—— 专注于螺纹刀具、切槽(断)刀具 ——

specialized in manufacturing the threading inserts, grooving and parting inserts

成都道勤数控刀具有限公司

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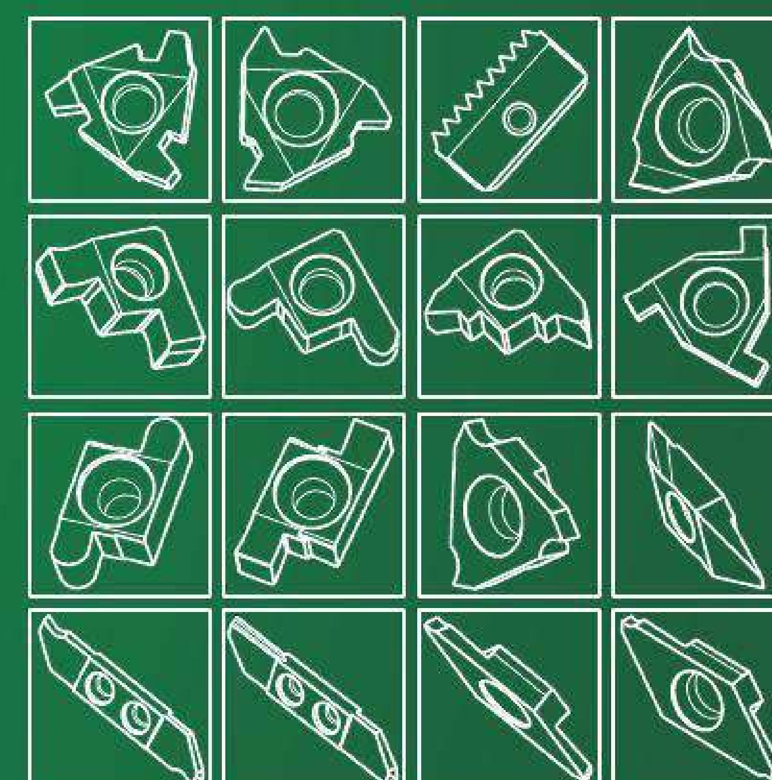
DAOQING 道勤刀具

2015 修正版

DAOQING
道勤刀具

道勤切削刀具

螺纹刀具、切槽(断)刀具



道勤 —— 用心打造每一粒刀片

DAOQING
道勤刀具

公司简介

成都道勤数控刀具有限公司是集研究、开发、生产于一体的现代化高新技术企业，成立于2008年5月，位于西部第一强县的双流县长顺路2段，距机场8公里，交通十分便利。

公司现有专业磨削螺纹刀片的数控磨床多台以及投影仪、电子显微镜等检测设备。公司自成立起就一直致力于公、英、美制螺纹刀片以及石油管螺纹刀片与各种切槽刀片的研发与生产。产品定位于国内中高端市场，采用国外高品质坯体以及世界领先的刃口钝化处理工艺，产品投入市场后得到用户好评，一直供不应求！

我们秉承诚信为本的理念，坚持锐意进取/开发创新的发展精神，致力于把“道勤”打造成为国内一流的刀具品牌！

品质成就道勤品牌，诚信延续你我合作！

Company Profile

Chengdu Daoqin NC Cutting Tools Co., Ltd is a professional manufacturer in designation, development and production of cutting tools. Setting up in May 2008, Daoqin has been already recognized as one of three largest threading insert companies, located in Shuangliu county which is the strongest county in the west of China, 8 kilometers away from airport.Our company has over ten CNC grinding machines which are used for grinding threading inserts professionally; we also have various specialized testing equipments, such as large-sized projectors, electronic microscope, etc. Our company is dedicated to R&D of threading inserts and grooving & parting off inserts since establishment. And we aim at developing mid-market and high-end market's products in the world, via choosing foreign high-quality materials and the world's advanced edge control techniques. Our products are recognized by all customers after being put into the market, and always demand exceeds supply .

Daoqin is committed to become the first-class brand of threading tools in the world with concept of honesty & spirit of creation.

Our slogan is "quality determines the brand of Daoqin; credibility continues our cooperation".

[1]参考：《公制、美制和英制螺纹标准手册》(第三版).全国螺纹标准化技术委员会.中国标准出版社
[2]参考：《螺纹标准汇编》(上)(中)(下).全国螺纹标准化技术委员会.中国标准出版社

目录 Contents



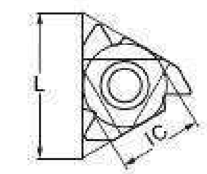



目录 Contents

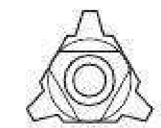
螺纹车刀刀片型号说明 Threading Insert Identification System

1、刀片尺寸 Insert Size

L(mm)	D
06	5/32"
08	3/16"
11	1/4"
16	3/8"
22	1/2"
27	5/8"



2、刀片型式 Insert Style



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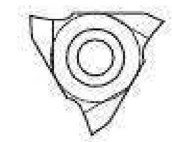
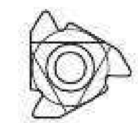
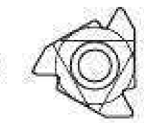


V

3、刀片类型 Type of Insert

E 外螺纹 External

N 内螺纹 Internal

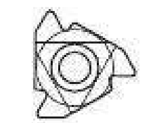
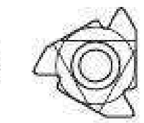
E N

图片为右手刀片
Right Insert(see picture)

4、螺纹旋向 RH/LH Insert

R 右手刀片 Right Hand Insert

L 左手刀片 Left Hand Insert

R L

图片为外螺纹刀片
External Insert(see picture)

16		E	R	1.5	ISO		
1	2	3	4	5	6	7	8

5、螺距 Pitch

完全形
Full Profile Pitch Range

mm	TPI
0.5~6	48~4

局部面截顶形
Partial Profile Pitch Range

	mm	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

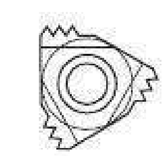
6、螺纹标准 Standard

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
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° 美制干密封螺纹 NPTF
BSPT---55° 英制标准锥管螺纹 British Standard Pipe Thread
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 Trapeze DIN 103
ABUT---美制锯齿形螺纹 American Buttress
RD---消防食品机械圆螺纹 Round DIN 405
RD20400---消防及食品机械圆螺纹 Round DIN 20400
APIRD---API圆螺纹 API Round Casing & Tubing
BUT---API偏梯扣螺纹 API Butress Casing

7、齿数(对梳齿形M) No.of Teeth(for Multitooth Style)

2 3 5 6 8

8、梳齿的刀片型式 Insert Style of Multitooth



M

螺纹车削刀具 THREADING TURNING TOOLS

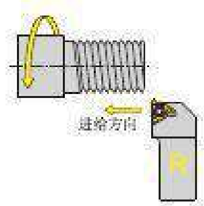
如何选择并正确使用螺纹刀具需进行以下5个步骤:
How to choose and use threading cutters?

首先需要了解:加工外螺纹/内螺纹 You have to know firstly: machining internal & external threads
主轴旋转方向 turning direction of spindle
右旋螺纹/左旋螺纹 right hand & left hand
进给方向 feed direction

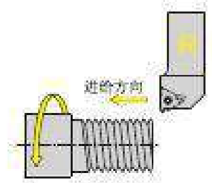
第一步:选择旋转螺纹的加工方法和刀具式样(详见37页)
Firstly choosing machining ways & cutter styles of turning thread (see page37)

外螺纹(右旋螺纹) External (Right Hand)

铁屑向上排-刀杆正向安装
主轴正转(M03)
进给方向--向卡盘方向进给
Scrap iron displaced upward
—tool holders installed forward
Spindle turned forward-M03
Feed direction—feed towards chuck

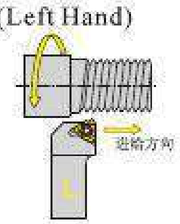


铁屑向下排-刀杆反向安装
主轴正转(M03)
进给方向--向卡盘方向进给
Scrap iron displaced downward
—tool holders installed backward
Spindle turned forward-M03
Feed direction—feed towards chuck

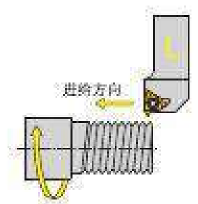


外螺纹(左旋螺纹) External (Left Hand)

铁屑向上排-刀杆正向安装
主轴正转(M03)
进给方向--向顶尖方向进给
Scrap iron displaced upward
—tool holders installed forward
Spindle turned forward-M03
Feed direction—feed towards center

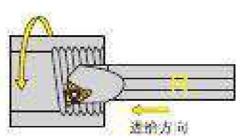


铁屑向上排-刀杆正向安装
主轴正转(M04)
进给方向--向卡盘方向进给
Scrap iron displaced upward
—tool holders installed forward
Spindle turned forward-M03
Feed direction—feed towards chuck

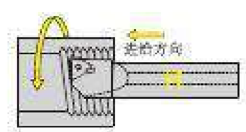


内螺纹(右旋螺纹) Internal (Right Hand)

铁屑向上排-刀杆正向安装
主轴正转(M03)
进给方向--向卡盘方向进给
Scrap iron displaced upward
—tool holders installed forward
Spindle turned forward-M03
Feed direction—feed towards chuck

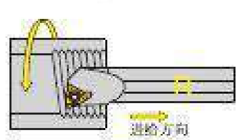


铁屑向下排-刀杆反向安装
主轴反转(M03)
进给方向--向卡盘方向进给
Scrap iron displaced upward
—tool holders installed forward
Spindle turned backforward-M04
Feed direction—feed towards chuck

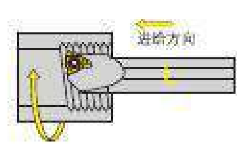


内螺纹(左旋螺纹) Internal (Left Hand)

铁屑向上排-刀杆正向安装
主轴正转(M03)
进给方向--向顶尖方向进给
注:建议更换成带角度的垫片,改变刀具径向倾角,使其加工出的牙型角合格。
Scrap iron displaced upward
—tool holders installed forward
Spindle turned backforward-M04
Feed direction—feed towards chuck
Note: It is good for machining perfect tooth by using parallel with reasonable angle and by changing the radial direction of cutters.



铁屑向上排-刀杆正向安装
主轴反转(M04)
进给方向--向卡盘方向进给
Scrap iron displaced upward
—tool holders installed forward
Spindle turned backforward-M04
Feed direction—feed towards chuck



第二步:挑选适合应用的刀片 Secondly choosing applicable inserts

刀片尺寸 Insert Dimension	目录编号 Model No.		材质代号 Material Type			
			DK110	DP220	DM215	
11	11E...	11N...	●	●	●	
16	16E...	16N...	●	●	●	
22	22E...	22N...	●	●	●	
	MTTR43...		●	●	●	

第三步:选择材质与切削参数 Thirdly choosing suitable material and cutting parameter

DK110:适合加工有色金属,推荐线速度Vc:(100~300)m/min
DP220:适合加工各种钢件,推荐线速度Vc:(100~150)m/min
DM215:适合加工不锈钢,推荐线速度Vc:(60~120)m/min,也可加工钢件,推荐线速度Vc:(100~180)m/min

DK110 is the top choice for cast iron and non-ferrous metals (e.g. aluminum alloy), recommended Vc: 100~300m/min
DP220 is the top choice for various steel, recommended Vc: 100~150m/min
DM215 is the top choice for stainless steels as well as steel, recommended Vc:60~120m/min for stainless steel; Vc:100~180m/min for steel

第四步:从样本选择适合的刀具 Fourthly choosing suitable cutters according to catalogue

所需资料: Data required:
1. 加工内螺纹还是外螺纹 1 Internal or external thread you need machining.
2. 螺纹底孔直径(加工内螺纹时) 2 Under port's diameter when you machining internal thread.
3. 刀具样式(详见第一步) 3 Cutter style (see the first step)
4. 刀片规格 4 Inserts Specification
5. 刀杆规格 5 Tool holders Specification

第五步:选择适合的刀垫 Finally choosing applicable anvil

根据螺纹牙型大小,螺距直径,螺旋方法,选择垫片。
Choosing applicable anvil according to thread tooth size, pitch diameter and screw ways.

刀片材质说明
Instruction for Insert Material

← Wear resistance　　　　Toughness →

	01	10	20	30	40
P 钢 steels		DP220	DP220		
			DM215	DM215	
M 不锈钢 stainless steel		DP220	DP220		
			DM215	DM215	
K 铸铁 cast iron			DM215	DM215	
		DP220	DP220		
N 有色金属 non-ferrous metals		DK110	DK110		


DP220


PM125


DM215


DK110

DP220(P30,M40)　　　　Layer system:PVD TiN
DP220 钢件各种场合下的广泛应用，具有较好的韧性！推荐使用线速度Vc：90~180m/min
DP220 is good at all application with perfect toughness. Recommended parameter Vc: 90~180m/min

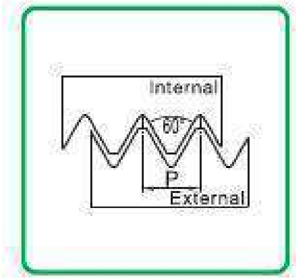
PM125(M25,P20)　　　　Layer system:PVD TiAIN
PM125钢件不锈钢通用材质，耐高温性能提升，适应更高转速的加工场合
加工不锈钢时推荐使用线速度Vc：80~140m/min，加工钢件时推荐使用线速度Vc：120~180m/min
PM125 apply to stainless steel and steel,thermostable,superior to high speed machining high speed. Recommended parameter Vc:80~140m/min for stainless steel; Vc:120~180m/min for steel

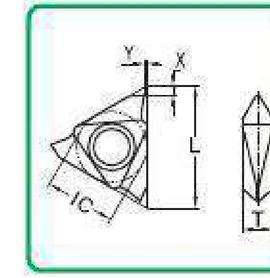
DM215(M25,P20)　　　　Layer system:PVD TiAIN
DM215不锈钢材质的首选，但是在钢件的中高速加工中也有比较优异的表现！也可以加工铸铁！
加工不锈钢时推荐使用线速度Vc：60~120m/min，加工钢件时推荐使用线速度Vc：100~ 80m/min
DM215 is the first choice in stainless steels, superior to other steels machining under medium and high speed. Recommended parameter Vc:60~120m/min for stainless steel; Vc:100~180m/min for steel

DK110(K15)　颗粒度：Grain size:0.6μm　　硬度：Hardness:HV1670
DK110铝合金等有色金属材质的首选！推荐使用线速度Vc：100~300m/min
DK110 is the top choice in cast iron and non-ferrous metals (e.g. aluminum alloy) machining. Recommended parameter Vc:100~300m/min

60° 立装泛用型螺纹刀片 Partial Profile V-style Inserts


图片为右手刀片
Right Insert(see picture)



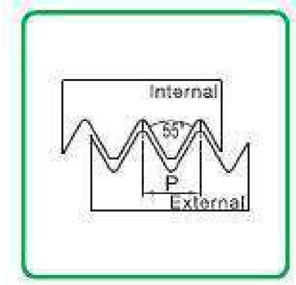


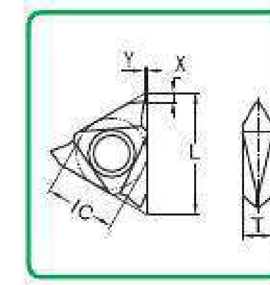
型号 Ordering Code	材质 Material Code		型 号 Ordering Code	材质 Material Code		加工螺距范围 Pitch		刀片尺寸 Insert Size		尺寸 Dimensions (mm)		
右手刀片 Right Hand	DP220	DM215	左手刀片 Left Hand	DP220	DM215	mm	tpi	IC	L/inch	r	X	Y
MTTR 436001	○	●	MTTL 436001		○	1.0~1.75	24-14	1/2"	.87	0.1	1.7	0.29
MTTR 436002	○	●	MTTL 436002		○	2.0~2.5	13-10			0.2	1.7	0.29
MTTR 436003	○	●	MTTL 436003		○	3.0~3.5	9-7			0.3	1.7	0.29
MTTR 436004	○	●	MTTL 436004		○	4.0~4.5	6-5			0.4	1.7	0.29

●:常备库存(主推) Stock standard(main)　○:一般库存 Stock standard
订货示例：MTTR 436002 DM215 10片　Ordering example：MTTR 436002 DM215 10pcs

55° 立装泛用型螺纹刀片 Partial Profile V-style Inserts


图片为右手刀片
Right Insert(see picture)



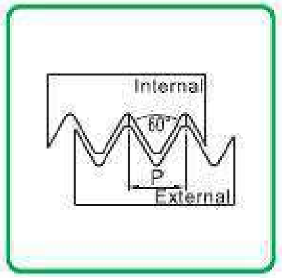


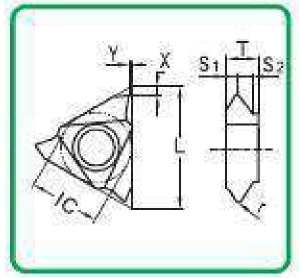
型号 Ordering Code	材质 Material Code		型 号 Ordering Code	材质 Material Code		加工螺距范围 Pitch		刀片尺寸 Insert Size		尺寸 Dimensions (mm)		
右旋螺纹 Right Hand	DP220	DM215	左旋螺纹 Left Hand	DP220	DM215	mm	tpi	IC	L/inch	r	X	Y
MTTR 435501		○	MTTL 435501			1.0~1.75	24-14	1/2"	.87	0.1	1.7	0.29
MTTR 435502		○	MTTL 435502			2.0~2.5	13-10			0.2	1.7	0.29
MTTR 435503		○	MTTL 435503			3.0~3.5	9-7			0.3	1.7	0.29
MTTR 435504		○	MTTL 435504			4.0~4.5	6-5			0.4	1.7	0.29

●:常备库存(主推) Stock standard(main)　○:一般库存 Stock standard
订货示例：MTTR 435502 DM215 10片　Ordering example：MTTR 435502 DM215 10pcs

TTX 立装泛用型螺纹刀片 TTX Partial Profile V-style Inserts

图片为右手刀片
Right Insert(see picture)





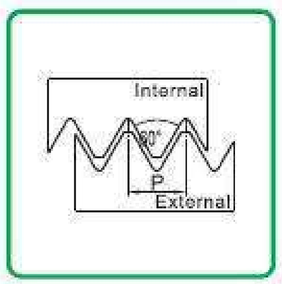
型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	PM125	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	PM125	加工螺距范围 Pitch mm	tpi	尺寸 Dimensions (mm) IC	L	T	S_1	S_2	r	适用刀杆 tool holders 详见P45 SeeP45
TTX32R60005	○	●	TTX32L60005	○	○	0.5~1.0	48~32	9.525	16	3.18	0.6	1.12	0.05	
TTX32R6001	○	●	TTX32L6001	○	○	1.0~2.0	28~14	9.525	16	3.18	1.1	1.62	0.1	KTT...-16
TTX32R5501	○	●	TTX32L5501	○	○	-	28~19	9.525	16	3.18	0.75	1.01	0.1	

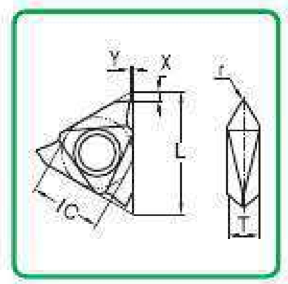
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例: TTX32R6001 PM125 10片 Ordering example: TTX32R6001 PM125 10pcs

TT 立装泛用型螺纹刀片 TT Partial Profile V-style Inserts

图片为右手刀片
Right Insert(see picture)





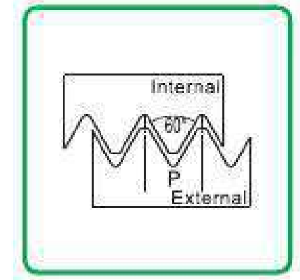
型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	PM125	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	PM125	加工螺距范围 Pitch mm	tpi	尺寸 Dimensions (mm) IC	L	T	r	适用刀杆 tool holders 详见P45 SeeP45
TT32R6000	○	●	TT32L6000	○	○	0.5~1.0	48~32	9.525	16	3.18	0	
TT32R6001	○	●	TT32L6001	○	○	1.0~2.5	28~14	9.525	16	3.18	0.1	
TT32R6002	○	●	TT32L6002	○	○	1.5~2.5	16~10	9.525	16	3.18	0.2	
TT32R6003	○	●	TT32L6003	○	○	2.5	11~10	9.525	16	3.18	0.3	KTT...-16
TT32R5501	○	●	TT32L5501	○	○	-	28~10	9.525	16	3.18	0.1	
TT32R5502	○	●	TT32L5502	○	○	-	14~10	9.525	16	3.18	0.2	

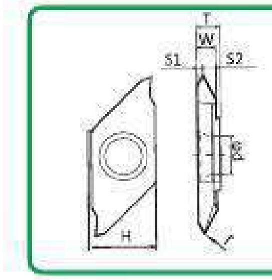
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例: TT32R6001 PM125 10片 Ordering example: TT32R6001 PM125 10pcs

TKFT 立装泛用型螺纹刀片 TKFT Partial Profile V-sytle Inserts

图片为右手刀片
Right Insert(see picture)





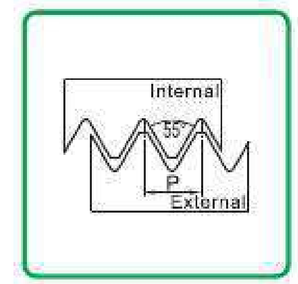
型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	PM125	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	PM125	加工螺距范围 Pitch mm	tpi	尺寸 Dimensions (mm) H	T	W	S1	S2	r	适用刀杆 tool holders 详见P99 SeeP99
TKFT12RA60005	○	●	TKFT12LA60005	○	○	-	28~19	8.7	3.0	2.5	0.4	2.1	0.05	
TKFT12RB60005	○	●	TKFT12LB60005	○	○	0.5~1.0	48~32	8.7	3.0	2.5	2.1	0.4	0.05	
TKFT12RN6001	○	●	TKFT12LN6001	○	○	1.0~2.0	28~14	8.7	3.0	2.5	1.25	1.25	0.1	KTKFR...-12
TKFT12RA55005	○	●	TKFT12LA55005	○	○	-	28~19	8.7	3.0	2.5	0.8	1.7	0.05	
TKFT12RB55005	○	●	TKFT12LB55005	○	○	0.5~1.0	48~32	8.7	3.0	2.5	1.7	0.8	0.05	

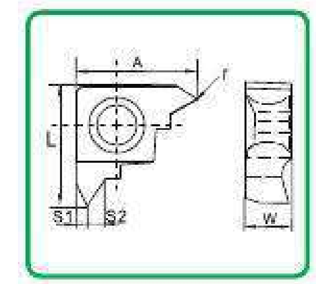
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例: TKFT12RN6001 PM125 10片 Ordering example: TKFT12RN6001 PM125 10pcs

GE 螺纹刀片 GE Threading Insert

图片为右手刀片
Right Insert(see picture)





型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	PM125	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	PM125	加工螺 距范围 Pit ch mm	tpi	尺寸 Dimensions (mm) A	L	W	r	适用刀杆 tool holders 详见P96 SeeP96
GER6001-A	○	●	GEL6001-A	○	○	0.5~1.5	48~16	6.69	6.5	2.58	0.05	SIGE...A
GER5501-A	○	●	GEL5501-A	○	○	0.5~1.5	48~16	6.69	6.5	2.58	0.05	
GER6001-B	○	●	GEL6001-B	○	○	0.5~1.5	48~16	8.46	8.2	3.18	0.1	
GER6002-B	○	●	GEL6002-B	○	○	1.0~2.5	25~10	8.46	8.2	3.18	0.05	SIGE...B
GER5501-B	○	●	GEL5501-B	○	○	0.5~1.5	48~16	8.46	8.2	3.18	0.05	
GER2.0TR-B	○	●	GEL2.0TR-B	○	○	2.0	—	8.46	8.2	3.18	0.1	
GER3.0TR-B	○	●	GEL3.0TR-B	○	○	3.0	—	8.46	8.2	3.18	0.1	SIGE...B
★GER4.0TR-B	○	○	★GEL4.0TR-B	○	○	4.0	—	8.46	8.2	3.18	0.2	
GER3.0TR-C	○	●	GEL3.0TR-C	○	○	3.0	—	5.8	11.5	4.0	0.1	SIGE...C
GER4.0TR-C	○	●	GEL4.0TR-C	○	○	4.0	—	5.8	11.5	4.0	0.2	
GER4.0TR-D	○	●	GEL4.0TR-D	○	○	4.0	—	6.8	16.5	5.0	0.2	
GER5.0TR-D	○	●	GEL5.0TR-D	○	○	5.0	—	6.8	16.5	5.0	0.2	SIGE...D
GER6.0TR-D	○	●	GEL6.0TR-D	○	○	6.0	—	6.8	16.5	5.0	0.2	

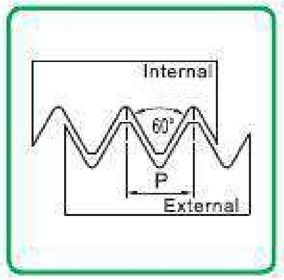
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

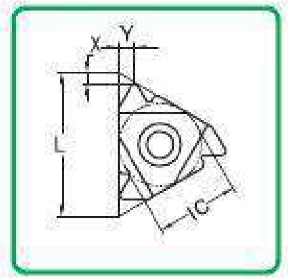
订货示例: GER6001-A PM125 10片 Ordering example:GER6001-A PM125 10pcs

★ 建议该刀片只能用作精修梯形螺纹尺寸时使用

60° 泛用型螺纹刀片 Partial Profile 60° Threading Insert

外螺纹 External





图片为右手刀片
Right Insert(see picture)

型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
11ERA60	○	●	●	11ELA60			○	0.5-1.5	48-16	1/4"	.43	0.07	.029	.035
16ERA60	○	●	●	16ELA60			○	0.5-1.5	48-16			0.07	.031	.035
16ERAG60	○	●	●	16ELAG60			○	0.5-3.0	48-8	3/8"	.63	0.07	.047	.067
16ERG60	○	●	●	16ELG60			○	1.75-3.0	18-8			0.25	.047	.067
22ERN60	○	●	●	22ELN60			○	3.5-5.0	7-5	1/2"	.87	0.4	.067	.098
27ERQ60	○	●	●	27ELQ60			○	5.5-6.0	4.5-4	5/8"	1.06	0.68		
27VERV60	○	●	●	27VELV60			○	6.0-10	4-2.5			0.68		

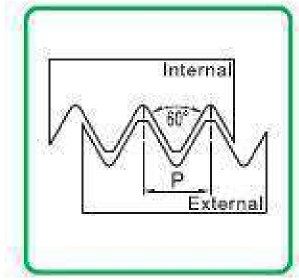
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

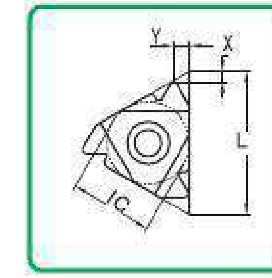
订货示例：16ERAG60 DM215 10片 Ordering example：16ERAG60 DM215 10pcs

★27V刀片为立装型，形状参考05页MTTR系列

60° 泛用型螺纹刀片 Partial Profile 60° Threading Insert

内螺纹 Internal





图片为右手刀片
Right Insert(see picture)

型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
06NRA60				06NLA60				0.5-1.5	48-16	5/32"	.271	0.07	.03	.031
08NRA60				08NLA60				0.5-1.5	48-16	3/16"	.325	0.07	.03	.031
11NRA60	○	●	●	11NLA60			○	0.5-1.5	48-16	1/4"	.43	0.07	.031	.035
16NRA60	○	●	●	16NLA60			○	0.5-1.5	48-16			0.07	.031	.035
16NRAG60	○	●	●	16NLAG60			○	0.5-3.0	48-8	3/8"	.63	0.07	.047	.067
16NRG60	○	●	●	16NLG60			○	1.75-3.0	18-8			0.2	.047	.067
22NRN60	○	●	●	22NLN60			○	3.5-5.0	7-5	1/2"	.87	0.4	.067	.098
27NRQ60	○	●	●	27ELQ60			○	5.5-6.0	4.5-4	5/8"	1.06	0.61		
27VNRV60	○	●	●	27VELV60			○	6.0-10	4-2.5			0.61		

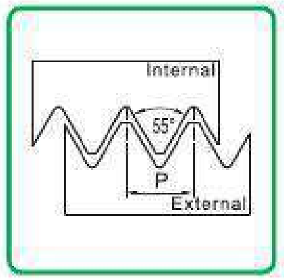
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

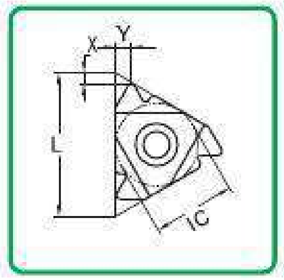
订货示例：16NRAG60 DM215 10片 Ordering example：16NRAG60 DM215 10pcs

★27V刀片为立装型，形状参考05页MTTR系列

55° 泛用型螺纹刀片 Partial Profile 55° Threading Insert

外螺纹 External





图片为右手刀片
Right Insert(see picture)

型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
11ERA55	○	●	●	11ELA55			○	0.5-1.5	48-16	1/4"	.43	0.07	.031	.035
16ERA55	○	●	●	16ELA55			○	0.5-1.5	48-16			0.07	.031	.035
16ERAG55	○	●	●	16ELAG55			○	0.5-3.0	48-8	3/8"	.63	0.07	.047	.067
16ERG55	○	●	●	16ELG55			○	1.75-3.0	18-8			0.25	.047	.067
22ERN55	○	●	●	22ELN55			○	3.5-6.0	7-5	1/2"	.87	0.4	.067	.098
27ERQ55	○	●	●	27ELQ55			○	5.5-6.0	4.5-4	5/8"	1.06	0.68		
27VERV55	○	●	●	27VELV55			○	6.0-9.0	4-2.5			0.68		

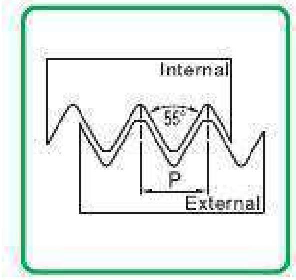
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

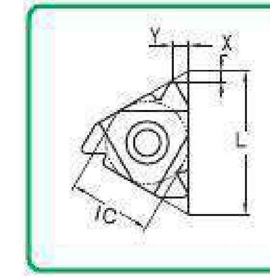
订货示例：16ERAG55 DM215 10片 Ordering example：16ERAG55 DM215 10pcs

★27V刀片为立装型，形状参考05页MTTR系列

55° 泛用型螺纹刀片 Partial Profile 55° Threading Insert

内螺纹 Internal





图片为右手刀片
Right Insert(see picture)

型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
06NRA55				06NLA55				0.5-1.5	48-16	5/32"	.271	0.06	.03	.035
08NRA55				08NLA55				0.5-1.5	48-16	3/16"	.325	0.06	.03	.035
11NRA55	○	●	●	11NLA55			○	0.5-1.5	48-16	1/4"	.43	0.06	.031	.035
16NRA55	○	●	●	16NLA55			○	0.5-1.5	48-16			0.06	.031	.035
16NRAG55	○	●	●	16NLAG55			○	0.5-3.0	48-8	3/8"	.63	0.06	.047	.067
16NRG55	○	●	●	16NLG55			○	1.75-3.0	18-8			0.2	.047	.067
22NRN55	○	●	●	22NLN55			○	3.5-6.0	7-5	1/2"	.87	0.4	.067	.098
27NRQ55	○	●	●	27NLQ55			○	5.5-6.0	4.5-4	5/8"	1.06	0.61		
27VNRV55	○	●	●	27VNLV55			○	6.0-9.0	4-2.5			0.61		

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

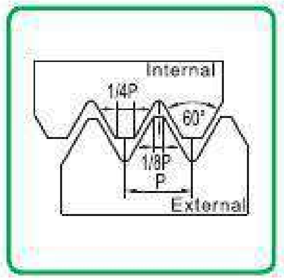
订货示例：16NRAG55 DM215 10片 Ordering example：16NRAG55 DM215 10pcs

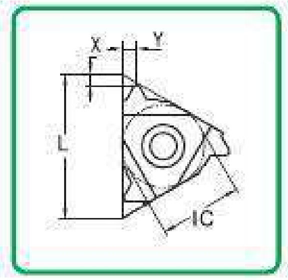
★27V刀片为立装型，形状参考05页MTTR系列

ISO标准型螺纹刀片 ISO Metric

外螺纹 External

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	M215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions [illegible]	X (inch)	Y (inch)
11ER0.50 ISO				11EL0.50 ISO				0.50				0.07	.024	.016
11ER0.75 ISO	●	●	●	11EL0.75 ISO			○	0.75				0.11	.024	.024
11ER1.00 ISO	●	●	●	11EL1.00 ISO			○	1.00				0.14	.027	.027
11ER1.25 ISO	●	●	●	11EL1.25 ISO			○	1.25		1/4"	.43	0.18	.031	.035
11ER1.50 ISO	●	●	●	11EL1.50 ISO			○	1.50				0.22	.031	.039
11ER1.75 ISO	●	●	●	11EL1.75 ISO			○	1.75				0.25	.035	.047
11ER2.00 ISO	●	●	●	11EL2.00 ISO			○	2.00				0.29	.039	.051
16ER0.50 ISO	○	○	○	16EL0.50 ISO				0.50				0.07	.024	.016
16ER0.75 ISO	●	●	●	16EL0.75 ISO			○	0.75				0.07	.024	.024
16ER1.00 ISO	●	●	●	16EL1.00 ISO			●	1.00				0.1	.027	.027
16ER1.25 ISO	●	●	●	16EL1.25 ISO			●	1.25				0.12	.031	.035
16ER1.50 ISO	●	●	●	16EL1.50 ISO			●	1.50				0.18	.031	.039
16ER1.75 ISO	●	●	●	16EL1.75 ISO			●	1.75		3/8"	.63	0.23	.035	.047
16ER2.00 ISO	●	●	●	16EL2.00 ISO			●	2.00				0.25	.039	.051
16ER2.50 ISO	●	●	●	16EL2.50 ISO			●	2.50				0.36	.043	.059
16ER3.00 ISO	●	●	●	16EL3.00 ISO			●	3.00				0.43	.047	.063
16ER3.50 ISO	○	○	○	16EL3.50 ISO				3.50				0.51	.047	.063
22ER3.00 ISO	○	○	○	22EL3.00 ISO				3.00				0.43	.047	.063
22ER3.50 ISO	○	●	●	22EL3.50 ISO			○	3.50				0.51	.063	.09
22ER4.00 ISO	○	●	●	22EL4.00 ISO			●	4.00				0.58	.063	.09
22ER4.50 ISO	○	●	●	22EL4.50 ISO			○	4.50		1/2"	.87	0.65	.067	.094
22ER5.00 ISO	○	●	●	22EL5.00 ISO			●	5.00				0.75	.067	.098
22ER5.50 ISO			○	22EL5.50 ISO				5.50				0.79	.067	.098
22ER6.00 ISO		●	●	22EL6.00 ISO				6.00				0.87	.067	.098
27ER5.50 ISO			○	27EL5.50 ISO				5.50				0.79		
27ER6.00 ISO		●	●	27EL6.00 ISO				6.00				0.87		
27VER6.00 ISO			○	27VEL6.00 ISO				6.00		5/8"	1.06	0.87		
27VER8.00 ISO		●	●	27VEL8.00 ISO				8.00						
27VER10.0ISO			○	27VEL10.0ISO				10.0						

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

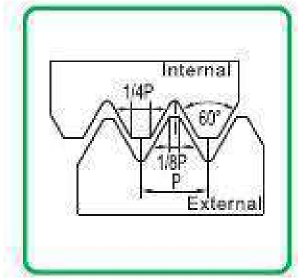
订货示例：16ER1.50ISO DM215 10片 Ordering example：16ER1.50ISO DM215 10pcs

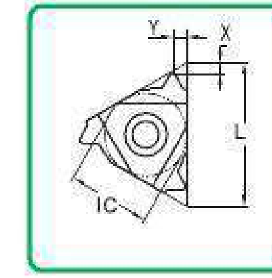
★27V刀片为立装型，形状参考05页MTTR系列

ISO标准型螺纹刀片 ISO Metric

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	M215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions [illegible]	X (inch)	Y (inch)
11NR0.50 ISO				11NL0.50 ISO				0.50				0.04	.024	.016
11NR0.75 ISO	○	○	●	11NL0.75 ISO			○	0.75				0.05	.024	.024
11NR1.00 ISO	○	●	●	11NL1.00 ISO			○	1.00				0.07	.024	.027
11NR1.25 ISO	○	●	●	11NL1.25 ISO			○	1.25		1/4"	.43	0.09	.031	.035
11NR1.50 ISO	○	●	●	11NL1.50 ISO			○	1.50				0.11	.031	.039
11NR1.75 ISO	○	●	●	11NL1.75 ISO			○	1.75				0.13	.035	.047
11NR2.00 ISO	○	●	●	11NL2.00 ISO			○	2.00				0.14	.039	.051
16NR0.50 ISO				16NL0.50 ISO				0.50				0.04	.024	.016
16NR0.75 ISO	○	●	●	16NL0.75 ISO			○	0.75				0.05	.024	.024
16NR1.00 ISO	●	●	●	16NL1.00 ISO			●	1.00				0.07	.024	.027
16NR1.25 ISO	●	●	●	16NL1.25 ISO			●	1.25				0.09	.031	.035
16NR1.50 ISO	●	●	●	16NL1.50 ISO			●	1.50				0.11	.031	.039
16NR1.75 ISO	●	●	●	16NL1.75 ISO			●	1.75		3/8"	.63	0.13	.035	.047
16NR2.00 ISO	●	●	●	16NL2.00 ISO			●	2.00				0.14	.039	.051
16NR2.50 ISO	●	●	●	16NL2.50 ISO			●	2.50				0.18	.043	.059
16NR3.00 ISO	●	●	●	16NL3.00 ISO			●	3.00				0.22	.043	.059
16NR3.50 ISO	○	○	○	16NL3.50 ISO				3.50				0.25	.043	.059
22NR3.00 ISO	○	○	○	22NL3.00 ISO				3.00				0.22	.043	.059
22NR3.50 ISO	○	●	●	22NL3.50 ISO			○	3.50				0.25	.063	.09
22NR4.00 ISO	○	●	●	22NL4.00 ISO			●	4.00				0.29	.063	.09
22NR4.50 ISO	○	●	●	22NL4.50 ISO			○	4.50		1/2"	.87	0.32	.063	.094
22NR5.00 ISO	○	●	●	22NL5.00 ISO			●	5.00				0.36	.063	.094
22NR5.50 ISO			○	22NL5.50 ISO				5.50				0.4	.063	.094
22NR6.00 ISO		●	●	22NL6.00 ISO				6.00				0.43	.063	.094
27NR5.50 ISO			○	27NL5.50 ISO				5.50				0.4		
27NR6.00 ISO		●	●	27NL6.00 ISO				6.00				0.43		
27VNR6.00 ISO			○	27VNL6.00 ISO				6.00		5/8"	1.06	0.43		
27VNR8.00 ISO		●	●	27VNL8.00 ISO				8.00						
27VNR10.0ISO			○	27VNL10.0ISO				10.0						

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

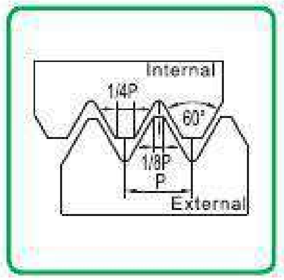
订货示例：16NR1.50ISO DM215 10片 Ordering example：16NR1.50ISO DM215 10pcs

