5 2 1/2"×8 (and up)	1 1/4"×11.5; 1 1/2"×11.5; 2"×11.5 2 1/2"×8; 3"×8	1 1/2"×11 -6"×11

螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸40mm的标准刀杆 Standard Toolholders for Insert Size 40mm



标准螺纹刀杆 WSC - for standard threads

刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)						槽数 No. of Flutes	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
		L	L1	D	D1	D2	Z				
40	WSC 2522-43403	102	43	25	18	22	3	LS M4×0.7	CS M4×0.7	T08	
	WSC 2522-65403	124	65	25	18	22	3				
	WSC 3230-55404	117	55	32	26	30	4				
	WSC 3230-80403	142	80	32	26	30	3				

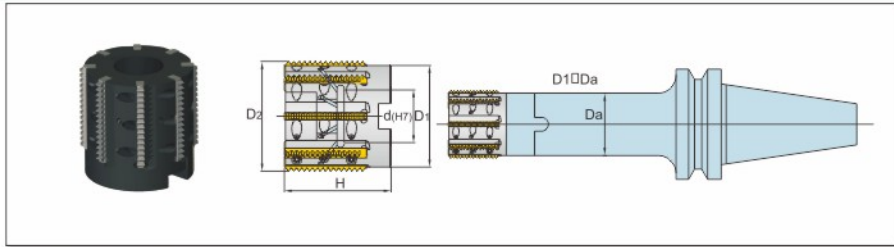
刀杆所适用的标准螺纹 Standard Thread Application by Toolholder

刀杆 Tool holder	最小螺纹直径 Min.Thread φ						
	D2 mm	ISO 细牙 ISO Fine	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
WSC 2522-43403	22	M27×3	M24×1; M24×1.5; M25×2; M25×2.5	-	1 11/16"×8UN; 1"×9UN; 1"×10UNS; 1"×12UNF; 1"×14UNS; 1"×16UN; 1"×18UN; 15/16"×20UNEF	1"×11; 1"×12; 1"×14; 1"×16	3/4"×14
WSC 2522-65403	22	M27×3	M24×1; M24×1.5; M25×2; M25×2.5	-	1 11/16"×8UN; 1"×9UN; 1"×10UNS; 1"×12UNF; 1"×14UNS; 1"×16UN; 1"×18UN; 15/16"×20UNEF	1"×11; 1"×12; 1"×14; 1"×16	3/4"×14
WSC 3230-55404	30	-	M32×1; M32×1.5; M33×2; M33×2.5; M34×3	-	1 3/8"×8UN; 1 3/8"×9UN; 1 3/8"×10UN; 1 3/8"×14UNS; 1 5/16"×16UN; 1 5/16"×18UNEF; 1 5/16"×12UN; 1 5/16"×20UN	1 3/8"×11; 1 3/8"×12; 1 3/8"×14; 1 3/8"×16	1"×11
WSC 3230-80403	30	-	M32×1; M32×1.5; M33×2; M33×2.5; M34×3	-	1 3/8"×8UN; 1 3/8"×9UN; 1 3/8"×10UN; 1 3/8"×14UNS; 1 5/16"×16UN; 1 5/16"×18UNEF; 1 5/16"×12UN; 1 5/16"×20UN	1 3/8"×11; 1 3/8"×12; 1 3/8"×14; 1 3/8"×16	1"×11



螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸40mm的螺纹套式铣刀 Shell Mills for Insert Size 40mm



标准和锥度套式铣刀 Standard and Conical shell mills

刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver	内六角螺钉 Holder Screw
		D1	D2	d(H7)	H					
mm					Z					
标准 Standard	WSC D44-22-406	40	44	22	48	6	LS M4×0.7	CS M4×0.7	T08	M10×1.50×40
	WSC D52-27-408	48	52	27	50	8				M12×1.75×40
锥度 Conical	WCC D45-22-406	40	45	22	48	6				M10×1.50×40

刀杆所适用的标准螺纹 Standard Thread Application by Toolholder

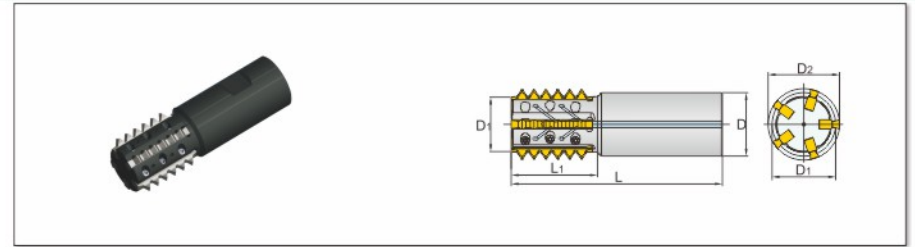
刀杆 Tool holder	最小螺纹直径 Min.Thread φ					
	D2 mm	ISO 细牙 ISO Fine	UN/UNF/UNEF/UNS	BSW	BSP(G)	
标准 Standard	WSC D44-22-406	M48×1; M48×1.5; M48×2; M48×3	1 7/8"×12UN; 1 13/16"×16UN; 1 13/16"×20UN; 1 15/16"×8UN; 1 7/8"×10UNS; 1 7/8"×14UNS	2"×16 2"×12	1 1/2"×11	
	WSC D52-27-408	M55×1; M55×1.5; M55×2; M56×3	2 1/4"×8UN; 2 1/4"×10UN; 2 1/4"×12UN; 2 1/4"×14UN; 2 1/4"×16UN; 2 1/4"×18UN; 2 1/4"×20UN	2 1/4"×16 2 1/4"×12	2"×11	

刀杆所适用的锥度螺纹 Conical Thread Application by Toolholder

刀杆 Tool holder	最小螺纹直径 Min.Thread φ				
	D2 mm	NPT	NPTF	BSPT	
锥度 Conical	WCC D45-22-406	45	2"×11.5; 2 1/2"×8 (and up)	2"×11.5; 2 1/2"×8; 3"×8	2"×11 -6"×11

螺纹铣削刀具 THREADING MILLING TOOLS

适用于刀片尺寸41mm的标准刀杆 Standard Toolholders for Insert Size 41mm



标准螺纹刀杆 WSC - for standard threads

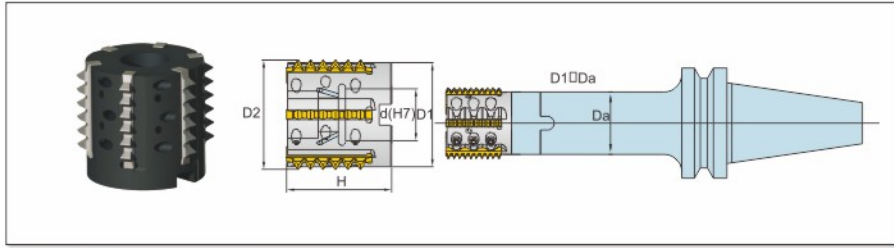
刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver	
		L	L1	D	D1					
mm					Z					
41	WSC 2524-43412	104	43	25	19.2	24.5	2	LS M4×0.7	CS M4×0.7	T08
	WSC 3230-43413	106.5	43	32	24.2	30	3			
	WSC 3230-65413	128.5	65	32	24.2	30	3			
	WSC 3236-43415	106	43	32	28.3	36	5			
	WSC 3236-65414	128	65	32	28.3	36	4			

刀杆所适用的标准螺纹 Standard Thread Application by Toolholder

刀杆 Tool holder	最小螺纹直径 Min.Thread φ							
	D2 mm	ISO 细牙 ISO Fine	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSW/BSF	NPT	NPTF
WSC 2524-43412	24.5	M30×3.5; M36×4	M28×3; M45×4	1 1/8"×7; 1 3/8"×6	1 3/8"×8UN; 1 7/16"×6UN	1 3/8"×8BSF; 1 1/4"×7BSW	-	-
WSC 3230-43413	30	M36×4; M42×4.5	M34×3; M34×3.5; M45×4	1 3/8"×6	1 3/8"×8UN; 1 7/16"×6UN	1 3/8"×8BSF; 1 3/4"×7BSF; 1 1/2"×6BSW	-	-
WSC 3230-65413	30	M36×4; M42×4.5	M34×3; M34×3.5; M45×4	1 3/8"×6	1 3/8"×8UN; 1 7/16"×6UN	1 3/8"×8BSF; 1 3/4"×7BSF; 1 1/2"×6BSW	-	-
WSC 3236-43415	36	M42×4.5; M48×5; M56×5.5; M64×6	M40×3; M40×3.5; M42×4; M70×6	1 3/4"×5; 2"×4.5; 2 1/2"×4	1 5/8"×8UN; 1 5/8"×6UN	1 5/8"×8BSF; 1 3/4"×7BSF; 1 7/8"×6BSF	2 1/2"×8	2 1/2"×8
WSC 3236-65414	36	M42×4.5; M48×5; M56×5.5; M64×6	M40×3; M40×3.5; M42×4; M70×6	1 3/4"×5; 2"×4.5; 2 1/2"×4	1 5/8"×8UN; 1 5/8"×6UN	1 5/8"×8BSF; 1 3/4"×7BSF; 1 7/8"×6BSF	2 1/2"×8	2 1/2"×8



适用于刀片尺寸41mm的螺纹套式铣刀 Shell Mills for Insert Size 41mm



标准螺纹套式铣刀 Standard shell mills

刀片尺寸 Insert Size	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	紧定螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver	内六角螺钉 Holder Screw
mm		D1	D2	d(H7)	H	Z				
41	WSC D48-22-415	40	48	22	50	5	LS M4×0.7	CS M4×0.7	T08	M10×1.50×40
	WSC D58-27-416	50	58	27	50	6				M12×1.75×40

刀杆所适用的标准螺纹 Standard Thread Application by Toolholder

刀杆 Tool holder	最小螺纹直径 Min.Thread φ							
	D2 mm	ISO 细牙 ISO Fine	ISO 粗牙 ISO Coarse	UNC	UN/UNF/UNEF/UNS	BSF	NPT	NPTF
WSC D48-22-415	48	M56×5.5; M64×6	M55×4; M70×6	2 1/4"×4.5; 2 1/2"×4	2 1/8"×8UN; 2 1/8"×6UN	2 1/4"×8; 2 1/4"×6	2 1/2"×8	2 1/2"×8
WSC D58-27-416	58	M68×6	M64×4; M70×6	2 3/4"×4	2 1/2"×8UN; 2 1/2"×6UN	2 1/2"×8; 2 3/4"×6	2 1/2"×8	2 1/2"×8

整体硬质合金螺纹铣刀型号说明 Solid Carbide Threading Mills Ordering Code System

1 **HH** 2 **12** 3 **116** 4 **N** 5 **2.00** 6 **ISO** 7

1、产品系列 Product Line	2、牙数 No. of Teeth	3、柄径 Shank Dia.	4、切削刃径 Cutting Dia.
HH — 螺旋槽带内冷却直孔 HeliCool HHR — 螺旋槽带内冷却斜孔 HeliCool R HHC — 螺旋槽带内冷却直孔并带倒角 HeliCool C H — 螺旋槽无冷却孔 HeliCal S — 直槽无冷却孔 Straight Flutes DH — 深孔螺纹铣刀 Deep Threading	只对深孔螺纹铣刀 Only for Deep Threading - Long Tools	03 — 3.0 mm 04 — 4.0 mm 06 — 6.0 mm 08 — 8.0 mm 10 — 10.0 mm 12 — 12.0 mm 14 — 14.0 mm 16 — 16.0 mm 18 — 18.0 mm 20 — 20.0 mm	0.7 — 19.9 mm

5、加工类型 Type of Tool	6、螺距 Pitch	7、螺纹标准 Standard
E — 外螺纹 External N — 内螺纹 Internal EN - 内外通用螺纹 External + Internal	全牙型螺距范围 Full Profile Pitch Range mm TPI 0.35 - 6.0 72 - 4.5 通用型螺距范围 Partial Profile Pitch Range mm TPI A 0.5-0.8 32-56 B 0.5-1.0 24-56 C 1.0-1.50 16-24 D 1.0-1.75 14-24 F 0.5-1.25 20-48	ISO — ISO 标准型螺纹 ISO Metric UN — 60° 美制统一标准型螺纹 American UN UNC — 60° 美制统一粗牙螺纹 UN Coarse UNF — 60° 美制统一细牙螺纹 UN Fine UNEF — 60° 美制统一超细牙螺纹 UN Extra Fine UNJ — 60° 美制航空航天螺纹 UNJ BSW — 55° 英国惠氏粗牙螺纹 Whit.Coarse BSF — 55° 英国惠氏细牙螺纹 Whit.Fine BSPT — 55° 英制标准锥管螺纹 BSPT BSP — 55° 英制标准管螺纹 BSP NPT — 60° 美国标准锥管螺纹 NPT NPTF — 60° 美国标准密封螺纹 NPTF

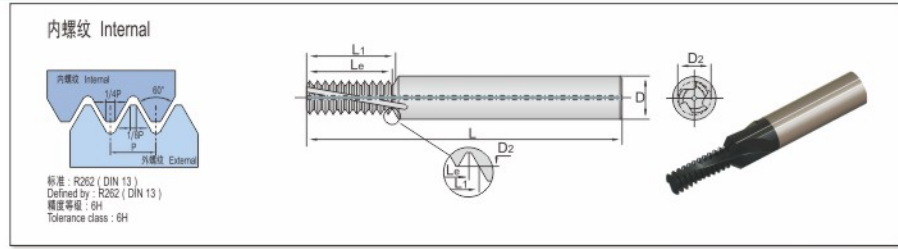
多功能复合螺纹铣刀型号说明 DCTC

1 **DCTC** 2 **M6** 3 **1.0** 4 **2D**

1、产品系列 Product Line	2、螺纹直径 Thread Diameter	3、螺距 Pitch	4、螺纹长度 Thread Length
DCTC - 多功能复合螺纹铣刀 Multi-function threading mill	M6 - M12	1 - 1.75mm	2D 2.5D



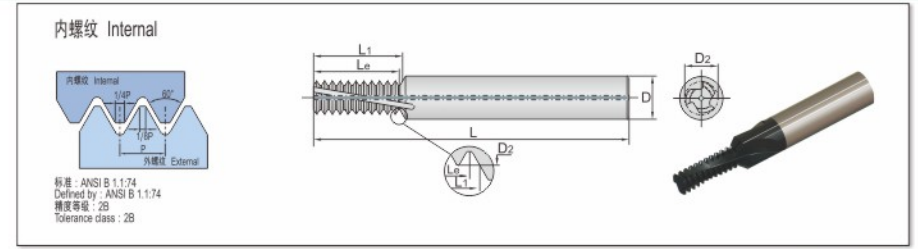
ISO 标准型螺纹 ISO Metric Full Profile



螺旋槽带内冷直孔螺纹铣刀 Helical Flutes with Thru-Hole Coolant 1.5×D0 (Le≤1.5×螺纹直径)
1.5×D0 (Le≤1.5×Thread Diameter)

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	细牙 Fine	mm	内螺纹刀 Internal	D	D ₂	L	Le	L ₁	Z	Z _t	mm
M3×0.5	M3.5-M16×0.5	0.50	HH04024N0.50ISO	4	2.40	45	4.5	4.7	3	9	2.5
M4×0.7		0.70	HH04031N0.70ISO	4	3.15	45	6.3	6.6	3	9	3.3
M5×0.8		0.80	HH04039N0.80ISO	4	3.90	45	7.2	7.6	3	9	4.2
M6×1.0	M8-M40×1.0	1.00	HH06048N1.00ISO	6	4.80	57	9.0	9.5	3	9	5.0
M8×1.25		1.25	HH08065N1.25ISO	8	6.50	61	12.5	13.1	3	10	6.8
M10×1.5	M12-M48×1.5	1.50	HH10082N1.50ISO	10	8.20	73	15.0	15.7	3	10	8.5
M12×1.75		1.75	HH10099N1.75ISO	10	9.90	73	17.5	18.4	4	10	10.2
M14×2.0	M17-M80×2.0	2.00	HH12116N2.00ISO	12	11.60	73	20.0	21.0	4	10	12.0
M16×2.0	M17-M80×2.0	2.00	HH14136N2.00ISO	14	13.60	92	24.0	25.0	4	12	14.0

UN-60° 美制统一标准螺纹 American UN Full Profile

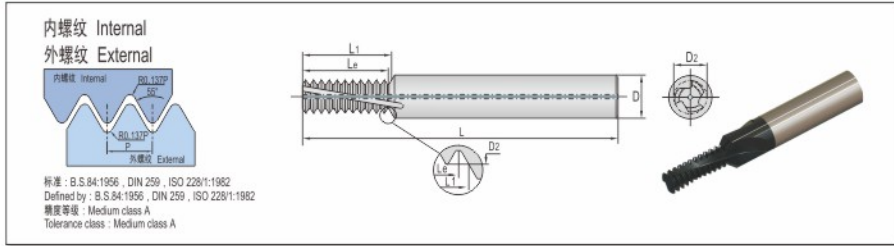


螺旋槽带内冷直孔螺纹铣刀 Helical Flutes with Thru-Hole Coolant 1.5×D0 (Le≤1.5×螺纹直径)
1.5×D0 (Le≤1.5×Thread Diameter)

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.	
UNC粗牙 UNC (Coarse)	UNF细牙 UNF (Fine)		内螺纹刀 Internal	D	D ₂	L	Le	L ₁	Z	Z _t	mm	
NO.10-24	5/16", 3/8"×24	9/16"-11/16"×24	24	HH04035N24UNC	4	3.58	45	7.4	7.9	3	7	3.8
NO.10-24	5/16", 3/8"×24	9/16"-11/16"×24	24	HH06041N24UNC	6	4.15	57	8.5	9.0	3	8	4.5
1/4"×20	7/16", 1/2"×20	3/4"-1"×20	20	HH06048N20UNC	6	4.88	57	8.9	9.5	3	7	5.2
5/16"×18	9/16", 5/8"×18	11/16"-1 1/16"×18	18	HH08061N18UNC	8	6.15	61	11.3	12.0	3	8	6.5
3/8"×16	3/4"×16		16	HH08076N16UNC	8	7.65	61	14.3	15.1	3	9	8.0
7/16"×14	7/8"×14		14	HH10090N14UNC	10	9.00	73	16.3	17.2	3	9	9.3
1/2"×13			13	HH12104N13UNC	12	10.35	73	19.5	20.5	4	10	10.8
9/16"×12	1"-1 1/2"×12		12	HH12118N12UNC	12	11.80	73	21.2	22.2	4	10	12.3



W-55° 英国惠氏螺纹 55° Whitworth Full Profile

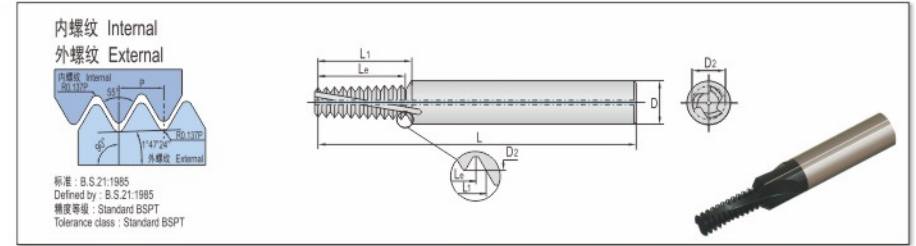


螺旋槽带内冷直孔螺纹铣刀 Helical Flutes with Thru-Hole Coolant

2×D0 (Le≤2×螺纹直径)
2×D0 (Le≤2×Thread Diameter)

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.	
			D	D ₂	L	Le	L ₁				
BSW粗牙 BSW (Coarse)	BSF细牙 BSF (Fine)	内外共用刀 Internal+External	D	D ₂	L	Le	L ₁	Z	Z _t	mm	
	1/4"×26	26	HH06050EN26BSF	6	5.00	57	12.7	13.2	3	13	5.3
	5/16"×22	22	HH08063EN22BSF	8	6.35	61	16.2	16.7	3	14	6.7
1/4"×20	3/8"×20	20	HH06044EN20BSW	6	4.45	57	12.7	13.3	3	10	5.0
	3/8"×20	20	HH08076EN20BSF	8	7.65	61	19.0	19.7	3	15	8.2
5/16"×18	7/16"×18	18	HH6058EN18BSW	6	5.85	57	15.5	16.2	3	11	6.5
	7/16"×18	18	HH10092EN18BSF	10	9.20	73	22.6	23.3	3	16	9.7
3/8"×16	1/2", 9/16"×16	16	HH08072N16BSW	8	7.20	61	19.0	19.8	3	12	7.9
	1/2", 9/16"×16	16	HH12105EN16BSF	12	10.50	80	25.4	26.2	4	16	11.1
	9/16"×16	16	HH14122EN16BSF	14	12.15	92	28.6	29.4	4	18	12.6
7/16"×14	5/8", 11/16"×14	14	HH10085EN14BSW	10	8.50	73	21.8	22.7	3	12	9.2
	5/8", 11/16"×14	14	HH14134EN14BSF	14	13.40	92	30.8	31.7	4	17	14.0
	11/16"×14	14	HH16150EN14BSF	16	15.00	92	34.5	35.4	4	19	15.6
1/2"×12	3/4"×12	12	HH10096EN12BSW	10	9.65	73	25.4	26.5	3	12	10.5
9/16"×12	3/4"×12	12	HH12113EN12BSW	12	11.25	80	27.5	28.6	4	13	12.1
	3/4"×12	12	HH18162EN12BSF	18	16.20	102	38.1	39.2	4	18	16.8
5/8"×11	7/8"×11	11	HH14126EN11BSW	14	12.60	92	32.3	33.5	4	14	13.4
11/16"×11		11	HH16142EN11BSW	16	14.20	92	34.6	35.8	4	15	15.0

BSPT-55° 英国标准锥管螺纹 British Standard Pipe Full Profile

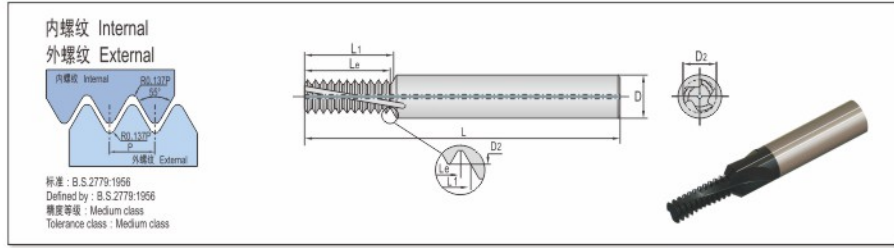


螺旋槽带内冷直孔螺纹铣刀 Helical Flutes with Thru-Hole Coolant

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D ₂	L	Le	L ₁			
	TPI	内外共用刀 Internal+External	D	D ₂	L	Le	L ₁	Z	Z _t	mm
1/16"×28	28	HH06059EN28BSPT	6	5.90	57	10.0	10.2	3	11	6.7
1/8"×28	28	HH08076EN28BSPT	8	7.65	61	10.0	10.2	3	11	8.7
1/4"×19	19	HH10099EN19BSPT	10	9.90	73	14.7	15.4	3	11	11.8
3/8"×19	19	HH12111EN19BSPT	12	11.15	73	14.7	15.4	4	11	15.2
1/2", 3/4"×14	14	HH16142EN14BSPT	16	14.25	92	21.8	22.7	4	12	19.0
1", 1 1/2", 2", 2 1/2"×11	11	HH20196EN11BSPT	20	19.60	102	27.7	28.9	4	12	30.7



BSP (G) -55° 英国标准管螺纹 British Standard Pipe Full Profile

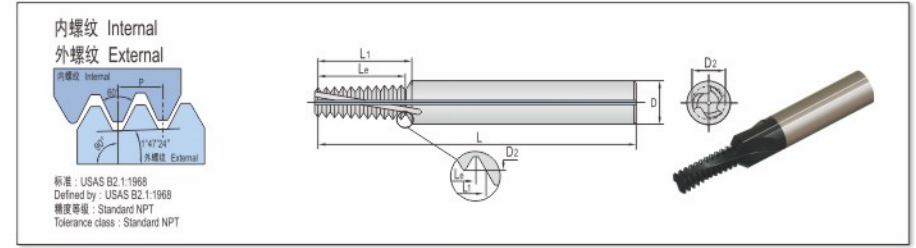


1.5×D0 (Le≤1.5×螺纹直径)
1.5×D0 (Le≤1.5×Thread Diameter)

螺旋槽带内冷直孔螺纹铣刀 Helical Flutes with Thru-Hole Coolant

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D2	L	Le	L1			
	TPI	内外共用刀 Internal+External	D	D2	L	Le	L1	Z	Zt	mm
1/16", 1/8"×28	28	HH08064EN28BSP	8	6.40	61	11.8	12.2	3	13	6.7
1/8"×28	28	HH10082EN28BSP	10	8.20	73	14.5	15.0	3	16	8.7
1/4", 3/8"×19	19	HH12110EN19BSP	12	11.00	80	20.0	20.7	4	15	11.8
3/8"×19	19	HH16145EN19BSP	16	14.50	92	25.4	26.1	4	19	15.2
1"-4"×11	11	HH20199EN11BSP	20	19.90	102	41.6	42.7	4	18	30.7

NPT-60° 美国标准锥管螺纹 National Pipe Threads

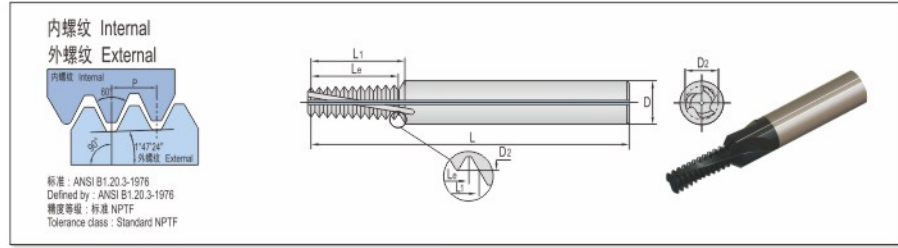


螺旋槽带内冷直孔螺纹铣刀 Helical Flutes with Thru-Hole Coolant

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D2	L	Le	L1			
	TPI	内外共用刀 Internal+External	D	D2	L <td>Le <td>L1</td> <td>Z</td> <td>Zt</td> <td>mm</td> </td>	Le <td>L1</td> <td>Z</td> <td>Zt</td> <td>mm</td>	L1	Z	Zt	mm
1/16"×27	27	HH06059EN27NPT	6	5.90	57	9.4	9.9	3	10	6.3
1/8"×27	27	HH08076EN27NPT	8	7.65	61	9.4	9.9	3	10	8.5
1/4"×18	18	HH10099EN18NPT	10	9.90	73	14.1	14.8	3	10	11.1
3/8"×18	18	HH12111EN18NPT	12	11.15	73	14.1	14.8	4	10	14.5
1/2", 3/4"×14	14	HH16142EN14NPT	16	14.25	92	18.1	19	4	10	17.7, 23.0
1", 1 1/4", 1 1/2", 2"×11.5	11.5	HH20196EN11.5NPT	20	19.60	102	22.1	23.2	4	10	29.0, 37.7, 44.0, 56.0
2 1/2", 3"×8	8	HH20196EN8NPT	20	19.60	102	31.7	33.3	4	10	66.5, 82.1



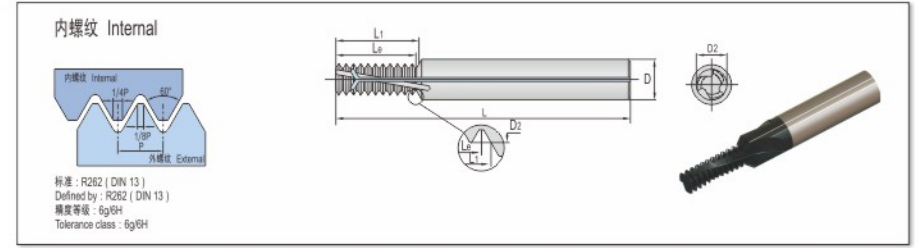
NPTF美制干密封锥管螺纹 NPTF



螺旋槽带内冷直孔螺纹铣刀 Helical Flutes with Thru-Hole Coolant

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
	TPI	内外共用刀 Internal+External	D	D ₂	L	L _e	L ₁	Z	Z _t	mm
1/16"×27	27	HH06059EN27NPTF	6	5.90	57	9.4	9.9	3	10	6.3
1/8"×27	27	HH08076EN27NPTF	8	7.65	61	9.4	9.9	3	10	8.4
1/4"×18	18	HH10099EN18NPTF	10	9.90	73	14.1	14.8	3	10	11.1
3/8"×18	18	HH12111EN18NPTF	12	11.15	73	14.1	14.8	4	10	14.7
1/2", 3/4"×14	14	HH16142EN14NPTF	16	14.25	92	18.1	19.0	4	10	17.9, 23.4
1", 1 1/4", 1 1/2", 2"×11.5	11.5	HH20196EN11.5NPTF	20	19.60	102	22.1	23.2	4	10	29.0, 37.7, 43.7, 55.6
2 1/2", 3"×8	8	HH20196EN8NPTF	20	19.60	102	31.7	33.3	4	10	66.3, 82.1

ISO标准型螺纹铣刀 ISO METRIC Full Profile

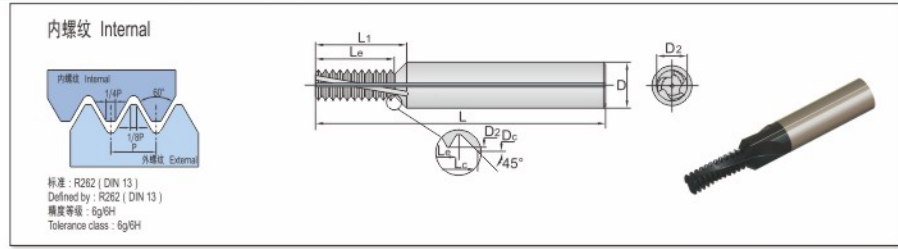


螺旋槽带内冷斜孔螺纹铣刀 Helicool-R Helical Flutes with Radial Cooling

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)					槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	细牙 Fine	mm	内螺纹刀 Internal	D	D ₂	L	L _e	L ₁	Z	Z _t	mm
M6×1.0	M8-M40×1.0	1.00	HH-R06048N1.00ISO	6	4.8	57	12.0	12.5	3	12	5.0
	M10×1.0	1.00	HH-R10087N1.00ISO	10	8.7	73	20.0	20.5	3	20	9.0
	M12×1.0	1.00	HH-R12107N1.00ISO	12	10.7	73	24.0	24.5	4	24	11.0
M8×1.25		1.25	HH-R08065N1.25ISO	8	6.5	64	16.3	16.9	3	13	6.8
M10×1.5	M12-M48×1.5	1.50	HH-R10082N1.50ISO	10	8.2	73	19.5	20.3	3	13	8.5
	M12×1.5	1.50	HH-R10099N1.50ISO	10	9.9	73	24.0	24.8	4	16	10.5
	M14×1.5	1.50	HH-R12119N1.50ISO	12	11.9	84	28.5	29.3	4	19	12.5
	M16×1.5	1.50	HH-R14139N1.50ISO	14	13.9	84	31.5	32.3	4	21	14.5
M12×1.75		1.75	HH-R10099N1.75ISO	10	9.9	73	24.5	25.4	4	14	10.2



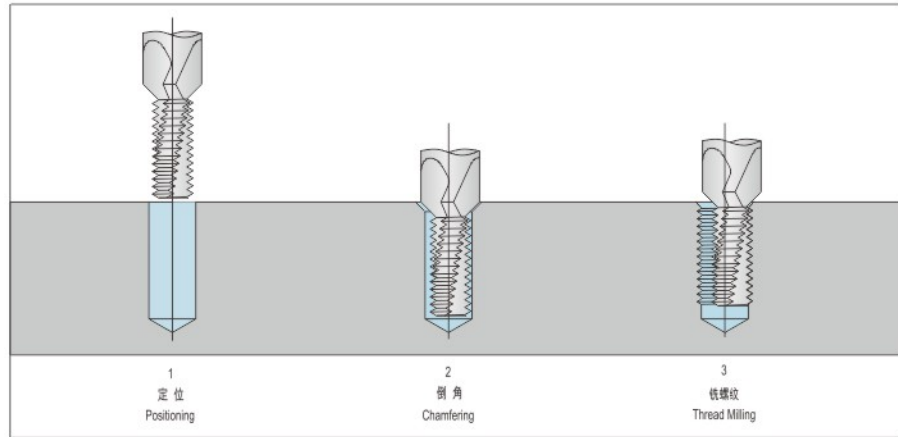
ISO标准型螺纹 ISO METRIC Full Profile



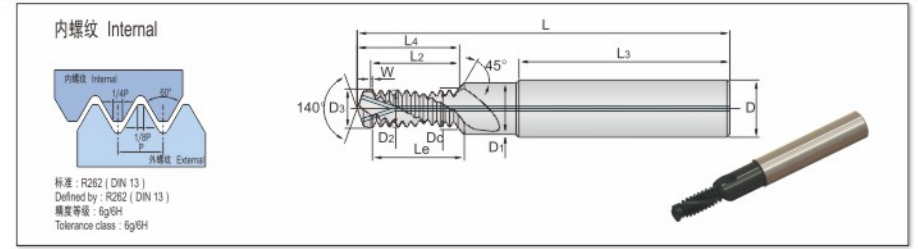
螺旋槽带内冷直孔并带倒角功能螺纹铣刀 HelicoolC(HHC) Flutes with Axial Coolant-Thru & Chamfer $2 \times D_0$ ($Le \leq 2 \times$ 螺纹直径) $2 \times D_0$ ($Le \leq 2 \times$ Thread Diameter)

