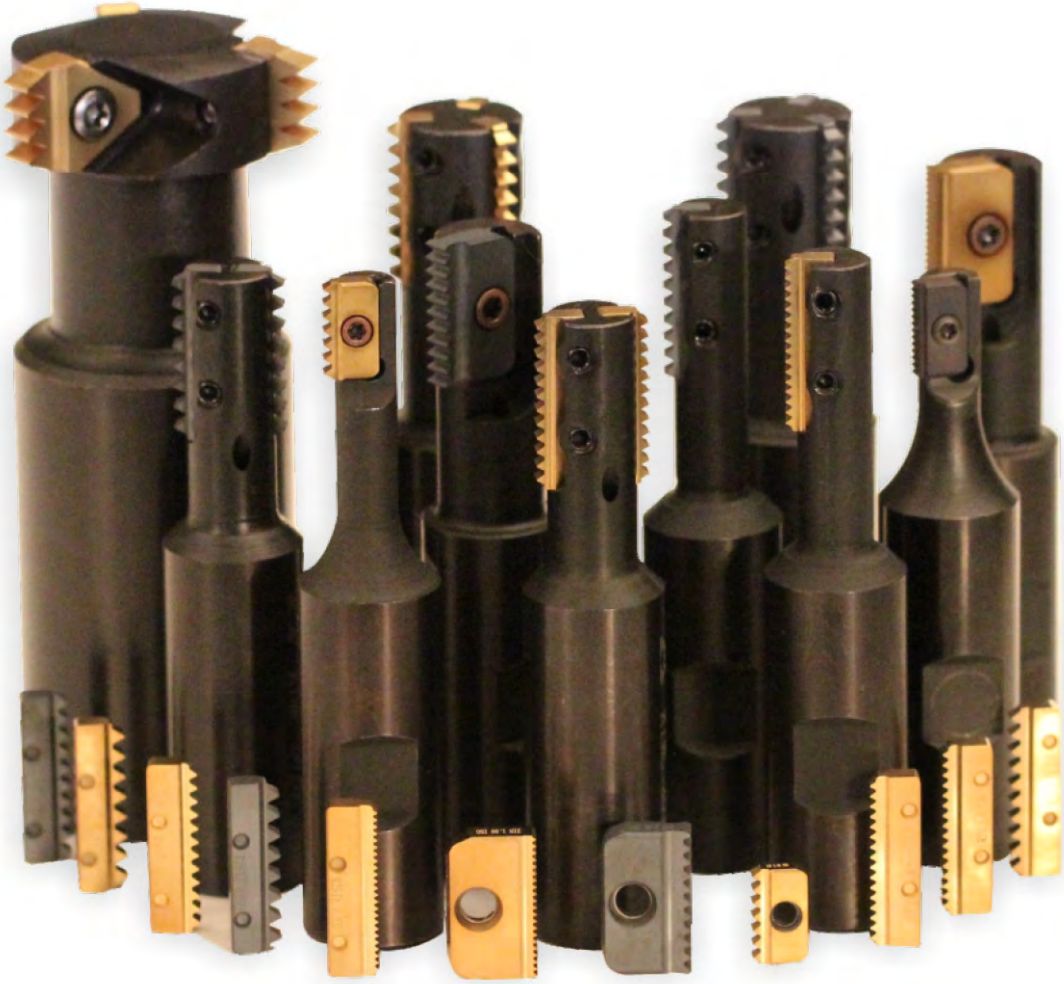
螺纹铣削刀具

THREAD MILLING TOOLS



成都戴梦迪超硬工具有限责任公司

CHENGDU DIAMOND TOOLS CO., LTD.

螺纹铣削刀具

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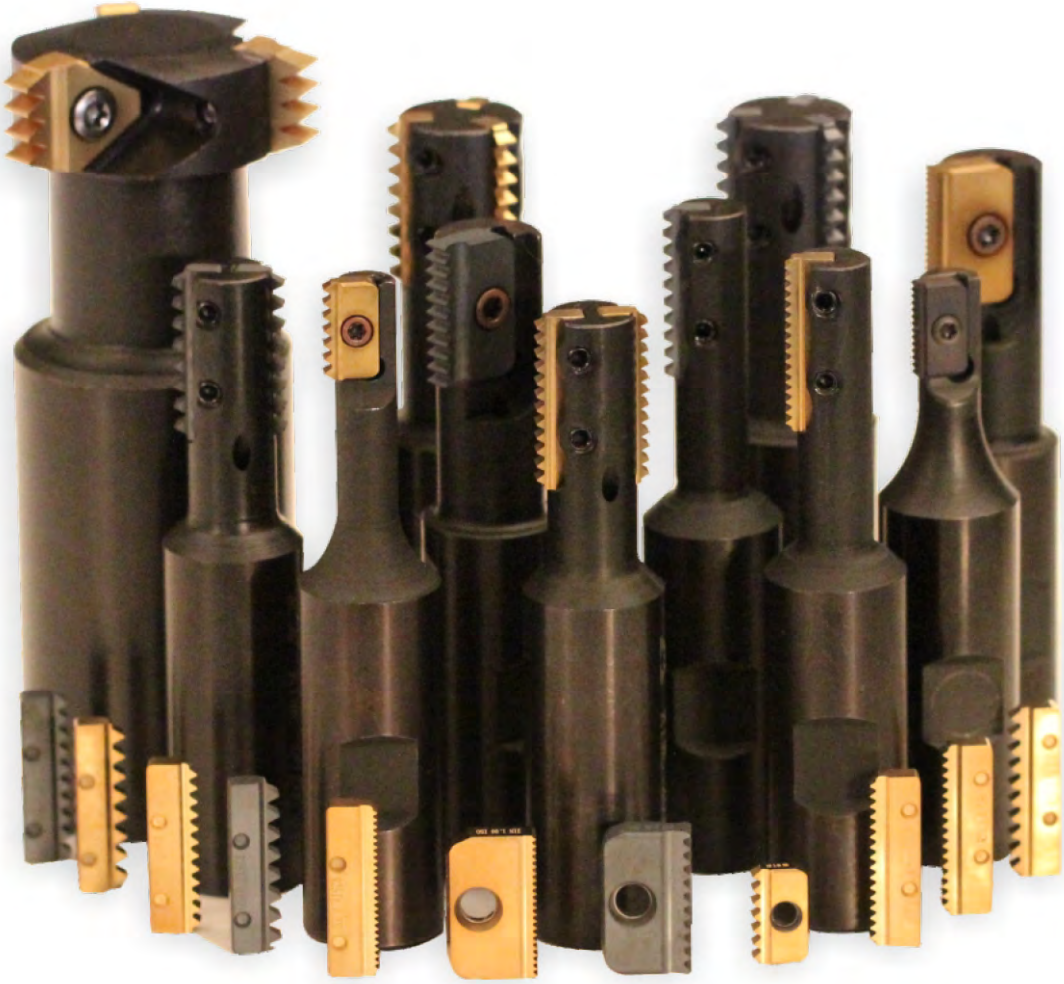

成都戴梦迪超硬工具有限责任公司

CHENGDU DIAMOND TOOLS CO., LTD.

公司简介 Introduction

成都戴梦迪超硬工具有限责任公司
是专业生产 PCBN/PCD 金属切削刀具、PCD螺旋立铣刀、
PCBN/PCD轧辊刀具、PCD木工刀具、PCD家俱刀、PCD石材刀具、
硬质合金螺纹车铣刀具、硬质合金成形刀片的民营企业。
公司制造设备先进, 技术力量雄厚。
公司的宗旨是“生产精品刀具，打造世界品牌”。
公司生产的刀具产品在替代进口刀具；高速切削；高稳定性加工；
以车代磨；硬态加工等方面效果显著。
尤其适合于汽车、电子行业的规模化生产。
公司目前已成为国内众多汽车及零部件制造厂的指定供应商,
知名企业上海大众、潍柴集团、富士康等都是公司的大用户,
戴梦迪®刀具产品远销欧美市场。
公司已通过ISO9001-2008质量管理体系认证、
德国TUV认证、瑞士SGS认证。

Chengdu Diamond Tools Co., Ltd.
We are a leading and professional manufacture of PCBN/PCD Cutting Tools, PCD End Mills,
PCBN/PCD Roller Cutting Tools,PCD Woodworking Tools,PCD Furniture Tools,
PCD Stone Engraving Tools,Carbide Threading Turning / Milling Cutting Tools/Forming Tools.
We possess advanced equipments and outstanding experts.
Our Mission : Excellent Cutting Tools To Produce,World Famous Brand To Create.
Our cutting tools are featured as high-speed cutting,high stability machining,
replacement of grinding with turning.
Therefore they are ideal alternative solutions for imported ones.
These products are suitable for the mass production in Automobile and electronic industry.
We have been certified supplier for many automobiles and spare parts factories in China,
including the famous corporations-Shanghai Volkswagen, Weichai Group,Foxconn,etc.
Meanwhile,our DIAMOND® branded tools are exported to dozens of countries all over the world.
We are granted ISO9001-2008 certification,
TUV certification and SGS certification.

生产精品刀具　打造世界品牌

Excellent Cutting Tools To Produce　World Famous Brand To Create

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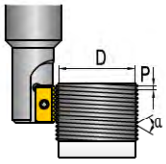
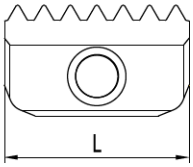


T 系列螺纹铣刀

T Series Threading Milling Tools

T系列螺纹铣刀片型号

T Series Threading Milling Inserts - Code Keys



T	21	I	2.00	ISO	-	DLT9
1	2	3	4	5		6

1、产品系列 Product Series

T - T系列
T - T Series

2、刀片尺寸 Insert size

L = 12mm　L = 14mm
L = 21mm　L = 30mm
L = 40mm

3、加工类型 Type of Insert

E — 外螺纹　External
I — 内螺纹　Internal
- — 对两面刃刀片，一面做外螺纹，另一面做内螺纹
One edge for internal.other edge for external
EI— 内外通用螺纹 External + Internal

4、螺 距 Pitch

0.5 - 5.5 mm
32 - 4 TPI

5、螺纹标准 Standard

ISO — ISO 标准型螺纹　ISO Metric
UN — 60° 美制统一螺纹　American UN
W — 55° 英国惠氏螺纹　Whitworth for BSW BSP
NPT — 60° 美制管螺纹　NPT
NPTF - 60° 美制干密封螺纹　NPTF
BSPT - 55° 英制管螺纹　British Standard Pipe Thread (BSPT)

6、涂层种类 Coating type

DT3–适用于碳钢，通用材料
First choice for carbon steel and ordinary steel process
DLT9–适用于不锈钢及难加工材料
Excellent for stainless steel and difficult operations

T系列直柄螺纹铣刀杆型号

T Series Threading Milling Toolholders - Code Keys

T	S	C	25	30	-	52	21	-	2
1	2	3	4	5		6	7		8

1、产品系列 Product Series

T - T系列
T - T Series

2、刀杆类型 Holder Type

S - 标准型
- Standard holder
C - 锥度型
- Conical holder

3、冷却形式 Cooling Form

C - 内冷却
- Cooling
E - 外冷却
- External Cooling

4、刀柄直径 Shank Dia.[mm]

20 25 32 40

5、切削刃直径 Cutting Dia.[mm]

9.5- 50

6、刀柄悬长 Tool Overhang[mm]

14 - 78

7、刀片尺寸 Insert size

12 14 21 30 40

8、槽 数 Flutes

1 - 2

T系列套式螺纹铣刀杆型号

T Series Threading Shell Mill Toolholders - Code Keys

T	S	E	D80	27	-	30	-	6
1	2	3	4	5		6		7

1、产品系列 Product Series

T - T系列
T - T Series

2、刀杆类型 Holder Type

S - 标准型
- Standard holder

3、冷却形式 Cooling Form

E - 外冷却
- External Cooling

4、切削刃直径 Cutting Dia.[mm]

63 - 100

5、内孔直径 Drive Hole Dia.[mm]

22 27 32

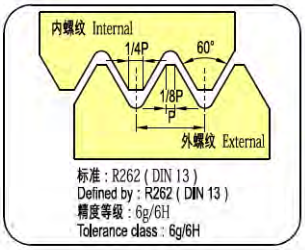
6、刀片尺寸 Insert size

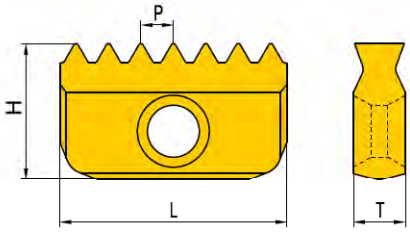
21 30 40

7、槽 数 Flutes

5 - 7

ISO标准螺纹铣刀片 ISO Metric Full Profile

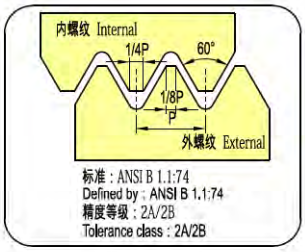


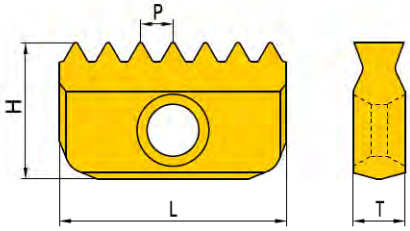


加工螺距 Pitch mm		刀片尺寸 Insert Size L=12mm	L=14mm	L=21mm	L=30mm	L=40mm
0.5	外 Ext					
	内 Int	*T12I0.50 ISO	T14I0.50 ISO			
0.75	外 Ext		T14E0.75 ISO			
	内 Int	*T12I0.75 ISO	T14I0.75 ISO			
1	外 Ext		T14E1.00 ISO	T21E1.00 ISO		
	内 Int	*T12I1.00 ISO	T14I1.00 ISO	T21I1.00 ISO		
1.25	外 Ext		T14E1.25 ISO			
	内 Int	*T12I1.25 ISO	T14I1.25 ISO			
1.5	外 Ext		T14E1.50 ISO	T21E1.50 ISO	T30E1.50 ISO	T40E1.50 ISO
	内 Int	*T12I1.50 ISO	T14I1.50 ISO	T21I1.50 ISO	T30I1.50 ISO	T40I1.50 ISO
1.75	外 Ext		T14E1.75 ISO			
	内 Int		T14I1.75 ISO	T21I1.75 ISO		
2	外 Ext		T14E2.00 ISO	T21E2.00 ISO	T30E2.00 ISO	T40E2.00 ISO
	内 Int		T14I2.00 ISO	T21I2.00 ISO	T30I2.00 ISO	T40I2.00 ISO
2.5	外 Ext		T14E2.50 ISO	T21E2.51 ISO		
	内 Int		T14I2.50 ISO	T21I2.51 ISO		
3	外 Ext			T21E3.00 ISO	T30E3.00 ISO	T40E3.00 ISO
	内 Int			T21I3.00 ISO	T30I3.00 ISO	T40I3.00 ISO
3.5	外 Ext				T30E3.50 ISO	
	内 Int			T21I3.50 ISO	T30I3.50 ISO	T40I3.50 ISO
4	外 Ext				T30E4.00 ISO	T40E4.00 ISO
	内 Int				T30I4.00 ISO	T40I4.00 ISO
4.5	外 Ext					
	内 Int				T30I4.50 ISO	T40I4.50 ISO
5	外 Ext					T40E5.00 ISO
	内 Int					T40I5.00 ISO
5.5	外 Ext					
	内 Int					T40I5.50 ISO
6	外 Ext					T40E6.00 ISO
	内 Int					T40I6.00 ISO
H		6.5	7.9	12.6	16.7	20.9
T		2.9	3.2	4.8	5.5	6.4

* 表示只有单面刃
* Insert with one cutting edge

UN-60°美制统一螺纹铣刀片 UN-60° American UN Full Profile



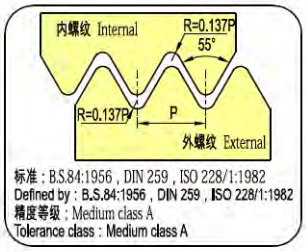


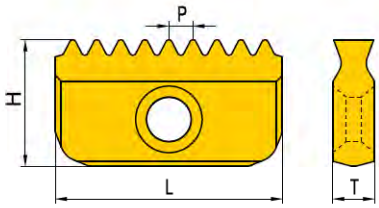
加工螺距 Pitch		刀片尺寸 Insert Size				
TPI		L=12mm	L=14mm	L=21mm	L=30mm	L=40mm
32	外 Ext		T14E32 UN			
	内 Int	*T12I32 UN	T14I21 UN			
28	外 Ext		T14E28 UN			
	内 Int	*T12I28 UN	T14I28 UN			
27	外 Ext					
	内 Int		T14I27 UN			
24	外 Ext		T14E24 UN	T21E24 UN		
	内 Int	*T12I24 UN	T14I24 UN	T21I24 UN		
20	外 Ext		T14E20 UN	T21E20 UN	T30E20 UN	
	内 Int	*T12I20 UN	T14I20 UN	T21I20 UN	T30I20 UN	
18	外 Ext		T14E18 UN	T21E18 UN	T20E18 UN	
	内 Int	*T12I18 UN	T14I18 UN	T21I18 UN	T30I18 UN	
16	外 Ext		T14E16 UN	T21E16 UN	T30E16 UN	T40E16 UN
	内 Int	*T12I16 UN	T14I16 UN	T21I16 UN	T30I16 UN	T40I16 UN
14	外 Ext		T14E14 UN	T24E14 UN	T30E14 UN	T40E14 UN
	内 Int		T14I14 UN	T21I14 UN	T30I14 UN	T40I14 UN
12	外 Ext		T14E12 UN	T21E12 UN	T30E12 UN	T40E12 UN
	内 Int		T14I12 UN	T21I12 UN	T30I12 UN	T40I12 UN
10	外 Ext			T21E10 UN	T30E10 UN	T40E10 UN
	内 Int			T21I10 UN	T30I10 UN	T40I10 UN
8	外 Ext				T30E8 UN	T40E8 UN
	内 Int			T21I8 UN	T30I8 UN	T40I8 UN
6	外 Ext				T30E6 UN	T40E6 UN
	内 Int				T30I6 UN	T40I6 UN
4.5	外 Ext					
	内 Int					T40I4.5 UN
4	外 Ext					
	内 Int					T40I4 UN
H		6.5	7.9	12.6	16.7	20.9
T		2.9	3.2	4.8	5.5	6.4

* 表示只有单面刃

* Insert with one cutting edge

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



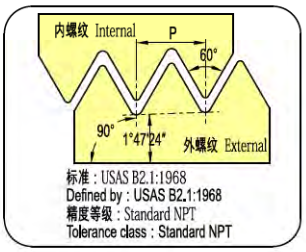


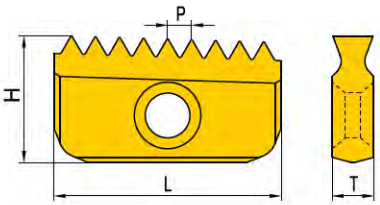
加工螺距 Pitch	刀片尺寸 Insert Size				
TPI	L=12mm	L=14mm	L=21mm	L=30mm	L=40mm
24		T14EI24 W			
20		T14EI20 W	T21EI20 W		
19	*T12EI19 W	T14EI19 W	T21EI19 W		
16		T14EI16 W	T21EI16 W	T30EI16 W	
14		T14EI14 W	T21EI14 W	T30EI14 W	
11			T21EI11 W	T30EI11 W	T40EI11 W
8					T40EI8 W

* 表示只有单面刃

* Insert with one cutting edge

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



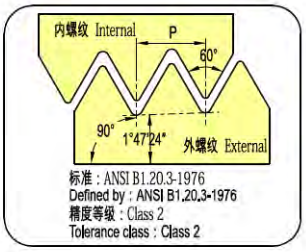


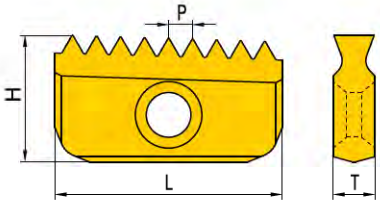
加工螺距 Pitch	刀片尺寸 Insert Size				
TPI	L=12mm	L=14mm	L=21mm	L=30mm	L=40mm
18	*T12E18 NPT、*T12I18 NPT	T14-18 NPT			
14		T14-14 NPT	T21-14 NPT		
11.5			T21-11.5 NPT	T30-11.5 NPT	T40-11.5 NPT
8				T30-8 NPT	T40-8 NPT

* 表示只有单面刃

* Insert with one cutting edge

NPTF美制干密封锥管螺纹铣刀片 American NPTF



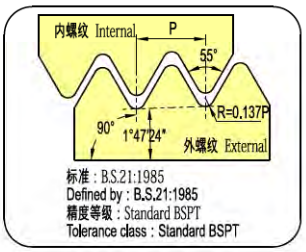


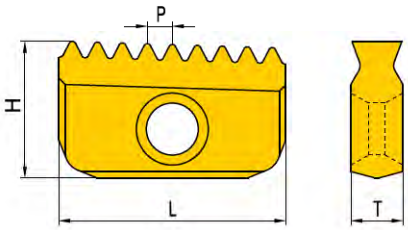
加工螺距 Pitch	刀片尺寸 Insert Size				
TPI	L=12mm	L=14mm	L=21mm	L=30mm	L=40mm
18	*T12E18 NPTF、*T12I18 NPTF	T14-18 NPTF			
14		T14-14 NPTF	T21-14 NPTF		
11.5			T21-11.5 NPTF	T30-11.5 NPTF	T40-11.5 NPTF
8				T30-8 NPTF	T40-8 NPTF

* 表示只有单面刃

* Insert with one cutting edge

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



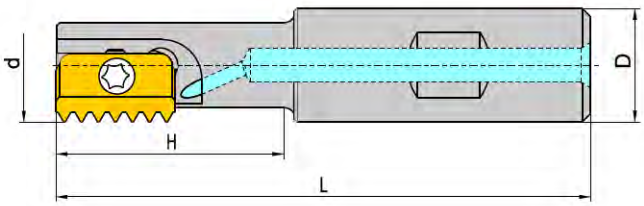


加工螺距 Pitch	刀片尺寸 Insert Size				
TPI	L=12mm	L=14mm	L=21mm	L=30mm	L=40mm
19	*T12E19 BSPT、*T12I19 BSPT	T14-19 BSPT			
14		T14-14 BSPT	T21-14 BSPT		
11			T21-11 BSPT	T30-11 BSPT	T40-11 BSPT