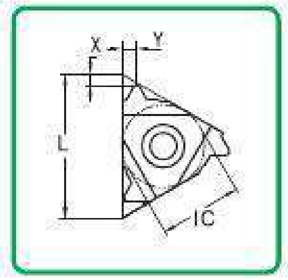
★27V刀片为立装型，形状参考05页MTTR系列

UN-60° 美制统一标准型螺纹刀片 60° American UN NC NF NEF NS

外螺纹 External

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r(mm)	X(inch)	Y(inch)
11ER32UN		○	○	11EL32UN				0.794	32			0.13	.024	.024
11ER28UN	○	○	○	11EL28UN				0.907	28			0.13	.024	.027
11ER24UN	○	○	●	11EL24UN			○	1.058	24			0.16	.027	.031
11ER20UN	○	○	●	11EL20UN			○	1.270	20			0.18	.031	.035
11ER18UN	○	○	●	11EL18UN			○	1.411	18	1/4"	.43	0.18	.035	.039
11ER16UN	○	○	●	11EL16UN			○	1.588	16			0.23	.039	.043
11ER14UN	○	○	●	11EL14UN			○	1.814	14			0.26	.043	.047
11ER12UN	○	○	●	11EL12UN			○	2.117	12			0.3	.043	.055
16ER32UN		○	○	16EL32UN				0.794	32			0.13	.024	.024
16ER28UN	○	○	●	16EL28UN				0.907	28			0.13	.024	.027
16ER24UN	○	○	●	16EL24UN			○	1.058	24			0.16	.027	.031
16ER20UN	○	○	●	16EL20UN			○	1.270	20			0.18	.031	.035
16ER18UN	○	○	●	16EL18UN			○	1.411	18			0.18	.035	.039
16ER16UN	○	○	●	16EL16UN			○	1.588	16	3/8"	.63	0.23	.039	.043
16ER14UN	○	○	●	16EL14UN			○	1.814	14			0.26	.043	.047
16ER12UN	○	○	●	16EL12UN			○	2.117	12			0.3	.043	.055
16ER11UN				16EL11UN				2.309	11			0.33	.043	.055
16ER10UN	○	○	○	16EL10UN				2.540	10			0.36	.043	.059
16ER9UN				16EL9UN				2.822	9			0.41	.047	.059
16ER8UN	○	○	●	16EL8UN			○	3.175	8			0.46	.047	.063
22ER7UN		○	●	22EL7UN			○	3.629	7			0.52	.047	.063
22ER6UN		○	●	22EL6UN			○	4.233	6			0.61	.047	.063
22ER5UN		○	●	22EL5UN			○	5.080	5	1/2"	.87	0.74	.057	.073
22ER4.5UN		○	●	22EL4.5UN				5.644	4.5			0.83	.057	.073
22ER4UN		○	●	22EL4UN				6.350	4			0.87	.057	.073
27ER4.5UN		○	●	27EL4.5UN				5.644	4.5					
27ER4UN		○	●	27EL4UN				6.350	4	5/8"	1.06			
27VER4UN		○	●	27VEL4UN				6.350	4					
27VER3UN		○	●	27VEL3UN				8.466	3					

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16ER14UN DM215 10片 Ordering example：16ER14UN DM215 10pcs

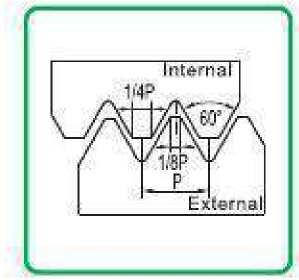
★27V刀片为立装型，形状参考05页MTTR系列

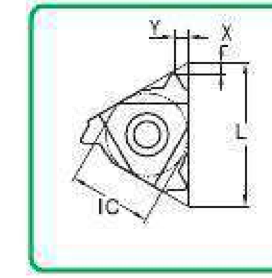
公、英、美制螺纹刀具 THREADING TOOLS DAQING

UN-60° 美制统一标准型螺纹刀片 60° American UN NC NF NEF NS

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r(mm)	X(inch)	Y(inch)
11NR32UN		○	○	11NL32UN			○	0.794	32			0.07	.024	.024
11NR28UN	○	○	○	11NL28UN			○	0.907	28			0.07	.024	.024
11NR24UN	○	○	●	11NL24UN			○	1.058	24			0.08	.027	.031
11NR20UN	○	○	●	11NL20UN			○	1.270	20			0.09	.031	.035
11NR18UN	○	○	●	11NL18UN			○	1.411	18	1/4"	.43	0.1	.031	.039
11NR16UN	○	○	●	11NL16UN			○	1.588	16			0.11	.035	.043
11NR14UN	○	○	●	11NL14UN			○	1.814	14			0.13	.035	.047
11NR12UN	○	○	●	11NL12UN			○	2.117	12			0.16	.043	.055
16NR32UN				16NL32UN				0.794	32			0.07	.024	.024
16NR28UN				16NL28UN				0.907	28			0.07	.024	.024
16NR24UN				16NL24UN				1.058	24			0.08	.027	.031
16NR20UN	○	○	●	16NL20UN			○	1.270	20			0.09	.031	.035
16NR18UN	○	○	●	16NL18UN			○	1.411	18			0.1	.031	.039
16NR16UN	○	○	●	16NL16UN			○	1.588	16	3/8"	.63	0.11	.035	.043
16NR14UN	○	○	●	16NL14UN			○	1.814	14			0.13	.035	.047
16NR12UN	○	○	●	16NL12UN			○	2.117	12			0.16	.043	.055
16NR11UN				16NL11UN				2.309	11			0.16	.043	.055
16NR10UN	○	○	●	16NL10UN			○	2.540	10			0.18	.043	.059
16NR9UN				16NL9UN				2.822	9			0.2	.043	.059
16NR8UN	○	○	●	16NL8UN			○	3.175	8			0.23	.043	.059
22NR7UN		○	●	22NL7UN			○	3.629	7			0.23	.047	.065
22NR6UN		○	●	22NL6UN			○	4.233	6			0.31	.047	.065
22NR5UN		○	●	22NL5UN			○	5.080	5	1/2"	.87	0.37	.057	.072
22NR4.5UN		○	●	22NL4.5UN				5.644	4.5			0.42	.057	.072
22NR4UN		○	●	22NL4UN				6.350	4			0.43	.057	.072
27NR4.5UN		○	●	27NL4.5UN				5.644	4.5					
27NR4UN		○	●	27NL4UN				6.350	4	5/8"	1.06			
27VNR4UN		○	●	27VNL4UN				6.350	4					
27VNR3UN		○	●	27VNL3UN				8.466	3					

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

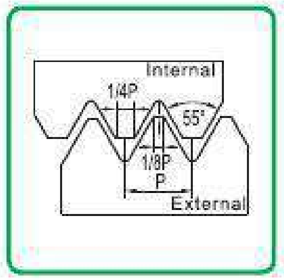
订货示例：16NR14UN DM215 10片 Ordering example：16NR14UN DM215 10pcs

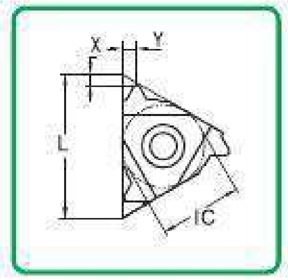
★27V刀片为立装型，形状参考05页MTTR系列

螺纹车削刀具 THREADING TURNING TOOLS

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

外螺纹 External





图片为右手刀片
Right Insert(see picture)

型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r(mm)	X(inch)	Y(inch)
11ER28W		○	●	11EL28W				0.907	28			0.1	.024	.027
11ER26W				11EL26W				0.977	26			0.1	.024	.027
11ER24W		○	●	11EL24W				1.058	24			0.1	.024	.027
11ER20W		○	●	11EL20W				1.27	20			0.17	.031	.035
11ER19W		○	●	11EL19W				1.337	19	1/4"	.43	0.18	.031	.039
11ER18W		○	●	11EL18W				1.411	18			0.19	.031	.039
11ER16W		○	●	11EL16W				1.588	16			0.22	.035	.043
11ER14W		○	●	11EL14W				1.814	14			0.25	.039	.047
16ER28W		○	●	16EL28W				0.907	13			0.1	.024	.027
16ER26W				16EL26W				0.977	26			0.1	.024	.027
16ER24W		○	●	16EL24W				1.058	24			0.1	.024	.027
16ER20W		○	●	16EL20W				1.27	20			0.17	.031	.035
16ER19W		○	●	16EL19W			○	1.337	19			0.18	.031	.039
16ER18W		○	●	16EL18W				1.411	18			0.19	.031	.039
16ER16W		○	●	16EL16W				1.588	16	3/8"	.63	0.22	.035	.043
16ER14W		○	●	16EL14W			○	1.814	14			0.25	.039	.047
16ER12W		○	●	16EL12W				2.117	12			0.29	.043	.055
16ER11W		○	●	16EL11W			○	2.309	11			0.32	.043	.059
16ER10W		○	●	16EL10W				2.54	10			0.35	.043	.059
16ER9W		○	●	16EL9W			○	2.822	9			0.39	.047	.067
16ER8W		○	●	16EL8W				3.175	8			0.44	.047	.059
16ER7W		○	●	16EL7W				3.629	7			0.5	.047	.059
22ER7W		○	●	22EL7W				3.629	7			0.5	.063	.088
22ER6W		○	●	22EL6W				4.233	6			0.58	.063	.088
22ER5W		○	●	22EL5W				5.08	5	1/2"	.87	0.7	.063	.088
22ER4.5W		○	●	22EL4.5W				5.644	4.5			0.77	.071	.091
22ER4W		○	●	22EL4W				6.35	4			0.87	.071	.091
27ER4.5W		○	●	27EL4.5W				5.644	4.5			0.77		
27ER4W		○	●	27EL4W				6.350	4			0.87		
27VER4W		○	●	27VEL4W				6.350	4	5/8"	1.06			
27VER3W		○	●	27VEL3W				8.466	3					
27VER2.5W		○	●	27VEL2.5W				10.16	2.5					

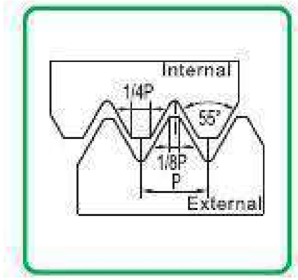
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

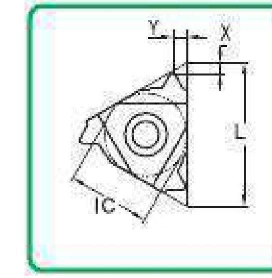
订货示例：16ER14W DM215 10片 Ordering example：16ER14W DM215 10pcs

★27V刀片为立装型，形状参考05页MTTR系列

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

内螺纹 Internal





图片为右手刀片
Right Insert(see picture)

型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r(mm)	X(inch)	Y(inch)
11NR28W		○	●	11NL28W				0.907	28			0.1	.031	.035
11NR26W				11NL26W				0.977	26			0.1	.031	.035
11NR24W		○	○	11NL24W				1.058	24			0.1	.031	.035
11NR20W		○	○	11NL20W				1.27	20			0.17	.031	.035
11NR19W		○	●	11NL19W			○	1.337	19	1/4"	.43	0.18	.031	.035
11NR18W		○	○	11NL18W				1.411	18			0.19	.031	.035
11NR16W		○	○	11NL16W				1.588	16			0.22	.035	.039
11NR14W		○	●	11NL14W			○	1.814	14			0.25	.035	.039
16NR28W				16NL28W				0.907	13			0.1	.031	.035
16NR26W				16NL26W				0.977	26			0.1	.031	.035
16NR24W				16NL24W				1.058	24			0.1	.031	.035
16NR20W		○	●	16NL20W				1.27	20			0.17	.031	.035
16NR19W		○	●	16NL19W			○	1.337	19			0.18	.031	.035
16NR18W				16NL18W				1.411	18			0.19	.031	.035
16NR16W		○	●	16NL16W				1.588	16	3/8"	.63	0.22	.035	.039
16NR14W		○	●	16NL14W			○	1.814	14			0.25	.035	.039
16NR12W		○	●	16NL12W				2.117	12			0.29	.039	.047
16NR11W		○	●	16NL11W			○	2.309	11			0.32	.039	.055
16NR10W		○	●	16NL10W				2.54	10			0.35	.043	.059
16NR9W		○	●	16NL9W			○	2.822	9			0.39	.043	.059
16NR8W		○	●	16NL8W				3.175	8			0.44	.047	.059
16NR7W		○	●	16NL7W				3.629	7			0.5	.047	.059
22NR7W		○	●	22NL7W				3.629	7			0.5	.063	.088
22NR6W		○	●	22NL6W				4.233	6			0.58	.063	.088
22NR5W		○	●	22NL5W				5.08	5	1/2"	.87	0.7	.063	.088
22NR4.5W		○	●	22NL4.5W				5.644	4.5			0.77	.072	.091
22NR4W		○	●	22NL4W				6.35	4			0.87	.072	.091
27NR4.5W		○	●	27NL4.5W				5.644	4.5			0.77		
27NR4W		○	●	27NL4W				6.350	4			0.87		
27VNR4W		○	●	27VNL4W				6.350	4	5/8"	1.06			
27VNR3W		○	●	27VNL3W				8.466	3					
27VNR2.5W		○	●	27VNL2.5W				10.16	2.5					

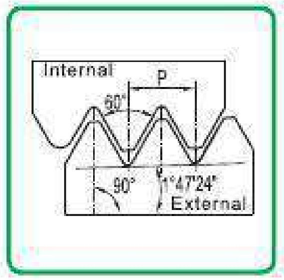
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

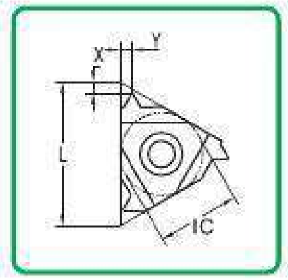
订货示例：16NR14W DM215 10片 Ordering example：16NR14W DM215 10pcs

★27V刀片为立装型，形状参考05页MTTR系列

60° NPT 美国标准锥管螺纹刀片 NPT

外螺纹 External





图片为右手刀片
Right Insert(see picture)

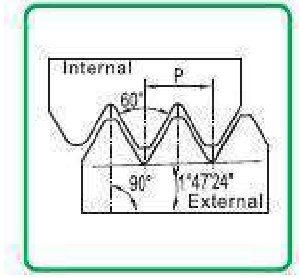
型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r(mm)	X(inch)	Y(inch)
11ER27NPT		○	●	11EL27NPT				0.941	27				.031	.027
11ER18NPT		○	●	11EL18NPT				1.411	18	1/4"	.43	0.03	.039	.031
11ER14NPT		○	●	11EL14NPT				1.814	14			0.04	.047	.035
16ER27NPT		○	●	16EL27NPT			○	0.941	27				.031	.027
16ER18NPT		○	●	16EL18NPT			○	1.411	18			0.03	.039	.031
16ER14NPT		○	●	16EL14NPT			○	1.814	14	3/8"	.63	0.04	.047	.035
16ER11.5NPT		○	●	16EL11.5NPT			○	2.209	11.5			0.05	.059	.043
16ER8NPT		○	●	16EL8NPT			○	3.175	8			0.07	.071	.051

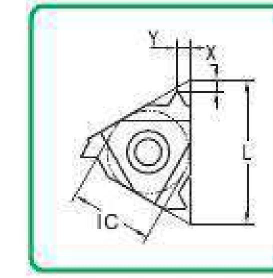
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16ER14NPT DM215 10片 Ordering example：16ER14NPT DM215 10pcs

60° NPT 美国标准锥管螺纹刀片 NPT

内螺纹 Internal





图片为右手刀片
Right Insert(see picture)

型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r(mm)	X(inch)	Y(inch)
11NR27NPT		○	●	11NL27NPT			○	0.941	27				.039	.031
11NR18NPT		○	●	11NL18NPT			○	1.411	18	1/4"	.43	0.03	.039	.031
11NR14NPT		○	●	11NL14NPT			○	1.814	14			0.04	.039	.031
16NR27NPT		○	●	16NL27NPT				0.941	27				.039	.031
16NR18NPT		○	●	16NL18NPT				1.411	18			0.03	.039	.031
16NR14NPT		○	●	16NL14NPT			○	1.814	14	3/8"	.63	0.04	.039	.031
16NR11.5NPT		○	●	16NL11.5NPT			○	2.209	11.5			0.05	.052	.049
16NR8NPT		○	●	16NL8NPT			○	3.175	8			0.07	.071	.051

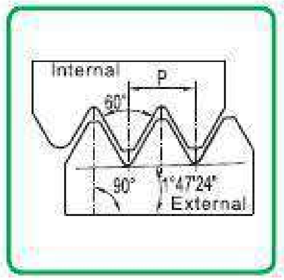
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

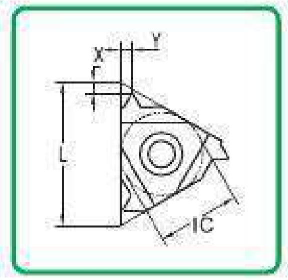
订货示例：16NR14NPT DM215 10片 Ordering example：16NR14NPT DM215 10pcs

60° NPTF 美国干密封圆锥管螺纹刀片 NPTF

外螺纹 External

图片为右手刀片
Right Insert(see picture)





型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X (inch)	Y (inch)
11ER27NPTF		○	○	11EL27NPTF				0.941	27				.039	.031
11ER18NPTF		○	○	11EL18NPTF				1.411	18	1/4"	.43		.039	.031
11ER14NPTF		○	○	11EL14NPTF				1.814	14				.039	.031
16ER27NPTF		○	○	16EL27NPTF				0.941	27				.039	.031
16ER18NPTF		○	○	16EL18NPTF				1.411	18				.039	.031
16ER14NPTF		○	○	16EL14NPTF				1.814	14	3/8"	.63		.039	.031
16ER11.5NPTF		○	○	16EL11.5NPTF				2.209	11.5				.052	.049
16ER8NPTF		○	○	16EL8NPTF				3.175	8				.071	.051

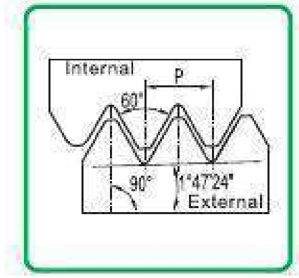
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

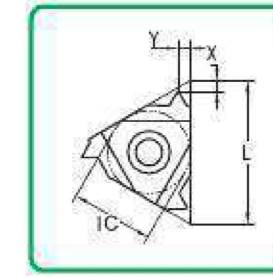
订货示例：16ER14NPTF DM215 10片 Ordering example：16ER14NPTF DM215 10pcs

60° NPTF 美国干密封圆锥管螺纹刀片 NPTF

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





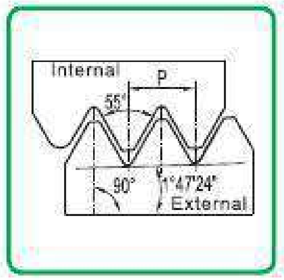
型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X (inch)	Y (inch)
11NR27NPTF		○		11NL27NPTF				0.941	27				.039	.031
11NR18NPTF		○		11NL18NPTF				1.411	18	1/4"	.43		.039	.031
11NR14NPTF		○	○	11NL14NPTF				1.814	14				.039	.031
16NR27NPTF		○	○	16NL27NPTF				0.941	27				.039	.031
16NR18NPTF		○	○	16NL18NPTF				1.411	18				.039	.031
16NR14NPTF		○	○	16NL14NPTF				1.814	14	3/8"	.63		.039	.031
16NR11.5NPTF		○	○	16NL11.5NPTF				2.209	11.5				.052	.049
16NR8NPTF		○	○	16NL8NPTF				3.175	8				.071	.051

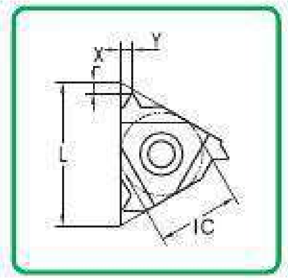
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16NR14NPTF DM215 10片 Ordering example：16NR14NPTF DM215 10pcs

BSPT-55° 英国标准锥管螺纹刀片 BSPT

外螺纹 External





图片为右手刀片
Right Insert(see picture)

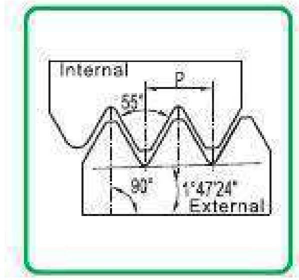
型 号	材质			型 号	材质			加工螺距范围		刀片尺寸		尺寸		
Ordering Code	Material Code			Ordering Code	Material Code			Pitch		Insert Size		Dimensions		
右手刀片 Right Hand	DK110	DP220	DM215	左手刀片 Left Hand	DK110	DP220	DM215	mm	tpi	IC	L/inch	[illegible]	X (inch)	Y (inch)
11ER28BSPT		○	●	11EL28BSPT				0.907	28	1/4"	.43	0.1	.031	.035
11ER19BSPT		○	●	11EL19BSPT				1.337	19			0.16	.037	.039
11ER14BSPT		○	●	11EL14BSPT				1.814	14			0.22	.047	.039
16ER28BSPT		○	●	16EL28BSPT				0.907	28	3/8"	.63	0.1	.031	.035
16ER19BSPT		○	●	16EL19BSPT			○	1.337	19			0.16	.037	.039
16ER14BSPT		○	●	16EL14BSPT			○	1.814	14			0.22	.047	.039
16ER11BSPT		○	●	16EL11BSPT			○	2.309	11			0.29	.059	.041

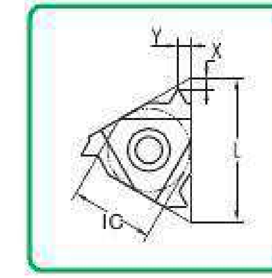
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16ER14BSPT DM215 10片 Ordering example：16ER14BSPT DM215 10pcs

BSPT-55° 英国标准锥管螺纹刀片 BSPT

内螺纹 Internal





图片为右手刀片
Right Insert(see picture)

型 号	材质			型 号	材质			加工螺距范围		刀片尺寸				
Ordering Code	Material Code			Ordering Code	Material Code			Pitch		Insert Size				
右手刀片 Right Hand	DK110	DP220	DM215	左手刀片 Left Hand	DK110	DP220	DM215	mm	tpi	IC	L/inch			
11NR28BSPT		○	●	11NL28BSPT			○	0.907	28	1/4"	.43	0.1	.031	.035
11NR19BSPT		○	●	11NL19BSPT			○	1.337	19			0.16	.037	.039
11NR14BSPT		○	●	11NL14BSPT			○	1.814	14			0.22	.047	.039
16NR28BSPT				16NL28BSPT				0.907	28	3/8"	.63	0.1	.031	.035
16NR19BSPT		○	●	16NL19BSPT				1.337	19			0.16	.037	.039
16NR14BSPT		○	●	16NL14BSPT			○	1.814	14			0.22	.047	.039
16NR11BSPT		○	●	16NL11BSPT			○	2.309	11			0.29	.059	.041

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

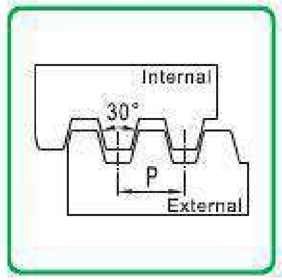
订货示例：16NR14BSPT DM215 10片 Ordering example：16NR14BSPT DM215 10pcs

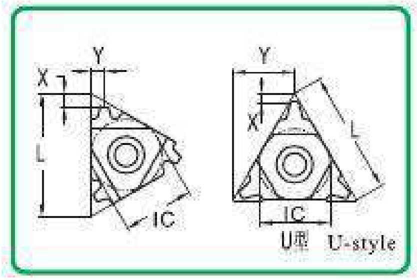
螺纹车削刀具 THREADING TURNING TOOLS

TR-30° 梯形螺纹 Trapez DIN 103

外螺纹 External

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code	材质 Material Code			型 号 Ordering Code	材质 Material Code			加工螺距范围 Pitch		刀片尺寸 Insert Size		尺寸 Dimensions		
右手刀片 Right Hand	DK110	DP220	DM215	左手刀片 Left Hand	DK110	DP220	DM215	mm	tpi	IC	L/inch	r	X	Y
16ER1.5TR		○	●	16EL1.5TR			○	1.50				0.1	.041	.039
16ER2.0TR		○	●	16EL2.0TR			○	2.00		3/8"	.63	0.1	.051	.043
16ER3.0TR		○	●	16EL3.0TR			○	3.00				0.1	.059	.051
22ER4.0TR		○	●	22EL4.0TR			○	4.00				0.1	.075	.067
22ER5.0TR		○	●	22EL5.0TR			○	5.00		1/2"	.87	0.1	.098	.083
22ER6.0TR		○	●	22EL6.0TR			○	6.00				0.1	.101	.099
★ 22ER7.0TR		○	●	★ 22EL7.0TR				7.00				0.1	.095	.54
27ER6.0TR		○	●	27EL6.0TR			○	6.00				0.1		
27ER7.0TR		○	●	27EL7.0TR				7.00				0.1		
27VER6.0TR		○	●	27VEL6.0TR			○	6.00				0.1		
27VER7.0TR		○	●	27VEL7.0TR			○	7.00		5/8"	1.06	0.15		
27VER8.0TR		○	●	27VEL8.0TR			○	8.00				0.2		
27VER9.0TR		○	○	27VEL9.0TR				9.00				0.2		
27VER10TR		○	○	27VEL10TR			○	10.0				0.2		
27VER12TR				27VEL12TR				12.0				0.3		

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16ER3.0TR DM215 10片 Ordering example：16ER3.0TR DM215 10pcs

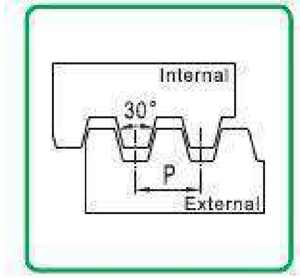
★:该产品为U型样式 The insert is U style.

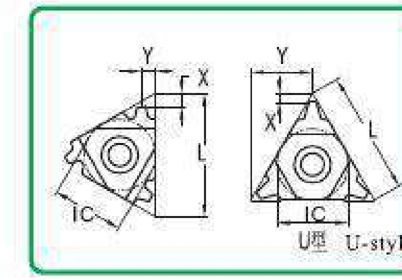
★27V刀片为立装型，形状参考05页MTTR系列

TR-30° 梯形螺纹 Trapez DIN 103

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code	材质 Material Code			型 号 Ordering Code	材质 Material Code			加工螺距范围 Pitch		刀片尺寸 Insert Size		尺寸 Dimensions		
右手刀片 Right Hand	DK110	DP220	DM215	左手刀片 Left Hand	DK110	DP220	DM215	mm	tpi	IC	L/inch	r	X	Y
11NR1.5TR		○	●	11NL1.5TR			○	1.50		1/4"	.43	0.1	.041	.039
11NR2.0TR		○	●	11NL2.0TR			○	2.00				0.1	.051	.043
16NR1.5TR		○	●	16NL1.5TR			○	1.50				0.1	.041	.039
16NR2.0TR		○	●	16NL2.0TR			○	2.00		3/8"	.63	0.1	.051	.043
16NR3.0TR		○	●	16NL3.0TR			○	3.00				0.1	.059	.051
22NR4.0TR		○	●	22NL4.0TR			○	4.00				0.1	.075	.067
22NR5.0TR		○	●	22NL5.0TR			○	5.00		1/2"	.87	0.1	.098	.083
22NR6.0TR		○	●	22NL6.0TR			○	6.00				0.1	.101	.099
★ 22NR7.0TR		○	●	★ 22NL7.0TR				7.00				0.1	.095	.54
27NR6.0TR		○	●	27NL6.0TR			○	6.00				0.1		
27NR7.0TR		○	●	27NL7.0TR				7.00				0.1		
27VNR6.0TR		○	●	27VNL6.0TR			○	6.00				0.1		
27VNR7.0TR		○	●	27VNL7.0TR			○	7.00		5/8"	1.06	0.15		
27VNR8.0TR		○	●	27VNL8.0TR			○	8.00				0.2		
27VNR9.0TR		○	○	27VNL9.0TR				9.00				0.2		
27VNR10TR		○	○	27VNL10TR			○	10.0				0.2		
27VNR12TR				27VNL12TR				12.0				0.3		

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16NR3.0TR DM215 10片 Ordering example：16NR3.0TR DM215 10pcs

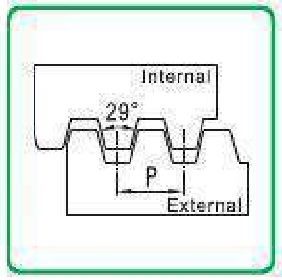
★:该产品为U型样式 The insert is U-style.

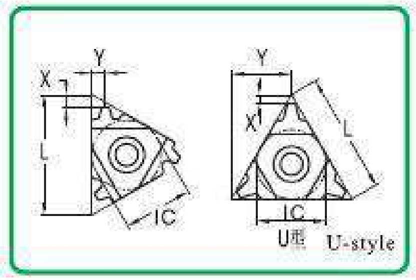
★27V刀片为立装型，形状参考05页MTTR系列

ACME-29° 美制ACME梯形螺纹刀片 American ACME

外螺纹 External

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
16ER16ACME		○	●	16EL16ACME				1.588	16			0.06	.043	.039
16ER14ACME		○	●	16EL14ACME				1.814	14			0.08	.043	.039
16ER12ACME		○	●	16EL12ACME				2.117	12	3/8"	.63	0.01	.047	.043
16ER10ACME		○	●	16EL10ACME			○	2.540	10			0.12	.055	.051
16ER8ACME		○	●	16EL8ACME			○	3.175	8			0.18	.059	.055
22ER6ACME		○	●	22EL6ACME			○	4.233	6			0.2	.083	.071
22ER5ACME		○	●	22EL5ACME				5.080	5	1/2"	.87	0.25	.09	.079
22ER4ACME		○	●	22EL4ACME				6.350	4			0.3	.112	.092
27ER4ACME		○	●	27EL4ACME				6.350	4	5/8"	1.06	0.3		
27VER3ACME		○	●	27VEL3ACME				8.466	3			0.3		

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

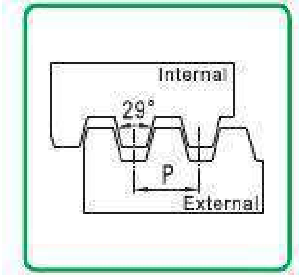
订货示例：16ER12ACME DM215 10片 Ordering example：16ER12ACME DM215 10pcs

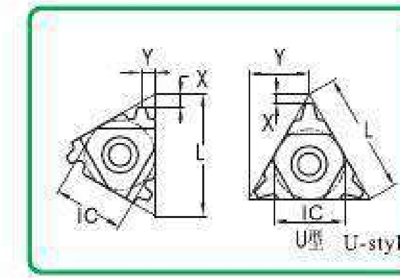
★27V刀片为立装型，形状参考05页MTTR系列

ACME-29° 美制ACME梯形螺纹刀片 American ACME

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
11NR16ACME		○	●	11NL16ACME				1.588	16	1/4"	.43	0.06	.043	.039
11NR14ACME		○	●	11NL14ACME				1.814	14			0.08	.043	.039
16NR16ACME		○	●	16NL16ACME				1.588	16			0.06	.043	.039
16NR14ACME		○	●	16NL14ACME				1.814	14			0.08	.043	.039
16NR12ACME		○	●	16NL12ACME			○	2.117	12	3/8"	.63	0.01	.047	.043
16NR10ACME		○	●	16NL10ACME			○	2.540	10			0.12	.055	.051
16NR8ACME		○	●	16NL8ACME			○	3.175	8			0.18	.059	.055
22NR6ACME		○	●	22NL6ACME			○	4.233	6			0.2	.083	.071
22NR5ACME		○	●	22NL5ACME				5.080	5	1/2"	.87	0.25	.09	.079
22NR4ACME		○	●	22NL4ACME				6.350	4			0.3	.112	.092
27NR4ACME		○	●	27NL4ACME				6.350	4	5/8"	1.06	0.3		
27VNR3ACME		○	●	27VNL3ACME				8.466	3			0.3		

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16NR12ACME DM215 10片 Ordering example：16NR12ACME DM215 10pcs

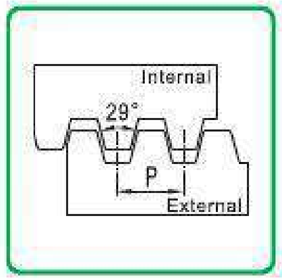
★27V刀片为立装型，形状参考05页MTTR系列

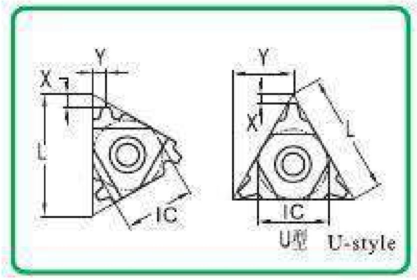
螺纹车削刀具 THREADING TURNING TOOLS

STACME-29° 美制短齿梯形螺纹刀片 Stub ACME

外螺纹 External

图片为右手刀片
Right Insert(see picture)





型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	材质 Material Code DP220	材质 Material Code DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	材质 Material Code DP220	材质 Material Code DM215	加工螺距范围 Pitch mm	加工螺距范围 Pitch tpi	刀片尺寸 Insert Size IC	刀片尺寸 Insert Size L/inch	尺寸 Dimensions r(mm)	尺寸 Dimensions X(inch)	尺寸 Dimensions Y(inch)
16ER16STACME		○	○	16EL16STACME				1.588	16			0.06	.039	.039
16ER14STACME		○	○	16EL14STACME				1.814	14			0.08	.039	.039
16ER12STACME		○	○	16EL12STACME				2.117	12	3/8"	.63	0.01	.051	.047
16ER10STACME		○	○	16EL10STACME				2.540	10			0.12	.051	.047
16ER8STACME		○	●	16EL8STACME				3.175	8			0.18	.059	.055
16ER6STACME		○	●	16EL6STACME				4.233	6			0.2	.059	.055
22ER6STACME		○	○	22EL6STACME				4.233	6			0.2	.059	.055
22ER5STACME		○	●	22EL5STACME				5.080	5	1/2"	.87	0.25	.090	.083
22ER4STACME		○	●	22EL4STACME				6.350	4			0.3	.099	.087
27ER4STACME		○	●	27EL4STACME				6.350	4	5/8"	1.06	0.3		
27VER3STACME		○	●	27VEL3STACME				8.466	3			0.3		

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16ER12STACME DM215 10片 Ordering example：16ER12STACME DM215 10pcs

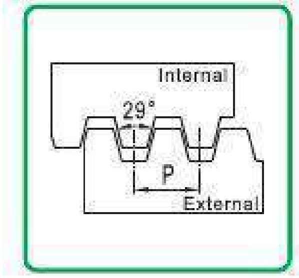
★27V刀片为立装型，形状参考05页MTTR系列

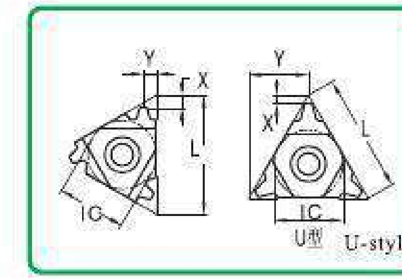
螺纹车削刀具 THREADING TURNING TOOLS

STACME-29° 美制短齿梯形螺纹刀片 Stub ACME

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	材质 Material Code DP220	材质 Material Code DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	材质 Material Code DP220	材质 Material Code DM215	加工螺距范围 Pitch mm	加工螺距范围 Pitch tpi	刀片尺寸 Insert Size IC	刀片尺寸 Insert Size L/inch	尺寸 Dimensions r(mm)	尺寸 Dimensions X(inch)	尺寸 Dimensions Y(inch)
11NR16STACME		○	○	11NL16STACME				1.588	16	1/4"	.43	0.06	.039	.039
11NR14STACME		○	○	11NL14STACME				1.814	14			0.08	.039	.039
16NR16STACME		○	○	16NL16STACME				1.588	16			0.06	.039	.039
16NR14STACME		○	○	16NL14STACME				1.814	14			0.08	.039	.039
16NR12STACME		○	○	16NL12STACME				2.117	12	3/8"	.63	0.01	.051	.047
16NR10STACME		○	○	16NL10STACME				2.540	10			0.12	.051	.047
16NR8STACME		○	●	16NL8STACME				3.175	8			0.18	.059	.055
16NR6STACME		○	●	16NL6STACME				4.233	6			0.2	.059	.055
22NR6STACME		○	○	22NL6STACME				4.233	6			0.2	.059	.055
22NR5STACME		○	●	22NL5STACME				5.080	5	1/2"	.87	0.25	.090	.083
22NR4STACME		○	●	22NL4STACME				6.350	4			0.3	.099	.087
27NR4STACME		○	●	27NL4STACME				6.350	4	5/8"	1.06	0.3		
27VNR3STACME		○	●	27VNL3STACME				8.466	3			0.3		

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16NR12STACME DM215 10片 Ordering example：16NR12STACME DM215 10pcs

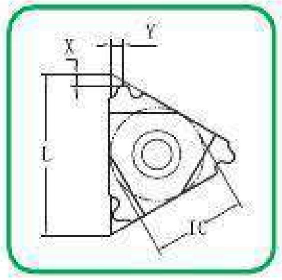
★27V刀片为立装型，形状参考05页MTTR系列

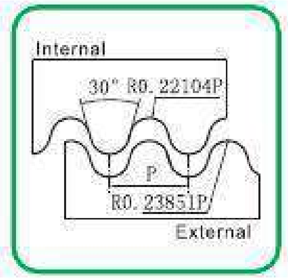
螺纹车削刀具 THREADING TURNING TOOLS

RD圆螺纹 30° DIN405

外螺纹 External

图片为右手刀片
Right Insert(see picture)





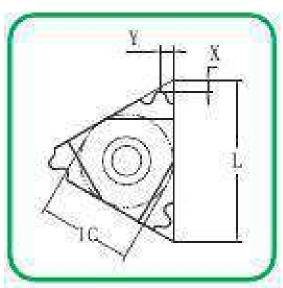
型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
16ER10RD		○	●	16EL10RD				2.54	10			0.61	.051	.055
16ER 8RD		○	●	16EL 8RD				3.175	8	3/8"	.63	0.78	.059	.063
16ER 6RD		○	●	16EL 6RD				4.23	6			1.01	.067	.059
22ER 6RD		○	●	22EL 6RD				4.23	6			1.01	.067	.059
22ER 5RD		○	○	22EL 5RD				5.08	5	2/1"	.87	1.21	.078	.066
22ER 4RD		○	●	22EL 4RD				6.35	4			1.51	.092	.087

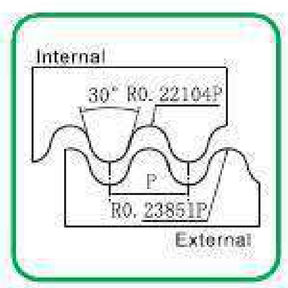
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16ER8RD DM215 10片 Ordering example：16ER8RD DM215 10pcs

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions r	X	Y
16NR10RD		○	●	16NL10RD				2.54	10			0.56	.051	.055
16NR 8RD		○	●	16NL 8RD				3.175	8	3/8"	.63	0.7	.059	.063
16NR 6RD		○	●	16NL 6RD				4.23	6			0.94	.067	.059
22NR 6RD		○	●	22NL 6RD				4.23	6			0.94	.067	.059
22NR 5RD		○	○	22NL 5RD				5.08	5	2/1"	.87	1.12	.078	.066
22NR 4RD		○	●	22NL 4RD				6.35	4			1.4	.092	.087

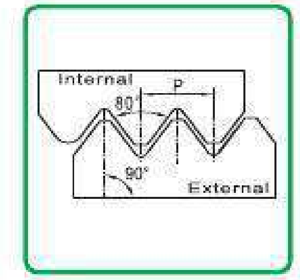
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

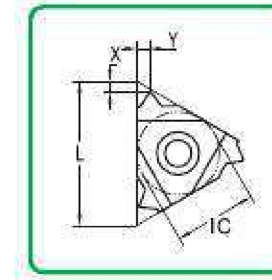
订货示例：16NR8RD DM215 10片 Ordering example：16NR8RD DM215 10pcs

PG螺纹刀片 PG DIN40430

外螺纹 External

图片为右手刀片
Right Insert(see picture)





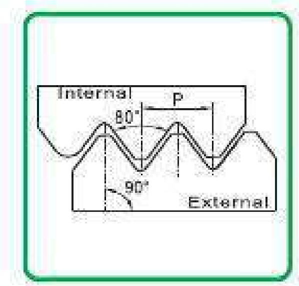
型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
11ER20PG		○	●	11EL20PG				1.27	20				.031	.035
11ER18PG		○	●	11EL18PG				1.41	18	1/4"	.43		.031	.039
11ER16PG		○	●	11EL16PG				1.59	16				.035	.043
16ER20PG		○	●	16EL20PG				1.27	20				.031	.035
16ER18PG		○	●	16EL18PG				1.41	18	3/8"	.63		.031	.039
16ER16PG		○	●	16EL16PG				1.59	16				.035	.043