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)									槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	细牙 Fine	mm	内螺纹刀 Internal	D	D ₂	D _c	L	Le	L ₁	L _c	Z	Z _t	mm		
M6×1.0	M8-M40×1.0	1.00	HHC08048N1.00ISO	8	4.8	6.3	61	12.0	12.5	13.3	3	12	5.0		
	M10×1.0	1.00	HHC12087N1.00ISO	12	8.7	10.3	73	20.0	20.5	21.3	3	20	9.0		
M8×1.25	M12×1.0	1.00	HHC14107N1.00ISO	14	10.7	12.3	80	24.0	24.5	25.3	4	24	11.0		
	M12×1.25	1.25	HHC10065N1.25ISO	10	6.5	8.3	73	16.3	16.9	17.8	3	13	6.8		
M10×1.5	M12-M48×1.5	1.50	HHC12082N1.50ISO	12	8.2	10.3	80	19.5	20.3	21.3	3	13	8.5		
	M12×1.5	1.50	HHC14099N1.50ISO	14	9.9	12.3	80	24.0	24.8	26.0	4	16	10.5		
M14×1.5	M16×1.5	1.50	HHC16199N1.50ISO	16	11.9	14.3	92	28.5	29.3	30.5	4	19	12.5		
	M16×1.5	1.50	HHC18139N1.50ISO	18	13.9	16.3	92	31.5	32.3	33.5	4	21	14.5		
M12×1.75		1.75	HHC14099N1.75ISO	14	9.9	12.3	80	24.5	25.4	26.6	4	14	10.2		

HHC-加工示意图 Operating Cycle



ISO标准型螺纹 ISO METRIC Full Profile

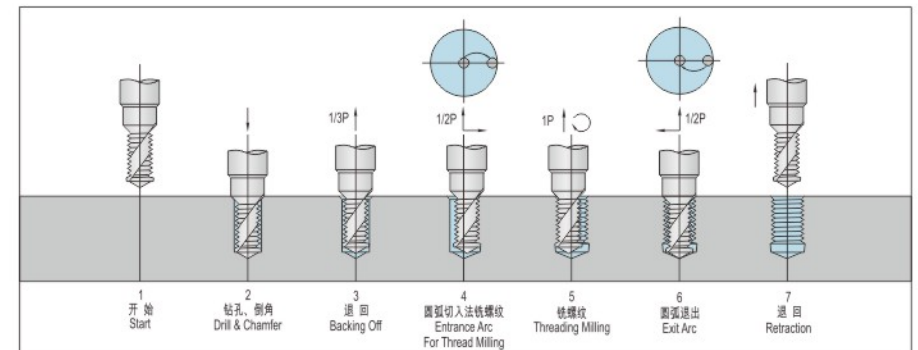


DCTC多功能复合螺纹铣刀 DCTC Multi-functional Threading Mill 带内冷却孔的钻孔、倒角螺纹铣刀 Drill, Chamfer & Thread With Coolant-Thru

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)										槽数 No. of Flutes	齿数 Teeth	
ISO 2×D ₀ 粗牙 ISO 2×D ₀ Coarse	mm	mm	内螺纹刀 Internal	L	L ₄	L ₂	L ₃	W	Le	D ₃	D	D ₁	D _c	D ₂	Z	Z _t
M6×1.0	1.00	DCTC M6×1.0×2D		62.0	14.5	13.7	36	1.0	12.7	5.0	8	6.6	6.3	4.85	2	11
M8×1.25	1.25	DCTC M8×1.25×2D		74.0	18.2	17.1	40	1.3	15.8	6.8	10	9.0	8.3	6.45	2	11
M10×1.5	1.50	DCTC M10×1.5×2D		79.0	23.4	22.1	45	1.5	20.6	8.5	12	11.0	10.3	8.08	2	12
M12×1.75	1.75	DCTC M12×1.75×2D		89.0	27.1	25.5	45	1.5	24.0	10.3	14	13.5	12.3	9.74	2	12

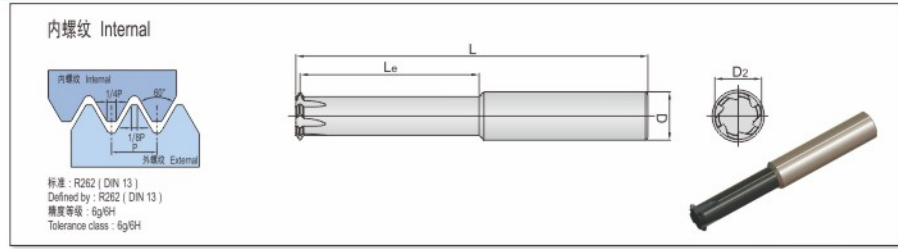
螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)										槽数 No. of Flutes	齿数 Teeth	
ISO 2.5×D ₀ 粗牙 ISO 2.5×D ₀ Coarse	mm	mm	内螺纹刀 Internal	L	L ₄	L ₂	L ₃	W	Le	D ₃	D	D ₁	D _c	D ₂	Z	Z _t
M6×1.0	1.00	DCTC M6×1.0×2.5D		62.0	16.5	15.7	36	1.0	14.7	5.0	8	6.6	6.3	4.85	2	13
M8×1.25	1.25	DCTC M8×1.25×2.5D		74.0	23.2	22.1	40	1.3	20.8	6.8	10	9.0	8.3	6.45	2	15
M10×1.5	1.50	DCTC M10×1.5×2.5D		79.0	27.9	26.6	45	1.5	25.1	8.5	12	11.0	10.3	8.08	2	15

DCTC多功能螺纹铣刀-加工示意图 DCTC Operating Cycle





ISO标准型螺纹 ISO METRIC Full Profile



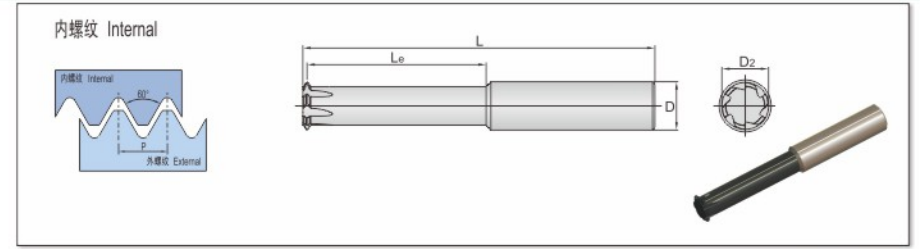
标准: R262 (DIN 13)
Defined by: R262 (DIN 13)
精度等级: 6g/6H
Tolerance class: 6g/6H

3×D0 (Le≤3×螺纹直径)
3×D0 (Le≤3×Thread Diameter)

深孔螺纹铣刀 Deep Threading-Long Tools for Deep Holes

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D ₂	L	Le			
粗牙 Coarse	mm	内螺纹刀 Internal	D	D ₂	L	Le	Z	Z _t	mm
M6×1	1.00	DH1T08041N1.0ISO	8	4.1	63	19	3	1	5.0
M8×1.25	1.25	DH1T10058N1.25ISO	10	5.8	73	26	3	1	6.8
M10×1.5	1.50	DH1T10077N1.50ISO	10	7.7	73	32	3	1	8.5
M12×1.5	1.50	DH1T10094N1.50ISO	10	9.4	83	38	4	1	10.5
M12×1.75	1.75	DH1T10087N1.75ISO	10	8.7	83	38	4	1	10.2
M14×2.0	2.00	DH1T12102N2.0ISO	12	10.2	92	44	4	1	12.0
M16×2.0	2.00	DH1T14122N2.0ISO	14	12.2	100	50	4	1	14.0
M18×2.5	2.50	DH1T14129N2.50ISO	14	12.9	108	57	5	1	15.5
M20×2.5	2.50	DH1T16148N2.50ISO	16	14.8	114	63	5	1	17.5

范围牙型60° Partial Profile 60°



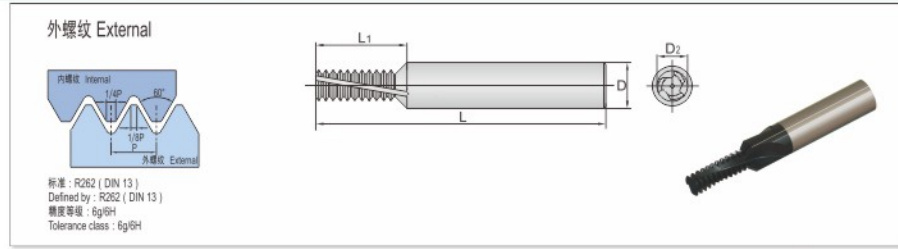
3×D0 (Le≤3×螺纹直径)
3×D0 (Le≤3×Thread Diameter)

深孔螺纹铣刀 Deep Threading-Long Tools for Deep Holes

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				
M粗牙 M Coarse	M细牙 M Fine			D	D ₂	L	Le	Z
M5×0.8	M5×0.5 M5×0.75	NO.10-56UNS, NO.10-48UNS, NO.10-40UNS, NO.10-36UNS, NO.10-32UNF	4	3.90	45	16	4	1
M6×1.0	M6×0.5 M6×0.75	NO.12-56UNS, NO.12-48UNS, 1/4-40UNS, 1/4-36UNS, 1/4-32UNF, 1/4-28UNF 1/4-27UNS, 1/4-24UNS	6	4.85	51	20	5	1
M8×1.25	M7×0.5 M7×0.75 M7.5×1.0	5/16-48UNS, 5/16-40UNS, 5/16-36UNS, 5/16-32UNF, 5/16-28UN, 5/16-27UNS, 5/16-24UNS, 5/16-20UN	6	5.90	64	25	5	1
-	M10.5×0.5 M11×0.75 M11×1.0	7/16-32UN, 7/16-28UNEF, 7/16-27UNS, 7/16-24UNS	10	9.90	73	35	6	1
M10×1.5	M10×1.0 M10×1.25	3/8-24UNF, 3/8-20UN, 7/16-18UNS, 7/16-16UN	8	7.90	63	32	6	1
M12×1.75	M12×1.0 M12×1.25 M12×1.5	1/2-24UNS, 1/2-20UNS, 1/2-18UNS, 1/2-16UNS, 1/2-14UNS	10	9.90	73	38	6	1
-	M13.5×1.0 M14×1.25 M14×1.5	9/16-24UNEF	12	11.90	83	45	6	1



ISO标准型螺纹铣刀 ISO METRIC Full Profile



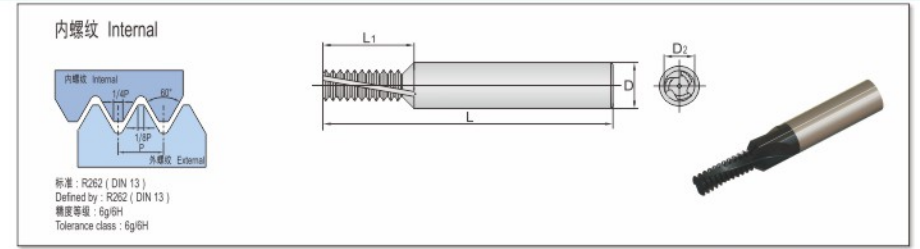
标准: R262 (DIN 13)
Defined by: R262 (DIN 13)
精度等级: 6g/6H
Tolerance class: 6g/6H

2×D0 (Les2×螺纹直径)
2×D0 (Les2×Thread Diameter)

螺旋槽无冷却孔外螺纹铣刀 Helical Flutes Without Coolant Thru - External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	齿数 Teeth
			D	D ₂	L	L _e		
粗牙 Coarse	mm	外螺纹刀 External						
M3×0.5	0.5	H04039E0.5ISO	4	3.9	45	6	3	12
M4.5×0.75	0.75	H04039E0.75ISO	4	3.9	45	9	3	12
M6×1.0	1.0	H04039E1.0ISO	4	3.9	45	12	3	12
M8×1.25	1.25	H06059E1.25ISO	6	5.9	57	16.25	3	13
M10×1.5	1.5	H08079E1.5ISO	8	7.9	63	21	3	14
M14×2.0	2.0	H10099E2.0ISO	10	9.9	73	28	4	14

ISO标准型螺纹铣刀 ISO METRIC Full Profile



标准: R262 (DIN 13)
Defined by: R262 (DIN 13)
精度等级: 6g/6H
Tolerance class: 6g/6H

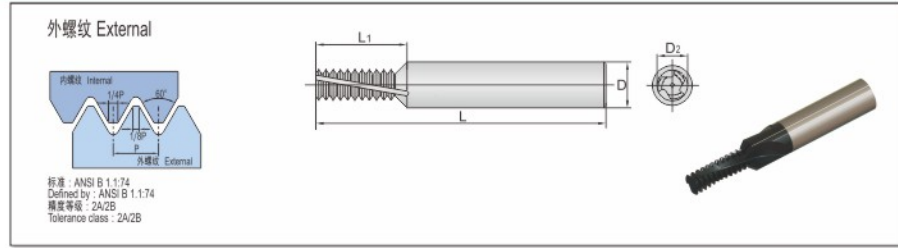
2×D0 (Les2×螺纹直径)
2×D0 (Les2×Thread Diameter)

螺旋槽无冷却孔内螺纹铣刀 Helical Flutes Without Coolant Thru - Internal

粗牙 Coarse	细牙 Fine	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia. mm
				D	D ₂	L	L _e			
M3×0.5	M3.5-M16×0.5	0.5	H04022N0.5ISO	4	2.2	45	6	3	12	2.5
	M4×0.5	0.5	H04030N0.5ISO	4	3	45	8	3	16	3.5
	M5×0.5	0.5	H04039N0.5ISO	4	3.9	45	10	3	20	4.5
	M4×0.7	0.7	H04028N0.7ISO	4	2.8	45	8.4	3	12	3.3
	M6×0.75	0.75	H04039N0.75ISO	4	3.9	45	12	3	16	5.3
	M5×0.8	0.8	H04035N0.8ISO	4	3.5	45	10.4	3	13	4.2
	M6×1.0	1.0	H04039N1.0ISO	4	3.9	45	12	3	12	5
	M8×1.0	1.0	H06059N1.0ISO	6	5.9	57	16	3	16	7
	M10×1.0	1.0	H08079N1.0ISO	8	7.9	63	20	3	20	9
	M12×1.0	1.0	H10099N1.0ISO	10	9.9	73	24	4	24	11
	M8×1.25	1.25	H06058N1.25ISO	6	5.8	57	16.25	3	13	6.8
	M10×1.25	1.25	H08077N1.25ISO	8	7.7	63	20	3	16	8.8
	M10×1.5	1.5	H08077N1.5ISO	8	7.7	63	21	3	14	8.5
	M12×1.5	1.5	H10094N1.5ISO	10	9.4	73	24	4	16	10.5
	M14×1.5	1.5	H12112N1.5ISO	12	11.2	83	28.5	4	19	12.5
	M16×1.5	1.5	H12119N1.5ISO	12	11.9	83	33	4	22	14.5
	M12×1.75	1.75	H10087N1.75ISO	10	8.7	73	24.5	4	14	10.2
	M14×2.0	2.0	H10099N2.0ISO	10	9.9	73	28	4	14	12
	M16×2.0	2.0	H12119N2.0ISO	12	11.9	83	32	4	16	14
	M18-M22×2.5	2.5	H16139N2.5ISO	16	13.9	92	40	5	16	15.5
	M24×3.0	3.0	H16159N3.0ISO	16	15.9	92	42	4	14	21



UN-60° 美制统一标准螺纹 American UN Full Profile

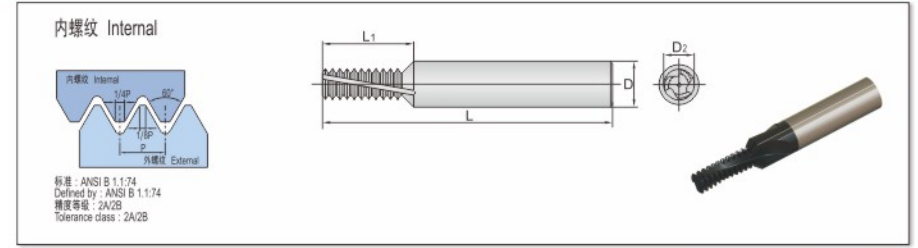


螺旋槽无冷却孔外螺纹铣刀 Helical Flutes Without Coolant Thru - External

2×D0 (Les2×螺纹直径)
2×D0 (Les2×Thread Diameter)

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	齿数 Teeth
UNC	UNF	TPI	外螺纹刀 External	D	D ₂	L	L _e	Z	Z _t
No.8-32		32	H04039E32UNC	4	3.9	45	8.7	3	11
	No.12-28	28	H04039E28UNF	4	3.9	45	11.8	3	13
No.12-24		24	H04039E24UNC	4	3.9	45	11.6	3	11
1/4×20		20	H04039E20UNC	4	3.9	45	12.7	3	10
5/16×18		18	H06059E18UNC	6	5.9	57	16.9	3	12
3/8×16		16	H08079E16UNC	8	7.9	63	19.1	3	12
9/16×12		12	H12119E12UNC	12	11.9	83	29.6	4	14

UN-60° 美制统一标准螺纹 American UN Full Profile



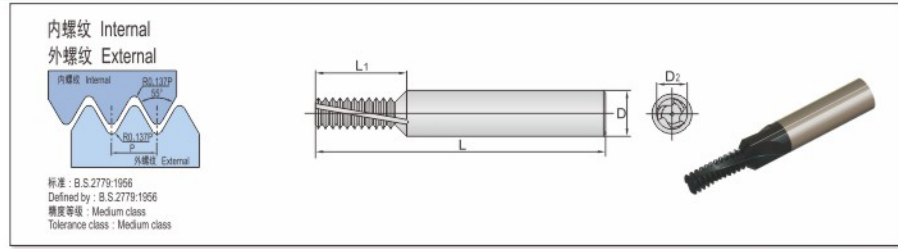
螺旋槽无冷却孔内螺纹铣刀 Helical Flutes Without Coolant Thru - Internal

2×D0 (Les2×螺纹直径)
2×D0 (Les2×Thread Diameter)

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	齿数 Teeth	加工孔径 Bore Dia.		
UNC	UNF	UNEF	TPI	内螺纹刀 Internal		D	D ₂	L	L _e	Z	Z _t	mm
	No.8-32		36	H04030N36UNF	4	3	45	8.5	3	12	3.5	
	No.10-32	No.12-3/8×32	32	H04033N32UNF	4	3.3	45	11.1	3	14	4	
	No.12-28, 1/4×28	7/16", 1/2×28	28	H04038N28UNF	4	3.8	45	11.8	3	13	4.6	
	1/4×28	7/16", 1/2×28	28	H06046N28UNF	6	4.6	57	12.7	3	14	5.5	
		7/16", 1/2×28	28	H10092N28UNF	10	9.2	73	22.7	4	25	10.2	
No.10-24	5/16", 3/8×24	9/16"-11/16×24	24	H04029N24UNC	4	2.9	45	10.6	3	10	3.8	
No.12-24	5/16", 3/8×24	9/16"-11/16×24	24	H04035N24UNC	4	3.5	45	11.6	3	11	4.5	
	5/16", 3/8×24	9/16"-11/16×24	24	H06057N24UNF	6	5.7	57	15.9	3	15	6.8	
	3/8×24	9/16"-11/16×24	24	H08074N24UNF	8	7.4	63	19.1	3	18	8.5	
		9/16"-11/16×24	24	H12119N24UNEF	12	11.9	83	28.6	4	27	13.2	
1/4×20	7/16", 1/2×20	3/4"-1×20	20	H04039N20UNC	4	3.9	45	12.7	3	10	5.2	
	7/16", 1/2×20	3/4"-1×20	20	H10085N20UNF	10	8.5	73	22.9	4	18	9.8	
	1/2×20	3/4"-1×20	20	H10099N20UNF	10	9.9	73	25.4	4	20	11.5	
		3/4"-1×20	20	H16159N20UNEF	16	15.9	92	38.1	5	30	17.8	
5/16×18	9/16", 5/8×18	11/16"-1 11/16×18	18	H06052N18UNC	6	5.2	57	16.9	3	12	6.5	
	9/16", 5/8×18	11/16"-1 11/16×18	18	H12113N18UNF	12	11.3	83	29.6	4	21	12.8	
	5/8×18	11/16"-1 11/16×18	18	H12119N18UNF	12	11.9	83	32.5	4	23	14.5	
3/8×16	3/4×16		16	H08067N16UNC	8	6.7	63	19.1	3	12	8	
	3/4×16		16	H16159N16UNF	16	15.9	92	38.1	4	24	17.5	
7/16×14	7/8×14		14	H08076N14UNC	8	7.6	63	23.6	4	13	9.3	
	7/8×14		14	H20187N14UNF	20	18.7	104	44.4	4	24	20.5	
1/2×13			13	H10089N13UNC	10	8.9	73	25.4	4	13	10.8	
9/16×12	1"-1 1/2×12		12	H12103N12UNC	12	10.3	83	29.6	4	14	12.3	
	1"-1 1/2×12		12	H20199N12UNF	20	19.9	104	50.8	5	24	23.5	
5/8×11			11	H12110N11UNC	12	11	83	32.3	4	14	13.5	
3/4×10			10	H16135N10UNC	16	13.5	92	38.1	5	15	16.5	
7/8×9			9	H16152N9UNC	16	15.2	92	45.2	4	16	19.5	
1×8			8	H20170N8UNC	20	17	104	50.8	4	16	22	



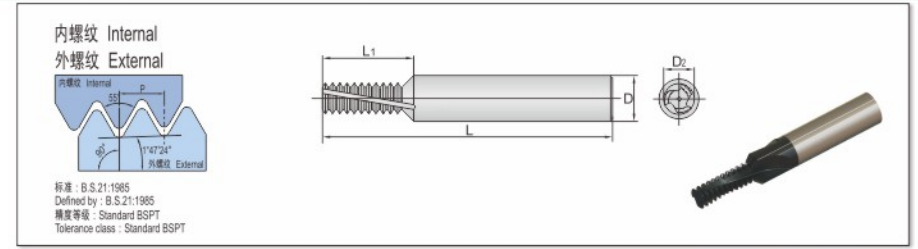
BSP (G) -55° 英制标准管螺纹 British Standard Pipe Full Profile



螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru - External and Internal $2 \times D_0$ ($L_{es} \leq 2 \times$ 螺纹直径)
 $2 \times D_0$ ($L_{es} \leq 2 \times$ Thread Diameter)

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D ₂	L	L _e			
	TPI	内外共用刀 External+Internal							mm
1/16"×28, 1/8"×28	28	H06058EN28BSP	6	5.8	57	16.3	3	18	6.7
1/8"×28	28	H08077EN28BSP	8	7.7	63	20	3	22	8.7
1/4"×19, 3/8"×19	19	H10099EN19BSP	10	9.9	73	26.7	4	20	11.8
3/8"×19	19	H16134EN19BSP	16	13.4	92	33.4	4	25	15.2
1/2", 3/4"×14	14	H16157EN14BSP	16	15.7	92	43.5	5	24	19
1", 1 1/2", 2", 2 1/2"×11	11	H20199EN11BSP	20	19.9	104	41.6	5	18	30.7

BSPT-55° 英国标准锥管螺纹 British Standard Pipe Full Profile

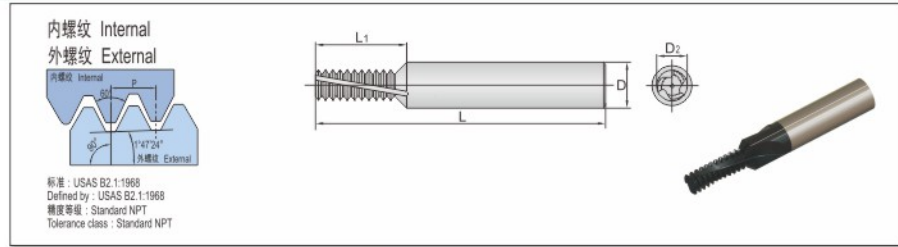


螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru - External and Internal $2 \times D_0$ ($L_{es} \leq 2 \times$ 螺纹直径)
 $2 \times D_0$ ($L_{es} \leq 2 \times$ Thread Diameter)

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D ₂	L	L _e			
	TPI	内外共用刀 External+Internal							mm
1/16"×28	28	H06058EN28BSPT	6	5.8	57	16.3	3	18	6.7
1/8"×28	28	H08077EN28BSPT	8	7.7	63	20	3	22	8.7
1/4"×19	19	H10099EN19BSPT	10	9.9	73	26.7	4	20	11.8
3/8"×19	19	H16134EN19BSPT	16	13.4	92	33.4	4	25	15.2
1/2", 3/4"×14	14	H16157EN14BSPT	16	15.7	92	43.5	5	24	19
1", 1 1/2", 2", 2 1/2"×11	11	H20199EN11BSPT	20	19.9	104	41.6	5	18	30.7



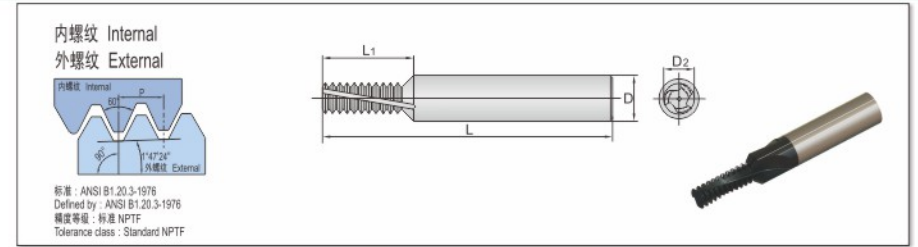
NPT-60° 美国标准锥管螺纹 National Pipe Threads



螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru - External and Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D ₂	L	L _e			
内外共用刀 External+Internal									
1/16"×27	27	H06053EN27NPT	6	5.3	57	9.4	3	10	6.3
1/8"×27	27	H08075EN27NPT	8	7.5	63	9.4	4	10	8.5
1/4"×18	18	H10094EN18NPT	10	9.4	73	14.1	4	10	11.1
3/8"×18	18	H12119EN18NPT	12	11.9	83	14.1	4	10	14.5
1/2", 3/4"×14	14	H16155EN14NPT	16	15.5	92	25.4	5	14	17.7, 23.0
1"-2"×11.5	11.5	H20199EN11.5NPT	20	19.9	104	33.1	5	15	29.0-56.0
2 1/2", 3"×8	8	H20199EN8NPT	20	19.9	104	38.1	4	12	66.5

NPTF美制干密封锥管螺纹 NPTF

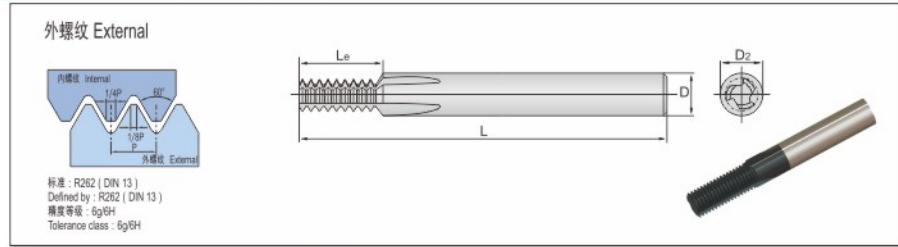


螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru - External and Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
			D	D ₂	L	L _e			
内外共用刀 External+Internal									
1/16"×27	27	H06053EN27NPTF	6	5.3	57	9.4	3	10	6.3
1/8"×27	27	H08075EN27NPTF	8	7.5	63	9.4	4	10	8.5
1/4"×18	18	H10094EN18NPTF	10	9.4	73	14.1	4	10	11.1
3/8"×18	18	H12119EN18NPTF	12	11.9	83	14.1	4	10	14.7
1/2", 3/4"×14	14	H16155EN14NPTF	16	15.5	92	25.4	5	14	17.9, 23.4
1"-2"×11.5	11.5	H20199EN11.5NPTF	20	19.9	104	33.1	5	15	29.4-56.2
2 1/2", 3"×8	8	H20199EN8NPTF	20	19.9	104	38.1	4	12	67.0



ISO标准型螺纹 ISO Metric Full Profile



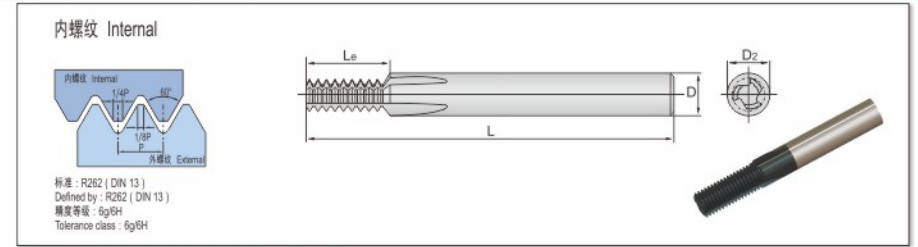
标准直槽外刀 Standard Straight Flutes - External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	mm	外螺纹刀 External	D	D ₂	L	Le*	Z	Z _t	mm
M3	0.50	S06059E0.5 ISO	6.0	5.9	57	15.0	3	30	0.31
M4.5	0.75	S08079E0.75 ISO	8.0	7.9	63	19.5	3.5*	26	0.46
M6	1.00	S10099E1.0 ISO	10.0	9.9	72	24.0	5	24	0.61
M10	1.50	S12119E1.5 ISO	12.0	11.9	83	30.0	5	20	0.92
M14	2.00	S12119E2.0 ISO	12.0	11.9	83	30.0	5	15	1.23
M24	3.00	S16159E3.0 ISO	16.0	15.9	92	36.0	5	12	1.84
M36	4.00	S16159E4.0 ISO	16.0	15.9	92	40.0	5	10	2.45
M64	6.00	S20199E6.0 ISO	20.0	19.9	104	36.0	5	6	3.68

* 表示可以订购3或者5个槽，订货时把3或者5加在订货号后面

* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.

ISO标准型螺纹 ISO Metric Full Profile



标准直槽内刀 Standard Straight Flutes - Internal

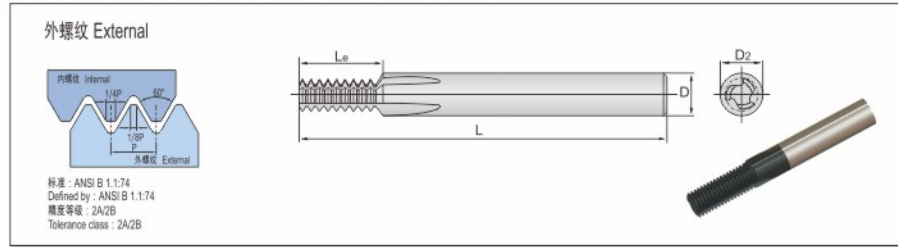
螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	mm	内螺纹刀 Internal	D	D ₂	L	Le*	Z	Z _t	mm
M4.5	0.75	S04030N0.75 ISO	4.0	3.0	42	6.7	3	9	0.43
M8	0.75	S06059N0.75 ISO	6.0	5.9	57	15.0	3	20	0.43
M5	0.80	S04036N0.8 ISO	4.0	3.6	42	8.0	3	10	0.46
M6	1.00	S06040N1.0 ISO	6.0	4.0	57	9.0	3	9	0.58
M12	1.00	S08079N1.0 ISO	8.0	7.9	63	20.0	3.5*	20	0.58
M8	1.25	S06050N1.25 ISO	6.0	5.0	57	12.5	3	10	0.72
M10	1.50	S06059N1.5 ISO	6.0	5.9	57	15.0	3	10	0.87
M14	1.50	S10099N1.5 ISO	10.0	9.9	72	24.0	5	16	0.87
M18	1.50	S12119N1.5 ISO	12.0	11.9	83	30.0	5	20	0.87
M12	1.75	S08079N1.75 ISO	8.0	7.9	63	19.2	3.5*	11	1.01
M16	2.00	S10099N2.0 ISO	10.0	9.9	72	24.0	5	12	1.15
M18	2.00	S12119N2.0 ISO	12.0	11.9	83	30.0	5	15	1.15
M20	2.50	S12119N2.5 ISO	12.0	11.9	83	30.0	5	12	1.44
M24	3.00	S16159N3.0 ISO	16.0	15.9	92	36.0	5	12	1.73
M30	3.50	S16159N3.5 ISO	16.0	15.9	92	38.5	5	11	2.02
M36	4.00	S16159N4.0 ISO	16.0	15.9	92	40.0	5	10	2.31
M48	5.00	S20199N5.0 ISO	20.0	19.9	104	40.0	5	8	2.89
M64	6.00	S20199N6.0 ISO	20.0	19.9	104	36.0	5	6	3.46

* 表示可以订购3或者5个槽，订货时把3或者5加在订货号后面

* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.