* 表示只有单面刃

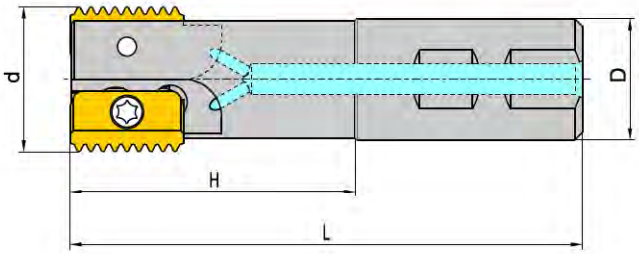
* Insert with one cutting edge

螺纹铣刀杆 Threading Milling Toolholders



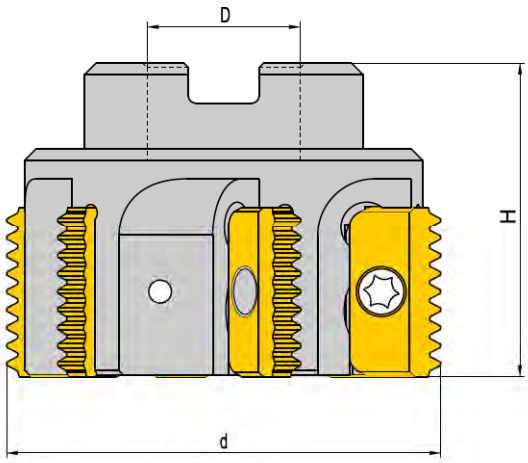
订货号 Order NO.	尺寸 Dimensions (mm)				齿数 Teeth	螺距 Pitch		刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	d	D	H	L	Zt	mm	TPI			
TSE209.5-1412-1	9.5	20	14	85	1	0.5~1.5	16~32	T12	M2.5×7	T08
TSE209.9-1612-1	9.9	20	16	85	1	0.5~1.5	16~32	T12	M2.5×7	T08
TSE2012-2014-1	12	20	20	85	1	0.5~2.5	10~32	T14	M3×8	T08
TSE2014.5-2514-1	14.5	20	25	85	1	0.5~2.5	10~32	T14	M3×8	T08
TSC2017-3014-1	17	20	30	85	1	0.5~2.5	10~32	T14	M3×8	T08
TSC2018-3021-1	18	20	30	85	1	1~3.5	7~24	T21	M4×10	T15
TSC2021-4021-1	21	20	40	94	1	1~3.5	7~24	T21	M4×10	T15
TSC2025-3021-1	25	20	30	125	1	1~3.5	7~24	T21	M4×10	T15
TSC2529-5030-1	29	25	50	110	1	1.5~5.0	6~20	T30	M5×11	T20
TSC2531-5030-1	31	25	50	150	1	1.5~5.0	6~20	T30	M5×11	T20
TSC3238-5038-1	38	32	50	150	1	1.5~5.0	6~20	T30	M5×11	T20
TSC4045-7840-1	45	40	78	210	1	1.5~6.0	4~16	T40	M5×12	T20
TSC4048-7840-1	48	40	78	153	1	1.5~6.0	4~16	T40	M5×12	T20

螺纹铣刀杆 Threading Milling Toolholders



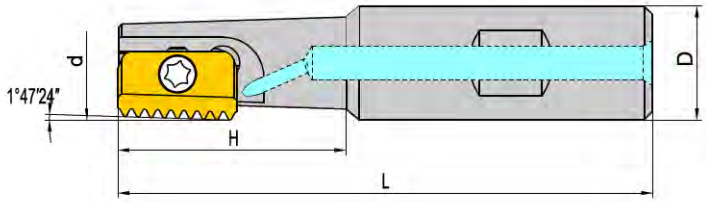
订货号 Order NO.	尺寸 Dimensions (mm)				齿数 Teeth	螺距 Pitch		刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	d	D	H	L	Zt	mm	TPI			
TSC2020-4114-2	20	20	41	96	2	0.5~2.5	10~32	T14	M3×8	T08
TSC2530-5221-2	30	25	52	113	2	1~3.5	7~24	T21	M4×10	T15
TSC3240-7030-2	40	32	70	135	2	1.5~5.0	6~20	T30	M5×11	T20
TSC4050-7840-2	50	40	78	153	2	1.5~6.0	4~16	T40	M5×12	T20

螺纹铣刀杆 Threading Milling Toolholders



订货号 Order NO.	尺寸 Dimensions (mm)			齿数 Teeth	螺距 Pitch		刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	d	D	H	Zt	mm	TPI			
TSED6322-21-6	63	22	50	6	1~3.5	7~24	T21	M4×10	T15
TSED6322-30-5	63	22	50	5	1.5~5.0	6~20	T30	M5×11	T20
TSED8027-30-6	80	27	55	6	1.5~5.0	6~20	T30	M5×11	T20
TSED10032-30-7	100	32	60	7	1.5~5.0	6~20	T30	M5×11	T20
TSED8027-40-5	80	27	65	5	1.5~6.0	4~16	T40	M5×12	T20
TSED10032-40-6	100	32	70	6	1.5~6.0	4~16	T40	M5×12	T20

螺纹铣刀杆 Threading Milling Toolholders



订货号 Order NO.	尺寸 Dimensions (mm)				齿数 Teeth	螺距 Pitch		刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	d	D	H	L	Zt	mm	TPI			
TCE209.5-1412-1	9.5	20	14	85	1	0.5~1.5	16~32	T12	M2.5×7	T08
TCE209.9-1612-1	9.9	20	16	85	1	0.5~1.5	16~32	T12	M2.5×7	T08
TCE2012-2014-1	12	20	20	85	1	0.5~2.5	10~32	T14	M3×8	T08
TCE2014.5-2514-1	14.5	20	25	85	1	0.5~2.5	10~32	T14	M3×8	T08
TCC2017-3014-1	17	20	30	85	1	0.5~2.5	10~32	T14	M3×8	T08
TCC2018-3021-1	18	20	30	85	1	1~3.5	7~24	T21	M4×10	T15
TCC2021-4021-1	21	20	40	94	1	1~3.5	7~24	T21	M4×10	T15
TCC2025-3021-1	25	20	30	125	1	1~3.5	7~24	T21	M4×10	T15
TCC2529-5030-1	29	25	50	110	1	1.5~5.0	6~20	T30	M5×11	T20
TCC2531-5030-1	31	25	50	150	1	1.5~5.0	6~20	T30	M5×11	T20
TCC3238-5038-1	38	32	50	150	1	1.5~5.0	6~20	T30	M5×11	T20
TCC4045-7840-1	45	40	78	210	1	1.5~6.0	4~16	T40	M5×12	T20
TCC4048-7840-1	48	40	78	153	1	1.5~6.0	4~16	T40	M5×12	T20

成都戴梦迪超硬工具有限责任公司
CHENGDU DIAMOND TOOLS CO., LTD.

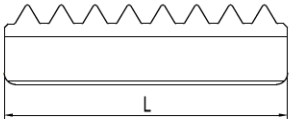
S 系列螺纹铣刀

S Series Threading Milling Tools

S系列螺纹铣刀片型号

S Series Threading Milling Inserts - Code Keys

S	25	I	2.00	ISO	-	DLT9
1	2	3	4	5		6



1、产品系列	2、刀片尺寸	3、加工类型	4、螺 距
Product Series	Insert size	Type of Insert	Pitch
S - S系列 S - S Series	L = 24mm L = 25mm L = 40mm L = 41mm	E — 外螺纹 External I — 内螺纹 Internal EI - 内外通用螺纹 External + Internal	0.5 - 6.0 mm 32 - 4 TPI

5、螺纹标准	
Standard	
ISO — ISO 标准型螺纹	ISO Metric
UN — 60° 美制统一螺纹	American UN
W — 55° 英国惠氏螺纹	Whitworth for BSW BSP
NPT — 60° 美制管螺纹	NPT
NPTF - 60° 美制干密封螺纹	NPTF
BSPT - 55° 英制管螺纹	British Standard Pipe Thread (BSPT)

6、涂层种类
Coating type
DT3–适用于碳钢，通用材料 First choice for carbon steel and ordinary steel process DLT9–适用于不锈钢及难加工材料 Excellent for stainless steel and difficult operations

S系列直柄螺纹铣刀杆型号说明

S Series Threading Milling Toolholders - Code Keys

S	S	C	25	30	-	52	21	-	2
1	2	3	4	5		6	7		8

1、产品系列	2、刀杆类型	3、冷却形式	4、刀柄直径	5、切削刃直径
Product Series	Holder Type	Cooling Form	Shank Dia.[mm]	Cutting Dia.[mm]
S - S系列 S - S Series	S - 标准型 - Standard holder C - 锥度型 - Conical holder	C - 内冷却 - Cooling	20 25 32	13.6- 36

6、刀柄悬长	7、刀片尺寸	8、槽 数
Tool Overhang[mm]	Insert size	Flutes
26 - 80	24 25 40 41	1 - 5

S系列套式螺纹铣刀杆型号说明

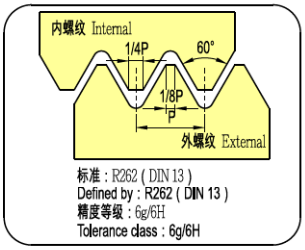
S Series Threading Shell Mill Toolholders - Code Keys

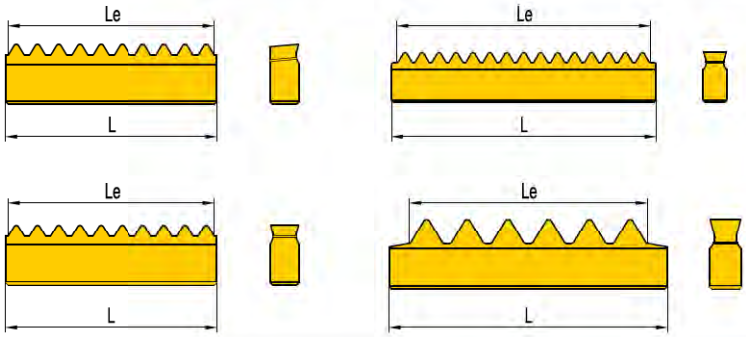
S	S	C	D80	27	-	30	-	6
1	2	3	4	5		6		7

1、产品系列	2、刀杆类型	3、冷却形式	4、切削刃直径	5、内孔直径
Product Series	Holder Type	Cooling Form	Cutting Dia.[mm]	Drive Hole Dia.[mm]
S - S系列 S - S Series	S - 标准型 - Standard holder C - 锥度型 - Conical holder	C - 内冷却 - Cooling	36 - 58	16 22 27

6、刀片尺寸	7、槽 数
Insert size	Flutes
25 40 41	5 - 8

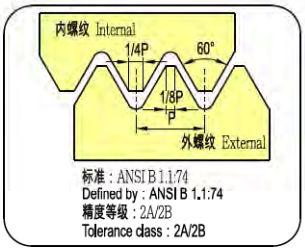
ISO标准螺纹铣刀片 ISO Metric Full Profile

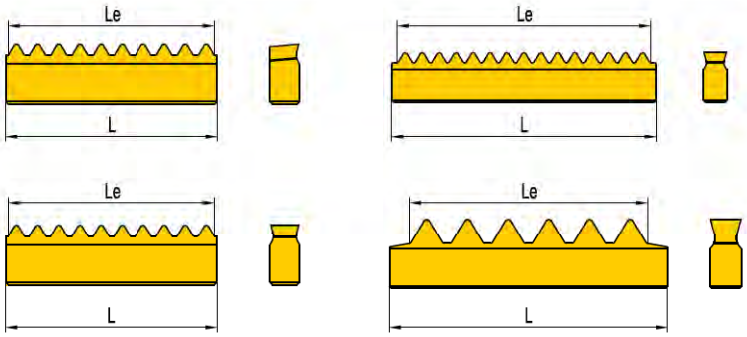




	刀片尺寸 L(mm)	螺距	订货号 Order No.		刃数	Le	齿数	刀杆
	Insert Size L(mm)	Pitch	外螺纹 External	内螺纹 Internal	Cutting Edge	mm	Teeth Zt	Tool holder
	24	0.5		S24I0.50 ISO	1	24.50	49	SSC....24
		0.75		S24I0.75 ISO	1	24.75	33	
		1		S24I1.00 ISO	1	24.00	24	
		1.25		S24I1.25 ISO	1	25.00	20	
		1.5		S24I1.50 ISO	1	24.00	16	
		1.75		S24I1.75 ISO	1	24.50	14	
		2		S24I2.00 ISO	1	24.00	12	
		2.5		S24I2.50 ISO	1	25.00	10	
	25	1	S25E1.00 ISO	S25I1.00 ISO	2	24.00	24	SSC....25
		1.5	S25E1.50 ISO	S25I1.50 ISO	2	24.00	16	
		2	S25E2.00 ISO	S25I2.00 ISO	2	24.00	12	
		2.5	S25E2.50 ISO	S25I2.50 ISO	2	25.00	10	
		3	S25E3.00 ISO	S25I3.00 ISO	2	24.00	8	
	40	1		S40I1.00 ISO	2	39.00	39	SSC....40
		1.5		S40I1.50 ISO	2	39.00	26	
		2		S40I2.00 ISO	2	38.00	19	
		2.5		S40I2.50 ISO	2	37.50	15	
		3		S40I3.00 ISO	2	39.00	13	
	41	3	S41E3.00 ISO	S41I3.00 ISO	2	39.00	13	SSC....41
		3.5	S41E3.50 ISO	S41I3.50 ISO	2	38.50	11	
		4	S41E4.00 ISO	S41I4.00 ISO	2	40.00	10	
		4.5	S41E4.50 ISO	S41I4.50 ISO	2	40.50	9	
		5	S41E5.00 ISO	S41I5.00 ISO	2	40.00	8	
		5.5	S41E5.50 ISO	S41I5.50 ISO	2	38.50	7	
		6	S41E6.00 ISO	S41I6.00 ISO	2	36.00	6	

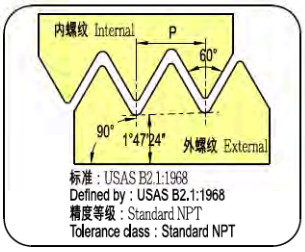
UN-60°美制统一螺纹铣刀片 UN-60° American UN Full Profile

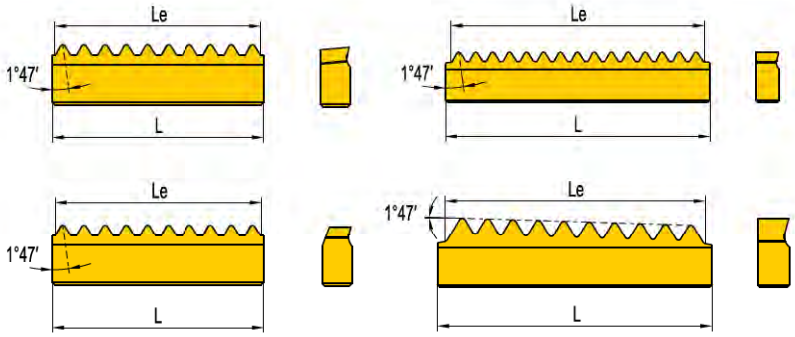




	刀片尺寸 L(mm)	螺距	订货号 Order No.		刃 数	Le	齿 数	刀 杆
	Insert Size L(mm)	Pitch	外螺纹 External	内螺纹 Internal	Cutting Edge	mm	Teeth Zt	Tool holder
	24	32		S24I32 UN	1	24.61	31	SSC....24
		28		S24I28 UN	1	24.49	27	
		24		S24I24 UN	1	24.34	23	
		20		S24I20 UN	1	24.13	19	
		18		S24I18 UN	1	23.99	17	
		16		S24I16 UN	1	23.81	15	
		14		S24I14 UN	1	23.59	13	
		12		S24I12 UN	1	23.28	11	
		10		S24I10 UN	1	22.86	9	
	25	20	S25E20 UN	S25I20 UN	2	24.13	19	SSC....25
		18	S25E18 UN	S25I18 UN	2	23.99	17	
		16	S25E16 UN	S25I16 UN	2	23.81	15	
		14	S25E14 UN	S25I14 UN	2	23.58	13	
		12	S25E12 UN	S25I12 UN	2	23.28	11	
		10	S25E10 UN	S25I10 UN	2	22.86	9	
		9	S25E9 UN	S25I9 UN	2	22.58	8	
		8	S25E8 UN	S25I8 UN	2	22.22	7	
	40	20		S40I20 UN	2	39.37	31	SSC....40
		18		S40I18 UN	2	39.51	28	
		16		S40I16 UN	2	39.69	25	
		14		S40I14 UN	2	39.91	22	
		12		S40I12 UN	2	38.10	18	
		10		S40I10 UN	2	38.10	15	
		9		S40I9 UN	2	39.51	14	
		8		S40I8 UN	2	38.10	12	
	41	8	S41E8 UN	S41I8 UN	2	38.10	12	SSC....41
		7	S41E7 UN	S41I7 UN	2	39.91	11	
		6	S41E6 UN	S41I6 UN	2	38.10	9	
		5	S41E5 UN	S41I5 UN	2	35.56	7	
		4.5	S41E4.5 UN	S41I4.5 UN	2	39.51	7	
		4	S41E4 UN	S41I4 UN	2	38.10	6	

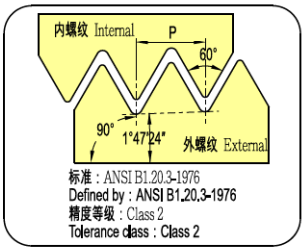
NPT-60°美国标准锥管螺纹铣刀片 NPT-60° American National Pipe Threads

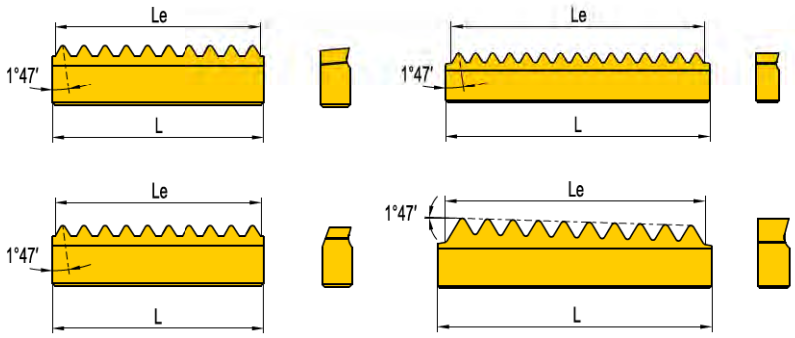




	刀片尺寸 L(mm) Insert Size L(mm)	螺距 Pitch	订货号 Order No. 内外螺纹通用 External+Internal	刃数 Cutting Edge	Le mm	齿数 Teeth Zt	刀杆 Tool holder
	24	18	S24EI18 NPT	1	23.99	17	SCC....24
	25	14	S25EI14 NPT	1	23.58	13	SCC....25
		11.5	S25EI11.5 NPT	1	24.30	11	
		8	S25EI8 NPT	1	22.22	7	SCC D3616-25-5
	40	11.5	S40EI11.5 NPT	1	37.55	17	SCC D4522-40-6
		8	S40EI8 NPT	1	38.10	12	
	41	8	S41EI8 NPT	1	38.10	12	SCC....41

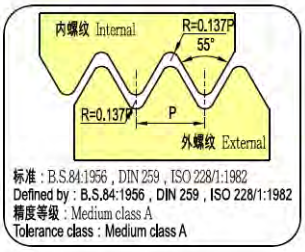
NPTF美制干密封锥管螺纹铣刀片 American NPTF

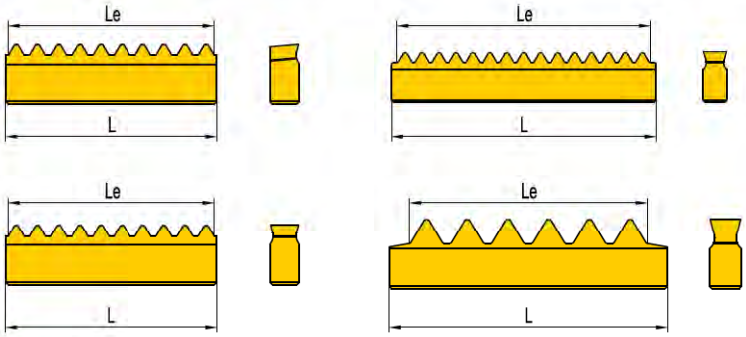




	刀片尺寸 L(mm) Insert Size L(mm)	螺距 Pitch	订货号 Order No. 内外螺纹通用 External+Internal	刃数 Cutting Edge	Le mm	齿数 Teeth Zt	刀杆 Tool holder
	24	18	S24EI18 NPTF	1	23.99	17	SCC....24
	25	14	S25EI14 NPTF	1	23.58	13	SCC....25
		11.5	S25EI11.5 NPTF	1	24.30	11	
		8	S25EI8 NPTF	1	22.22	7	SCC D3616-25-5
	40	11.5	S40EI11.5 NPTF	1	37.55	17	SCC D4522-40-6
		8	S40EI8 NPTF	1	38.10	12	
	41	8	S41EI8 NPTF	1	38.10	12	SCC....41

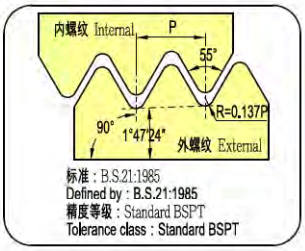
W-55°英国惠氏螺纹铣刀片 W-55° Whitworth Full Profile

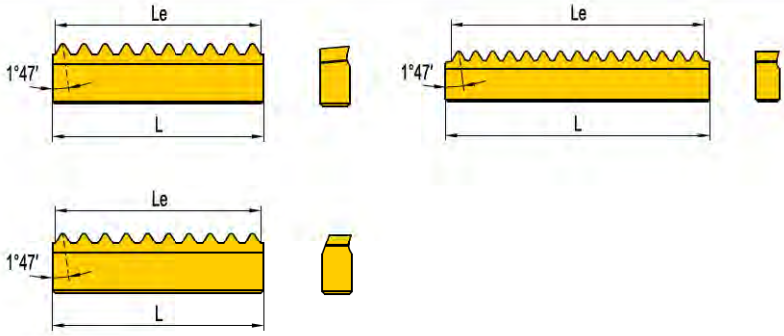




	刀片尺寸 L(mm) Insert Size L(mm)	螺距 Pitch	订货号 Order No. 内外螺纹通用 External+Internal	订货号 Order No. 内螺纹 Internal	刃数 Cutting Edge	Le mm	齿数 Teeth Zt	刀杆 Tool holder
	24	19	S24EI19 W		1	24.06	18	SSC....24
		14	S24EI14 W		1	23.59	13	
		12	S24EI12 W		1	23.28	11	
	25	16	S25EI16 W		2	23.81	15	SSC....25
		14	S25EI14 W		2	23.58	13	
		12	S25EI12 W		2	22.28	11	
		11	S25EI11 W		2	23.09	10	
	40	16	S40EI16 W		2	39.69	25	SSC....40
		14	S40EI14 W		2	39.91	22	
		12	S40EI12 W		2	38.10	18	
		11	S40EI11 W		2	39.25	17	
	41	8		S41I8 W	2	38.10	12	SSC....41
		7		S41I7 W	2	39.91	11	
		6		S41I6 W	2	38.10	9	