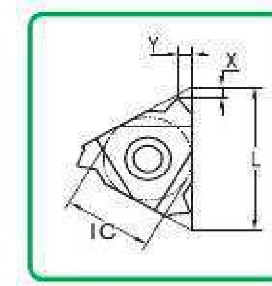
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16NR8RD DM215 10片 Ordering example：16NR8RD DM215 10pcs

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型 号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
11NR20PG		○	●	11NL20PG				1.27	20				.030	.034
11NR18PG		○	●	11NL18PG				1.41	18	1/4"	.43		.030	.038
11NR16PG		○	●	11NL16PG				1.59	16				.033	.041
16NR20PG		○	●	16NL20PG				1.27	20				.031	.035
16NR18PG		○	●	16NL18PG				1.41	18	3/8"	.63		.031	.039
16NR16PG		○	●	16NL16PG				1.59	16				.035	.043

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

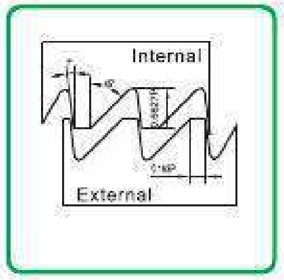
订货示例：16NR8RD DM215 10片 Ordering example：16NR8RD DM215 10pcs

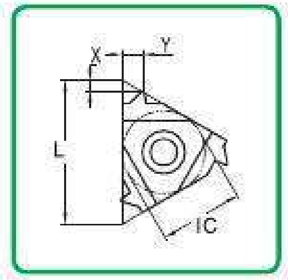
螺纹车削刀具 THREADING TURNING TOOLS

ABUT美制锯齿形螺纹刀片 American Buttress

外螺纹 External

图片为右手刀片
Right Insert(see picture)

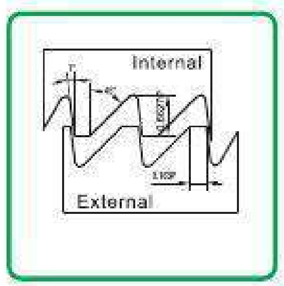


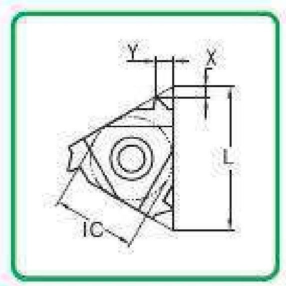


型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
11ER20ABUT		○	○	11EL20ABUT				1.270	20	1/4"	.43	.003	.031	.035
11ER16ABUT		○	○	11EL16ABUT				1.588	16			.003	.031	.034
16ER20ABUT		○	○	16EL20ABUT				1.270	20	3/8"	.63	.004	.031	.034
16ER16ABUT		○	○	16EL16ABUT				1.588	16			.005	.031	.034
16ER12ABUT		○	○	16EL12ABUT				2.117	12			.007	.039	.041
16ER10ABUT		○	○	16EL10ABUT				2.540	10			.008	.043	.047
22ER8ABUT		○	○	22EL8ABUT				3.175	8	1/2"	.87	.010	.047	.052
22ER6ABUT		○	○	22EL6ABUT				4.233	6			.012	.063	.059

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
11NR20ABUT		○	○	11NL20ABUT				1.270	20	1/4"	.43	.003	.031	.035
11NR16ABUT		○	○	11NL16ABUT				1.588	16			.003	.031	.034
16NR20ABUT				16NL20ABUT				1.270	20	3/8"	.63	.004	.031	.034
16NR16ABUT		○	○	16NL16ABUT				1.588	16			.005	.031	.034
16NR12ABUT		○	○	16NL12ABUT				2.117	12			.007	.039	.041
16NR10ABUT		○	○	16NL10ABUT				2.540	10			.008	.043	.047
22NR8ABUT		○	○	22NL8ABUT				3.175	8	1/2"	.87	.010	.047	.052
22NR6ABUT		○	○	22NL6ABUT				4.233	6			.012	.063	.059

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：16NR12ABUT DM215 10片 Ordering example：16NR12ABUT DM215 10pcs

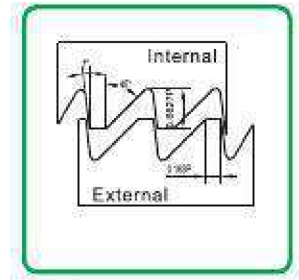
公、英、美制螺纹刀具 THREADING TOOLS DAOQING

螺纹车削刀具 THREADING TURNING TOOLS

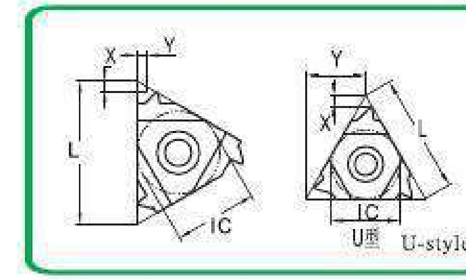
SAGE德标锯齿螺纹 DIN513

外螺纹 External

图片为右手刀片
Right Insert(see picture)



DIN513
GB/T 13576

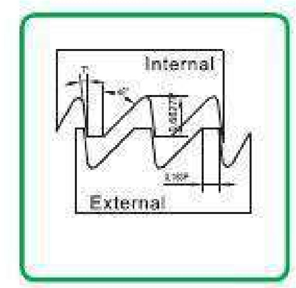


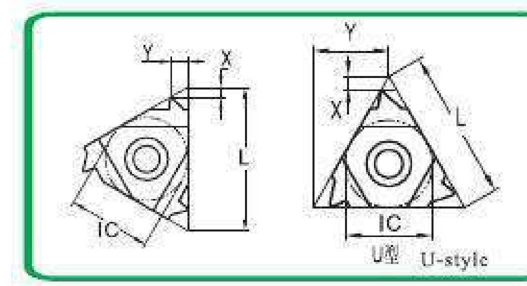
型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
16ER2SAGE		○	○	16EL2SAGE				2.0	3/8"	.63		0.059	0.086
22ER3SAGE		○	○	22EL3SAGE				3.0	1/2"	.87		0.065	0.114
22ER4SAGE		○	○	22EL4SAGE				4.0				0.083	0.126
＊22UER5SAGE		○	○	＊22UEL5SAGE				5.0					
＊22UER6SAGE		○	○	＊22UEL6SAGE				6.0					
27ER5SAGE		○	○	27EL5SAGE				5.0	7/8"	1.06			
27ER6SAGE		○	○	27EL6SAGE				6.0					

＊代表刀片为U型结构 The insert is U-style

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)





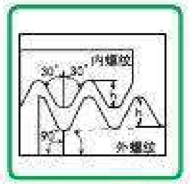
型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
16NR2SAGE		○	○	16NL2SAGE				2.0	3/8"	.63		0.059	0.086
22NR3SAGE		○	○	22NL3SAGE				3.0	1/2"	.87		0.065	0.114
22NR4SAGE		○	○	22NL4SAGE				4.0				0.083	0.126
＊22UNR5SAGE		○	○	＊22UNL5SAGE				5.0					
＊22UNR6SAGE		○	○	＊22UNL6SAGE				6.0					
27NR5SAGE		○	○	27NL5SAGE				5.0	7/8"	1.06			
27NR6SAGE		○	○	27NL6SAGE				6.0					

＊代表刀片为U型结构 The insert is U-style

美制API螺纹刀片 API

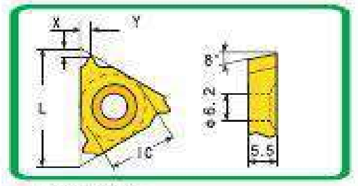
外螺纹 External


图片为右手刀片
Right Insert(see picture)



美标API Spec 7-1985
国标GB/T-T 9253.1-1999

α= arctg(IPF/24)

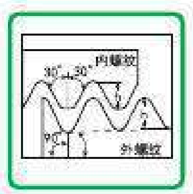


外螺纹刀片

刀片尺寸 Insert size IC	Lmm	螺距 tpi	螺纹 Thread	锥度 Taper IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2"	22	4	V-0.038R	1:6	22ER4API382A		○	●	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	22ER4API383A		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0.050	1:6	22ER4API502A		○	○	6-5/8"REG	3.75	2.0	2.9
		4	V-0.050	1:4	22ER4API503A		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.0	2.9
		5	V-0.040	1:4	22ER5API403A		○	○	2 -3/8" -4-1/2"REG	2.99	1.8	2.6
		6	V-0.055	1:8	22ER6API551A		○	○	NC10-NC16	1.41	2.6	2.0
5/8"	27	4	V-0.038R	1:6	27ER4API382A		○	○	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	27ER4API383A		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0050	1:6	27ER4API502A		○	○	6-5/8"REG	3.75	2.1	3.1
		4	V-0050	1:4	27ER4API503A		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.1	3.1
		5	V-0.040	1:6	27ER5API403A		○	○	2-3/8"-4-1/2"REG	2.99	1.9	2.7

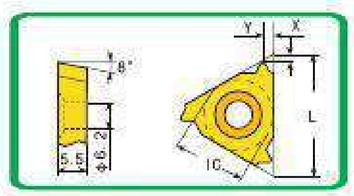
内螺纹 Internal


图片为右手刀片
Right Insert(see picture)



美标API Spec 7-1985
国标GB/T-T 9253.1-1999

α= arctg(IPF/24)



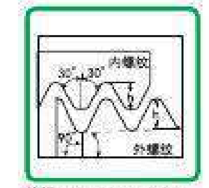
内螺纹刀片

刀片尺寸 Insert size IC	Lmm	螺距 tpi	螺纹 Thread	锥度 Taper IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2"	22	4	V-0.038R	1:6	22NR4API382A		○	●	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	22NR4API383A		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0050	1:6	22NR4API502A		○	○	6-5/8"REG	3.75	2.0	2.9
		4	V-0050	1:4	22NR4API503A		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.0	2.9
		5	V-0.040	1:4	22NR5API403A		○	○	2-3/8" ~ 4-1/2"REG	2.99	1.8	2.6
		6	V-0.055	1:8	22NR6API551A		○	○	NC10-NC16	1.41	2.6	2.0
5/8"	27	4	V-0.038R	1:6	27NR4API382A		○	○	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	27NR4API383A		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0050	1:6	27NR4API502A		○	○	6-5/8"REG	3.75	2.1	3.1
		4	V-0050	1:4	27NR4API503A		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.1	3.1
		5	V-0.040	1:6	27NR5API403A		○	○	2-3/8"~4-1/2"REG	2.99	1.9	2.7

美制API螺纹刀片 API

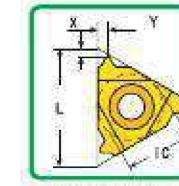
外螺纹 External


图片为右手刀片
Right Insert(see picture)



美标API Spec 7-1985
国标GB/T-T 9253.1-1999

α= arctg(IPF/24)

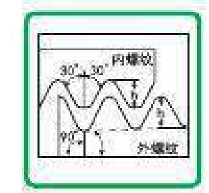


外螺纹刀片

刀片尺寸 Insert size IC	Lmm	螺距 tpi	螺纹 Thread	锥度 Taper IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2"	22	4	V-0.038R	1:6	22ER4API382B		○	●	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	22ER4API383B		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0.050	1:6	22ER4API502B		○	○	6-5/8"REG	3.75	2.0	2.9
		4	V-0.050	1:4	22ER4API503B		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.0	2.9
		5	V-0.040	1:4	22ER5API403B		○	○	2 -3/8" ~4-1/2"REG	2.99	1.8	2.6
		6	V-0.055	1:8	22ER6API551B		○	○	NC10-NC16	1.41	2.6	2.0
5/8"	27	4	V-0.038R	1:6	27ER4API382B		○	○	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	27ER4API383B		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0050	1:6	27ER4API502B		○	○	6-5/8"REG	3.75	2.1	3.1
		4	V-0050	1:4	27ER4API503B		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.1	3.1
		5	V-0.040	1:6	27ER5API403B		○	○	2-3/8"~4-1/2"REG	2.99	1.9	2.7

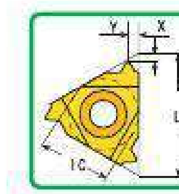
内螺纹 Internal


图片为右手刀片
Right Insert(see picture)



美标API Spec 7-1985
国标GB/T-T 9253.1-1999

α= arctg(IPF/24)



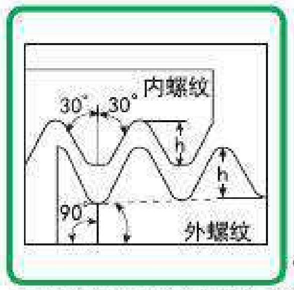
内螺纹刀片

刀片尺寸 Insert size IC	Lmm	螺距 tpi	螺纹 Thread	锥度 Taper IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2"	22	4	V-0.038R	1:6	22NR4API382B		○	●	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	22NR4API383B		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0050	1:6	22NR4API502B		○	○	6-5/8"REG	3.75	2.0	2.9
		4	V-0050	1:4	22NR4API503B		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.0	2.9
		5	V-0.040	1:4	22NR5API403B		○	○	2-3/8" ~ 4-1/2"REG	2.99	1.8	2.6
		6	V-0.055	1:8	22NR6API551B		○	○	NC10-NC16	1.41	2.6	2.0
5/8"	27	4	V-0.038R	1:6	27NR4API382B		○	○	NC23-NC50	3.09	2.1	2.8
		4	V-0.038R	1:4	27NR4API383B		○	○	NC56-NC77	3.08	2.1	2.8
		4	V-0050	1:6	27NR4API502B		○	○	6-5/8"REG	3.75	2.1	3.1
		4	V-0050	1:4	27NR4API503B		○	○	5-1/2", 7-5/8", 8-5/8"REG	3.74	2.1	3.1
		5	V-0.040	1:6	27NR5API403B		○	○	2-3/8"~4-1/2"REG	2.99	1.9	2.7

60° -API石油管用螺纹刀片 Insert for API Oil Pipe

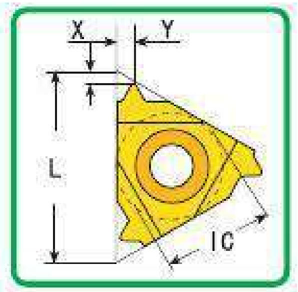
外螺纹 External

图片为右手刀片
Right Insert(see picture)



α = arctg(IPF/24)

标准 美制API螺纹 SPEC. 7:1990
公差等级标准 美制API螺纹



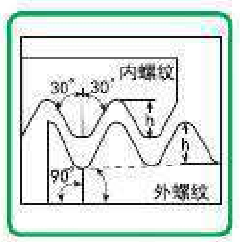
外螺纹刀片

型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
16ER10APIRD		○	●	16EL10APIRD				2.540	10	3/8"	.63	.004	.043	.059
16ER08APIRD		○	●	16EL08APIRD				3.175	8			.005	.047	.063

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard
订货示例: 16ER10APIRD DM215 10片 Ordering example: 16ER10APIRD DM215 10pcs

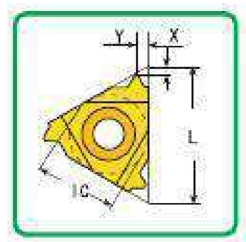
内螺纹 Internal

图片为右手刀片
Right Insert(see picture)



α = arctg(IPF/24)

标准 美制API螺纹 SPEC. 7:1990
公差等级标准 美制API螺纹



内螺纹刀片

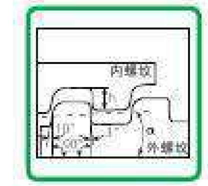
型号 Ordering Code 右手刀片 Right Hand	材质 Material Code DK110	DP220	DM215	型号 Ordering Code 左手刀片 Left Hand	材质 Material Code DK110	DP220	DM215	加工螺距范围 Pitch mm	tpi	刀片尺寸 Insert Size IC	L/inch	尺寸 Dimensions (inch) r	X	Y
16NR10APIRD		○	●	16NL10APIRD				2.540	10	3/8"	.63	.004	.043	.059
16NR08APIRD		○	●	16NL08APIRD				3.175	8			.005	.047	.063

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard
订货示例: 16NR10APIRD DM215 10片 Ordering example: 16NR10APIRD DM215 10pcs

美制VAM螺纹刀片 VAM

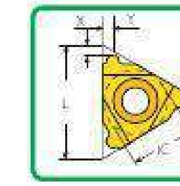
外螺纹 External

图片为右手刀片
Right Insert(see picture)



α = arctg (IPF/24)

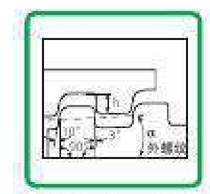
标准 STD. 5B:1979



刀片尺寸 Insert size IC	Lmm	螺距 tpi	锥度 IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
3/8	16	8	0.75	16ER8VAM***		○	○	2-3/8",2-7/8"	0.97	1.7	1.8
1/2	22	6	0.75	22ER6VAM***		○	○	3-1/2"	0.97	2.4	2.4
		5	0.75	22ER5VAM***		○	○	5"~9-5/8"	1.54	2.4	2.7

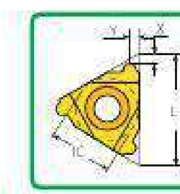
内螺纹 Internal

图片为右手刀片
Right Insert(see picture)



α = arctg (IPF/24)

标准 STD. 5B:1979

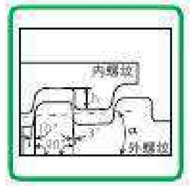


刀片尺寸 Insert size IC	Lmm	螺距 tpi	锥度 IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
3/8	16	8	0.75	16NR8VAM***		○	○	2-3/8",2-7/8"	0.97	1.7	1.8
1/2	22	6	0.75	22NR6VAM***		○	○	3-1/2"	0.97	2.4	2.4
		5	0.75	22NR5VAM***		○	○	5"~9-5/8"	1.54	2.4	2.7

美制EL石油套管螺纹刀片 EL

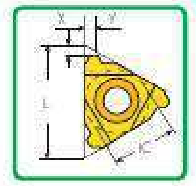
外螺纹 External

图片为右手刀片
Right Insert(see picture)



α = arctg (IPF/24)

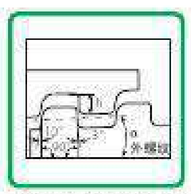
标准 美制API螺纹 STD.5B:1979



刀片尺寸 Insert size IC	Lmm	螺距 tpi	锥度 IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2	22	6	1.5	22NR6EL***		○	○	5"~7-5/8"	1.39	1.8	1.9
		5	1.25	22NR5EL**		○	○	8-5/8"~10-3/4"	1.91	2.2	2.4

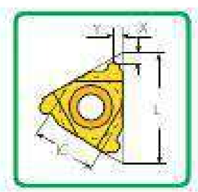
内螺纹 Internal

图片为右手刀片
Right Insert(see picture)



α = arctg (IPF/24)

标准 美制API螺纹 STD.5B:1979

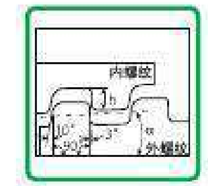


刀片尺寸 Insert size IC	Lmm	螺距 tpi	锥度 IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2	22	6	1.5	22NR6EL***		○	○	5"~7-5/8"	1.39	1.8	1.9
		5	1.25	22NR5EL**		○	○	8-5/8"~10-3/4"	1.91	2.2	2.4

API锯齿套螺纹刀片

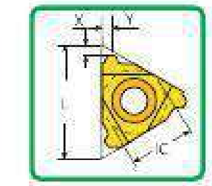
外螺纹 External

图片为右手刀片
Right Insert(see picture)



α = arctg (IPF/24)

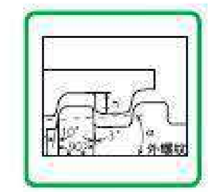
标准 STD.5B:1979



刀片尺寸 Insert size IC	Lmm	螺距 tpi	锥度 IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2"	22	5	0.75	22ER5BUT75***		○	○	4-1/2"~13-3/8"	1.55	3.1	1.9
		5	1	22ER5BUT1***		○	○	16"~20"	1.55	3.1	1.9

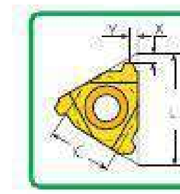
内螺纹 Internal

图片为右手刀片
Right Insert(see picture)



α = arctg (IPF/24)

标准 STD.5B:1979

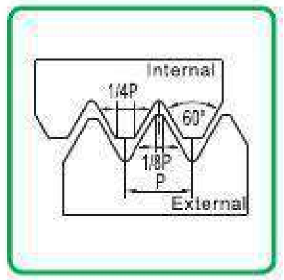


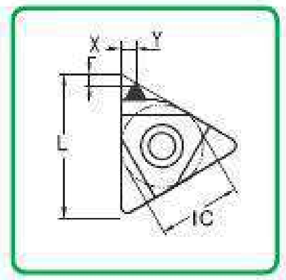
刀片尺寸 Insert size IC	Lmm	螺距 tpi	锥度 IPF	刀片型号 Ordering Code RH	材质 Material Code DK110	DP220	DM215	螺纹尺寸 Size	尺寸规格 Dimension(mm) hmin	X	Y
1/2"	22	5	0.75	22NR5BUT75***		○	○	4-1/2"~13-3/8"	1.55	3.1	1.9
		5	1	22NR5BUT1***		○	○	16"~20"	1.55	3.1	1.9

PCD/PCBN螺纹刀片 PCD/PCBN

外螺纹 External

图片为右手刀片
Right Insert(see picture)





型 号 Ordering Code	材质 Material Code		型 号 Ordering Code	材质 Material Code		加工螺距范围 Pitch		刀片尺寸 Insert Size		尺寸 Dimensions (inch)		
右手刀片 Right Hand	CB20	PC20	左手刀片 Left Hand	CB20	PC20	mm	tpi	IC	L/inch	r	X	Y
11ERA60F			11ELA60F			0.5-1.5	48-16	1/4"	.43	.003	.031	.035
11ERA55F			11ELA55F			0.5-1.5	48-16			.003	.031	.035
16ERAG60F	●	●	16ELAG60F	●	●	1.0-2.5	24-10	3/8"	.63	.004	.047	.067
16ERAG55F	●	●	16ELAG55F	●	●	1.0-2.5	24-10			.004	.047	.067
22ERN60F	○	○	22ELN60F	○	○	3.0-5.0	8-5	1/2"	.87	.021	.067	.098
22ERN55F	○	○	22ELN55F	○	○	3.0-5.0	8-5			.021	.067	.098

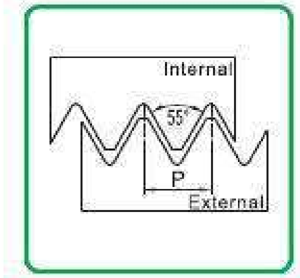
★CB20为立方氮化硼刀片（PCBN），适用于精加工高硬度钢
CB20: Polycrystalline Cubic Boron Nitride (PCBN) Inserts, application of High hardness steel for finishing

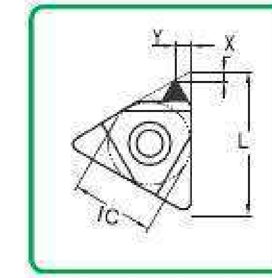
★PC20为金刚石刀片（PCD），适用于精加工有色金属
PC20: Polycrystalline diamond (PCD) Inserts, application of Non-ferrous metals for finishing

PCD/PCBN螺纹刀片 PCD/PCBN

内螺纹 Internal

图片为右手刀片
Right Insert(see picture)



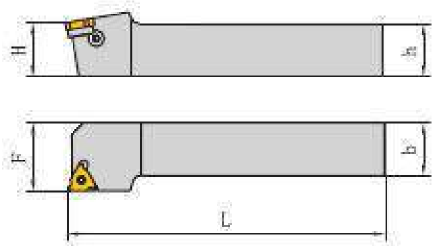


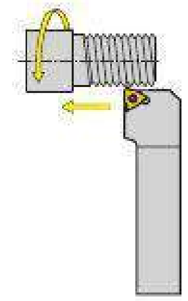
型 号 Ordering Code	材质 Material Code		型 号 Ordering Code	材质 Material Code		加工螺距范围 Pitch		刀片尺寸 Insert Size		尺寸 Dimensions (inch)		
右手刀片 Right Hand	CB20	PC20	左手刀片 Left Hand	CB20	PC20	mm	tpi	IC	L/inch	r	X	Y
11NRA60F			11NLA60F			0.5-1.5	48-16	1/4"	.43	.003	.031	.035
11NRA55F			11NLA55F			0.5-1.5	48-16			.003	.031	.035
16NRAG60F	●	●	16NLAG60F	●	●	0.5-3.0	48-8	3/8"	.63	.004	.047	.067
16NRAG55F	●	●	16NLAG55F	●	●	0.5-3.0	48-8			.004	.047	.067
22NRN60F	○	○	22NLN60F	○	○	3.5-6.0	7-5	1/2"	.87	.021	.067	.098
22NRN55F	○	○	22NLN55F	○	○	3.5-6.0	7-5			.021	.067	.098

★CB20为立方氮化硼刀片（PCBN），适用于精加工高硬度钢
CB20: Polycrystalline Cubic Boron Nitride (PCBN) Inserts, application of High hardness steel for finishing

★PC20为金刚石刀片（PCD），适用于精加工有色金属
PC20: Polycrystalline diamond (PCD) Inserts, application of Non-ferrous metals for finishing

外螺纹车刀杆（偏头） Threading Tool Holders





图片为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)					刀片Insert		刀片螺钉	扳手	刀垫	侧面螺钉	扳手
右刀Right Hand	左刀Left Hand	h	b	H	F	L	右Right	左Left	Insert Screw	Torx Key	Anvil	Anvil Screw	Hex Wrench
SER1212F16	SEL1212F16	12	12	12	16	80	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER1616H16	SEL1616H16	16	16	16	20	100	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER2020K16	SEL2020K16	20	20	20	25	125	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER2525M16	SEL2525M16	25	25	25	32	150	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER3225P16	SEL3225P16	32	25	32	32	170	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER3232P16	SEL3232P16	32	32	32	40	170	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER2020K22	SEL2020K22	20	20	20	27	125	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SER2525M22	SEL2525M22	25	25	25	32	150	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SER3225P22	SEL3225P22	32	25	32	32	170	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SER3232P22	SEL3232P22	32	32	32	40	170	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SER4040R22	SEL4040R22	40	40	40	50	200	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5

订货示例：SER2020K16 1件　　Ordering example：SER2020K16 1pc

梯形螺纹专用刀垫（外）

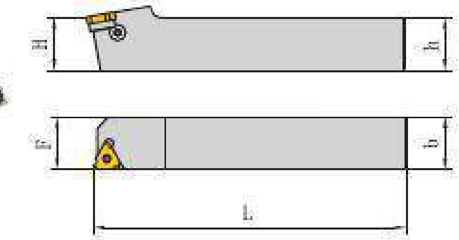
Shims for trapezoidal threading inserts (External)

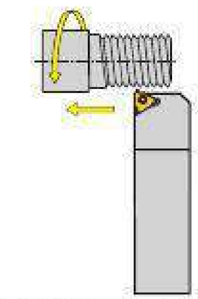
订货型号EGM-22T
Ordering code: EGM-22T

★梯形螺纹刀垫EGM-22T适用于22ER6.0TR、22ER5.0TR、22ER4ACME、22ER4STACME
The shim EGM-22T apply to 22ER6.0TR, 22ER5.0TR, 22ER4ACME, 22ER4STACME

★刀垫需单独订购
Shim EGM-22T must be ordered separately

外螺纹车刀杆（直头） Threading Tool Holders (b=F)





图片为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)					刀片Insert		刀片螺钉	扳手	刀垫	侧面螺钉	扳手
右刀Right Hand	左刀Left Hand	h	b	H	F	L	右Right	左Left	Insert Screw	Torx Key	Anvil	Anvil Screw	Hex Wrench
SER1010K11-A	SEL1010K11-A	10	10	10	10	125	11ER..	11EL..	L60M2.5x6	T-08	-	-	-
SER1212K11-A	SEL1212K11-A	12	12	12	12	125	11ER..	11EL..	L60M2.5x6	T-08	-	-	-
SER1616K11-A	SEL1616K11-A	16	16	16	16	125	11ER..	11EL..	L60M2.5x6	T-08	-	-	-
SER1616H16-A	SEL1616H16-A	16	16	16	16	100	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER2020K16-A	SEL2020K16-A	20	20	20	20	125	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER2525M16-A	SEL2525M16-A	25	25	25	25	150	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER3225P16-A	SEL3225P16-A	32	25	32	25	170	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER3232P16-A	SEL3232P16-A	32	32	32	32	170	16ER..	16EL..	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SER2525M22-A	SEL2525M22-A	25	25	25	25	150	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SER3225P22-A	SEL3225P22-A	32	25	32	25	170	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SER3232P22-A	SEL3232P22-A	32	32	32	32	170	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SER4040R22-A	SEL4040R22-A	40	40	40	40	200	22ER..	22EL..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5

订货示例：SER2020K16-A 1件　　Ordering example：SER2020K16-A 1pc

梯形螺纹专用刀垫（外）

Shims for trapezoidal threading inserts (External)

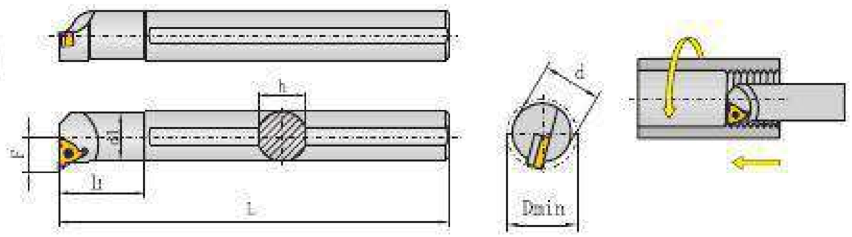
订货型号EGM-22T
Ordering code: EGM-22T

★梯形螺纹刀垫EGM-22T适用于22ER6.0TR、22ER5.0TR、22ER4ACME、22ER4STACME
The shim EGM-22T apply to 22ER6.0TR, 22ER5.0TR, 22ER4ACME, 22ER4STACME

★刀垫需单独订购
Shim EGM-22T must be ordered separately

螺纹车削刀具 THREADING TURNING TOOLS

内螺纹车刀杆 Threading Tool Holders



图片为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)							刀片Insert		刀片螺钉	扳手	刀垫	侧面螺钉	扳手
右刀Right Hand	左刀Left Hand	d1	d	F	L	h	l1	Dmin	右Right	左Left	Insert Screw	Torx Key	Anvil	Anvil Screw	Hex Wrench
SNR0010H11	SNL0010H11	10	10	7.4	100	9	12	12	11NR..	11NL..	L60M2.5x6	T-08	-	-	-
SNR0012K11	SNL0012K11	12	12	8.4	125	11	15	15	11NR..	11NL..	L60M2.5x6	T-08	-	-	-
SNR0013M11	SNL0013M11	13	16	8.9	150	15	25	15	11NR..	11NL..	L60M2.5x6	T-08	-	-	-
SNR0013M16	SNL0013M16	13	16	10.2	150	15	25	16	16NR..	16NL..	L60M3.5x8	T-15	-	-	-
SNR0016M16	SNL0016M16	15	16	11.7	150	15	25	19	16NR..	16NL..	L60M3.5x8	T-15	-	-	-
SNR0020Q16	SNL0020Q16	19	20	13.7	180	18	24	24	16NR..	16NL..	L60M3.5x12	T-15	NGM-16	MQ030080	T10
SNR0025R16	SNL0025R16	24	25	16.2	200	23	29	29	16NR..	16NL..	L60M3.5x12	T-15	NGM-16	MQ030080	T10
SNR0032S16	SNL0032S16	31	32	19.7	250	30	36	36	16NR..	16NL..	L60M3.5x12	T-15	NGM-16	MQ030080	T10
SNR0040T16	SNL0040T16	38	40	23.7	300	37	44	44	16NR..	16NL..	L60M3.5x12	T-15	NGM-16	MQ030080	T10
SNR0050U16	SNL0050U16	47	50	28.7	350	46	54	54	16NR..	16NL..	L60M3.5x12	T-15	NGM-16	MQ030080	T10
SNR0020Q22	SNL0020Q22	19	20	15.6	180	18	24	24	22NR..	22NL..	L60M4.5x14	T-20	NGM-22	MQ040080	S2.5
SNR0025R22	SNL0025R22	24	25	18.1	200	23	29	29	22NR..	22NL..	L60M4.5x14	T-20	NGM-22	MQ040080	S2.5
SNR0032S22	SNL0032S22	31	32	21.6	250	30	38	38	22NR..	22NL..	L60M4.5x14	T-20	NGM-22	MQ040080	S2.5
SNR0040T22	SNL0040T22	38	40	25.6	300	37	46	46	22NR..	22NL..	L60M4.5x14	T-20	NGM-22	MQ040080	S2.5
SNR0050U22	SNL0050U22	47	50	30.6	350	46	56	56	22NR..	22NL..	L60M4.5x14	T-20	NGM-22	MQ040080	S2.5

订货示例：SNR0020Q16 1件　　Ordering example：SNR0020Q16 1pc

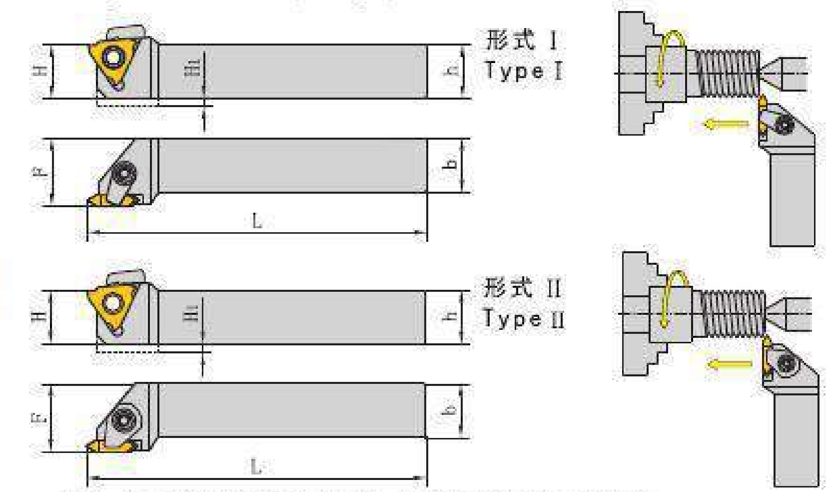
梯形螺纹专用刀垫（内）
Shims for trapezoidal threading inserts (Internal)

订货型号NGM-22T
Ordering code: NGM-22T

★梯形螺纹刀垫NGM-22T适用于22NR6.0TR、22NR5.0TR、22NR4ACME、22NR4STACME
The shim NGM-22T apply to 22NR6.0TR, 22NR5.0TR, 22NR4ACME, 22NR4STACME

★刀垫需单独订购
Shim NGM-22T must be ordered separately

外螺纹车刀杆(立装型) Threading Tool Holders (V-Style)



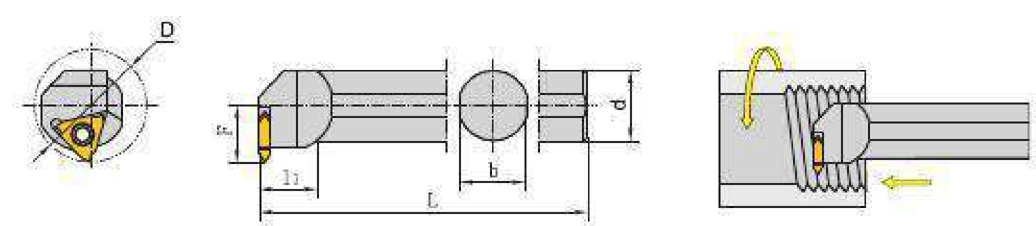
图片为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)						刀片Insert		形式	刀片螺钉	扳手	压板	压板螺钉	扳手
左刀Left Hand	右刀Right Hand	h	b	H	F	L	H1	左Left	右Right	Type	Insert Screw	Torx Key	Clamp	Clamp Screw	Hex Wrench
MTHL1616H43	MTHR1616H43	16	16	16	20	100	3	MTTL43..	MTTR43..	I	L60M4.5x12	T-20	HL1814	ML0620	S4
MTHL2020K43	MTHR2020K43	20	20	20	25	125	-	MTTL43..	MTTR43..		L60M4.5x12	T-20	HL1814	ML0620	S4
MTHL2525M43	MTHR2525M43	25	25	25	32	150	-	MTTL43..	MTTR43..		L60M4.5x12	T-20	HL1814	ML0620	S4
MTHL3225P43	MTHR3225P43	32	25	32	32	170	-	MTTL43..	MTTR43..		L60M4.5x12	T-20	HL1814	ML0620	S4
MTHL3232P43	MTHR3232P43	32	32	32	40	170	-	MTTL43..	MTTR43..		L60M4.5x12	T-20	HL1814	ML0620	S4
WTHL2020K43	WTHR2020K43	20	20	20	25	125	-	MTTL43..	MTTR43..	II	L60M4.5x12	T-20	DLM4	MS0625	S4
WTHL2525M43	WTHR2525M43	25	25	25	32	150	-	MTTL43..	MTTR43..		L60M4.5x12	T-20	DLM4	MS0625	S4

订货示例：MTHR2020K43 1件　　Ordering example：MTHR2020K43 1pc

内螺纹车刀杆(立装型) Threading Tool holders(V-Style)



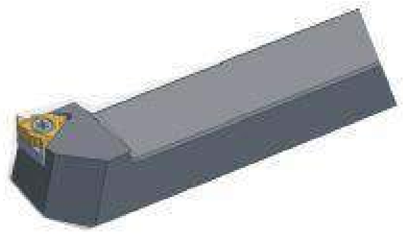
图片为右手刀具
Right Cutting Tools(see picture)

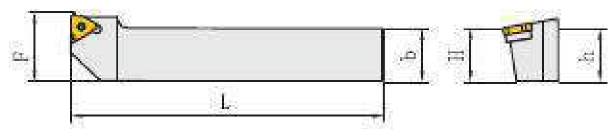
注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:right tools match with right inserts;left tools match with left inserts.