UN-60° 美制统一标准螺纹铣刀 American UN Full Profile

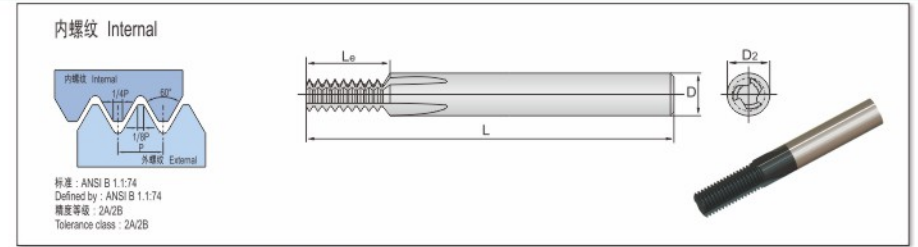


标准直槽外刀 Standard Straight Flutes - External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	外螺纹刀 External	D	D ₂	L	Le	Z	Z _t	mm
NO.6	32	S06059E32 UN	6	5.9	57	14.3	3	18	0.49
NO.12	28	S08079E28 UN	8	7.9	63	19.9	3.5*	22	0.56
1/4"	20	S10099E20 UN	10	9.9	72	22.9	5	18	0.78
5/16"	18	S10099E18 UN	10	9.9	72	24.0	5	17	0.87
3/8"	16	S12119E16 UN	12	11.9	83	28.6	5	18	0.97
9/16"	12	S12119E12 UN	12	11.9	83	29.6	5	14	1.30
1"	8	S16159E8 UN	16	15.9	92	38.1	5	12	1.95
1 3/8"	6	S20199E6 UN	20	19.9	104	38.1	5	9	2.60

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面
* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.

UN-60° 美制统一标准螺纹铣刀 American UN Full Profile



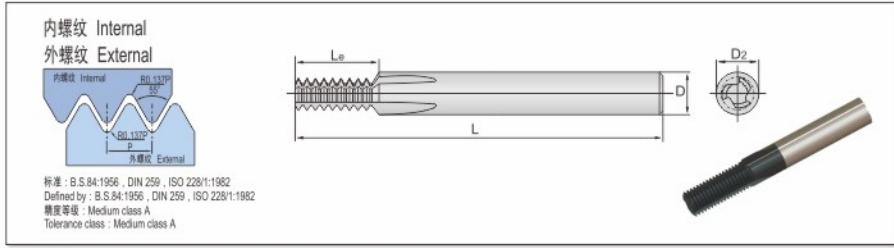
标准直槽内刀 Standard Straight Flutes - Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No. of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	内螺纹刀 Internal	D	D ₂	L	Le	Z	Z _t	mm
NO.8	36	S04030N36 UN	4.0	3.0	42	6.3	3	9	0.41
NO.8	32	S04030N32 UN	4.0	3.0	42	6.3	3	8	0.46
5/16"	32	S06059N32 UN	6.0	5.9	57	14.3	3	18	0.46
NO.12	28	S04036N28 UN	4.0	3.6	42	8.2	3	9	0.52
7/16"	28	S08079N28 UN	8.0	7.9	63	19.9	3.5*	22	0.52
NO.12	24	S06040N24 UN	6.0	4.0	57	8.5	3	8	0.61
1/4"	20	S06040N20 UN	6.0	4.0	57	10.2	3	8	0.73
9/16"	20	S10099N20 UN	10.0	9.9	72	22.9	5	18	0.73
5/16"	18	S06050N18 UN	6.0	5.0	57	12.7	3	9	0.81
9/16"	18	S10099N18 UN	10.0	9.9	72	24	5	17	0.81
3/8"	16	S06059N16 UN	6.0	5.9	57	14.3	3	9	0.92
3/4"	16	S12119N16 UN	12.0	11.9	83	28.6	5	18	0.92
7/16"	14	S08079N14 UN	8.0	7.9	63	18.1	3.5*	10	1.05
1/2"	13	S08079N13 UN	8.0	7.9	63	19.5	3.5*	10	1.13
9/16"	12	S10099N12 UN	10.0	9.9	72	23.3	5	11	1.22
1"	12	S12119N12 UN	12.0	11.9	83	29.6	5	14	1.22
5/8"	11	S10099N11 UN	10.0	9.9	72	23.1	5	10	1.33
3/4"	10	S12119N10 UN	12.0	11.9	83	27.9	5	11	1.47
7/8"	9	S16159N9 UN	16.0	15.9	92	33.3	5	12	1.63
1"	8	S16159N8 UN	16.0	15.9	92	38.1	5	12	1.83
1 1/8"	7	S16159N7 UN	16.0	15.9	92	36.3	5	10	2.09
1 3/8"	6	S20199N6 UN	20.0	19.9	104	38.1	5	9	2.44
1 3/4"	5	S20199N5 UN	20.0	19.9	104	40.6	5	8	2.93
2"	4.5	S20199N4.5 UN	20.0	19.9	104	39.5	5	7	3.26

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面
* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.



W-55° 英国惠氏螺纹铣刀 55° Whitworth Full Profile



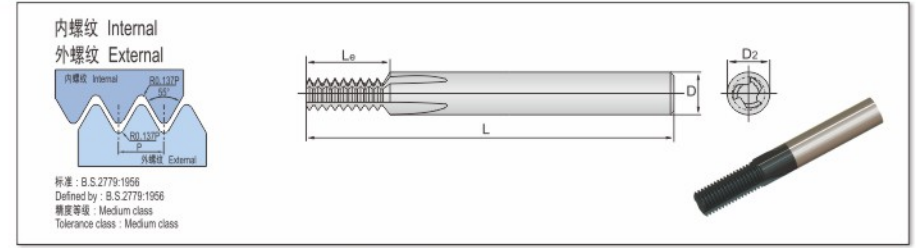
标准直槽内外刀 Standard Straight Flutes-External and Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	内外共用刀 External+Internal	D	D2	L	Le	Z	Zt	mm
1/4"	20	S06040EN20 BSW	6.0	4.0	57	10.16	3	8	0.81
5/16"	18	S06050EN18 BSW	6.0	5.0	57	11.29	3	8	0.90
3/8"	16	S06059EN16 BSW	6.0	5.9	57	14.29	3	9	1.02
7/16"	14	S08079EN14 BSW	8.0	7.9	63	18.14	3.5*	10	1.16
1/2"	12	S08079EN12 BSW	8.0	7.9	63	19.05	3.5*	9	1.36
5/8"	11	S10099EN11 BSW	10.0	9.9	72	23.09	5	10	1.48
3/4"	10	S12119EN10 BSW	12.0	11.9	83	27.94	5	11	1.63
7/8"	9	S12119EN9 BSW	12.0	11.9	83	28.22	5	10	1.81
1"	8	S16159EN8 BSW	16.0	15.9	92	38.10	5	12	2.03
1 1/8"	7	S16159EN7 BSW	16.0	15.9	92	36.29	5	10	2.32
1 3/8"	6	S16159EN6 BSW	16.0	15.9	92	38.10	5	9	2.71
1 5/8"	5	S20199EN5 BSW	20.0	19.9	104	40.64	5	8	3.25
1 7/8"	4.5	S20199EN4.5 BSW	20.0	19.9	104	39.51	5	7	3.61

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面

* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.

BSP-55° 英国标准管螺纹铣刀 British Standard Pipe Full Profile



标准直槽内外刀 Standard Straight Flutes-External and Internal

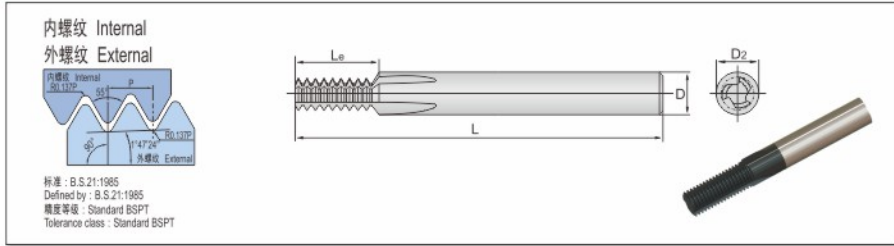
螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	内外共用刀 External+Internal	D	D2	L	Le	Z	Zt	mm
1/16"	28	S06059EN28 BSP	6.0	5.9	57	14.51	3	16	0.58
1/4"	19	S08079EN19 BSP	8.0	7.9	63	18.72	3.5*	14	0.86
1/2"	14	S12119EN14 BSP	12.0	11.9	83	29.03	5	16	1.16
1"	11	S16159EN11 BSP	16.0	15.9	92	34.64	5	15	1.48

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面

* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.



BSPT-55° 英国标准锥管螺纹铣刀 British Standard Pipe Full Profile



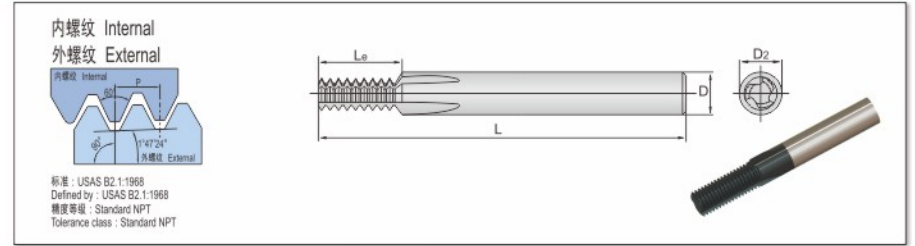
标准直槽内外刀 Standard Straight Flutes-External and Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	内外共用刀 External+Internal	D	D ₂	L	Le	Z	Z _t	mm
1/16"	28	S06059EN28 BSPT	6.0	5.9	57	9.98	3	11	0.58
1/4"	19	S08079EN19 BSPT	8.0	7.9	63	14.71	3.5*	11	0.86
1/2"	14	S12119EN14 BSPT	12.0	11.9	83	19.96	5	11	1.16
1"	11	S16159EN11 BSPT	16.0	15.9	92	39.25	5	17	1.48

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面

* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.

NPT-60° 美国标准锥管螺纹铣刀 National Pipe Threads



标准直槽内外刀 Standard Straight Flutes-External and Internal

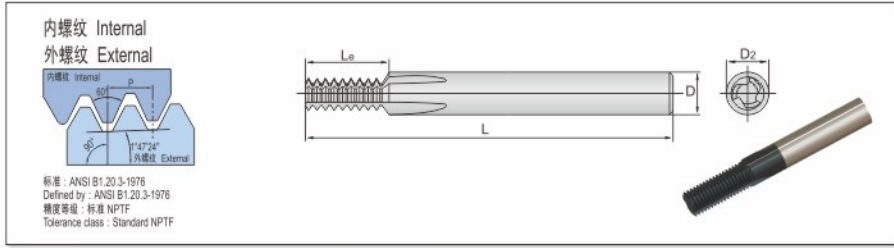
螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	内外共用刀 External+Internal	D	D ₂	L	Le	Z	Z _t	mm
1/16"	27	S06059EN27 NPT	6.0	5.9	57	9.41	3	10	0.66
1/4"	18	S08079EN18 NPT	8.0	7.9	63	14.11	3.5*	10	1.01
1/2"	14	S12119EN14 NPT	12.0	11.9	83	19.96	5	11	1.33
1"	11.5	S16159EN11.5 NPT	16.0	15.9	92	26.51	5	12	1.64
2 1/2"	8	S16159EN8 NPT	16.0	15.9	92	38.10	5	12	2.42

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面

* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.



NPTF美制干密封锥管螺纹铣刀 NPTF

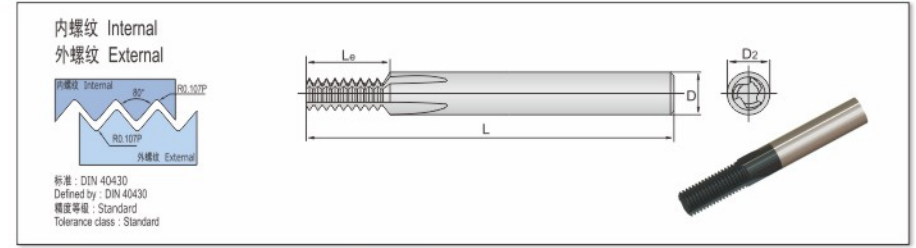


标准直槽内外刀 Standard Straight Flutes-External and Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	内外共用刀 External+Internal	D	D ₂	L	Le	Z	Z _t	mm
1/16"	27	S06059EN27 NPTF	6.0	5.9	57	9.41	3	10	0.64
1/4"	18	S08079EN18 NPTF	8.0	7.9	63	14.11	3.5*	10	1.00
1/2"	14	S12119EN14 NPTF	12.0	11.9	83	19.96	5	11	1.35
1"	11.5	S16159EN11.5 NPTF	16.0	15.9	92	26.51	5	12	1.63
2 1/2"	8	S16159EN8 NPTF	16.0	15.9	92	38.10	5	12	2.38

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面
* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.

螺纹 Pg



标准直槽内外刀 Standard Straight Flutes-External and Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸 Dimensions (mm)				槽数 No.of Flutes	齿数 Teeth	齿高 h
最小直径 Min Dia.	TPI	内外共用刀 External+Internal	D	D ₂	L	Le	Z	Z _t	mm
Pg7	20	S08079EN20 PG	8	7.9	63	19.05	3.5*	15	0.61
Pg9, 11, 13.5, 16	18	S10099EN18 PG	10	9.9	72	23.99	5	17	0.67
Pg21, 29, 36, 42, 48	16	S12119EN16 PG	12	11.9	83	28.58	5	18	0.76

* 表示可以订购3或者5个槽, 订货时把3或者5加在订货号后面
* Available with 3 and 5 flutes, Add 3 or 5 to the order NO.







石油管螺纹刀具 Threading Tools for Oil Pipes



石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

石油管螺纹刀片型号说明 Threading Insert for oil pipe Ordering Code system

L 40 V E R 8 RD 1-2
1 2 3 4 5 6 7 8 9 10

1、刀片形状及适用机床 Insert style or used for machine tools		2、刀片尺寸 (mm) Insert size	
 L、长条形 prism			
 S、方形 square and rectangle		 B、蝶形 butterfly	
 T、三角形 triangle		 R、平行四边形 parallelogram	
P、适用于PMC (美) 机床 Used for PMC machine tools (USA) C、适用于Colinet (比利时) 机床 Used for Colinet machine tool (Belgium)			

3 V—立装刀片 V—Style 不标注为其它形状刀片 Nothing means others	4 E—外螺纹 External N—内螺纹 Internal	5 R—右旋螺纹 Right hand L—左旋螺纹 Left hand	6 4—每寸4牙 4 TPI 5—每寸5牙 5 TPI 6—每寸6牙 6 TPI 8—每寸8牙 8 TPI 10—每寸10牙 10 TPI
7 RD—API圆螺纹 For API Round BU—API偏梯扣 For API Buttress G—管线管螺纹 For API Line Type	8 刀片切削刃数 Edges of the Insert	9 每切削刃上的齿数 Teeth of the edge	10 对多刀片配合使用的用 1、2、3代表刀号 Sequence NO. of the Insert

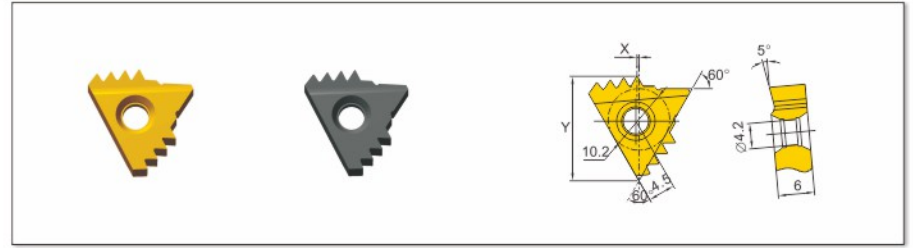


石油管线管外螺纹刀片 External API Line Type Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
B17ER8G2-3	8	1:16	0.32	17.6

石油管线管外螺纹刀片 External API Line Type Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
B17ER11.5G2-4	11.5	1:16	0.32	17.3

石油管线管内螺纹刀片 Internal API Line Type Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
B17NR8G2-3	8	1:16	0.32	17.6

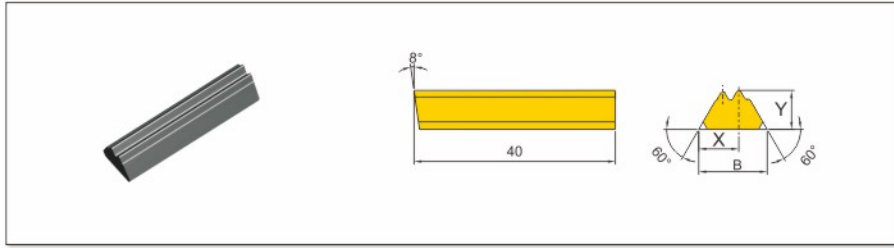
石油管线管内螺纹刀片 Internal API Line Type Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
B17NR11.5G2-4	11.5	1:16	0.32	17.3

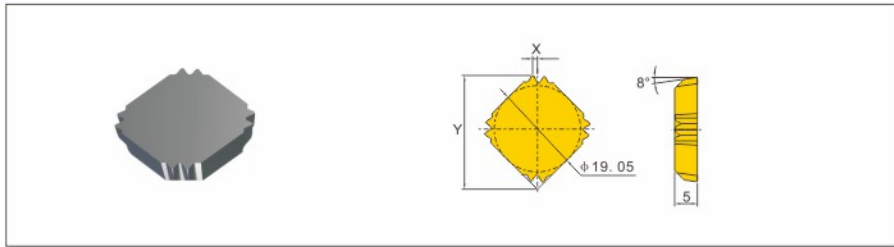


长条形油、套管外螺纹刀片 External API Round Inserts



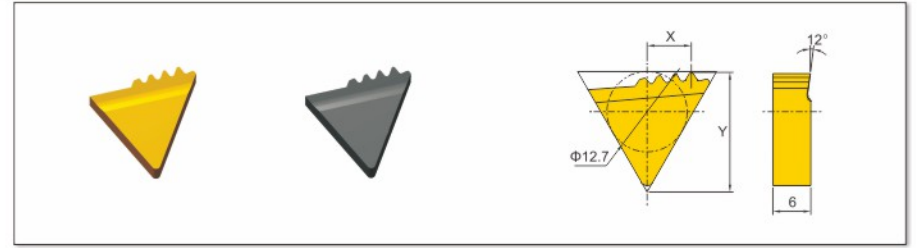
订货号	螺距	螺纹锥度	牙形位置		
Order No.	TPI	Thread Taper	B	X	Y
L40VER10RD1-2	10	1:16	12.8	9.82	7.76
L40VER8RD1-2	8	1:16	13.6	10.78	7.76

四边形油、套管内螺纹刀片 Internal API Round Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
S19NR10RD4-2	10	1:16	1.06	25.20
S19NR8RD4-2	8	1:16	1.30	25.00

三角形油、套管外螺纹刀片 External API Round Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
T22ER10RD1-4	10	1:16	7.0	18.9

三角形油、套管外螺纹刀片 External API Round Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
T22ER8RD1-4	8	1:16	5.2	18.9



蝶形油、套管外螺纹刀片 External API Round Inserts



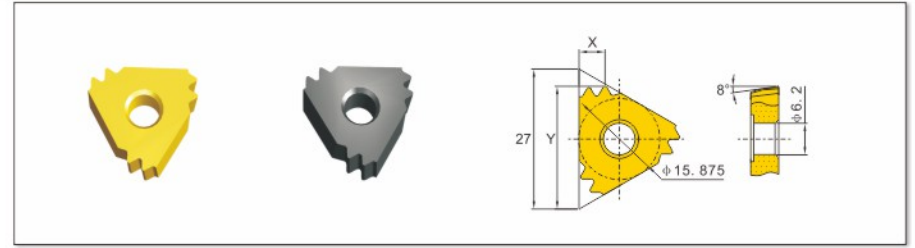
订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
B17ER10RD2-4	10	1:16	0.18	17.10
B17ER8RD2-3	8	1:16	0.32	17.10

蝶形油、套管内螺纹刀片 Internal API Round Inserts



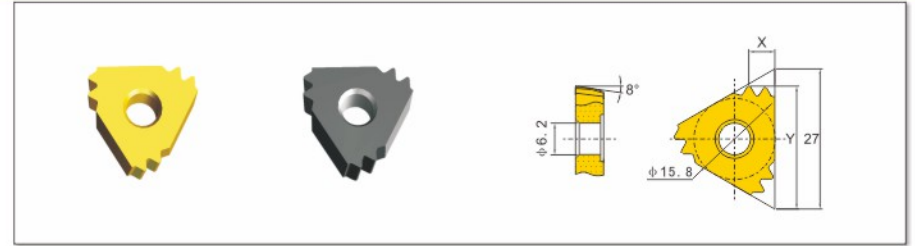
订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
B17NR10RD2-4	10	1:16	0.18	17.10
B17NR8RD2-3	8	1:16	0.32	17.10
B23NR8RD2-5	8	1:16	3.50	21.90

石油套管三角形圆扣二齿外螺纹刀片 External API Round Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
T27ER8RD3-2	8	1:16	5.00	24.30
T27ER10RD3-2	10	1:16	4.70	24.50

石油套管三角形圆扣二齿内螺纹刀片 Internal API Round Inserts



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
T27ER8RD3-2	8	1:16	5.00	24.30
T27ER10RD3-2	10	1:16	4.70	24.50



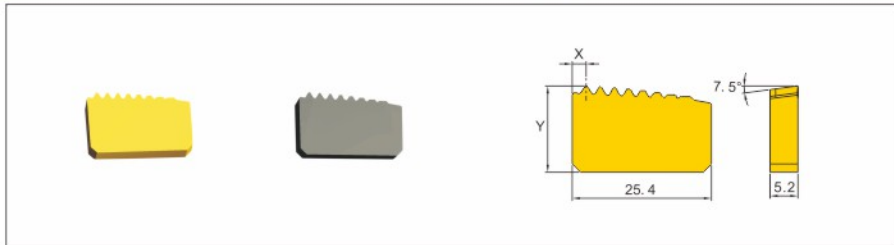
石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

PMC(美)车丝机用石油油、套管圆扣外螺纹刀片
External API Round Inserts for PMC Machine Tools(USA)



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
P16ER8RD1-31	8	1:16	7.73	14.70
P16ER8RD1-32	8	1:16	6.67	14.96
P16ER8RD1-33	8	1:16	5.61	15.04
P16ER10RD1-31	10	1:16	7.30	14.27
P16ER10RD1-32	10	1:16	6.46	14.55
P16ER10RD1-33	10	1:16	5.61	14.65

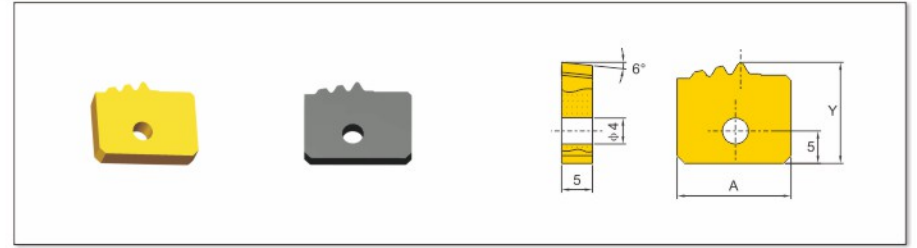
PMC(美)车丝机用石油油、套管圆扣内螺纹刀片
Internal API Round Inserts for PMC Machine Tools(USA)



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
P25NR8RD1-7	8	1:16	3.70	15.70
P25NR10RD1-8	10	1:16	3.70	15.40

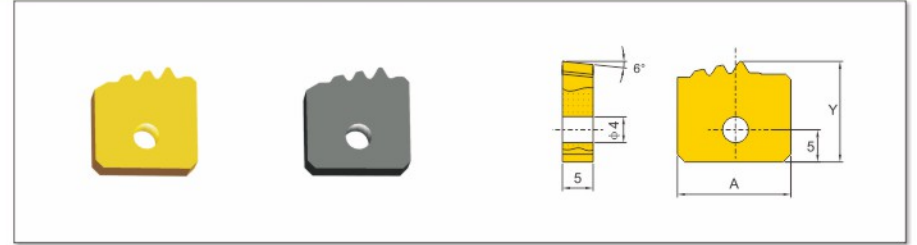
石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

比利时 (Colinet) 车丝机用石油油、套管圆扣外螺纹刀片
External API Round Inserts for Colinet Machine Tools



订货号	螺距	螺纹锥度	牙形位置		
Order No.	TPI	Thread Taper	A	X	Y
C20ER8RD1-31(12°)	8	1:16	20	10.20	15.63
C20ER8RD1-32(12°)	8	1:16	20	8.61	15.92
C16ER8RD1-31(15°)	8	1:16	16	6.00	15.40
C16ER8RD1-32(15°)	8	1:16	16	4.41	15.86
C16ER10RD1-31	10	1:16	16	5.67	15.16
C16ER10RD1-32	10	1:16	16	4.40	15.45

比利时 (Colinet) 车丝机用石油油、套管圆扣外螺纹刀片
External API Round Inserts for Colinet Machine Tools

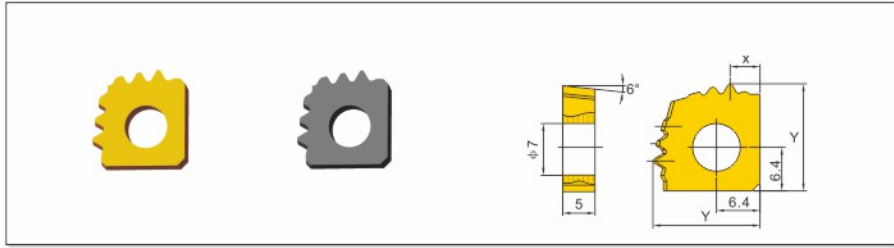


订货号	螺距	螺纹锥度	牙形位置		
Order No.	TPI	Thread Taper	A	X	Y
C16ER8RD1-3	8	1:16	16	4.40	15.86



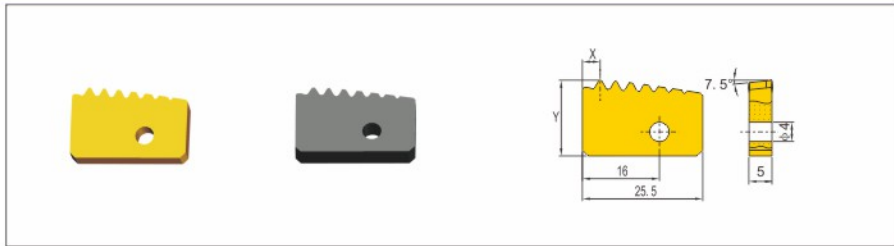
石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

比利时 (Colinet) 车丝机用石油油、套管圆扣外螺纹刀片
External API Round Inserts for Colinet Machine Tools



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
C16ER8RD2-3	8	1:16	4.40	15.74
C16ER10RD2-3	10	1:16	4.40	15.74

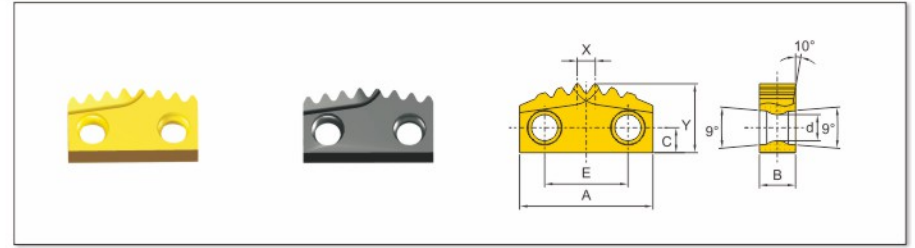
比利时 (Colinet) 车丝机用石油油、套管圆扣内螺纹刀片
Internal API Round Inserts for Colinet Machine Tools



订货号	螺距	螺纹锥度	牙形位置	
Order No.	TPI	Thread Taper	X	Y
C25NR8RD1-7	8	1:16	3.70	17.10
C25NR10RD1-8	10	1:16	3.70	16.80

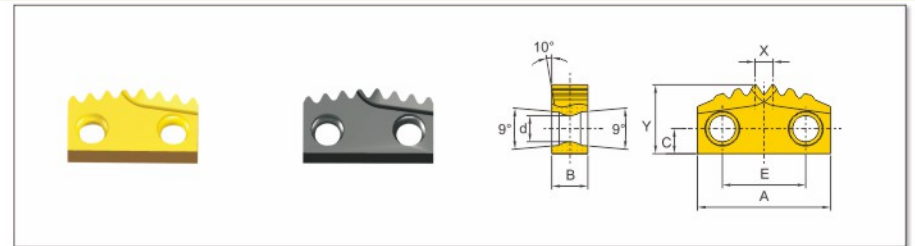
石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

双孔双刃平装石油管圆扣外螺纹刀片 External API Round Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	D	E	X	Y
S24ER10RD2-3	10	1:16	24	6.5	4.5	4.7	15	3.6	12.4
S24ER8RD2-3	8	1:16	24	6.5	4.5	4.7	15	3.3	12.4

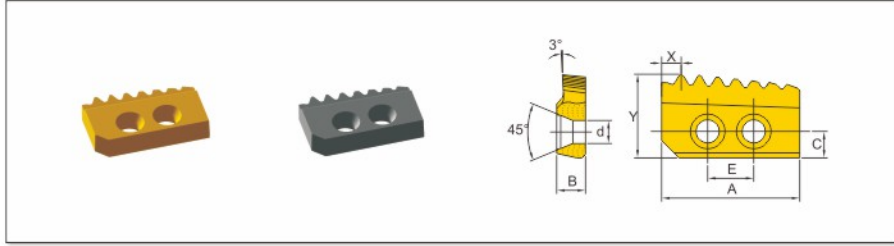
双孔双刃平装石油管圆扣内螺纹刀片 Internal API Round Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	D	E	X	Y
S24NR10RD2-4	10	1:16	24	6.5	4.5	4.7	15	3.6	12.4
S24NR8RD2-4	8	1:16	24	6.5	4.5	4.7	15	3.3	12.4

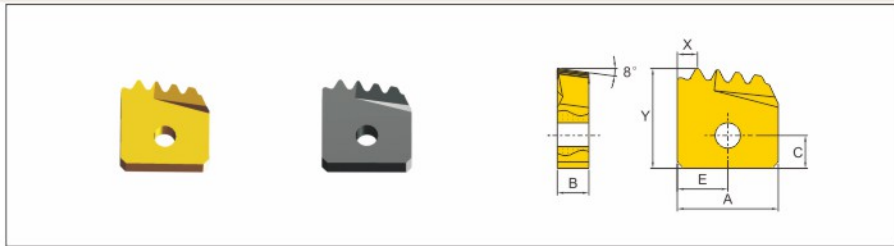


双孔单刃平装石油管圆扣内螺纹刀片 Internal API Round Inserts



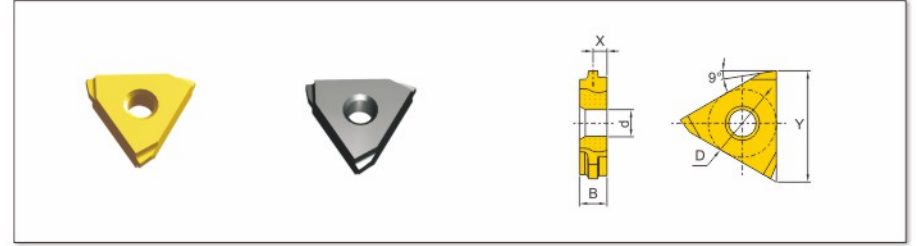
订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
S24NR10RD1-7	10	1:16	24	5	4.6	4	8	7.4	14.48
S24NR8RD1-7	8	1:16	24	5	4.6	4	8	3.4	14.53

平装单面刃石油管圆扣内螺纹刀片 Internal API Round Inserts



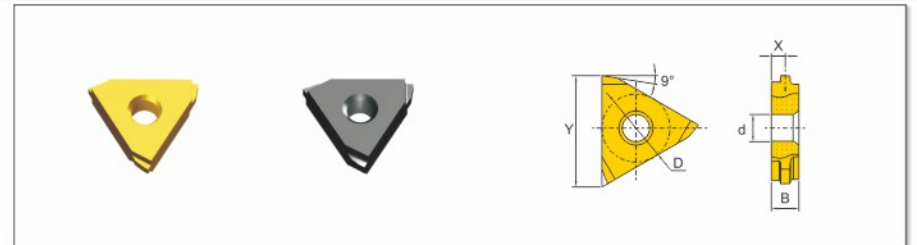
订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	D	E	X	Y
S16NR10RD1-4	10	1:16	16	5	5.2	4	8	3.2	15.8
S16NR8RD1-4	8	1:16	16	5	5.2	4	8	3.2	15.8

石油套管立装偏梯扣外螺纹刀片 External API Buttress Inserts(V Style)



订货号	螺距	螺纹锥度	牙形位置				
Order No.	TPI	Thread Taper	D	d	B	X	Y
T28VERSBU3-1	5	1:16	16	6.2	6.5	3.60	26.20

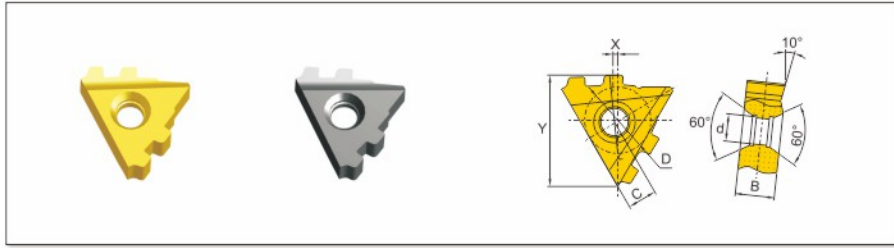
石油套管立装偏梯扣内螺纹刀片 Internal API Buttress Inserts(V Style)



订货号	螺距	螺纹锥度	牙形位置				
Order No.	TPI	Thread Taper	D	d	B	X	Y
T28VNR5BU3-1	5	1:16	16	6.2	6.5	3.60	26.20