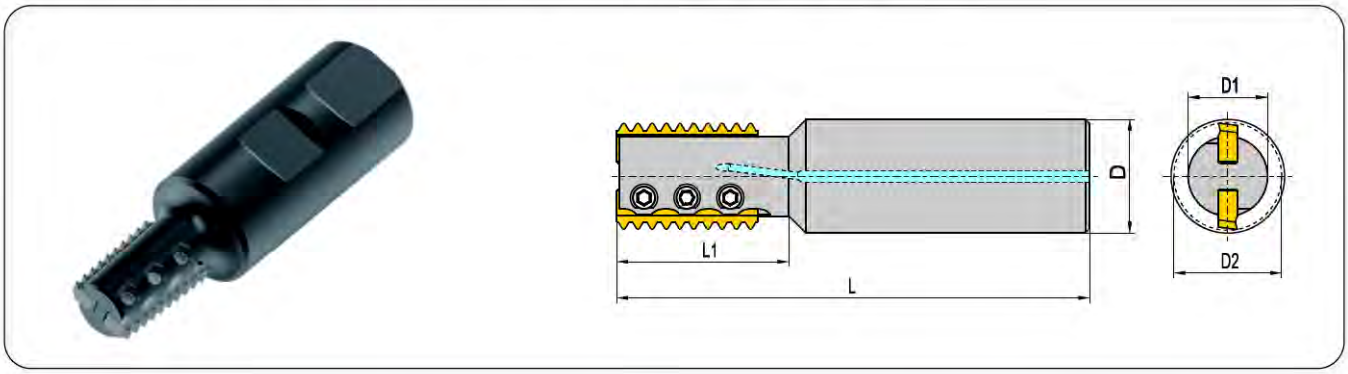
BSPT-55°英国标准锥管螺纹铣刀片 BSPT-55° British Standard Pipe Full Profile





	刀片尺寸 L(mm) Insert Size L(mm)	螺距 Pitch	订货号 Order No. 内外螺纹通用 External+Internal	刃数 Cutting Edge	Le mm	齿数 Teeth Zt	刀杆 Tool holder
	24	19	S24EI19 BSPT	1	24.06	18	SCC 2014-2624-1
	25	14	S25EI14 BSPT	1	23.58	13	SCC....25
		11	S25EI11 BSPT	1	23.09	10	
	40	11	S40EI11 BSPT	1	39.25	17	SCC D4522-40-6

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

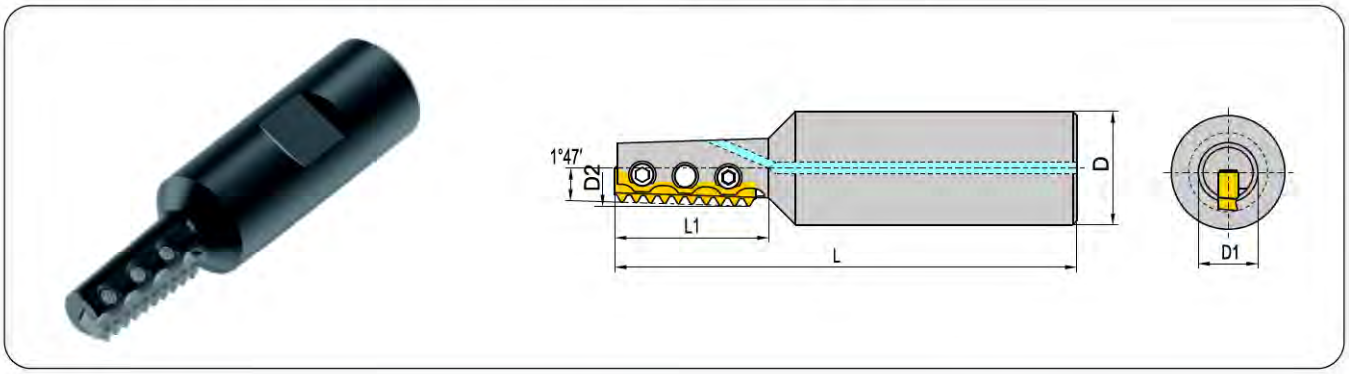


刀片尺寸 mm	订货号	尺寸 Dimensions(mm)					槽 数	配件 Spare Parts		
								定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
Insert Size mm	Order No.	L	L1	D	D1	D2	No.of Flutes Z			
24	SSC 2013-2624-1	82	26	20	10.7	13.6	1	DW M4×0.7	YJ M4×0.7	BS T08
	SSC 2015-3024-1	85	30	20	11.9	15.1	1			
	SSC 2016-2824-2	83	28	20	12.6	16	2			
	SSC 2016-3624-1	91	36	20	12.6	16	1			

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

最小螺纹直径 Min.Thread φ							
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
SSC 2013-2624-1	13.6	M16×2	M14.5×0.5；M15×0.75；M15×1；M15×1.25；M16×1.5；M16×1.75；	—	11/16-12UN;5/8-14UNS;5/8-16UN;5/8-18UNF;5/8-20UN;5/8-24UNEF;5/8-28UN;5/8-32UN	11/16-14 3/4-12	3/8-19
SSC 2015-3024-1	15.1	M18×2.5	M16×0.5；M17×0.75；M17×1；M17×1.25；M17×1.5；M18×1.75；M18×2	3/4-10	3/4-12UN;3/4-14UNS;11/16-16UN;11/16-20UN;11/16-24UNEF;11/16-28UN;11/16-32UN	3/4-12	—
SSC 2016-2824-2	16	M20×2.5	M17×0.5；M17×0.75；M18×1；M18×1.25；M18×1.5；M18×1.75；M19×2；	3/4-10	3/4-12UN;3/4-14UNS;3/4-16UN;3/4-18UNS;3/4-20UNEF;11/16-24UNEF;11/16-28UN;11/16-32UN	3/4-12	—
SSC 2016-3624-1	16	M20×2.5	M17×0.5；M17×0.75；M18×1；M18×1.25;M18×1.5；M18×1.75；M19×2；	3/4-10	3/4-12UN;3/4-14UNS;3/4-16UN;3/4-18UNS;3/4-20UNEF;11/16-24UNEF;11/16-28UN;11/16-32UN	3/4-12	—

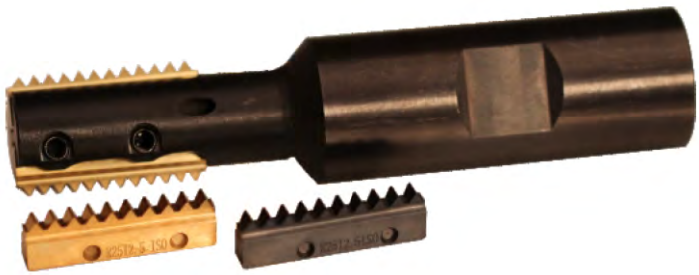
适用于刀片尺寸24mm的锥度刀杆 Conical Toolholders For Insert Size 24mm



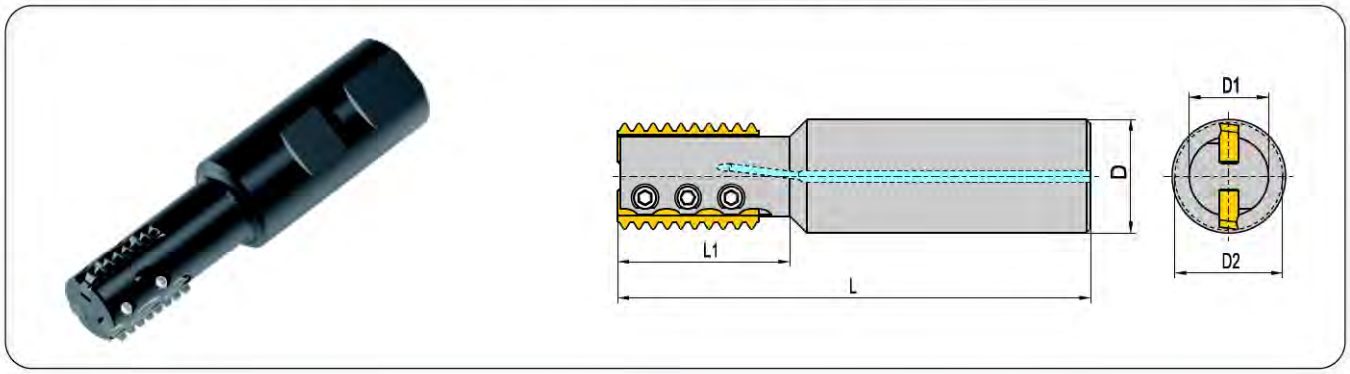
刀片尺寸 mm	订货号	尺寸 Dimensions(mm)					槽 数	配件 Spare Parts		
								定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
Insert Size mm	Order No.	L	L1	D	D1	D2	No.of Flutes Z			
24	SCC 2014-2624-1	81	26	20	11.5	13.9	1	DW M4×0.7	YJ M4×0.7	BS T08

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

最小螺纹直径 Min.Thread φ				
刀杆 Tool holder	D2 (mm)	NPT	NPTF	BSPT
SCC 2014-2624-1	13.9	3/8-18	3/8-18	3/8-19



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

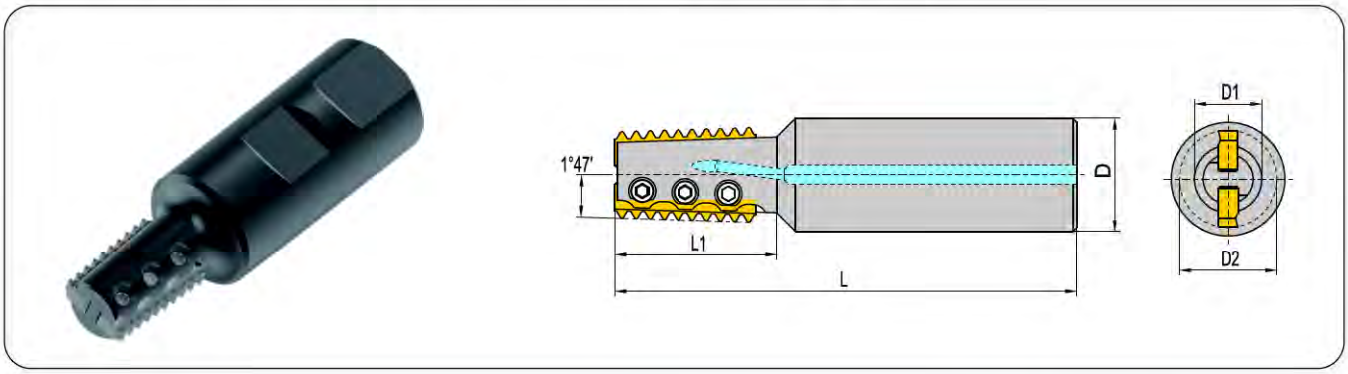


刀片尺寸 mm	订货号	尺寸 Dimensions(mm)					槽 数	配件 Spare Parts		
								定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
Insert Size mm	Order No.	L	L1	D	D1	D2	No.of Flutes Z			
25	SSC 2517-2625-2	85	26	25	14	17	2	DW M4×0.7	YJ M4×0.7	BS T08
	SSC 2517-3625-2	95	36	25	14	17	2			
	SSC 2519-3225-2	92	32	25	15	19	2			
	SSC 2519-4425-2	104	44	25	15	19	2			
	SSC 2520-3725-3	96	37	25	16.5	20.5	3			
	SSC 2520-4425-3	103	44	25	16.5	20.5	3			
	SSC 2522-4325-3	102	43	25	18	22	3			
	SSC 2522-5525-3	114	55	25	18	22	3			
	SSC 2530-5525-5	115	55	25	26	30	5			
	SSC 2530-8025-4	140	80	25	26	30	4			

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

最小螺纹直径 Min.Thread φ							
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
SSC 2517-2625-2 SSC 2517-3625-2	17	M20×2.5	M19×1;M19×1.5;M20×2	——	7/8-10UNS;13/16-12UN;7/8-14UNF;3/4-16UNF; 3/4-18UNS;3/4-20UNEF	7/8-11;7/8-12; 7/8-14;7/8-16	1/2-14
SSC 2519-3225-2 SSC 2519-4425-2	19	M22×2.5； M24×3	M21×1;M21×1.5;M22×2	7/8-9； 1-8	7/8-20UNEF;7/8-18UNS;7/8-16UN;7/8-14UNF; 7/8-12UN;7/8-10UNS	7/8-16;7/8-14; 15/16-12;15/16-11	5/8-14
SSC 2520-3725-3 SSC 2520-4425-3	20.5	M24×3	M22×1;M23×1.5;M23×2;M23.5×2.5	1 - 8	15/16-9UN;1-10UNS;15/16-12UN;1-14UNS; 15/16-16UN;7/8-18UNS;7/8-20UNEF	1-11;1-12;1-14;1-16	5/8-14
SSC 2522-4325-3 SSC 2522-5525-3	22	M27×3	M24×1;M24×1.5;M25×2;M25×2.5	——	1 11/16-8UN;1-9UN;1-10UNS;1-12UNF;1-14UNS; 1-16UN;1-18UN;15/16-20UNEF	1-11;1-12;1-14;1-16	3/4-14
SSC 2530-5525-5 SSC 2530-8025-4	30	——	M32×1;M32×1.5;M33×2;M33×2.5; M34×3	——	1 3/8-8UN;1 3/8-9UN;1 3/8-10UN;1 5/16-12UN; 1 3/8-14UNS;1 5/16-16UN;1 5/16-18UNEF; 1 5/16-20UN	1 3/8-11;1 3/8-12; 1 3/8-14;1 3/8-16	1-11

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

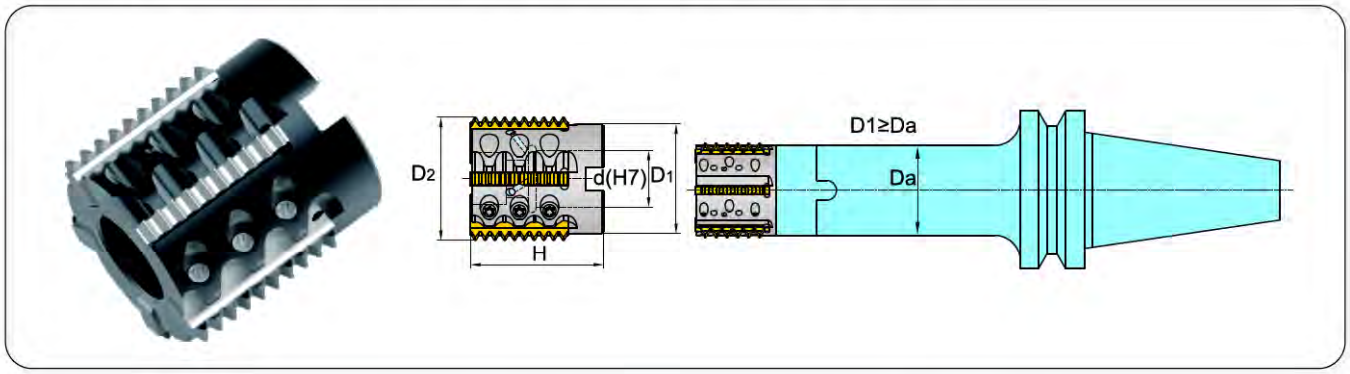


刀片尺寸 mm	订货号	尺寸 Dimensions(mm)					槽 数	配件 Spare Parts		
								定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
Insert Size mm	Order No.	L	L1	D	D1	D2	No.of Flutes Z			
25	SCC 2517-2625-2	85	26	25	14	17	2	DW M4×0.7	YJ M4×0.7	BS T08
	SCC 2522-4325-3	102	43	25	18	22	3			
	SCC 2528-4325-4	103	43	25	26	28	4			

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

最小螺纹直径 Min.Thread φ				
刀杆 Tool holder	D2 (mm)	NPT	NPTF	BSPT
SCC 2517-2625-2	17	1/2-14;3/4-14;1-11.5;1 1/4-11.5; 1 1/2-11.5;2-11.5	1/2-14;3/4-14;1-11.5;1 1/4-11.5; 1 1/2-11.5;2-11.5	1/2-14;3/4-14
SCC 2522-4325-3	22	3/4-14;1-11.5;1 1/4-11.5;1 1/2-11.5;2-11.5	3/4-14;1-11.5;1 1/4-11.5;1 1/2-11.5;2-11.5	3/4-14;1-11;1 1/4-11;1 1/2-11;2-11;2 1/2-11; 3-11;4-11;5-11;6-11
SCC 2528-4325-4	28	1-11.5;1 1/4-11.5;1 1/2-11.5;2-11.5	1-11.5;1 1/4-11.5;1 1/2-11.5;2-11.5	1-11;1 1/4-11;1 1/2-11;2-11;2 1/2-11;3-11; 4-11;5-11;6-11

适用于刀片尺寸25mm的套式螺纹铣刀杆 Shell Mills For Insert Size 25mm



刀片尺寸 mm	订货号	尺寸 Dimensions(mm)				槽 数	配件 Spare Parts			
							定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver	内六角螺钉 Holder Screw
Insert Size mm	Order No.	D1	D2	d(H7)	H	No.of Flutes Z				
25	SSC D3616-25-5	32	36	16	33.5	5	DW M4×0.7	YJ M4×0.7	BS T08	M8×1.25×30
	SSC D4422-25-6	40	44	22	38	6				M10×1.5×40
	SSC D5227-25-8	48	52	27	40	8				M12×1.75×40
	SCC D3616-25-5	32	36	16	33.5	5				M8×1.25×30

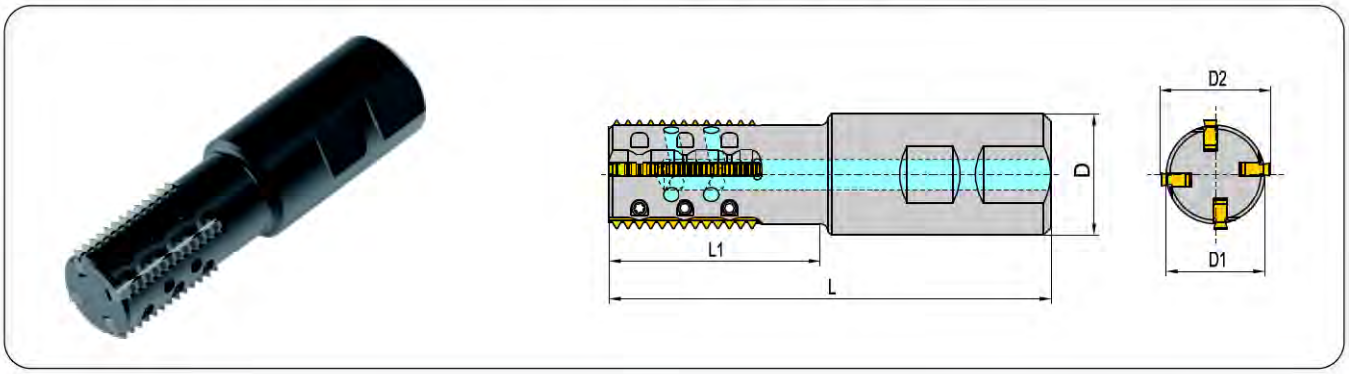
刀杆所适用的标准螺纹 Standard Thread Application By Toolholder

最小螺纹直径 Min.Thread φ						
刀杆 Tool holder		D2 (mm)	ISO 细牙 ISO Fine	UN/UNF/UNEF/UNS	BSW	BSP(G)
标准 Standard	SSC D3616-25-5	36	M38×1;M39×1.5;M39×2;M40×3	1 9/16-12UN;1 5/8-14UNS;1 9/16-UN; 1 1/2-18UNEF;1 1/2-20UN	1 3/4-16;1 3/4-12	1 1/4-11
	SSC D4422-25-6	44	M48×1;M48×1.5;M48×2;M48×3	1 7/8-12UN;1 13/16-16UN;1 13/16-20UN; 1 15/16-8UN;1 7/8-10UNS;1 7/8-14UNS	2-16;2-12	1 1/2-11
	SSC D5227-25-8	52	M55×1;M55×1.5;M55×2;M56×3	2 1/4-8UN;2 1/4-10UN;2 1/4-12UN;2 1/4-14UN; 2 1/4-16UN;2 1/4-18UN;2 1/4-20UN	2 1/4-16;2 1/4-12	2-11

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

最小螺纹直径 Min.Thread φ					
刀杆 Tool holder		D2 (mm)	NPT	NPTF	BSPT
锥度 Conical	SCC D3616-25-5	36	1 1/4-11.5；1 1/2-11.5；2-11.5;2 1/2-8	1 1/4-11.5；1 1/2-11.5；2-11.5;2 1/2-8	1 1/2-6×11

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

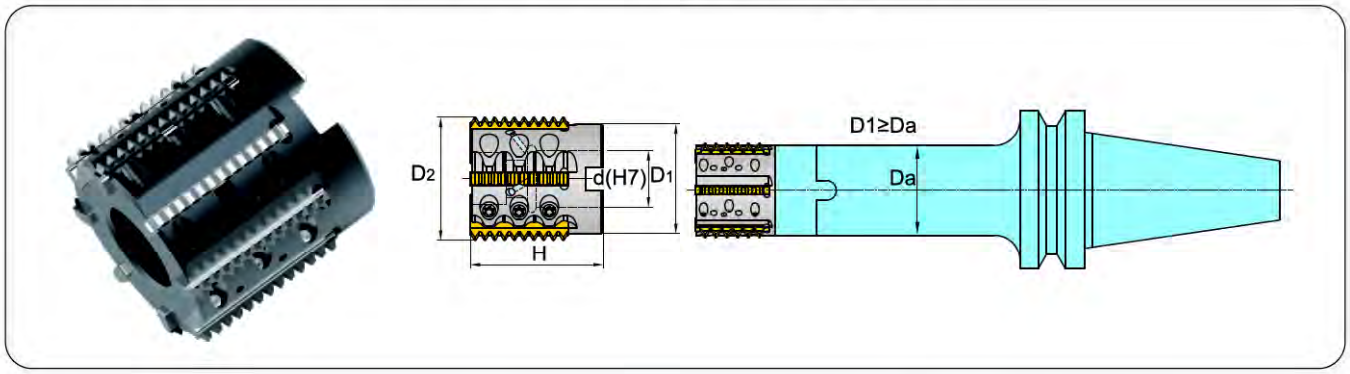


刀片尺寸 mm	订货号	尺寸 Dimensions(mm)					槽 数	配件 Spare Parts		
								定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
Insert Size mm	Order No.	L	L1	D	D1	D2	No.of Flutes Z			
40	SSC 2522-4340-3	102	43	25	18	22	3	DW M4×0.7	YJ M4×0.7	BS T08
	SSC 2522-6540-3	124	65	25	18	22	3			
	SSC 3230-5540-4	117	55	32	26	30	4			
	SSC 3230-8040-3	142	80	32	26	30	3			