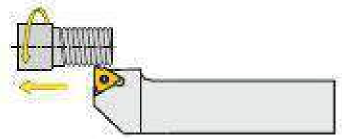
型号Ordering Code		尺寸Dimensions(mm)						刀片Insert		刀片螺钉	扳手	压板	压板螺钉	扳手
左刀Left Hand	右刀Right Hand	b	l1	d	F	L	Dmin	左Left	右Right	Insert Screw	Torx Key	Clamp	Clamp Screw	Hex Wrench
STVEL3525T43	STVER3525T43	23	20	25	17.5	220	35	MTTL43..	MTTR43..	L60M4.5x12	T-20	-	-	-
STVEL4532T43	STVER4532T43	30	30	32	22.5	250	45	MTTL43..	MTTR43..	L60M4.5x12	T-20	-	-	-
STVEL5240T43	STVER5240T43	38	38	40	25	300	52	MTTL43..	MTTR43..	L60M4.5x12	T-20	-	-	-

订货示例：STVER3525T43 1件　　Ordering example：STVER3525T43 1pc

外螺纹刀杆(排刀型) Threading Tool Holders







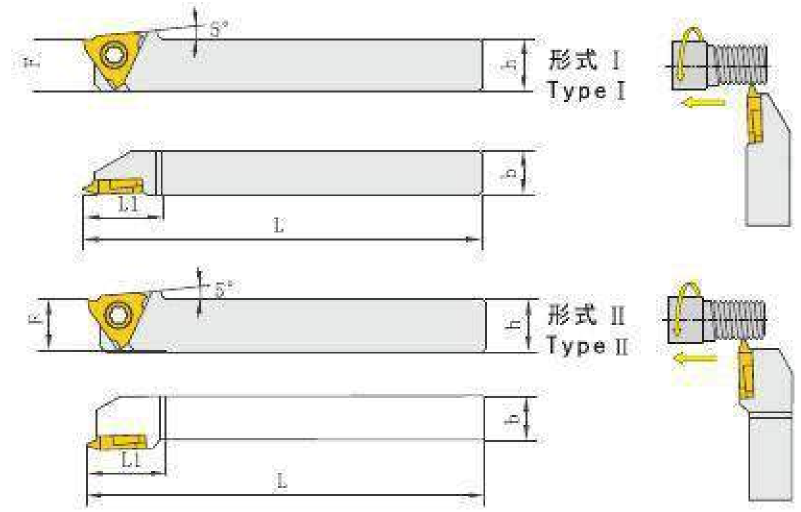
图片为左手刀具
Right Cutting Tools(see picture)

型号Ordering Code	尺寸Dimensions(mm)					刀片Insert	刀片螺钉	扳手	刀垫	侧面螺钉	扳手
左刀杆 Left Hand	h	b	H	F	L	右Right	Insert Screw	Torx Key	Anvi	Anvil Screw	Hex Wrench
SEL1010K11-A90	10	10	10	10	125	11ER★★★★	L60M2.5x6	T-08	-	-	-
SEL1212K11-A90	12	12	12	12	125	11ER★★★★	L60M2.5x6	T-08	-	-	-
SEL1616K11-A90	16	16	16	16	125	11ER★★★★	L60M2.5x6	T-08	-	-	-
SEL1616H16-A90	16	16	16	16	100	16ER★★★★	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SEL2020K16-A90	20	20	20	20	125	16ER★★★★	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SEL2525M16-A90	25	25	25	25	150	16ER★★★★	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SEL3225P16-A90	32	25	32	25	170	16ER★★★★	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SEL3232P16-A90	32	32	32	32	170	16ER★★★★	L60M3.5x12	T-15	EGM-16	MQ030080	T10
SEL2525M22-A90	25	25	25	25	150	22ER★★★★	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SEL3232P22-A90	32	32	32	32	170	22ER★★★★	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5

订货示例：SER2020K16-A 1件　　Ordering example：SER2020K16-A 1pc

螺纹车削刀具
THREADING TURNING TOOLS

TT/TTX型螺纹刀杆 Threading Tool Holders

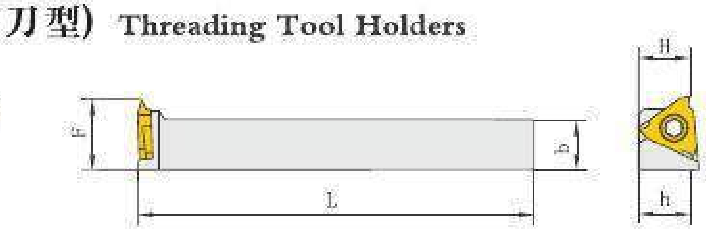


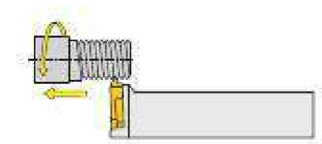
图片为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note: right tools match with right inserts,left tools match with left inserts.

右刀杆	左刀杆	尺寸Dimensions(mm)					形式	刀片	刀片螺钉	扳手
Right Hand	Left Hand	h	b	L	L1	F	Type	Insert	Insert Screw	Torx Key
KTTR1010K-16F	KTTL1010K-16F	10	10	125	20	10	I	TT★★★★	L60M4X8	T-15
KTTR1212K-16F	KTTL1212K-16F	12	12	125	25	12			L60M4X8	T-15
KTTR1616M-16F	KTTL1616M-16F	16	16	150	30	16			L60M4X8	T-15
KTTR2020K-16F	KTTL2020K-16F	20	20	125	20	20		TTX★★★★	L60M4X8	T-15
KTTR2020K-16	KTTL2020K-16	20	20	125	20	20	II		L60M4X8	T-15
KTTR2525M-16	KTTL2525M-16	25	25	150	30	25			L60M4X8	T-15

TT型螺纹刀杆(排刀型) Threading Tool Holders





图片为左手刀具
Right Cutting Tools(see picture)

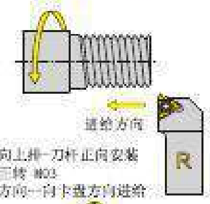
左刀杆	尺寸Dimensions(mm)						刀片	刀片螺钉	扳手
Left Hand	H	h	b	L	F	h	Insert	Insert Screw	Torx Key
KTTL1010H-16F-A90	10	10	10	100	18	4.8	TT32R★★★★	L60M4X8	T-15
KTTL1212H-16F-A90	12	12	12	100	20	6.2		L60M4X8	T-15
KTTL1616K-16F-A90	16	16	16	125	24	7	TTX32R★★★★	L60M4X8	T-15
KTTL2020K-16F-A90	20	20	20	125	28	8.5		L60M4X8	T-15

螺纹车削刀具
THREADING TURNING TOOLS

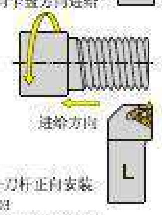
应用资料 Application Data

螺纹车削加工方案对照表
Comparison Table of Threading Cutting Machining

外螺纹---右旋螺纹 External-Right Hand

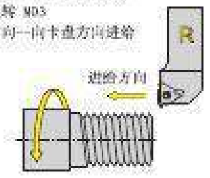


铁屑向上排-刀杆正向安装
主轴正转 M03
进给方向—向卡盘方向进给

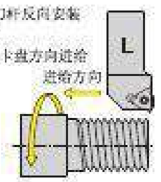


铁屑向上排-刀杆正向安装
主轴正转 M03
进给方向—向卡盘方向进给
注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

铁屑向下排-刀杆反向安装
主轴正转 M03
进给方向—向卡盘方向进给

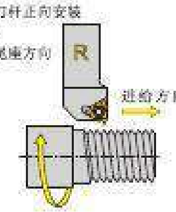


铁屑向下排-刀杆反向安装
主轴正转 M03
进给方向—向卡盘方向进给

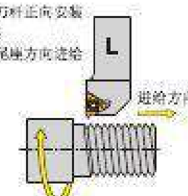


注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

铁屑向上排-刀杆正向安装
主轴反转 M04
进给方向-向尾座方向进给

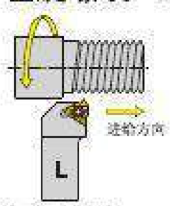


铁屑向上排-刀杆正向安装
主轴反转 M04
进给方向-向尾座方向进给

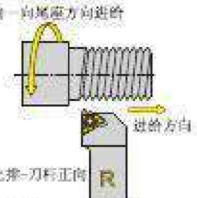


注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

外螺纹---左旋螺纹 External-Left Hand

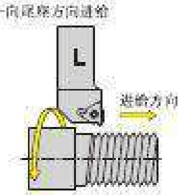


铁屑向上排-刀杆正向安装
主轴正转 M03
进给方向—向尾座方向进给

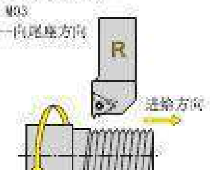


铁屑向上排-刀杆正向安装
主轴正转 M03
进给方向—向尾座方向进给
注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

铁屑向下排-刀杆反向安装
主轴正转 M03
进给方向—向尾座方向进给

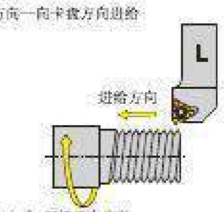


铁屑向下排-刀杆反向安装
主轴正转 M03
进给方向—向尾座方向进给

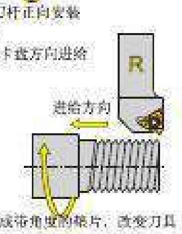


注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

铁屑向上排-刀杆正向安装
主轴反转 M04
进给方向—向卡盘方向进给



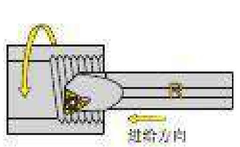
铁屑向上排-刀杆正向安装
主轴反转 M04
进给方向—向卡盘方向进给



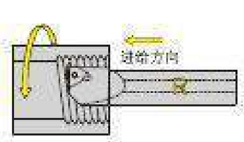
注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

内螺纹---右旋螺纹 Internal-Right Hand

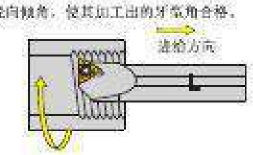
铁屑向上排-刀杆正向安装
主轴正转 M03
进给方向—向卡盘方向进给



铁屑向下排-刀杆反向安装
主轴正转 M03
进给方向—向卡盘方向进给

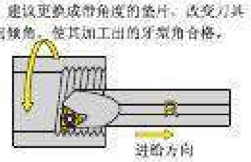


铁屑向上排-刀杆正向安装
主轴反转 M04
进给方向-向尾座方向进给
注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

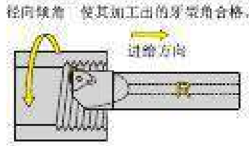


内螺纹---左旋螺纹 Internal-Left Hand

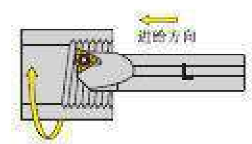
铁屑向上排-刀杆正向安装
主轴正转 M03
进给方向—向尾座方向进给
注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。



铁屑向下排-刀杆反向安装
主轴正转 M03
进给方向—向尾座方向进给
注：建议更换成带角度的垫片，改变刀具径向倾角，使其加工出的牙型角合格。

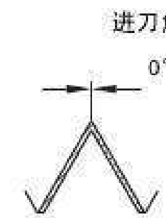


铁屑向上排-刀杆正向安装
主轴反转 M04
进给方向-向卡盘方向进给



应用资料 Application Data

径向对中（0°）进刀



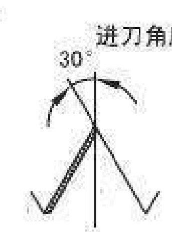
优点：

刀片全部刀刃对螺纹牙形两侧同时切削，防止刀刃崩刀。

缺点：

排屑困难。在切削高强度材料时容易崩刀。产生毛刺的可能性增大。
由于在精车螺纹时整个切削刃全部切入，容易会引起振刀。

齿侧30°进刀



优点：

利用刀片侧刃进给切削，使切屑容易排出切削区域，这就减少刀片后沿形成毛刺的问题，为了避免由于刀刃后沿摩擦而降低表面光洁度、崩刀或齿侧面过度的磨损，横向进刀的角度应小于螺纹齿形角3°-5°这是一种齿侧面修正类型。

缺点：

刀片可能有拖曳或摩擦的现象而使刃口崩刃。在切削软而粘性的金属，如低碳钢，铝和不锈钢时，会破坏表面光洁度。

修正齿侧进刀

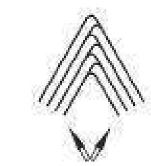
优点：

刀片同时切削螺纹牙形两侧，防止像0°进刀时容易发生的崩刃，虽然也会形成排屑沟槽，但是由于切屑厚度不平均有利于排屑，犹如齿侧进刀 这是比较好的进刀方法，尤其是使用有断屑槽的刀片时。

缺点：

和径向对中进刀的缺点相同，但是在降低切削力方面比较明显，同时排屑的问题也得到解决。

齿侧交替进刀



优点：

由于两侧切削刃平均使用，提高了刀片的寿命。
注：采用这种进刀方法对一些机床可能需要特殊的编程技术。

缺点：

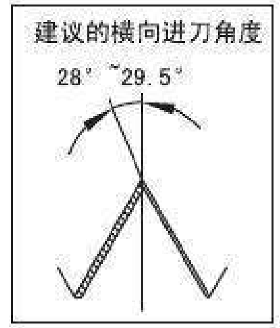
在传统机床上加工困难。

应用资料 Application Data

■ 机床编程

现代CNC控制的刀片在横向进刀角度28°-29.5°时性能最好，当然也可使用20°-30°的进刀角度。同时，重要的是要保持每一刀的最小切削深度为0.005英寸（0.13mm）；为了更稳定的控制切屑，建议进刀深度保持在0.005-0.010英寸（0.13-0.25 mm）之间的一个恒定的数值。

横向进刀角度

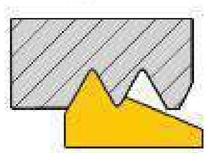


修正齿侧进刀

■ 最后一刀

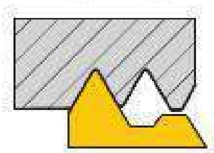
某些CNC控制的机床要求最后一刀为0°的进刀速度，切削大部分碳钢和合金钢工件时，最后一刀的切削深度可以为0.005英寸（0.13 mm），以形成合格的表面光洁度，对某些材料可采用进刀深度为0.001-0.003英寸（0.02-0.25 mm）的来回式走刀以提高表面光洁度。

全牙形刀片



全牙形和泛螺距牙形比较

泛螺距刀片



-螺纹尺寸是按照已制定的螺纹标准确定。
-由于螺纹外径和底径同时加工，因此可以得到同心度的螺纹。
-由于最后一刀加工出准确的螺纹牙形，减少额外的操作或去毛刺操作，因此降低加工成本。

-同一刀片可以加工规定范围内的不同螺距的螺纹。
-对非标螺纹的加工有较大的柔性。

公、英、美制螺纹刀具 THREADING TOOLS DROQING

应用资料 Application Data

走刀次数和进刀量

走刀次数和进刀量对于螺纹切削工序具有决定性影响。在大多数现代机床上，应在螺纹切削周期中给定总螺纹深度和第一次或最后一次切深。

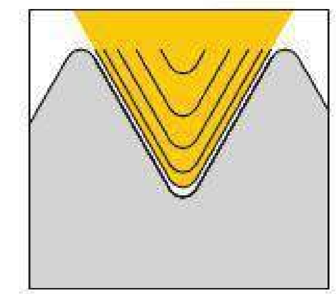
为了提高螺纹切削质量，应使用下面推荐的进刀量，对于多齿刀片，坚持使用进刀量推荐值是极为重要的。
可作为初始值的推荐值，合适的走刀次数必须通过实验来决定。

-为优化刀具寿命，工件直径应不超过螺纹的最大直径0.14mm
-应避免进刀量低于0.05mm
-对于奥氏不锈钢,进刀量应避免低于0.08mm

两种进一步提高切削质量的方法

① 连续递减 - 可获得不变的切屑面积

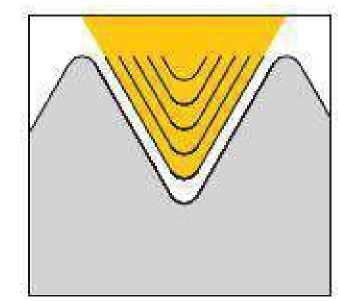
这包括相对较大的初始值（0.2-0.35mm），并且与螺纹牙形的具体深度有关。此值会逐渐降低且以0.02-0.09mm的进给进行精加工。最后一次走刀可以是不进刀的空走刀，这是用于消除切削过程中的反弹，这种走刀方式是现代 CNC 机床上最常用的方法。



切屑面积 + 跳跃走刀

② 恒定的进刀量 - 可获得最佳的切屑控制和长的刀具寿命。

在新型机床上正变得越来越通用的加工方法。通过固定螺纹切削周期中的某一个参数，而使切屑厚度恒定，进而可以形成最佳切屑。初始值大约为0.18-0.12mm，实际值应由上一次走刀（至少应为 0.08mm）的具体值确定。



恒定的走刀量

用于部分牙形刀片（V 形 55° 和 60°）的切削 参数

使用部分牙形刀片进行螺纹切削时，可使用推荐的走刀次数，但是，当使用具有小螺距的刀片时，每次走刀量不能超过最大推荐值。

注意！
当螺纹要求小公差时，最后一次走刀可不进刀（空走刀）。对于硬材料，则需要相应增加走刀次数。当螺纹切削加工淬硬材料（例如奥氏体不锈钢）时，进刀量应不得超过 0.08mm 。

螺纹车削刀具 THREADING TURNING TOOLS

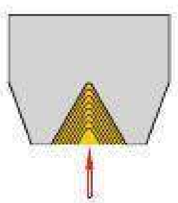
应用资料 Application Data

进刀方式的选择

共有三种不同类型的进刀方式
(1) 径向进刀
(2) 改进式侧向进刀
(3) 交替式进刀

■径向进刀

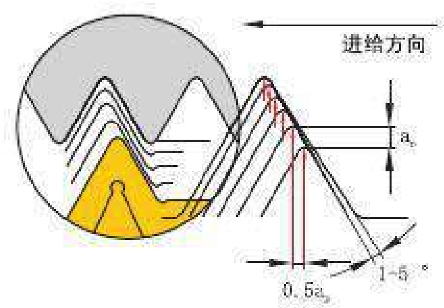
许多机床上最常用也只能使用的方法。可获得较软的断屑和使刀片磨损更均匀。适合于小螺距。当用于疏齿距时具有振动风险和较差的切屑控制。加工硬化材料（例如奥氏体不锈钢）的首选。



推荐使用表中给定的径向进给。

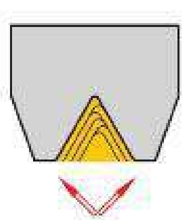
■改进式侧向进刀

对于60°牙形角的螺纹切削，轴向进刀量可以简单地按 0.5x 径向进刀量来计算。对于55°的牙形角，则应以0.42x径向进刀量进行计算.这便可得到一个比螺纹的牙形角小5°的进刀角。



■交替式进刀

主要用于切削大牙形时。此方法可获得均匀的刀片磨损和长刀具寿命。



需要在 CNC 机床上进行特定编程。

■如何控制切屑

当排屑通畅时，可获得良好的表面质量。当排屑不通畅和发生振动时，适合于粗牙螺纹和内螺纹。为避免表面粗糙度或由于后缘的摩擦而导致过度的后刀面磨损，应使进刀角保持为3~5°，且比螺旋角要小。

实际上，由机床、工件材料、刀片槽型和螺距共同决定了进刀方式的选择。

应用资料 Application Data

■公式

按公式以连续递减方式计算每次走刀量

$$\Delta_{apx} = \frac{a_p}{\sqrt{nap-1}} \times \sqrt{\eta}$$

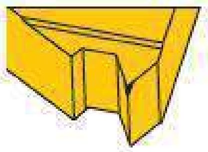
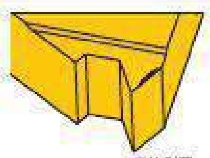
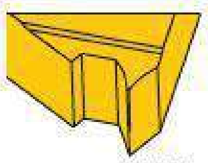
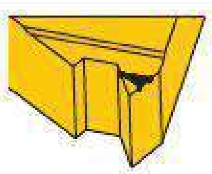
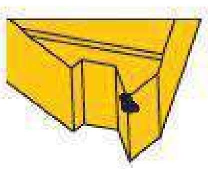
Δ_{ap} 径向进给
x 实际走刀（从 1 到 nap 的系列值）
a_p 螺纹总深度
nap 走刀次数
η 第一次走刀 = 0.3
第二次走刀 = 1
第三次及更多走刀 = X-1

示例:

工况:	计算:	结果:
外螺纹切削 螺距: 1.5mm a_p: 0.94mm nap: 6次走刀	$\Delta_{ap}1 = \frac{0.94}{\sqrt{5}} \times \sqrt{0.3} = 0.23$	第一次走刀，进刀量 =0.23mm
	$\Delta_{ap}2 = \frac{0.94}{\sqrt{5}} \times \sqrt{1} = 0.42$	第二次走刀，进刀量 0.42-0.23=0.19mm
	$\Delta_{ap}3 = \frac{0.94}{\sqrt{5}} \times \sqrt{2} = 0.59$	第三次走刀，进刀量 0.59-0.42=0.17mm
	$\Delta_{ap}4 = \frac{0.94}{\sqrt{5}} \times \sqrt{3} = 0.73$	第四次走刀，进刀量 0.73-0.59=0.14mm
	$\Delta_{ap}5 = \frac{0.94}{\sqrt{5}} \times \sqrt{4} = 0.84$	第五次走刀，进刀量 0.84-0.73=0.11mm
	$\Delta_{ap}6 = \frac{0.94}{\sqrt{5}} \times \sqrt{5} = 0.94$	第六次走刀，进刀量 0.94-0.84=0.1mm

应用资料 Application Data

疑难解析 FAQ

问题 Questions	原因 Reasons	措施 Solutions
 后刀面磨损过快 Quick-wearing flank	切削速度太高 Cutting speed is fast	减小主轴转速 To decrease spindle speed
	横切深度太小 Transverse cutting depth is too small	增大横切深度 To enlarge transverse cutting depth
		更改侧向进给 To change the lateral feeding
	材料不耐磨 Material is not wear-resistant	应用涂层类 To make applicable coating
	冷却液供给不足 Coolant is not enough for demand	增加冷却液供给 To increase the supply of coolant
	错误的倾斜刀垫 The slope of anvil is wrong	重新选择刀垫 To choose a new anvil
	错误的车削直径 The cutting diameter is wrong	调整车削直径 To adjust cutting diameter
	刀片在中心线以上 The insert is above the center line	调整中心高度 To adjust center height
 刃边剥落 Cutting edge peeling off	切削速度太高 Cutting speed is fast	减小主轴转速 To decrease spindle speed
	横切深度太小 Transverse cutting depth is too small	减小切削深度 To decrease cutting depth
	牌号选择错误 Coating grade is wrong	应用涂层类牌号 To choose applicable coating grade
		应用高韧性类牌号 To use high-roughness coating grade
	切屑控制不良 Control of cutting is not good	更改侧向进给 To change the lateral feeding
	冷却液供给不足 Coolant is not enough for demand	增加冷却液供给 To increase the supply of coolant
	中心高度不正确 The center height is not correct	调整中心高度 To adjust center height
 塑性变形 Plastic deformation	塑性变切削区温度过高 The temperature in plastic variation cutting area is too high	减小主轴转速 To decrease spindle speed
		减小切削深度 To decrease cutting depth
		调整车削直径 To adjust cutting diameter
	牌号选择错误 Coating grade is wrong	应用涂层类牌号 To choose applicable coating grade
		应用硬性牌号 To used hardness coating grade
	冷却液供给不足 Coolant is not enough for demand	增加冷却液供给 To increase the supply of coolant
 积屑瘤 Cutting tumor	切削温度过低 Cutting temperature is too low	增加主轴转速 To increase spindle speed
		增加切削深度 To increase cutting depth
	牌号选择错误 Coating grade is wrong	应用涂层类牌号 To choose applicable coating grade
	冷却液供给不足 Coolant is not enough for demand	增加冷却液供给 To increase the supply of coolant
 刀片破损 Insert broken	切削刃温度过低 The temperature of cutting edge is too low	增加主轴转速 To increase spindle speed
	切深太大 Cutting depth is too large	降低切深 To decrease cutting depth
		增加进刀次数 To increase feed times
	牌号选择错误 Coating grade is wrong	应用韧性牌号 To choose roughness coating greade
	错误的车削直径 Cutting diameter is wrong	调整车削直径 To adjust cutting diameter
	中心高度不正确 Center height is wrong	调整中心高度 To adjust center height
	横切深度太小 Transverse cutting depth is too small	更改侧向进给 To change lateral feeding
	错误的倾斜刀垫 The slope of anvil is wrong	重新选择刀垫 To choose a new anvil
	刀具悬伸太长 The overhang of cutter is too long	减少刀具悬伸 To shorten overhang of cutter
表面质量差 Bad quality of surface	错误的切削速度 Cutting speed is wrong	增加主轴转速 To increase spindle speed
		降低切削速度 To decrease cutting speed
	切削区温度过高 Temperature in cutting area is too high	减小切削深度 To decrease cutting depth
	切屑控制不良 Control of cutting is not good	更改侧向进给 To change the lateral feeding
	冷却液供给不足 Coolant is not enough for demand	增加冷却液供给 To increase the supply of coolant
	错误的倾斜刀垫 The slope of anvil is wrong	重新选择刀垫 To choose a new anvil
	刀具悬伸太长 The overhang of cutter is too long	减少刀具悬伸 To shorten overhang of cutter
	中心高度不正确 The center height is not correct	调整中心高度 To adjust center height
切屑控制不良 Bad control of cutting	切削区温度过高 Temperature in cutting area is too high	减小主轴转速 To decrease spindle speed
		减小切削深度 To decrease cutting speed
		调整车削直径 To adjust cutting diameter
	牌号选择错误 Coating grade is wrong	应用涂层类牌号 To choose applicable coating grade
		调整车削直径 To adjust cutting diameter
		应用 M 型刀片 To use M-style inserts
	冷却液供给不足 Coolant is not enough for demand	增加冷却液供给 To increase the supply of coolant
	错误的车削直径 Cutting diameter is wrong	调整车削直径 To adjust cutting diameter

应用资料 Application Data

螺纹刀片进刀量推荐值

Treading Insert Cutting Times within Definite Depth for Reference

ISO公制螺纹60° -外螺纹　　60° ISO Metric Full Profile-External

螺距（mm） Pitch	总切削深度 Cutting Depth	加工步数 Cutting Steps 1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	适用刀片 Applicable Inserts 全面磨削型 Full Profile Cutting Style
0.5	0.31	0.1	0.08	0.07	0.06												16ER0.50ISO
0.75	0.46	0.16	0.14	0.10	0.06												16ER0.75ISO
1.0	0.61	0.18	0.15	0.12	0.10	0.06											16ER1.00ISO
1.25	0.77	0.19	0.17	0.14	0.11	0.10	0.06										16ER1.25ISO
1.5	0.92	0.22	0.21	0.17	0.14	0.12	0.06										16ER1.50ISO
1.75	1.07	0.22	0.21	0.16	0.13	0.11	0.09	0.09	0.06								16ER1.75ISO
2.0	1.23	0.24	0.23	0.17	0.16	0.14	0.12	0.11	0.06								16ER2.00ISO
2.5	1.53	0.26	0.23	0.19	0.17	0.15	0.13	0.12	0.11	0.11	0.06						16ER2.50ISO
3.0	1.84	0.27	0.25	0.20	0.18	0.16	0.14	0.13	0.12	0.12	0.11	0.10	0.06				16ER3.00ISO
3.5	2.15	0.33	0.30	0.24	0.21	0.18	0.17	0.15	0.14	0.14	0.12	0.11	0.06				22ER3.50ISO
4.0	2.45	0.34	0.31	0.24	0.22	0.19	0.17	0.16	0.14	0.14	0.13	0.12	0.12	0.11	0.06		22ER4.00ISO
4.5	2.76	0.38	0.34	0.28	0.24	0.22	0.20	0.18	0.16	0.16	0.15	0.14	0.13	0.12	0.06		22ER4.50ISO
5.0	3.07	0.42	0.38	0.32	0.27	0.24	0.22	0.20	0.18	0.18	0.17	0.16	0.15	0.12	0.06		22ER5.00ISO

UN 螺纹60° -外螺纹　　UN 60° Full Profile-External

螺距（牙数/英寸） Pitch(Tooth/inch)	总切削深度 Cutting Depth	加工步数 Cutting Steps 1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	适用刀片 Applicable Inserts 全面磨削型 Full Profile Cutting Style
32	0.49	0.17	0.15	0.11	0.06												16ER32UN
28	0.56	0.17	0.14	0.10	0.09	0.06											16ER28UN
24	0.65	0.18	0.16	0.14	0.11	0.06											16ER24UN
20	0.78	0.20	0.18	0.13	0.11	0.10	0.06										16ER20UN
18	0.87	0.22	0.20	0.15	0.13	0.11	0.06										16ER18UN
16	0.97	0.22	0.20	0.15	0.12	0.11	0.11	0.06									16ER16UN
14	1.11	0.23	0.21	0.16	0.13	0.11	0.11	0.10	0.06								16ER14UN
13	1.20	0.25	0.22	0.17	0.14	0.13	0.12	0.11	0.06								16ER13UN
12	1.30	0.28	0.23	0.18	0.16	0.14	0.13	0.12	0.06								16ER12UN
11	1.42	0.28	0.23	0.19	0.16	0.14	0.13	0.12	0.11	0.06							16ER11UN
10	1.56	0.28	0.24	0.19	0.16	0.14	0.13	0.13	0.12	0.11	0.06						16ER10UN
9	1.73	0.34	0.29	0.22	0.17	0.15	0.14	0.13	0.12	0.11	0.06						16ER9UN
8	1.95	0.35	0.30	0.24	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					16ER8UN
7	2.22	0.37	0.33	0.28	0.24	0.20	0.17	0.16	0.15	0.14	0.12	0.06					22ER7UN
6	2.60	0.42	0.35	0.29	0.25	0.21	0.18	0.17	0.16	0.15	0.15	0.12	0.11	0.06			22ER6UN
5	3.12	0.43	0.39	0.31	0.27	0.24	0.22	0.20	0.19	0.19	0.19	0.17	0.15	0.12	0.06		22ER5UN

应用资料 Application Data

螺纹刀片进刀量推荐值
Treading Insert Cutting Times within Definite Depth for Reference

惠氏螺纹55° -外螺纹　Whitworth 55° Full Profile-External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style
28	0.58	0.17	0.14	0.11	0.10	0.06											16ER28W
26	0.63	0.18	0.15	0.13	0.11	0.06											16ER26W
20	0.81	0.20	0.18	0.14	0.12	0.11	0.06										16ER20W
19	0.86	0.21	0.19	0.15	0.13	0.12	0.06										16ER19W
18	0.90	0.25	0.19	0.15	0.13	0.12	0.06										16ER18W
16	1.02	0.21	0.18	0.15	0.13	0.11	0.09	0.09	0.06								16ER16W
14	1.16	0.23	0.21	0.17	0.14	0.12	0.12	0.11	0.06								16ER14W
12	1.36	0.27	0.25	0.20	0.16	0.15	0.14	0.13	0.06								16ER12W
11	1.48	0.27	0.24	0.20	0.17	0.15	0.14	0.13	0.12	0.06							16ER11W
10	1.63	0.27	0.25	0.20	0.17	0.15	0.15	0.13	0.13	0.12	0.06						16ER10W
9	1.81	0.28	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.06					16ER9W
8	2.03	0.30	0.27	0.22	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.06				16ER8W
7	2.32	0.34	0.32	0.26	0.22	0.20	0.18	0.17	0.16	0.15	0.14	0.12	0.06				22ER7W
6	2.71	0.35	0.33	0.27	0.23	0.21	0.20	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.06		22ER6W
5	3.25	0.42	0.40	0.35	0.29	0.26	0.24	0.22	0.20	0.19	0.18	0.17	0.15	0.12	0.06		22ER5W

英制BSPT55° -外螺纹　BSPT55° -External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style
28	0.58	0.17	0.14	0.11	0.10	0.06											16ER28BSPT
19	0.86	0.22	0.19	0.15	0.12	0.12	0.06										16ER19BSPT
14	1.16	0.24	0.20	0.17	0.14	0.12	0.12	0.11	0.06								16ER14BSPT
11	1.48	0.25	0.23	0.21	0.18	0.16	0.14	0.13	0.12	0.06							16ER11BSPT

圆形DIN405 30° -外螺纹　Round DIN405 30° -External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style
10	1.27	0.02	0.21	0.20	0.19	0.16	0.12	0.10	0.06								16ER10RD
8	1.59	0.23	0.21	0.20	0.19	0.18	0.16	0.14	0.12	0.10	0.06						16ER8RD
6	2.12	0.26	0.25	0.24	0.22	0.21	0.19	0.17	0.16	0.14	0.12	0.10	0.06				16ER6RD
4	3.18	0.34	0.33	0.32	0.30	0.18	0.26	0.24	0.22	0.20	0.19	0.17	0.15	0.12	0.06		22ER4RD

公、英、美制螺纹刀具 THREADING TOOLS DROQING

螺纹车削刀具 THREADING TURNING TOOLS

应用资料 Application Data

螺纹刀片进刀量推荐值
Treading Insert Cutting Times within Definite Depth for Reference

ISO梯形30° -外螺纹　ISO TR-30° -External

螺距（mm）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts
Pitch	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style
1.5	0.90	0.23	0.21	0.16	0.13	0.11	0.06										16ER1.5TR
2	1.25	0.29	0.26	0.21	0.17	0.14	0.12	0.06									16ER2.0TR
3	1.75	0.32	0.31	0.24	0.19	0.18	0.17	0.15	0.13	0.06							16ER3.0TR
4	2.25	0.33	0.32	0.24	0.22	0.21	0.17	0.16	0.15	0.14	0.13	0.12	0.16				22ER4.0TR
5	2.75	0.35	0.32	0.26	0.24	0.22	0.21	0.19	0.19	0.17	0.15	0.14	0.13	0.12	0.06		22ER5.0TR

ACME梯形29° -外螺纹　ACME 29° -External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style
12	1.19	0.27	0.23	0.20	0.17	0.14	0.12	0.06	0.06								16ER12ACME
10	1.52	0.29	0.25	0.21	0.18	0.16	0.14	0.12	0.11	0.06							16ER10ACME
8	1.84	0.30	0.26	0.22	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					16ER8ACME
6	2.37	0.34	0.30	0.27	0.24	0.21	0.19	0.16	0.14	0.12	0.12	0.11	0.11	0.06			22ER6ACME
5	2.79	0.36	0.33	0.30	0.26	0.23	0.20	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.06		22ER5ACME

UNJ60° 美制航空航天螺纹-外螺纹　UNJ 60° -External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style
32	0.46	0.16	0.14	0.10	0.06												16ER32UNJ
28	0.52	0.16	0.12	0.09	0.09	0.06											16ER28UNJ
24	0.61	0.17	0.14	0.14	0.14	0.06											16ER24UNJ
20	0.73	0.19	0.16	0.13	0.13	0.09	0.06										16ER20UNJ
18	0.81	0.23	0.18	0.14	0.14	0.10	0.06										16ER18UNJ
16	0.92	0.26	0.21	0.14	0.14	0.10	0.09										16ER16UNJ
14	1.05	0.26	0.23	0.17	0.17	0.11	0.10	0.06									16ER14UNJ
12	1.22	0.28	0.27	0.20	0.20	0.13	0.11	0.06									16ER12UNJ
10	1.47	0.30	0.29	0.21	0.21	0.13	0.12	0.11	0.10	0.06							16ER10UNJ
8	1.83	0.31	0.30	0.23	0.23	0.15	0.14	0.13	0.12	0.11	0.10	0.06					16ER8UNJ

API锯齿形-外螺纹　API Buttress-External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style
5	1.55	0.25	0.23	0.17	0.15	0.13	0.12	0.12	0.11	0.11	0.10	0.06					22ER5APBU

应用资料 Application Data

螺纹刀片进刀量推荐值
Treading Insert Cutting Times within Definite Depth for Reference

API圆形60° -外螺纹　　API Round 60° -External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
10	1.41	0.25	0.23	0.16	0.14	0.12	0.12	0.12	0.11	0.10	0.06						16ER10APRD	
8	1.81	0.25	0.24	0.19	0.16	0.14	0.14	0.13	0.13	0.13	0.13	0.11	0.06				16ER8APRD	

美制NPT60° -外螺纹　　NPT60° -External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
27	0.66	0.15	0.13	0.12	0.11	0.09	0.06										16ER27NPT	
18	1.01	0.20	0.16	0.14	0.13	0.12	0.11	0.09	0.06								16ER18NPT	
14	1.33	0.23	0.19	0.16	0.14	0.13	0.12	0.11	0.10	0.09	0.06						16ER14NPT	
11.5	1.64	0.24	0.19	0.17	0.15	0.15	0.13	0.13	0.12	0.11	0.10	0.09	0.06				16ER11.5NPT	
8	2.42	0.33	0.28	0.23	0.20	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.11	0.10	0.06	16ER8NPT	

美制NPTF60° -外螺纹　　NPTF60° -External

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
27	0.64	0.16	0.14	0.11	0.09	0.08	0.06										16ER27NPTF	
18	1.00	0.19	0.16	0.14	0.13	0.12	0.11	0.09	0.06								16ER18NPTF	
14	1.35	0.23	0.21	0.21	0.14	0.13	0.12	0.11	0.10	0.09	0.06						16ER14NPTF	
11.5	1.63	0.24	0.23	0.23	0.15	0.13	0.11	0.11	0.11	0.10	0.10	0.10	0.06				16ER11.5NPTF	
8	2.38	0.32	0.27	0.27	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.11	0.10	0.06	16ER8NPTF	

螺纹车削刀具 THREADING TURNING TOOLS

应用资料 Application Data

螺纹刀片进刀量推荐值
Treading Insert Cutting Times within Definite Depth for Reference

ISO公制螺纹60° -内螺纹　　60° ISO Metric Full Profile-Internal

螺距（mm）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
0.5	0.29	0.09	0.07	0.07	0.06												11NR0.50ISO	16NR0.50ISO
0.75	0.43	0.15	0.13	0.09	0.06												11NR0.75ISO	16NR0.75ISO
1.0	0.58	0.17	0.15	0.11	0.09	0.06											11NR1.00ISO	16NR1.00ISO
1.25	0.72	0.18	0.16	0.12	0.11	0.09	0.06										11NR1.25ISO	16NR1.25ISO
1.5	0.87	0.21	0.20	0.16	0.13	0.11	0.06										11NR1.50ISO	16NR1.50ISO
1.75	1.01	0.21	0.20	0.15	0.12	0.10	0.09	0.08	0.06								11NR1.75ISO	16NR1.75ISO
2.0	1.15	0.24	0.22	0.18	0.14	0.12	0.10	0.09	0.06								11NR2.00ISO	16NR2.00ISO
2.5	1.44	0.25	0.24	0.21	0.15	0.13	0.12	0.10	0.09	0.09	0.06							16NR2.50ISO
3.0	1.73	0.26	0.25	0.22	0.17	0.14	0.13	0.12	0.11	0.10	0.09	0.08	0.06					16NR3.00ISO
3.5	2.02	0.32	0.30	0.23	0.19	0.17	0.15	0.14	0.13	0.12	0.11	0.10	0.06					22NR3.50ISO
4.0	2.31	0.33	0.31	0.24	0.22	0.18	0.15	0.14	0.13	0.12	0.12	0.11	0.10	0.10	0.06			22NR4.00ISO
4.5	2.60	0.36	0.33	0.28	0.24	0.21	0.19	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.06			22NR4.50ISO
5.0	2.89	0.41	0.38	0.32	0.27	0.24	0.21	0.18	0.16	0.15	0.14	0.13	0.13	0.12	0.06			22NR5.00ISO

UN 螺纹60° -内螺纹　　UN 60° Full Profile-Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
32	0.46	0.16	0.14	0.10	0.06												11NR32UN	16NR32UN
28	0.52	0.16	0.13	0.09	0.08	0.06											11NR28UN	16NR28UN
24	0.61	0.17	0.15	0.13	0.10	0.06											11NR24UN	16NR24UN
20	0.73	0.18	0.15	0.13	0.11	0.10	0.06										11NR20UN	16NR20UN
18	0.81	0.20	0.18	0.14	0.12	0.11	0.06										11NR18UN	16NR18UN
16	0.92	0.20	0.18	0.15	0.12	0.11	0.10	0.06									11NR16UN	16NR16UN
14	1.06	0.21	0.18	0.15	0.13	0.11	0.11	0.10	0.06								11NR14UN	16NR14UN
13	1.13	0.22	0.19	0.16	0.14	0.13	0.12	0.11	0.06									16NR13UN
12	1.22	0.24	0.22	0.18	0.16	0.13	0.12	0.11	0.06									16NR12UN
11	1.33	0.24	0.22	0.20	0.15	0.12	0.12	0.11	0.11	0.06								16NR11UN
10	1.47	0.25	0.22	0.21	0.14	0.13	0.12	0.12	0.11	0.11	0.06							16NR10UN
9	1.63	0.31	0.23	0.21	0.17	0.15	0.14	0.13	0.12	0.11	0.06							16NR9UN
8	1.83	0.31	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.11	0.06						16NR8UN
7	2.09	0.36	0.30	0.24	0.21	0.18	0.17	0.16	0.15	0.14	0.12	0.06						22NR7UN
6	2.44	0.40	0.33	0.25	0.23	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.11	0.06				22NR6UN
5	2.93	0.41	0.35	0.31	0.26	0.23	0.21	0.20	0.19	0.17	0.15	0.14	0.13	0.12	0.06			22NR5UN