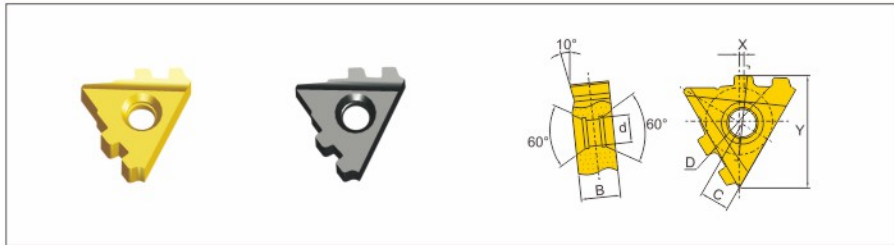


石油套管蝶形偏梯扣二齿外螺纹刀片 External API Buttress Inserts



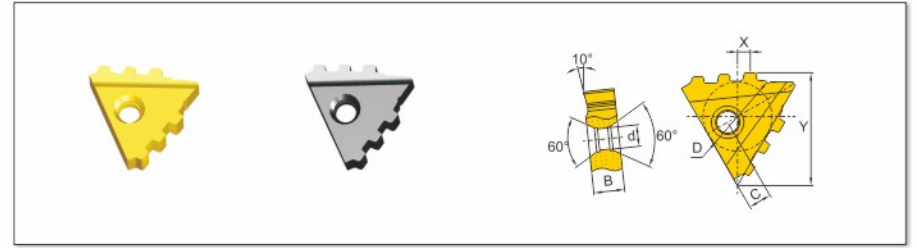
订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	D	d	C	B	X	Y	
B17ERSBU2-2	5	1:16	10.2	4.2	4.5	6	2.05	16.80	

石油套管蝶形偏梯扣二齿内螺纹刀片 Internal API Buttress Inserts



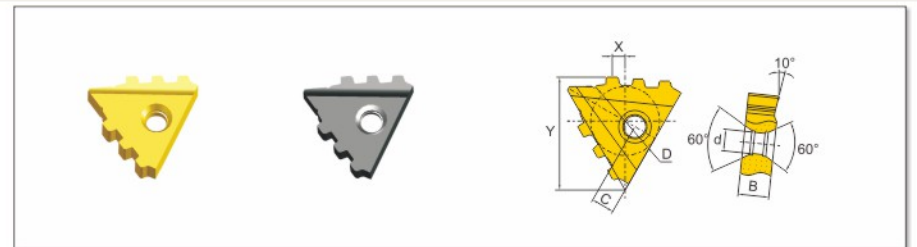
订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	D	d	C	B	X	Y	
B17NRSBU2-2	5	1:16	10.2	4.2	4.5	6	1.14	16.65	

石油套管蝶形偏梯扣三齿外螺纹刀片 External API Buttress Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	D	d	C	B	X	Y	
B23ERSBU2-3	5	1:16	13.4	4.2	4.5	6	2.46	21.90	
B23ERSBU2-3(1:12)	5	1:12	13.4	4.2	4.5	6	2.46	21.90	

石油套管蝶形偏梯扣三齿内螺纹刀片 Internal API Buttress Inserts

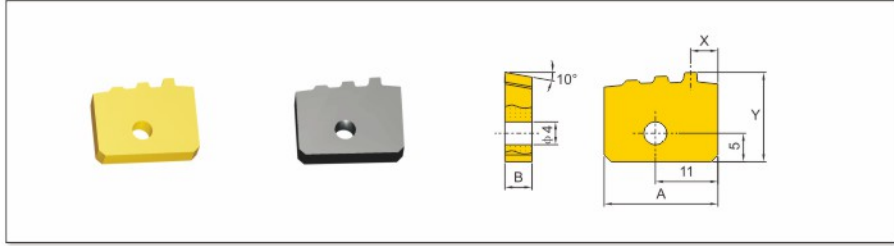


订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	D	d	C	B	X	Y	
B23NRSBU2-3	5	1:16	13.4	4.2	4.5	6	2.46	21.90	
B23NRSBU2-3(1:12)	5	1:12	13.4	4.2	4.5	6	2.46	21.90	



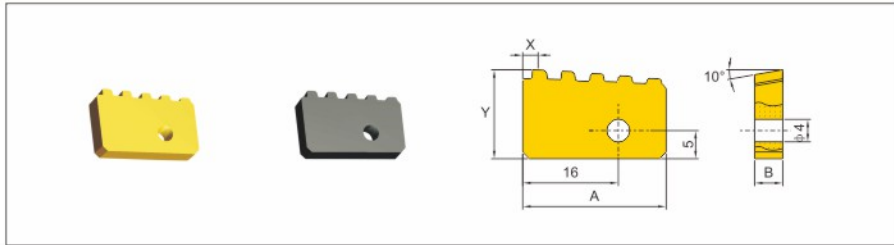
石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

比利时(Colinet)车丝机用石油套管偏梯扣外螺纹刀片
External Inserts API Buttress for Colinet Machine Tools



订货号	螺距	螺纹锥度	牙形位置			
Order No.	TPI	Thread Taper	A	B	X	Y
C20ERSBU1-31	5	1:16	20	5	4.84	15.67
C20ERSBU1-32	5	1:16	20	5	2.30	4.84

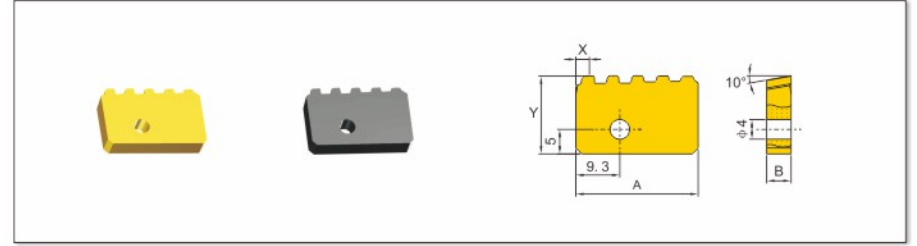
比利时(Colinet)车丝机用石油套管偏梯扣内螺纹刀片
Internal API Buttress Inserts for Colinet Machine Tools



订货号	螺距	螺纹锥度	牙形位置			
Order No.	TPI	Thread Taper	A	B	X	Y
C25NRSBU1-5	5	1:16	25.5	5	3.00	15.60

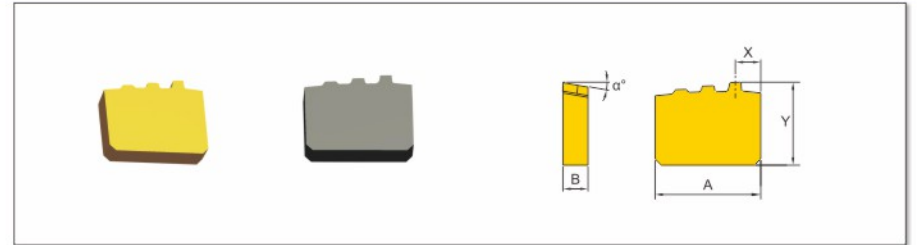
石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

比利时(Colinet)车丝机用石油套管偏梯扣内螺纹刀片 (反向车)
Internal Inserts of inverse thread cutting for Colinet Machine Tools



订货号	螺距	螺纹锥度	牙形位置			
Order No.	TPI	Thread Taper	A	B	X	Y
C25NRSBU1-5(B)	5	1:16	25.5	5	2.5	15.8

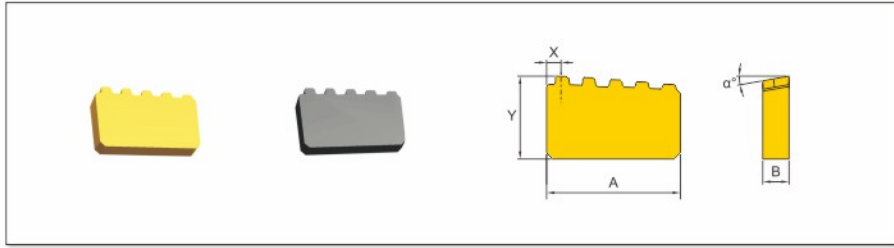
PMC车丝机用石油套管偏梯扣外螺纹刀片 External API Buttress Inserts for PMC Machine Tools



订货号	螺距	螺纹锥度	牙形位置			
Order No.	TPI	Thread Taper	A	B	X	Y
P16ERSBU1-31	5	1:16	16.9	5.2	4.29	14.60
P16ERSBU1-32	5	1:16	16.9	5.2	2.60	14.86
P16ERSBU1-33	5	1:16	16.9	5.2	0.91	15.00

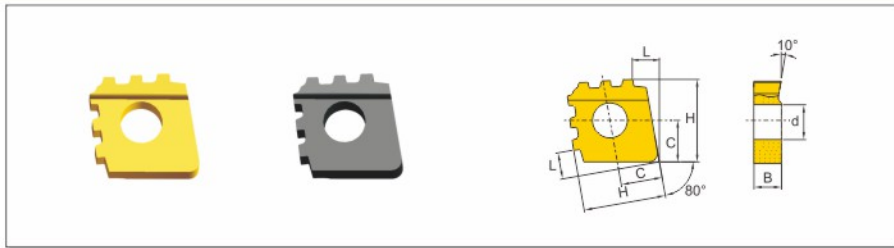


PMC车丝机用石油套管偏梯扣内螺纹刀片 Internal API Buttress Inserts for PMC Machine Tools



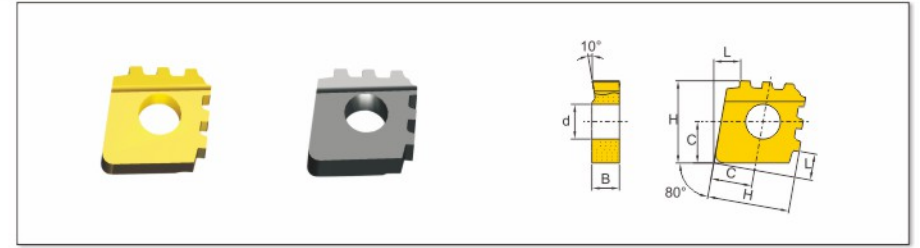
订货号	螺距	螺纹锥度	牙形位置			
Order No.	TPI	Thread Taper	A	B	X	Y
P25NRSBU1-5	5	1:16	25.4	5.2	4.29	14.60

石油管80° 棱形偏梯扣外螺纹刀片 External API Buttress Inserts



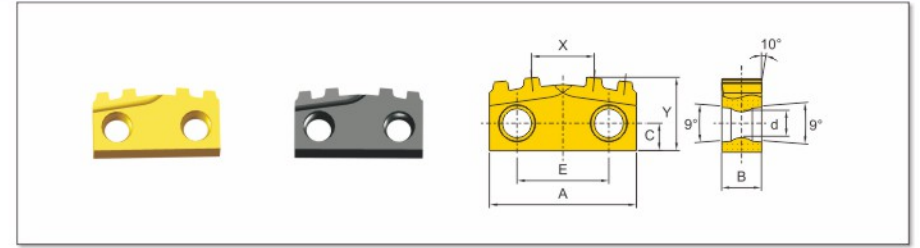
订货号	螺距	螺纹锥度	牙形位置				
Order No.	TPI	Thread Taper	B	C	d	H	L
R19ERSBU2-3	5	1:16	6.35	9.5	8	18.4	6.00

石油管80° 棱形偏梯扣内螺纹刀片 Internal API Buttress Inserts



订货号	螺距	螺纹锥度	牙形位置				
Order No.	TPI	Thread Taper	B	C	d	H	L
R19NRSBU2-3	5	1:16	6.35	9.5	8	18.4	6.00

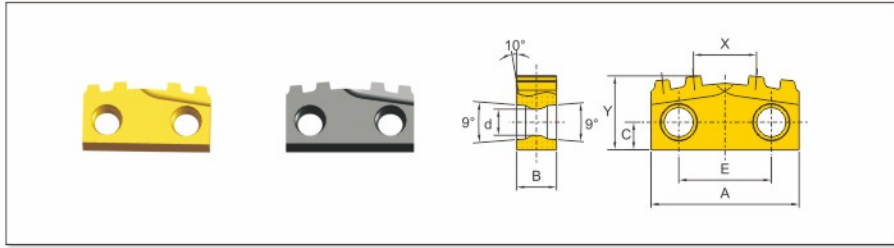
双孔双刃平装石油套管偏梯扣外螺纹刀片 External API Buttress Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
S24ERSBU2-2	5	1:16	24	6.5	4.5	4.7	15	10.3	12

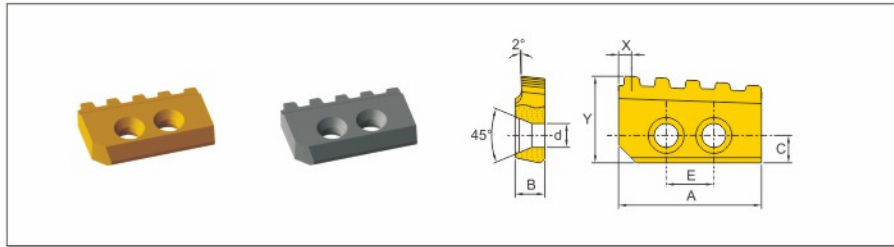


双孔单刃平装石油管偏梯扣内外螺纹刀片 Internal API Buttress Inserts



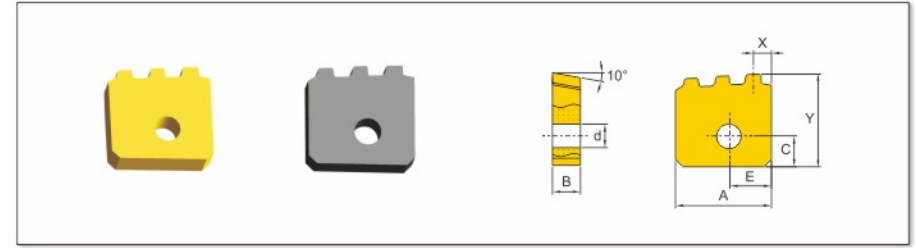
订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
S24NRSBU2-2	5	1:16	24	6.5	4.5	4.7	15	10.3	12

双孔单刃平装石油管偏梯扣内螺纹刀片 Internal API Buttress Inserts



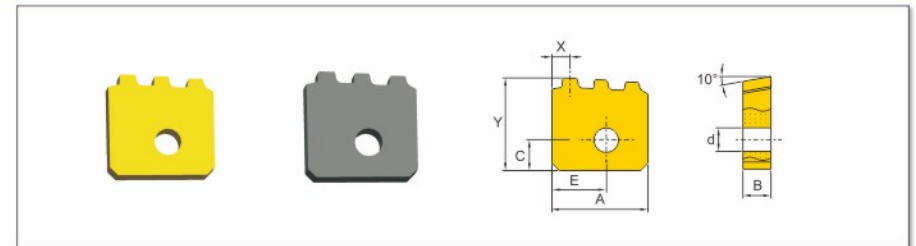
订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
S24NRSBU1-5	5	1:16	24	5	4.6	4	8	2.26	14.54

平装单面刃石油管偏梯扣外螺纹刀片 External API Buttress Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
S16ERSBU1-3	5	1:16	15.8	4.76	5	4	7	3	15.2

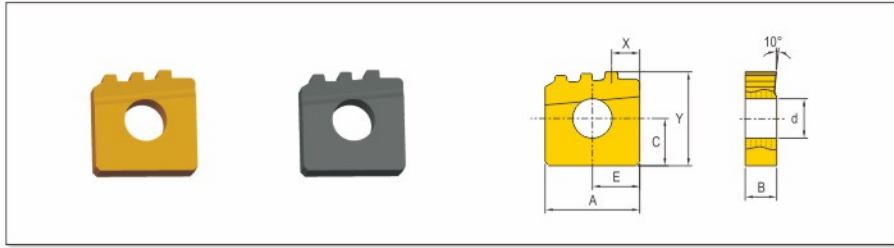
平装单面刃石油管偏梯扣内螺纹刀片 Internal API Buttress Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
S16NRSBU1-3	5	1:16	15.8	4.76	5	4	7	2.5	15.8

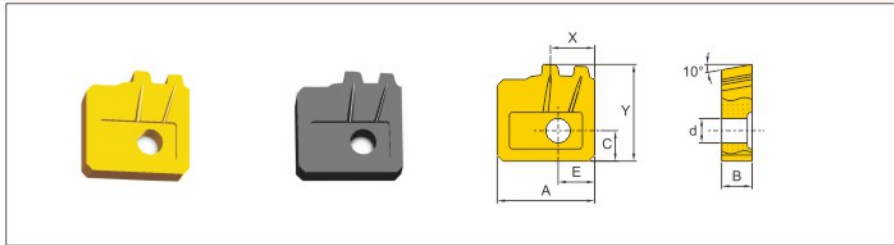


平装单面刃API偏梯口外螺纹刀片 External API Buttress Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
C19ERSBU1-3(1:12)	5	1:12	19	6.35	9.5	7.93	9.5	5.7	18.92

平装单面刃API管偏梯扣内螺纹刀片 Internal API Buttress Inserts



订货号	螺距	螺纹锥度	牙形位置						
Order No.	TPI	Thread Taper	A	B	C	d	E	X	Y
S16ERSBU1-2		1:56	15.8	5	5	4	7	3	15.2

石油钻杆(接头)螺纹刀片型号说明 Threading Inserts for Oil Drill Rods & Conectors Ordering Code System

22 E R V38R - 04 - 02 C

1 2 3 4 5 6 7

1、刀片尺寸 Insert size

- 29 — IC=17mm
- 27 — IC=15.875mm
- 22 — IC=12.7mm

2、刀片类型 Type of Insert

- E — 外螺纹刀片 External
- N — 内螺纹刀片 Internal

3、螺纹旋向 RH/LH Standard

- R — 右旋螺纹 Right hand
- L — 左旋螺纹 Left hand

4、螺纹牙型 Thread Standard

- V38R — V0.038R
- V40 — V0.040
- V50 — V0.050
- V55 — V0.055
- V65 — V0.065

5、螺距 Pitch

- 4 — 每寸4牙 4 TPI
- 5 — 每寸5牙 5 TPI
- 6 — 每寸6牙 6 TPI

6、螺纹锥度 Thread taper

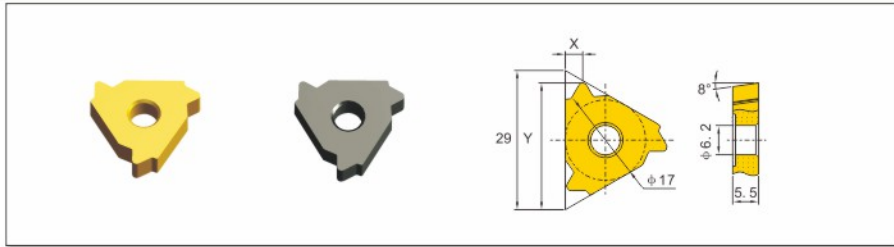
- 01 — 1:8
- 02 — 1:6
- 03 — 1:4

7、刀片类别 Insert Style

- A, B, C, D

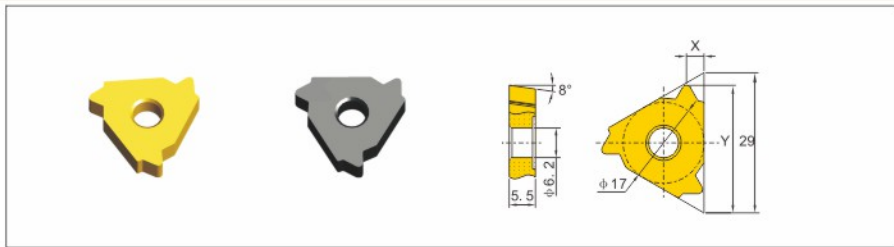


石油钻杆(接头)A型外螺纹刀片 A Style External Inserts



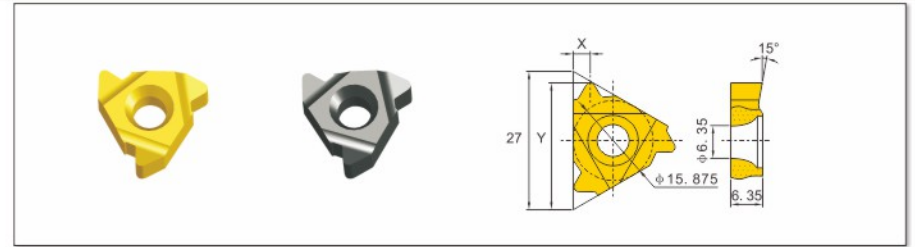
订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
29ERV38R-0402A	V-0.038R	4	1:6	3.80	26.60
29ERV38R-0403A	V-0.038R	4	1:4	3.80	26.60
29ERV40-0503A	V-0.040	5	1:4	3.10	26.80
29ERV50-0403A	V-0.050	4	1:4	3.80	26.95
29ERV50-0402A	V-0.050	4	1:6	3.80	26.95
29ERV55-0601A	V-0.055	6	1:8	3.70	26.50
29ERV65-0402A	V-0.065	4	1:6	3.80	26.30

石油钻杆(接头)A型内螺纹刀片 A Style Internal Inserts



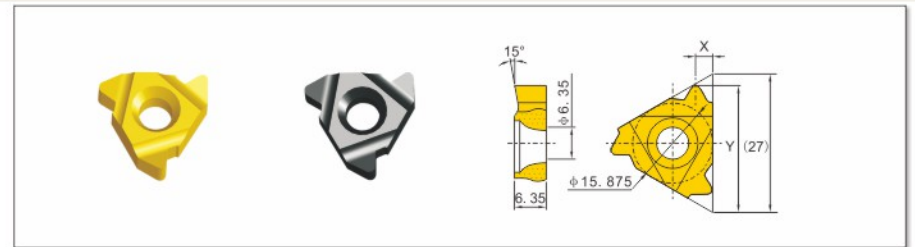
订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
29NRV38R-0402A	V-0.038R	4	1:6	3.80	26.60
29NRV38R-0403A	V-0.038R	4	1:4	3.80	26.60
29NRV40-0503A	V-0.040	5	1:4	3.10	26.80
29NRV50-0403A	V-0.050	4	1:4	3.80	26.95
29NRV50-0402A	V-0.050	4	1:6	3.80	26.95
29NRV55-0601A	V-0.055	6	1:8	3.70	26.50
29NRV65-0402A	V-0.065	4	1:6	3.80	26.30

石油钻杆(接头)B型外螺纹刀片 B Style External Inserts*



订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
27ERV38R-0402B	V-0.038R	4	1:6	2.80	25.15
27ERV38R-0403B	V-0.038R	4	1:4	2.80	25.15
27ERV40-0503B	V-0.040	5	1:4	2.80	25.35
27ERV50-0403B	V-0.050	4	1:4	3.00	25.50
27ERV50-0402B	V-0.050	4	1:6	3.00	25.50
27ERV55-0601B	V-0.055	6	1:8	2.80	25.00
27ERV65-0402B	V-0.065	4	1:6	3.00	24.80

石油钻杆(接头)B型内螺纹刀片 B Style Internal Inserts*

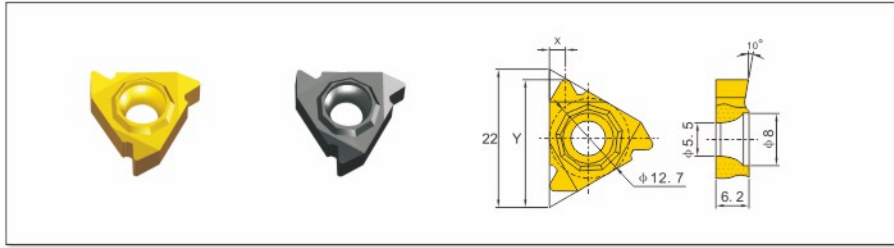


订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
27NRV38R-0402B	V-0.038R	4	1:6	2.80	25.15
27NRV38R-0403B	V-0.038R	4	1:4	2.80	25.15
27NRV40-0503B	V-0.040	5	1:4	2.80	25.35
27NRV50-0403B	V-0.050	4	1:4	3.00	25.50
27NRV50-0402B	V-0.050	4	1:6	3.00	25.50
27NRV55-0601B	V-0.055	6	1:8	2.80	25.00
27NRV65-0402B	V-0.065	4	1:6	3.00	24.80

*注：可装于Vardex刀杆上
can be fixe in the toolholders of Vardex

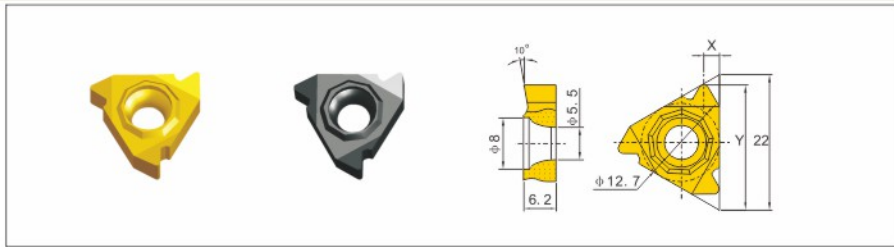


石油钻杆(接头)C型外螺纹刀片 C Style External Inserts*



订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
22ERV38R-0402C	V-0.038R	4	1:6	2.60	20.30
22ERV38R-0403C	V-0.038R	4	1:4	2.70	20.30
22ERV40-0503C	V-0.040	5	1:4	2.60	20.60
22ERV50-0403C	V-0.050	4	1:4	2.80	20.80
22ERV50-0402C	V-0.050	4	1:6	2.80	20.80
22ERV55-0601C	V-0.055	6	1:8	2.00	19.30
22ERV65-0402C	V-0.065	4	1:6	2.65	19.80

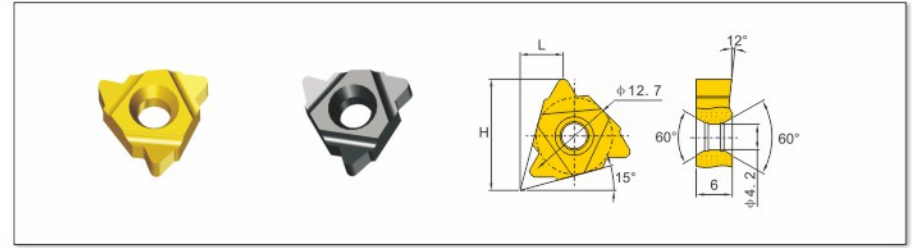
石油钻杆(接头)C型内螺纹刀片 C Style Internal Inserts*



订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
22NRV38R-0402C	V-0.038R	4	1:6	2.60	20.30
22NRV38R-0403C	V-0.038R	4	1:4	2.70	20.30
22NRV40-0503C	V-0.040	5	1:4	2.60	20.60
22NRV50-0403C	V-0.050	4	1:4	2.80	20.80
22NRV50-0402C	V-0.050	4	1:6	2.80	20.80
22NRV55-0601C	V-0.055	6	1:8	2.00	19.30
22NRV65-0402C	V-0.065	4	1:6	2.65	19.80

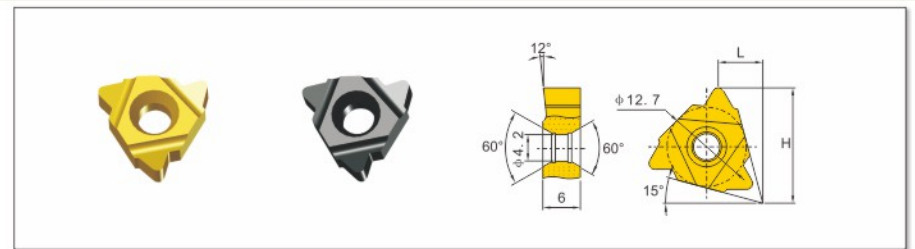
*注：可装于Sandvik Coromat刀杆上
can be fixed in the toolholders of Sandvik Coromat

石油钻杆(接头)D型外螺纹刀片 D Style External Inserts



订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
22ERV38R-0402D	V-0.038R	4	1:6	18.43	7.13
22ERV38R-0403D	V-0.038R	4	1:4	18.43	7.13
22ERV40-0503D	V-0.040	5	1:4	18.43	7.13
22ERV50-0403D	V-0.050	4	1:4	18.75	7.28
22ERV50-0402D	V-0.050	4	1:6	18.75	7.28
22ERV55-0601D	V-0.055	6	1:8	17.75	6.85
22ERV65-0402D	V-0.065	4	1:6	18.00	6.85

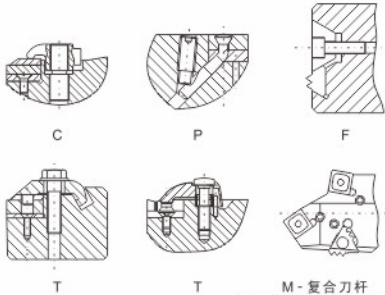
石油钻杆(接头)D型内螺纹刀片 D Style Internal Inserts



订货号	螺纹牙型	螺距	螺纹锥度	牙形位置	
Order No.	Thread Standard	TPI	Thread Taper	X	Y
22NRV38R-0402D	V-0.038R	4	1:6	18.43	7.13
22NRV38R-0403D	V-0.038R	4	1:4	18.43	7.13
22NRV40-0503D	V-0.040	5	1:4	18.43	7.13
22NRV50-0403D	V-0.050	4	1:4	18.75	7.28
22NRV50-0402D	V-0.050	4	1:6	18.75	7.28
22NRV55-0601D	V-0.055	6	1:8	17.75	6.85
22NRV65-0402D	V-0.065	4	1:6	18.00	6.85



1、螺纹刀片夹紧方式
Clamping system



M - 复合刀杆
Multifunction tool holders

7、刀片型式
Insert style

对复合刀杆多个刀片用“/”隔开。
Use “/” to mark different Inserts on a Multi-function tool holder.