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

最小螺纹直径 Min.Thread φ							
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
SSC 2522-4340-3	22	M27×3	M24×1;M24×1.5;M25×2;M25×2.5	——	1 11/16-8UN;1-9UN;1-10UNS;1-12UNF;1-14UNS; 1-16UN;1-18UN;15/16-20UNEF	1-11;1-12;1-14;1-16	3/4-14
SSC 2522-6540-3	22	M27×3	M24×1;M24×1.5;M25×2;M25×2.5	——	1 11/16-8UN;1-9UN;1-10UNS;1-12UNF;1-14UNS; 1-16UN;1-18UN;15/16-20UNEF	1-11;1-12;1-14;1-16	3/4-14
SSC 3230-5540-4	30	——	M32×1;M32×1.5;M33×2; M33×2.5;M34×3	——	1 3/8-8UN;1 3/8-9UN;1 3/8-10UN;1 5/16-12UN; 1 3/8-14UNS;1 5/16-16UN;1 5/16-18UNEF;1 5/16-20UN	1 3/8-11;1 3/8-12; 1 3/8-14;1 3/8-16	1-11
SSC 3230-8040-3	30	——	M32×1;M32×1.5;M33×2; M33×2.5;M34×3	——	1 3/8-8UN;1 3/8-9UN;1 3/8-10UN;1 5/16-12UN; 1 3/8-14UNS;1 5/16-16UN;1 5/16-18UNEF;1 5/16-20UN	1 3/8-11;1 3/8-12; 1 3/8-14;1 3/8-16	1-11

适用于刀片尺寸40mm的套式螺纹铣刀杆 Shell Mills For Insert Size 40mm



刀片尺寸 mm	订货号	尺寸 Dimensions(mm)				槽 数	配件 Spare Parts			
							定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver	内六角螺钉 Holder Screw
Insert Size mm	Order No.	D1	D2	d(H7)	H	No.of Flutes Z				
40	SSC D4422-40-6	40	44	22	48	6	DW M4×0.7	YJ M4×0.7	BS T08	M10×1.5×40
	SSC D5227-40-8	48	52	27	50	8				M12×1.75×40
	SCC D4522-40-6	40	45	22	48	6				M10×1.5×40

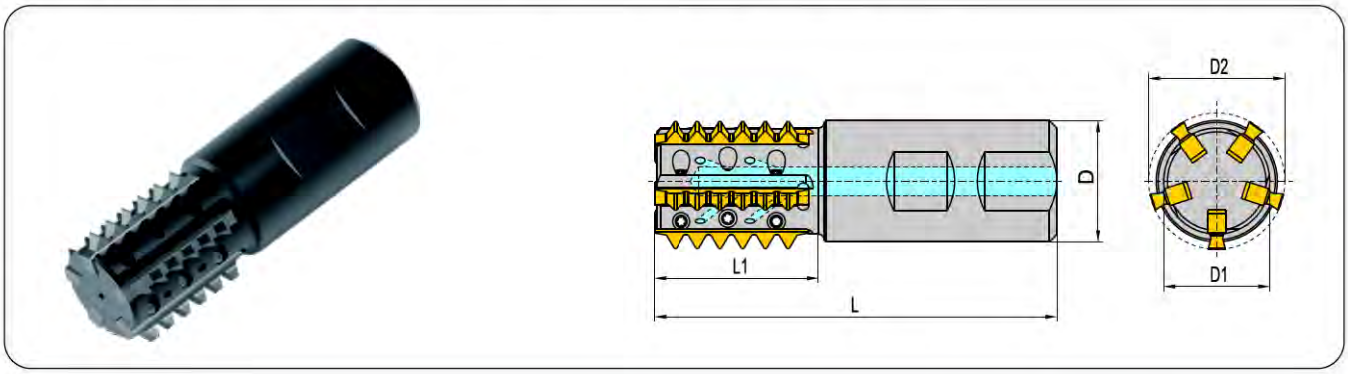
刀杆所适用的标准螺纹 Standard Thread Application By Toolholder

最小螺纹直径 Min.Thread φ						
刀杆 Tool holder		D2 (mm)	ISO 细牙 ISO Fine	UN/UNF/UNEF/UNS	BSW	BSP(G)
标准 Standard	SSC D4422-40-6	44	M48×1;M48×1.5;M48×2;M48×3	1 7/8-12UN;1 13/16-16UN;1 13/16-20UN; 1 15/16-8UN;1 7/8-10UNS;1 7/8-14UNS	2-16;2-12	1 1/2-11
	SSC D5227-40-8	52	M55×1;M55×1.5;M55×2;M56×3	2 1/4-8UN;2 1/4-10UN;2 1/4-12UN;2 1/4-14UN; 2 1/4-16UN;2 1/4-18UN;2 1/4-20UN	2 1/4-16;2 1/4-12	2-11

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

最小螺纹直径 Min.Thread φ					
刀杆 Tool holder		D2 (mm)	NPT	NPTF	BSPT
锥度Conical	SCC D4522-40-6	45	2-11.5;2 1/2-8	2-11.5;2 1/2-8;3-8	2-6×11

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

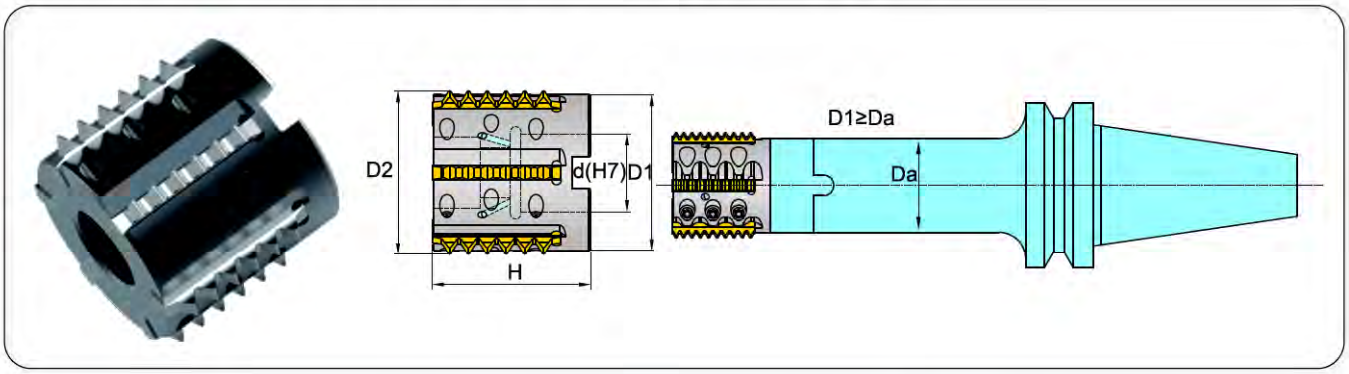


刀片尺寸 mm	订货号	尺寸 Dimensions(mm)					槽 数	配件 Spare Parts		
								定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver
Insert Size mm	Order No.	L	L1	D	D1	D2	No.of Flutes Z			
41	SSC 2524-4341-2	104	43	25	19.2	24.5	2	DW M4×0.7	YJ M4×0.7	BS T08
	SSC 3230-4341-3	106.5	43	32	24.2	30	3			
	SSC 3230-6541-3	128.5	65	32	24.2	30	3			
	SSC 3236-4341-5	106	43	32	28.3	36	5			
	SSC 3236-6541-4	128	65	32	28.3	36	4			

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

最小螺纹直径 Min.Thread φ								
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSW/BSF	NPT	NPTF
SSC 2524-4341-2	24.5	M30×3.5;M36×4	M28×3;M45×4	1 1/8-7;1 3/8-6	1 1/8-8UN;1 7/16-6UN	1 3/8-8BSF;1 1/4-7BSW	—	—
SSC 3230-4341-3	30	M36×4;M42×4.5	M34×3;M34×3.5; M45×4	1 3/8-6	1 3/8-8UN;1 7/16-6UN	1 3/8-8BSF;1 3/4-7BSF; 1 1/2-6BSW	—	—
SSC 3230-6541-3	30	M36×4;M42×4.5	M34×3;M34×3.5; M45×4	1 3/8-6	1 3/8-8UN;1 7/16-6UN	1 3/8-8BSF;1 3/4-7BSF; 1 1/2-6BSW	—	—
SSC 3236-4341-5	36	M42×4.5;M48×5; M56×5.5;M64×6	M40×3;M40×3.5; M42×4;M70×6	1 3/4-5;2-4.5;2 1/2-4	1 5/8-8UN;1 5/8-6UN	1 5/8-8BSF;1 3/4-7BSF; 1 7/8-6BSF	2 1/2-8	2 1/2-8
SSC 3236-6541-4	36	M42×4.5;M48×5; M56×5.5;M64×6	M40×3;M40×3.5; M42×4;M70×6	1 3/4-5;2-4.5;2 1/2-4	1 5/8-8UN;1 5/8-6UN	1 5/8-8BSF;1 3/4-7BSF; 1 7/8-6BSF	2 1/2-8	2 1/2-8

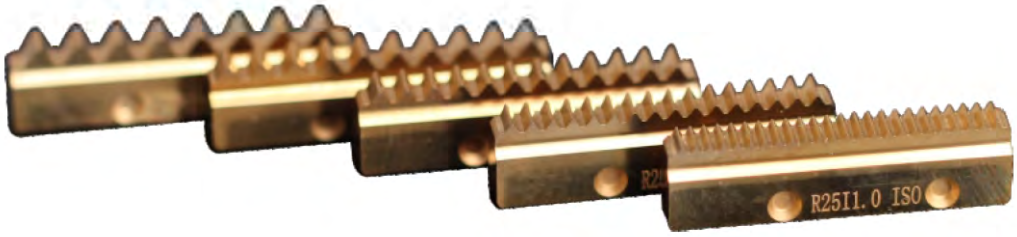
适用于刀片尺寸41mm的套式螺纹铣刀杆 Shell Mills For Insert Size 41mm



刀片尺寸 mm	订货号	尺寸 Dimensions(mm)				槽 数	配件 Spare Parts			
							定位螺钉×1 Location Screw×1	压紧螺钉×2 Clamping Screw×2	扳手 Torx+Screwdriver	内六角螺钉 Holder Screw
Insert Size mm	Order No.	D1	D2	d(H7)	H	No.of Flutes Z				
41	SSC D4822-41-5	40	48	22	50	5	DW M4×0.7	YJ M4×0.7	BS T08	M10×1.5×40
	SSC D5827-41-6	50	58	27	50	6				M12×1.75×40

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

最小螺纹直径 Min.Thread φ								
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSF	NPT	NPTF
SSC D4822-41-5	48	M56×5.5;M64×6	M55×4;M70×6	2 1/4-4.5;2 1/2-4	2 1/8-8UN;2 1/8-6UN	2 1/4-8;2 1/4-6	2 1/2-8	2 1/2-8
SSC D5827-41-6	58	M68×6	M64×4;M70×6	2 3/4-4	2 1/2-8UN;2 1/2-6UN	2 1/2-8;2 3/4-6	2 1/2-8	2 1/2-8



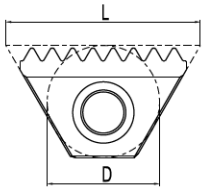
成都戴梦迪超硬工具有限责任公司
CHENGDU DIAMOND TOOLS CO., LTD.

K 系列螺纹铣刀

K Series Threading Milling Tools

K系列螺纹铣刀片型号说明

K Series Threading Milling Inserts - Code Keys



K	3	I	2.00	ISO	-	DLT9
1	2	3	4	5		6

1、产品系列 Product Series

K - K系列
K - K Series

2、刀片尺寸 Insert size

6.0 - D = 6.0mm　2 - D = 1/4"
3 - D = 3/8"　3B - D = 3/8"B
4 - D = 2/1"　5 - D = 5/8"
6B - D = 3/4"B

3、加工类型 Type of Insert

E — 外螺纹 External
I — 内螺纹 Internal
- — 对两面刃刀片，一面做外螺纹，另一面做内螺纹
One edge for internal.other edge for external
EI— 内外通用螺纹 External + Internal

4、螺 距 Pitch

0.5 - 6.0 mm
48 - 4 TPI

5、螺纹标准 Standard

ISO — ISO 标准型螺纹　ISO Metric
UN — 60° 美制统一螺纹　American UN
W — 55° 英国惠氏螺纹　Whitworth for BSW BSP
NPT — 60° 美制管螺纹　NPT
NPTF - 60° 美制干密封螺纹　NPTF
BSPT - 55° 英制管螺纹　British Standard Pipe Thread (BSPT)

6、涂层种类 Coating type

DT3–适用于碳钢，通用材料
First choice for carbon steel and ordinary steel process
DLT9–适用于不锈钢及难加工材料
Excellent for stainless steel and difficult operations

K系列直柄螺纹铣刀杆型号说明

K Series Threading Milling Toolholders - Code Keys

K	S	C	25	30	-	52	21	-	2
1	2	3	4	5		6	7		8

1、产品系列 Product Series

K - K系列
K - K Series

2、刀杆类型 Holder Type

S - 标准型
- Standard holder
C - 锥度型
- Conical holder

3、冷却形式 Cooling Form

C - 内冷却
- Cooling

4、刀柄直径 Shank Dia.[mm]

12 16 20 25 32 40

5、切削刃直径 Cutting Dia.[mm]

9 - 52

6、刀柄悬长 Tool Overhang[mm]

12 - 98

7、刀片尺寸 Insert size

D=6.0mm　D=1/4"
D=3/8"　D=3/8"B
D=2/1"　D=5/8"
D=3/4"B

8、槽 数 Flutes

1 - 2

K系列套式螺纹铣刀杆型号说明

K Series Threading Shell Mill Toolholders - Code Keys

K	S	C	D80	27	-	30	-	6
1	2	3	4	5		6		7

1、产品系列 Product Series

K - K系列
K - K Series

2、刀杆类型 Holder Type

S - 标准型
- Standard holder

3、冷却形式 Cooling Form

C - 内冷却
- Cooling

4、切削刃直径 Cutting Dia.[mm]

38 - 125

5、内孔直径 Drive Hole Dia.[mm]

16 22 27 32 40

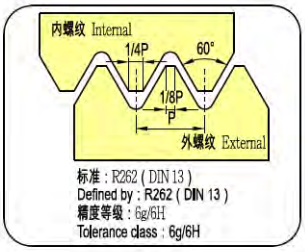
6、刀片尺寸 Insert size

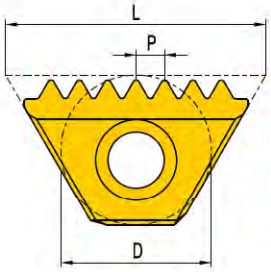
1/4"　3/8"
3/8"B　2/1"
5/8"　3/4"B

7、槽 数 Flutes

4 - 9

ISO标准螺纹铣刀片 ISO Metric Full Profile



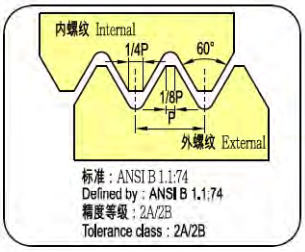


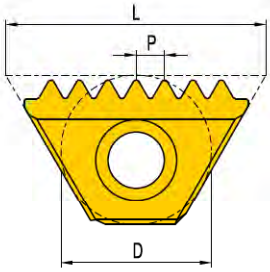
加工螺距 Pitch mm		刀片尺寸 Insert Size					
		D=6mm L=10.4mm	D=1/4″ L=11mm	D=3/8″ L=16mm	D=3/8B″ L=22mm	D=5/8″ L=27mm	D=3/4″ L=38mm
0.5	外 Ext						
	内 Int	*K6.0I0.5 ISO	K2I0.5 ISO	K3I0.5 ISO			
0.75	外 Ext		K2E0.75 ISO	K3E0.75 ISO			
	内 Int	*K6.0I0.75 ISO	K2I0.75 ISO	K3I0.75 ISO			
1	外 Ext		K2E1.0 ISO	K3E1.0 ISO	K3BE1.0 ISO	K5E1.0 ISO	
	内 Int	*K6.0I1.0 ISO	K2I1.0 ISO	K3I1.0 ISO	K3BI1.0 ISO	K5I1.0 ISO	
1.25	外 Ext		K2E1.25 ISO	K3E1.25 ISO	K3BE1.25 ISO	K5E1.25 ISO	
	内 Int	*K6.0I1.25 ISO	K2I1.25 ISO	K3I1.25 ISO	K3BI1.25 ISO	K5I1.25 ISO	
1.5	外 Ext		K2E1.5 ISO	K3E1.5 ISO	K3BE1.5 ISO	K5E1.5 ISO	K6BE1.5 ISO
	内 Int	*K6.0I1.5 ISO	K2I1.5 ISO	K3I1.5 ISO	K3BI1.5 ISO	K5I1.5 ISO	K6BI1.5 ISO
1.75	外 Ext			K3E1.75 ISO	K3BE1.75 ISO	K5E1.75 ISO	
	内 Int			K3I1.75 ISO	K3BI1.75 ISO	K5I1.75 ISO	
2	外 Ext			K3E2.0 ISO	K3BE2.0 ISO	K5E2.0 ISO	K6BE2.0 ISO
	内 Int			K3I2.0 ISO	K3BI2.0 ISO	K5I2.0 ISO	K6BI2.0 ISO
2.5	外 Ext					K5E2.5 ISO	K6BE2.5 ISO
	内 Int					K5I2.5 ISO	K6BI2.5 ISO
3	外 Ext					K5E3.0 ISO	K6BE3.0 ISO
	内 Int					K5I3.0 ISO	K6BI3.0 ISO
3.5	外 Ext					K5E3.5 ISO	
	内 Int					K5I3.5 ISO	
4	外 Ext					K5E4.0 ISO	K6BE4.0 ISO
	内 Int					K5I4.0 ISO	K6BI4.0 ISO
4.5	外 Ext					K5E4.5 ISO	K6BE4.5 ISO
	内 Int					K5I4.5 ISO	K6BI4.5 ISO
5	外 Ext						K6BE5.0 ISO
	内 Int						K6BI5.0 ISO
5.5	外 Ext						K6BE5.5 ISO
	内 Int						K6BI5.5 ISO
6	外 Ext						K6BE6.0 ISO
	内 Int						K6BI6.0 ISO

* 表示只有单面刃

* Insert with one cutting edge

UN-60°美制统一螺纹铣刀片 UN-60° American UN Full Profile



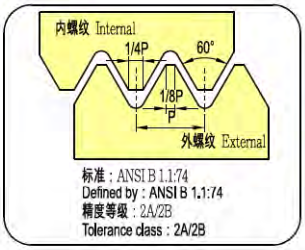


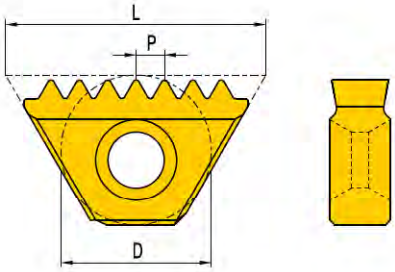
加工螺距 Pitch		刀片尺寸 Insert Size					
TPI		D=6mm L=10.4mm	D=1/4″ L=11mm	D=3/8″ L=16mm	D=3/8B″ L=22mm	D=5/8″ L=27mm	D=3/4″ L=38mm
48	外 Ext						
	内 Int		K2I48 UN				
40	外 Ext						
	内 Int		K2I40 UN	K3I40 UN			
32	外 Ext						
	内 Int	*K6.0I32 UN	K2I32 UN	K3I32 UN			
28	外 Ext		K2E28 UN	K3E28 UN			
	内 Int	*K6.0I28 UN	K2I28 UN	K3I28 UN			
27	外 Ext		K2E27 UN	K3E27 UN			
	内 Int		K2I27 UN	K3I27 UN			
26	外 Ext		K2E26 UN	K3E26 UN			
	内 Int		K2I26 UN	K3I26 UN			
24	外 Ext		K2E24 UN	K3E24 UN	K3BE24 UN	K5E24 UN	
	内 Int	*K6.0I24 UN	K2I24 UN	K3I24 UN	K3BI24 UN	K5I24 UN	
20	外 Ext		K2E20 UN	K3E20 UN	K3BE20 UN	K5E20 UN	
	内 Int	*K6.0I20 UN	K2I20 UN	K3I20 UN	K3BI20 UN	K5I20 UN	
18	外 Ext		K2E18 UN	K3E18 UN	K3BE18 UN	K5E18 UN	
	内 Int	*K6.0I18 UN	K2I18 UN	K3I18 UN	K3BI18 UN	K5I18 UN	
16	外 Ext		K2E16 UN	K3E16 UN	K3BE16 UN	K5E16 UN	
	内 Int	*K6.0I16 UN	K2I16 UN	K3I16 UN	K3BI16 UN	K5I16 UN	
14	外 Ext		K2E14 UN	K3E14 UN	K3BE14 UN	K5E14 UN	
	内 Int		K2I14 UN	K3I14 UN	K3BI14 UN	K5I14 UN	
13	外 Ext			K3E13 UN	K3BE13 UN	K5E13 UN	
	内 Int			K3I13 UN	K3BI13 UN	K5I13 UN	

* 表示只有单面刃

* Insert with one cutting edge

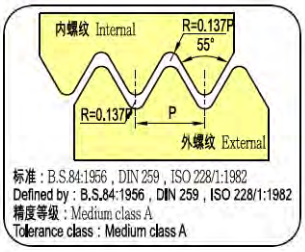
UN-60°美制统一螺纹铣刀片(续) UN-60° American UN Full Profile(Con't)

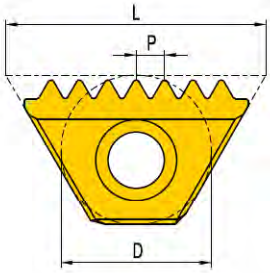




加工螺距 Pitch		刀片尺寸 Insert Size					
TPI		D=6mm L=10.4mm	D=1/4" L=11mm	D=3/8" L=16mm	D=3/8B" L=22mm	D=5/8" L=27mm	D=3/4" L=38mm
12	外 Ext			K3E12 UN	K3BE12 UN	K5E12 UN	
	内 Int			K3I12 UN	K3BI12 UN	K5I12 UN	
11.5	外 Ext			K3E11.5 UN		K5E11.5 UN	
	内 Int			K3I11.5 UN		K5I11.5 UN	
11	外 Ext					K5E11 UN	
	内 Int					K5I11 UN	
10	外 Ext					K5E10 UN	
	内 Int					K5I10 UN	
9	外 Ext					K5E9 UN	
	内 Int					K5I9 UN	
8	外 Ext					K5E8 UN	
	内 Int					K5I8 UN	
7	外 Ext					K5E7 UN	
	内 Int					K5I7 UN	
6	外 Ext					K5E6 UN	K6BE6 UN
	内 Int					K5I6 UN	K6BI6 UN
5	外 Ext						K6BE5 UN
	内 Int						K6BI5 UN
4.5	外 Ext						K6BE4.5 UN
	内 Int						K6BI4.5 UN
4	外 Ext						K6BE4 UN
	内 Int						K6BI4 UN