螺纹车削刀具 THREADING TURNING TOOLS

应用资料 Application Data

螺纹刀片进刀量推荐值
Treading Insert Cutting Times within Definite Depth for Reference

惠氏螺纹55° -内螺纹　Whitworth 55° Full Profile-Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
28	0.58	0.17	0.14	0.11	0.10	0.06												16NR28W
26	0.63	0.18	0.15	0.13	0.11	0.06												16NR26W
20	0.81	0.20	0.18	0.14	0.12	0.11	0.06											16NR20W
19	0.86	0.21	0.19	0.15	0.13	0.12	0.06										11NR19W	16NR19W
18	0.90	0.25	0.19	0.15	0.13	0.12	0.06											16NR18W
16	1.02	0.21	0.18	0.15	0.13	0.11	0.09	0.09	0.06									16NR16W
14	1.16	0.23	0.21	0.17	0.14	0.12	0.12	0.11	0.06								11NR14W	16NR14W
12	1.36	0.27	0.25	0.20	0.16	0.15	0.14	0.13	0.06									16NR12W
11	1.48	0.27	0.24	0.20	0.17	0.15	0.14	0.13	0.12	0.06								16NR11W
10	1.63	0.27	0.25	0.20	0.17	0.15	0.15	0.13	0.13	0.12	0.06							16NR10W
9	1.81	0.28	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.06						16NR9W
8	2.03	0.30	0.27	0.22	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.06					16NR8W
7	2.32	0.34	0.32	0.26	0.22	0.20	0.18	0.17	0.16	0.15	0.14	0.12	0.06					22NR7W
6	2.71	0.35	0.33	0.27	0.23	0.21	0.20	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.06			22NR6W
5	3.25	0.42	0.40	0.35	0.29	0.26	0.24	0.22	0.20	0.19	0.18	0.17	0.15	0.12	0.06			22NR5W

英制BSPT55° -内螺纹　BSPT55° -Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
19	0.86	0.22	0.19	0.15	0.12	0.12	0.06										11NR19BSPT	16NR19BSPT
14	1.16	0.24	0.20	0.17	0.14	0.12	0.12	0.11	0.06								11NR14BSPT	16NR14BSPT
11	1.48	0.25	0.23	0.21	0.18	0.16	0.14	0.13	0.12	0.06								16NR11BSPT

园形DIN405 30° -内螺纹　Round DIN405 30° -Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
10	1.27	0.02	0.21	0.20	0.19	0.16	0.12	0.10	0.06								16NR10RD	
8	1.59	0.23	0.21	0.20	0.19	0.18	0.16	0.14	0.12	0.10	0.06						16NR8RD	
6	2.12	0.26	0.25	0.24	0.22	0.21	0.19	0.17	0.16	0.14	0.12	0.10	0.06				16NR6RD	
4	3.18	0.34	0.33	0.32	0.30	0.18	0.26	0.24	0.22	0.20	0.19	0.17	0.15	0.12	0.06		22NR4RD	

应用资料 Application Data

螺纹刀片进刀量推荐值
Treading Insert Cutting Times within Definite Depth for Reference

ISO梯形30° -内螺纹　ISO TR-30° -Internal

螺距（mm）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
1.5	0.90	0.23	0.21	0.16	0.13	0.11	0.06										16NR1.5TR	
2	1.25	0.29	0.26	0.21	0.17	0.14	0.12	0.06									16NR2.0TR	
3	1.75	0.32	0.31	0.24	0.19	0.18	0.17	0.15	0.13	0.06							16NR3.0TR	
4	2.25	0.33	0.32	0.24	0.22	0.21	0.17	0.16	0.15	0.14	0.13	0.12	0.16				22NR4.0TR	
5	2.75	0.35	0.32	0.26	0.24	0.22	0.21	0.19	0.19	0.17	0.15	0.14	0.13	0.12	0.06		22NR5.0TR	

ACME梯形29° -内螺纹　ACME 29° -Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
12	1.19	0.27	0.23	0.20	0.17	0.14	0.12	0.06	0.06								16NR12ACME	
10	1.52	0.29	0.25	0.21	0.18	0.16	0.14	0.12	0.11	0.06							16NR10ACME	
8	1.84	0.30	0.26	0.22	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					16NR8ACME	
6	2.37	0.34	0.30	0.27	0.24	0.21	0.19	0.16	0.14	0.12	0.12	0.11	0.11	0.06			22NR6ACME	
5	2.79	0.36	0.33	0.30	0.26	0.23	0.20	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.06		22NR5ACME	

API锯齿形-内螺纹　API Buttress-Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
5	1.55	0.25	0.23	0.17	0.15	0.13	0.12	0.12	0.11	0.11	0.10	0.06					22NR5APBU	

API圆形60° -内螺纹　API Round 60° -Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
10	1.41	0.25	0.23	0.16	0.14	0.12	0.12	0.12	0.11	0.10	0.06						16NR10APRD	
8	1.81	0.25	0.24	0.19	0.16	0.14	0.14	0.13	0.13	0.13	0.13	0.11	0.06				16NR8APRD	

美制NPT60° -内螺纹　NPT60° -Internal

螺距（牙数/英寸）	总切削深度	加工步数 Cutting Steps															适用刀片 Applicable Inserts	
Pitch(Tooth/inch)	Cutting Depth	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全面磨削型 Full Profile Cutting Style	
27	0.66	0.15	0.13	0.12	0.11	0.09	0.06										16NR27NPT	
18	1.01	0.20	0.16	0.14	0.13	0.12	0.11	0.09	0.06								16NR18NPT	
14	1.33	0.23	0.19	0.16	0.14	0.13	0.12	0.11	0.10	0.09	0.06						16NR14NPT	
11.5	1.64	0.24	0.19	0.17	0.15	0.15	0.13	0.13	0.12	0.11	0.10	0.09	0.06				16NR11.5NPT	
8	2.42	0.33	0.28	0.23	0.20	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.11	0.10	0.06	16NR8NPT	

螺纹识别表 Thread Identification Table

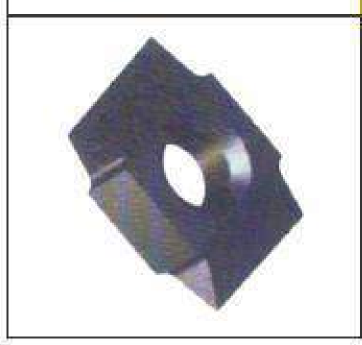
特征代号 Code	名称 Description	牙型（牙型角或牙侧角、锥度） Thread Angle	标记示例 Example of marking	适用刀片 Insert	国家、地区及标准编号 Example of marking
Acme	爱克母螺纹	牙型角29°；锥度为0	1 3/4-4Acme-2G	22ER4ACME	澳大利亚 AS B202-1962
					英国 BS1104:1957
					新西兰 NZS 1342:1958
					美国 ASME B1.5-1997
STUB Acme	矮牙爱克母螺纹	牙型角29°；锥度为0	0.500-16STUB；ACME	16ER16STACME	美国 ASME B1.8-1977
API Sucker Rod	美国石油学会抽油杆螺纹	牙型角60°；锥度为0	3/4 API Sucker Rod	16ER10APIRD	罗马尼亚 STAS 329-80
					美国 API Spec 11B-1986
B.S.F.	惠氏细牙螺纹	牙型角55°；锥度为0	1/2in.-16 B.S.F.	16ER16W	澳大利亚 AS 3501-1987
					英国 BS84-1956
					马来西亚 MS 218:1974
B.S.W.	惠氏粗牙螺纹	牙型角55°；锥度为0	1/4in.-20 B.S.W.	16ER20W	澳大利亚 AS 3501-1987
					英国 BS84-1956
					马来西亚 MS 218:1974
Butt	锯齿螺纹	牙侧角为7°/45°；锥度为0	2.5-8 Butt-2A	16ER8ABUT	美国 ANSI B1.9-1973
Buttress			2.0 BS Buttress; thread 8 tpi medium class		澳大利亚 AS B182-1961
					英国 BS 1657:1950
					新西兰 NZS 955:1951
G	55°非密封管螺纹	牙型角55°；锥度为0	G 1 1/2; G 1 1/2A; G 1 1/2B	16ER11W	国际 ISO 228-1:2000
					中国 GB/T 7307-2001
					德国DIN ISO228-1:2001
					法国pr NF EN ISO 228-1:2002
					英国BS 2779:1986
					俄罗斯GOST 6357-81
					日本JIS B 0202-1999
					澳大利亚 AS 1722:Part 2-1975
					巴西NBR 6414/83
					意大利UNI ISO 228-1
NPT	一般密封圆锥管螺纹	牙型角60°；锥度为1:16	NPT 3/8; 3/8-18 NPT	16ER18NPT	中国 GB/T 12716-2002
					厄瓜多尔 INEN 117
					法国 NF E03-601，NF E29-684
					俄罗斯GOST 6111
					美国 ASME B1.20.1-1983
NPTF	干密封圆锥管螺纹	牙型角60°；锥度为1:16	1/8-27 NPTF-1	11ER27NPTF	瑞典SMS1704，SMS1706，SMS1707
					美国 ANSI B1.20.3-1976
Tr	ISO米制梯形螺纹	牙型角30°；锥度为0	Tr 40x7	27ER7.0TR	国际 ISO 2901，ISO2903-1993，ISO2902，ISO2904-1977
					中国 GB/T5796.1`5796.4-2005，BT/T12359-2008
					德国DIN 103 T1~T8，DIN263 T1~T2,DIN6341
					法国NF ISO 2901-2903:1997
					英国NF BS5346:1976
					日本JIS B 0216~0218
					俄罗斯GOST 9484，GOST 9562，GOST 24737，GOST 24738，GOST 24739-1981
					意大利UNI ISO 2901~2904
					荷兰 NEN2780~2784
					印度IS:7008(Part Ⅰ~Ⅳ)-1973
					芬兰SFS 4499~4502

螺纹识别表 Thread Identification Table

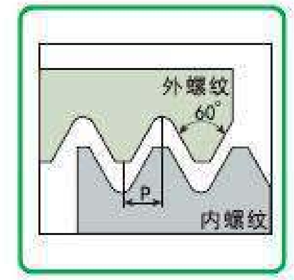
特征代号 Code	名称 Description	牙型（牙型角或牙侧角、锥度） Thread Angle	标记示例 Example of marking	适用刀片 Insert	国家、地区及标准编号 Example of marking
UN	统一螺纹	牙型角60°；锥度为0	2 1/2-16 UN-2B	16ER16UN	国际ISO 68-2:1998，ISO 263:1973，ISO 725:1978，ISO 5864:1993
					澳大利亚AS B133：Part1~2
					中国GB/T 20667~20670-2006
					丹麦DS/ISO 263.DS/ISO 725
					英国BS ISO 68-2:1998，BS 1580-1~1580-3
					新西兰 NZS 1227
					瑞典 SMS 1713
					美国 ASME B1.1-1989
W	惠氏螺纹	牙型角55°；锥度为0	W 3/16	16ER24W	阿根廷 IRAM 5030 IRAM 5036
					瑞士SNV 24460.SNV 219504
					德国 DIN 477 Tl.DIN 4668，DIN 49301
					意大利 UNI 2708~2709
					瑞典 SMS 3 B
Rc	55°密封圆锥内螺纹	牙型角55°；锥度1:16	Rc 1 1/4	16ER11BSPT	国际ISO 7-1:1994
					中国 GB/T 7306.2-2000
					法国 NF E03-004
					英国 BS 21:1985
					印度IS:554-1975
					意大利 UNI ISO 7-1
					日本JIS B 0203-1999
					俄罗斯GOST 6211-81
					瑞典 SS ISO 7-1

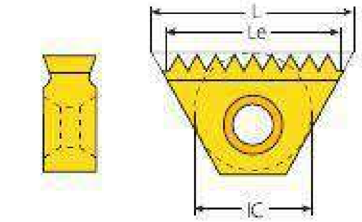
DAOQING

目录 Contents



ISO标准型螺纹铣刀片 ISO Metric Full Profile



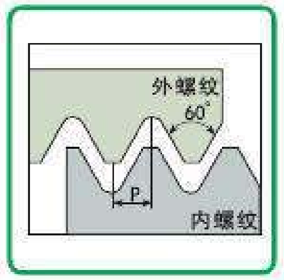


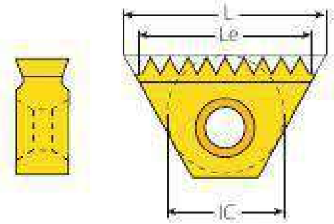
双面使用 TM标准型

加工螺距 Pitch		尺寸 Dimensions (mm)					
mm		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
0.5	外Ext						
	内Int	TM6.0N0.5 ISO	TM2N0.5 ISO	TM3N0.5 ISO			
0.75	外Ext		TM2E0.75 ISO	TM3E0.75 ISO			
	内Int	TM6.0N0.75 ISO	TM2N0.75 ISO	TM3N0.75 ISO			
1.0	外Ext		TM2E1.0 ISO	TM3E1.0 ISO	TM3BE1.0 ISO	TM5E1.0 ISO	
	内Int	TM6.0N1.0 ISO	TM2N1.0 ISO	TM3N1.0 ISO	TM3BN1.0 ISO	TM5N1.0 ISO	
1.25	外Ext		TM2E1.25 ISO	TM3E1.25 ISO	TM3BE1.25 ISO	TM5E1.25 ISO	
	内Int	TM6.0N1.25 ISO	TM2N1.25 ISO	TM3N1.25 ISO	TM3BN1.25 ISO	TM5N1.25 ISO	
1.5	外Ext		TM2E1.5 ISO	TM3E1.5 ISO	TM3BE1.5 ISO	TM5E1.5 ISO	TM6BE1.5 ISO
	内Int	TM6.0N1.5 ISO	TM2N1.5 ISO	TM3N1.5 ISO	TM3BN1.5 ISO	TM5N1.5 ISO	TM6BN1.5 ISO
1.75	外Ext			TM3E1.75 ISO	TM3BE1.75 ISO	TM5E1.75 ISO	
	内Int			TM3N1.75 ISO	TM3BN1.75 ISO	TM5N1.75 ISO	
2.0	外Ext			TM3E2.0 ISO	TM3BE2.0 ISO	TM5E2.0 ISO	TM6BE2.0 ISO
	内Int			TM3N2.0 ISO	TM3BN2.0 ISO	TM5N2.0 ISO	TM6BN2.0 ISO
2.5	外Ext					TM5E2.5 ISO	TM6BE2.5 ISO
	内Int					TM5N2.5 ISO	TM6BN2.5 ISO
3.0	外Ext					TM5E3.0 ISO	TM6BE3.0 ISO
	内Int					TM5N3.0 ISO	TM6BN3.0 ISO
3.5	外Ext					TM5E3.5 ISO	
	内Int					TM5N3.5 ISO	
4.0	外Ext					TM5E4.0 ISO	TM6BE4.0 ISO
	内Int					TM5N4.0 ISO	TM6BN4.0 ISO
4.5	外Ext					TM5E4.5 ISO	TM6BE4.5 ISO
	内Int					TM5N4.5 ISO	TM6BN4.5 ISO
5.0	外Ext						TM6BE5.0 ISO
	内Int						TM6BN5.0 ISO
5.5	外Ext						TM6BE5.5 ISO
	内Int						TM6BN5.5 ISO
6.0	外Ext						TM6BE6.0 ISO
	内Int						TM6BN6.0 ISO

订货示例：TM5E4.0 ISO BR215 10片 Ordering example：TM5E4.0 ISO BR215 10pcs

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





双面使用 TM标准型

加工螺距 Pitch		尺寸 Dimensions (mm)					
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
48	外Ext						
	内Int		TM2N48 UN				
40	外Ext						
	内Int		TM2N40 UN	TM3N40 UN			
32	外Ext						
	内Int	TM6.0N32 UN	TM2N32 UN	TM3N32 UN			
28	外Ext		TM2E28 UN	TM3E28 UN			
	内Int	TM6.0N28 UN	TM2N28 UN	TM3N28 UN			
27	外Ext		TM2E27 UN	TM3E27 UN			
	内Int		TM2N27 UN	TM3N27 UN			
26	外Ext			TM3E26 UN			
	内Int			TM3N26 UN			
24	外Ext		TM2E24 UN	TM3E24 UN	TM3BE24 UN	TM5E24 UN	
	内Int	TM6.0N24 UN	TM2N24 UN	TM3N24 UN	TM3BN24 UN	TM5N24 UN	
20	外Ext		TM2E20 UN	TM3E20UN	TM3BE20UN	TM5E20 UN	
	内Int	TM6.0N20 UN	TM2N20 UN	TM3N20 UN	TM3BN20 UN	TM5N20 UN	
18	外Ext		TM2E18 UN	TM3E18 UN	TM3BE18 UN	TM5E18 UN	
	内Int	TM6.0N18 UN	TM2E18 UN	TM3N18 UN	TM3BN18 UN	TM5N18 UN	
16	外Ext		TM2N16 UN	TM3E16 UN	TM3BE16 UN	TM5E16 UN	
	内Int	TM6.0N16 UN	TM2N16 UN	TM3N16 UN	TM3BN16 UN	TM5N16 UN	
14	外Ext		TM2E14 UN	TM3E14 UN	TM3BE14 UN	TM5E14 UN	
	内Int		TM2N14 UN	TM3N14 UN	TM3BN14 UN	TM5N14 UN	
13	外Ext			TM3E13 UN	TM3BE13 UN	TM5E13 UN	
	内Int			TM3N13 UN	TM3BN13 UN	TM5N13 UN	
12	外Ext			TM3E12 UN	TM3BE12 UN	TM5E12 UN	
	内Int			TM3N12 UN	TM3BN12 UN	TM5N12 UN	
11.5	外Ext			TM3E11.5 UN		TM5E11.5 UN	
	内Int			TM3N11.5 UN		TM5N11.5 UN	

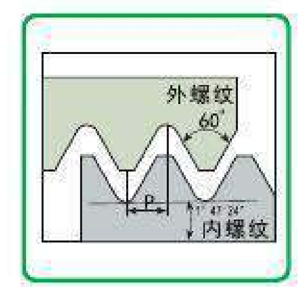
订货示例：TM3E12UN BR215 10片 Ordering example：TM3E12UN BR215 10pcs

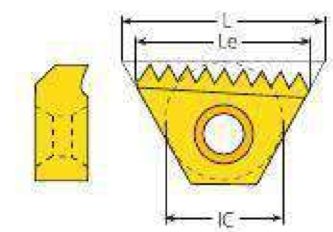
UN-60° 美制统一标准螺纹铣刀片 UN-60° American UN Full Profile

加工螺距 Pitch		尺寸 Dimensions (mm)					
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					TM5E11 UN	
	内Int					TM5N11 UN	
10	外Ext					TM5E10 UN	
	内Int					TM5N10 UN	
9	外Ext					TM5E9 UN	
	内Int					TM5N9 UN	
8	外Ext					TM5E8 UN	
	内Int					TM5N8 UN	
7	外Ext					TM5E7 UN	
	内Int					TM5N7 UN	
6	外Ext					TM5E6 UN	TM6BE6 UN
	内Int					TM5N6 UN	TM6BN6 UN
5	外Ext						TM6BE5 UN
	内Int						TM6BN5 UN
4.5	外Ext						TM6BE4.5 UN
	内Int						TM6BN4.5 UN
4	外Ext						TM6BE4 UN
	内Int						TM6BN4 UN

订货示例：TM5E6UN BR215 10片 Ordering example：TM5E6UN BR215 10pcs

NPTF 美制干密封螺纹铣刀片 NPTF (Dry seal)



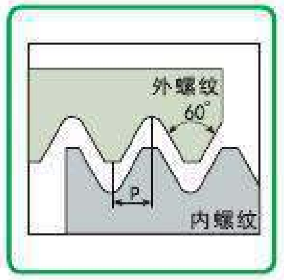


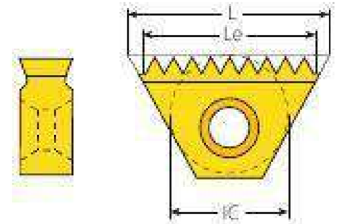
单面使用 TM标准型

加工螺距 Pitch	尺寸 Dimensions (mm)			
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	TM3-14 NPTF	TM3B-14 NPTF		
11.5	TM3-11.5 NPTF	TM3B-11.5 NPTF	TM5-11.5 NPTF	TM6B-11.5 NPTF
8			TM5-8 NPTF	TM6B-8 NPTF

订货示例：TM3-14NPTF BR215 10片 Ordering example：TM3-14NPTF BR215 10pcs

UNJ 美制航空航天机械螺纹铣刀片 UNJ Aviation Thread



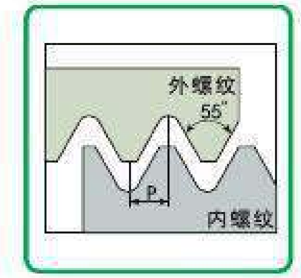


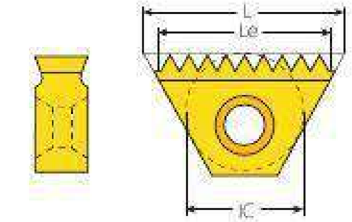
双面使用 TM标准型

加工螺距 Pitch		尺寸 Dimensions (mm)			
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		TM2E24 UNJ	TM3E24 UNJ	
	内Int	TM6.0N24 UNJ	TM2N24 UNJ	TM3N24 UNJ	
20	外Ext		TM2E20 UNJ	TM3E20 UNJ	
	内Int	TM6.0N20 UNJ	TM2N20 UNJ	TM3N20 UNJ	
18	外Ext			TM3E18 UNJ	
	内Int	TM6.0N18 UNJ	TM2N18 UNJ	TM3N18 UNJ	
16	外Ext		TM2E16 UNJ	TM3E16 UNJ	TM5E16 UNJ
	内Int	TM6.0N18 UNJ	TM2N16 UNJ	TM3N16 UNJ	TM5N16 UNJ
14	外Ext		TM2E14 UNJ	TM3E14 UNJ	
	内Int		TM2N14 UNJ	TM3N14 UNJ	
13	外Ext			TM3E13 UNJ	
	内Int			TM3N13 UNJ	
12	外Ext			TM3E12 UNJ	TM5E12 UNJ
	内Int			TM3N12 UNJ	TM5N12 UNJ
11	外Ext			TM3E11 UNJ	TM5E11 UNJ
	内Int			TM3N11 UNJ	TM5N11 UNJ

订货示例：TM3E13UNJ BR215 10片 Ordering example：TM3E13UNJ BR215 10pcs

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



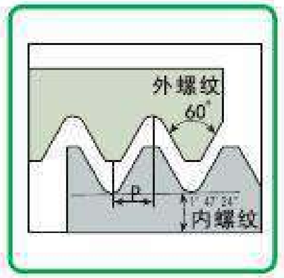


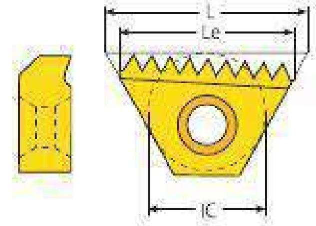
双面使用 TM标准型

加工螺距 Pitch		尺寸 Dimensions (mm)					
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	外Ext	TM6.0E28 W	TM2E28 W				
	内Int	TM6.0N28 W	TM2N28 W				
26	外Ext	TM6.0E26 W	TM2E26 W	TM3E26 W			
	内Int	TM6.0N26 W	TM2N26 W	TM3N26 W			
24	外Ext	TM6.0E24 W	TM2E24 W	TM3E24 W	TM3BE24 W		
	内Int	TM6.0N24 W	TM2N24 W	TM3N24 W	TM3BN24 W		
20	外Ext	TM6.0E20 W	TM2E20 W	TM3E20 W	TM3BE20 W		
	内Int	TM6.0N20 W	TM2N20 W	TM3N20 W	TM3BN20 W		
19	外Ext	TM6.0E19 W	TM2E19 W	TM3E19 W	TM3BE19 W		
	内Int	TM6.0N19 W	TM2N19 W	TM3N19 W	TM3BN19 W		
18	外Ext			TM3E18 W	TM3BE18 W		
	内Int			TM3N18 W	TM3BN18 W		
16	外Ext			TM3E16 W	TM3BE16 W	TM5E16 W	
	内Int			TM3N16 W	TM3BN16 W	TM5N16 W	
14	外Ext		TM2E14 W	TM3E14 W	TM3BE14 W	TM5E14 W	
	内Int		TM2N14 W	TM3N14 W	TM3BN14 W	TM5N14 W	
12	外Ext			TM3E12 W	TM3BE12 W	TM5E12 W	
	内Int			TM3N12 W	TM3BN12 W	TM5N12 W	
11	外Ext			TM3E11 W	TM3BE11 W	TM5E11 W	6BE11 W
	内Int			TM3N11 W	TM3BN11 W	TM5N11 W	6BN11 W
10	外Ext					TM5E10 W	
	内Int					TM5N10 W	
9	外Ext					TM5E9 W	
	内Int					TM5N9 W	
8	外Ext					TM5E8 W	
	内Int					TM5N8 W	
7	外Ext					TM5E7 W	
	内Int					TM5N7 W	
6	外Ext					TM5E6 W	TM6BE6 W
	内Int					TM5N6 W	TM6BN6 W
5	外Ext						TM6BE5 W
	内Int						TM6BN5 W
4.5	外Ext						TM6BE4.5 W
	内Int						TM6BN4.5 W

订货示例：TM3E11W BR15 10片 Ordering example：TM3E11W BR215 10pcs

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



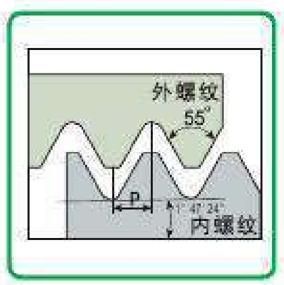


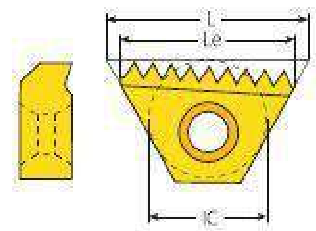
单面使用　TM标准型

加工螺距 Pitch	尺寸 Dimensions (mm)			
TPI	L=16mm D=3/8"	L=22mm D=3/8"B	L=27mm D=5/8"	L=38.5mm D=3/4"B
18	TM3E18 NPT			
14	TM3-14 NPT	TM3B-14 NPT		
11.5	TM3-11.5 NPT	TM3B-11.5 NPT	TM5-11.5 NPT	TM6B-11.5 NPT
8			TM5-8 NPT	TM6B-8 NPT

订货示例：TM3E14NPT BR215　10片　Ordering example：TM3E14NPT BR215　10pcs

BSPT 英国标准锥管螺纹铣刀片 BSPT-55°





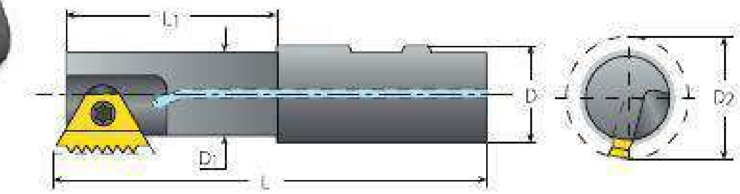
单面使用　TM标准型

加工螺距 Pitch	尺寸 Dimensions (mm)		
TPI	L=11mm D=1/4"	L=16mm D=3/8"	L=27mm D=5/8"
19	TM2-19 BSPT		
14		TM3-14 BSPT	
11		TM3-11 BSPT	TM5-11 BSPT

订货示例：TM3-14BSPT BR15　10片　Ordering example：TM3-14BSPT BR215　10pcs

螺纹铣削刀具 THREADING MILLING TOOLS

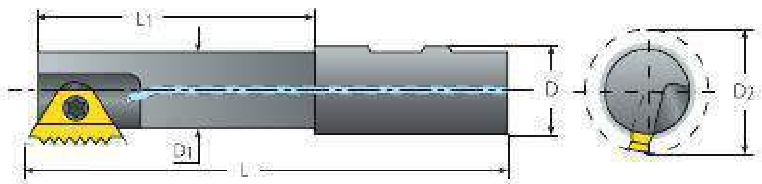
螺纹铣刀杆 Threading Milling Tool Holders



型号	尺寸Dimensions(mm)					适用刀片	刀片螺钉	扳手
Ordering Code	L	L1	D	D1	D2	Insert	Insert Screw	Torx Key
STM6,0-C12	69	12	12	6.8	9	6.0****	M2.2X5	T7
STM6.0-C20	84	17	20	6.8	9	6.0****	M2.2X5	T7
STM2-C12	70	12	12	8.9	11.5	2****	M3X7	T8
STM2-C20	85	20	20	8.9	11.5	2****	M3X7	T8
STM3-C16	90	22	16	13.6	17	3****	M3.5X8	T15
STM3-C20	95	43	20	16.6	20	3****	M3.5X8	T15
SBTM3B-C16	79.5	29	16	13.5	17	3B****	M3.5X8	T15
SBTM3B-C20	81.5	29	20	15.5	19	3B****	M3.5X8	T15
SBTM3B-C25	92.3	30	25	15.5	19	3B****	M3.5X8	T15
SBTMW3B-C25	90.8	30	25	18.5	22	3B****	M3.5X8	T15
STM5-C25	110	52	25	24	30	5****	M5X14	T20
STM5-C25LH	110	52	25	24	30	5****	M5X14	T20
STM5-C32	120	58	32	31	37	5****	M5X14	T20
STM6B-C32	115	53	32	27	35	6B****	M7X15	T25
STM6B-C40	135	63	40	38	46	6B****	M7X15	T25

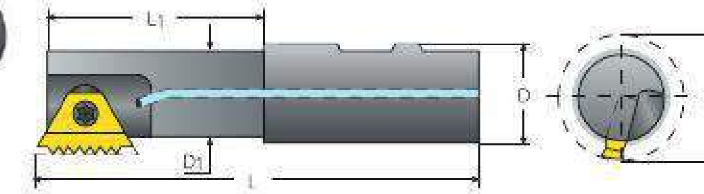
螺纹铣削刀具 THREADING MILLING TOOLS

螺纹铣刀杆 Threading Milling Tool Holders



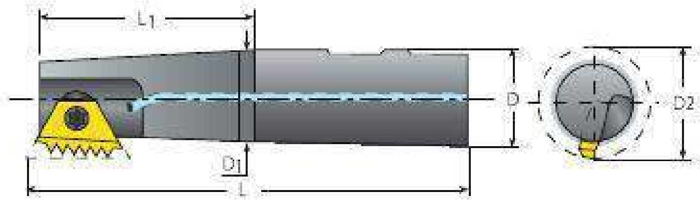
型号	尺寸Dimensions(mm)					适用刀片	刀片螺钉	扳手
Ordering Code	L	L1	D	D1	D2	Insert	Insert Screw	Torx Key
STML2-C25	125	17	25	8.9	11.5	2****	M3X7	T8
STML3-C25	125	25	25	18.6	22	3****	M3.5X8	T15
SBTML3-C25	125	63.5	25	18.6	22	3****	M3.5X8	T15
SBTML3B-C20	96.5	44	20	15.5	19	3B****	M3.5X8	T15
SBTML3B-C25	125	63.5	25	18.6	22	3B****	M3.5X15	T15
STML5-C25	150	92	25	24	30	5****	M5X14	T20
STML5-C32	160	98	32	31	37	5****	M5X14	T20
STML6B-C40	165	93	40	38	46	6B****	M7X15	T25

螺纹铣刀杆 Threading Milling Tool Holders



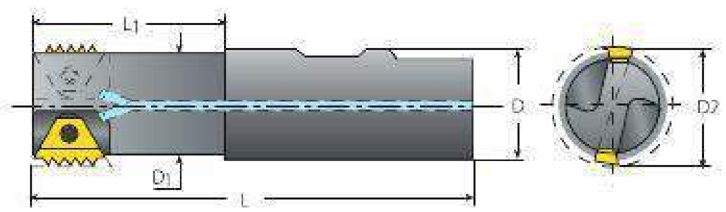
型号	尺寸Dimensions(mm)					适用刀片	刀片螺钉	扳手
Ordering Code	L	L1	D	D1	D2	Insert	Insert Screw	Torx Key
STM6.0-C20 124/003	85	15	20	6.7	9	6.0****	M2.2X5	T7
STM2-C20 124/005	77	15.5	20	7.4	10	6.0****	M2.2X5	T7
STM2-C20 124/006	77	15.5	20	9	12	2****	M3X7	T8
STM2-C20 124/009	77	15.5	20	7.4	10	2****	M3X7	T8
STM3-C16 124/001	91	20.5	16	12.2	15.5	3****	M3.5X8	T15
STM4-C25 124/002	88	30	25	13.4	18	3****	M3.5X8	T15
STM4-C25 124/007	98	40	25	16	20	3B****	M3.5X8	T15
STM5-C25 124/004	98	40	25	19	25	3B****	M3.5X8	T15
STM5-C25 124/008	98	40	25	16.4	22	3B****	M3.5X8	T15

螺纹铣刀杆 Threading Milling Tool Holders



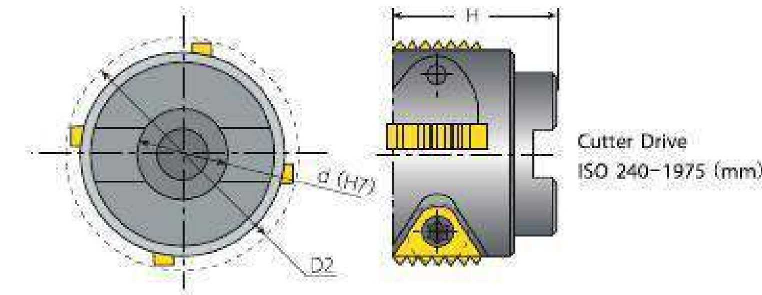
右刀杆 Right Hand	左刀杆 Left Hand	尺寸Dimensions(mm) L	L1	D	D1	D2	适用刀片 Insert	刀片螺钉 Insert Screw	扳手 Torx Key
STMN3-C16	STMN3-C16 LH	125	17	25	8.9	11.5	2****	M3X7	T8
STMN3-C20	STMN3-C20 LH	125	25	25	18.6	22	3****	M3.5X8	T15
SBTMN3N-C16	SBTMN3N-C16 LH	125	63.5	25	18.6	22	3****	M3.5X8	T15
SBTMN3B-C20	SBTMN3B-C20 LH	96.5	44	20	15.5	19	3B****	M3.5X8	T15
SBTMN5-C32	SBTMN5-C32 LH	125	63.5	25	18.6	22	3B****	M3.5X8	T15

螺纹铣刀杆 Threading Milling Tool Holders



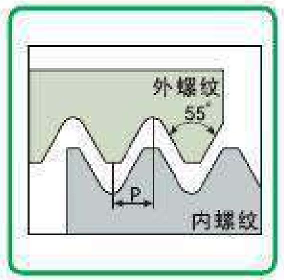
型号 Ordering Code	尺寸Dimensions(mm) L	L1	D	D1	D2	适用刀片 Insert	刀片螺钉 Insert Screw	扳手 Torx Key
2STM2-C20	85	20	20	14.4	17	6.0****	M2.2X5	T7
2STM3-C25	100	43	25	22.5	26	6.0****	M2.2X5	T7
2SBTM3B-C25	104.2	46	25	22.5	26	2****	M3X7	T8
2STM5-C32	120	45	32	36	42	2****	M3X7	T8
2STM6B-C40	137.2	65	40	44	52	3****	M3.5X8	T15

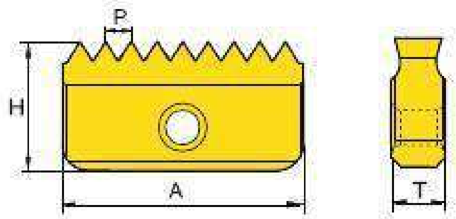
螺纹铣刀杆 Threading Milling Tool Holders



型号 Ordering Code	刀片数量 NO. of insert	尺寸Dimensions(mm) D2	d(H7)	H	适用刀片 Insert	刀片螺钉 Insert Screw	扳手 Torx Key
SHTM2-D38-16	6	38	16	40	2****	M3X7	T8
SHTM2-D50-22	8	50	22	40	2****	M3X7	T8
SHTM3-D50-22	6	50	22	40	3****	M3.5X8	T15
SHTM3B-D63-22	6	63	22	40	3B****	M3.5X8	T15
SHTM5-D63-22	4	63	22	45	5****	M5X14	T20
SHTM6B-D63-22	4	63	22	50	6B****	M7X15	T25
SHTM5-D80-27	6	80	27	50	5****	M5X14	T20
SHTM6B-D80-27	5	80	27	50	6B****	M7X15	T25
SHTM5-D100-32	7	100	32	55	5****	M5X14	T20
SHTM6B-D100-32	6	100	32	55	6B****	M7X15	T25
SHTM5-D125-40	9	125	40	63	5****	M5X14	T20
SHTM6B-D125-40	8	125	40	63	6B****	M7X15	T25

ISO标准型螺纹刀片 ISO

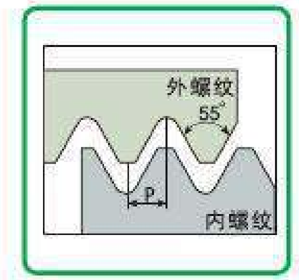



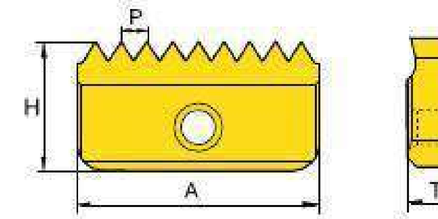


H		6.3	7.5	12	16	20
T		2.9	3.1	4.7	5.5	6.3
加工螺距 Pitch		尺寸 Dimensions (mm)=A				
mm		12	14	21	30	40
0.5	外Ext.					
0.5	内 Int.	*12 I 0.5 ISO	14 I 0.5 ISO			
0.75	外Ext.		14 E 0.75 ISO			
0.75	内 Int.	*12 I 0.75 ISO	14 I 0.75 ISO			
1.0	外Ext.		14 E 1.0 ISO	21 E 1.0 ISO		
1.0	内 Int.	*12 I 1.0 ISO	14 I 1.0 ISO	21 I 1.0 ISO		
1.25	外Ext.		14 E 1.25 ISO			
1.25	内 Int.	*12 I 1.25 ISO	14 I 1.25 ISO			
1.5	外Ext.		14 E 1.5 ISO	21 E 1.5 ISO	30 E 1.5 ISO	40 E 1.5 ISO
1.5	内 Int.	*12 I 1.5 ISO	14 I 1.5 ISO	21 I 1.5 ISO	30 I 1.5 ISO	40 I 1.5 ISO
1.75	外Ext.		14 E 1.75 ISO			
1.75	内 Int.		14 I 1.75 ISO	21 I 1.75 ISO		
2.0	外Ext.		14 E 2.0 ISO	21 E 2.0 ISO	30 E 2.0 ISO	40 E 2.0 ISO
2.0	内 Int.		14 I 2.0 ISO	21 I 2.0 ISO	30 I 2.0 ISO	40 I 2.0 ISO
2.5	外Ext.		14 E 2.5 ISO	21 E 2.5 ISO		
2.5	内 Int.		14 I 2.5 ISO	21 I 2.5 ISO		
3.0	外Ext.			21 E 3.0 ISO	30 E 3.0 ISO	40 E 3.0 ISO
3.0	内 Int.			21 I 3.0 ISO	30 I 3.0 ISO	40 I 3.0 ISO
3.5	外Ext.				30 E 3.5 ISO	
3.5	内 Int.			21 I 3.5 ISO	30 I 3.5 ISO	40 I 3.5 ISO
4.0	外Ext.				30 E 4.0 ISO	40 E 4.0 ISO
4.0	内 Int.				30 I 4.0 ISO	40 I 4.0 ISO
4.5	外Ext.					
4.5	内 Int.				30 I 4.5 ISO	40 I 4.5 ISO
5.0	外Ext.					40 E 5.0 ISO
5.0	内 Int.				30 I 5.0 ISO	40 I 5.0 ISO
5.5	外Ext.					
5.5	内 Int.					40 I 5.5 ISO
6.0	外Ext.					40 E 6.0 ISO
6.0	内 Int.					