9

特别注明项
无需注明省略
Remarks (if unnecessary can be omitted)

M N R 00 80 395 B17/S15/S15 A

1 2 3 4 5 6 7 8 9

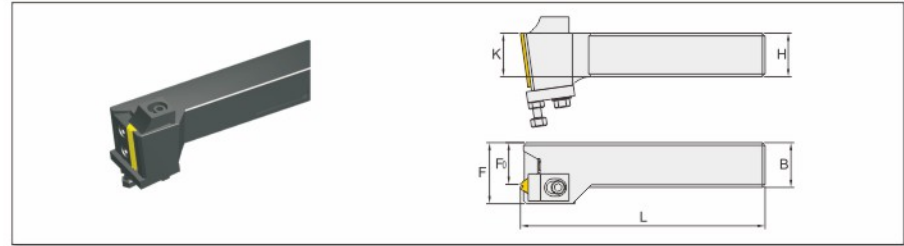
2
E - 外刀杆
External
N - 内螺纹
Internal

3
R - 右手刀
Right hand
L - 左手刀
Left hand

6
刀杆总长(mm)
Tool length
8、适用于加工
A1 - 2 3/8"
A2 - 2 7/8"
A3 - 3 1/2" - 4 1/2"

5
方柄刀杆为刀柄厚度 (mm)
The height of square shanks (mm)
圆柄刀杆为刀柄直径 (mm)
The Diameter of round shanks (mm)

4
00 - 内螺纹圆柄刀杆
00 - For round shank
方柄刀杆为刀具中心高 (mm)
Insert height for square shanks (mm)



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size							
		L	H	K	B	F	Fo	λ	
FER3232-175-L40A	L40VER10RD1-2	2 3/8" ~ 3 1/2"	175	32	32	36	43	30	70'
FER3232-175-L40B		4" ~ 5 1/2"	175	32	32	36	43	30	50'
FER3232-175-L40C		6 5/8" ~ 8 5/8"	175	32	32	36	43	30	30'
FER3232-175-L40D	L40VER8RD1-2	9 5/8" ~ 13 3/8"	175	32	32	36	43	30	15'

配件 Spare parts

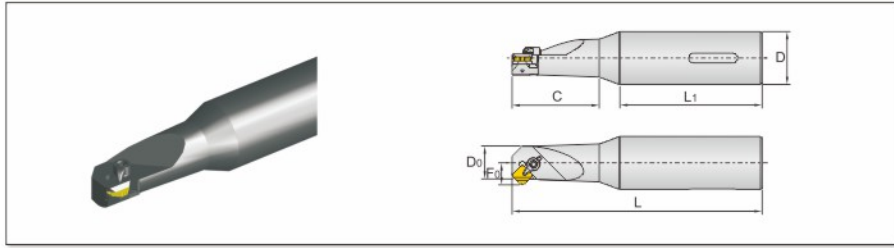


导屑板	模块	挡板
Chip breaker	Clamp	Stopper
SP10	SP08	SP11

*注：λ- 刀具螺旋升角
λ- helix angle



四边形内螺纹刀片用圆柄刀杆 Internal Round Shank for API Round



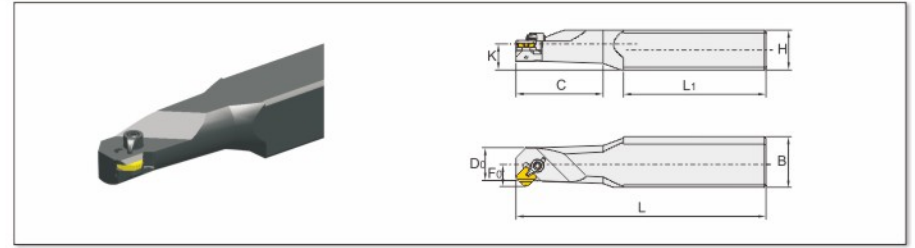
订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size								
			L	L1	D	C	D0	Fd	λ	
CNR0060-305-S19A	S19NR10RD4-2	2 3/8" ~ 3 1/2"	305	180	60	100	42	26	70'	
CNR0060-335-S19B	S19NR8RD4-2	4" ~ 5 1/2"	335	180	60	130	50	31	50'	
CNR0060-358-S19C	S19NR8RD4-2	6 5/8" ~ 8 5/8"	358	180	60	158	56	36	30'	
CNR0060-375-S19D		9 5/8" ~ 13 3/8"	375	180	60	175	60	43	15'	

配件 Spare parts



*注：λ- 刀具螺旋升角
λ- helix angle

四边形内螺纹刀片用方柄刀杆 Internal Square Shank for API Round



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size									
			L	L1	H	C	K	D0	B	Fd	λ
CNR2540-305-S19A	S19NR10RD4-2	2 3/8" ~ 3 1/2"	305	180	40	100	25	42	65.8	26	70'
CNR3248-305-S19A			305	180	48	100	32	42	74.3	26	70'
CNR3248-335-S19B	S19NR8RD4-2	4" ~ 5 1/2"	335	180	48	130	32	50	74.3	31	50'
CNR3655-335-S19B			335	180	55	130	36	50	77.2	31	50'
CNR3248-358-S19C	S19NR8RD4-2	6 5/8" ~ 8 5/8"	358	180	48	158	32	56	74.3	36	30'
CNR3655-358-S19C			358	180	55	158	36	56	77.2	36	30'
CNR3655-375-S19D			375	180	55	175	36	60	81.5	43	15'

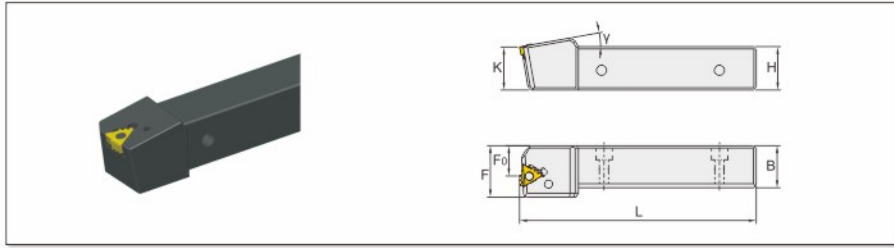
配件 Spare parts



*注：λ- 刀具螺旋升角
λ- helix angle



蝶形外螺纹刀片用刀杆 External Toolholders



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size								
			L	F	K	Y	B	Fo	A	H	
PER2525-175-B17A	B17ER10RD2-4 B17ER8RD2-3	2 3/8" ~ 3 1/2"	175	29	25	5*	25	21.5	70'	25	
PER3232-175-B17A			175	38	32	5*	32	26.5	70'	32	
PER3232-175-B17B		4" ~ 5 1/2"	175	38	32	5*	32	26.5	50'	32	
PER3232-175-B17C		6 5/8" ~ 8 5/8"	175	38	32	5*	32	26.5	30'	32	
PER3232-175-B17D	B17ER8RD2-3	9 5/8" ~ 13 3/8"	175	38	32	5*	32	26.5	15'	32	
PER4040-175-B17D			175	40	40	5*	40	26.5	15'	40	

配件 Spare parts

斜拉杆	顶丝	刀垫	扳手
Leaver	Screw	Shim	Wrench
L4-1	M6×18	BE17	S3

*注：λ- 刀具螺旋升角
λ- helix angle

蝶形外螺纹刀片用刀杆(续) External Toolholders(con't)

订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size								
			L	F	K	Y	B	Fo	A	H	
PER3232-175-B17B(10°)	B17ER5BU2-2	4 1/2" ~ 6 5/8"	175	38	32	10*	32	25	60'	32	
PER3232-175-B17C(10°)		7" ~ 11 1/2"	175	38	32	10*	32	25	40'	32	
PER3232-175-B17D(10°)		13 3/8" ~ 20"	175	38	32	10*	32	25	20'	32	
PER4040-175-B17D(10°)			175	40	40	10*	40	25	20'	40	

配件 Spare parts

斜拉杆	顶丝	刀垫	扳手
Leaver	Screw	Shim	Wrench
L4-1	M6×18	BE17	S3

*注：λ- 刀具螺旋升角
λ- helix angle

订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size								
			L	F	K	Y	B	Fo	A	H	
PER3240-175-B23B(10°)	B23ER5BU2-3	4 1/2" ~ 6 5/8"	175	38	32	10*	32	25	60'	32	
PER3240-175-B23C(10°)		7" ~ 11 1/2"	175	38	32	10*	32	25	40'	32	
PER3240-175-B23D(10°)		13 3/8" ~ 20"	175	38	32	10*	32	25	20'	32	
PER4040-175-B23D(10°)			175	40	40	10*	40	25	20'	40	

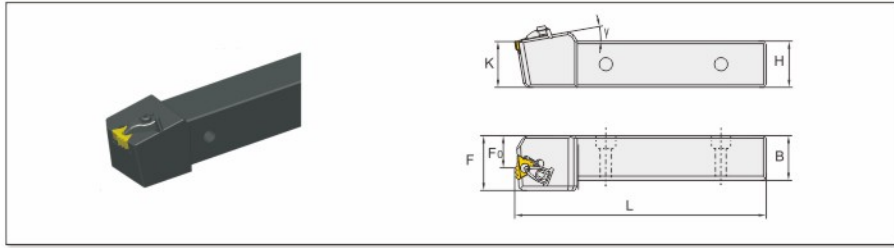
配件 Spare parts

斜拉杆	顶丝	刀垫	扳手
Leaver	Screw	Shim	Wrench
L4-1	M6×18	BE23	S3

*注：λ- 刀具螺旋升角
λ- helix angle



蝶形外螺纹刀片用刀杆 External Toolholders



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size								
			L	F	K	Y	B	Fo	A	H	
TER2525-175-B17A	B17ER10RD2-4 B17ER8RD2-3	2 3/8" ~ 3 1/2"	175	29	25	5°	25	21.5	70'	25	
TER3232-175-B17A			175	38	32	5°	32	26.5	70'	32	
TER3232-175-B17B	B17ER8RD2-3	4" ~ 5 1/2"	175	38	32	5°	32	26.5	50'	32	
TER3232-175-B17C			175	38	32	5°	32	26.5	30'	32	
TER3232-175-B17D	B17ER8RD2-3	9 5/8" ~ 13 3/8"	175	38	32	5°	32	26.5	15'	32	
TER4040-175-B17D			175	40	40	5°	40	26.5	15'	40	

配件 Spare parts



*注：λ- 刀具螺旋升角
λ- helix angle

蝶形外螺纹刀片用刀杆(续) External Toolholders(con't)

订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size								
			L	F	K	Y	B	Fo	A	H	
TER3232-175-B17B(10°)	B17ERSBU2-2	4 1/2" ~ 6 5/8"	175	38	32	10°	32	25	60'	32	
TER3232-175-B17C(10°)		7" ~ 11 1/2"	175	38	32	10°	32	25	40'	32	
TER3232-175-B17D(10°)		13 3/8" ~ 20"	175	38	32	10°	32	25	20'	32	
TER4040-175-B17D(10°)			175	40	40	10°	40	25	20'	40	

配件 Spare parts



*注：λ- 刀具螺旋升角
λ- helix angle

订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size								
			L	F	K	Y	B	Fo	A	H	
TER3240-175-B23B(10°)	B23ERSBU2-3	4 1/2" ~ 6 5/8"	175	38	32	10°	32	25	60'	32	
TER3240-175-B23C(10°)		7" ~ 11 1/2"	175	38	32	10°	32	25	40'	32	
TER3240-175-B23D(10°)		13 3/8" ~ 20"	175	38	32	10°	32	25	20'	32	
TER4040-175-B23D(10°)			175	40	40	10°	40	25	20'	40	

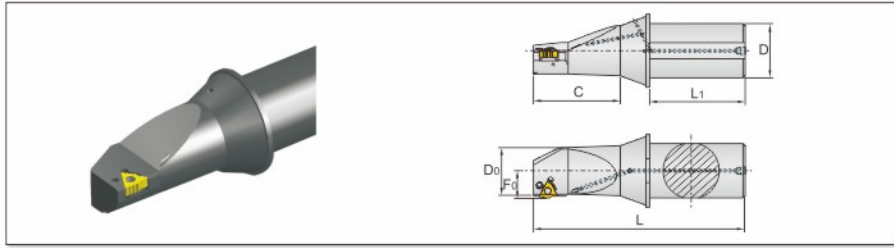
配件 Spare parts



*注：λ- 刀具螺旋升角
λ- helix angle




蝶形圆柄内螺纹刀片用刀杆 Internal Toolholders



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size							
			L	L1	D	C	Do	F0	λ
PNR0040-205-B17A	B17NR5BU2-2	2 3/8" ~ 3 1/2"	205	80	40	100	42	26	70°
PNR0050-220-B17A			220	90	50	105	42	26	70°
PNR0060-225-B17A			225	100	60	100	42	26	70°
PNR0080-280-B17A			280	150	80	105	42	26	70°
PNR0040-235-B17B	B17NR10RD2-4	4" ~ 5 1/2"	235	80	40	130	50	31	50°
PNR0050-273-B17B			273	90	50	158	56	36	50°
PNR0060-273-B17B			273	90	60	158	56	36	50°
PNR0080-300-B17B			300	140	80	158	56	36	50°
PNR0060-278-B17C	B17NR8RD2-3	6 5/8" ~ 8 5/8"	278	100	60	158	56	36	30°
PNR0080-318-B17C			318	140	80	158	56	36	30°
PNR0060-295-B17D			295	100	60	175	60	43	15°
PNR0080-335-B17D			335	140	80	175	60	43	15°

配件 Spare parts




斜拉杆	顶丝	刀垫	扳手
Leaver	Screw	Shim	Wrench
L4-1	M6×18	BN17	S3

*注：λ- 刀具螺旋升角
λ- helix angle

蝶形圆柄内螺纹刀片用刀杆 (续) Internal Toolholders (con't)

订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size							
			L	L1	D	C	Do	F0	λ
PNR0050-273-B23B	B23NR5BU2-3	4" ~ 5 1/2"	273	90	50	158	56	36	50°
PNR0060-255-B23B			255	90	60	158	56	36	50°
PNR0080-300-B23B			300	140	80	158	56	36	50°
PNR0060-278-B23C	B23NR8RD2-5	6 5/8" ~ 8 5/8"	278	100	60	158	56	36	30°
PNR0080-318-B23C			318	140	80	158	56	36	30°
PNR0060-295-B23D			295	100	60	175	60	43	15°
PNR0080-335-B23D			335	140	80	175	60	43	15°

配件 Spare parts

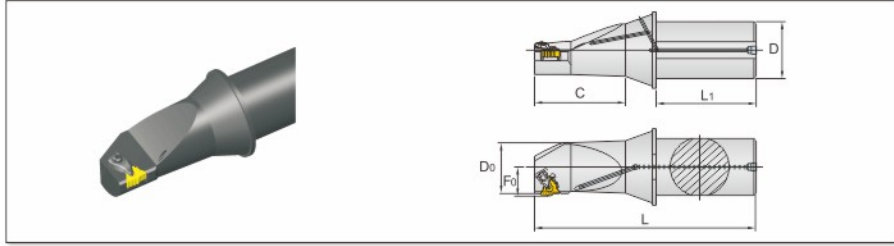


斜拉杆	顶丝	刀垫	扳手
Leaver	Screw	Shim	Wrench
L4-1	M6×18	BN23	S3

*注：λ- 刀具螺旋升角
λ- helix angle



蝶形圆柄内螺纹刀片用刀杆 Internal Toolholders



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size							
			L	L1	D	C	D0	F0	λ
TNR0040-205-B17A	B17NR5BU2-2	2 3/8" ~ 3 1/2"	205	80	40	100	42	26	70°
TNR0050-220-B17A			220	90	50	105	42	26	70°
TNR0060-225-B17A			225	100	60	100	42	26	70°
TNR0080-280-B17A	B17NR10RD2-4	4" ~ 5 1/2"	280	150	80	105	42	26	70°
TNR0040-235-B17B			235	80	40	130	50	31	50°
TNR0050-273-B17B			273	90	50	158	56	36	50°
TNR0060-273-B17B	B17NR8RD2-3	4" ~ 5 1/2"	273	90	60	158	56	36	50°
TNR0080-300-B17B			300	140	80	158	56	36	50°
TNR0060-278-B17C			278	100	60	158	56	36	30°
TNR0080-318-B17C	B17NR8RD2-3	6 5/8" ~ 8 5/8"	318	140	80	158	56	36	30°
TNR0060-295-B17D			295	100	60	175	60	43	15°
TNR0080-335-B17D			335	140	80	175	60	43	15°

配件 Spare parts

压板	螺钉	弹簧	刀垫	刀垫螺钉	弹性销	扳手
Clamp	Screw	Spring	Shim	Shim screw	Pin	Wrench
CL2	M521	φ7×11	TN17	M4×8	φ2×10	S3

*注：λ- 刀具螺旋升角

λ- helix angle

蝶形圆柄内螺纹刀片用刀杆 (续) Internal Toolholders (con't)

订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size							
			L	L1	D	C	D0	F0	λ
TNR0050-273-B23B	B23NR5BU2-3	4" ~ 5 1/2"	273	90	50	158	56	36	50°
TNR0060-255-B23B			255	90	60	158	56	36	50°
TNR0080-300-B23B			300	140	80	158	56	36	50°
TNR0060-278-B23C	B23NR8RD2-5	6 5/8" ~ 8 5/8"	278	100	60	158	56	36	30°
TNR0080-318-B23C			318	140	80	158	56	36	30°
TNR0060-295-B23D			295	100	60	175	60	43	15°
TNR0080-335-B23D		9 5/8" ~ 13 3/8"	335	140	80	175	60	43	15°

配件 Spare parts

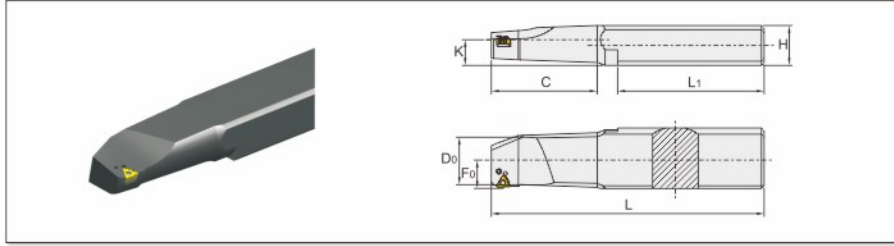
压板	螺钉	弹簧	刀垫	刀垫螺钉	弹性销	扳手
Clamp	Screw	Spring	Shim	Shim screw	Pin	Wrench
CL2	M521	φ7×11	TN23	M4×8	φ2×10	S3

*注：λ- 刀具螺旋升角

λ- helix angle



蝶形方柄内螺纹刀片用刀杆 Internal Toolholders



订货号Order No.	配用刀片Inserts	加工范围Pipe size										
			L	L1	H	C	K	D0	B	F0	λ	
PNR2538-285-B17A	B17NR10RD2-4	2 3/8" ~ 3 1/2"	285	160	38	105	25	42	62	26	70°	
PNR3249-285-B17A			285	160	49	105	32	42	62	26	70°	
PNR3249-335-B17B	B17NR8RD2-3	4" ~ 5 1/2"	335	180	49	130	32	50	74.3	31	50°	
PNR3655-335-B17B			335	180	55	130	36	50	77.2	31	50°	
PNR3249-363-B17C	B23NR8RD2-5	6 5/8" ~ 8 5/8"	363	180	49	158	32	56	74.3	36	30°	
PNR3655-378-B17C			378	200	55	163	36	71	82	36	30°	
PNR3249-400-B17D	B17NRSBU2-2	9 5/8" ~ 13 3/8"	400	280	49	158	32	56	74.3	52	30°	
PNR4055-400-B17D			400	200	55	163	40	71	82	52	15°	

配件 Spare parts

斜拉杆	顶丝	刀垫	扳手
Leaver	Screw	Shim	Wrench
L4-1	M6×18	BN17	S3

*注：λ- 刀具螺旋升角
λ- helix angle

蝶形方柄内螺纹刀片用刀杆(续) Internal Toolholders (con' t)

订货号Order No.	配用刀片Inserts	加工范围Pipe size										
			L	L1	H	C	K	D0	B	F0	λ	
PNR3249-335-B23B	B23NRSBU2-3	4" ~ 5 1/2"	335	180	49	130	32	50	74.3	31	50°	
PNR3655-335-B23B			335	180	55	130	36	50	77.2	31	50°	
PNR3249-363-B23C	B23NR8RD2-5	6 5/8" ~ 8 5/8"	363	180	49	158	32	56	74.3	36	30°	
PNR3655-378-B23C			378	200	55	163	36	71	82	36	30°	
PNR3249-400-B23D	B23NR8RD2-5	9 5/8" ~ 13 3/8"	400	280	49	158	32	56	74.3	52	30°	
PNR4055-400-B23D			400	200	55	163	40	71	82	52	15°	

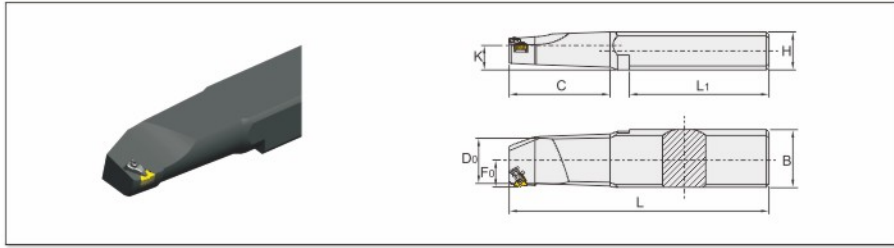
配件 Spare parts

斜拉杆	顶丝	刀垫	扳手
Leaver	Screw	Shim	Wrench
L4-1	M6×18	BN23	S3

*注：λ- 刀具螺旋升角
λ- helix angle



蝶形方柄内螺纹刀片用刀杆 Internal Toolholders



订货号Order No.	配用刀片Inserts	加工范围Pipe size	L	L1	H	C	K	D0	B	F0	λ
TNR2538-285-B17A	B17NR10RD2-4	2 3/8" ~ 3 1/2"	285	160	38	105	25	42	62	26	70°
TNR3249-285-B17A			285	160	49	105	32	42	62	26	70°
TNR3249-335-B17B		4" ~ 5 1/2"	335	180	49	130	32	50	74.3	31	50°
TNR3655-335-B17B	335		180	55	130	36	50	77.2	31	50°	
TNR3249-363-B17C	B17NR8RD2-3	6 5/8" ~ 8 5/8"	363	180	49	158	32	56	74.3	36	30°
TNR3655-378-B17C			378	200	55	163	36	71	82	36	30°
TNR3249-400-B17D	B17NR5BU2-2	9 5/8" ~ 13 3/8"	400	280	49	158	32	56	74.3	52	30°
TNR4055-400-B17D			400	200	55	163	40	71	82	52	15°

配件 Spare parts

压板	螺钉	弹簧	刀垫	刀垫螺钉	弹性销	扳手
Clamp	Screw	Spring	Shim	Shim screw	Pin	Wrench
CL2	M521	φ7×11	TN17	M4×8	φ2×10	S3

*注: λ - 刀具螺旋升角
λ - helix angle

蝶形方柄内螺纹刀片用刀杆(续) Internal Toolholders(con't)

订货号Order No.	配用刀片Inserts	加工范围Pipe size	L	L1	H	C	K	D0	B	F0	λ
			TNR3249-335-B23B	B23NR5BU2-3	4" ~ 5 1/2"	335	180	49	130	32	50
TNR3655-335-B23B	335	180	55			130	36	50	77.2	31	50°
TNR3249-363-B23C	B23NR8RD2-5	6 5/8" ~ 8 5/8"	363	180	49	158	32	56	74.3	36	30°
TNR3655-378-B23C			378	200	55	163	36	71	82	36	30°
TNR3249-400-B23D			400	280	49	158	32	56	74.3	52	30°
TNR4055-400-B23D			400	200	55	163	40	71	82	52	15°

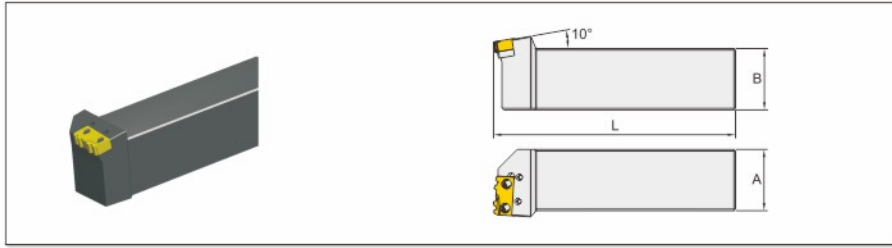
配件 Spare parts

压板	螺钉	弹簧	刀垫	刀垫螺钉	弹性销	扳手
Clamp	Screw	Spring	Shim	Shim screw	Pin	Wrench
CL2	M521	φ7×11	TN23	M4×8	φ2×10	S3

*注: λ - 刀具螺旋升角
λ - helix angle

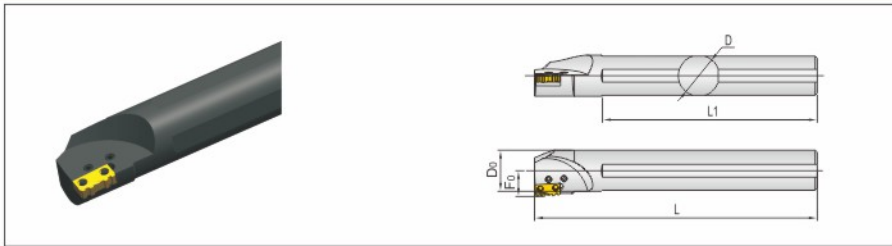


双孔刀片外螺纹刀杆 External Toolholders



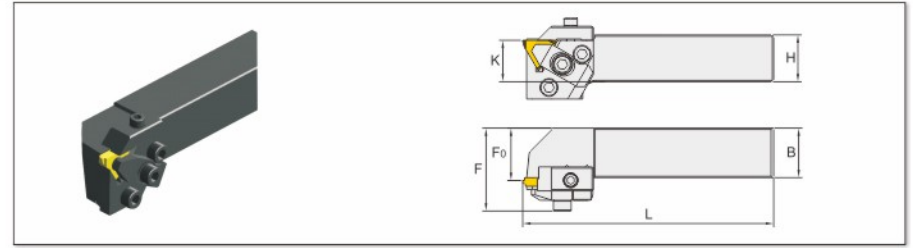
订货号 Order No.	配用刀片 Inserts	A	B	L	刀垫 Shim	杠杆×2 Leaver×2	弹簧卡×2 Shim Pin×2	杠杆螺钉×2 Screw×2	扳手 Wrench
PER3232-148-S24	S24ERSBU2-2	32	32	148	SH14×4	PL3A	SP10	LEM6×17	S2.5
PER3838-148-S24	S24ER8BU2-3 S24ER10BU2-3	38	38	148					

双孔刀片内螺纹刀杆 Internal Toolholders



订货号 Order No.	配用刀片 Insert	尺寸 Dimensions					刀垫 Shim	杠杆×2 Leaver×2	弹簧卡×2 Shim Pin×2	杠杆螺钉×2 Screw×2	扳手 Wrench
		L1	L	D	Do	Fo					
PNR0040-275-S24A	S24NRSBU2-2	275	208	40	4	25	SF24×4	PL3A	SP10	LEM6×17	S2.5

立装偏梯形外螺纹刀片用刀杆 External Toolholders for V Style API Buttress Insert



订货号Order No.	配用刀片Inserts	加工范围Pipe size	L	H	K	B	F	Fo	λ
TVER3235-175-T28B	T28VERSBU3-1	4 1/2" ~ 5 1/2"	175	35	32	35	56	40	60°
TVER3235-175-T28C		7" ~ 11 1/2"	175	35	32	35	56	40	40°
TVER3235-175-T28D		13 3/8" ~ 20"	175	35	32	35	56	40	20°

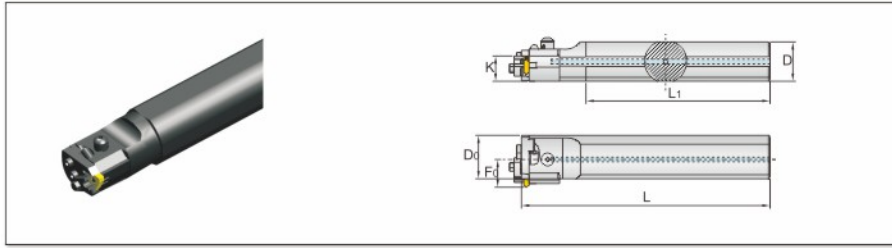
配件 Spare parts

压板 Clamp	导屑板 Chip breaker	镶块 Adapter
SP31	SP29	SP30

*注: λ - 刀具螺旋升角
λ - helix angle



立装偏梯形内螺纹刀片用圆柄刀杆 Internal Toolholders for V Style API Buttress Insert



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	L	L1	D	D0	F0	A	
TVNR0050-250-T28B	T28VNRSBU3-1	4 1/2" ~ 6 5/8"	250	90	50	50	31	60'	
TVNR0060-260-T28C		7" ~ 11 3/4"	260	100	60	50	31	60'	
TVNR0080-300-T28D		13 3/8" ~ 20"	300	140	80	50	31	60'	
TVNR0050-273-T28C		7" ~ 11 3/4"		273	90	50	56	36	40'
TVNR0060-283-T28C				283	100	60	56	36	40'
TVNR0080-323-T28C				323	140	80	56	36	40'
TVNR0050-290-T28C		13 3/8" ~ 20"		290	90	50	60	43	20'
TVNR0060-300-T28D				300	100	60	60	43	20'
TVNR0080-340-T28D				340	140	80	60	43	20'

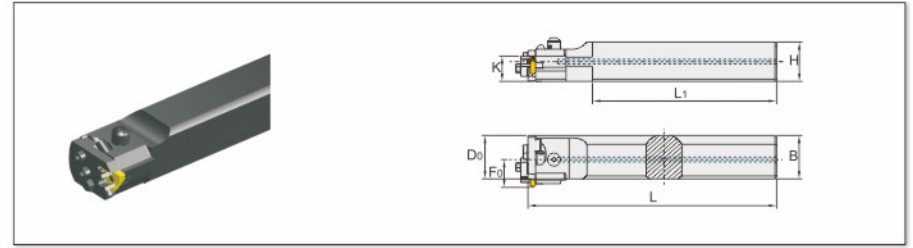
配件 Spare parts



压板	螺母	镶块	T型螺钉
Clamp	Nut	Adapter	T Screw
SP25	SP26	SP27	SP28

*注: λ - 刀具螺旋升角
 λ - helix angle

立装偏梯形内螺纹刀片用圆柄刀杆 Internal Toolholders for V Style API Buttress Insert



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	L	L1	H	K	D0	B	A
TVNR3248-340-T28B	T28VNRSBU3-1	4 1/2" ~ 6 5/8"	340	180	48	32	50	74.3	60'
TVNR3655-360-T28B			360	200	55	36	50	77.2	60'
TVNR3655-383-T28C		7" ~ 11 3/4"	383	200	55	36	56	77.2	40'
TVNR3248-363-T28D			363	180	48	32	56	74.3	40'
TVNR3655-400-T28D		13 3/8" ~ 20"	400	200	55	36	60	81.5	20'

配件 Spare parts

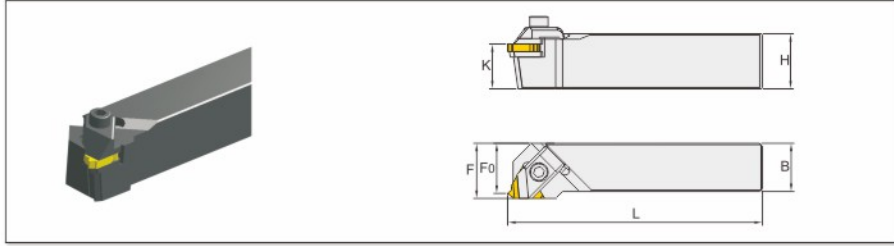


压板	螺母	镶块	T型螺钉
Clamp	Nut	Adapter	T Screw
SP25	SP26	SP27	SP28

*注: λ - 刀具螺旋升角
 λ - helix angle



钻杆A型外螺纹刀片用刀杆 External Toolholders for A Style Inserts of Oil Drill Rods & Connectors



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size						
			L	H	K	B	F	Fo	λ
TER3235-175-29A	29NRV38R-0402 29NRV38R-0403	2 3/8" ~ 3 1/2"	175	35	32	35	40	36.3	1°50'
TER3235-175-29B	29NRV40-0503 29NRV50-0403 29NRV50-0402	4" ~ 5 1/2"	175	35	32	35	40	36.3	1°20'
TER3235-175-29C	29NRV55-0601 29NRV65-0402	6 5/8" ~ 8 5/8"	175	35	32	35	40	36.3	45'

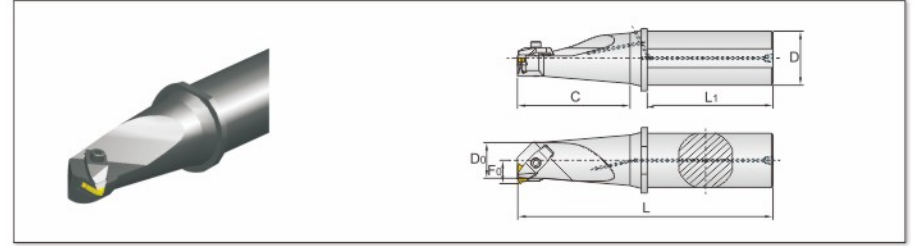
配件 Spare parts



压板	导屑板	刀垫	刀垫螺钉
Clamp	Chip breaker	Shim	Shim screw
SP38	SP40	SP39	M4×8

*注: λ - 刀具螺旋升角
λ - helix angle

钻杆A型内螺纹刀片用圆柄刀杆 Internal Round Shank for A Style Inserts of Oil Drill Rods & Connectors



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size						
			L	Li	D	C	D0	Fo	λ
TNR0060-330-29B	29NRV38R-0402 29NRV38R-0403	4" ~ 5 1/2"	330	160	60	145	48	30.8	1°20'
TNR0080-355-29B	29NRV40-0503 29NRV50-0403		355	180	80	145	48	30.8	1°20'
TNR0060-340-29C	29NRV40-0402 29NRV55-0601	6 5/8" ~ 8 5/8"	340	100	60	170	53	33.5	45'
TNR0080-295-29C	29NRV65-0402		295	100	80	170	53	33.5	45'

配件 Spare parts

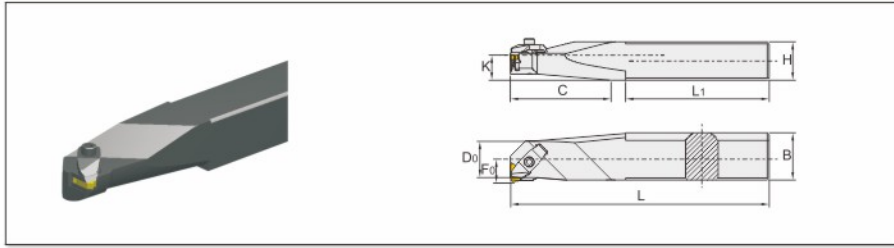


压板	导屑板	刀垫	刀垫螺钉
Clamp	Chip breaker	Shim	Shim screw
SP36	SP37	SP35	M4×8

*注: λ - 刀具螺旋升角
λ - helix angle



钻杆A型内螺纹刀片用方柄刀杆
Internal Square Shank for A Style Inserts of Oil Drill Rods & Connectors



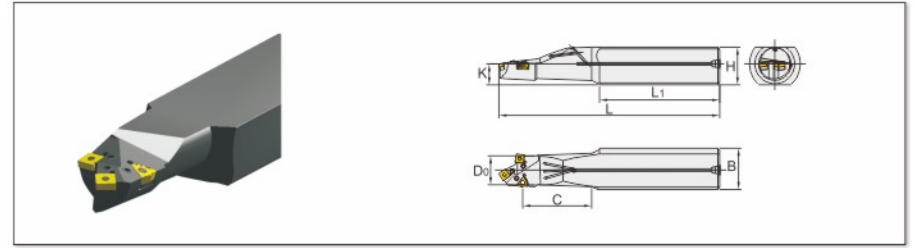
订货号 Order No.	配套刀片 Inserts	加工范围 Pipe size									
			L	L1	H	C	K	D0	B	Fo	λ
TNR3248-330-29B	29ERV38R-0402 29ERV38R-0403	4" ~ 5 1/2"	330	180	48	150	32	48	74.3	30.8	1°20'
TNR3655-350-29B	29ERV40-0503 29ERV50-0403 29ERV50-0402		350	200	55	150	36	48	77.2	30.8	1°20'
TNR3655-382-29C	29ERV55-0601 29ERV65-0402	6 5/8" ~ 8 5/8"	382	200	55	182	36	53	81.5	33.5	45°