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



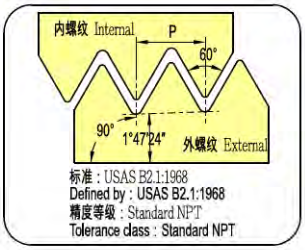


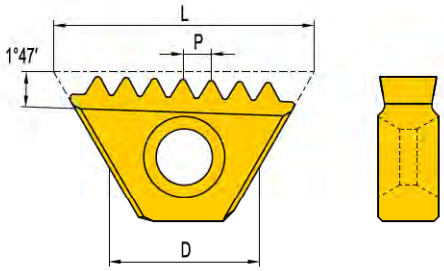
加工螺距 Pitch	刀片尺寸 Insert Size					
TPI	D=6mm L=10.4mm	D=1/4″ L=11mm	D=3/8″ L=16mm	D=3/8B″ L=22mm	D=5/8″ L=27mm	D=3/4″ L=38mm
28	*K6.0EI28 W	K2EI28 W				
26	*K6.0EI26 W	K2EI26 W	K3EI26 W			
24	*K6.0EI24 W	K2EI24 W	K3EI24 W	K3BEI24 W		
20	*K6.0EI20 W	K2EI20 W	K3EI20 W	K3BEI20 W		
19	*K6.0EI19 W	K2EI19 W	K3EI19 W	K3BEI19 W		
18			K3EI18 W	K3BEI18 W		
16			K3EI16 W	K3BEI16 W	K5EI16 W	
14		K2EI14 W	K3EI14 W	K3BEI14 W	K5EI14 W	
12			K3EI12 W	K3BEI12 W	K5EI12 W	
11			K3EI11 W	K3BEI11 W	K5EI11 W	K6BEI11 W
10					K5EI10 W	
9					K5EI9 W	
8					K5EI8 W	
7					K5EI7 W	
6					K5EI6 W	K6BEI6 W
5						K6BEI5 W
4.5						K6BEI4.5 W

*的刀片表示只有单面刃

* Insert with one cutting edge

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



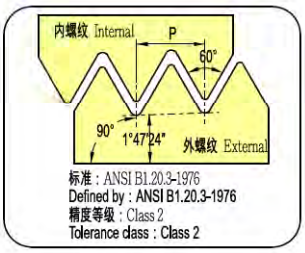


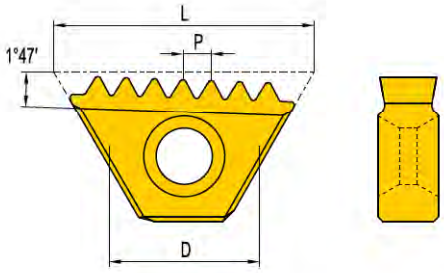
加工螺距 Pitch	刀片尺寸 Insert Size			
TPI	D=3/8" L=16mm	D=3/8B" L=22mm	D=5/8" L=27mm	D=3/4" L=38mm
18	*K3 - 18 NPT			
14	K3 - 14 NPT	K3B - 14 NPT		
11.5	K3 - 11.5 NPT	K3B - 11.5 NPT	K5 - 11.5 NPT	K6B - 11.5 NPT
8			K5 - 8 NPT	K6B - 8 NPT

*的刀片表示只有单面刃

* Insert with one cutting edge

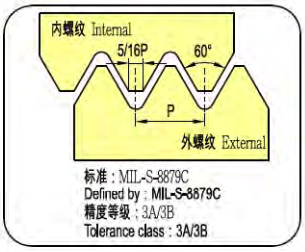
NPTF美制干密封锥管螺纹铣刀片 American NPTF

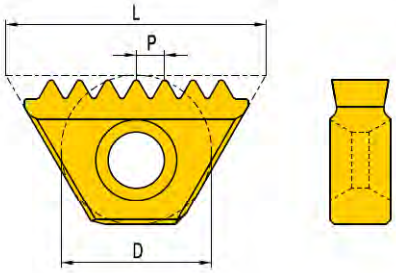




加工螺距 Pitch	刀片尺寸 Insert Size			
TPI	D=3/8" L=16mm	D=3/8B" L=22mm	D=5/8" L=27mm	D=3/4" L=38mm
14	K3 - 14 NPTF	K3B - 14 NPTF		
11.5	K3 - 11.5 NPTF	K3B - 11.5 NPTF	K5 - 11.5 NPTF	K6B - 11.5 NPTF
8			K5 - 8 NPTF	K6B - 8 NPTF

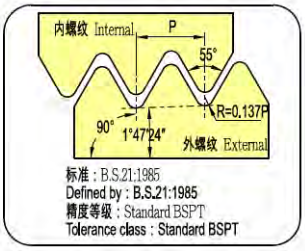
UNJ美国航空航天机械螺纹铣刀片 UNJ Aviation Thread

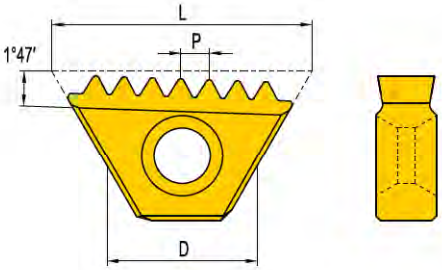




加工螺距 Pitch		刀片尺寸 Insert Size			
TPI		D=6mm L=10.4mm	D=1/4″ L=11mm	D=3/8″ L=16mm	D=5/8″ L=27mm
24	外 Ext		K2E24 UNJ	K3E24 UNJ	
	内 Int	*K6.0I24 UNJ	K2I24 UNJ	K3I24 UNJ	
20	外 Ext		K2E20 UNJ	K3E20 UNJ	
	内 Int	*K6.0I20 UNJ	K2I20 UNJ	K3I20 UNJ	
18	外 Ext			K3E18 UNJ	
	内 Int	*K6.0I18 UNJ	K2I18 UNJ	K3I18 UNJ	
16	外 Ext		K2E16 UNJ	K3E16 UNJ	K5E16 UNJ
	内 Int	*K6.0I16 UNJ	K2I16 UNJ	K3I16 UNJ	K5I16 UNJ
14	外 Ext		K2E14 UNJ	K3E14 UNJ	
	内 Int		K2I14 UNJ	K3I14 UNJ	
13	外 Ext			K3E13 UNJ	
	内 Int				
12	外 Ext			K3E12 UNJ	K5E12 UNJ
	内 Int			K3I12 UNJ	K5I12 UNJ
11	外 Ext				K5E11 UNJ
	内 Int				K5I11 UNJ

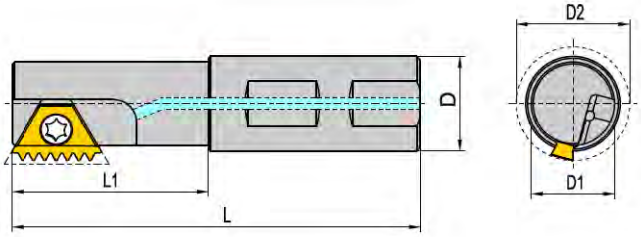
BSPT-55°英国标准锥管螺纹铣刀片 BSPT-55° British Standard Pipe Full Profile





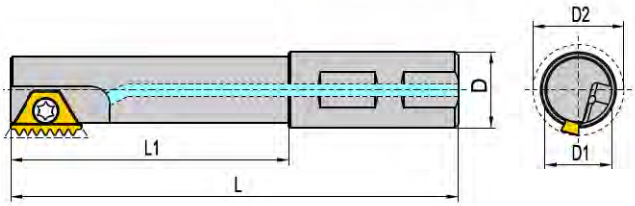
加工螺距 Pitch	刀片尺寸 Insert Size		
TPI	D=1/4″ L=11mm	D=3/8″ L=16mm	D=5/8″ L=27mm
19	K2-19 BSPT		
14		K3-14 BSPT	
11		K3-11 BSPT	K5-11 BSPT

螺纹铣刀杆 Threading Milling Toolholders

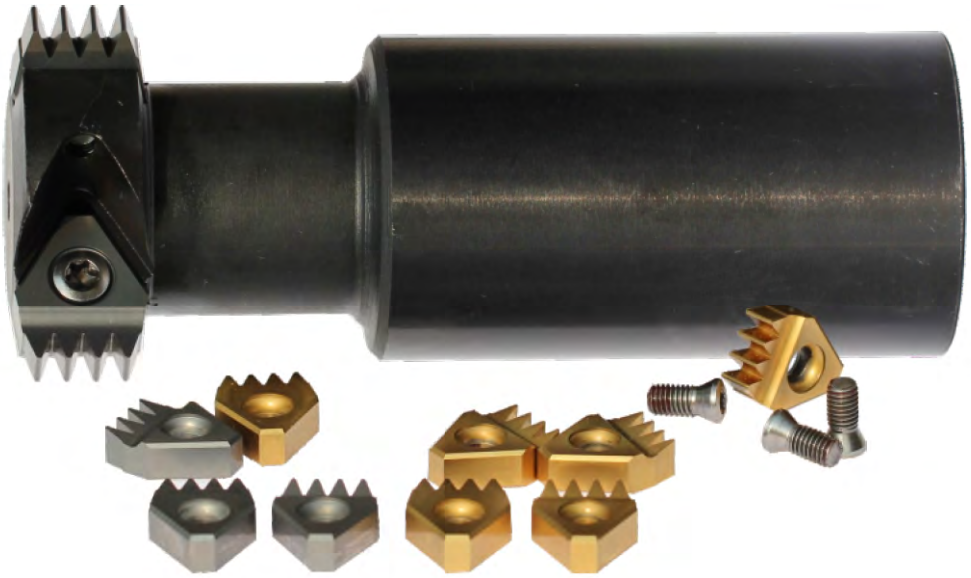


订货号 Order NO.	尺寸 Dimensions (mm)					齿数 Teeth	刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	L	L1	D	D1	D2	Zt			
KSC1209-126.0-1	69	12	12	6.8	9	1	K6.0	M2.2×0.45×5	T07
KSC2009-176.0-1	84	17	20	6.8	9	1			
KSC1211-122-1	70	12	12	8.9	11.5	1	K2	M2.6×0.45×6	T08
KSC2011-202-1	85	20	20	8.9	11.5	1			
KSC1617-223-1	90	22	16	13.6	17	1	K3	UNC5×8	T10
KSC2020-433-1	95	43	20	16.6	20	1			
KSC1617-293B-1	79.5	29	16	13.5	17	1	K3B		
KSC2019-293B-1	81.5	29	20	15.5	19	1		UNC5×9.5	
KSC2519-303B-1	92.3	30	25	15.5	19	1			
KSC2522-303B-1	90.8	30	25	18.5	22	1			
KSC2530-525-1	110	52	25	24	30	1	K5	M5×0.8×15	T25
KSC3237-585-1	120	58	32	31	37	1			
KSC3235-536B-1	115	53	32	27	35	1	K6B	M7×1×15	
KSC4046-636B-1	135	63	40	38	46	1			

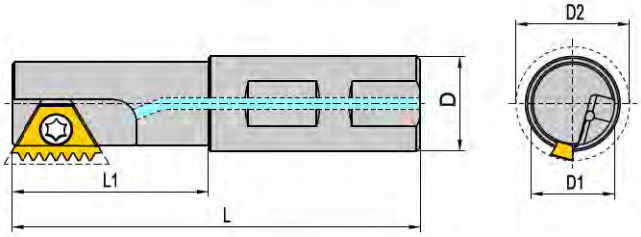
螺纹铣刀杆 Threading Milling Toolholders



订货号 Order NO.	尺寸 Dimensions (mm)					齿数 Teeth	刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	L	L1	D	D1	D2	Zt			
KSC2511-172-1	125	17	25	8.9	11.5	1	K2	M2.6×0.45×6	T08
KSC2522-253-1	125	25	25	18.6	22	1	K3	UNC5×8	T10
KSC2522-633-1	125	63.5	25	18.6	22	1			
KSC2019-443B-1	96.5	44	20	15.5	19	1	K3B		
KSC2522-633B-1	125	63.5	25	18.6	22	1			
KSC2530-925-1	150	92	25	24	30	1	K5	M5×0.8×15	T25
KSC3237-985-1	160	98	32	31	37	1			
KSC4046-936B-1	165	93	40	38	46	1	K6B	M7×1×15	

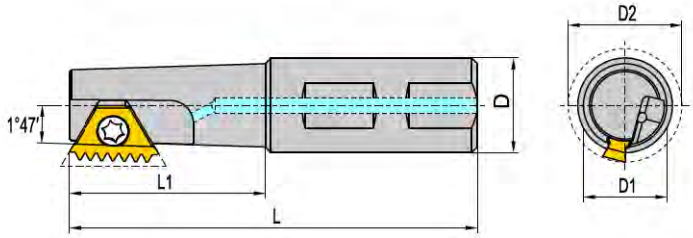


螺纹铣刀杆 Threading Milling Toolholders

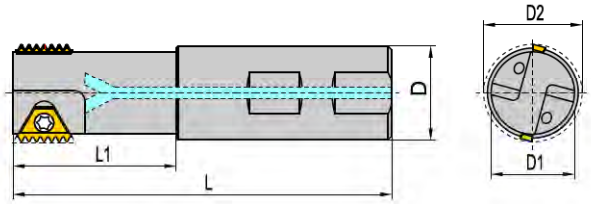


订货号 Order NO.	尺寸 Dimensions (mm)					齿数 Teeth	刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	L	L1	D	D1	D2	Zt			
KSC2009-156.0-1	85	15	20	6.7	9	1	K6.0	M2.2×0.45×5	T07
KSC2010-152-1	77	15.5	20	7.4	10	1	K2	M2.6×0.45×6	T08
KSC2012-152-1	77	15.5	20	9	12	1			
KSC1615-203-1	91	20.5	16	12.2	15.5	1	K3	UNC5×8	T10
KSC2518-304-1	88	30	25	13.4	18	1	K4	UNC8×11	T20
KSC2520-404-1	98	40	25	16	20	1		UNC8×12	
KSC2525-405-1	98	40	25	19	25	1	K5	M5×0.8×15	T25
KSC2522-405-1	98	40	25	16.4	22	1		M7×1×15	

螺纹铣刀杆 Threading Milling Toolholders

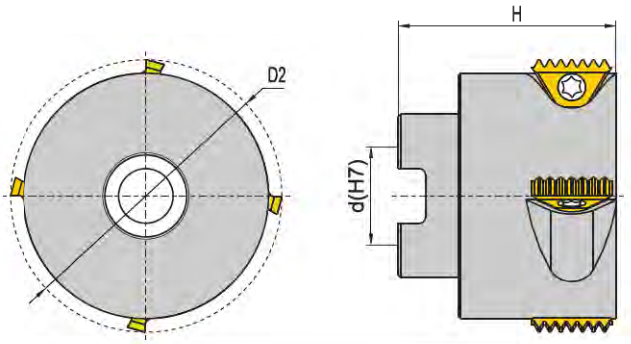


订货号 Order NO.	尺寸 Dimensions (mm)					齿数 Teeth	刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	L	L1	D	D1	D2	Zt			
KCC1615-223-1	90	22	16	12.5	15.5	1	K3	UNC5×8	T10
KCC2019-233-1	85	23	20	15	19	1			
KCC1617-293B-1	79.5	29	16	13.5	17	1	K3B		
KCC2019-293B-1	81.5	29	20	15.5	19	1			
KCC3237-585-1	120	58	32	31	37	1	K5	M5×0.8×15	T25

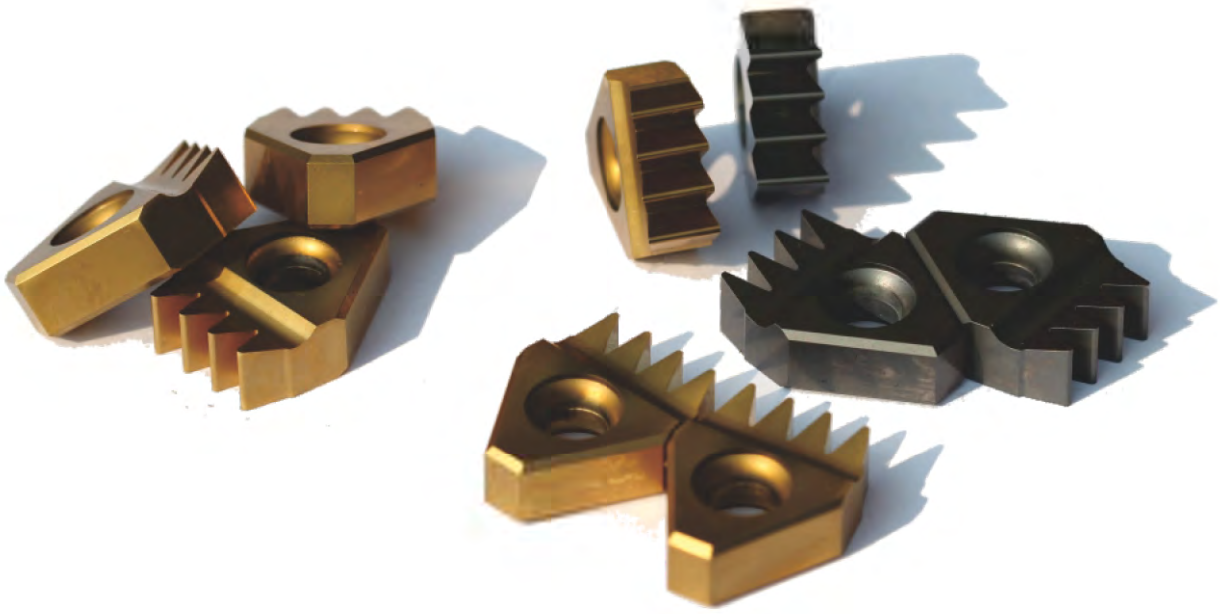


订货号 Order NO.	尺寸 Dimensions (mm)					齿数 Teeth	刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key
	L	L1	D	D1	D2	Zt			
KSC2017-202-2	85	20	20	14.4	17	2	K2	M2.6×0.45×6	T08
KSC2526-433-2	100	43	25	22.5	26	2	K3	UNC5×10	T10
KSC2526-463B-2	104.2	46	25	22.5	26	2	K3B		
KSC3242-455-2	120	45	32	36	42	2	K5	M5×0.8×15	T25
KSC4052-656B-2	137.2	65	40	44	52	2	K6B	M7×1×15	

螺纹铣刀杆 Threading Milling Toolholders



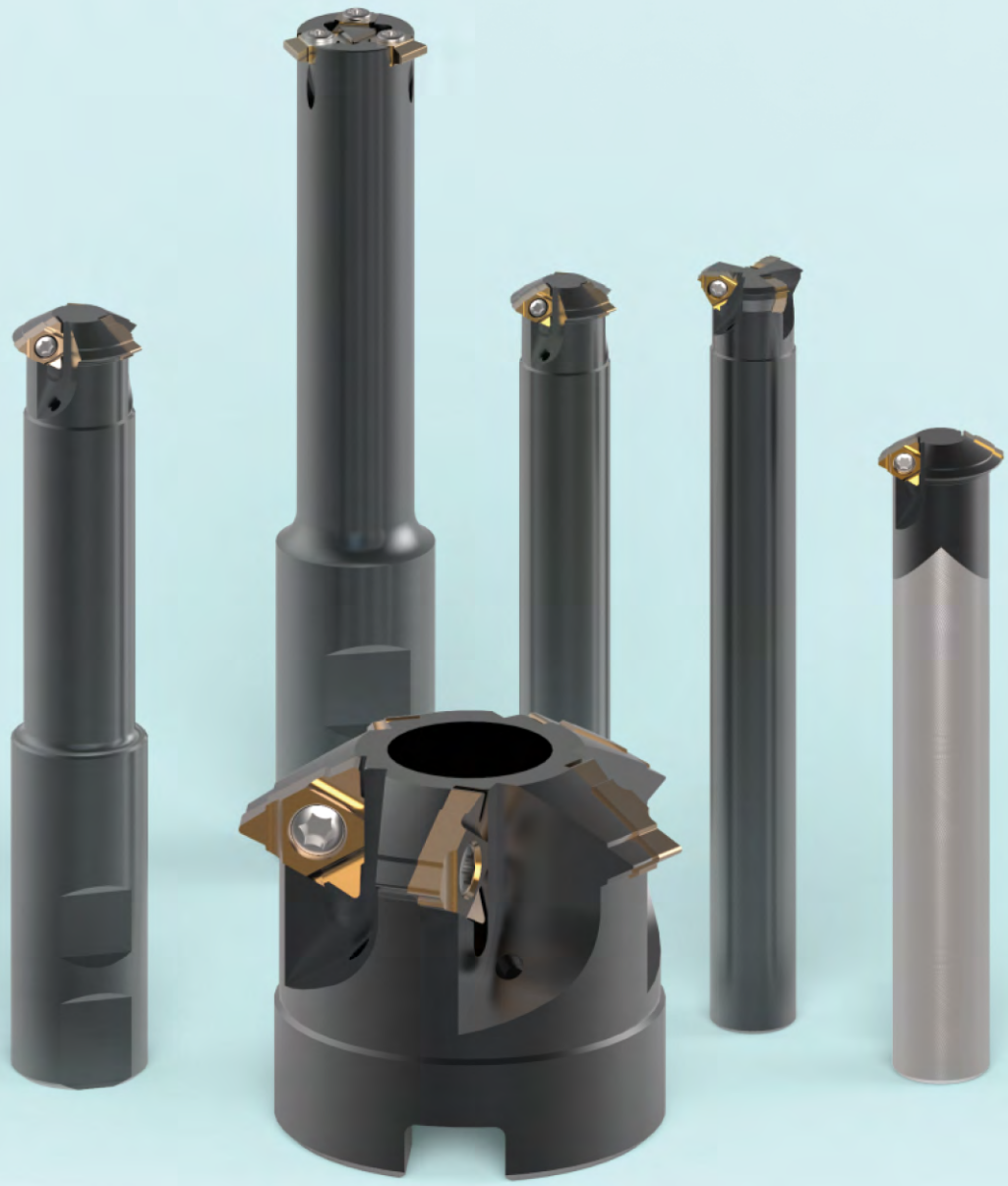
订货号 Order NO.	尺寸 Dimensions (mm)			齿数 Teeth	刀片 Insert	螺钉 Anvil Screw	梅花扳手 Torx Key	内六角螺钉 Holder Screw
	D2	d	H	Zt				
KSED3816-2-6	38	16	40	6	K2	M2.6×0.45×6	T08	M8×1.25×35
KSED5022-2-8	50	22	40	8				M10×1.5×35
KSED5022-3-6	50	22	40	6	K3	UNC5×10	T10	
KSED6322-3B-6	63	22	40	6	K3B			
KSED6322-5-4	63	22	45	4	K5	M5×0.8×15	T25	
KSED6322-6B-4	63	22	50	4	K6B	M7×1×15		
KSED8027-5-6	80	27	50	6	K5	M5×0.8×15		M12×1.75×40
KSED8027-6B-5	80	27	50	5	K6B	M7×1×15		
KSED10032-5-7	100	32	55	7	K5	M5×0.8×15		M16×2×40
KSED10032-6B-6	100	32	55	6	K6B	M7×1×15		
KSED12540-5-9	125	40	63	9	K5	M5×0.8×15		M20×2.5×50
KSED12540-6B-8	125	40	63	8	K6B	M7×1×15		



成都戴梦迪超硬工具有限责任公司
CHENGDU DIAMOND TOOLS CO., LTD.