订货示例：14E2.5 ISO BR215 10片 Ordering example：14E2.5 ISO BR215 10pcs

UN-60° 美制统一标准性螺纹刀片 UN,UNC,UNF,UNEF,UNS

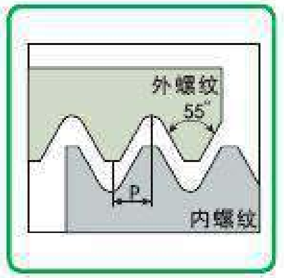



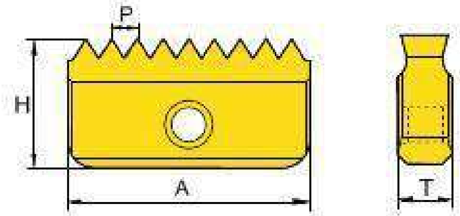


H		6.3	7.5	12	16	20
T		2.9	3.1	4.7	5.5	6.3
加工螺距 Pitch		尺寸 Dimensions (mm)=A				
tpi		12	14	21	30	40
32	外Ext.		14 E 32 UN			
32	内 Int.	*12 I 32 UN	14 I 32 UN			
28	外Ext.		14 E 28 UN			
28	内 Int.	*12 I 28 UN	14 I 28 UN			
27	外Ext.					
27	内 Int.		14 I 27 UN			
24	外Ext.		14 E 24 UN	21 E 24 UN		
24	内 Int.	*12 I 24 UN	14 I 24 UN	21 I 24 UN		
20	外Ext.		14 E 20 UN	21 E 20 UN	30 E 20 UN	
20	内 Int.	*12 I 20 UN	14 I 20 UN	21 I 20 UN	30 I 20 UN	
18	外Ext.		14 E 18 UN	21 E 18 UN	30 E 18 UN	
18	内 Int.	*12 I 18 UN	14 I 18 UN	21 I 18 UN	30 I 18 UN	
16	外Ext.		14 E 16 UN	21 E 16 UN	30 E 16 UN	40 E 16 UN
16	内 Int.	*12 I 16 UN	14 I 16 UN	21 I 16 UN	30 I 16 UN	40 I 16 UN
14	外Ext.		14 E 14 UN	21 E 14 UN	30 E 14 UN	40 E 14 UN
14	内 Int.		14 I 14 UN	21 I 14 UN	30 I 14 UN	40 I 14 UN
12	外Ext.		14 E 12 UN	21 E 12 UN	30 E 12 UN	40 E 12 UN
12	内 Int.		14 I 12 UN	21 I 12 UN	30 I 12 UN	40 I 12 UN
11	外Ext.					
11	内 Int.		14 I 11 UN			
10	外Ext.			21 E 10 UN	30 E 10 UN	40 E 10 UN
10	内 Int.		14 I 10 UN	21 I 10 UN	30 I 10 UN	40 I 10 UN
8	外Ext.				30 E 8 UN	40 E 8 UN
8	内 Int.			21 I 8 UN	30 I 8 UN	40 I 8 UN
7	外Ext.					
7	内 Int.			21 I 7 UN		
6	外Ext.				30 E 6 UN	40 E 6 UN
6	内 Int.				30 I 6 UN	40 I 6 UN
5	外Ext.					
5	内 Int.				30 I 5 UN	
4.5	外Ext.					
4.5	内 Int.					40 I 4.5UN
4	外Ext.					
4	内 Int.					40 I 4 UN

订货示例：14E10UN BR215 10片 Ordering example：14E10UN BR215 10pcs

W-55° 英国惠氏螺纹刀片 BSW,BSF,BSP

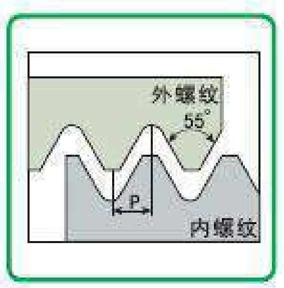



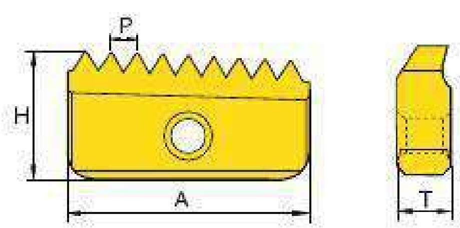


H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3
加工螺距	尺寸 Dimensions (mm)=A				
tpi	12	14	21	30	40
24		14-24 W			
20		14-20 W	21-20 W		
19	* 12-19 W	14-19 W	21-19 W		
16		14-16 W	21-16 W	30-16 W	
14		14-14 W	21-14 W	30-14 W	
11		14-11 W	21-11 W	30-11 W	40-11 W
8					40- 8 W

订货示例：14-19W BR215 10片 Ordering example：14-19W BR215 10pcs

BSPT-55° 英国标准锥管螺纹刀片 BSPT

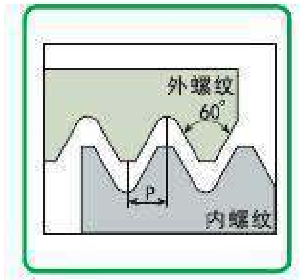



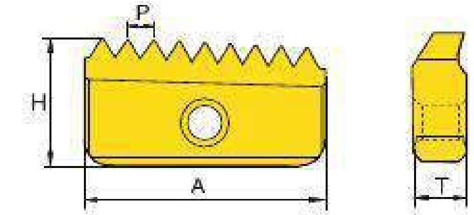


H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3
加工螺距	尺寸 Dimensions (mm)=A				
tpi	12	14	21	30	40
19	12-19 BSPT	14-19 BSPT			
14		14-14 BSPT	21-14 BSPT		
11			21-11 BSPT	30-11 BSPT	40-11 BSPT

订货示例：14-19BSPT BR215 10片 Ordering example：14-19BSPT BR215 10pcs

NPT-60° 美国标准锥管螺纹刀片 NPT

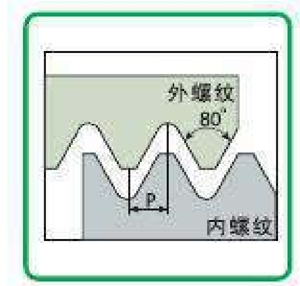



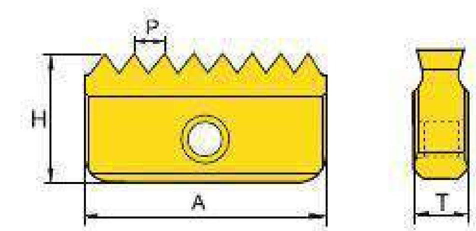


H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3
加工螺距	尺寸 Dimensions (mm)=A				
tpi	12	14	21	30	40
18	12-18 NPT	14-18 NPT			
14		14-14 NPT	21-14 NPT		
11.5			21-11.5 NPT	30-11.5 NPT	40-11.5 NPT
8				30- 8 NPT	40- 8 NPT

订货示例：14-19BSPT BR215 10片 Ordering example：14-19BSPT BR215 10pcs

PG螺纹刀片 PG-DIN 40430

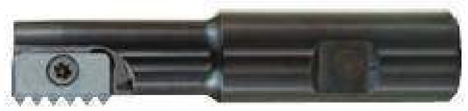



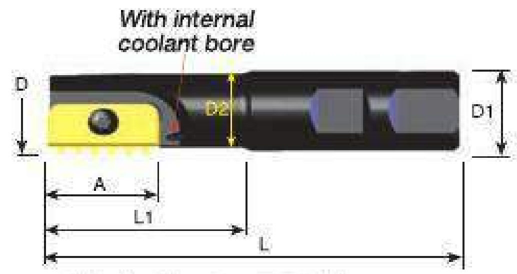


H	7.5	12	16
T	3.1	4.7	5.5
加工螺距	尺寸 Dimensions (mm)=A		
tpi	14	21	30
18	**14-18 PG** (PG 9, 11, 13.5, 16)	**21-18 PG** (PG 16)	
16		**21-16 PG** (PG 21, 29, 36, 42, 48)	**30-16 PG** (PG 36, 42, 48)

订货示例：14-18PG BR215 10片 Ordering example：14-18PG BR215 10pcs

单刃螺纹铣刀杆 single insert toolholders

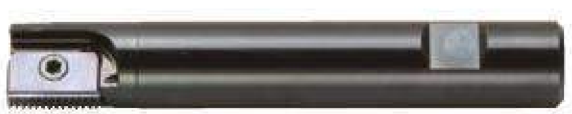


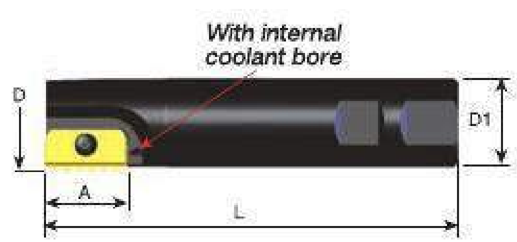


＊带内冷孔的刀杆，需要订制

型号 Ordering Code	尺寸 Dimensions (mm)						刀片 Insert	螺钉 Insert Screw	扳手 Torx Key
	A	D	D1	D2	L	L1			
SR0009H12	12	9.5	20	7.5	85	14	12****	M2.5X7	T8
* SR0010H12	12	9.9	20	7.6	85	16	12****	M2.5X7	T8
SR0012F14	14	12.0	20	8.9	75	20	14****	M3X8	T8
SR0014H14	14	14.5	20	11.2	85	25	14****	M3X8	T8
SR0017H14	14	17.0	20	13.4	85	30	14****	M3X8	T8
** SR0018H21	21	18.0	20	14.4	85	30	21****	M3.5X8	T15
SR0021H21	21	21.0	20	16.5	94	40	21****	M3.5X8	T15
SR0029J30	30	29.0	25	22.4	110	50	30****	M4X10	T15
SR0048M40	40	48.0	40	35.0	153	78	40****	M5X14	T20

单刃螺纹铣刀杆（加长型） single insert toolholders (long shank)

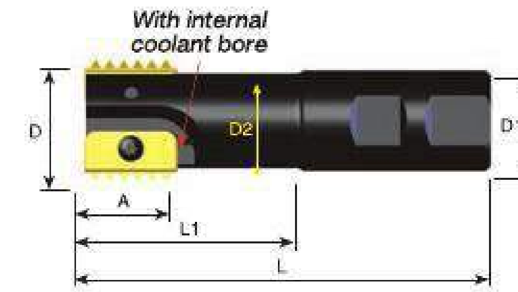




＊带内冷孔的刀杆，需要订制

型号 Ordering Code	尺寸 Dimensions (mm)				刀片 Insert	螺钉 Insert Screw	扳手 Torx Key
	A	D	D1	L			
SR0025K21	21	25	20	125	21****	M3.5X8	T15
SR0031M30	30	31	25	150	30****	M4X10	T15
SR0038M30	30	38	32	150	30****	M4X10	T15
SR0048R40	40	48	40	210	40****	M5X14	T20

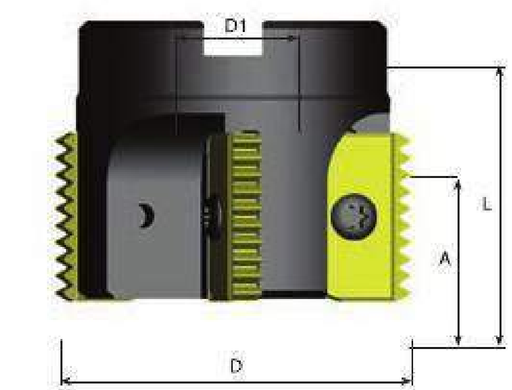
双刃螺纹铣刀杆 Twin Insert Toolholders



＊带内冷孔的刀杆，需要订制

型号 Ordering Code	尺寸 Dimensions (mm)						刀片 Insert	刃数 No. of Insert	螺钉 Insert Screw	扳手 Torx Key
	A	D	D1	D2	L	L1				
SR0020H14-2	14	20	20	16	93	41	14****	2	M3X7	T8
SR0030J21-2	21	30	25	24	108	52	21****	2	M3.5X8	T15
SR0040L30-2	30	40	32	30	130	70	30****	2	M4X10	T15
SR0050M40-2	40	50	40	38	153	78	40****	2	M5X14	T20

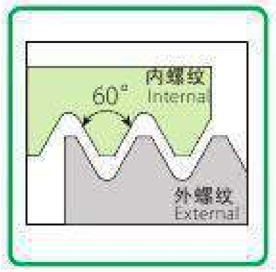
螺纹铣刀盘（多刃） multi Insert Toolholders



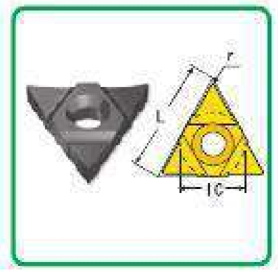
＊带内冷孔的刀杆，需要订制

型号 Ordering Code	尺寸 Dimensions (mm)				刀片 Insert	刃数 No. of Insert	螺钉 Insert Screw	扳手 Torx Key
	A	D	D1	L				
SR0063C21-5	21	63	22	50	21****	5	M3.5X7	T15
SR0063C30-4	30	63	22	50	30****	4	M4X10	T15
SR0080D30-4	30	80	27	55	30****	4	M4X10	T15
SR0100D30-4	30	100	32	60	30****	4	M4X10	T15
SR0080D40-4	40	80	27	65	40****	4	M5X14	T20
SR0100E40-4	40	100	32	70	40****	4	M5X14	T20

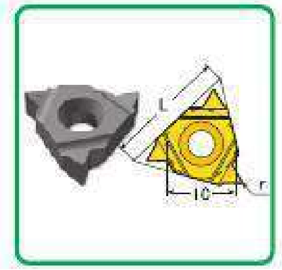
60° 深孔加工螺纹铣刀片 Thread Mill for Deep Holes



2UIDD60

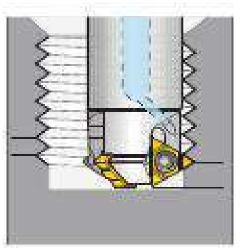


3UIDD60
4UIDD60

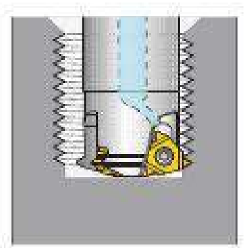


2AIDD60
3AIDD60

型号 Ordering Code	材质 Material Code DK110	DM315	DM215	加工螺距范围 mm	tpi	尺寸 Dimensions (mm) IC	L	r	刀杆 toolholder
2UIDA60 TM***	○	○	○	0.5-1.5	48-16			0.05	TM.SC***2U
2UIDB60 TM***	○	○	○	1.5-2.0	16-12	1/4"	11	0.06	CTM.SC***2U
2UIDD60 TM***	○	○	○	2.0-2.5	9-12			0.11	CTM2SC 14C17-65-2U
2UIDM60 TM***	○	○	○	2.5	10			0.11	
2UIDC60 TM***	○	○	●	2.5-4.0	10-6			0.14	TM.SC***2U CTM.SC***2U
3UIDB60 TM***	○	○	○	1.5-2.0	16-12			0.06	
3UIDE60 TM***	○	○	○	2.5-3.5	10-7	3/8"	16	0.14	TM.SC***3U
3UIDH60 TM***	○	○	○	4.0-6.0	6-4			0.25	
4UIDK60 TM***	○	○	○	6.0-8.0	4-3	1/2"	22	0.30	TM.SC D***4U
2AIDP60 TM***	○	○	●	1.5-3.0	16-8	1/4"	11	0.06	TM.SC***2A
3AIDT60 TM***	○	○	○	2.0-4.0	12-6	3/8"	16	0.08	TM.SC***3A

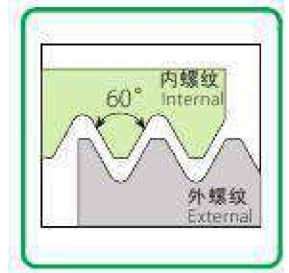


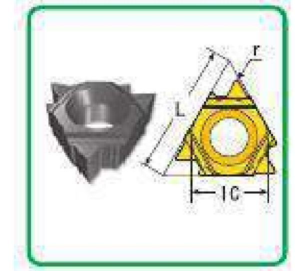
U型适用于大螺距
for large pitches



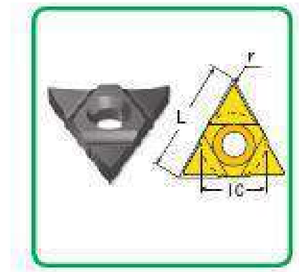
A型适用于小螺距以及退刀槽较短的情况
for short pitches

55° 深孔加工螺纹铣刀片 Thread Mill for Deep Holes





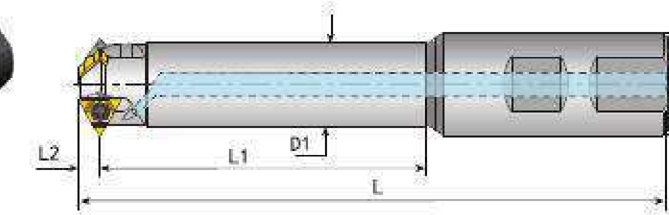
2UIDD60

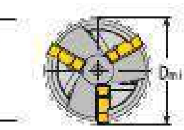


3UIDD60
4UIDD60

型号 Ordering Code	材质 Material Code DK110	DM315	DM215	加工螺距范围 mm	tpi	尺寸 Dimensions (mm) IC	L	r	刀杆 toolholder
2UIDA55 TM***	○	○	○	0.5-1.5	48-16			0.11	TM.SC***2U CTM.SC***2U
2UIDB55 TM***	○	○	○	1.5-2.0	16-12	1/4"	11	0.08	
2UIDL55 TM***	○	○	●	2.5-3.5	11-7			0.24	
3UIDB55 TM***	○	○	○	1.5-2.0	16-12			0.08	
3UIDL55 TM***	○	○	○	2.5-3.5	11-7	3/8"	16	0.24	TM.SC***3U
3UIDH55 TM***	○	○	○	4.0-6.0	6-4			0.27	
4UIDK55 TM***	○	○	○	6.0-8.5	4-3	1/2"	22	0.50	TM.SC***4U

深孔加工螺纹铣刀具(U型) Thread Milling holder for Deep Holes

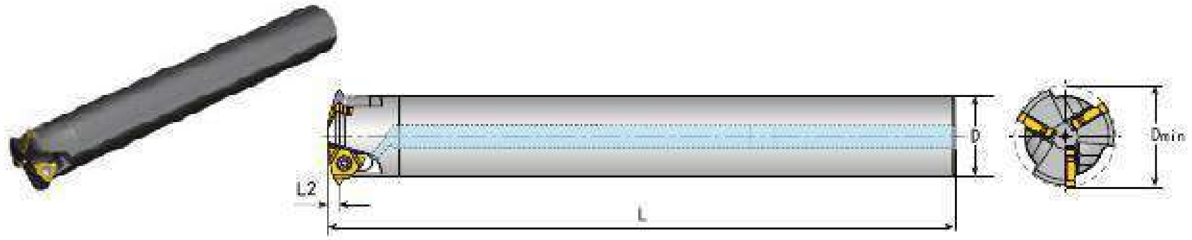




型号 Ordering Code	尺寸 Dimensions (mm) L	L1	L2	D	D1	D_{min}	刃数 NO. of insert	适用刀片 Insert	刀片螺钉 Insert Screw	扳手 Torx Key
TM1SC 16W15-40-2U	95	40		16	11	14.75*	1			
TM2SC 25W21-60-2U	123	60		25	16	20.65*	2			
TM2SC 25W23-70-2U	135	70	5.4	25	17.7	23	2	2UID***	L60M2.5X6	T8
TM3SC 25W26-80-2U	147	80		25	20.4	26	3			
TM4SC 32W31-95-2U	164	95		32	25.7	31	4			
TM3SC 32W36-95-3U	166	95	8.0	32	29	36.5	3	3UID***	L60M3.5X10	T15
TM4SC 40W42-120-3U	201	120		40	34.2	42	4			

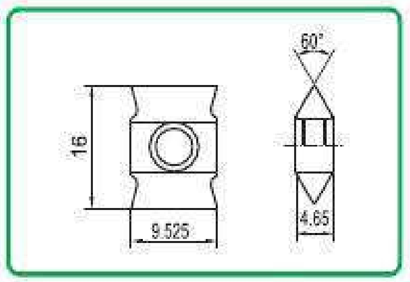
螺纹铣削刀具 THREADING MILLING TOOLS

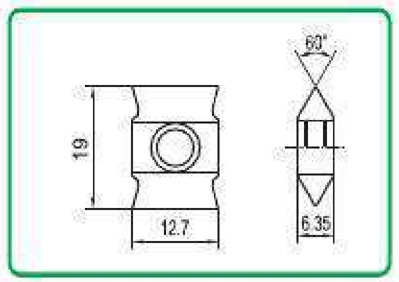
深孔加工螺纹铣刀具(A型) Thread Milling holder for Deep Holes



型号	尺寸 Dimensions(mm)				刃数	适用刀片	刀片螺钉	扳手
Ordering Code	L	L2	D	Dmin	NO. of insert	Insert	Insert Screw	Torx Key
TM3SC 20C26-105-2A	105	3.0	20	26	3	2UID***	L60M2.5X6	T8
TM3SC 28C35-144-3A	144	4.0	28	35	3	3UID***	L60M3.5X8	T15

旋风铣螺纹刀片 Partial Profile Thread Milling Inserts



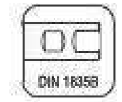


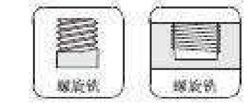
名称	刀片型号	材质		
		Material Code		
Name	Designation	DK110	DP220	DM215
60° 通用螺纹刀片 Partial Profile 60°	SV1906		○	●
60° 通用螺纹刀片 Partial Profile 60°	SV1604		○	●

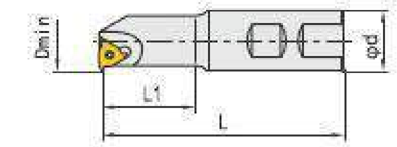
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例: SV1604 DM215 10片 Ordering example: SV1604 DM215 10pcs

单刃螺纹铣刀 Indexable Threading Mills







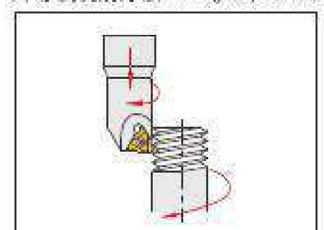
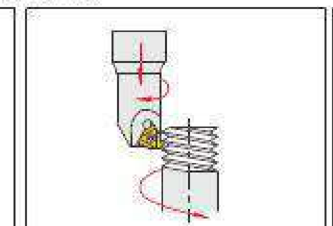
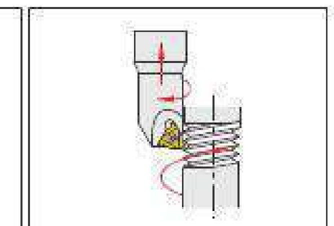
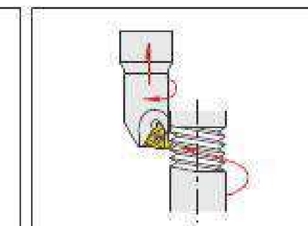
型号 Model No.	尺寸Dimension(mm)				刀片 Insert	螺钉 Screw	扳手 Torx-key
	Dmin	φd	L1	L			
SMT12-12F11	12	12	25	80	11NR***	L60M2.5X6	T-08
SMT18-20K16	18	20	35	125	16NR***	L60M3.5X8	T-15
SMT25-25M16	25	25	65	150	16NR***	L60M3.5X8	T-15
SMT35-32S22	35	32	110	250	22NR***	L60M4.5X12	T-20

● 订货示例：1 件 SMT18-20K16
Ordering example : 1pc SMT18-20K16

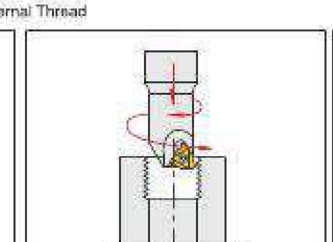
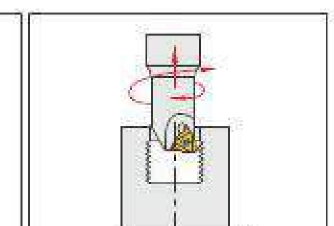
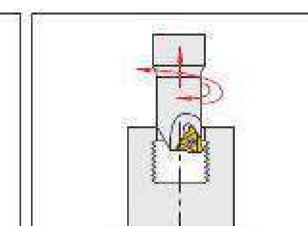
刀片使用：加工外螺纹：16NR ****
加工内螺纹：16NR ****

Insert information: External threading inserts : 16NR ****
Internal threading inserts : 16NR ****

外螺纹铣削方法 Milling Ways for External Thread

			
右旋螺纹 -R Right Hand-R	左旋螺纹 -L Left Hand-L	右旋螺纹 -R Right Hand-R	左旋螺纹 -L Left Hand-L
顺时针进给，顺铣 CW.Feed and Milling	逆时针进给，逆铣 CCW.Feed and Milling	顺时针进给，逆铣 CW.Feed and CCW Milling	逆时针进给，顺铣 CW.Feed and CW Milling
刀片Insert:16NR****	刀片Insert:16NR****	刀片Insert:16NR****	刀片Insert:16NR****

内螺纹铣削方法 Milling Ways Internal Thread

			
右旋螺纹 -R Right Hand-R	左旋螺纹 -L Left Hand-L	右旋螺纹 -R Right Hand-R	左旋螺纹 -L Right Hand-R
顺时针进给，顺铣 CW.Feed and Milling	逆时针进给，逆铣 CCW.Feed and Milling	顺时针进给，逆铣 CW.Feed and CCW Milling	逆时针进给，顺铣 CW.Feed and CCW Milling
刀片 Insert :16NR ****	刀片 Insert :16NR ****	刀片 Insert :16NR ****	刀片 Insert :16NR ****

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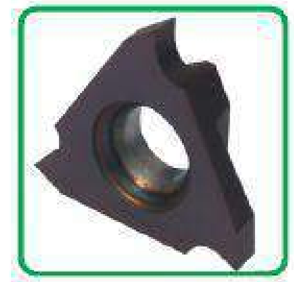
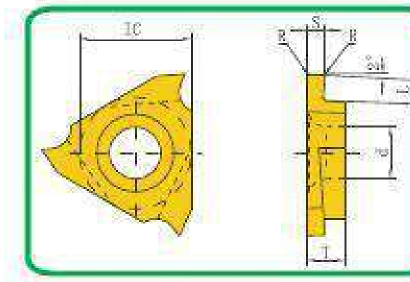
TGF32切槽刀片 TGF32 Grooving Insert



图片为右手刀片
Right Insert(see picture)



说明:带"*"尺寸可以根据用户需求定制
* The dimension can be customized

型号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125		型号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125		尺寸 Dimensions (mm) IC±0.02	T±0.02	d	*S±0.02	*L	*R
TGF32R033				TGF32L033							0.33	0.85	
TGF32R040	○	●		TGF32L040		○					0.40	1.25	0.05
TGF32R050	○	●		TGF32L050		●					0.50		
TGF32R060	○	●		TGF32L060		●					0.60		
TGF32R065	○	●		TGF32L065		●					0.55		
TGF32R070	○	●		TGF32L070		○					0.70	2.05	
TGF32R075	○	●		TGF32L075		○					0.75		
TGF32R080	○	●		TGF32L080		●					0.80		
TGF32R085	○	●		TGF32L085		○					0.85		
TGF32R090	○	●		TGF32L090		●					0.90		0.1
TGF32R095	○	●		TGF32L095		○					0.95		
TGF32R100	○	●		TGF32L100		○					1.00		
TGF32R110	○	●		TGF32L110		○					1.10	2.2	
TGF32R115	○	○		TGF32L115		○					1.15		
TGF32R120	○	○		TGF32L120		○					1.20		
TGF32R125	○	●		TGF32L125		○					1.25		
TGF32R130	○	●		TGF32L130		○		9.525	3.18	4.5	1.30		
TGF32R135	○	●		TGF32L135		○					1.35		
TGF32R140	○	●		TGF32L140		○					1.40		
TGF32R145	○	●		TGF32L145		○					1.45	2.4	
TGF32R150	○	●		TGF32L150		○					1.50		
TGF32R155	○	●		TGF32L155		○					1.55		
TGF32R160	○	●		TGF32L160		○					1.60		
TGF32R165	○	●		TGF32L165		○					1.65		
TGF32R170	○	●		TGF32L170		○					1.70		
TGF32R175	○	●		TGF32L175		○					1.75	2.7	0.15
TGF32R180	○	●		TGF32L180		○					1.80		
TGF32R185	○	●		TGF32L185		○					1.85		
TGF32R190	○	●		TGF32L190		○					1.90		
TGF32R200	○	●		TGF32L200		○					2.00		
TGF32R210	○	●		TGF32L210		○					2.10		
TGF32R215	○	●		TGF32L215		○					2.15	3.0	
TGF32R220	○	●		TGF32L220		○					2.20		
TGF32R225	○	●		TGF32L225		○					2.25		

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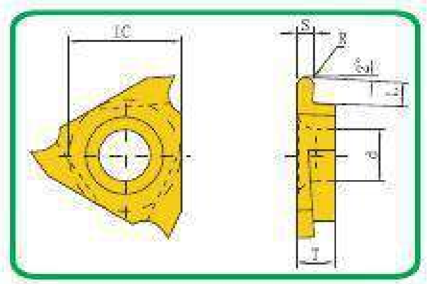
型 号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125		型 号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125		尺寸 Dimensions (mm) IC±0.02	T±0.02	d	*S±0.02	*L	*R
TGF32R230	○	●		TGF32L230		●					2.30		
TGF32R240	○	●		TGF32L240		○					2.40		
TGF32R250	○	●		TGF32L250		●					2.50		
TGF32R260	○	●		TGF32L260		●					2.60		
TGF32R265	○	●		TGF32L265		●		9.525	3.18	4.5	2.65	3.4	0.2
TGF32R270	○	●		TGF32L270		●					2.70		
TGF32R275	○	●		TGF32L275		●					2.75		
TGF32R280	○	●		TGF32L280		●					2.80		
TGF32R300	○	●		TGF32L300		●					3.00		
TGF32R320	○	●		TGF32L320		●					3.20		

订货示例：TGF32R200-R1.0 PM12510件　　Ordering example: TGF32R200-R1.0 PM12510pc

TGF32切槽刀片(球头型)　TGF32 Grooving Insert

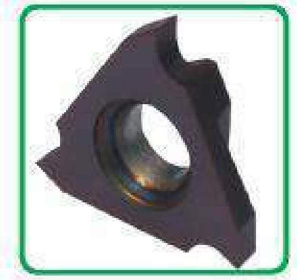
图片为右手刀片
Right Insert(see picture)



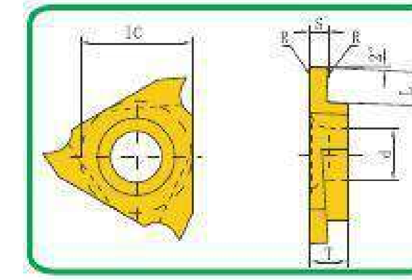
型 号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125		型 号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125		尺寸 Dimensions (mm) IC±0.02	T±0.02	d	S±0.02	L	R
TGF32R100-R0.5				TGF32L100-R0.5							1.0	2.2	0.50
TGF32R150-R0.75	○	●		TGF32L150-R0.75		○					1.5	2.2	0.75
TGF32R200-R1.0	○	●		TGF32L200-R1.0		●		9.525	3.18	4.5	2.0	2.7	1.00
TGF32R250-R1.25	○	●		TGF32L250-R1.25		●					2.5	3.0	1.25
TGF32R300-R1.5	○	●		TGF32L300-R1.5		●					3.0	3.2	1.50

订货示例：TGF32R200-R1.0 PM12510件　　Ordering example: TGF32R200-R1.0 PM12510pc

TGF32切槽刀片(大切深)　TGF32 Grooving Insert



图片为右手刀片
Right Insert(see picture)

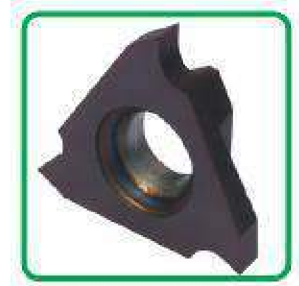


型 号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125		型 号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125		尺寸 Dimensions (mm) IC±0.02	T±0.02	d	S±0.02	*L	R
TGF32R050L220				TGF32L050L220							0.50	2.20	0.05
TGF32R100L330	○	●		TGF32L100L330		○					1.00	3.30	
TGF32R150L380	○	●		TGF32L150L380		●		9.525	3.18	4.5	1.50	3.80	0.1
TGF32R200L400	○	●		TGF32L200L400		●					2.00	4.00	
TGF32R250L400	○	●		TGF32L250L400		●					2.50	4.00	

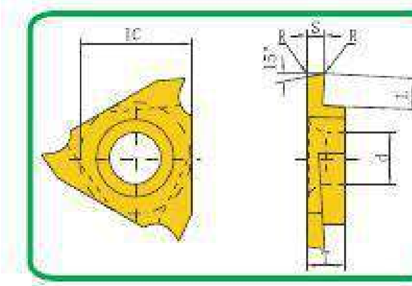
订货示例：TGF32R200L400 PM125 10件　　Ordering example: TGF32R200L400 PM125 10pc

说明：该刀片实际最大切削深度“L”与被加工直径相关，当直径比较大时，实际切削深度都会小于“L”值。

TGF32切断刀片(斜刃型)　TGF32 Parting-off Insert



图片为右手刀片
Right Insert(see picture)

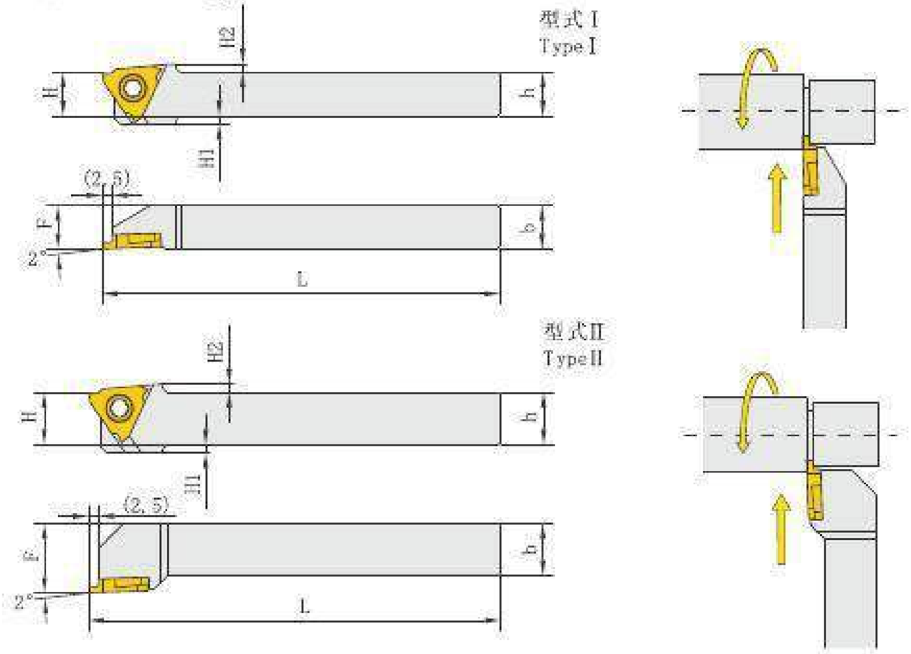


导程角“15°”显示为刀片安装在刀杆上面后的角度
Note: Relative to the toolholder, 15° is the insert's angle after installation.