配件 Spare parts

压板 Clamp	导屑板 Chip breaker	刀垫 Shim	刀垫螺钉 Shim screw
SP36	SP37	SP35	M4×8

*注: λ - 刀具螺旋升角
λ - helix angle

整体式接箍加工方柄复合刀杆 Multi-function Square Shank for Couplings



订货号 Order No.	配套刀片 Inserts	加工范围 Pipe size							
			L	L1	D0	H	C	K	λ
MNR3246-290-B17/S12/S12A	B17NR8RD2-3 B17NR10RD2-4 SNMG120408	2 3/8" ~ 3 1/2"	290	150	45	46	82	32	70°
MNR2539-290-B17/S12/S12A	B17NR8RD2-3 B17NR10RD2-4 SNMG120408		290	150	45	39	82	25	70°

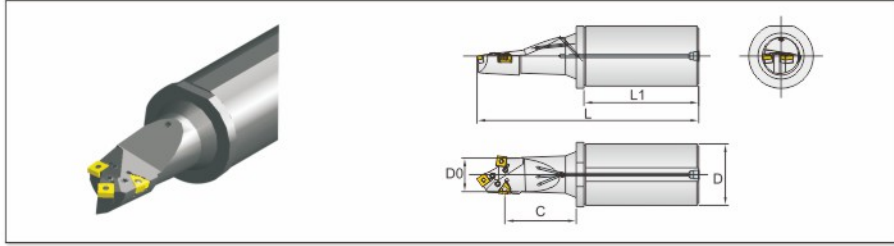
配件 Spare parts

斜拉杆 Leaver	顶丝 Screw	顶丝 Screw	杠杆 Leaver	刀垫 Shim	刀垫 Shim	扳手 Wrench
L4-1	M6×18	M6×12	G1	BN17	SP12	S3

*注: λ - 刀具螺旋升角
λ - helix angle



整体式接箍加工圆柄复合刀杆 Multi-Function Round Shank for Couplings



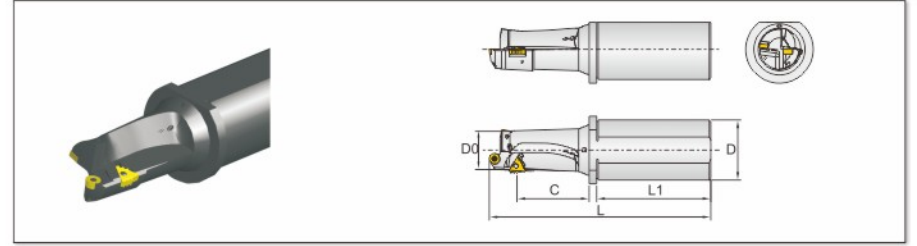
订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size					
			L	L1	D	D0	C	A
MNR0080-290-B17/S12/S12A	B17NR8RD2-3 B17NR10RD2-4 SNMG120408	2 7/8" ~ 3 1/2"	290	150	80	45	82	70°
MNR0050-290-B17/S12/S12A	B17NR8RD2-3 B17NR10RD2-4 SNMG120408		290	150	50	45	82	70°

配件 Spare parts

斜拉杆	顶丝	顶丝	杠杆	刀垫	刀垫	扳手
Leaver	Screw	Screw	Leaver	Shim	Shim	Wrench
L4-1	M6×18	M6×12	G1	BN17	SP12	S3

*注: λ - 刀具螺旋升角
λ - helix angle

整体式接箍加工圆柄复合刀杆 Multi-Function Round Shank for Couplings



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	加工范围 Pipe size					
			L	L1	D0	D	C	A
MNR0080-280-B17/S12/R16A1	B17NR8RD2-3 B17NR10RD2-4 RCMX1606M0 SNMG120408	2 3/8"	280	150	44	80	70	70°
MNR0080-290-B17/S12/R16A2		2 7/8"	290	150	51	80	81	70°
MNR0080-300-B17/S12/R16A3		3 1/2" ~ 4 1/2"	300	150	63	80	104	70°

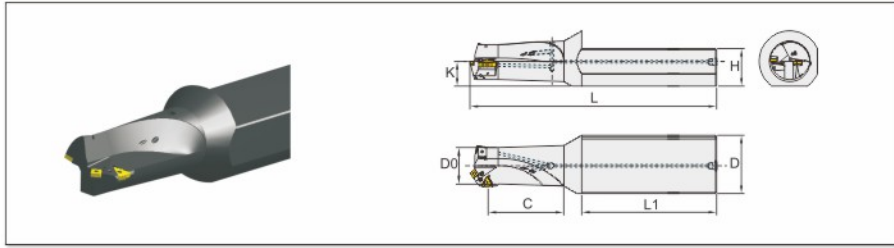
配件 Spare parts

斜拉杆	顶丝	螺母	杠杆	刀垫	刀垫	梅花螺钉	扳手	扳手
Leaver	Screw	Nut	Leaver	Shim	Shim	Screw	Torx Key	Wrench
L4-2	M6×12	SM4	G1	BN17	SP12	M5×16	T20	S3

*注: λ - 刀具螺旋升角
λ - helix angle



整体式接箍加工方柄复合刀杆 Multi-Function Round Square Shank for Couplings



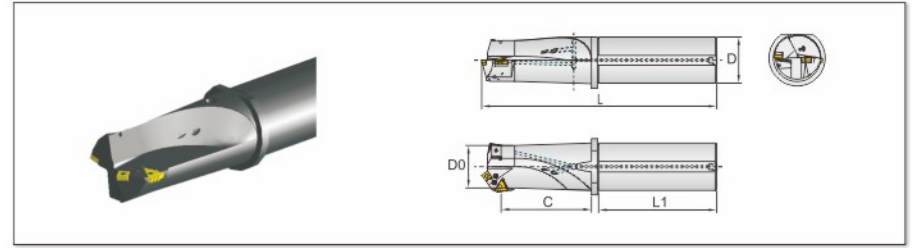
订货号Order No.	配用刀片Inserts	加工范围Pipe size	加工范围Pipe size						
			L	Li	D0	H	C	K	A
MNR3249-315-B17/S12/S12A3	B17NR8RD2-3 B17NRSBU2-2 SNMG120408	3 1/2" ~ 4 1/2"	315	150	50	49	116	32	60°
MNR3249-395-B17/S15/S15B	B17NR8RD2-3 B17NRSBU2-3 SNMG150612	5" ~ 7"	395	200	70	49	168	32	50°
MNR4055-403-B17/S15/S15C	B17NR8RD2-3 B17NRSBU2-3 SNMG150612	7" ~ 13 3/8"	403	200	84	55	176	40	30°

配件 Spare parts

斜拉杆	顶丝	螺母	杠杆	刀垫	刀垫	扳手	加工范围
Leaver	Screw	Nut	Leaver	Shim	Shim	Wrench	Pipe size
L4-2	M6×12	SM4	G1	BN17	SP12	S3	4" ~ 4 1/2"
L4-2	M8×12	SM4	G2	BN17	SP15	S3/S4	5" ~ 7"
L4-2	M8×12	SM4	G2	BN17	SP15	S3/S4	7" ~ 13 3/8"

*注: λ - 刀具螺旋升角
λ - helix angle

整体式接箍加工圆柄复合刀杆 Multi-Function Round Shank for Couplings



订货号Order No.	配用刀片Inserts	加工范围Pipe size	加工范围Pipe size						
			L	Li	D0	D	C	A	
MNR0060-315-B17/S12/S12A3	B17NR8RD2-4 B17NRSBU2-2 SNMG120408	3 1/2" ~ 4 1/2"	315	150	50	60	116	60°	
MNR0080-315-B17/S12/S12A3			315	150	50	80	116	60	
MNR0060-395-B17/S15/S15B	B17NR8RD2-4 B17NRSBU2-2 SNMG150612	5" ~ 7"	395	200	70	60	168	50°	
MNR0080-395-B17/S15/S15B			395	200	70	80	160	50°	
MNR0080-403-B17/S15/S15C		7" ~ 13 3/8"	403	200	84	80	176	30°	

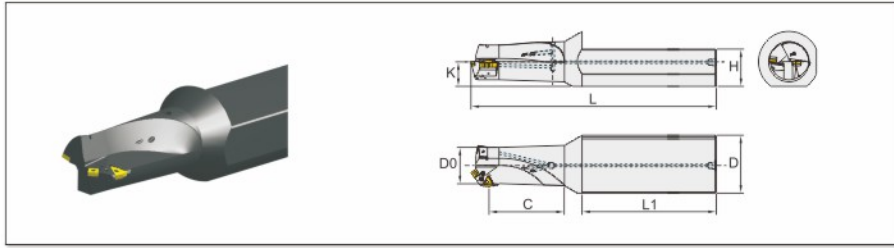
配件 Spare parts

斜拉杆	顶丝	螺母	杠杆	刀垫	刀垫	扳手	加工范围
Leaver	Screw	Nut	Leaver	Shim	Shim	Wrench	Pipe size
L4-2	M6×12	SM4	G1	BN17	SP12	S3	4" ~ 4 1/2"
L4-2	M8×12	SM4	G2	BN17	SP15	S3/S4	5" ~ 7"
L4-2	M8×12	SM4	G2	BN17	SP15	S3/S4	7" ~ 13 3/8"

*注: λ - 刀具螺旋升角
λ - helix angle



整体式接箍加工方柄复合刀杆 Multi-Function Square Shank for Couplings



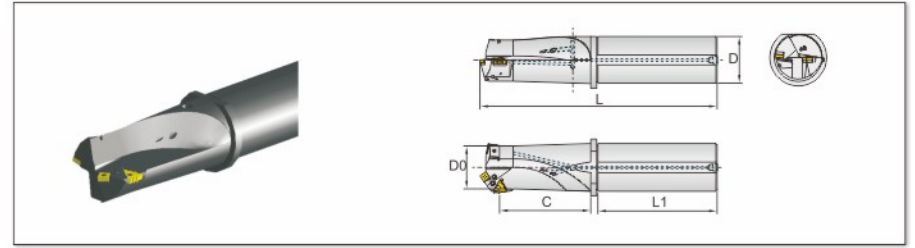
订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size							
			L	L1	D0	H	C	K	A
MNR3249-395-B23/S15/S15B	B23NRSBU2-3 B23NR8RD2-5 SNMG150612	5" ~ 7"	395	200	70	49	168	32	50'
MNR4055-403-B23/S15/S15C		7" ~ 13 5/8"	403	200	84	55	176	40	30'

配件 Spare parts

斜拉杆	顶丝	螺母	杠杆	刀垫	刀垫	扳手
Leaver	Screw	Nut	Leaver	Shim	Shim	Wrench
L4-2	M8*12	SM4	G2	BN23	SP15	S4

*注: λ - 刀具螺旋升角
λ - helix angle

整体式接箍加工圆柄复合刀杆 Multi-Function Round Shank for Couplings



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size							
			L	L1	D0	D	C	A	
MNR0060-395-B23/S15/S15B	B23NRSBU2-3 B23NR8RD2-5 SNMG150612	5" ~ 7"	395	200	70	60	168	50'	
MNR0080-395-B23/S15/S15B			395	200	70	80	168	50'	
MNR0080-403-B23/S15/S15C		7" ~ 13 3/8"	403	200	84	80	176	30'	

配件 Spare parts

斜拉杆	顶丝	螺母	杠杆	刀垫	刀垫	扳手
Leaver	Screw	Nut	Leaver	Shim	Shim	Wrench
L4-2	M8*12	SM4	G2	BN23	SP15	S4

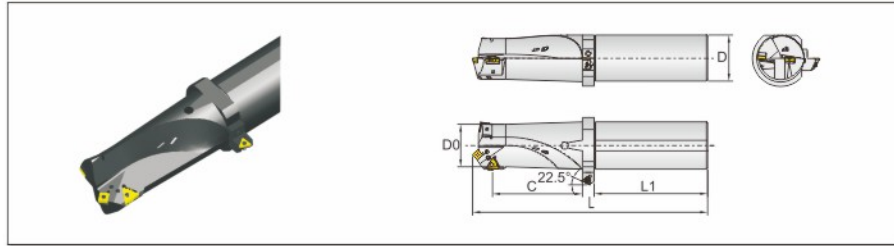
*注: λ - 刀具螺旋升角
λ - helix angle



石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

整体式带修毛刺的接箍加工用复合刀杆

Multi-Function Couplings Toolholders With a Insert for Cutting off Burrs at Thread Beginning



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size						
			L	L1	D0	D	C	A
MNR0080-413-TB17/S15/S15/T16B	B17NR8RD2-3 B17NRSBU2-2 SNMG150612 TPET16T304	5" ~ 7"	413	200	70	80	141	50'
MNR0080-425-TB17/S15/S15/T16C		7" ~ 13 3/8"	425	200	85	80	153	30'
MNR0080-413-TB23/S15/S15/T16B	B23NR8RD2-5 B23NRSBU2-3 SNMG150612 TPET16T304	5" ~ 7"	413	200	70	80	141	50'
MNR0080-425-TB23/S15/S15/T16C		7" ~ 13 3/8"	425	200	85	80	153	30'

修毛刺小刀夹 Cartridge for Cutting off Burrs

订货号 Order No.	立体图			
SNR2848T16		刀片 Insert	螺钉 Screw	扳手 Wrench
		TPET16T304	M4 × 12	T15

配件 Spare parts

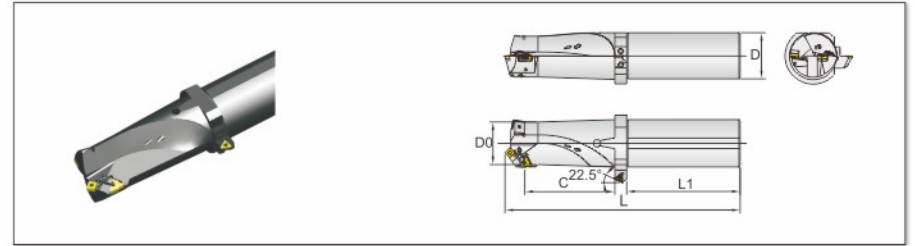
斜拉杆 Leaver	顶丝 Screw	螺母 Nut	杠杆 Leaver	刀垫 Shim	刀垫 Shim	扳手 Wrench	修毛刺小刀夹 Cartridge for Cutting off burrs
L4-2	M8×12	SM4	G2	BN23/BN17	SP15	S3/S4	SNR2848T16

*注: λ - 刀具螺旋升角
λ - helix angle

石油管螺纹刀具 THREADING TOOLS FOR OIL PIPES

整体式带修毛刺的接箍加工用复合刀杆

Multi-Function Couplings Toolholders With a Insert for Removing Burrs at Thread Beginning



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size						
			L	L1	D0	D	C	A
MNR0080-413-TB17/S15/S15/T16B	B17NR8RD2-3 B17NRSBU2-2 SNMG150612 TPET16T304	5" ~ 7"	413	200	70	80	141	50'
MNR0080-425-TB17/S15/S15/T16C		7" ~ 13 3/8"	425	200	85	80	153	30'
MNR0080-413-TB23/S15/S15/T16B	B23NR8RD2-5 B23NRSBU2-3 SNMG150612 TPET16T304	5" ~ 7"	413	200	70	80	141	50'
MNR0080-425-TB23/S15/S15/T16C		7" ~ 13 3/8"	425	200	85	80	153	30'

配件 Spare parts

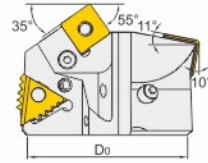
压板 Clamp	螺钉 Screw	刀垫 Shim	刀垫螺钉 Shim screw	弹簧 Spring	弹性销 Pin	杠杆 Leaver	刀垫 Shim	顶丝 Wcrew	扳手 Wrench	修毛刺小刀夹 Cartridge for Cutting off burrs
CL2	M521	TN23/TN17	M4×8	φ7×11	φ2×10	G2	SP15	M8×12	S3/S4	SNR2848T16

*注: λ - 刀具螺旋升角
λ - helix angle



模块式接箍加工用复合刀杆 Modular Multi-Function Toolholders for Couplings

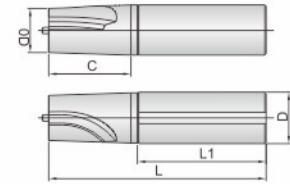
复合刀头
Cutting parts (Multi-function style)



刀头型号 Order No.	配用刀片 Inserts	加工范围 Pipe size	斜拉杆 Leaver	顶丝 Screw	刀垫 Shim	顶丝*2 Screw*2	弹簧卡*2 Shim Pin*2	杠杆*2 Leaver*2	刀垫*2 Shim*2	扳手 Wrench
	D0									
MNR63B17/S12/S12A3	63	3 1/2" ~ 4 1/2"	L4-1	M6*18	BN17	LEM8*12	THK4	PL4	SS12	S3/S4
MNR70B17/S15/S15B	70	4 1/2" ~ 7"	L4-1	M6*18	BN17	LEM8*12	THK5	PL5	SS15-5	S3/S4
MNR84B17/S15/S15C	84	7" ~ 13 3/8"	L4-1	M6*18	BN17	LEM8*12	THK5	PL5	SS15-5	S3/S4
MNR70B23/S15/S15B	70	4 1/2" ~ 7"	L4-1	M6*18	BN23	LEM8*12	THK5	PL5	SS15-5	S3/S4
MNR84B23/S15/S15C	84	7" ~ 13 3/8"	L4-1	M6*18	BN23	LEM8*12	THK5	PL5	SS15-5	S4/S4

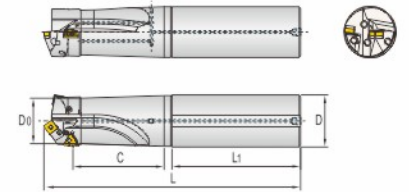
模块式接箍加工用复合刀杆 Moudlar Multi-Function Toolholders for Couplings

复合圆刀柄
Round Shanks



刀柄型号 Order No.	尺寸 Dimensions					加工范围 Dipe size	螺钉*4 Screw*4	销子*2 Pin*2
	L	L1	D	D0	C			
D63/0080-259A3	259	150	80	63	89	3 1/2" ~ 4 1/2"	M6*40-1; M6*50-2; M6*60-1; M8*50-1	Φ8*20-2
D70/0080-338B	338	200	80	70	128	4 1/2" ~ 7"	M6*55-2; M6*60-1; M8*40-1; M8*55-1	Φ8*20-2
D84/0080-343C	343	200	80	84	133	7" ~ 13 3/8"	M6*50-1; M6*60-1; M8*40-1; M10*65-2	Φ10*26-2

圆柄模块式刀杆
Moudlar Multi-function round shank

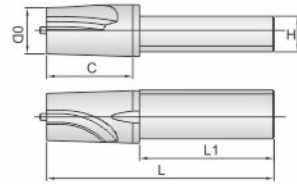


模块式圆柄刀杆型号 Order No.	所配刀柄 Shank part No.	所配复合刀头 Cutting parts order No.	加工范围 Dipe size	D0	L	L1	C
INR0080-315-B17/S12/S12A3	D63/0080-259A3	MNR63B17/S12/S12A3	3 1/2" ~ 4 1/2"	63	315	150	115
INR0080-395-B17/S15/S15B	D70/0080-338B	MNR70B17/S15/S15B	4 1/2" ~ 7"	70	395	200	142
INR0080-395-B23/S15/S15B		MNR70B23/S15/S15B	4 1/2" ~ 7"				
INR0080-408-B17/S15/S15C	D84/0080-343C	MNR84B17/S15/S15C	7" ~ 13 3/8"	84	408	200	154
INR0080-408-B23/S15/S15C		MNR84B23/S15/S15C	7" ~ 13 3/8"				



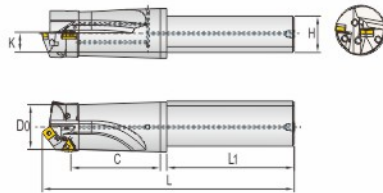
模块式接箍加工用复合刀杆 Modular Multi-Function Toolholders for Couplings

复合方刀柄
Square Shanks



刀柄型号 Order No.	尺寸 Dimensions					加工范围 Dipe size	螺钉×4 Screw×4	销子×2 Pin×2
	L	L1	D0	H	C			
D63/3249-259A3	259	150	63	49	89	3 1/2"~4 1/2"	M6×40-1 ; M6×50-2 ;	Φ8×20-2
D63/4055-259A3	259	150	63	55	89	3 1/2"~4 1/2"	M6×60-1 ; M8×50-1	
D70/3249-338B	338	200	70	49	128	4 1/2"~7"	M6×55-2 ; M6×60-1 ;	Φ8×20-2
D70/4055-338B	338	200	70	55	128	4 1/2"~7"	M8×40-1 ; M8×55-1	
D84/3249-343C	343	200	84	49	133	7"~13 3/8"	M6×50-1 ; M6×60-1 ;	Φ10×26-2
D84/4055-343C	343	200	84	55	133	7"~13 3/8"	M8×40-1 ; M10×65-2	

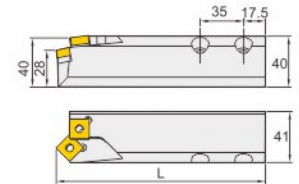
方柄模块式刀杆
Modular Multi-function square shank



模块式方柄刀杆型号 Order No.	所配刀柄 Shank part No.	所配复合刀头 Cutting parts order No.	加工范围 Dipe size	D0	L	L1	C
INR3249-315-B17/S12/S12A3	D63/3249-259A3	MNR63B17/S12/S12A3	3 1/2"~4 1/2"	63	315	150	115
INR4055-315-B17/S12/S12A3	D63/4055-259A3						
INR3249-395-B17/S15/S15B	D70/3249-338B	MNR70B17/S15/S15B	3 1/2"~4 1/2"	70	395	200	142
INR4055-395-B17/S15/S15B	D70/4055-338B						
INR3249-395-B23/S15/S15B	D70/3249-338B	MNR70B23/S15/S15B	4 1/2"~7"	70	395	200	142
INR4055-395-B23/S15/S15B	D70/4055-338B						
INR3249-408-B17/S15/S15C	D84/3249-343C	MNR84B17/S15/S15C	7"~13 3/8"	84	408	200	154
INR4055-408-B17/S15/S15C	D84/4055-343C						
INR3249-408-B23/S15/S15C	D84/3249-343C	MNR84B23/S15/S15C	7"~13 3/8"	84	408	200	154
INR4055-408-B23/S15/S15C	D84/4055-343C						

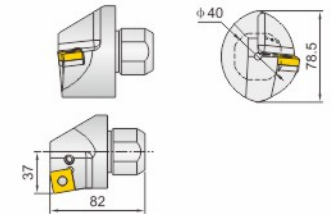
比利时 (Colinet) 车丝机专用刀具 Tools for Colinet Machine Tools

接箍平端面倒外角刀具
Toolholders for facing and chamfering of couplings



订货号 Order No.	配用刀片 Inserts	L	杠销 Lock pin	刀垫 Shim	扳手 Wrench
BM-5057	168				
BM-5056	203.5				

接箍锥内孔刀头
Internal turning unit of couplings

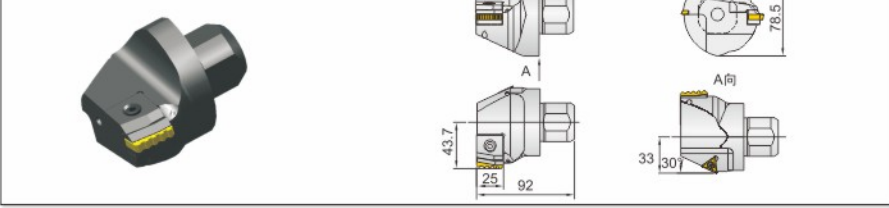


订货号 Order No.	配用刀片 Inserts	杠杆 Leaver	刀垫 Shim	弹簧卡 Shim Pin	杠杆螺钉 Screw	扳手 Wrench
BM-5055	SNMG190624	PL6	SP1904	THK6	LEM10×27	S4



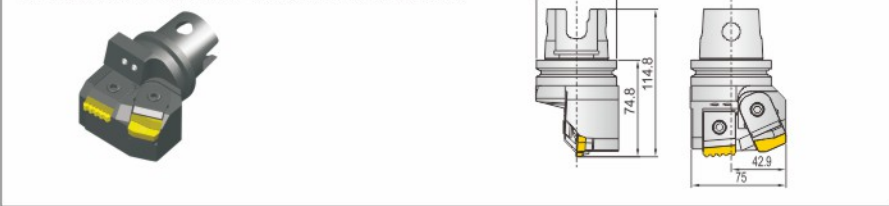
比利时 (Colinet) 车丝机专用刀具 Tools for Colinet Machine Tools

接插用车丝刀头
Internal thread unit tool of couplings



订货号	螺纹梳刀片	刀垫	刀垫螺钉	断屑器	压板	压板螺钉	去毛刺刀片	毛刺刀片螺钉	扳手	扳手
Order No.	Thread Inserts	Shim	Shim screw	Chip breaker	Clamp	Clamp screw	Insert	Screw	Torx Key	Wrench
BM-5062	C25NR8RD1-7 C25NR5BU1-5	DN2504	M5*0.5	BN2504	CC2425	CM620	TPET16T304	M4*12	T15	S4

管体用偏扣粗车复合刀头
The rough external tool unit for cutting API buttress pipebody

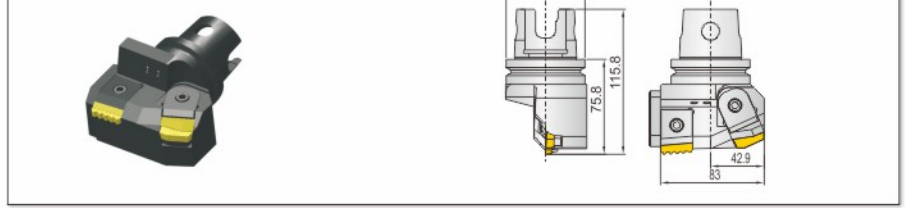


订货号	螺纹梳刀片	刀垫	刀垫螺钉	断屑器	螺纹刀压板	外圆刀片	外圆刀断屑器	外圆刀压板	外圆刀垫	外圆刀垫螺钉	挡板	扳手
Order No.	Thread Inserts	Shim	Shim screw	Chip breaker	Clamp	Rough Insert	Chip breaker	Clamp	Shim	Shim screw	Stopper	Wrench
BM-0036	C25ERSBU1-5	DW2504	M5*0.5	BW2504	BM-0018	SC2506	TA-5585	BM-0017	C/26418	M6*0.5	BM-0020	S4

* 注: BM-0036粗车刀头与BM-0035配对使用, 两者有严格的相对尺寸要求。
* Note: BM-0036 and BM-0035 must be used as a pair

比利时 (Colinet) 车丝机专用刀具 Tools for Colinet Machine Tools

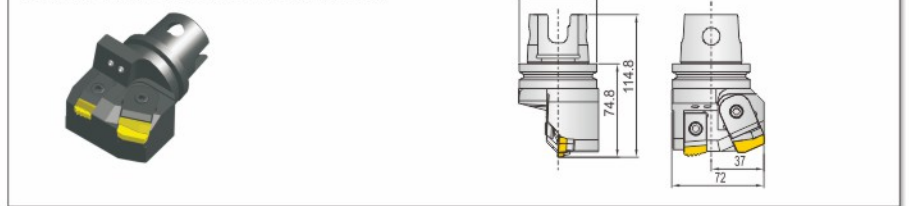
管体用偏扣精车复合刀头
The finish external tool unit for cutting API buttress



订货号	螺纹梳刀片	刀垫	刀垫螺钉	断屑器	螺纹刀压板	外圆刀片	外圆刀断屑器	外圆刀压板	外圆刀垫	外圆刀垫螺钉	挡板	扳手
Order No.	Thread Inserts	Shim	Shim screw	Chip breaker	Clamp	Rough Insert	Chip breaker	Clamp	Shim	Shim screw	Stopper	Wrench
BM-0035	C25ERSBU1-5	DW2504	M5*0.5	BW2504	BM-0018	SC2506	TA-5585	BM-0017	C/26418	M6*0.5	BM-0020	S4

* 注: BM-0035精车刀头与BM-0036配对使用, 两者有严格的相对尺寸要求。
* Note: BM-0035 and BM-0036 must be used as a pair

管体用圆扣粗车复合刀头
The rough external tool unit for cutting API round



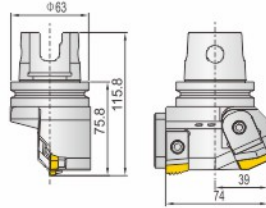
订货号	螺纹梳刀片	刀垫	刀垫螺钉	断屑器	螺纹刀压板	外圆刀片	外圆刀断屑器	外圆刀压板	外圆刀垫	外圆刀垫螺钉	挡板	扳手
Order No.	Thread Inserts	Shim	Shim screw	Chip breaker	Clamp	Rough Insert	Chip breaker	Clamp	Shim	Shim screw	Stopper	Wrench
BM-0040	C16ER8RD1-3	DD1604	M5*0.5	BW1604	DM-0021	SC2506	TA-5585	BM-0017	C/26418	M6*0.5	BM-0020	S4

* 注: BM-0040粗车刀头与BM-0039配对使用, 两者有严格的相对尺寸要求。
* Note: BM-0040 and BM-0039 must be used as a pair



比利时 (Colinet) 车丝机专用刀具 Tools for Colinet Machine Tools

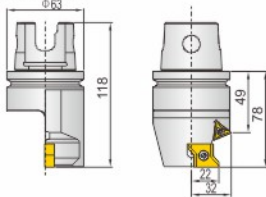
管体用圆扣精车复合刀头
The finish external tool unit for cutting API round



订货号 Order No.	螺纹梳刀片 Thread Inserts	刀垫 Shim	刀垫螺钉 Shim screw	断屑器 Chip breaker	螺纹刀压板 Clamp	外圆刀片 Rough Insert	外圆刀断屑器 Chip breaker	外圆刀压板 Clamp	外圆刀刀垫 Shim	外圆刀垫螺钉 Shim screw	挡板 Stopper	扳手 Wrench
BM-0039	C16ER8RD1-3	DD1604	M5x0.5	BW1604	DM-0021	SC2506	TA-5585	BM-0017	C/26418	M6x0.5	BM-0020	S4

* BM-0039精车刀头与BM-0040配对使用，两者有严格的相对尺寸要求。
* Note: BM-0039 and BM-0040 must be used as a pair

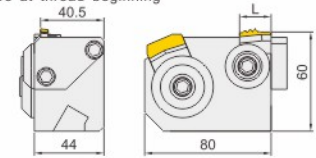
管体用平端面及去毛刺复合刀头
External tool unit for facing & chamfering and removing burrs at thread beginning



订货号 Order No.	端面倒角刀片 Insert	去毛刺刀片 Insert	端面倒角刀片用螺钉 Screw	去毛刺刀片用螺钉 Screw	扳手 Torx Key
BM-0075	C/32246/8	TPET16T304	M5x16	M4x12	T15/T20

国产高效车丝机专用刀具 Tools for Chinest High Efficient Machine Tools

管体用平端面及去毛刺复合刀头
External tool unit for facing & chamfering and removing burrs at thread beginning



订货号 Order No.	配用刀片 Inserts	L	断屑器 Chip breaker	刀垫 Shim
MER4460-80-SC2506/C16	C16ER8RD1-31(15°)	16	BXCQW1-B I	DD1604
	C16ER8RD1-32(15°)			
	C16ER10RD1-31			
MER4460-80-SC2506/C20	C20ER8RD1-31(12°)	20	BXCQW1-B II	DD2004
	C20ER8RD1-32(12°)			
	C20ER10RD1-31			
	C20ER10RD1-32			

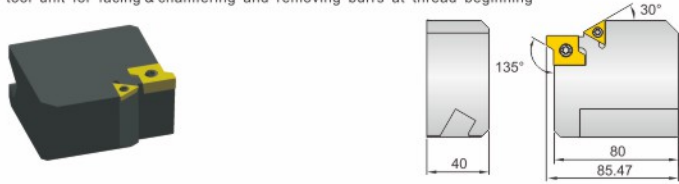
配件 Spare parts

刀垫螺钉 Shim screw	螺纹刀压板 Clamp	外圆刀片 Rough Insert	外圆刀刀垫 Shim	外圆刀垫螺钉 Shim screw	外圆刀断屑器 Chip breaker	外圆刀压板 Clamp	压板螺钉 Clamp screw	挡板 Stopper
M5x0.5	YB28x7	SC2506	C/26418	M6x0.5	C/26419	YB39x8	YM8x16	D01



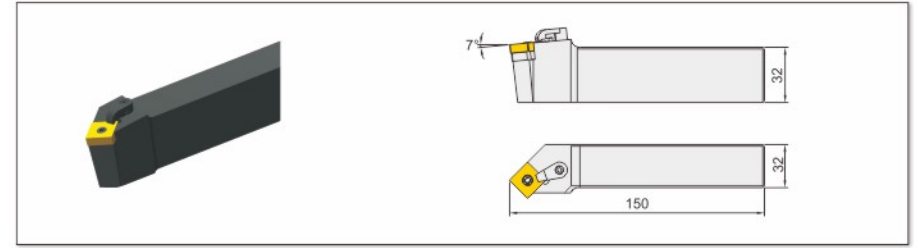
国产高效车丝机专用刀具 Tools for Chinese High Efficiency Machine Tools

管体用平端面及去毛刺复合刀头
External tool unit for facing & chamfering and removing burrs at thread beginning