深孔系列螺纹铣刀

Deep Series Threading Milling Tools



深孔系列螺纹铣刀片型号说明
Deep Series Threading Milling Inserts - Code Keys

D	2	U	I	DB	60	-	DLT9
1	2	3	4	5	6		7

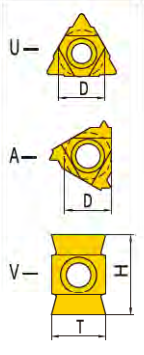
1、产品系列 Product Series

D - 深孔系列
D - D Series

2、刀片尺寸 Insert size

1-H= 9.525mm
2-D= 1/4″ 3-D=3/8″
4-D =1/2″

3、刀片形式 Insert type



4、加工类型 Type of insert

I-内螺纹 Internal

5、螺 距 Pitch

全牙型-螺距范围 Full Profile-Pitch Range		范围牙型-螺距范围 Partial Profile-Pitch Range		
mm	tpi		mm	tpi
2.0-5.0	-	DA	0.5-1.5	48-16
		DB	1.5-2.0	16-12
		DC	2.5-4.0	10-6
		DD	2.0-2.5	12-9
		DE	2.5-3.5	10-7
		DH	4.0-6.0	6-4
		DK	6.0-8.0	4-3
		DL	-	11-7
		DM	2.5	10-5
		DN	1.0-2.0	24-11
		DP	1.5-3.0	16-8
		DR	2.0-4.0	26-14
		DT	-	12-6

6、螺纹标准 Thread Standard

60°-范围牙型 60°
-Partial Profile 60°
55°-范围牙型 55°
-Partial Profile 55°
TR-30°梯形螺纹
-Trapez DIN 103

6、涂层种类 Coating type

DT3–适用于碳钢，通用材料
First choice for carbon steel and ordinary steel process
DLT9–适用于不锈钢及难加工材料
Excellent for stainless steel and difficult operations

深孔系列直柄螺纹铣刀杆型号说明
Deep Series Threading Milling Toolholders - Code Keys

D	N	C	25	W	26	-	80	2	U	-	3
1	2	3	4	5	6		7	8	9		10

1、产品系列 Product Series

D- 深孔系列
D - D Series

2、刀杆材质 Tool Material

N - 钢材
- Steel
C - 硬质合金
- Hard Alloy

3、冷却形式 Cooling Form

C - 内冷却
- Cooling

4、刀柄直径 Shank Dia.[mm]

9.5-40

5、紧固形式 Fastening Form

W - 侧固式
- Side Lock
C - 圆柱式
- Cylindrical Style

6、切削刃直径 Cutting Dia.[mm]

13-42

7、刀杆悬长 Tool Overhang[mm]

12 14 21 30 40

8、刀片尺寸 Insert size

H=9.525mm
D=1/4″ D=3/8″
D=1/2″

9、刀片形式 Insert type

U
A
V

10、槽数 Flutes

1-4

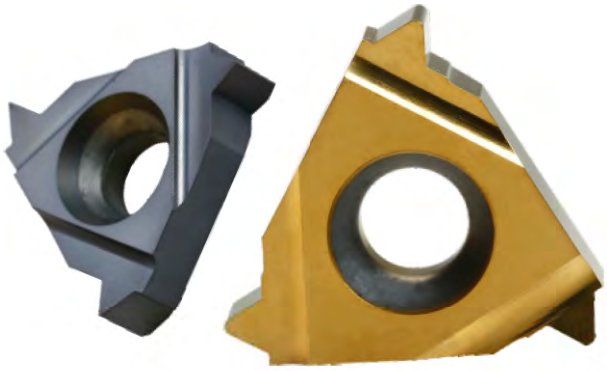
深孔系列套式螺纹铣刀杆型号说明

Deep Series Threading Shell Mill Toolholders - Code Keys

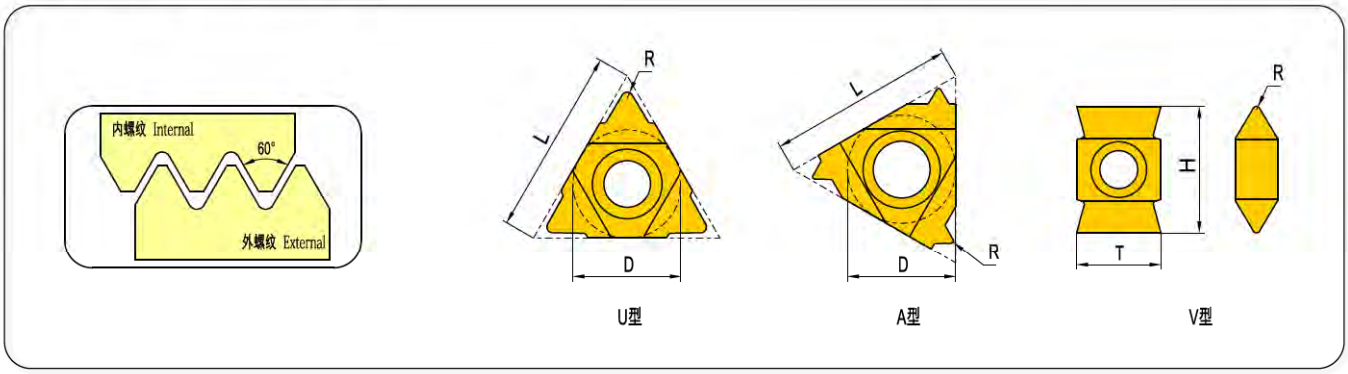
D	C	D48	-	22	-	3	U	-	5
1	2	3		4		5	6		7

1、产品系列	2、冷却形式	3、切削刃直径	4、内孔直径	5、刀片尺寸
Product Series	Cooling Form	Cutting Dia.[mm]	Drive Hole Dia.[mm]	Insert size
D- 深孔系列 D - D Series	C - 内冷却 Cooling	42-98	16 22 27 32	D=1/4″ D=3/8″ D=1/2″

6、刀片形式	7、槽数
Insert type	Flutes
U	4-7



60°范围牙型 Partial Profile 60°



V型 V-type

图片	刀片尺寸 Insert Size H(mm)	T(mm)	订货号 Order No.	螺距 Pitch MM	TPI	R(mm)	刀杆 Tool holder
	9.525	6.35	D1VIDA60	0.5-1.5	48-16	0.04	DNC...1V
			D1VIDT60	2.0-4.0	12-6	0.08	

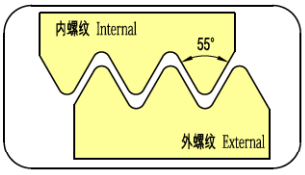
U型 U-type

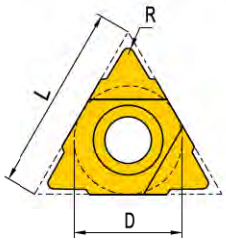
图片	刀片尺寸 Insert Size D	L(mm)	订货号 Order No.	螺距 Pitch MM	TPI	R(mm)	刀杆 Tool holder
	1/4″U	11	D2UIDA60	0.5-1.5	48-16	0.05	DNC...2U
			D2UIDB60	1.5-2.0	16-12	0.06	DCC...2U
			D2UIDD60	2.0-2.5	12-9	0.11	DCC14C17-652U-2
			D2UIDM60	2.5	10	0.11	
			D2UIDC60	2.5-4.0	10-6	0.14	DNC...2U/DCC...2U
	3/8″U	16	D3UIDB60	1.5-2.0	16-12	0.06	DNC...3U
			D3UIDE60	2.5-3.5	10-7	0.14	
			D3UIDH60	4.0-6.0	6-4	0.25	
	1/2″U	22	D4UIDK60	6.0-8.0	4-3	0.30	DNC...4U

A型 A-type

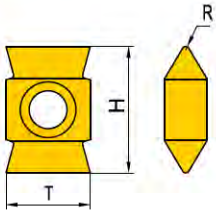
图片	刀片尺寸 Insert Size D	L(mm)	订货号 Order No.	螺距 Pitch MM	TPI	R(mm)	刀杆 Tool holder
	1/4″A	11	D2AIDP60	1.5-3.0	16-8	0.06	DNC...2A
	3/8″A	16	D2AIDT60	2.0-4.0	12-6	0.08	DNC...3A

55°范围牙型 Partial Profile 55°





U型



V型

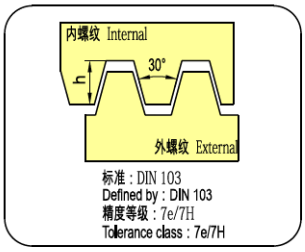
V型 V-type

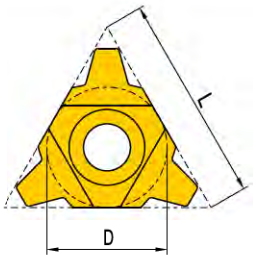
图片	刀片尺寸 Insert Size H(mm)	T(mm)	订货号 Order No.	螺距 TPI	R(mm)	刀杆 Tool holder
	9.525	6.35	D1VIDR55	26-14	0.10	DNC...1V/DCC...1V

U型 U-type

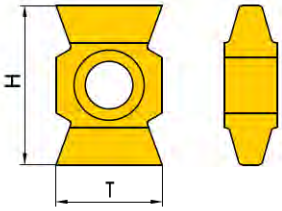
图片	刀片尺寸 Insert Size D	L(mm)	订货号 Order No.	螺距 TPI	R(mm)	刀杆 Tool holder
	1/4"U	11	D2UIDA55	48-16	0.08	DNC...2U/DCC...2U
			D2UIDB55	16-12	0.11	
			D2UIDL55	11-7	0.24	
	3/8"U	16	D3UIDB55	16-12	0.08	DNC...3U
			D3UIDL55	11-7	0.24	
			D3UIDH55	6-4	0.27	
	1/2"U	22	D4UIDK55	4-3	0.50	DNC...4U

梯形螺纹 Trapez





U型



V型

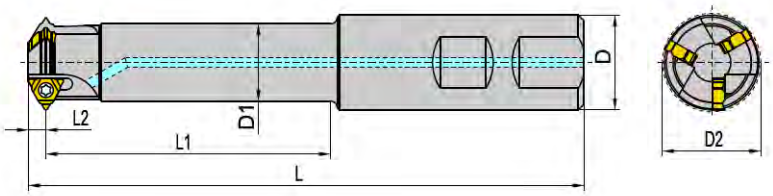
V型 V-type

图片	刀片尺寸 Insert Size H(mm)	T(mm)	订货号 Order No.	螺距 mm
	9.525	6.35	D1VI2.00TR	2.0
			D1VI3.00TR	3.0
			D1VI4.00TR	4.0

U型 U-type

图片	刀片尺寸 Insert Size D	L(mm)	订货号 Order No.	应用 Application
	1/4"U	11	D2UI3.00TR	(TR22-60)×3
			D2UI4.00TR	(TR20-110)×4
			D2UI5.00TR	(TR22-28)×5

侧固式(U型)标准刀杆 Standard Toolholders For Side Lock(U-type)

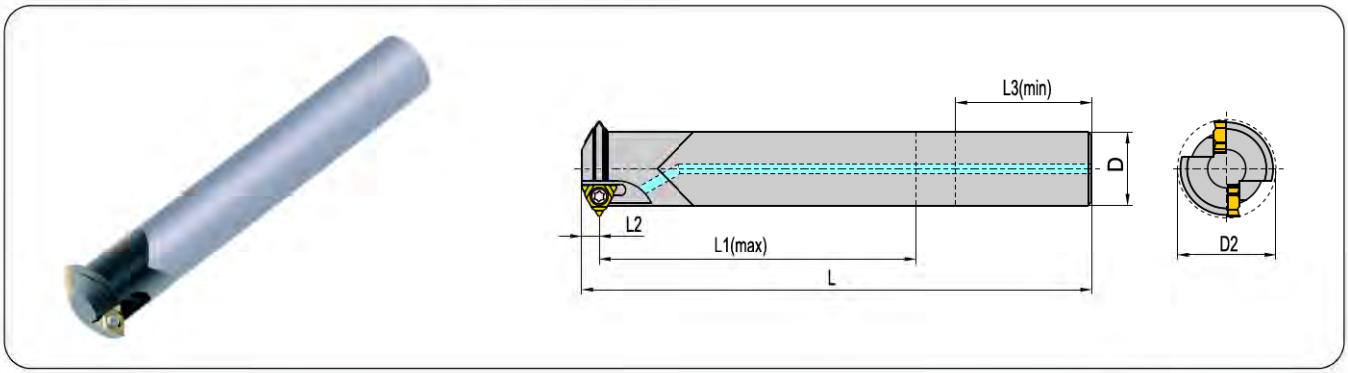


刀片尺寸(D)	订货号	尺寸 Dimensions(mm)						槽数	配件 Spare Parts	
									螺钉 Anvil Screw	梅花扳手 Torx Key
Insert Size(D)	Order No.	L	L1	L2	D	D1	D2	No.of Flutes Z		
1/4"U	DNC16W15-402U-1	95	40	5.4	16	11	14.75	1	M3×7	T08
	DNC25W21-602U-2	123	60		25	16	20.65	2		
	DNC25W23-702U-2	135	70		25	17.7	23	2		
	DNC25W26-802U-3	147	80		25	20.4	26	3		
	DNC32W31-952U-4	164	95		32	25.7	31	4		
3/8"U	DNC32W37-953U-3	166	95	8.0	32	29	36.5	3	M3.5×12	T15
	DNC40W42-1203U-4	201	120		40	34.2	42	4		

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

最小螺纹直径 Min.Thread φ								
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSP(G)	55°	TR
DNC16W15-402U-1	14.75	M18×2.5, M24×3.0	M16×0.5,M16×0.75; M16×1.0,M17×1.25; M17×1.5,M17×2.0;	3/4-10	5/8-32UN,5/8-28UN,5/8-27UNS, 11/16-24UN,11/16-20UN, 11/16-16UN,3/4-14UNS, 3/4-12UN	3/8-19, 1/2-14, 1-11	11/16-14,3/4-12, 7/8-11,3/4-10, 7/8-9,1-8, 1 1/8-7	TR22×3, TR24×3
DNC25W21-602U-2	20.65	M24×3.0, M30×3.5	M22×0.5,M22×0.75; M22×1.0,M23×1.25; M23×1.5,M23×2.0;	1-8, 1 1/8-7, 1 3/8-6	7/8-32UN,7/8-28UN,7/8-27UNS, 7/8-24UNS,7/8-20UNEF,1-18UNS, 15/16-16UN,1-14UNS, 15/16-12UN,1-10UNS	3/4-14, 1-11	1-26,1-20, 1-16,1-12, 1-10,1 1/8-9, 1-8,1 1/8-7	TR26-TR60×3
DNC25W23-702U-2	23	M27×3.0; M30×3.5; M36×4.0	M24×0.5,M24×0.75; M25×1.0,M25×1.25; M26×1.5,M26×2.0; M27×2.5	1 1/8-7	1-32UN,1-28UN,1-27UNS, 1-24UNS,1-20UNEF,1-18UNS, 1-16UN,1-14UNS,1-12UNF, 1 1/8-10UNS,1 1/8-8UN	3/4-14, 1-11	1-26,1-20, 1-16, 1 1/16-12, 1 1/8-9, 1 1/8-7	—
DNC25W26-802U-3	26	M30×3.5; M36×4.0	M27×0.5,M27×0.75; M28×1.0,M28×1.25; M28×1.5,M29×2.0; M30×2.5,M30×3.0	1 1/4-7, 1 3/8-6	1 1/8-28UN,1 1/8UNS, 1 1/8-20UN,1 1/8-18UNEF, 1 1/8-16UN,1 1/8-14UNS,1 1/8-12UNF,11/4-10UNS, 1 3/16-8UN	7/8-14, 1-11	1 1/8-26,1 1/8-20, 1 3/8-16,1 3/8-12, 1 3/16-8,1 1/4-7	—
DNC32W31-952U-4	31	M36×4.0	M32×0.5,M32×0.75; M33×1.0,M33×1.25; M33×1.5,M34×2.0; M34×2.5,M35×3.0; M36×3.5	1 1/2-6	1 5/16-28UN,1 3/8-24UNS, 1 5/16-20UN,1 5/16-18UNEF, 1 5/16-16UN,1 3/8-14UNS, 1 3/8-12UNF,1 3/8-10UNS, 1 3/8-8UN	1 1/8-11	1 3/8-26,1 3/8-20, 1 3/8-16,1 3/8-12, 1 7/16-8	—
DNC32W37-953U-3	36.5	M42×4.5, M48×5.0; M56×5.5, M64×6.0;	M39×1.5,M39×2.0; M40×2.5,M41×3.0; M42×3.5,M42×4.0	1 3/4-5, 2-4.5, 2 1/2-4	1 9/16-16UN,1 5/8-14UNS, 1 9/16-12UN,1 5/8-10UNS, 1 5/8-8UN,1 5/8-6UN	1 1/4-11	1 5/8-16, 1 5/8-12, 1 5/8-8, 2 1/4-6, 1 3/4-5	—
DNC40W42-1203U-4	42	M48×5.0; M56×5.5; M64×6.0	M45×1.5,M45×2.0; M46×2.5,M48×3.0; M48×3.5,M48×4.0	2-4.5, 2 1/2-4	1 3/4-16UN,1 3/4-14UNS, 1 13/16-12UN,1 13/16-8UN, 1 15/16-6UN	1 1/2-11	1 7/8-16, 1 7/8-12, 1 7/8-8, 1 7/8-6, 2-4.5	—

硬质合金圆柱式标准刀杆(U型) Hard Alloy Standard Toolholders For Cycindrical Style(U-type)

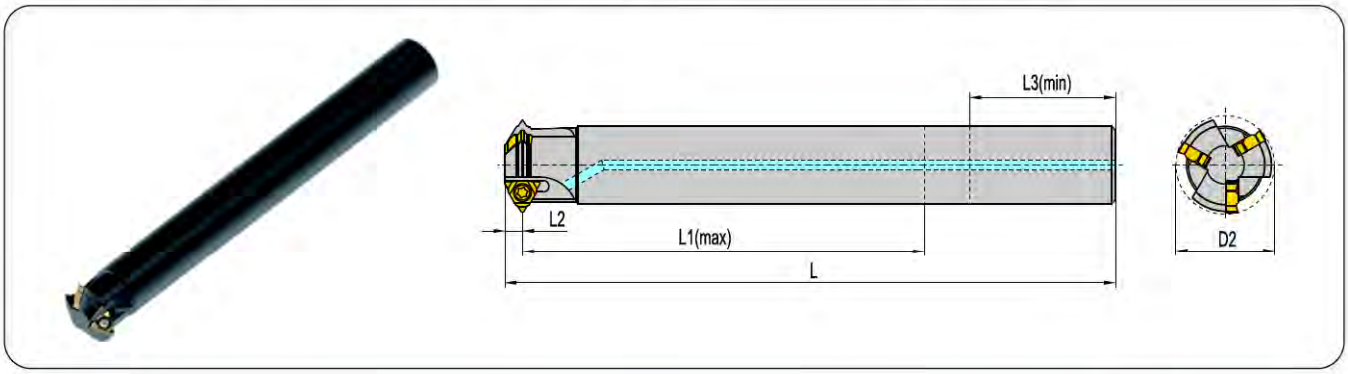


刀片尺寸(D)	订货号	尺寸 Dimensions(mm)						槽数	配件 Spare Parts	
									螺钉 Anvil Screw	梅花扳手 Torx Key
Insert Size(D)	Order No.	L	L1	L2	D	D1	D2	No.of Flutes Z		
1/4"U	DCC8C15-402U-1	109	40	5.4	18	8	14.75	1	M3×7	T08
	DCC10C15-602U-1	120	60	5.4	25	10.7	14.75	1		
	DCC14C17-652U-2	132	65	3.4	30	14	17.2	2		
	DCC14C21-652U-2	136	65	5.4	30	14	20.65	2		
	DCC16C21-802U-2	135	80	5.5	34	16	20.65	2		

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

最小螺纹直径 Min.Thread φ								
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSP(G)	55°	TR
DCC8C15-402U-1	14.75	M18×2.5, M24×3.0, M30×3.5, M36×4.0	M16×0.5,M16×0.75, M16×1.0,M17×1.25, M17×1.5,M17×2.0	3/4-10, 7/8-9, 1-8, 1 1/8-7, 1 3/8-6	5/8-32UN,5/8-28UN,5/8-27UNS, 11/16-24UNEF,11/16-20UN, 11/16-16UN,3/4-14UNS, 11/16-12UN	1/2-14, 1-11	11/16-26,11/16-20, 11/16-16,11/16-14, 3/4-12,7/8-11, 3/4-10,7/8-9, 1-8,17/8-7	TR22×3,TR24×3, TR20×4,TR22×5, TR24×5,TR26×5, TR28×5
DCC10C15-602U-1	14.75	M18×2.5, M24×3.0	M16×0.5,M16×0.75, M16×1.0,M17×1.25, M17×1.5,M17×2.0	3/4-10, 7/8-9, 1-8	5/8-32UN,5/8-28UN,5/8-27UNS, 11/16-24UNEF,11/16-20UN, 11/16-16UN,3/4-14UNS, 11/16-12UN	1/2-14, 1-11	11/16-26,11/16-20, 11/16-16,11/16-14, 3/4-12,7/8-11, 3/4-10,7/8-9	TR22×3, TR24×3
DCC14C17-652U-2	17.2	M20×2.5, M22×2.5	M21×2.0	7/8-9	7/8-10UNS,13/16-12UN	—	—	—
DCC14C21-652U-2	20.65	M24×3.0, M30×3.5, M36×4.0	M22×0.5,M22×0.75, M22×1.0,M23×1.25, M23×1.5,M23×2.0	1-8, 1 1/8-7, 1 3/8-6	7/8-32UN,7/8UN,7/8-27UNS, 7/8-24UNS,7/8-20UNEF, 1-18UNS,15/16-16UN,1-14UNS, 15/16-12UN,1-10UNS	3/4-14, 1-11	1-26,1-20, 1-16,1-12, 1-10,1 1/8-9, 1-8,1 1/8-7	(TR26-TR60)×3, TR28×4, (TR65-TR110)×4, TR28×5
DCC16C21-802U-2	20.65	M24×3.0, M30×3.5	M22×0.5,M22×0.75, M22×1.0,M23×1.25, M23×1.5,M23×2.0	1-8, 1 1/8-7, 1 3/8-6	7/8-32UN,7/8UN,7/8-27UNS, 7/8-24UNS,7/8-20UNEF, 1-18UNS,15/16-16UN,1-14UNS, 15/16-12UN,1-10UNS	3/4-14, 1-11	1-26,1-20, 1-16,1-12, 1-10,1 1/8-9, 1-8,1 1/8-7	(TR26-TR60)×3

钢材圆柱式标准刀杆（U型） Steel Standard Toolholders For Cycindrical Style(U-type)