型 号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125		型 号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125		尺寸 Dimensions (mm) IC±0.02	T±0.02	d	S±0.02	*L	R
TGF32R075A15		●		TGF32L075A15		●					0.75	2.30	0.05
TGF32R100A15		●		TGF32L100A15		●					1.00	3.10	
TGF32R125A15		●		TGF32L125A15		●		9.525	3.18	4.5	1.25	3.60	0.1
TGF32R150A15		●		TGF32L150A15		●					1.50	3.80	
TGF32R200A15		●		TGF32L200A15		●					2.00	4.00	
TGF32R250A15		●		TGF32L250A15		●					2.50	4.00	

订货示例：TGF32R200A12 PM125 10件　　Ordering example: TGF32R200A12 PM125 10pc

TKGFR/L刀杆 Grooving Tools



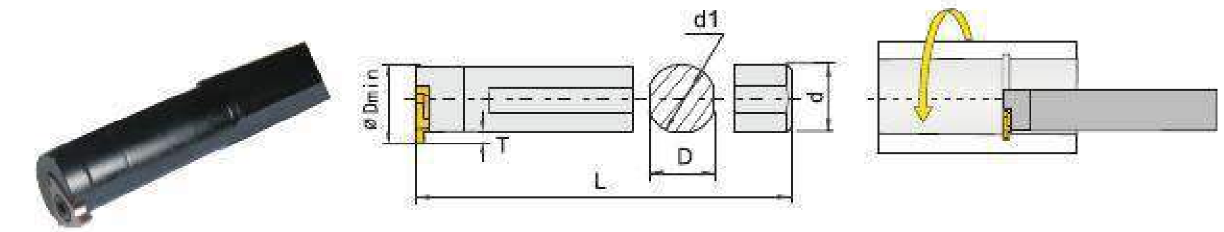
图示为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:Right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)							型式 Type	适用刀片Insert		刀片螺钉	扳手
右刀Right Hand	左刀Left Hand	h	b	H	F	L	H2	H1		左Left	右Right	Insert Screw	Torx Key
TKGFR1010K-16F	TKGFL1010K-16F	10	10	10	10	125	2.5	2	I	TGF32L.	TGF32R.	L60M4x8	T-15
TKGFR1212K-16F	TKGFL1212K-16F	12	12	12	12	125	2.5	-					
TKGFR1212M-16F	TKGFL1212M-16F	12	12	12	12	150	2.5	-					
TKGFR1616M-16F	TKGFL1616M-16F	16	16	16	16	150	2.5	-					
TKGFR1212H-16	TKGFL1212H-16	12	12	12	12	100	2.5	2	II	TGF32L.	TGF32R.	L60M4x8	T-15
TKGFR1616H-16	TKGFL1616H-16	16	16	16	20	100	2.5	-					
TKGFR2020K-16	TKGFL2020K-16	20	20	20	25	125	2.5	-					
TKGFR2525M-16	TKGFL2525M-16	25	25	25	32	150	2.5	-					

订货示例：TKGFR1212M-16F 1件　　Ordering example:TKGFR1212M-16F 1pc

TGF、DBA型内切槽刀杆 TGF Type Excellent Bar



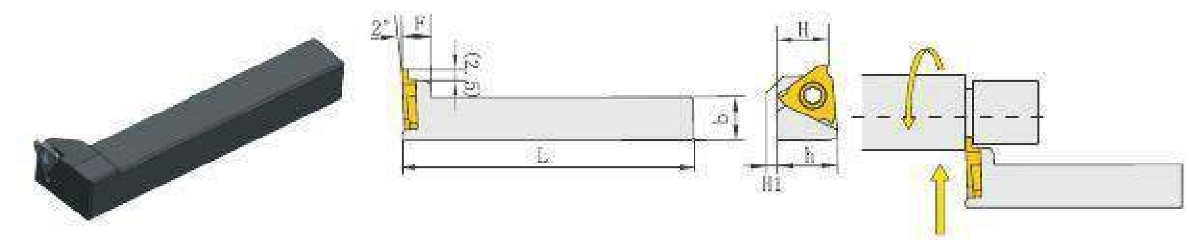
图示为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配TGF32L系列刀片
Note:Right tools match with left inserts

右刀杆	尺寸Dimensions(mm)						适用刀片	刀片螺钉	扳手
Right Hand	d1	d	L	D	T	øDmin	Insert	Insert Screw	Torx Key
S16K-SRTGF3219	16	16	125	15	切槽深度参考刀片切深	19	TGF32L***	L60M4X8	T-15
S20M-SRTGF3223	20	20	150	19		23		L60M4X8	T-15
S25Q-SRTGF3227	25	25	180	23		27		L60M4X8	T-15
S25R-SRDBA4329	25	25	200	23		29	DBA43L***	L60M5X11	T-20
S32S-SRDBA4335	32	32	250	30		35		L60M5X11	T-20

订货示例：S20M-SRTGF3219 1件　　Ordering example: S20M-SRTGF3219 1pc

TGF32切槽刀杆(排刀型) Grooving Tools



图示为左手刀具
Right Cutting Tools(see picture)

注意：左手刀具(R)配TGF32R系列刀片
Note:Left tools match with right inserts

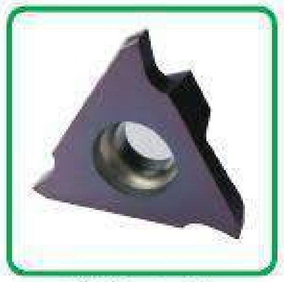
型号Ordering Code	尺寸Dimensions(mm)							适用刀片Insert	刀片螺钉	扳手
左刀Left Hand	h	b	H	F	L	H2	H1	右Right Hand	Insert Screw	Torx Key
TKGFL1010F-16-A90	10	10	10	12	85	2.5	2	TGF32R****	L60M4x8	T-15
TKGFL1212H-16-A90	12	12	12	16	100	2.5	-			
TKGFL1616H-16-A90	16	16	16	20	100	2.5	-			
TKGFL2020K-16-A90	20	20	20	25	125	2.5	-			
TKGFL2525M-16-A90	25	25	25	32	150	2.5	-			

订货示例：TKGFR1212M-16F 1件　　Ordering example: TKGFR1212M-16F 1pc

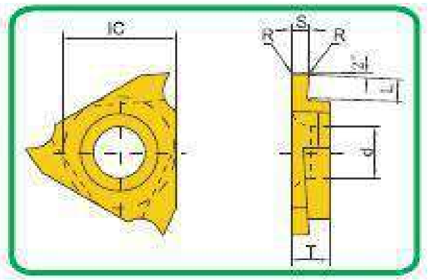
切槽(断)刀具 GROOVING TOOLS

切槽(断)刀具 GROOVING TOOLS

DBA43切槽刀片 DBA43 Grooving Insert



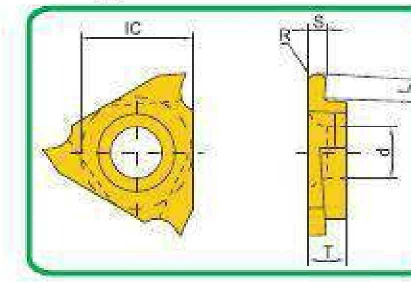
图片为右手刀片
Right Insert(see picture)



型号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125		型号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125		尺寸 Dimensions (mm) IC±0.02	T±0.02	d	*S±0.02	*L	*R
DBA43R075				DBA43L075							1.00		
DBA43R100	●	●		DBA43L100							1.00		
DBA43R120		○		DBA43L120							1.25		
DBA43R125		○		DBA43L125							1.25		
DBA43R140				DBA43L140							1.40	2.5	
DBA43R145				DBA43L145							1.45		
DBA43R150	●	●		DBA43L150							1.50		0.1
DBA43R160				DBA43L160							1.60		
DBA43R170	○	○		DBA43L170							1.70		
DBA43R175	○	○		DBA43L175							1.75		
DBA43R180	○	○		DBA43L180							1.80		
DBA43R185		○		DBA43L185							1.85	3.5	
DBA43R195				DBA43L195							1.95		
DBA43R200	●	●		DBA43L200		●					2.00		
DBA43R210	○	●		DBA43L210							2.10		
DBA43R220	○	○		DBA43L220		○					2.20		
DBA43R225	○	○		DBA43L225		●					2.25		
DBA43R230	○	●		DBA43L230		●					2.30		
DBA43R240	○	○		DBA43L240		●					2.40		
DBA43R250	●			DBA43L250				12.7	4.76	5.4	2.50		
DBA43R265	○	●		DBA43L265		●					2.65	4.6	0.2
DBA43R270				DBA43L270							2.70		
DBA43R280	○	●		DBA43L280		●					2.80		
DBA43R300	●	○		DBA43L300		○					3.00		
DBA43R320	○	○		DBA43L320		○					3.20		
DBA43R325	○	○		DBA43L325		○					3.25		
DBA43R330	○	●		DBA43L330		○					3.30		
DBA43R350	○	●		DBA43L350		●					3.50		
DBA43R360	○	●		DBA43L360		○					3.60		
DBA43R380				DBA43L380							3.80		
DBA43R400	○	○		DBA43L400		●					4.00		
DBA43R420	○	●		DBA43L420		○					4.20		
DBA43R450	○	○		DBA43L450		○					4.50		
DBA43R460	○	●		DBA43L460		○					4.60	5.0	0.3
DBA43R470	○	○		DBA43L470		○					4.70		
DBA43R480	○	●		DBA43L480		○			4.90		4.80		

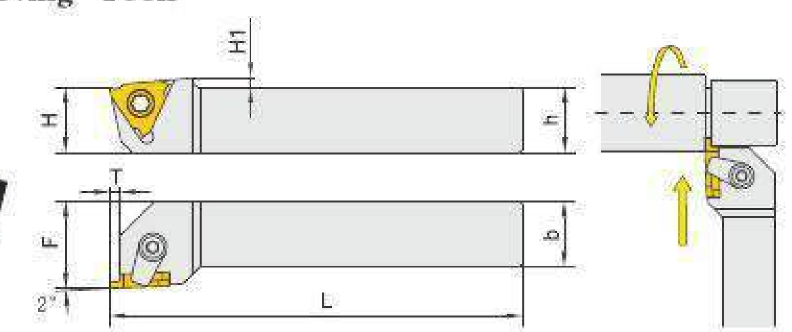
DBA43切槽刀片(球头型) DBA43 Grooving Insert

图片为右手刀片
Right Insert(see picture)



型号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125		型号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125		尺寸 Dimensions (mm) IC±0.02	T±0.02	d	*S±0.02	*L	*R
DBA43R200-R1. 0	○	●		DBA43L200-R1. 0	○	○					2.00	3.5	1.0
DBA43R250-R1. 25	○	○		DBA43L250-R1. 25	○	○		12.7	4.76	5.4	2.50	4.6	1.25
DBA43R300-R1. 5	○	●		DBA43L300-R1. 5	○	○					3.00	4.6	1.5
DBA43R400-R2. 0	○	●		DBA43L400-R2. 0	○	○					4.00	5.0	2.0

DBA43切槽刀杆 Grooving Tools



图示为右手刀具
Right Cutting Tools(see picture)

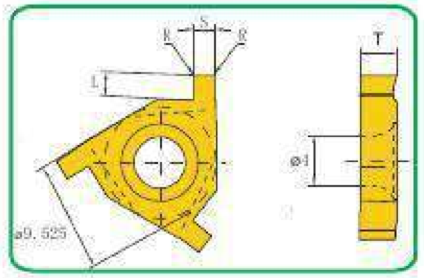
注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:Right tools match with right inserts;left tools match with left inserts.

型号Ordering Code 左刀Left Hand	右刀Right Hand	尺寸Dimensions(mm) h	b	H	F	L	H1	T	适用刀片Insert 左Left	右Right	刀片螺钉 Insert Screw	扳手 Torx Key	压板 Clamp	双头螺栓 Clamp Screw	扳手 Hex wrench
TKGBAL2020K22-35	TKGBAR2020K22-35	20	20	20	25	125									
TKGBAL2525M22-35	TKGBAR2525K22-35	25	25	20	32	150		4.2	DBA43L075~320	DBA43R075 ~320					
TKGBAL2020K22-52	TKGBAR2020K22-52	20	20	20	25	125	4				L60M5x11	T-20	HI1814	MI0625	S2.5
TKGBAL2525M22-52	TKGBAR2525M22-52	25	25	25	32	150		5.2	DBA43L300~480	DBA43L300 ~480					
TKGBAL3232P22-52	TKGBAR3232P22-52	32	32	23	40	170									

订货示例：TKGBAR2020K22-35 1件　　Ordering example: TKGBAR2020K22-35 1pc

T11/T16平装切槽刀片

图片为内切槽刀片
Internal Grooving Insert(see picture)



当"S"值较小时，刀杆上的垫片有可能发生干涉，用户需根据实际情况把发生干涉的部位磨掉。

型号 Ordering Code 内切槽刀片 Internal grooving insert	材质 Material code			型号 Ordering Code 外切槽刀片 External grooving insert	材质 Material code			尺寸 Dimensions (mm)			
	DK110	PM125			DK110	PM125		T	S±0.02	L	R
T11N040		○		T11E040					0.40	1.00	
T11N050		○		T11E050					0.50	1.00	
T11N060		○		T11E060					0.60	1.00	
T11N070		○		T11E070					0.70	1.20	0.06
T11N080		○		T11E080					0.80	1.20	
T11N090		○		T11E090					0.90	1.20	
T11N100	○	●		T11E100	○	●		3.18	1.00	1.50	
T11N110				T11E110					1.10	1.50	
T11N120	○	○		T11E120	○	○			1.20	1.50	
T11N130	○	●		T11E130					1.30	1.50	
T11N140	○	●		T11E140	○	●			1.40	1.50	
T11N150	○	○		T11E150	○	●			1.50	1.50	0.10
T11N160	○	○		T11E160					1.60	1.40	
T11N170	○	○		T11E170					1.70	1.40	
T11N180				T11E180					1.80	1.30	
T11N200	○	●		T11E200	○	●			2.00	1.20	
T16N033				T16E033					0.33		
T16N040				T16E040					0.40		
T16N050				T16E050					0.50		
T16N060				T16E060					0.60	1.6	0.06
T16N070				T16E070					0.70		
T16N075				T16E075					0.75		
T16N080	○	●		T16E080	○	●			0.80		
T16N095	○	○		T16E095	○	○			0.95		
T16N100	○	●		T16E100	○	●			1.00		
T16N110	○	○		T16E110	○	○			1.10		
T16N115	○	○		T16E115	○	○			1.15		
T16N120	○	●		T16E120	○	●			1.20		
T16N125	○	○		T16E125	○	○			1.25		
T16N130	○	●		T16E130					1.30		
T16N140	○	●		T16E140	○	●		3.65	1.40	1.8	0.1
T16N145	○	○		T16E145	○	○			1.45		
T16N150	○	●		T16E150	○	●			1.50		
T16N160	○	●		T16E160	○	●			1.60		
T16N175	○	○		T16E175	○	○			1.75		
T16N180	○	●		T16E180	○	●			1.80		
T16N200	○	●		T16E200	○	●			2.00		

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型号 Ordering Code 内切槽刀片 Internal grooving insert	材质 Material code		型号 Ordering Code 外切槽刀片 External grooving insert	材质 Material code			尺寸 Dimensions (mm)			
	DK110	PM125		DK110	PM125		T	S±0.02	L	R
T16N215	○	●	T16E215	○	●			2.15		
T16N225	○	○	T16E225	○	○			2.25	2.0	
T16N230	○	●	T16E230	○	●			2.30		0.2
T16N250	○	●	T16E250	○	●			2.50		
T16N265	○	●	T16E265	○	●			2.65	2.2	
T16N300	○	●	T16E300	○	●			3.00	2.0	

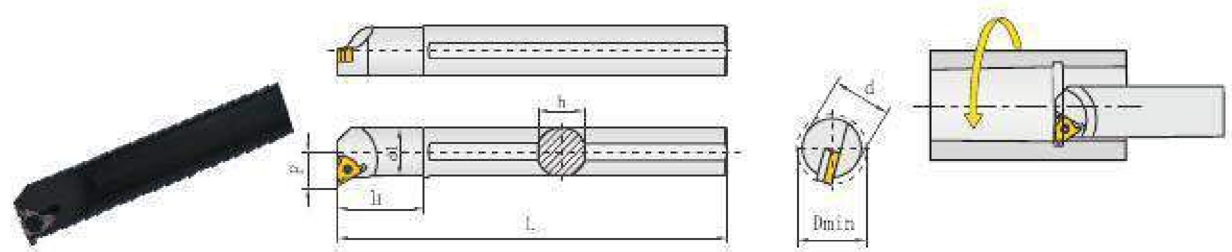
●:常备库存(主推)　Stock standard(main)　○:一般库存　Stock standard

订货示例：T16N200 PM125 10片　Ordering example: T16N200 PM125 10pcs

切槽(断)刀具 GROOVING TOOLS

T11/T16切槽刀具 T11/T16 Grooving Tools

内孔槽刀具 Internal



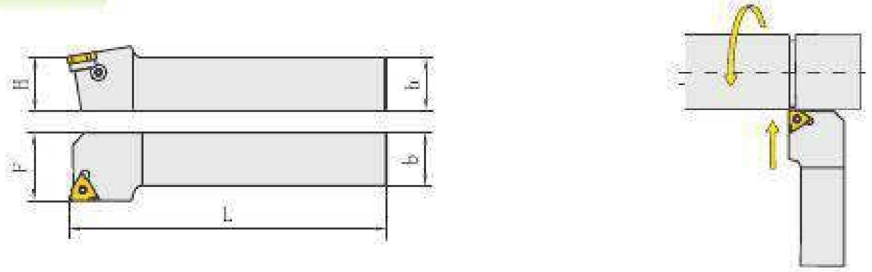
图片为右手刀具(SNR00**系列内切槽刀杆)
Right Cutting Tools(see picture)

型号Ordering Code		尺寸Dimensions(mm)							刀片Insert	刀片螺钉	扳手	刀垫	侧面螺钉	扳手
右刀Right Hand	左刀Left Hand	d1	d	F	L	h	l1	Dmin		Insert Screw	Torx Key	Anvil	Anvil Screw	Hex Wrench
SNR0010H11	SNL0010H11	10	10	7.4	100	9	12	12	T11N..	L60M2.5x6	T-08	-	-	-
SNR0012K11	SNL0012K11	12	12	8.4	125	11	15	15	T11N..	L60M2.5x6	T-08	-	-	-
SNR0013M11	SNL0013M11	13	16	8.9	150	15	25	15	T11N..	L60M2.5x6	T-08	-	-	-
SNR0013M16	SNL0013M16	13	16	10.2	150	15	25	16	T16N..	L60M3.5x8	T-15	-	-	
SNR0016M16	SNL0016M16	15	16	11.7	150	15	25	19	T16N..	L60M3.5x8	T-15	-	-	
SNR0020Q16	SNL0020Q16	19	20	13.7	180	18	24	24	T16N..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SNR0025R16	SNL0025R16	24	25	16.2	200	23	29	29	T16N..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SNR0032S16	SNL0032S16	31	32	19.7	250	30	36	36	T16N..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SNR0040T16	SNL0040T16	38	40	23.7	300	37	44	44	T16N..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SNR0050U16	SNL0050U16	47	50	28.7	350	46	54	54	T16N..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5

订货示例：SNR0020M16件　　Ordering example: SER2020K16 1pc

T11/T16切槽刀具 T11/T16 Grooving Tools

外圆槽刀具 External



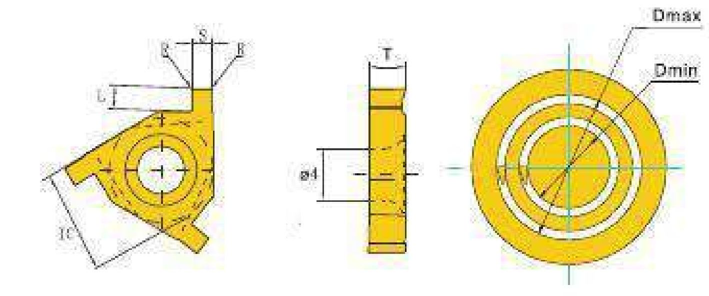
注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)					刀片Insert	刀片螺钉	扳手	刀垫	侧面螺钉	扳手
右刀Right Hand	左刀LeftHand	h	b	H	F	L		Insert Screw	Torx Key	Anvil	Anvil Screw	Hex Wrench
SEL1212F16	SER1212F16	12	12	12	16	80	T16E..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SEL1616H16	SER1616H16	16	16	16	20	100	T16E..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SEL2020K16	SER2020K16	20	20	20	25	125	T16E..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SEL2525M16	SER2525M16	25	25	25	32	150	T16E..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SEL3225P16	SER3225P16	32	25	32	32	170	T16E..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5
SEL3232P16	SER3232P16	32	32	32	40	170	T16E..	L60M3.5x12	T-15	GM-16	MQ040080	S2.5

订货示例：SER2020K161件　　Ordering example: SER2020K16 1pc

T16N/T22N端面切槽刀片 T16N/T22N Circlip Grooving Insert

图片为内切槽刀片
Internal Grooving Insert(see picture)



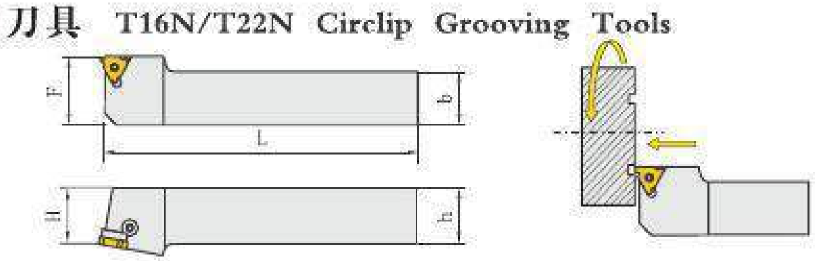
注意：该刀片配合螺纹车刀杆使用.
Note: The insert should be fited in threading

型号 Ordering Code	材质 Material code		适用刀杆 The Cutter Bar	所在页码	端面圆尺寸 Dmin~Dmax	尺寸 Dimensions (mm)					
	DK110	PM125				IC	d	T	S±0.02	L	R
T16N150DM10	○	●							1.50	1.8	
T16N200DM10	○	●	SEL****-16		10~∞	9.525	4	3.65	2.00	2.2	
T16N250DM10	○	●							2.50	2.2	0.1
T22N200DM15	○	●							2.00	3.0	
T22N250DM15	○	●	SEL****-22		15~∞	12.7	5	4.76	2.50	3.0	
T22N300DM15	○	●		40					3.00	3.0	
T16N150DM10R075	○	●		41	10~∞				1.50	2.0	0.75
T16N200DM10R100	○	●	SEL****-16			9.525	4	3.5	2.00	2.2	1.0
T22N200DM15R100	○	●							2.00	3.0	1.0
T22N250DM15R125	○	●	SEL****-22		15~∞	12.7	5	4.76	2.50	3.0	1.25

●:常备库存(主推)　Stock standard(main)　○:一般库存　Stock standard
订货示例：T16N200DM10 PM125 10片　　Ordering example: T16N200DM10 PM125 10pcs

T16N/T22N 端面切槽刀具 T16N/T22N Circlip Grooving Tools

图片为左手刀具
Right Cutting Tools(see picture)

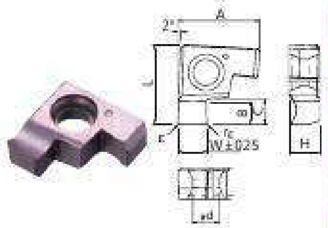
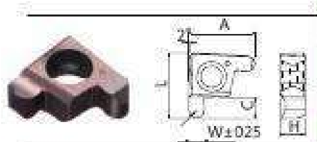
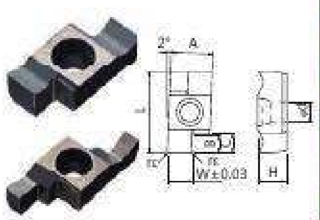


型号Ordering Code	尺寸Dimensions(mm)					刀片Insert	刀片螺钉	扳手	刀垫	侧面螺钉	扳手
左刀Left Hand	h	b	H	F	L		Insert Screw	Torx Key	Anvil	Anvil Screw	Hex Wrench
SEL1212F16	12	12	12	16	80	T16N..	L60M3.5x12	T-15	GM-16	MQ030080	T10
SEL1616H16	16	16	16	20	100	T16N.	L60M3.5x12	T-15	GM-16	MQ030080	T10
SEL2020K16	20	20	20	25	125	T16N..	L60M3.5x12	T-15	GM-16	MQ030080	T10
SEL2525M16	25	25	25	32	150	T16N..	L60M3.5x12	T-15	GM-16	MQ030080	T10
SEL2525M22	25	25	25	32	150	T22N..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SEL3225P22	32	25	32	32	170	T22N..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5
SEL3232P22	32	32	32	40	170	T22N..	L60M4.5x14	T-20	EGM-22	MQ040080	S2.5

订货示例：SER2020K161件　　Ordering example: SER2020K16 1pc

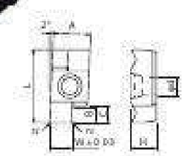
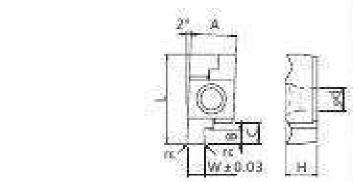
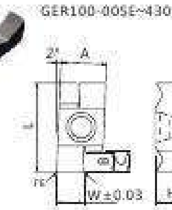
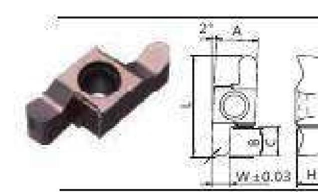
GE切槽刀片

型 号	A	L	H	Φd
GER/L...-A	6.69	6.5	2.58	2.5
GER/L...-AR				
GER/L...-B	8.46	8.2	3.18	2.7
GER/L...-BR				

形状 Shape	右刀片 Right Hand	左刀片 Left Hand	材质 Material Code		刀片尺寸 Dimensions (mm)			适用刀杆 Toolholders
			DK110	PM125	W	B	r	
	GER050-A	GEL050-A	○	●	0.50			
	GER060-A	GEL060-A	○	●	0.60			
	GER070-A	GEL070-A	○	●	0.70			
	GER080-A	GEL080-A	○	●	0.80		0.05	
	GER100-A	GEL100-A	○	●	1.00			
	GER120-A	GEL120-A	○	●	1.20	1.5		SIGER/L...A
	GER125-A	GEL125-A	○	●	1.25			SIGER/L...A
	GER140-A	GEL140-A	○	●	1.40			
	GER150-A	GEL150-A	○	●	1.50			
	GER180-A	GEL180-A	○	●	1.80		0.1	
	GER200-A	GEL200-A	○	●	2.00			
	GER080-B	GEL080-B	○	●	0.80			
	GER100-B	GEL100-B	○	●	1.00		0.05	
	GER120-B	GEL120-B	○	●	1.20			
	GER125-B	GEL125-B	○	●	1.25			
	GER130-B	GEL130-B	○	●	1.30			
	GER145-B	GEL145-B	○	●	1.45			SIGER/L...B
	GER150-B	GEL150-B	○	●	1.50	2.2		SIGER/L...B SIGER/L...B-A90
	GER180-B	GEL180-B	○	●	1.80		0.1	
	GER200-B	GEL200-B	○	●	2.00			
	GER225-B	GEL225-B	○	●	2.25			
	GER250-B	GEL250-B	○	●	2.50			
	GER280-B	GEL280-B	○	●	2.80		0.2	
	GER300-B	GEL300-B	○	●	3.00			
	GER100-050AR	GEL100-050AR	○	●	1.00	1.5	0.5	SIGER/L...A
	GER200-100AR	GEL200-100AR	○	●	2.00			SIGER/L...A
	GER100-050BR	GEL100-050BR	○	●	1.00	2.2	1.0	SIGER/L...B
	GER200-100BR	GEL200-100BR	○	●	2.00			SIGER/L...B SIGER/L...B-A90
	GER100-C	GEL100-C	○	●	1.00			
	GER120-C	GEL120-C	○	●	1.20		0.05	
	GER125-C	GEL125-C	○	●	1.25			
	GER140-C	GEL140-C	○	●	1.40	2.5		SIGER/L...C SIGER/L...C
	GER145-C	GEL145-C	○	●	1.45			SIGER/L...C-A90
	GER150-C	GEL150-C	○	●	1.50		0.1	
	GER160-C	GEL160-C	○	●	1.70	3.0		
	GER170-C	GEL170-C	○	●	1.85			

GE切槽刀片

型 号	A	L	H	Φd
GER/L...-C	5.8	11.48	4.05	2.8
GER/L...-CR				
GER/L...-D	6.8	16.44	5.05	4.4
GER/L...-DR				
GER/L...-E	9.54	21.66	5.55	4.4

形状 Shape	右刀杆 Right Hand	左刀杆 Left Hand	材质 Material Code		刀片尺寸 Dimensions (mm)			适用刀杆 Toolholders
			DK110	PM125	W	B	r	
	GER185-C	GEL185-C	○	●	1.85			
GER100-005D~080-020D	GER195-C	GEL195-C	○	●	1.95		0.1	
	GER200-C	GEL200-C	○	●	2.00			
GER300-020D~400-020D	GER225-C	GEL225-C	○	●	2.25			
	GER250-C	GEL250-D	○	●	2.50	2.5		SIGER/L...C SIGER/L...C
	GER275-C	GEL275-C	○	●	2.75			SIGER/L...C-A90
	GER280-C	GEL280-C	○	●	2.80		0.2	
	GER300-C	GEL300-C	○	●	3.00			
	GER320-C	GEL320-C	○	●	3.20			
	GER350-C	GEL350-C	○	●	3.50			
	GER100-D	GEL100-D	○	●	1.00			
GER100-005E~430-020E	GER120-D	GEL120-D	○	●	1.20		0.05	
	GER125-D	GEL125-D	○	●	1.25	2.5		
GER450-020E~500-020E	GER140-D	GEL140-D	○	●	1.40			
	GER145-D	GEL145-D	○	●	1.45			
	GER150-D	GEL150-D	○	●	1.50			
	GER170-D	GEL170-D	○	●	1.70	3.0		
	GER185-D	GEL185-D	○	●	1.85		0.1	
	GER195-D	GEL195-D	○	●	1.95			
	GER200-D	GEL200-D	○	●	2.00			SIGER/L...D
	GER225-D	GEL225-D	○	●	2.25			
	GER230-D	GEL230-D	○	●	2.30			
	GER250-D	GEL250-D	○	●	2.50	3.2		
	GER275-D	GEL275-D	○	●	2.75			
	GER280-D	GEL280-D	○	●	2.80			
	GER300-D	GEL300-D	○	●	3.00		0.2	
	GER320-D	GEL320-D	○	●	3.20			
	GER330-D	GEL330-D	○	●	3.30	4.5		
	GER350-D	GEL350-D	○	●	2.50			
	GER400-D	GEL400-D	○	●	4.00			
	GER200-100CR	GEL200-100CR	○	●	2.00		1.0	SIGER/L...C
	GER250-125CR	GEL250-125CR	○	●	2.50	2.5	1.25	SIGER/L...C
	GER300-150CR	GEL300-150CR	○	●	3.00		1.5	SIGER/L...C-A90
	GER200-100DR	GEL200-100DR	○	●	2.00	3.2	1.0	SIGER/L...D
	GER300-150DR	GEL300-150DR	○	●	3.00	4.5	1.5	

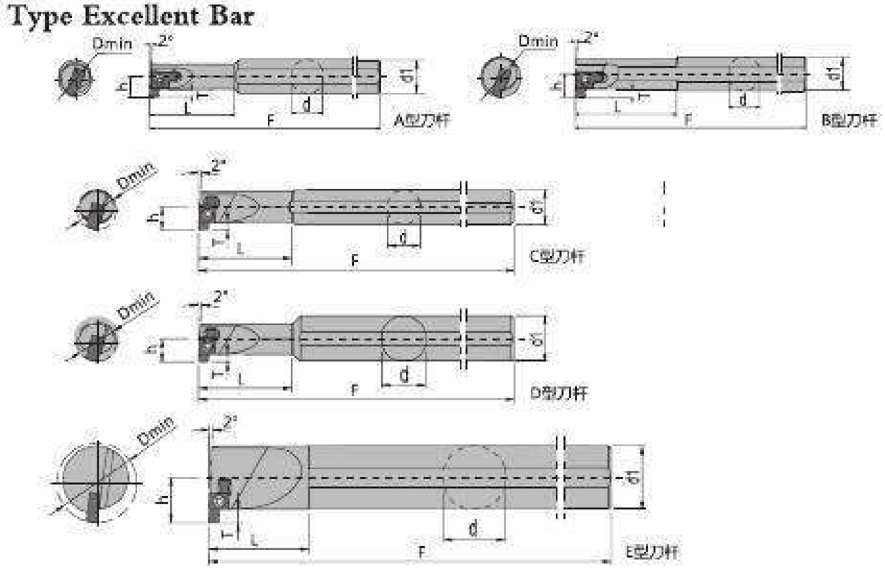
GE切槽刀片



型号	A	L	H	Φd
GER/L...-C	5.8	11.48	4.05	2.8
GER/L...-CR				
GER/L...-D	6.8	16.44	5.05	4.4
GER/L...-DR				
GER/L...-E	9.54	21.66	5.55	4.4

形状 Shape	右刀杆 Right Hand	左刀杆 Left Hand	材质 Material Code		刀片尺寸 Dimensions (mm)			适用刀杆 Toolholders
			DK110	PM125	W	B	r	
	GER100-E	GEL100-E			1.00	2.5	0.05	
	GER150-E	GEL150-E			1.50			
	GER170-E	GEL170-E			1.70	3.0		
	GER185-E	GEL185-E			1.85		0.1	
	GER195-E	GEL195-E			1.95			
	GER200-E	GEL200-E			2.00			
	GER225-E	GEL225-E			2.25	3.2		
	GER230-E	GEL230-E			2.30			
	GER250-E	GEL250-E			2.50			
	GER275-E	GEL275-E			2.75			SIGER/L...E
	GER280-E	GEL280-E			2.80	4.5		
	GER300-E	GEL300-E			3.00			
	GER330-E	GEL330-E			3.30		0.2	
	GER350-E	GEL350-E			3.50			
	GER400-E	GEL400-E			4.00	5.5		
	GER430-E	GEL430-E			4.30			
	GER450-E	GEL450-E			4.50			
	GER460-E	GEL460-E			4.60	6.5		
	GER500-E	GEL500-E			5.00			

SIGE型刀杆 SIGE Type Excellent Bar



图为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:Right tools match with right inserts;left tools match with left inserts.

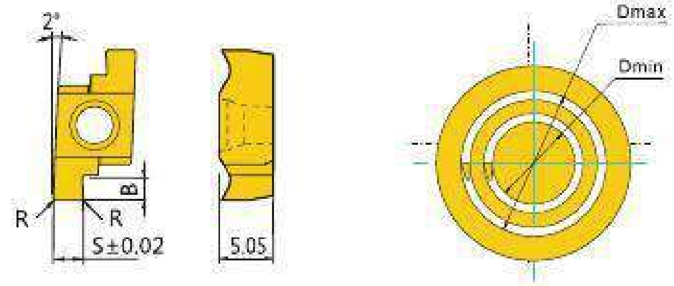
右刀杆 Right Hand	左刀杆 Left Hand	尺寸Dimensions(mm)						最小加工直径	适用刀片 Insert	刀片螺钉 Insert Screw	扳手 Torx Key
		d1	d	F	L	h	T	Dmin			
SIGER0808A	SIGEL0808A	8	7.2	100	20	4.8	1.5	8	GER/L100-A~200-A GER100-050AR~200-100AR	L60M2.2X5	T7
SIGER1010B	SIGEL1010B	10	9	125	25	6.2	2.2	10	GER/L100-B~300-B	L60M2.5X6	T8
SIGER1210B	SIGEL1210B	10	9	125	30	7	2.2	12	GER100-050BR~200-100BR		
SIGER1412C	SIGEL1412C	12	11.4	150	33	8	2.5	14	GER/L100-C~350-C		
SIGER1612C	SIGEL1612C	12	11.4	150	20	8.5	2.5	16	GER150-CM~350-CM	L60M2.5X6	T8
SIGER1616C	SIGEL1616C	16	15	160	36	9	2.5	16	GER200-100CR~300-150CR		
SIGER2020D	SIGEL2020D	20	19	180	40	12.1	4.5	20	GER/L100-D~400-D GER150-DM~400-DM GER200-100DR~300-150DR	L60M3.0X8.0	T10
SIGER2525E	SIGEL2525E	25	24	200	45	15.6	6.5	25			
SIGER3232E	SIGEL3232E	32	30.4	220	55	19	6.5	32	GER/L100-E~500-E GER150-EM~500-EM	L60M4.0X8.5	T15
SIGER4032E	SIGEL4032E	32	30.4	250	45	23	6.5	40			

●常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：SIGER2020D 1支 Ordering example:SIGER2020D 1pcs

GER 端面切槽刀片 GER Circlip Grooving Insert

图片为内切槽刀片
Internal Grooving Insert(see picture)



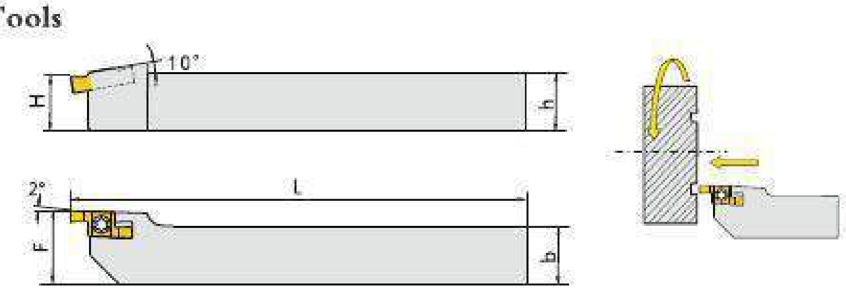
型号 Ordering Code	材质 Material code DK110	PM125	适用刀杆 The Cutter Bar	端面圆尺寸 Dmin~Dmax	尺寸 Dimensions (mm) S±0.02	B	R
GER100DM06-D	○	●		6~∞	1.00	2.5	0.05
GER150DM10-D	○	●	SEGER1010F-D	10~∞	1.50	2.8	0.1
GER200DM10-D	○	●			2.00	3.5	
GER250DM15-D	○	●	SEGER1212H-D		2.50	4.5	
GER300DM15-D	○	●		15~∞	3.00	4.5	0.2
GER400DM15-D	○	●	SEGER1616H-D		4.00	4.5	
★GER150DM10R075-D	○	●		10~∞	1.50	2.5	0.75
★GER200DM10R100-D	○	●	SEGER2020K-D		2.00	3.5	1.0
★GER250DM15R125-D	○	●			2.50	4.5	1.25
★GER300DM15R150-D	○	●	SEGER2525M-D	15~∞	3.00	4.5	1.5
★GER400DM15R200-D	○	●			4.00	4.5	2.0

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：GER200DM15-D PM125 10片 Ordering example: GER200DM15-D PM125 10pcs

★ 刃口为圆弧刃口

SEGE刀杆 Grooving Tools



图为左手刀具
Right Cutting Tools(see picture)

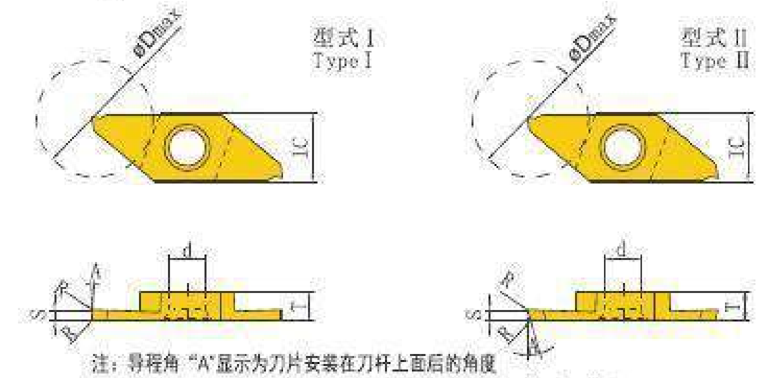
注意：左手刀具配GER系列刀片，右手刀具配GEL系列刀片
Note:Left tools match with right inserts;Right tools match with left inserts.

左刀杆 Left Hand	尺寸Dimensions(mm) h	b	L	F	H	最小加工直径 Dmin	适用刀片 右Right	刀片螺钉 Insert Screw	扳手 Torx Key
SEGEL1010K-D	10	10	125	10	10	10			
SEGEL1212K-D	12	12	125	12	12	12	GER****-D		
SEGEL1616H-D	16	16	100	20	16	16		L60M3.0X8.0	T8
SEGEL2020K-D	20	20	125	25	20	20	GER****DM15-D		
SEGEL2525M-D	25	25	150	32	25	25			

★ 当配GER***-D系列刀片时，可切外槽
★ 当配GER***DM15-D系列刀片时，可切端面槽

TKF切断刀片 TKF Parting-off Insert

图片为右手刀片
Right Insert(see picture)



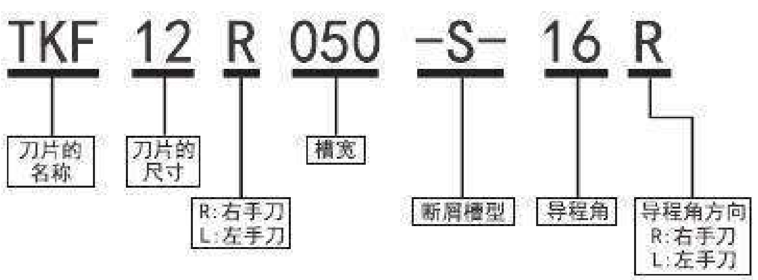
注：导程角 "A"显示为刀片安装在刀杆上面后的角度
Note: Relative to the toolholder, A is the insert's angle after installation.