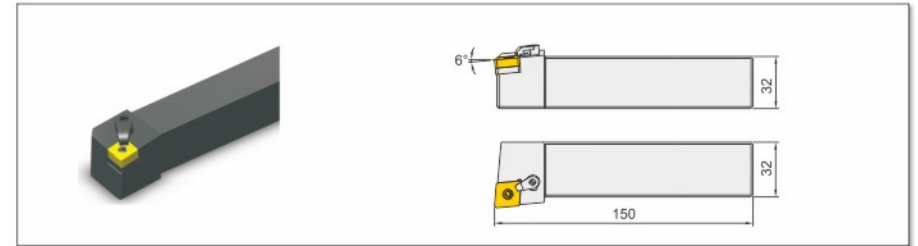


订货号 Order No.	配用刀片 Inserts			
		端面倒角刀片用螺钉 Screw	去毛刺刀片用螺钉 Screw	扳手 Torx Key
MER4080-75-C32246B/TP16	TPET16T304 C/32246/B	M5×16	M4×12	T15/T20

管体加工用外圆粗车刀杆 External Toolholders for Rough Turning



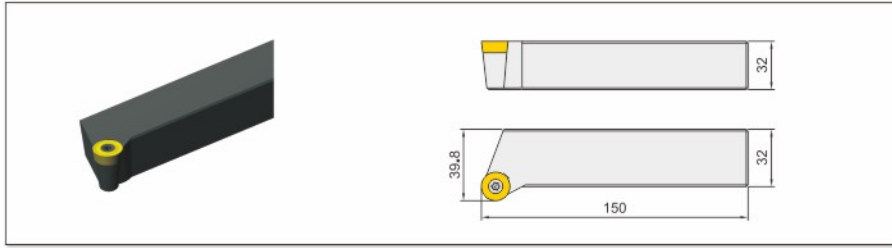
订货号 Order No.	刀片 Insert					
		红销 Lock Pin	刀垫 Shim	勾头压板 Clamp	双头螺钉 Clamp screw	扳手 Wrench
MSSNR3232M15	SNMG150612	ML58	S1504	MC620	M5625	S2.5 S3



订货号 Order No.	刀片 Insert					
		红销 Lock Pin	刀垫 Shim	勾头压板 Clamp	双头螺钉 Clamp screw	扳手 Wrench
MCLNR3232M16	CNMG160612	ML58	C1604	MC620	M5625	S2.5 S3

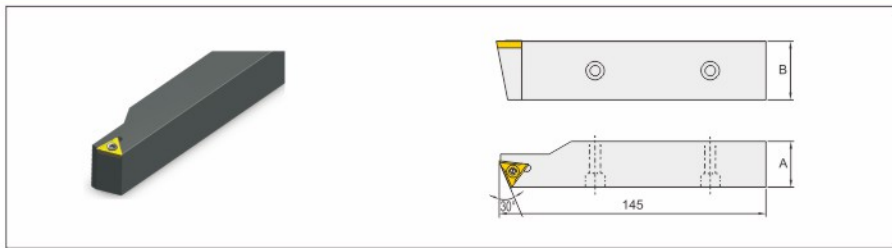


管体加工用外圆粗车刀杆 External Toolholders for Rough Turning



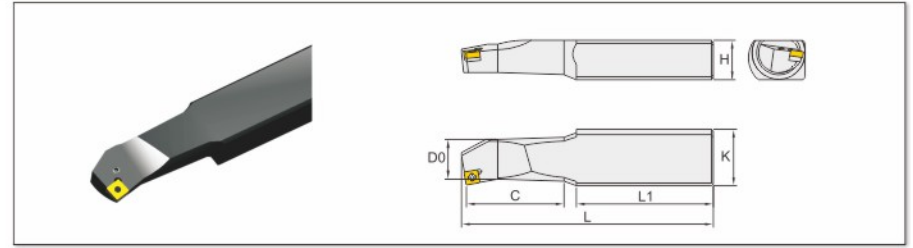
订货号 Order No.	刀片 Insert		
		螺钉 Screw	扳手 Torx Key
SRGCR3232M16	RCMX1606MD	M5×14	T20
SRGCL3232M16			

去毛刺刀杆 Toolholder for Cutting off Burrs at The Thread Beginning



订货号 Order No.	刀片 Insert		
		螺钉 Screw	扳手 Torx Key
STWC3225M16	TPET16T304	M4×14	T20
STWC3218M16			

接箍加工用镗孔方柄刀杆(杠杆压紧式) Internal Turning Toolholders for Couplings



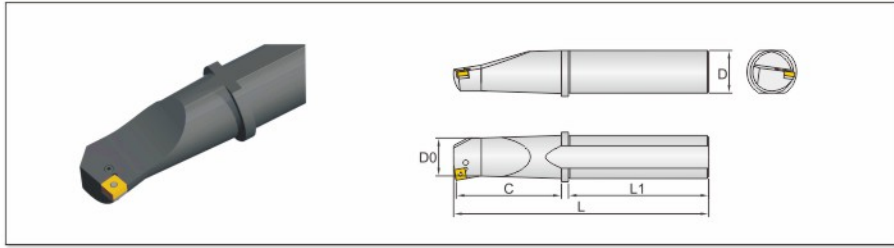
订货号Order No.	配用刀片Inserts	加工范围Pipe size	L	L1	D0	H	C	K
			PNR2538-290-S12A	SNMG120408	2 3/8" ~ 3 1/2"	290	155	45
PNR3238-290-S12A	290	155	45			38	116	32
PNR3246-290-S15A	290	155	45			46	116	32
PNR3238-331-S15B	SNMG150612	4" ~ 7"	331	180	45	38	137	32
PNR3246-331-S15B			331	180	45	46	137	32
PNR3240-350-S15C		7" ~ 13 3/8"	350	180	50	40	150	32
PNR3248-350-S15C			350	180	50	48	150	32

配件 Spare parts

				加工范围
Leaver	Shim	Screw	Wrench	Pipe size
G1	SP12	M6×12	S3	2 3/8" ~ 3 1/2"
G2	SP15	M8×12	S4	4" ~ 13 3/8"



接箍加工用镗刀圆柄刀杆(杠杆压紧式) Internal Turning Toolholders for Couplings

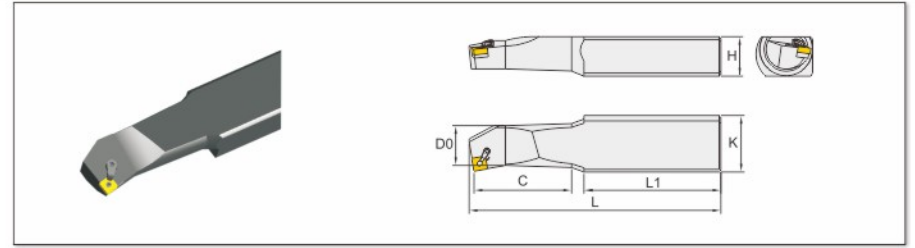


订货号Order No.	配用刀片Inserts	加工范围Pipe size	加工范围Pipe size				
			L	Li	C	D ₀	D
PNR0050-290-S12A	SNMG120408	2 3/8" ~ 3 1/2"	290	155	116	45	50
PNR0060-290-S12A			290	155	116	45	60
PNR0080-290-S12A			290	155	116	45	80
PNR0050-273-S15B	SNMG150612	4" ~ 7"	273	90	160	45	50
PNR0050-331-S15B			331	180	137	45	50
PNR0060-273-S15B		273	90	160	45	60	
PNR0060-350-S15C	SNMG150612	7" ~ 13 3/8"	350	180	150	50	60
PNR0080-350-S15C			350	180	150	50	80

配件 Spare parts

杠杆	刀垫	顶丝	扳手	加工范围
Leaver	Shim	Screw	Wrench	Pipe size
G1	SP12	M6×12	S3	2 3/8" ~ 3 1/2"
G2	SP15	M8×12	S4	4" ~ 13 3/8"

接箍加工用镗刀方柄刀杆(复合压紧式) Internal Turning Toolholders for Couplings



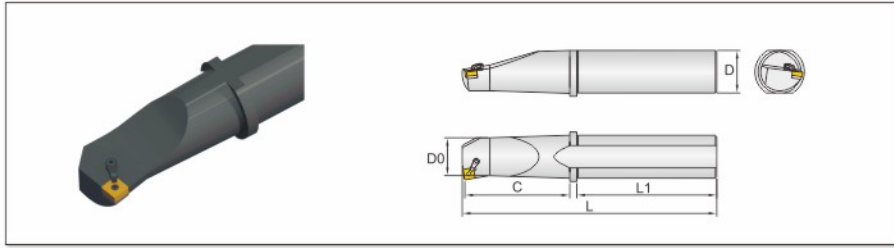
订货号Order No.	配用刀片Inserts	加工范围Pipe size	加工范围Pipe size					
			L	Li	D ₀	H	C	K
MNR2538-290-S12A	SNMG120408	2 3/8" ~ 3 1/2"	290	155	45	38	116	25
MNR3238-290-S12A			290	155	45	38	116	32
MNR3246-290-S15A			290	155	45	46	116	32
MNR3238-331-S15B	SNMG150612	4" ~ 7"	331	180	45	38	137	32
MNR3246-331-S15B			331	180	45	46	137	32
MNR3240-350-S15C		SNMG150612	7" ~ 13 3/8"	350	180	50	40	150
MNR3248-350-S15C	350			180	50	48	150	32

配件 Spare parts

杠杆	刀垫	压板	双头螺钉	扳手	加工范围
Lock pin	Shim	Clamp	Clamp Screw	Wrench	Pipe size
ML46	S1204	MC620	M5620	S3	2 3/8" ~ 3 1/2"
ML58	S1504	MC622	M5625	S4	4" ~ 13 3/8"



接箍加工用镗刀圆柄刀杆(复合压紧式) Internal Turning Toolholders for Couplings

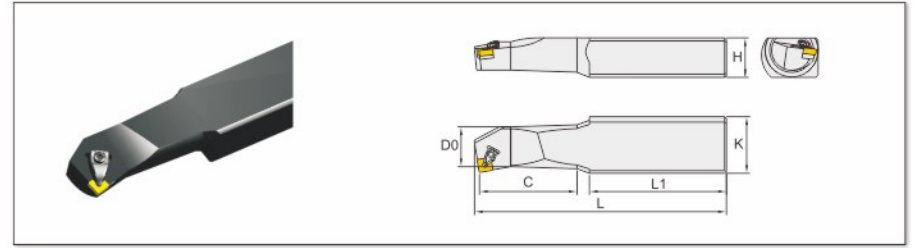


订货号Order No.	配用刀片Inserts	加工范围Pipe size					
			L	Li	C	Do	D
MNR0050-290-S12A	SNMG120408	2 3/8" ~ 3 1/2"	290	155	116	45	50
MNR0060-290-S12A			290	155	116	45	60
MNR0080-290-S12A			290	155	116	45	80
MNR0050-273-S15B	SNMG150612	4" ~ 7"	273	90	160	45	50
MNR0050-331-S15B			331	180	137	45	50
MNR0060-273-S15B		273	90	160	45	60	
MNR0060-350-S15C	SNMG150612	7" ~ 13 3/8"	350	180	150	50	60
MNR0080-350-S15C			350	180	150	50	80

配件 Spare parts

销钉	刀垫	压板	双头螺钉	扳手	加工范围
Lock pin	Shim	Clamp	Clamp Screw	Wrench	Pipe size
ML46	S1204	MC620	M5620	S3	2 3/8" ~ 3 1/2"
ML58	S1504	MC622	M5625	S4	4" ~ 13 3/8"

接箍加工用镗孔方柄刀杆(T-刚性压紧式) Internal Turning Toolholders for Couplings



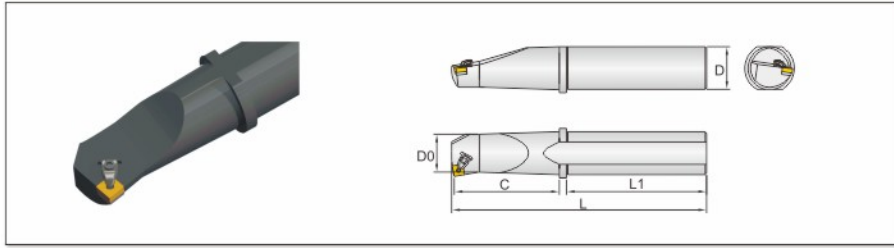
订货号Order No.	配用刀片Inserts	加工范围Pipe size						
			L	Li	Do	H	C	K
TNR2538-290-S12A	SNMG120408	2 3/8" ~ 3 1/2"	290	155	45	38	116	25
TNR3238-290-S12A			290	155	45	38	116	32
TNR3246-290-S15A			290	155	45	46	116	32
TNR3238-331-S15B	SNMG150612	4" ~ 7"	331	180	45	38	137	32
TNR3246-331-S15B			331	180	45	46	137	32
TNR3240-350-S15C		SNMG150612	7" ~ 13 3/8"	350	180	50	40	150
TNR3248-350-S15C	350			180	50	48	150	32

配件 Spare parts

压板	刀垫	刀垫固定螺钉	螺钉	弹簧	弹簧销	扳手	加工范围
T-clamp	Shim	Shim Screw	Screw	Spring	Pin	Wrench	Pipe size
CL1	CS12	M4*8	M418	φ6*9	φ2*10	S3	2 3/8" ~ 3 1/2"
CL2	CS15	M4*8	M521	φ7*11	φ2*10	S4	4" ~ 13 3/8"



接箍加工用镗孔圆柄刀杆 (T - 刚性压紧式) Internal Turning Toolholders for Couplings



订货号 Order No.	配用刀片 Inserts	加工范围 Pipe size	L	Li	C	D ₀	D
TNR0050-290-S12A	SNMG120408	2 3/8" ~ 3 1/2"	290	155	116	45	50
TNR0060-290-S12A			290	155	116	45	60
TNR0080-290-S12A			290	155	116	45	80
TNR0050-273-S15B	SNMG150612	4" ~ 7"	273	90	160	45	50
TNR0050-331-S15B			331	180	137	45	50
TNR0060-273-S15B		273	90	160	45	60	
TNR0060-350-S15C		350	180	150	50	60	
TNR0080-350-S15C		7" ~ 13 3/8"	350	180	150	50	80

配件 Spare parts

压板	刀垫	刀垫固定螺钉	螺钉	弹簧	弹簧销	扳手	加工范围
T-clamp	Shim	Shim Screw	Screw	Spring	Pin	Wrench	Pipe size
CL1	CS12	M4*8	M418	φ6*9	φ2*10	S3	2 3/8" ~ 3 1/2"
CL2	CS15	M4*8	M521	φ7*11	φ2*10	S4	4" ~ 13 3/8"

部分常用配件 Some of Spare Parts

断屑器 Chip Breakers

简图 Diagram	名称 Name	订货单 Order No.	简图 Diagram	名称 Name	订货单 Order No.
	断屑器 Chip breaker	BXCQW1-B1		断屑器 Chip breaker	BXP8W1-32
	断屑器 Chip breaker	BXCQW1-B11		断屑器 Chip breaker	BXP8W1-33
	断屑器 Chip breaker	C-26419		断屑器 Chip breaker	TA-5585
	断屑器 Chip breaker	XP5BN1-5		断屑器 Chip breaker	BW2504
	断屑器 Chip breaker	BXP8W1-31		断屑器 Chip breaker	BN2504

刀片 Inserts

简图 Diagram	名称 Name	订货单 Order No.	简图 Diagram	名称 Name	订货单 Order No.
	端面倒角刀片 Insert of facing and chamfering	C/32246/B		外圆刀片 Rough turning insert	SC2506
	毛刺刀片 Insert of cutting off burrs	TPET16T304			



部分常用配件 Some of Spare Parts

刀垫 Shims

简图 Diagram	名称 Name	订货号 Order No.	简图 Diagram	名称 Name	订货号 Order No.
	刀垫 Shim	BE17		刀垫 Shim	TE17
	刀垫 Shim	BN17		刀垫 Shim	TN17
	刀垫 Shim	BE23		刀垫 Shim	TE23
	刀垫 Shim	BN23		刀垫 Shim	TN23

技术资料

TECHNICAL INFORMATION



车削螺纹刀片材质的选择 Grade of Thread Turning Inserts

牌号 Grade	涂层(PVD) Coated(PVD)	适合加工对象 Machining Materials
P30	TIN	低、中、高碳钢、碳钢、合金钢、铸钢 Low,medium,high carbon steel,Alloy steel,Cast steel
M20	TIN	钢、不锈钢、铸钢、铸铁 Carbon steel,stainless steel,cast steel,Cast iron
M20	不涂层抛光前刀片 No coated	铝合金或铜合金 Aluminium alloy,Copper alloy
TP04	TIALN	钢、不锈钢、铸钢 Steel,Stainless steel,Cast steel
TP02	TIALN	不锈钢 Stainless steel
F618	TIALN	次高钢级石油管、高钢级石油管 High,subhigh grade steel pipe
F605	TIALN	低钢级石油管、次高钢级 Low,subhigh grade steel pipe

车削速度的选择 Choice of Cutting Speed

当选择了正确的材质后，必须再根据下表来设定其切削速度(m/min)，才能使刀片发挥应有的效果。右表中的切削速度是一个范围，在大多数情形下，最好先选择此范围的中间值来开始切削。 After choosing proper grade of insert, The cutting speed should be decided by the data on right form. On the right form, the cutting speed is a range. Generally We suggest. You'd better start with a meanspeed.	螺纹刀片 Threading inserts	M20	P30	TP04	F605	F618
		低碳钢或中碳钢 Low,medium carbon steel	80~130	80~140	120~140	
高碳钢 High carbon steel	60~110	60~120	100~120			
合金钢或调质钢 Alloy steel or quenched and tempered steel	60~110	60~120	80~120			
不锈钢 Stainless steel	60~100		60~120			
铸钢 Cast steel	60~110	60~120	100~120			
铸铁 Cast iron	60~100		60~120			
铝合金或铜合金 Aluminium alloy,Copper alloy	90~280					
加工石油管 Threading inserts for oil pipe	普通钢级 Low grade steel pipe J55、H40、K55、M65等				140~180	
次高钢级 Subhigh grade steel pipe N80、C75、L80等					120~160	140~180
高钢级 High grade steel pipe P110、C90、J95等						120~160

注：以上表列数据应在充分冷却条件下使用，冷却不充分时应适当降低切削速度。
The datum were taken under full cooling, if not enough cooling, Should reduce the cutting speed.

加工方法的选择 Guide to Chose Work Style

外螺纹加工方法 Work style of external thread

右旋螺纹
Right thread

右手刀具
Right tool

左旋螺纹
Left thread

左手刀具
Left tool

其它选项 Other option

右旋螺纹 左旋螺纹

右手刀具 左手刀具

左手刀具 右手刀具

内螺纹加工方法 Work style of internal thread

右旋螺纹
Right thread

右手刀具
Right tool

左旋螺纹
Left thread

左手刀具
Left tool

其它选项 Other option

右旋螺纹 左旋螺纹

左手刀具 右手刀具

注：多数螺纹刀片，内、外刀片不能交换使用，即NR(L)一定用于内螺纹加工，ER(L)用于外螺纹加工，因为除两类刀片的牙高、刀尖圆弧不同外，内刀片为15°前角，而外刀片为10°前角。
Note: Internal thread inserts must be used for machining of internal thread and external thread inserts for external thread. Don't exchange.

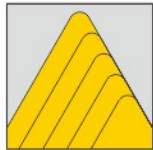


螺纹切削进刀方式选择 Choice of Cutting Style

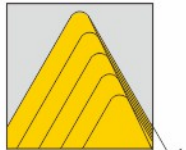
进刀方式 Cutting style



径向进刀
Radial cutting



沿齿侧面进刀
Cutting along side of teeth

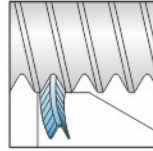


沿齿侧面进刀改进型
Cutting along teeth side

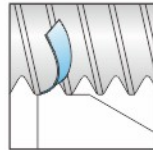


沿齿侧面交换式进刀
Alternate cutting along teeth side

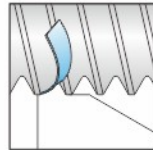
切削特征 Shape of chip



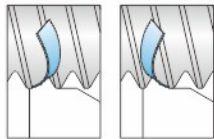
产生的V形切屑可能很难控制
it is hard to control V shape chip



齿间有足够空间供切屑排出
There is enough space to leave chips when make lateral cutting



减少后刀片磨损
Can reduce flank wear of a insert



交替使用切削刃有助于提高刀具寿命
Machining with cutting edge alternative can improve the life of inserts

螺纹车削走刀次数及径向进给量的选择 Choice of Cutting Passes and Cutting Depth

公、英、美制螺纹加工 For machining of Metric, British, American system thread

- 表中所给走刀量分配仅为参考值，是在好的加工条件下加工中等强度的钢材时得出的。
- The data in the form were taken from machining of medium grade material with good cutting conditions.
- 加工材料强度大时，径向走刀次数要增加，重要的是减少第一刀螺纹的切削深度。
- When cutting harder materials, Should add more pass. Especially it is important to reduce cutting depth of the first pass.
- 下表为ISO公制螺纹的推荐表，W、NPT、UN、BSPT等可参照选择。
- The data in the from are just for Metric(ISO) thread. The datum of W、NPT、UN、BSPT etc.Thread can be chosen with referring these datum.

外螺纹加工：ISO公制螺纹 External thread(Metric ISO)

径向进给次数 Pass No.	螺距 Pitch(mm)												
	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0
14											0.07	0.07	0.08
13											0.07	0.10	0.10
12										0.06	0.07	0.08	0.10
11										0.06	0.07	0.10	0.10
10									0.06	0.07	0.08	0.10	0.10
9								0.06	0.10	0.10	0.10	0.15	0.20
8						0.06	0.06	0.07	0.10	0.10	0.15	0.20	0.20
7						0.06	0.07	0.10	0.10	0.20	0.20	0.20	0.25
6				0.06	0.06	0.10	0.10	0.10	0.15	0.20	0.20	0.20	0.25
5			0.06	0.10	0.10	0.10	0.15	0.15	0.15	0.20	0.20	0.25	0.25
4	0.03	0.05	0.10	0.10	0.12	0.10	0.15	0.20	0.20	0.25	0.25	0.30	0.30
3	0.06	0.10	0.15	0.12	0.20	0.20	0.20	0.25	0.25	0.25	0.30	0.35	0.35
2	0.10	0.15	0.17	0.20	0.25	0.25	0.25	0.30	0.30	0.30	0.35	0.35	0.40
1	0.15	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35	0.35	0.40	0.40	0.40

径向进给 Cutting thread(Metric ISO)

内螺纹加工：ISO公制螺纹 Internal thread(Metric ISO)

径向进给次数 Pass No.	螺距 Pitch(mm)												
	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0
14											0.06	0.06	0.06
13											0.06	0.07	0.09
12										0.06	0.06	0.07	0.10
11										0.06	0.07	0.10	0.10
10									0.06	0.07	0.08	0.10	0.10
9								0.06	0.10	0.10	0.10	0.15	0.20
8						0.06	0.06	0.08	0.10	0.15	0.15	0.20	0.20
7						0.07	0.06	0.10	0.10	0.15	0.20	0.20	0.25
6				0.06	0.06	0.07	0.10	0.10	0.15	0.15	0.20	0.20	0.25
5			0.06	0.07	0.06	0.08	0.10	0.15	0.15	0.20	0.20	0.25	0.25
4	0.03	0.05	0.07	0.10	0.15	0.10	0.15	0.20	0.20	0.25	0.25	0.25	0.25
3	0.06	0.08	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25	0.25	0.30	0.30
2	0.08	0.15	0.15	0.15	0.25	0.25	0.25	0.25	0.25	0.30	0.30	0.35	0.35
1	0.15	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.30	0.35	0.35	0.40	0.40

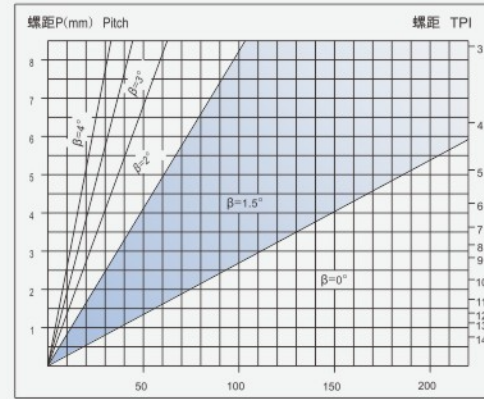
径向进给 Cutting thread(Metric ISO)



石油管螺纹加工 About Machining of Oil Pipe Thread

刀片种类规格 Type of inserts		径向进给(mm) Cutting depth	走刀次数 Pass No.	1	2	3	4	5	6	7	8	9	10	11	12	
每英寸8牙圆螺纹 API Round insert (8 tooth/inch)	内螺纹 Internal	2齿刀片 2 tooth insert	0.60	0.40	0.35	0.30	0.20	0.20								
		3齿刀片 3 tooth insert	0.80	0.60	0.40	0.20										
		5齿刀片 5 tooth insert	1.75	0.25												
	外螺纹 External	7齿刀片 (二次) 7 tooth insert (2 pass)	1.80	0.20												
		7齿刀片 (一次) 7 tooth insert (1 pass)	2.00													
		2齿刀片 2 tooth insert	0.70	0.45	0.40	0.30	0.20									
每英寸10牙圆螺纹 API Round insert (10 tooth/inch)	内螺纹 Internal	3齿刀片 3 tooth insert	0.85	0.60	0.35	0.20										
		3齿刀片 (2片成组) 3 tooth (2 pieces a group)	2.00													
		3齿刀片 (3片成组) 3 tooth (3 pieces a group)	2.00													
	外螺纹 External	2齿刀片 2 tooth insert	0.55	0.40	0.35	0.20	0.15									
		3齿刀片 3 tooth insert	0.80	0.55	0.20											
		4齿刀片 4 tooth insert	1.00	0.50	0.15											
每英寸5牙偏梯扣 API Buttress insert (5 tooth/inch)	内螺纹 Internal	8齿刀片 8 tooth insert	1.60													
		2齿刀片 2 tooth insert	0.55	0.50	0.35	0.20										
		3齿刀片 3 tooth insert	0.90	0.55	0.10											
	外螺纹 External	4齿刀片 4 tooth insert	1.05	0.50	0.15											
		3齿刀片 (2片、3片成组) 3 tooth (2, 3 pieces a group)	1.60													
		单齿立装刀片 1 tooth of V style	0.35	0.30	0.25	0.25	0.20	0.20	0.20							
钻杆接头螺纹 API drill rod insert	内螺纹 Internal	3齿刀片 3 tooth insert	0.50	0.40	0.35	0.30	0.20									
		5齿刀片 5 tooth insert	1.30	0.45												
		单齿立装刀片 1 tooth of V style	0.45	0.35	0.30	0.25	0.25	0.20								
	外螺纹 External	2齿刀片 2 tooth insert	0.45	0.40	0.35	0.35	0.20									
		3齿刀片 3 tooth insert	0.55	0.50	0.40	0.30										
		3齿刀片 3 tooth insert	0.85	0.60	0.35	0.20										
钻杆接头螺纹 API drill rod insert	3齿刀片 (3片成组) 3 tooth (3 pieces a group)	1.75														
	内螺纹 Internal	0.50	0.45	0.45	0.40	0.35	0.35	0.35	0.30	0.30	0.25	0.15	0.10			
外螺纹 External	0.55	0.50	0.45	0.40	0.40	0.35	0.35	0.35	0.30	0.20	0.10					

螺纹加工中的螺旋升角问题 About Helix Angle of Thread Machining



螺距中径d(mm) Major diameter(mm) 图1 Fig.1

螺纹螺旋升角 β 的大小取决于螺距与螺纹直径的大小，计算公式为
Helix angle β depends on pitch and pitch diameter

$$\tan \beta = \frac{P}{\pi d}$$

其中，P为螺距 Pitch (mm)
d为螺纹中径 Pitch diameter (mm)
 β 为螺旋升角 Helix angle

在螺纹加工中，要求刀片的安装一定要顺着螺旋升角的方向倾斜同样的角度，如图2所示，使刀片侧后角 α_1 尽量等于 α_2 ，这样尽可能避免侧后刀片面与螺纹一侧的剧烈磨损而缩短刀片寿命。

通常生产的刀杆一般取螺旋升角为 1.5° ，可满足大多数螺纹的加工，如图1中蓝色区所示。但在某些情况，如：大螺距小直径或小螺距的情况下，可能出现 $>1.5^\circ$ 或 $<<1.5^\circ$ 的螺旋升角，应专门定做刀杆或采取更换刀垫的办法解决。

In machining thread, the thread inserts must be fixed at an angle in the toolholder along helix angle as Fig 2. In order to improve life of the insert, α_1 equals α_2 as same as possible.

Generally thread toolholders have 1.5° helix angle, it can be satisfied with most applications as blue area in Fig 1. But if helix angle of workpiece thread is much more than 1.5° or much less than 1.5° , the solution can be got by ordering special toolholder with corresponding helix angle or changing the shim with corresponding helix angle.

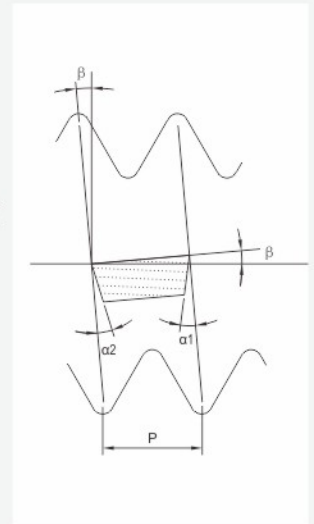


图2 Fig.2



螺纹铣削加工问题 About Threading Milling

为了实现螺纹铣削加工，需要一台具备螺旋插补功能的三轴联动的CNC加工中心，螺旋插补是一种沿螺旋线方向产生刀具移动的数控功能。这种螺旋运动是在一个平面内的圆周运动与垂直于该平面的直线运动的连续组合运动。例如：图A中，在一个圆柱的外表面上，从A点到B点的轨迹是在XY平面上的圆周运动与Z方向直线运动的组合。

In order to perform a thread milling operation, a milling machine with three-axis control capable of helical interpolation is required. Helical interpolation is a CNC function producing tool movement along a helical path. This helical motion combines circular movement in one plane with a simultaneous linear motion in a plane perpendicular to the first. For example, the path from point A to B (Fig.A) on the envelope of the cylinder combines a circular movement in the XY plane with a linear displacement in the Z direction.

在大多数的CNC系统中，这种功能有两种方式实现：

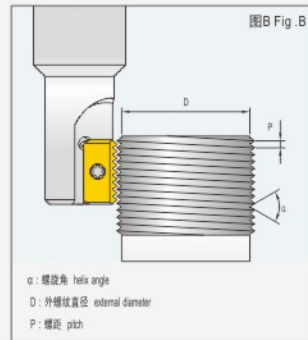
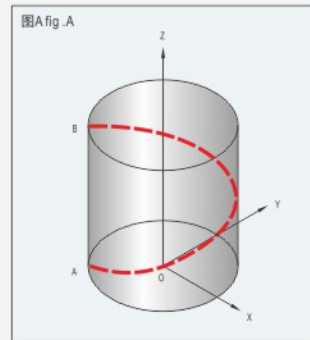
On most CNC systems this function can be executed in two different ways:

G02: 顺时针方向的螺旋插补

G03: 逆时针方向的螺旋插补

G02: Helical interpolation in a clockwise direction

G03: Helical interpolation in a counter-clockwise direction



螺纹的铣削加工（图B）由刀具绕自身的轴线旋转运动与沿工件内外圆表面的螺旋轨道运动组成。在一个这样的运动轨迹中，刀具将垂直移动一个螺距长度，就由螺纹铣刀的运动生产出所需要的螺纹形式。

为开始加工螺纹，这里有三种刀具切入工件的方法：

- 1、圆弧切线切入法。
- 2、径向切入法。
- 3、直线切线切入法。

The thread milling operation (Fig.B) consists of circular rotation of the tool around its own axis together with an orbiting motion along the bore or workpiece circumference. During one such orbit, the tool will shift vertically one pitch length. These movements combined with the insert geometry create the required thread form.

There are three acceptable ways of approaching the workpiece with the tool to initiate production of the thread:

- 1、Tangential Arc Approach
- 2、Radial Approach
- 3、Tangential Line Approach

螺纹铣削加工问题 About Threading Milling

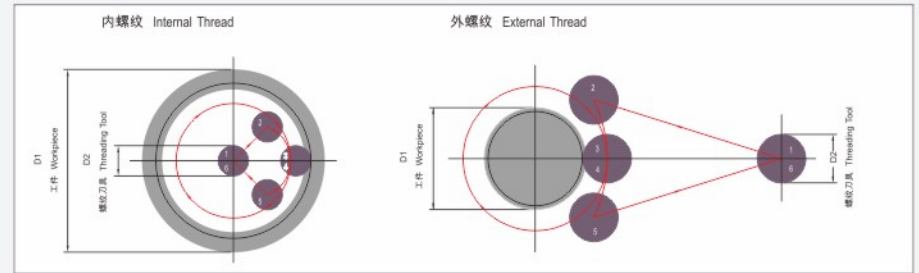
1. 圆弧切线切入法 Tangential Arc Approach

利用这种方法，刀具切入工件很平滑，没有痕迹留在工件上，且无振动，甚至对淬硬的材料也很好。

尽管此径向切入法需要编制更复杂的程序，但这种方法还是不失为加工高质量螺纹的首选。

With this method, the tool enters and exits the workpiece smoothly. No marks are left on the Workpiece and there is no vibration, even with harder materials.

Although it requires slightly more complex programming than the radial approach (see below), this is the method recommended for machining the highest quality threads.