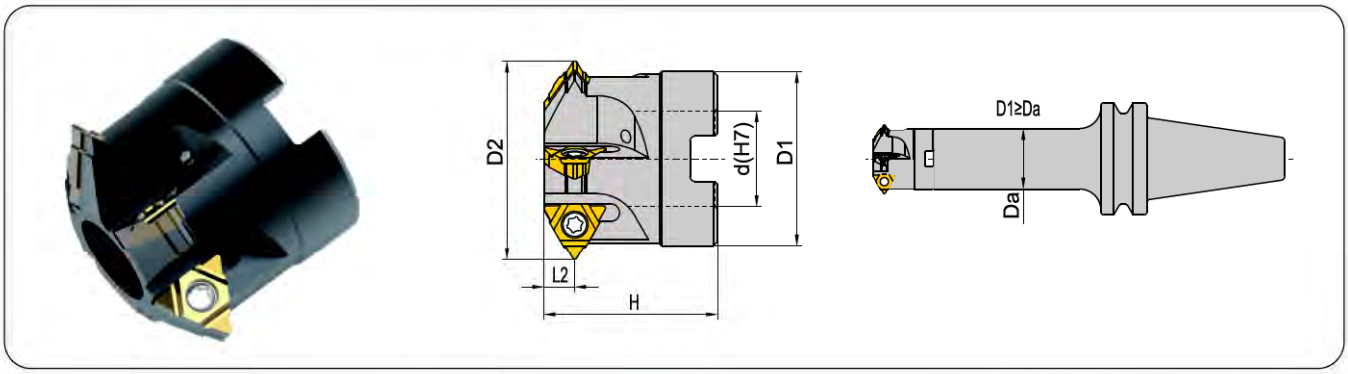


刀片尺寸(D)	订货号	尺寸 Dimensions(mm)						槽数	配件 Spare Parts	
									螺钉 Anvil Screw	梅花扳手 Torx Key
Insert Size(D)	Order No.	L	L1	L2	D	D1	D2	No.of Flutes Z		
1/4″U	DNC18C23-862U-2	166	86	5.4	40	18	23.3	2	M3×7	T08
	DNC20C26-1052U-3	186	105	5.4	40	20	26	3		
	DNC25C31-1152U-4	196	115	5.4	46	25	31	4		
3/8″U	DNC28C37-1443U-3	222	144	8	60	28	36.5	3	M3.5×12	T15

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

最小螺纹直径 Min.Thread φ							
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSP(G)	55°
DNC18C23-862U-2	23.3	M27×3.0, M30×3.5, M36×4.0	M24×0.5,M25×0.75, M25×1.0,M25×1.25, M26×1.5,M26×2.0, M27×2.5	1 1/8-7	1-32UN,1-28UN,1-27UN,1-24UNS, 1-20UNEF,1-18UNS,1-14UNS, 1 1/16-12UN,1 1/8-10UNS, 1 1/8-8UN	3/4-14, 1-11	1-26,1-20, 1 1/8-16, 1 1/8-12, 1 1/8-9, 1 1/8-7
DNC20C26-1052U-2	26	M30×3.5, M36×4.0	M27×0.5,M27×0.75, M28×1.0,M28×1.25, M28×1.5,M29×2.0, M30×2.5,M30×3.0	1 1/4-7	1 1/8-28UN,1 1/8-24UNS, 1 1/8-20UN,1 1/8-18UNEF, 1 1/8-16UN,1 1/8-14UNS, 1 1/8-12UNF,1 3/8-10UNS, 1 7/16-8UN	7/8-14, 1-11	1 1/8-26,1 1/8-20, 1 3/16-16, 1 3/16-12, 1 3/16-8,1 1/4-7
DNC25C31-1152U-4	31	M36×4.0	M32×0.5,M32×0.75, M33×1.0,M33×1.25, M33×1.5,M34×2.0, M34×2.5,M35×3.0, M36×3.5	1 1/2-6	1 5/16-28UN,1 1/2-24UNS, 1 1/2-20UN,1 1/2-18UNEF, 1 3/8-16UN,1 3/8-14UNS, 1 3/8-12UNF,1 3/8-10UNS, 1 7/16-8UN	1 1/8-11	1 5/16-26, 1 5/16-20, 1 3/8-16, 1 3/8-12, 1 7/16-8
DNC28C37-1443U-3	36.5	M42.5×4.5, M48×5.0, M56×5.5, M64×6.0	M39×1.5,M40×2.5, M41×3.0,M42×3.5, M42×4.0	1 3/4-5, 2-4.5, 2 1/2-4	1 9/16-16UN,1 5/8-14UNS, 1 9/16-12UN,1 5/8-10UNS, 1 5/8-8UN,1 5/8-6UN	1 1/4-11	1 5/8-16, 1 5/8-12, 1 5/8-8, 2 1/4-6, 1 3/4-5

刀盘（U型） Shell Mills(U-type)

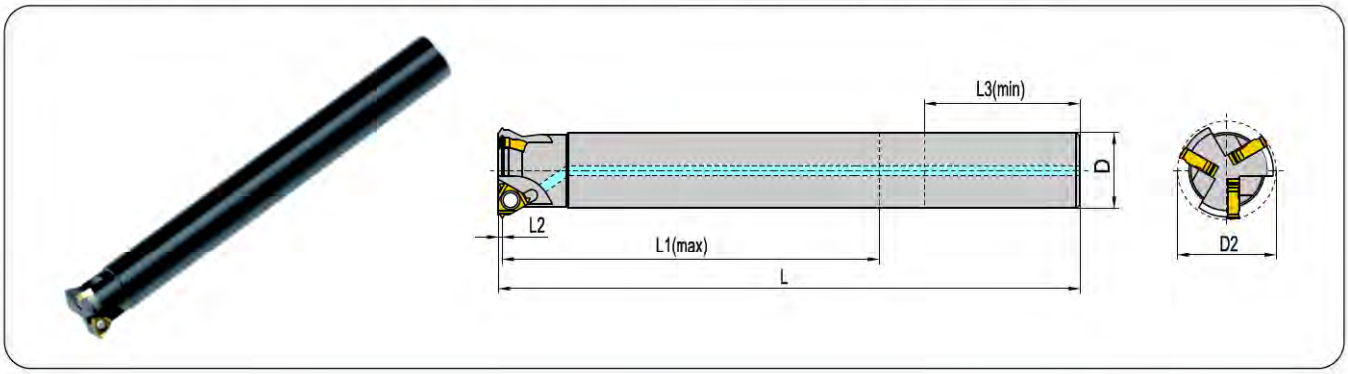


刀片尺寸(D)	订货号	尺寸 Dimensions(mm)					槽数	配件 Spare Parts 螺钉 Anvil Screw	梅花扳手 Torx Key	内六角螺钉 Holder Screw
Insert Size(D)	Order No.	D1	D2	d(H7)	H	L2	No.of Flutes Z			
3/8"U	DCD42-163U-4	34	42	16	40	8	4	M3.5×12	T15	M8×1.25×28
	DCD48-223U-5	40	48	22	40	8	5			M10×1.50×35
	DCD56-223U-6	48	56	22	40	8	6			
1/2"U	DCD88-274U-6	76	88	27	50	10.8	6	M4×14	T15	M12×1.75×40
	DCD98-324U-7	85	98	32	55	10.8	7			M16×2.00×40

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

最小螺纹直径 Min.Thread φ							
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSP(G)	55°
DCD42-163U-4	42	M48×5.0, M56×5.5, M64×6.0	M45×1.5,M45×2.0, M46×2.5,M48×3.0, M48×3.5,M48×4.0	2-4.5, 2 1/2-4	5/8-32UN,5/8-28UN,5/8-27UNS, 11/16-24UNEF,11/16-20UN, 11/16-16UN,3/4-14UNS, 11/16-12UN	1 1/2-11	1 7/8-16, 1 7/8-12, 1 7/8-8, 1 7/8-6,2-4.5
DCD48-223U-5	48	M56×5.5, M64×6.0	M52×1.5,M52×2.0, M52×2.5,M52×3.0, M55×4.0	2 1/4-4.5, 2 1/2-4	5/8-32UN,5/8-28UN,5/8-27UNS, 11/16-24UNEF,11/16-20UN, 11/16-16UN,3/4-14UNS, 11/16-12UN	1 3/4-11	2-16,2 1/4-12, 2 1/4-8, 2 1/4-6,3-5, 3 1/2-4.5,2 1/4-4
DCD56-223U-6	56	M64×6.0	M60×1.5,M60×2.0, M60×2.5,M60×3.0, M64×4.0	2 1/2-4	7/8-10UNS,13/16-12UN	2-11	2 1/2-16,2 1/2-12, 2 1/4-8,2 3/4-6, 3-5,3 1/2-4.5, 2 1/4-4
DCD88-274U-6	88	—	M95×6.0,M130×8	4-4	7/8-32UN	3 1/2-11	4-3,4 1/4-4
DCD98-324U-7	98	—	M105×6.0,M130×8	—	7/8-32UN	4-11	4 1/4-4

钢材圆柱式标准刀杆（A型） Steel Standard Toolholders For Cycindrical Style(A-type)

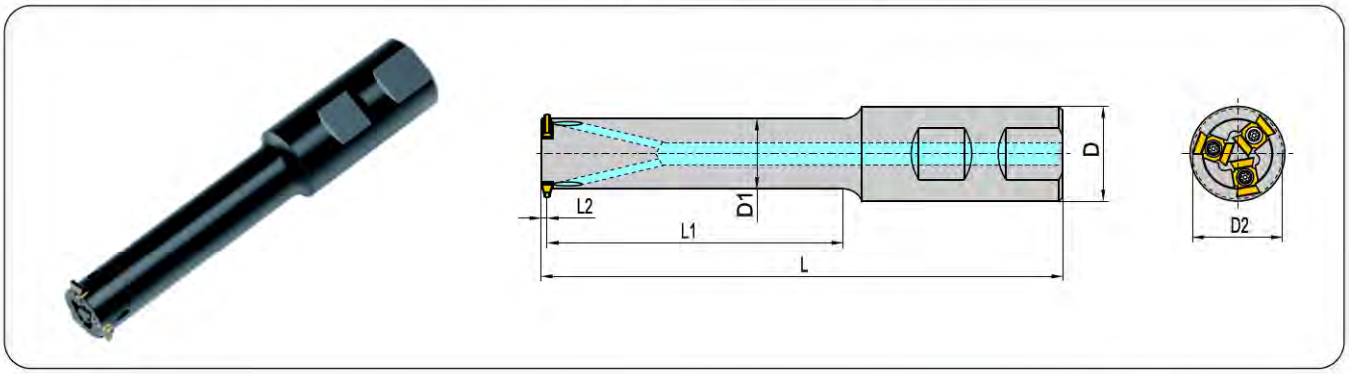


刀片尺寸(D)	订货号	尺寸 Dimensions(mm)						槽数	配件 Spare Parts	
									螺钉 Anvil Screw	梅花扳手 Torx Key
Insert Size(D)	Order No.	L	L1	L2	D	D1	D2	No.of Flutes Z		
1/4"A	DNC20C26-1052A-3	184	105	3	40	20	26	3	M3×7	T08
3/8"A	DNC28C35-1443A-3	218	144	4	46	28	35.3	3	M3.5×12	T15

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

最小螺纹直径 Min.Thread φ						
刀杆 Tool holder	D2 (mm)	ISO 粗牙 ISO Coarse	ISO 细牙 ISO Fine	UNC	UN/UNF/UNEF/UNS	BSP(G)
DNC20C26-1052A-3	26	—	M28×1.5,M29×2.0, M30×2.5,M30×3.0,	—	1 1/8-16UN,1 1/8-14UNS, 1 3/16-12UN,1 1/4-10UNS, 1 3/16-8UN	—
DNC28C35-1443A-3	35.3	—	M38×2.0,M39×2.5, M39×3.0,M40×4.0,	—	1 9/16-12UN,1 5/8-10UNS, 1 5/8-8UN,1 5/8-10UN	—

钢材侧固式标准刀杆（V型） Steel Standard Toolholders For Side Lock(V-type)



刀片尺寸 Insert Size		订货号	尺寸 Dimensions(mm)						槽数	配件 Spare Parts	
										螺钉 Anvil Screw	梅花扳手 Torx Key
H(mm)	T(mm)	Order No.	L	L1	L2	D	D1	D2	No.of Flutes Z		
9.525	6.35	DNC20W24-901V-3	142	90	2	20	19.3	23.85	3	M2.5×8.5	T07
		DNC32W33-1151V-5	179	115	2	32	27.7	23.85	5		
		DNC32W24-601V-3	122	60	2	32	19.3	23.85	3		
		DNC25W24-801V-3	138	80	2	25	19.3	23.85	3		
		DNC32W24-801V-3	142	80	2	32	19.3	23.85	3		
		DNC32W24-901V-3	152	90	2	32	19.3	23.85	3		
		DNC32W28-901V-5	153	90	2	32	23	28	5		
		DNC32W30-951V-3	157	95	2	32	24.6	29.5	3		
		DNC32W33-951V-5	159	95	2	32	27.7	32.85	5		
		DNC32W34-901V-6	122	90	2	32	29	34	6		
		DNC32W40-901V-8	142	90	2	32	35	40.25	8		

成都戴梦迪超硬工具有限责任公司
CHENGDU DIAMOND TOOLS CO., LTD.

整体硬质合金螺纹铣刀

Solid Carbide Threading Mills

整体硬质合金螺纹铣刀型号说明

Soild Carbide Threading Mills - Code Keys

RH		12	10	I	2.00	ISO	-	DLT9
1	2	3	4	5	6	7		8

1、产品系列 Product Series

RH — 螺旋槽带内冷却直孔 HeliCool
RHR — 螺旋槽带内冷却斜孔 HeliCool R
RHC — 螺旋槽带内冷却直孔并带倒角 HeliCool C
R — 螺旋槽无冷却孔 HeliCal
RS — 直槽无冷却孔 Straight Flutes
RD — 深孔螺纹铣刀 Deep Threading

2、牙数 Teeth

只对深孔螺纹铣刀
Only for Deep Threading - Long Tools

3、柄径 Shank Dia.

03 — 3.0 mm
04 — 4.0 mm
06 — 6.0 mm
08 — 8.0 mm
10 — 10.0 mm
12 — 12.0 mm
14 — 14.0 mm
16 — 16.0 mm
18 — 18.0 mm
20 — 20.0 mm

4、切削刃径 Cutting Dia.

0.7 — 19.9 mm

5、加工类型 Type of Series

E — 外螺纹 External
I — 内螺纹 Internal
EI - 内外通用螺纹 External + Internal

6、螺距 Pitch

全牙型螺距范围
Full Profile Pitch Range

mm	TPI
0.35 - 6.0	72 - 4.5

通用型螺距范围
Partial Profile Pitch Range

	mm	TPI
A	0.5-0.8	32-56
B	0.5-1.0	24-56
C	1.0-1.50	16-24
D	1.0-1.75	14-24
F	0.5-1.25	20-48

7、螺纹标准 Standard

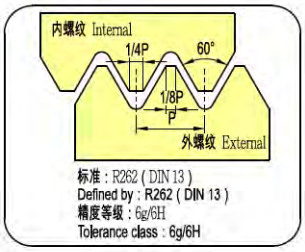
ISO	— ISO 标准型螺纹	ISO Metric
UN	— 60° 美制统一标准型螺纹	American UN
UNC	— 60° 美制统一粗牙螺纹	UN Coarse
UNF	— 60° 美制统一细牙螺纹	UN Fine
UNEF	- 60° 美制统一超细牙螺纹	UN Extra Fine
UNJ	— 60° 美制航空航天螺纹	UNJ
BSW	— 55° 英国惠氏粗牙螺纹	Whit.Coarse
BSF	— 55° 英国惠氏细牙螺纹	Whit.Fine
BSPT	- 55° 英制标准锥管螺纹	BSPT
BSP	— 55° 英制标准管螺纹	BSP
NPT	— 60° 美国标准锥管螺纹	NPT
NPTF	- 60° 美制干密封螺纹	NPTF

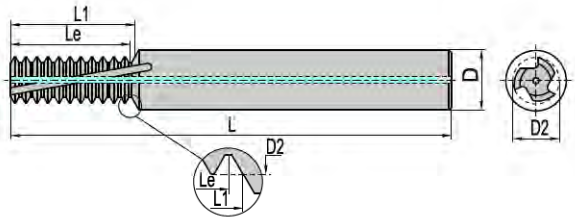
8、涂层种类 Coating type

DT3-适用于碳钢，通用材料
First choice for carbon steel and ordinary steel process
DLT9-适用于不锈钢及难加工材料
Excellent for stainless steel and difficult operations

ISO标准螺纹 ISO Metric Full Profile

内螺纹 Internal





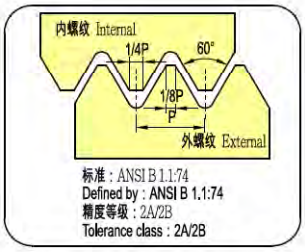
螺旋槽带内冷却直孔螺纹铣刀 Helical Flutes With Thru-Hole Coolant

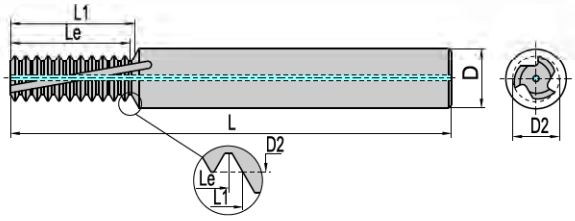
1.5×D0 (Le≤1.5×螺纹直径)
1.5×D0 (Le≤1.5×Thread Diameter)

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)					槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	细牙 Fine	mm	内螺纹刀 Internal	D	D2	L	Le	L1	Z	Zt	mm
M3×0.5	(M3.5-M16)×0.5	0.50	RH04024I0.50 ISO	4	2.40	45	4.5	4.7	3	9	2.5
M4×0.7	—	0.70	RH04031I0.70 ISO	4	3.15	45	6.3	6.6			3.3
M5×0.8	—	0.80	RH04039I0.80 ISO	4	3.90	45	7.2	7.6			4.2
M6×1.0	(M8-M40)×1.0	1.00	RH06048I1.00 ISO	6	4.80	57	9.0	9.5			5.0
M8×1.25	—	1.25	RH08065I1.25 ISO	8	6.50	61	12.5	13.1		10	6.8
M10×1.5	(M12-M48)×1.5	1.50	RH10082I1.50 ISO	10	8.20	73	15.0	15.7			8.5
M12×1.75	—	1.75	RH10099I1.75 ISO	10	9.90	73	17.5	18.4	4		10.2
M14×2.0	(M17-M80)×2.0	2.00	RH12116I2.00 ISO	12	11.60	73	20.0	21.0			12.0
M16×2.0	—	2.00	RH14136I2.00 ISO	14	13.60	92	24.0	25.0		12	14.0

UN-60°美制统一螺纹 UN-60° American UN Full Profile

内螺纹 Internal





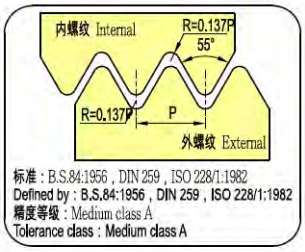
螺旋槽带内冷却直孔螺纹铣刀 Helical Flutes With Thru-Hole Coolant

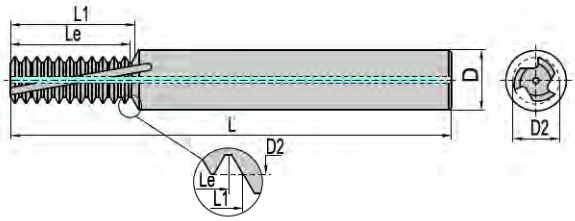
1.5×D0 (Le≤1.5×螺纹直径)
1.5×D0 (Le≤1.5×Thread Diameter)

螺纹 Thread			螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)					槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
UNC	UNF	UNEF	TPI	内螺纹刀 Internal	D	D2	L	Le	L1	Z	Zt	mm
NO.10-24	(5/16″,3/8″)-24	(9/16″-11/16″)×24	24	RH04035I24 UN	4	3.58	45	7.4	7.9	3	7	3.8
NO.10-24	(5/16″,3/8″)-24	(9/16″-11/16″)×24	24	RH06041I24 UN	6	4.15	57	8.5	9.0		8	4.5
1/4″-20	(7/16″,1/2″)-20	(3/4″,1″)-20	20	RH06048I20 UN	6	4.88	57	8.9	9.5		7	5.2
5/16″-18	(9/16″,5/8″)-18	(11/16″-1 11/16″)-18	18	RH08061I18 UN	8	6.15	61	11.3	12.0		8	6.5
3/8″-16	3/4″-16	—	16	RH08076I16 UN	8	7.65	61	14.3	15.1		9	8.0
7/16″-14	7/8″-14	—	14	RH10090I14 UN	10	9.00	73	16.3	17.2		9	9.3
1/2″-13	—	—	13	RH12104I13 UN	12	10.35	73	19.5	20.5	4	10	10.8
9/16″-12	(1″-1 1/2″)-12	—	12	RH12118I12 UN	12	11.80	73	21.2	22.2		10	12.3

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

内螺纹 Internal 外螺纹 External





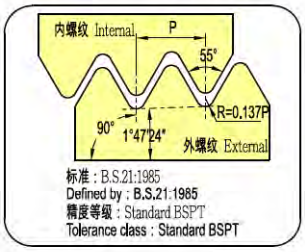
螺旋槽带内冷却直孔螺纹铣刀 Helical Flutes With Thru-Hole Coolant

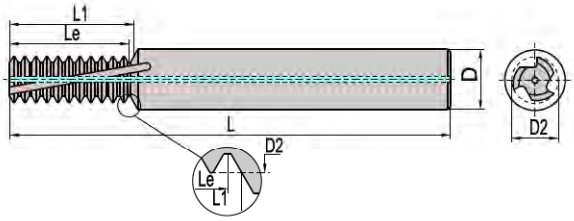
1.5×D0（Le≤1.5×螺纹直径）
1.5×D0（Le≤1.5×Thread Diameter）

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)					槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
BSW	BSF	TPI	内外通用 Internal+External	D	D2	L	Le	L1	Z	Zt	mm
—	1/4″-26	26	RH06050EI26 W	6	5.00	57	12.7	13.2	3	13	5.3
—	5/16″-22	22	RH08063EI22 W	8	6.35	61	16.2	16.7		14	6.7
1/4″-20	3/8″-20	20	RH06044EI20 W	6	4.45	57	12.7	13.3		10	5.0
—	3/8″-20	20	RH08076EI20 W	8	7.65	61	19.0	19.7		15	8.2
5/16″-18	7/16″-18	18	RH6058EI18 W	6	5.85	57	15.5	16.2		11	6.5
—	7/16″-18	18	RH10092EI18 W	10	9.20	73	22.6	23.3		16	9.7
3/8″-16	(1/2″,9/16″)-16	16	RH08072EI16 W	8	7.20	61	19.0	19.8		12	7.9
—	(1/2″,9/16″)-16	16	RH12105EI16 W	12	10.50	80	25.4	26.2	4	16	11.1
—	9/16″-16	16	RH14122EI16 W	14	12.15	92	28.6	29.4		18	12.6
7/16″-14	(5/8″,11/16″)-14	14	RH10085EI14 W	10	8.50	73	21.8	22.7	3	12	9.2
—	(5/8″,11/16″)-14	14	RH14134EI14 W	14	13.40	92	30.8	31.7	4	17	14.0
—	11/16″-14	14	RH16150EI14 W	16	15.00	92	34.5	35.4		19	15.6
1/2″-12	3/4″-12	12	RH10096EI12 W	10	9.65	73	25.4	26.5	3	12	10.5
9/16″-12	3/4″-12	12	RH12113EI12 W	12	11.25	80	27.5	28.6	4	13	12.1
—	3/4″-12	12	RH18162EI12 W	18	16.20	102	38.1	39.2		18	16.8
5/8″-11	7/8″-11	11	RH14126EI11 W	14	12.60	92	32.3	33.5		14	13.4
11/16″-11	—	11	RH16142EI11 W	16	14.20	92	34.6	35.8		15	15.0