型号 Ordering Code 右手刀片 Right Hand	材质 Material code DK110	PM125	型号 Ordering Code 左手刀片 Left Hand	材质 Material code DK110	PM125	型式 Type	尺寸 Dimensions (mm) IC±0.02	T±0.02	d	*A	*S±0.03	*D	*R
TKF12R050-S		○	TKF12L050-S								0.5	5	
TKF12R070-S		○	TKF12L070-S								0.7	8	
TKF12R100-S		●	TKF12L100-S		○	I	8.7	3	5	0°	1.0		0.03
TKF12R150-S		●	TKF12L150-S		○						1.5	12	
TKF12R200-S		●	TKF12L200-S		○						2.0		
TKF12R050-S16R		○	TKF12L050-S16R								0.5	5	
TKF12R070-S16R		○	TKF12L070-S16R								0.7	8	
TKF12R100-S16R		●	TKF12L100-S16R		○	II	8.7	3	5	16°	1.0		0.05
TKF12R150-S16R		●	TKF12L150-S16R		○						1.5	12	
TKF12R200-S16R		●	TKF12L200-S16R		○						2.0		
TKF16R100-S		●	TKF16L100-S		○						1.0		
TKF16R150-S		●	TKF16L150-S		○						1.5		
TKF16R200-S		●	TKF16L200-S		○	I	9.5	4	5	0°	2.0	16	0.05
TKF16R250-S		●	TKF16L250-S		○						2.5		
TKF16R300-S		●	TKF16L300-S		○						3.0		
TKF16R100-S16R		●	TKF16L100-S16R		○						1.0		
TKF16R150-S16R		●	TKF16L150-S16R		○						1.5		
TKF16R200-S16R		●	TKF16L200-S16R		○	II	9.5	4	5	16°	2.0	16	0.05
TKF16R250-S16R		●	TKF16L250-S16R		○						2.5		
TKF16R300-S16R		●	TKF16L300-S16R		○						3.0		

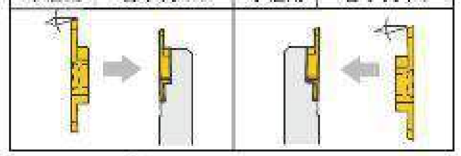
●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例：TKF12R200-S PM125 10片 Ordering example: TKF12R200-S PM125 10pcs

刀片型号的表示方法 Representation method for blade type



刀杆	右手刀(R)	刀杆	左手刀(L)
刀片	右手刀(R)	刀片	左手刀(L)
导程角	右手刀(R)	导程角	右手刀(R)



走芯机刀杆专用螺钉

Screw for CNC Precision Automatic Lathe tool holders

订货型号SP-M4X10

Ordering code: SP-M4X10

★走芯机刀杆专用螺钉(M4X10)

Screw for CNC Precision Automatic Lathe tool holders (M4*10)

★从正面锁紧使用扳手T15, 从背面锁紧使用扳手T8

Front Side : Locking with T15 Wrench

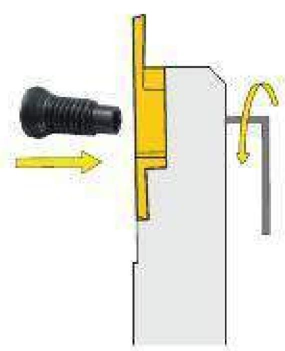
Reverse Side : Locking with T8 Wrench

★需单独订购

Ordered Separately

★适配于TGF32、TKF12/16、TKFB、THC42系列刀具

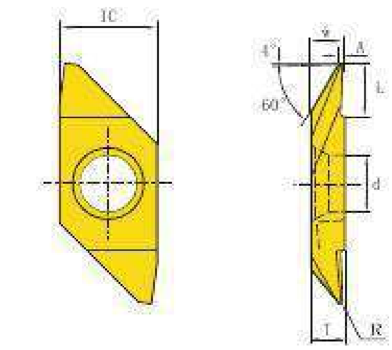
Apply to : Tool Holders for inserts TGF32, TKF12/16, TKFB, THC42



TKFB背车加工刀片

图片为右手刀片

Right Insert(see picture)



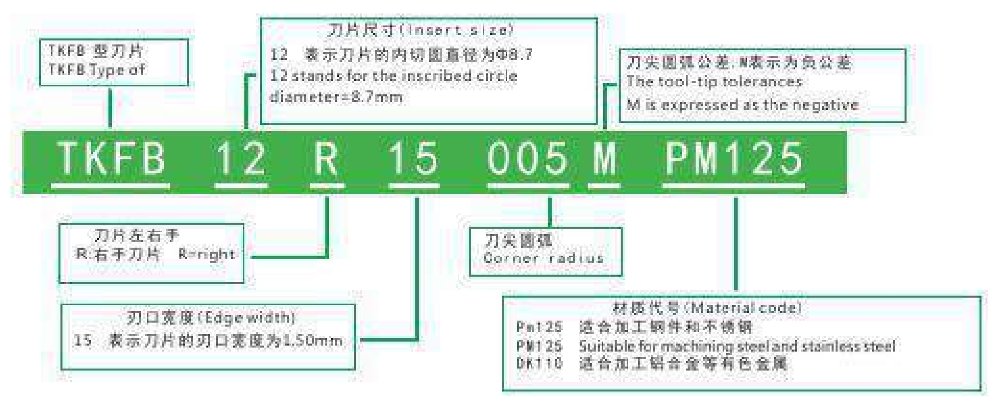
型 号 Ordering Code 右手刀片 Right Hand	材质 Material code			适用刀杆 (详见P10) Application of a knife(see P10)	尺寸 Dimensions (mm)						
	DK110	PM125			IC	T	W	A	*L	d	*R
TKFB12R15005M	○	●					1.5	0.25	2.6		<0.05
TKFB12R28005M	○	●		KTKFR...12	8.7	3	2.8	0.3	4.6		<0.05
TKFB12R28010M	○	●								5.0	<0.1
TKFB16R38005M	○	●		KTKFR...16	9.5	4	3.8	0.3	6.3		<0.05
TKFB16R38010M	○	●									<0.1

●:常备库存(主推) Stock standard(main) ○:一般库存 Stock standard

订货示例: TKFB12R50005M PM125 10片 Ordering example: TKFB12R50005M PM125 10pcs

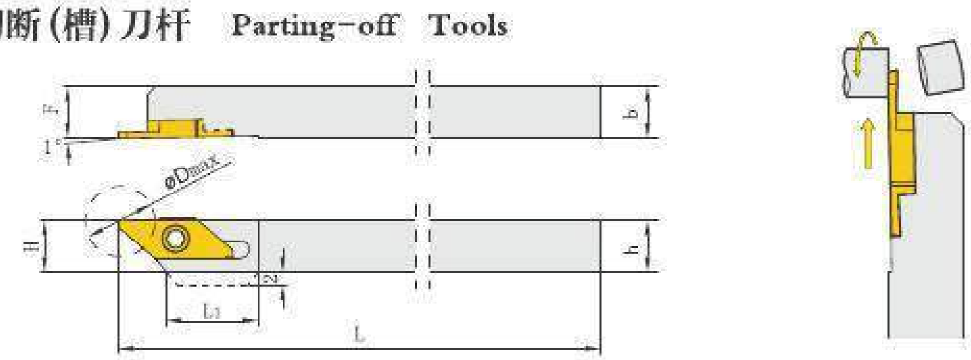
TKFB刀片命名规则:

TKFB Inser Identification chart:



切槽(断)刀具 GROOVING TOOLS

切断(槽)刀杆 Parting-off Tools



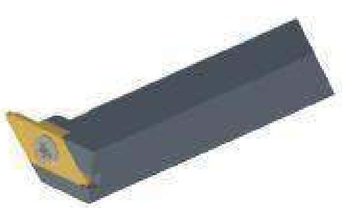
Right Cutting Tools(see picture)
图示为右手刀具

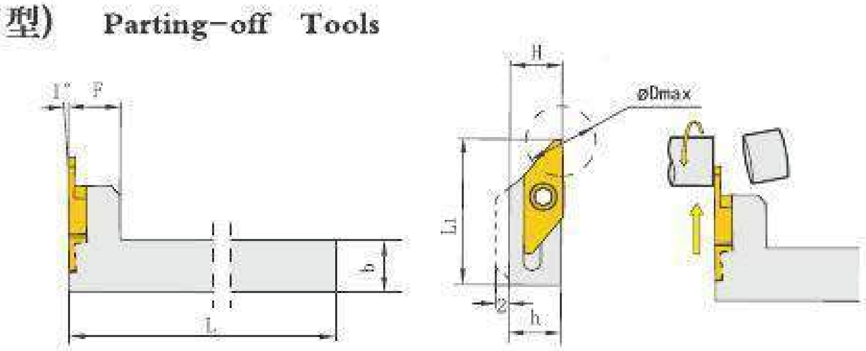
注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:Right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)							适用刀片Insert		刀片螺钉	扳手
左刀Left Hand	右刀Right Hand	h	b	H	F	L	D	L1	右Right	左Left	Insert Screw	Torx Key
KTKFL1010K-12	KTKFR1010K-12	10	10	10	10	125		15				
KTKFL1212F-12	KTKFR1212F-12	12	12	12	12	85			TKF12R..	TKF12L..		
KTKFL1212M-12	KTKFR1212M-12	12	12	12	12		12	-	TKFB12R..	TKFB12L..	L60M4x10	T-15
KTKFL1616M-12	KTKFR1616 M-12	16	16	16	16	150			TKFT12R..	TKFT12L..		
KTKFL2020M-12	KTKFR2020M-12	20	20	20	20							
KTKFL1010K-16	KTKFR1010K-16	10	10	10	10	125		20				
KTKFL1212F-16	KTKFR1212F-16	12	12	12	16	85			TKF16R..	TKF16L..		
KTKFL1212M-16	KTKFR1212M-16	12	12	12	12		16	-	TKFB16R..	TKFB16L..	L60M4x10	T-15
KTKFL1616M-16	KTKFR1616M-16	16	16	16	16	150			TKFT16R..	TKFT16L..		
KTKFL2020M-16	KTKFR2020M-16	20	20	20	20							

订货示例：KTKFR1212M-12 1件　　Ordering example:KTKFR1212M-12 1pc

TKF切槽刀杆(排刀型) Parting-off Tools



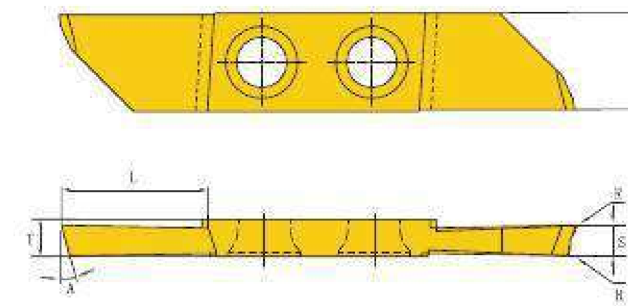


图示为左手刀具
Right Cutting Tools(see picture)

型号Ordering Code	尺寸Dimensions(mm)							适用刀片Insert	刀片螺钉	扳手
左刀Right Hand	h	b	H	F	L	D	L1	右Right	Insert Screw	Torx Key
KTKFL1010F-12-A90	10	10	10	10	80		16	TKF12R..		
KTKFL1212F-12-A90	12	12	12	12	80	12	20	TKFB12R..	L60M4x10	T-15
KTKFL1616H-12-A90	16	16	16	16	100		24	TKFT12R..		
KTKFL2020K-12-A90	20	20	20	20	125		30			
KTKFL1010K-16-A90	10	10	10	10	80		20	TKF16R..		
KTKFL1212F-16-A90	12	12	12	16	80	16	20	TKFB16R..	L60M4x10	T-15
KTKFL1616H-16-A90	16	16	16	16	100		24	TKFT16R..		
KTKFL2020K-16-A90	20	20	20	20	125		30			

THC42型双孔切断刀片 THC42 Double-hole Parting-off Insert

图片为右手刀片
Right Insert(see picture)



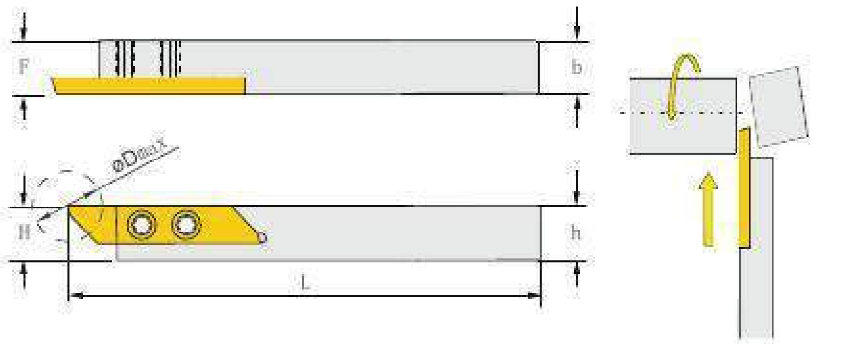
型号 Ordering Code	材质 Material code		型号 Ordering Code	材质 Material code		尺寸 Dimensions (mm)					
右手刀片 Right Hand	DK110	PM125	左手刀片 Left Hand	DK110	PM125	IC±0.01	T±0.01	A	*S±0.01	*L	*R
THC42R100-CE	○	●	THC42L100-CE	○	○			0°	1.00	5	0.06
THC42R100-CE15R	○	●	THC42L100-CE15R	○	○			15°	1.00		0.06
THC42R150-CE	○	●	THC42L150-CE	○	○			0°	1.50	8.5	0.06
THC42R150-CE15R	○	●	THC42L150-CE15R	○	○			15°	1.50		0.06
THC42R200-CE	○	●	THC42L200-CE	○	○		3.07	0°	2.00		0.1
THC42R200-CE15R	○	●	THC42L200-CE15R	○	○			15°	2.00		0.1
THC42R250-CE	○	●	THC42L250-CE	○	○			0°	2.50		0.1
THC42R250-CE15R	○	●	THC42L250-CE15R	○	○			15°	2.50		0.1
THC42R300-CE	○	●	THC42L300-CE	○	○	7.94		0°	3.00		0.2
THC42R300-CE15R	○	●	THC42L300-CE15R	○	○			15°	3.00	11.5	0.2
THC42R340-CE	○	●	THC42L340-CE	○	○		3.47	0°	3.40		0.2
THC42R340-CE15R	○	●	THC42L340-CE15R	○	○			15°	3.40		0.2
THC42R200-CN	○	●	THC42L200-CN	○	○			0°	2.00		0.1
THC42R200-CU15R	○	●	THC42L200-CU15R	○	○			15°	2.00		0.1
THC42R250-CN	○	●	THC42L250-CN	○	○		3.07	0°	2.50		0.1
THC42R250-CU15R	○	●	THC42L250-CU15R	○	○			15°	2.50		0.1
THC42R300-CN	○	●	THC42L300-CN	○	○			0°	3.00		0.2
THC42R300-CU15R	○	●	THC42L300-CU15R	○	○			15°	3.00		0.2

●:常备库存(主推)　Stock standard(main)　○:一般库存　Stock standard

订货示例：THC42R200-CE PM125 10片　Ordering example: THC42R200-CE PM125 10pcs

切槽(断)刀具 GROOVING TOOLS

双孔切断(槽)刀杆



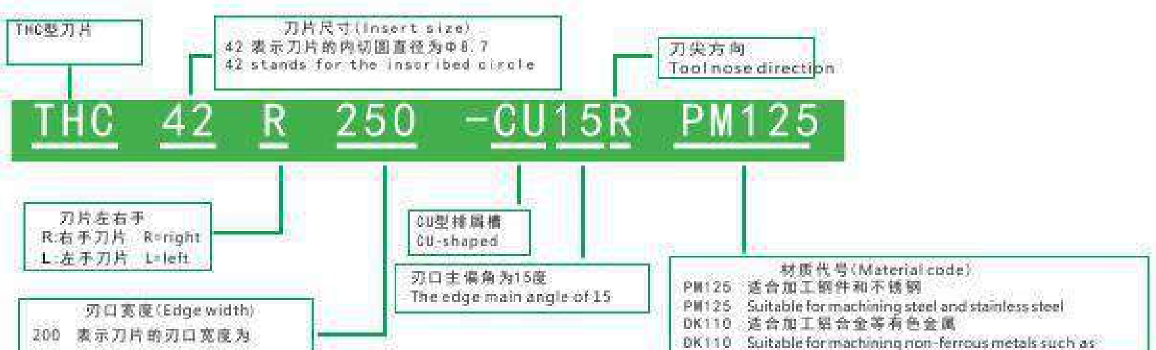
图为右手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:Right tools match with right inserts;left tools match with left inserts.

型号Ordering Code		尺寸Dimensions(mm)						适用刀片Insert		刀片螺钉	扳手
右刀Right Hand	左刀Left Hand	h	b	H	F	L	D	右Right	左Left	Insert Screw	Torx Key
THCR1010J42	THCL1010J42	10	10	10	10	110					
THCR1212J42	THCL1212J42	12	12	12	12	110					
THCR1616J42	THCL1616J42	12	16	16	16	110	21	THC42R..	THC42L..	L60M4x10	T15
THCR2020K42	THCL2020K42	16	20	20	20	125					
THCR2525M42	THCL2525M42	25	25	25	25	150					

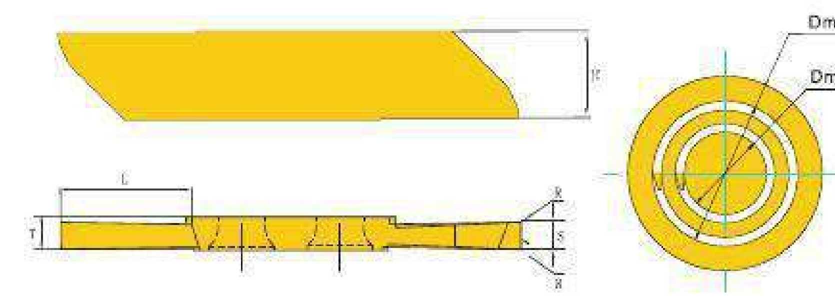
订货示例：THCR2020K42 1件　　Ordering example: THCR2020K42 1pc

双孔切断刀片命名规则:
Insert Identification Chart:



THC42型端面切槽刀片　THC42 Circlip Grooving Insert

图片为右手刀片
Right Insert(see picture)

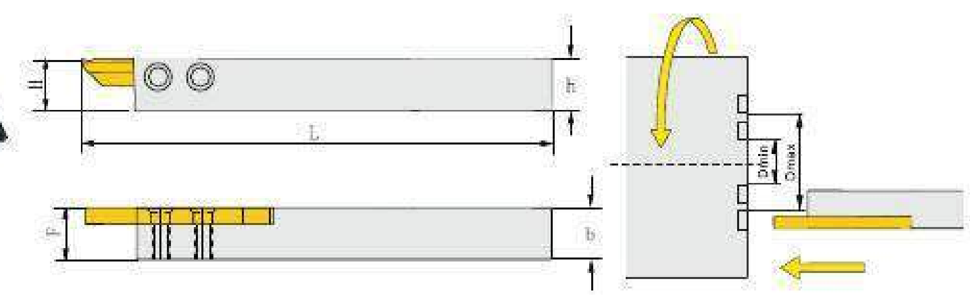


型　号 Ordering Code 右手刀片 Right Hand	材质 Material code			适用刀杆 The Cutter Bar	端面最小圆 Dmin	尺寸 Dimensions (mm)				
	DK110	PM125				IC±0.01	T±0.01	*S±0.01	*L	*R
THC42L200DM10-CE	○	●						2.00	9	0.06
THC42L250DM10-CE	○	●			10~∞	7.94	3.07	2.50	11.5	0.10
THC42L300DM10-CE	○	●		THCL****42				3.00	11.5	0.15
THC42L340DM10-CE	○	●					3.47	3.40	11.5	0.15

●:常备库存(主推)　Stock standard(main)　○:一般库存　Stock standard
订货示例：THC42R200-CE PM125 10片　Ordering example: THC42R200-CE PM125 10pcs

THC系列端面切槽刀杆　Cutting Tools

Dmax



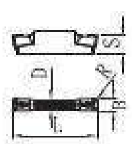
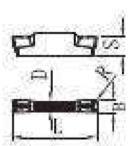
图为左手刀具
Right Cutting Tools(see picture)

注意：右手刀具(R)配右手刀片(R)，左手刀具(L)配左手刀片(L)
Note:Right tools match with right inserts;left tools match with left inserts.

型号Ordering Code	尺寸Dimensions(mm)					适用刀片Insert	刀片螺钉	扳手
左刀Left Hand	h	b	H	F	L		Insert Screw	Torx Key
THCL1010J42	10	10	10	10	110			
THCL1212J42	12	12	12	12	110	THC42L***DM10		
THCL1616J42	12	16	16	16	110		L60M4x10	T15
THCL2020K42	16	20	20	20	125	THC42L***		
THCL2525M42	25	25	25	25	150			

订货示例：THCR2020K42 1件　　Ordering example: THCR2020K42 1pc

DQ系列切槽刀片 GROOVING INSERT

刀片基本形状The basic shape of inserts		型号 Type	基本尺寸 Dimension（mm）			材质推荐 Grade recommended		
			B	R	Lmax	PM310	DP510	DK110
		DQPED02502-MG	2.5	0.2	17	○	○	
		DQPFD0302-MG	3	0.2	17	○	○	
		DQPGD0402-MG	4	0.2	22	○	○	
		DQPHD0503-MG	5	0.3	22	○	○	
		DQPKD0604-MG		0.4	22	○	○	
		DQTED02503-MG	2.5	0.3	17	○	○	
		DQTFD0303-MG	3	0.3	17	○	○	
		DQTGD0404-MG	4	0.4	22	○	○	
		DQTHD0504-MG	5	0.4	22	○	○	
		DQTKD0608-MG	6	0.8	22	○	○	

注：可与株洲钻石刀片互换

PM310:不锈钢和钢件通用材质，耐高温性能提升，适合加工不锈钢和软钢

PM310: Stainless steel and universal material, high temperature resistant performance, suitable for the processing of stainless steel and mild steel

DP510：钢件用材质，具有良好的韧性，适合加工大部分钢件

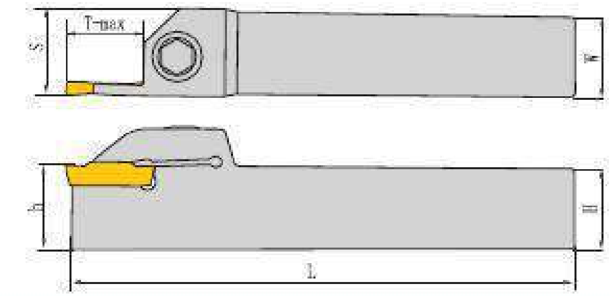
DP510: Steel material, with good toughness, suitable for processing most of the steel parts

DK110：铝用材质，适合加工有色金属

DK110: Aluminum material, suitable for processing non-ferrous metals

DQ系列切槽(断)刀杆 GROOVING TOOLS

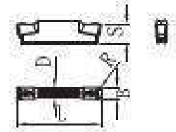
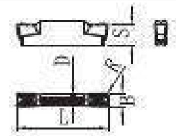
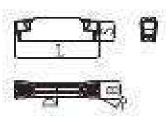
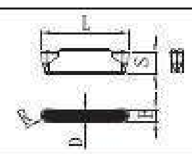
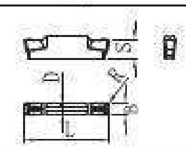
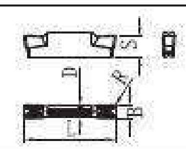
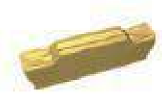
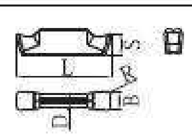
图片为右手刀具
Right Insert(see picture)



型号 Type		库存 Stock item		适用刀片 Recommended inserts	适用条件 Application 外切削槽、车削加工 External Grooving、Turning					配件 Parts	
		R	L		H=(h)	W	L	S	T(max)	螺丝 Screw	扳手 Wrench
DQEED	1616R/L10	○		DQ*ED025**	16	16	125	2.5	10	M5X20	L4.0
	1616R/L17	○			20	20	125	2.5	17		
	2020R/L10	○			25	25	125	2.5	10	M6X20	L5.0
	2020R/L17				12	12	125	2.5	17		
	2525R/L10	○	○		16	16	150	2.5	10		
	2525R/L17	○	○		20	20	150	2.5	17		
DQEFD	1616R/L10	○	○	DQ*FD03**	25	25	125	3	10	M5X20	L4.0
	1616R/L17	○	○		16	16	125	3	17		
	2020R/L10	○	○		20	20	125	3	10	M6X20	L5.0
	2020R/L17	○	○		25	25	125	3	17		
	2525R/L10	●	●		16	16	150	3	10		
	2525R/L17	●	●		20	20	150	3	17		
DQEGD	1616R/L13	●		DQ*GD04**	20	20	140	4	13	M6X20	L5.0
	1616R/L22	●	●		25	25	140	4	22		
	2020R/L13	●			25	25	150	4	13		
	2020R/L22	●	●		32	32	150	4	22		
	2525R/L13				32	32	170	4	13		
	2525R/L22	●	●		20	20	170	4	22		
DQEHD	2525R/L13	●		DQ*HD05**	20	20	150	5	13	M6X20	L5.0
	2525R/L22	●	●		25	25	150	5	22		
	3232R/L13	●	●		25	25	170	5	13		
	3232R/L22	●	●		32	32	170	5	22		
DQEKD	2525R/L13			DQ*KD06**	32	32	150	6	13	M6X20	L5.0
	2525R/L22	○	○		20	20	150	6	22		
	3232R/L13				20	20	170	6	13		
	3232R/L22	○	○		25	25	170	6	22		

●库存 stock item　○准库存 be preparing for stock　其余订货 the others can be made to order

MGMN系列切槽刀片 GROOVING INSERT

刀片基本形状The basic shape of inserts		型号 Type		基本尺寸 Dimension（mm） B	R	L	D	S	材质推荐 Grade recommended PM310	DP510	DK110
		MGMN	200-M	2	0.2	16	1.2	3.5	●	●	
			250-M	2.5	0.2	18.5	2	3.85	●	●	
			300-M	3	0.4	21	2.35	4.8	●	●	
			400-M	4	0.4	21	3.3	4.8	●	●	
			500-M	5	0.8	26	4.1	5.8	●	●	
		MGMN	150-G	1.5	0.15	16	1.2	3.5	●	●	
			200-G	2	0.2	16	1.6	3.5	●	●	
			300-G	3	0.4	21	2.35	4.8			
			400-G	4	0.4	21	3.3	4.8			
		MGMN	200-T	2	0.2	16	1.5	3.5			
			300-T	3	0.4	21	2.35	4.8			
			400-T	4	0.4	21	3.3	4.8			
			500-T	5	0.8	25.86	4.12	5.8			
		MRMN	200-M	2	1	16	1.5	3.5	●	●	
			300-M	3	1.5	21	2.35	4.8	●	●	
			400-M	4	2	21	3.3	4.8	●	●	
			500-M	5	2.5	25.86	4.12	5.8	●	●	
		MGGN	200-M	2	0.2	16	1.5	3.5			
			300-M	3	0.4	21	2.35	4.8			
			400-M	4	0.4	21	3.3	4.8			
			500-M	5	0.8	25.86	4.12	5.8			
		MGGN	200-G	2	0.2	16	1.5	3.5			
			300-G	3	0.4	21	2.35	4.8			
			400-G	4	0.4	21	3.3	4.8			
			500-G	5	0.8	25.86	4.12	5.8			
		MGGN	200-LH	2	0.2	16	1.5	3.5	●		○
			300-LH	3	0.4	21	2.35	4.8	●		○
			400-LH	4	0.4	21	3.3	4.8	●		○
			500-LH	5	0.8	25.86	4.12	5.8	●		○

PM310：不锈钢和钢件通用材质，耐高温性能提升，适合加工不锈钢和软钢

PM310：Stainless steel and universal material, high temperature resistant performance, suitable for the processing of stainless steel and mild steel

DP510：钢件用材质，具有良好的韧性，适合加工大部分钢件

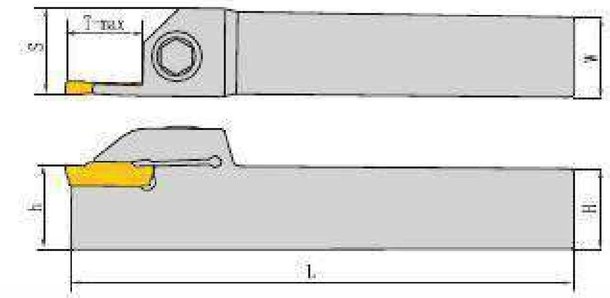
DP510：Steel material, with good toughness, suitable for processing most of the steel parts

DK110：铝用材质，适合加工有色金属

DK110：Aluminum material, suitable for processing non-ferrous metals

MGMN系列切槽(断)刀杆 GROOVING TOOLS

图片为右手刀具
Right Insert(see picture)



	型号 Type	库存 Stock Item R	L	适用刀片 Recommended inserts	适用条件 Application 外切削槽、车削加工 External Grooving, Turning H=(h)	W	L	S	T(max)	配件 Parts 螺丝 Screw	扳手 Wrench
	1616-1.5	○			16	16	100	16.25	14.5		
	2020-1.5	○		MGMN*** MGGN***	20	20	125	20.25	14.5	LTX0512	L2.0
	2525-1.5	○			25	25	150	25.25	14.5		
	1212-2.0				12	12	100	14.25	14.5		
	1616-2.0	●	○	MGMN***	16	16	100	16.25	14.5	BHA0616	L5.0
	2020-2.0	●	○	MGGN***	20	20	125	20.25	14.5		
	2525-2.0	●	○		25	25	150	25.25	14.5		
	1616-2.5	●	○	MGMN***	16	16	100	16.3	16.5		
	2020-2.5	●	○		20	20	125	20.3	16.5	MHA0512	L4.0
	2525-2.5	●	○	MGGN***	25	25	150	25.3	16.5		
	1616-3.0	●	○		16	16	100	16.35	18.5		
	2020-3.0	●	○		20	20	125	20.4	18		
	2020-3.0-T10	○		MGMN***	20	20	125	20.4	10		
	2525-3.0	●	○	MGGN***	25	25	150	25.4	18		
MGEHR/L	2525-3.0-T10	○			25	25	150	25.4	10		
	3232-3.0	●	○		32	32	170	32.4	18		
	3233-3.0-T10				32	32	170	32.4	10		
	2020-4.0	●	○		20	20	125	20.4	18		
	2020-4.0-T10	○			20	20	125	20.5	10		
	2525-4.0	●	○	MGMN***	25	25	150	25.4	18	BHA0616	L5.0
	2525-4.0-T10	○	○	MGGN***	25	25	150	25.4	10		
	3232-4.0	●	○		32	32	170	32.4	18		
	3232-4.0-T10				32	32	170	32.4	10		
	2020-5	○	○		20	20	150	20.5	23		
	2020-5-T15				20	20	150	20.5	15		
	2525-5	○	○	MGMN***	25	25	150	25.5	23		
	2525-5-T15			MGGN***	25	25	150	25.5	15		
	3232-5	○	○		32	32	170	32.5	23		
	3232-5-T15				32	32	170	32.5	15		

●库存 stock item　○准库存 be preparing for stock　其余订货 the others can be made to order

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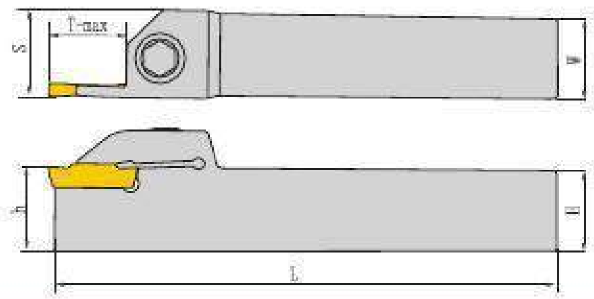
接上页

MGMN系列切槽(断)刀杆 GROOVING TOOLS

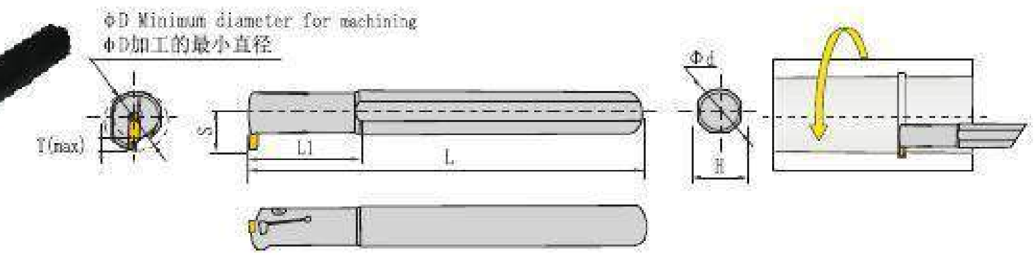
图片为右手刀具
Right Insert(see picture)



型号 Type		库存 Stock item R	库存 Stock item L	适用刀片 Recommended inserts	适用条件 Application 外切削槽、车削加工 External Grooving, Turning H=(h)	W	L	S	T(max)	配件 Parts 螺丝 Screw	配件 Parts 扳手 Wrench
	2020 -6	○	○		20	20	125	20.6	23		
	2020 -6-T15				20	20	125	20.6	15		
	2525 -6			MGMN600-M MRMN600-M	25	25	150	25.6	23		
MGEHR/L	2525 -6-T15				25	25	150	25.6	15		
	3232 -6				32	32	170	32.6	23		
	3232 -6-T15				32	32	170	32.6	15		

●库存 stock item　○准库存 be preparing for stock　其余订货 the others can be made to order

切槽(断)刀杆

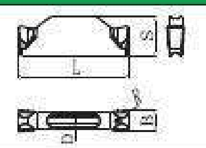
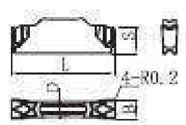
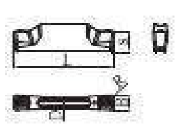


型号 Type		库存 Stock item R	库存 Stock item L	适用刀片 Recommended inserts	适用条件 Application 内槽加工、车削加工 Internal Grooving, Turning ΦD	Φd	L	L1	T(max)	H	S	配件 Parts 螺丝 Screw	配件 Parts 扳手 Wrench
	2020-1.5	○			20	16	125	35	4	15	11.3	MHB0310	L2.5
	2525-1.5	○		MGMN150-G	25	20	150	45	4	18	13.1	MHA0512	L4.0
	3925-1.5				29	25	200	45	4	23	16.2		
	2016-2.0	○			20	16	125	35	5	15	12.4	MHB0310	L2.5
	2520-2.0	○		MGMN200-G	25	20	150	45	5	18	14	MHA0512	L4.0
	2925-2.0	○			29	25	200	45	5	23	17.2		
	2016-2.5				20	16	125	35	6	15	12.5	MHB0310	L2.5
	2520-2.5	○		MGMN250-G	25	20	150	45	6	18	15.1	MHA0512	L4.0
	2925-2.5	○			29	25	200	45	6	23	18.2		
	2520-3.0	●	●		25	20	150	45	6	18	15.6		
	3125-3.0	●	●	MGMN300-M MRMN300-M	31	25	200	45	6	25	18.9		
	3732-3.0	●	●		37	32	250	65	6	30	21.5		
MGIVR/L	2520-4.0	●	●		25	20	150	45	6	18	15.6		
	3125-4.0	●		MGMN400-M MRMN400-M	31	25	200	45	6	23	18.9		
	3732-4.0	●			37	32	250	65	6	30	21.5		
	3125-5	○		MGMN500-M MRMN500-M	31	25	200	45	8	25	19.5		
	3732-5	○			37	32	250	65	8	30	21.5	MHA0512	L4.0
	3125-6			MGMN600-M MRMN600-M	31	25	200	45	8	23	19.4		
	3732-6				37	32	250	65	8	30	21.5		
	3732-8			MRMN800-M	37	32	250	65	10	30	23.4		
	3540-8				45	40	300	70	10	37	27.2		
	3125-6A			MRGN600-A	31	25	200	45	8	23	19.4		
	3732-6A				37	32	250	65	8	30	21.5		
	3732-8A			MNGN800-A	37	32	250	65	10	30	23.4		
	4540-8A				45	40	300	70	10	37	27.2		

●库存 stock item　○准库存 be preparing for stock　其余订货 the others can be made to order

切槽(断)刀具 GROOVING TOOLS

TD系列切槽刀片 GROOVING INSERT

刀片基本形状The basic shape of inserts		型号 Type	基本尺寸 Dimension（mm）					材质推荐 Grade recommended		
			B	R	L	D	S	PM310	DP510	DK120
		TDJ2	2	0.2	20	1.7	3.9	●	●	
		TDJ3	3	0.2	20	2.4	4	●	●	
		TDJ4	4	0.3	19.76	3	4.05	●	●	
		TDJ5	5	0.3	25	4	4.89	●	●	
		TDC2	2	0.2	20	1.7	3.84	●	●	
		TDC3	3	0.2	20	2.4	4	●	●	
		TDC4	4	0.3	20	3	4.03	●	●	
		TDC5	5	0.3	25	4	4.89	●	●	
		TDT2	2	0.2	20	1.7	3.9			
		TDT3	3	0.2	20	2.4	4			
		TDT4	4	0.3	19.76	3	4.05			
		TDT5	5	0.3	25	4	4.89			

PM310:不锈钢和钢件通用材质，耐高温性能提升，适合加工不锈钢和软钢

PM310：Stainless steel and universal material, high temperature resistant performance, suitable for the processing of stainless steel and mild steel

DP510：钢件用材质，具有良好的韧性，适合加工大部分钢件

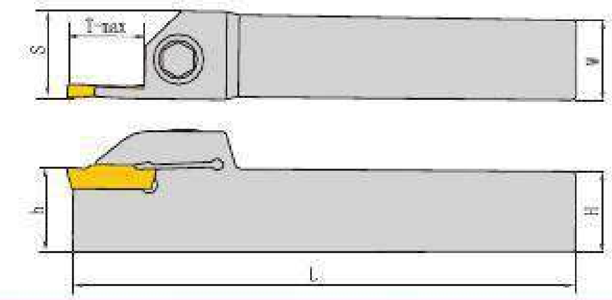
DP510：Steel material, with good toughness, suitable for processing most of the steel parts

DK110：铝用材质，适合加工有色金属

DK110：Aluminum material, suitable for processing non-ferrous metals

TD系列切槽(断)刀杆 GROOVING TOOLS

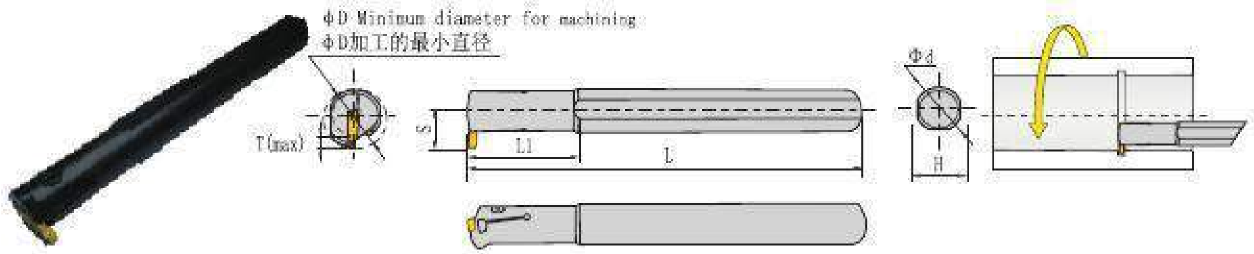
图片为右手刀具
Right Insert(see picture)



型号 Type		库存 Stock Item		适用刀片 Recommended inserts	适用条件 Application 外切削槽、车削加工 External Grooving、Turning					配件 Parts	
		R	L		H=(h)	W	L	S	T(max)	螺丝 Screw	扳手 Wrench
TTER/L	1616-2.0	○		TD***2	16	16	110	15.1	14	M5X16	L4.0
	2020-2.0	○			20	20	125	19.1			
	2525-2.0	○			25	25	150	24.1			
	1616-3.0	○		TD***3	16	16	110	14.8	18		
	2020-3.0	○			20	20	125	18.8			
	2525-3.0	○			25	25	150	23.8			
	1616-4.0			TD***4	16	16	110	14.5	18	M6X16	L5.0
	2020-4.0	○			20	20	125	18.5			
	2525-4.0	○			25	25	150	23.5			
	2525-5.0	○		TD***5	25	25	150	23.1	23	M8X20	L6.0
	3232-5.0	○			32	32	170	29.1			

●库存 stock item ○准库存 be preparing for stock 其余订货 the others can be made to order

TD系列切槽(断)刀杆 GROOVING TOOLS



型 号 Type	库存 Stock Item R	库存 Stock Item L	适用刀片 Recommended inserts	适用条件 Application 内槽加工、车削加工 Internal Grooving, Turning ΦDmin	Φd	L	L1	T(max)	H	S	配件 Parts 螺丝 Screw	配件 Parts 扳手 Wrench
TTIR/L16-2C			TDC/J2	25	16	125	–	8.5	7.5	16.5	M5X10	L4.0
TTIR/L20-2C				25	20	160	40	6.0	9.0	15.8	M5X12	
TTIR/L25-2C				25	25	200	40	5.0	11.5	17.5	M5X16	
TTIR/L20-3C			TDC/J3	25	20	160	40	6.0	9.0	15.8	M5X12	
TTIR/L25-3C				25	25	200	40	5.1	11.5	17.5	M5X16	
TTIR/L32-3C				31	32	250	60	4.7	14.0	19.8	M5X16	
TTIR/L20-4C			TDC/J4	25	20	160	40	6.0	9.0	15.8	M5X12	
TTIR/L25-4C				25	25	200	40	5.2	11.5	17.5	M5X16	
TTIR/L32-4C				31	32	250	60	4.7	14.0	20.8	M5X16	
TTIR/L25-5C			TDC/J5	25	25	200	40	5.2	11.5	17.3	M6X16	L5.0
TTIR/L32-5C				31	32	250	60	4.7	14.0	20.8	M6X20	
TTIR/L25-3C-T8			TDC/J3	32	25	200	40	8	11.5	21.5	M5X16	L4.0
TTIR/L32-3C-T10				40	32	250	60	10	15	27	M5X20	
TTIR/L40-3C-T12				50	40	300	65	12	19	33	M5X25	
TTIR/L25-4C-T8			TDC/J4	32	25	200	40	8	11.5	21.5	M5X16	
TTIR/L32-4C-T10				40	32	250	60	10	15	27	M5X20	
TTIR/L40-4C-T12				50	40	300	65	12	19	33	M5X25	
TTIR/L50-4C-T14				60	50	350	70	14	23.5	40	M6X20	
TTIR/L32-5C-T10			TDC/J5	40	32	250	60	10	15	27	M6X25	L5.0
TTIR/L40-5C-T12				50	40	300	65	12	19	33	M6X20	
TTIR/L50-5C-T12				60	50	350	70	12	23.5	40	M6X25	

●库存 stock item ○准库存 be preparing for stock 其余订货 the others can be made to order