1-2: 快进

Rapid approach

2-3: 刀具沿圆弧切线切入，同时沿Z轴同步进给

Tool entry along tangential arc, with simultaneous feed along z-axis

3-4: 在完整的运动轨迹中（360°），实现螺旋运动

Helical movement during one full orbit (360°)

4-5: 刀具沿圆弧切线切出，同时沿Z轴同步进给

Tool exit along tangential arc, with continuing feed along z-axis

5-6: 快退

Rapid return



螺纹铣削加工问题 About Threading Milling

2. 进向切入法 Radial approach

这是一个最简单的方法。关于径向切入法有两个缺点值得注意：

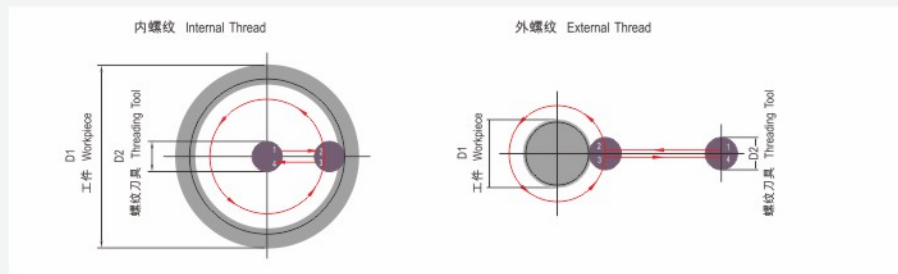
- A、一个小的垂直痕迹线可能会留在切入（切出）点上，这对螺纹本身无关大局。
- B、当用这种方法加工很硬的材料时，刀具可能有产生振动，因为刀具以全牙深切入。

注意：当全牙深切入时，其径向进给量只能取螺旋运动进给量的1/3。

This is the simplest method. There are two characteristics worth noting about the radial approach:

- A. A small vertical mark may be left at the entry (and exit) point. This is of no significance to the thread itself.
- B. When using this method with very hard materials, there may be a tendency of the tool to vibrate as it approaches the full cutting depth.

Note: Radial feed during entry to the full profile depth should only be 1/3 of the subsequent circular feed!

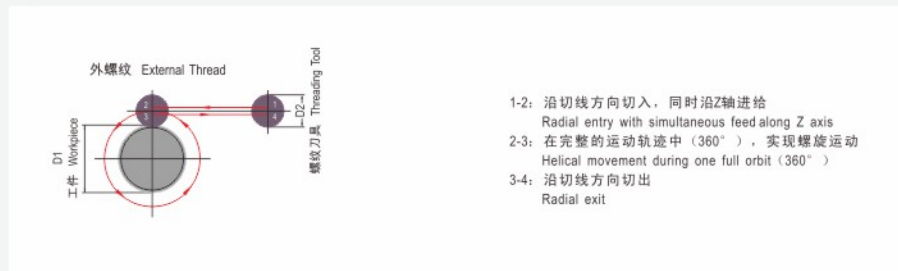


- 1-2: 快进
Radial entry
- 2-3: 在完整的运动轨迹中 (360°)，实现螺旋运动
Helical movement during one full orbit (360°)
- 3-4: 快退
Radial exit

3. 直线切线切入法 Tangential Line Approach

这种方法非常简单，具有圆弧切线切入法的所有优点，但仅适用于外螺纹加工

This method is very simple, and has all of advantages of tangential arc method. However, it is applicable only with external threads



螺纹切削加工的准备工作的准备工作 Preparing for The Thread Milling Operation

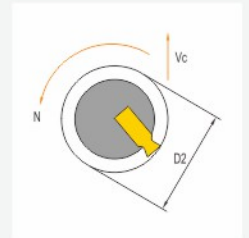
1. 计量转速和进给量 Calculation of rotational velocity and feed at the cutting edge

$$N = \frac{1000 \times V}{\pi \times D_2}$$

$$V = \frac{N \times \pi \times D_2}{1000}$$

$$F_1 = N \times Z \times f$$

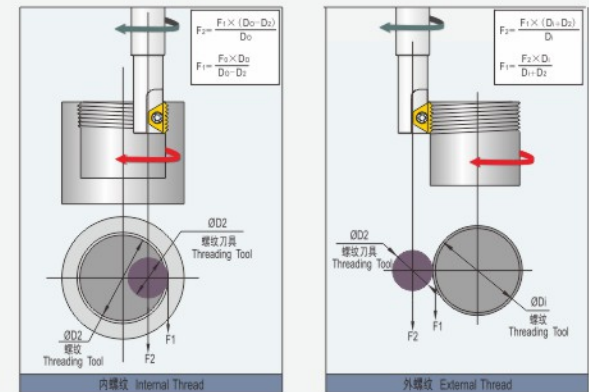
- N—转速 Rotational Velocity [R.P.M]
- V—切削速度 Cutting speed [m/min]
- D2—刀具切削刃直径 Toolholder Cutting Dia [mm]
- F1—切削刃上的刀具进给量 Tool Feed Rate at the cutting Edge [mm/min]
- Z—切削刃数 No. of cutting Edges
- f—每转每齿进给量 Feed per tooth per rotation [mm/rev]



2. 刀具中心线的进给量的计算 Calculation of feed rates at the tool center line

大多数的加工中心，编程所需的进给量是刀具中心线的进给量，在处理线性的刀具运动时，刀刃上与刀具中心线的进给量是相似的，图中的公式给出了切削刃和刀具中心线之间的关系。

On most CNC machines, the feed rate required for programming is that of the center-line of the tool. When dealing with linear tool movement, the feed rate at the cutting edge and the center line are identical, but with circular tool movement such is not the case. The equations define the relationship between feed rates at the cutting edge and at the tool center line.





螺纹铣刀的材料选择 Grades and Their Applications

牌号 Grade	性能及应用 Application	图例 Diagram
F1505	通用性及任性极强的牌号，带TiAlN涂层的超细颗粒硬质合金基体，具有很好的抗冲击及优秀的耐磨性。 Excellent for general use. A tough micron substrate with TiAlN coating. Provides good fracture toughness and excellent wear resistance.	
F1005	适用中等切削速度，通用性很强的螺纹铣削加工的牌号。带TiAlN涂层的超细颗粒的硬质合金基体，具有良好的抗冲击性及耐磨性。 Excellent for general use with medium cutting speed. A tough micron substrate with TiAlN coating. Provides excellent wear resistance and good toughness	
F0905	适用高切削速度，通用性很强的螺纹铣削加工的牌号。带TiAlN涂层的超细颗粒的德国生产的硬质合金基体，具有优秀的抗冲击性及耐磨性。 Excellent for general use with high cutting speed. A tough micron substrate from Germany with TiAlN coating. Provides excellent wear resistance and good toughness	

螺纹铣刀切削速度及进给量的选择 Recommended Grades, Cutting Speeds Vc[m/min]

被加工材料 Material	工件硬度 Hardness Brinell HB	切削速度 Vc[m/min]			进给量 Feed (mm/每齿)/(mm/tooth)				
		螺纹铣刀片 Indexable inserts		整体合金螺纹铣刀 Solid Carbide	螺纹铣刀片 Indexable Inserts	螺旋槽 Solid Helical Flute	直槽 Solid Straight Flute		
		F1505	F1005	F0905					
P	碳钢 Unalloyed steel	低碳钢 Low carbon [C=0.1-0.25%]	125	90-180	80-250	50-180	0.05-0.3	0.03-0.15	0.01-0.1
		中碳钢 Medium carbon [C=0.25-0.55%]	150	90-170	80-230	50-140	0.05-0.25	0.03-0.1	0.01-0.08
		高碳钢 High carbon [C=0.55-0.85%]	170	90-160	80-200	50-120	0.05-0.2	0.05-0.08	0.01-0.05
	低合金钢 Low alloy steel	非硬化 Non hardened	180	90-155	60-180	60-170	0.05-0.25	0.03-0.1	0.03-0.07
		硬化 Hardened	275	80-160	60-170	60-160	0.05-0.2	0.03-0.07	0.03-0.07
	高合金钢 High alloy steel	硬化 Hardened	350	70-150	60-160	60-150	0.05-0.15	0.01-0.03	0.005-0.01
		退火 Annealed	200	70-115	40-100	40-90	0.05-0.2	0.03-0.05	0.01-0.03
	铸钢 Cast steel	硬化 Hardened	325	60-100	30-80	30-70	0.05-0.1	0.01-0.03	0.005-0.01
		低合金 Low alloy (alloying elements<5%)	200	100-170	80-250	70-200	0.05-0.15	0.03-0.1	0.01-0.03
	M	铁素体不锈钢 Stainless steel ferritic	高合金 High alloy (alloying elements>5%)	225	70-130	60-170	60-150	0.05-0.1	0.01-0.03
非硬化 Non hardened			200	120-180	60-150	50-140	0.05-0.15	0.04-0.1	0.01-0.05
奥氏体不锈钢 Stainless steel Austenitic		硬化 Hardened	330	120-180	60-120	60-110	0.05-0.1	0.01-0.05	0.005-0.01
		奥氏体 Austenitic	180	100-140	60-140	60-130	0.05-0.15	0.04-0.1	0.007-0.02
超级奥氏体 Super Austenitic		奥氏体 Austenitic	200	100-140	60-130	50-120	0.05-0.1	0.01-0.1	0.007-0.02
		非硬化 Non hardened	200	100-140	60-160	50-150	0.05-0.15	0.04-0.1	0.01-0.03
铸造铁素体不锈钢 Stainless steel Cast ferritic		硬化 Hardened	330	100-140	60-110	50-100	0.05-0.1	0.03-0.05	0.005-0.01
		奥氏体 Austenitic	200	100-120	60-150	50-140	0.05-0.15	0.04-0.1	0.01-0.03
铸造奥氏体不锈钢 Stainless steel Cast Austenitic		硬化 Hardened	330	100-120	60-100	50-90	0.05-0.1	0.03-0.05	0.005-0.01
		退火 (铁基) Annealed (Iron based)	200	20-40	30-60	30-50	0.05-0.1	0.04-0.1	0.007-0.02
高温合金 High temperature alloys		时效 (铁基) Aged (Iron based)	280	20-30	20-50	20-40	0.02-0.05	0.01-0.03	0.005-0.01
		退火 (镍或钴基) Annealed(Nickel or Cobalt based)	250	15-20	15-35	15-30	0.02-0.05	0.01-0.03	0.005-0.01
		时效 (镍或钴基) Aged (Nickel or Cobalt based)	350	10-15	15-30	15-25	0.02-0.05	0.01-0.03	0.005-0.01
		纯99.5 Ti Pure 99.5 Ti	400Rm	70-120	40-80	30-70	0.02-0.05	0.03-0.05	0.007-0.02
钛合金 Titanium alloys		α+β 合金 α+β alloys	1050Rm	20-50	20-50	20-45	0.02-0.05	0.03-0.05	0.007-0.02



螺纹铣刀切削速度及进给量的选择 Recommended Grades, Cutting Speeds Vc[m/min]

被加工材料 Material		工件硬度 Hardness Brinell HB	切削速度 Vc [m/min]			进给量 Feed (mm/每齿)/(mm/tooth)		
			螺纹铣刀片 Indexable Inserts		整体合金螺纹铣刀 Solid Carbide	螺纹铣刀片 Indexable Inserts	螺旋槽 Solid Helical Flute	直槽 Solid Straight Flute
			F1505	F1005	F0905			
超硬钢 Extra hard steel	硬化 Hardened	55HRC	20-45	15-45	15-35	0.01-0.03	0.005-0.01	0.003-0.006
可锻铸铁 Malleable cast iron	铁素体 (短屑) Ferritic (short chips)	130	60-130	70-160	60-150	0.02-0.08	0.01-0.03	0.007-0.02
	珠光体 (长屑) Pearlitic (long chips)	230	60-120	60-150	100	0.02-0.05	0.03-0.05	0.005-0.01
灰口铸铁 Grey cast iron	低强度 Low tensile strength	180	60-130	70-160	50-140	0.05-0.15	0.05-0.1	0.007-0.02
	高强度 High tensile strength	280	60-100	40-120	40-110	0.05-0.1	0.03-0.05	0.005-0.01
球墨铸铁 Nodular SG iron	铁素体 Ferritic	160	60-125	40-110	40-100	0.05-0.15	0.05-0.1	0.007-0.02
	珠光体 Pearlitic	280	50-90	40-100	40-90	0.05-0.1	0.03-0.05	0.005-0.01
变形铝合金 Aluminium alloys wrought	非时效 Non aging	60	100-250	200-300	150-250	0.1-0.4	0.1-0.25	0.05-0.15
	时效 Aged	100	100-180	150-250	100-220	0.1-0.3	0.1-0.2	0.03-0.1
铝合金 Aluminium alloys	铸造 Cast	75	150-400	100-200	80-150	0.1-0.3	0.1-0.2	0.05-0.15
	铸造及时效 Cast & aged	90	150-280	120-220	90-160	0.05-0.25	0.1-0.15	0.03-0.1
铝合金 Aluminium alloys	铸造 Cast Si 13-22%	130	80-150	200-300	150-250	0.1-0.3	0.1-0.2	0.05-0.15
铜和铜合金 Copper and copper alloys	黄铜 Brass	90	120-210	200-300	150-250	0.1-0.3	0.1-0.25	0.05-0.15
	黄铜及无铅铜 Bronze and non leaded copper	100	120-210	150-250	100-220	0.05-0.25	0.1-0.2	0.03-0.1

螺纹加工中常出现的问题及解决对策 About problems and solutions with machining thread

问题 Problems	原因 Causes	措施 Solutions
<p>侧后刀面磨损过大 Side flank wear</p> <p>螺纹侧面质量差 Bad quality of tooth side of thread</p> 	<p>— 侧向进刀方法不正确 — Incorrect cutting along side of teeth</p>	<p>改变侧向进刀方法，高侧面3-5° Change to cutting along teeth side at 3-5°</p>
<p>振动 Vibration</p> 	<p>— 工件装夹不正确 — Incorrect setting of workpiece</p> <p>— 刀具安装不正确 — Incorrect setting of toolholder</p>	<p>选择较软的夹头 Use soft jaws</p> <p>减少刀具悬伸长度 Reduce overhanging part of toolholder 检查刀柄夹套是否磨损 Check jacket of tool shank 使用防震刀柄 Use anti-vibration toolholder</p>
<p>塑性变形 Plastic deformation</p> 	<p>— 切削区温度过高 — Much higher temperature of cutting area</p> <p>— 切削液不足 — Not enough cooling</p>	<p>提高切削速度，如果仍不可则大大降低速度 Up or down cutting speed 使用连续恒定进刀量0.1-0.16 Chose constant cutting depth 0.1-0.16</p> <p>调整中心高 Change insert height</p> <p>降低切削速度 Reduce cutting speed 增加进刀次数 Add passes 减小量大切深 Reduce cutting depth</p> <p>增加切削液 Full cooling</p>
<p>塑性变形开始 (A) 它将导致塑性断裂 (B) Plastic deformation (A) Will cause break (B)</p>	<p>— 错误的刀片材质 — Incorrect grade of insert</p>	<p>选择耐塑性变形的刀片材料 Chose correct grade of insert</p>



螺纹加工中常出现的问题及解决对策 About problems and solutions with machining thread

问题 Problems	原因 Causes	措施 Solutions
积屑瘤 (BUE) Built-up edge (BUE) 	一切削刀刃温度太低 — Too low temperature on the insert edge 经常产生于不锈钢材料 — Often occur while cutting stainless steel 经常产生于低碳钢材料 — Often occur while cutting low carbon steel	提高切削温度 Raise cutting temperature (raise cutting speed) 选择有良好韧性的刀片, 有涂层最好 Chose better toughness and coated insert
积屑瘤 (A) 和刃边剥落 (B) 经常混合产生, 积屑瘤积累后会带着刀片材料剥落。 BUE(A) and breaks often occur together, it makes breaks on the insert edges while it comes off the insert	不适合的刀片材质 — Incorrect grade of insert	选择有良好韧性的刀片, 有涂层最好 Chose better toughness and coated insert
刀片崩刃 Break of insert edge 	一车螺纹之前的余量太大 — Too much machining allowance before cutting thread 一进刀量过大 — Too much cutting depth 一刀片材质选错 — Incorrect grade of insert 一中心高不正确 — Incorrect insert height	正确的余量应大于最大外螺纹大径和小于内螺纹小径 (0.03-0.07mm) The proper allowance should be bigger than major diameter of external thread or smaller than minor diameter of internal thread 0.05-0.1mm 选择韧性更好的刀片材质 Chose better toughness grade 增加进刀次数减少最大切深 Add passes and reduce cutting depth 使用正确的中心高 Adjust insert height
后面面磨损 Flank wear 	一刀片不磨损 — Bad wear resistance of insert 一切削速度太高 — Too high cutting speed 一切深太浅 — Too small cutting depth 一刀片中心高偏高 — Much higher insert height	选择更耐磨的刀片材质或更好的涂层 Chose better wear resistance or coated insert 减小切削速度 Reduce cutting speed 减小进刀次数, 增加每次切深 Reduce passes, increase cutting depth 调整中心高 Adjust insert height

车削内螺纹用刀片推荐表
 Inserts Recommendation for A Given Internal Thread Specification

ISO标准型螺纹 ISO Metric Full Profile	螺距 Pitch (mm)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
1.00		12-14	D 3/16"	08NR1.0ISO
		15-17	D 1/4"	11NR1.0ISO
		18	D 1/4"	11NR1.0ISO
1.25		20-24	D 3/8"	16NR1.0ISO
		12-14	D 3/16"	08NR1.25ISO
		15-18	D 1/4"	11NR1.5ISO
1.50		20-25	D 3/8"	16NR1.5ISO
		26-28	D 3/8"	16NR1.5ISO
		30-36	D 3/8"	16NR1.5ISO
		38-45	D 3/8"	16NR1.5ISO
		48-68	D 3/8"	16NR1.5ISO
1.75		M12	D 3/16"	08NR1.75ISO
		M14	D 3/16"	08NR2.0ISO
		M16-18	D 1/4"	11NR2.0ISO
		20-22	D 3/8"	16NR2.0ISO
2.00		24	D 3/8"	16NR2.0ISO
		27-30	D 3/8"	16NR2.0ISO
		33-36	D 3/8"	16NR2.0ISO
		39-45	D 3/8"	16NR2.0ISO
		48-68	D 3/8"	16NR2.0ISO
2.50		M18	D 1/4"	11NR2.5ISO
		M20-M22	D 3/8"	16NR2.5ISO
3.00		M24-M27	D 3/8"	16NR3.0ISO
		36-45	D 3/8"	16NR3.0ISO
3.50		48-68	D 3/8"	16NR3.0ISO
		M30-M33	D 3/8"	16NR3.5ISO
4.00		M36	D 1/2"	22NR4.0ISO
		M39	D 1/2"	22NR4.0ISO
4.50		56-68	D 1/2"	22NR4.0ISO
		M42	D 1/2"	22NR4.5ISO
		M45	D 1/2"	22NR4.5ISO
5.00		M48	D 1/2"	22NR5.0ISO
		M52	D 1/2"	22NR5.0ISO
5.50		M56-60	D 5/8"	27NR5.5ISO
6.00		M64-68	D 5/8"	27NR6.0ISO



车削内螺纹用刀片推荐表

Inserts Recommendation for A Given Internal Thread Specification

UN美制统一标准螺纹 American UN Full Profile

螺距 Pitch (TPI)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
32	7/16"-1/2"	D 3/16"	08NR32UN
	9/16"-11/16"	D 1/4"	11NR32UN
	3/4"-15/16"	D 3/8"	16NR32UN
	7/8"-15/16"	D 3/8"	16NR32UN
28	1"	D 3/8"	16NR32UN
	7/16"-1/2"	D 3/16"	08NR28UN
	5/8"-11/16"	D 1/4"	11NR28UN
	3/4"-13/16"	D 3/8"	16NR28UN
	7/8"-15/16"	D 3/8"	16NR28UN
27	1"-1 1/8"	D 3/8"	16NR28UN
	1 3/16"	D 3/8"	16NR28UN
	7/16"-1/2"	D 3/16"	08NR27UN
	9/16"-5/8"	D 1/4"	11NR27UN
	3/4"	D 3/8"	16NR27UN
24	7/8"	D 3/8"	16NR27UN
	1"	D 3/8"	16NR27UN
	1/2"	D 3/16"	08NR24UN
	9/16"-11/16"	D 1/4"	11NR24UN
	3/4"	D 3/8"	16NR24UN
	7/8"	D 3/8"	16NR24UN
20	1"-1 1/8"	D 3/8"	16NR24UN
	1 1/4"-1 1/2"	D 3/8"	16NR24UN
	1 5/8"	D 3/8"	16NR24UN
	1/2"-9/16"	D 3/16"	08NR20UN
	5/8"-11/16"	D 1/4"	11NR20UN
12	3/4"-13/16"	D 3/8"	16NR20UN
	7/8"-15/16"	D 3/8"	16NR20UN
	1"-1 3/16"	D 3/8"	16NR20UN
	1 1/4"-1 1/2"	D 3/8"	16NR20UN
	1 9/16"-1 13/16"	D 3/8"	16NR20UN
	1 7/8"-2 1/8"	D 3/8"	16NR20UN

车削内螺纹用刀片推荐表

Inserts Recommendation for A Given Internal Thread Specification

UN美制统一标准螺纹(续) American UN Full Profile(con't)

螺距 Pitch (TPI)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
18	1/2"-9/16"	D 3/16"	08NR18UN
	5/8"	D 1/4"	11NR18UN
	3/4"	D 3/8"	16NR18UN
	7/8"-1"	D 3/8"	16NR18UN
	1 1/16"-1 3/16"	D 3/8"	16NR18UN
16	1 1/4"-1 1/2"	D 3/8"	16NR18UN
	1 9/16"-1 3/4"	D 3/8"	16NR18UN
	1 7/8"-2"	D 3/8"	16NR18UN
	1/2"-9/16"	D 3/16"	08NR16UN
	5/8"-11/16"	D 1/4"	11NR16UN
14	3/4"-13/16"	D 3/8"	16NR16UN
	7/8"-1"	D 3/8"	16NR16UN
	1 1/16"-1 1/8"	D 3/8"	16NR16UN
	1 3/16"	D 3/8"	16NR16UN
	1 1/4"-1 1/2"	D 3/8"	16NR16UN
	1 9/16"-1 13/16"	D 3/8"	16NR16UN
13	1 7/8"-2 1/8"	D 3/8"	16NR16UN
	1/2"-9/16"	D 3/16"	08NR14UN
	5/8"	D 1/4"	11NR14UN
	3/4"	D 3/8"	16NR14UN
	7/8"-1"	D 3/8"	16NR14UN
	1 1/8"	D 3/8"	16NR14UN
12	1 1/4"	D 3/8"	16NR14UN
	1 3/8"-1 1/2"	D 3/8"	16NR14UN
	1 5/8"-1 3/4"	D 3/8"	16NR14UN
	1 7/8"-2"	D 3/8"	16NR14UN
	1/2"	D 3/16"	08NR12UN
	9/16"-11/16"	D 1/4"	11NR12UN
11	3/4"-7/8"	D 3/8"	16NR12UN
	15/16"-1"	D 3/8"	16NR12UN
	1 1/16"-1 3/16"	D 3/8"	16NR12UN
	1 1/4"-1 1/2"	D 3/8"	16NR12UN
	1 9/16"-1 13/16"	D 3/8"	16NR12UN
	1 7/8"-2 1/8"	D 3/8"	16NR12UN
5/8"	D 1/4"U	11UN11UN	



车削内螺纹用刀片推荐表

Inserts Recommendation for A Given Internal Thread Specification

UN美制统一标准螺纹(续) American UN Full Profile(con't)

螺距 Pitch (TPI)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
10	7/8"	D 3/8"	16NR10UN
	1"	D 3/8"	16NR10UN
	1 1/8"	D 3/8"	16NR10UN
	1 1/4"-1 1/2"	D 3/8"	16NR10UN
	1 5/8"-1 3/4"	D 3/8"	16NR10UN
9	1 7/8"-2"	D 3/8"	16NR10UN
	7/8"	D 3/8"	16NR9UN
8	1"	D 3/8"	16NR8UN
	1 1/16"-1 3/16"	D 3/8"	16NR8UN
	1 1/4"	D 3/8"	16NR8UN
	1 5/16"-1 1/2"	D 3/8"	16NR8UN
	1 9/16"-1 13/16"	D 3/8"	16NR8UN
7	1 7/8"-2 1/8"	D 3/8"	16NR8UN
	1 1/8"-1 1/4"	D 1/2"	22NR7UN
6	1 3/8"-1 7/16"	D 1/2"	22NR6UN
	1 1/2"-1 5/8"	D 1/2"	22NR6UN
	1 11/16"	D 1/2"	22NR6UN
	1 3/4"-2"	D 1/2"	22NR6UN
5	2 1/8"	D 1/2"	22NR6UN
4.5	1 3/4"	D 1/2"	22NR5UN
	2"-4 1/2"	D 5/8"	27NR4.5UN

车削内螺纹用刀片推荐表

Inserts Recommendation for A Given Internal Thread Specification

英国惠氏螺纹 W-55° Whitworth

螺距 Pitch (TPI)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
26	5/16"-1/2"	D 3/16"	08NR26W
	9/16"-5/8"	D 1/4"	11NR26W
	1 1/16"	D 1/4"	11NR26W
	3/4"-13/16"	D 3/8"	16NR26W
	7/8"-15/16"	D 3/8"	16NR26W
20	1"-1 3/16"	D 3/8"	16NR26W
	1 1/4"-1 7/16"	D 3/8"	16NR26W
	1 1/2"-1 3/4"	D 3/8"	16NR26W
20	1 7/8"-2"	D 3/8"	16NR26W
	5/8"-11/16"	D 1/4"	11NR20W
	3/4"-13/16"	D 3/8"	16NR20W
	7/8"-1"	D 3/8"	16NR20W
	1 1/16"-1 3/16"	D 3/8"	16NR20W
	1 1/4"-1 7/16"	D 3/8"	16NR20W
	1 1/2"-1 3/4"	D 3/8"	16NR20W
	1 7/8"-3"	D 3/8"	16NR20W
	1 1/16"	D 1/4"	16NR20W
	3/4"-11/16"	D 3/8"	16NR20W
16	7/8"-1"	D 3/8"	16NR20W
	1 1/16"-1 1/8"	D 3/8"	16NR16W
	1 3/16"	D 3/8"	16NR16W
	1 1/4"-1 7/16"	D 3/8"	16NR16W
	1 1/2"-1 3/4"	D 3/8"	16NR16W
14	1 7/8"-4 5/8"	D 3/8"	16NR16W
	4 3/4"-7"	D 3/8"	16NR16W
	5/8"-11/16"	D 1/4"	11NR14W
12	13/16"	D 3/8"	16NR12W
	15/16"-1"	D 3/8"	16NR12W
	1 1/16"-1 3/16"	D 3/8"	16NR12W
	1 1/4"-1 1/2"	D 3/8"	16NR12W
	1 3/5"-1 3/4"	D 3/8"	16NR12W
	1 7/8"-6"	D 3/8"	16NR12W
11	6 1/4"-7"	D 3/8"	16NR12W
	7/8"	D 3/8"	16NR11W
10	1"	D 3/8"	16NR10W



车削内螺纹用刀片推荐表

Inserts Recommendation for A Given Internal Thread Specification

英国惠氏螺纹(续) W-55° Whitworth(cont')

螺距 Pitch (TPI)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
9	7/8"	D 3/8"	16NR9W
	1 1/8"-1 1/14"	D 3/8"	16NR9W
8	1"	D 3/8"	16NR8W
	1 3/16"	D 3/8"	16NR8W
	1 5/16"-1 1/2"	D 3/8"	16NR8W
	1 3/5"-1 7/8"	D 3/8"	16NR8W
	1 9/10"-2 1/4"	D 3/8"	16NR8W
	2 2/5"-7"	D 3/8"	16NR8W
7	1 1/4"	D 1/2"	22NR7W
	1 3/4"-2"	D 1/2"	22NR7W
6	1 5/16"-1 7/16"	D 1/2"	22NR6W
	1 1/2"-1 5/8"	D 1/2"	22NR6W
	1 7/8"-1 9/10"	D 1/2"	22NR6W
	2 1/10"-3 1/10"	D 1/2"	22NR6W
5	3 1/4"-7"	D 1/2"	22NR6W
	1 3/4"	D 1/2"	22NRSW
4.5	3"-3 1/4"	D 1/2"	22NRSW
	2"	D 5/8"	27NR4.5W
4	3 1/2"-4"	D 5/8"	27NR4.5W
	2 1/4"	D 5/8"	27NR4W
	2 1/2"	D 5/8"	27NR4W
	4 1/4"-4 3/4"	D 5/8"	27NR4W
3.5	4 7/8"-7"	D 5/8"	27NR4W
	2 3/4"	D 5/8"U	27UN3.5W
3.25	3"	D 5/8"U	27UN3.5W
	3 1/4"	D 5/8"U	27UN3.25W
3	3 1/2"	D 5/8"U	27UN3W
2.75	3 3/4"-4"	D 5/8"U	27UN3W
2.5	5"	D 5/8"U	27UN2.75W
	6"	D 5/8"V	27VNR2.5W

车削内螺纹用刀片推荐表

Inserts Recommendation for A Given Internal Thread Specification

G螺纹 BSP(55°)

螺距 Pitch (TPI)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
19	G1/4"	D 3/16"	08NR19BSP
	G3/8"	D 1/4"	11NR19BSP
14	G1/2" & G5/8"	D 3/8"	16NR14BSP
	G3/4" & G7/8"	D 3/8"	16NR14BSP
11	G1 & G1 1/8" & G1 1/4"	D 3/8"	16NR11BSP
	G1 1/2"	D 3/8"	16NR11BSP
	G1 3/4"	D 3/8"	16NR11BSP
	G2"	D 3/8"	16NR11BSP
	G2 1/4"	D 3/8"	16NR11BSP
	G2 1/2"	D 3/8"	16NR11BSP
	G2 3/4"	D 3/8"	16NR11BSP
	G3"	D 3/8"	16NR11BSP
	G3 1/2"	D 3/8"	16NR11BSP
	G4"	D 3/8"	16NR11BSP
11	G4 1/2"	D 3/8"	16NR11BSP
	G5"	D 3/8"	16NR11BSP
	G5 1/2"	D 3/8"	16NR11BSP
	G6"	D 3/8"	16NR11BSP

BSPT英国标准锥管螺纹 BSPT 55° British Standard Pipe Thread

螺距 Pitch (mm)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
19	1/4"	D 3/16"	08NR19BSPT
	3/8"	D 1/4"	11NR19BSPT
14	1/2"	D 3/8"	16NR14BSPT
	3/4"	D 3/8"	16NR14BSPT
11	1"	D 3/8"	16NR11BSPT
	1 1/4"	D 3/8"	16NR11BSPT
	1 1/2"	D 3/8"	16NR11BSPT
	2"	D 3/8"	16NR11BSPT
	2 1/2"	D 3/8"	16NR11BSPT
	3"	D 3/8"	16NR11BSPT
	4"	D 3/8"	16NR11BSPT
	5"	D 3/8"	16NR11BSPT
6"	D 3/8"	16NR11BSPT	



车削内螺纹用刀片推荐表

Inserts Recommendation for A Given Internal Thread Specification

NPT美国标准锥管螺纹 NPT-60° National pipe thread

螺距 Pitch (TPI)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
14	1/2"	D 3/8"	16NR14NPT
	3/4"	D 3/8"	16NR14NPT
11.5	1"	D 3/8"	16NR11.5NPT
	1 1/4"	D 3/8"	16NR11.5NPT
	1 1/2"	D 3/8"	16NR11.5NPT
	2"	D 3/8"	16NR11.5NPT
8	2 1/2"	D 3/8"	16NR8NPT
	3"	D 3/8"	16NR8NPT
	3 1/2"	D 3/8"	16NR8NPT
	4"	D 3/8"	16NR8NPT
	5"	D 3/8"	16NR8NPT
	6"	D 3/8"	16NR8NPT
	8"	D 3/8"	16NR8NPT
	10"	D 3/8"	16NR8NPT
	12"	D 3/8"	16NR8NPT

NPTF美国干密封锥管螺纹 NPTF (Dry seal)

螺距 Pitch (mm)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
18	1/4"	D 3/16"	08NR18NPTF
	3/8"	D 1/4"	11NR18NPTF
14	1/2"	D 3/8"	16NR14NPTF
	3/4"	D 3/8"	16NR14NPTF
11.5	1"	D 3/8"	16NR11.5NPTF
	1 1/4"	D 3/8"	16NR11.5NPTF
	1 1/2"	D 3/8"	16NR11.5NPTF
	2"	D 3/8"	16NR11.5NPTF
8	2 1/2"	D 3/8"	16NR8NPTF
	3"	D 3/8"	16NR8NPTF

PG螺纹 PG

螺距 Pitch (mm)	螺纹 Thread	刀片尺寸 Insert Size	刀片 Insert
20	Pg 7	D 3/16"	08NR20PG
18	Pg 9	D 1/4"	11NR18PG
	Pg 11 & Pg 13.5	D 3/8"	16NR18PG
	Pg 16	D 3/8"	16NR18PG
16	Pg 21	D 3/8"	16NR16PG
	Pg 29	D 3/8"	16NR16PG
	Pg 36 & Pg 42 & Pg 48	D 3/8"	16NR16PG