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

内螺纹 Internal 外螺纹 External



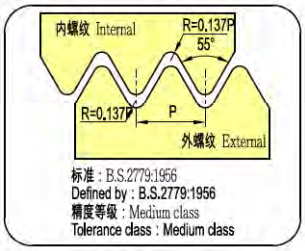


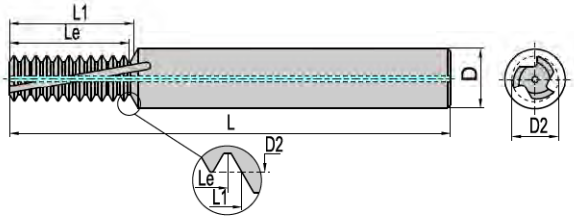
螺旋槽带内冷却直孔螺纹铣刀 Helical Flutes With Thru-Hole Coolant

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	L1	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
1/16″-28	28	RH06059EI28 BSPT	6	5.90	57	10.0	10.2	3	11	6.7
1/8″-28	28	RH08076EI28 BSPT	8	7.65	61	10.0	10.2		11	8.7
1/4″-19	19	RH10099EI19 BSPT	10	9.90	73	14.7	15.4		11	11.8
3/8″-19	19	RH12111EI19 BSPT	12	11.15	73	14.7	15.4	4	11	15.2
(1/2″,3/4″)-14	14	RH16142EI14 BSPT	16	14.25	92	21.8	22.7		12	19.0
(1″,1 1/2″,2″,2 1/2″)-11	11	RH20196EI11 BSPT	20	19.60	102	27.7	28.9		12	30.7

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

内螺纹 Internal 外螺纹 External



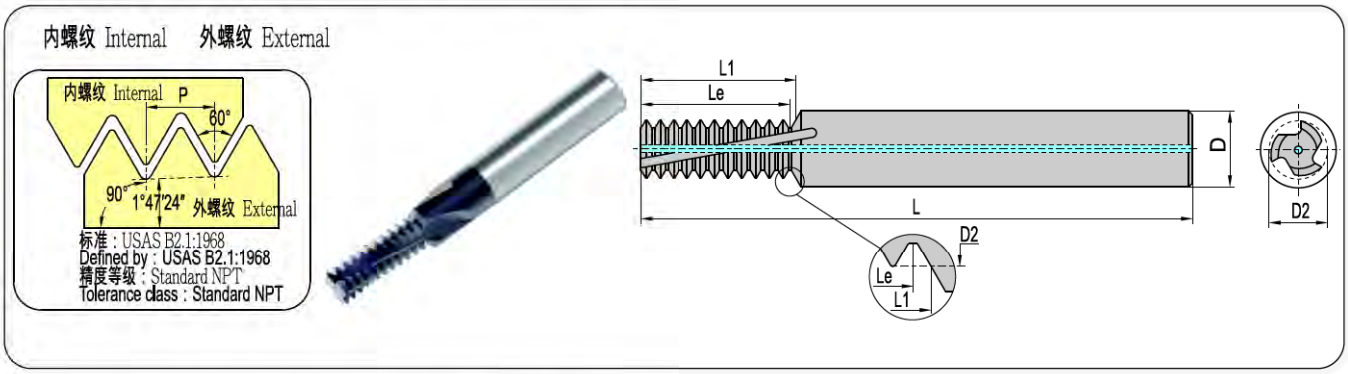


螺旋槽带内冷却直孔螺纹铣刀 Helical Flutes With Thru-Hole Coolant

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

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	L1	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
(1/16″,1/8″)-28	28	RH08064EI28 BSP	8	6.40	61	11.8	12.2	3	13	6.7
1/8″-28	28	RH10082EI28 BSP	10	8.20	73	14.5	15.0		16	8.7
(1/4″,3/8″)-19	19	RH12110EI19 BSP	12	11.00	80	20.0	20.7	4	15	11.8
3/8″-19	19	RH16145EI19 BSP	16	14.50	92	25.4	26.1		19	15.2
(1″-4″)-11	11	RH20199EI11 BSP	20	19.90	102	41.6	42.7		18	30.7

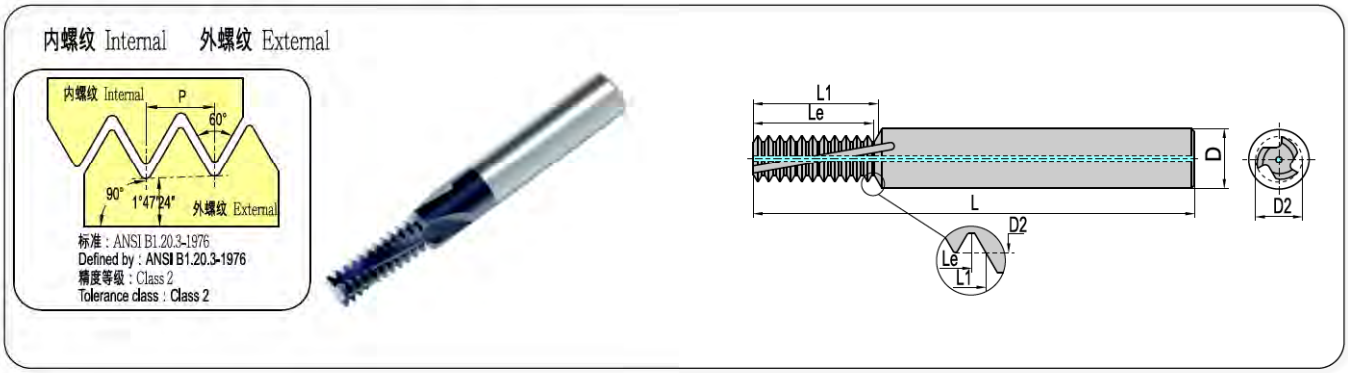
NPT-60°美国标准锥管螺纹 NPT-60° American National Pipe Threads



螺旋槽带内冷却直孔螺纹铣刀 Helical Flutes With Thru-Hole Coolant

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	L1	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
1/16"-27	27	RH06059EI27 NPT	6	5.90	57	9.4	9.9	3	10	6.3
1/8"-27	27	RH08076EI27 NPT	8	7.65	61	9.4	9.9		10	8.5
1/4"-18	18	RH10099EI18 NPT	10	9.90	73	14.1	14.8		10	11.1
3/8"-18	18	RH12111EI18 NPT	12	11.15	73	14.1	14.8	4	10	14.5
(1/2",3/4")-14	14	RH16142EI14 NPT	16	14.25	92	18.1	19		10	17.7，23.0
(1",1 1/4",1 1/2",2")-11.5	11.5	RH20196EI11.5 NPT	20	19.60	102	22.1	23.2		10	29.0，37.7，44.0，56.0
(2 1/2",3")-8	8	RH20196EI8 NPT	20	19.60	102	31.7	33.3		10	66.5，82.1

NPTF美制干密封锥管螺纹 American NPTF

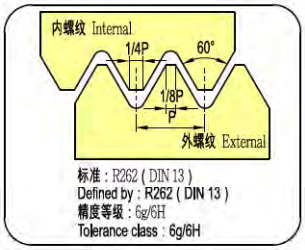


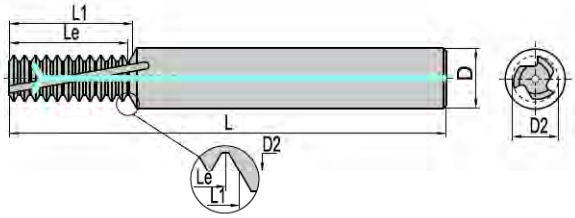
螺旋槽带内冷却直孔螺纹铣刀 Helical Flutes With Thru-Hole Coolant

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	L1	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
1/16"-27	27	RH06059EI27 NPTF	6	5.90	57	9.4	9.9	3	10	6.3
1/8"-27	27	RH08076EI27 NPTF	8	7.65	61	9.4	9.9		10	8.5
1/4"-18	18	RH10099EI18 NPTF	10	9.90	73	14.1	14.8		10	11.1
3/8"-18	18	RH12111EI18 NPTF	12	11.15	73	14.1	14.8	4	10	14.5
(1/2",3/4")-14	14	RH16142EI14 NPTF	16	14.25	92	18.1	19		10	17.7，23.0
(1",1 1/4",1 1/2",2")-11.5	11.5	RH20196EI11.5 NPTF	20	19.60	102	22.1	23.2		10	29.0，37.7，44.0，56.0
(2 1/2",3")-8	8	RH20196EI8 NPTF	20	19.60	102	31.7	33.3		10	66.5，82.1

ISO标准螺纹 ISO Metric Full Profile

内螺纹 Internal





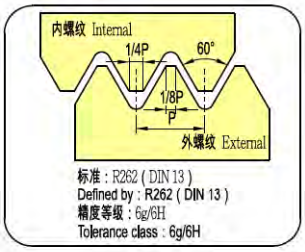
螺旋槽带内冷却斜孔螺纹铣刀 Helicool-R Helical Flutes With Radial Cooling

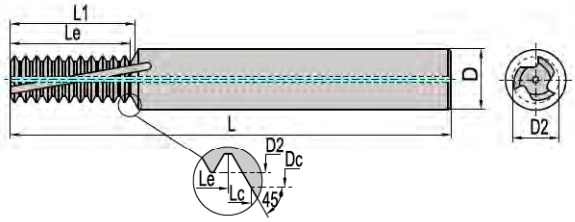
2×D0 (Le≤2×螺纹直径)
2×D0 (Le≤2×Thread Diameter)

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)					槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	细牙 Fine	mm	内螺纹刀 Internal	D	D2	L	Le	L1	Z	Zt	mm
M6×1.0	(M8-M40)×1.0	1.00	RHR06048I1.00 ISO	6	4.8	57	12.0	12.5	3	12	5.0
—	M10×1.0	1.00	RHR10087I1.00 ISO	10	8.7	73	20.0	20.5		20	9.0
—	M12×1.0	1.00	RHR12107I1.00 ISO	12	10.7	73	24.0	24.5	4	24	11.0
M8×1.25	—	1.25	RHR08065I1.25 ISO	8	6.5	64	16.3	16.9	3	13	6.8
M10×1.5	(M12-M48)×1.5	1.50	RHR10082I1.50 ISO	10	8.2	73	19.5	20.3		13	8.5
—	M12×1.5	1.50	RHR10099I1.50 ISO	10	9.9	73	24.0	24.8	4	16	10.5
—	M14×1.5	1.50	RHR12119I1.50 ISO	12	11.9	84	28.5	29.3		19	12.5
—	M16×1.5	1.50	RHR14139I1.50 ISO	14	13.9	84	31.5	32.3		21	14.5
M12×1.75	—	1.75	RHR10099I1.75 ISO	10	9.9	73	24.5	25.4		14	10.2

ISO标准螺纹 ISO Metric Full Profile

内螺纹 Internal



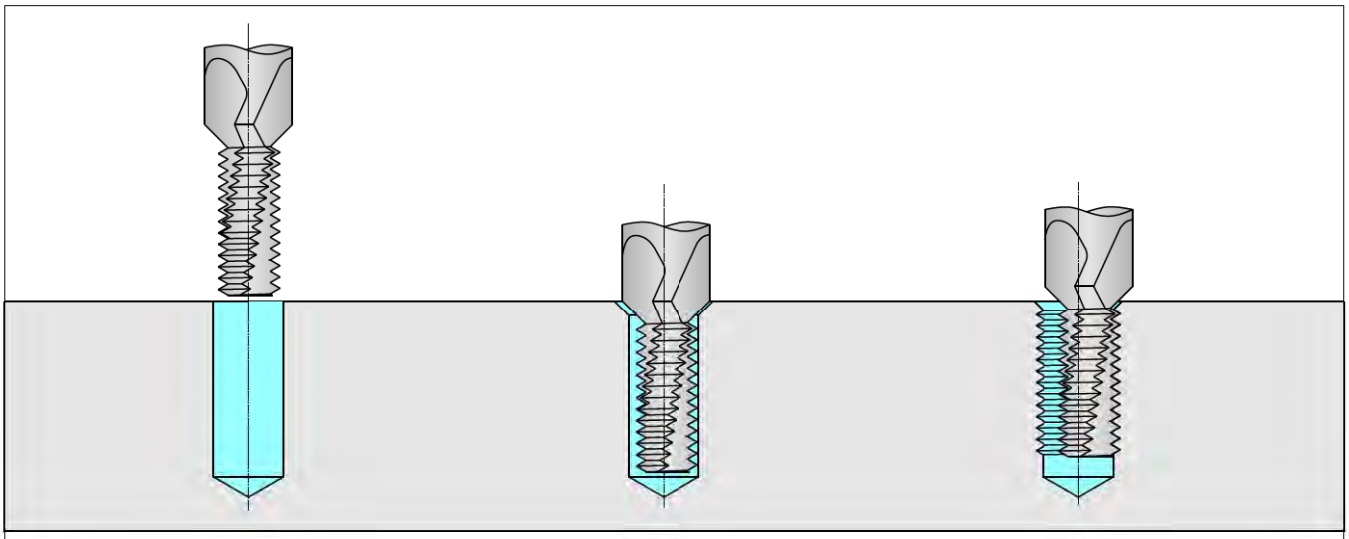


螺旋槽带内冷却直孔并带倒角功能螺纹铣刀 Helicool C(RHC) Flutes With Axial Coolant-Thru&Chamfer

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

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)							槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	细牙 Fine	mm	内螺纹刀 Internal	D	D2	Dc	L	Le	L1	Lc	Z	Zt	mm
M6×1.0	(M8-M40)×1.0	1.00	RHC08048I1.00 ISO	8	4.8	6.3	61	12.0	12.5	13.3	3	12	5.0
—	M10×1.0	1.00	RHC12087I1.00 ISO	12	8.7	10.3	73	20.0	20.5	21.3		20	9.0
—	M12×1.0	1.00	RHC14107I1.00 ISO	14	10.7	12.3	80	24.0	24.5	25.3	4	24	11.0
M8×1.25	—	1.25	RHC10065I1.25 ISO	10	6.5	8.3	73	16.3	16.9	17.8	3	13	6.8
M10×1.5	(M12-M48)×1.5	1.50	RHC12082I1.50 ISO	12	8.2	10.3	80	19.5	20.3	21.3		13	8.5
—	M12×1.5	1.50	RHC14099I1.50 ISO	14	9.9	12.3	80	24.0	24.8	26.0	4	16	10.5
—	M14×1.5	1.50	RHC16199I1.50 ISO	16	11.9	14.3	92	28.5	29.3	30.5		19	12.5
—	M16×1.5	1.50	RHC18139I1.50 ISO	18	13.9	16.3	92	31.5	32.3	33.5		21	14.5
M12×1.75	—	1.75	RHC14099I1.75 ISO	14	9.9	12.3	80	24.5	25.4	26.6		14	10.2

RHC-加工示意图 Operating Cycle



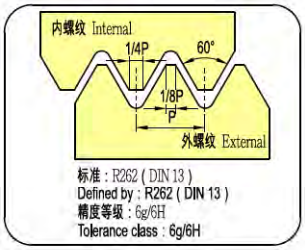
1
定 位
Positioning

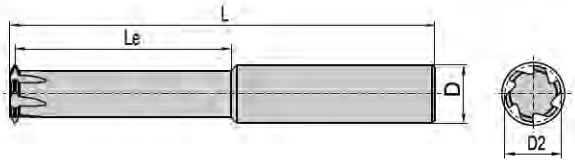
2
倒 角
Chamfering

3
铣螺纹
Thread Milling

ISO标准螺纹 ISO Metric Full Profile

内螺纹 Internal

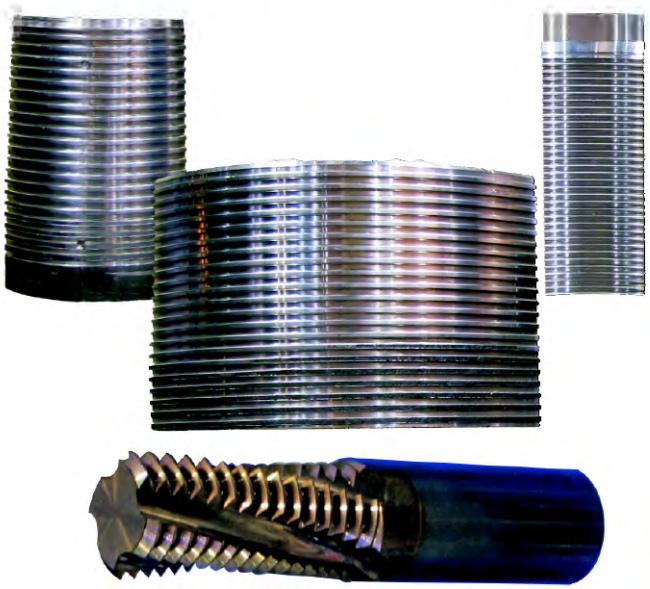




深孔螺纹铣刀 Deep Threading-Long Tools For Deep Holes

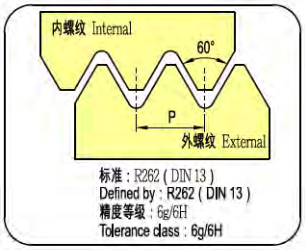
3×D0 (Le≤3×螺纹直径)
3×D0 (Le≤3×Thread Diameter)

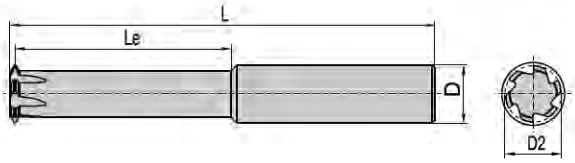
螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	mm	内螺纹刀 Internal	D	D2	L	Le	Z	Zt	mm
M6×1	1.00	RDH1T08041I1.00 ISO	8	4.1	63	19	3	1	5.0
M8×1.25	1.25	RDH1T10058I1.25 ISO	10	5.8	73	26			6.8
M10×1.5	1.50	RDH1T10077I1.50 ISO	10	7.7	73	32			8.5
M12×1.5	1.50	RDH1T10094I1.50 ISO	10	9.4	83	38	4		10.5
M12×1.75	1.75	RDH1T10087I1.75 ISO	10	8.7	83	38			10.2
M14×2.0	2.00	RDH1T12102I2.00 ISO	12	10.2	92	44			12.0
M16×2.0	2.00	RDH1T14122I2.00 ISO	14	12.2	100	50			14.0
M18×2.5	2.50	RDH1T14129I2.50 ISO	14	12.9	108	57	5		15.5
M20×2.5	2.50	RDH1T16148I2.50 ISO	16	14.8	114	63			17.5



范围牙型60° Partial Profile 60°

内螺纹 Internal





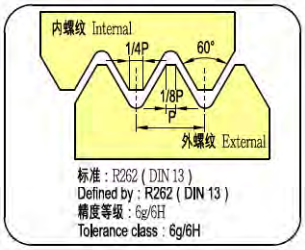
深孔螺纹铣刀 Deep Threading-Long Tools For Deep Holes

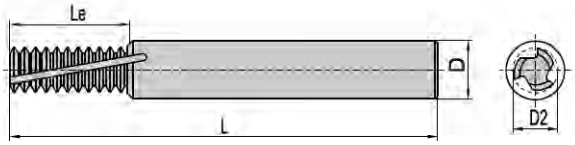
3×D0 (Le≤3×螺纹直径)
3×D0 (Le≤3×Thread Diameter)

螺纹 Thread			螺距 Pitch		订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
粗牙 Coarse	细牙 Fine	UN,UNF,UNEF,UNS	mm	TPI	内螺纹刀 Internal	D	D2	L	Le	Z	Zt
M5×0.8	M5×0.5,M5×0.75	NO.10-56UNS,NO.10-48UNS,NO.10-40UNS, NO.10-36UNS,NO.10-32UNF	0.5-0.8	32-56	RDH1T04390IA60	4	3.9	45	16	4	1
M6×1.0	M6×0.5,M6×0.75	NO.12-56UNS,NO.12-48UNS,1/4-40UNS, 1/4"36UNS,1/4"-32UNEF,1/4"28UNF, 1/4"-27UNS,1/4"-24UNS	0.5-1.0	24-56	RDH1T06485IB60	6	4.85	51	20	5	
M8×1.25	M7×0.5,M7×0.75, M7.5×1.0	5/16"-48UNS,5/16"-40UNS,5/16"-36UNS, 5/16"-32UEF,5/16"-28UN,5/16"-27UNS, 5/16"-24UNS,5/16"-20UN	0.5-1.25	20-48	RDH1T06590IF60	6	5.9	64	25	5	
—	M10.5×0.5,M11×0.75, M11×1.0	7/16"-32UN,7/16"-28UNEF, 7/16"-27UNS,7/16"-24UNS	0.5-1.0	24-56	RDH1T10990IB60	10	9.9	73	35	6	
M10×1.5	M10×1.0,M10×1.25	3/8"-24UNF,3/8"-20UN, 7/16"-18UNS,7/16"-16UN	1.0-1.50	16-24	RDH1T08790IC60	8	7.9	63	32	6	
M12×1.75	M12×1.0,M12×1.25, M12×1.5	1/2"-24UNS,1/2"-UNS,1/2"-18UNS, 1/2"-16UNS,1/2"-14UNS	1.0-1.75	14-24	RDH1T10990ID60	10	9.9	73	38	6	
—	M13.5×1.0,M14×1.25, M14×1.5	9/16"-24UNEF	1.0-1.75	14-24	RDH1T12119ID60	12	11.90	83	45	6	

ISO标准螺纹 ISO Metric Full Profile

内螺纹 Internal





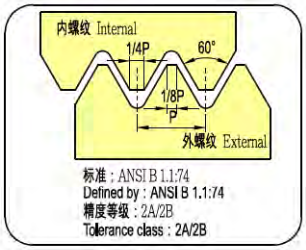
螺旋槽无冷却孔内螺纹铣刀 Helical Flutes Without Coolant Thru-Internal

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

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
粗牙 Coarse	细牙 Fine	mm	内螺纹刀 Internal	D	D2	L	Le	Z	Zt	mm
M3×0.5	M3.5-M16×0.5	0.5	R04022I0.5 ISO	4	2.2	45	6	3	12	2.5
—	M4×0.5	0.5	R04030I0.5 ISO	4	3	45	8	3	16	3.5
—	M5×0.5	0.5	R04039I0.5 ISO	4	3.9	45	10	3	20	4.5
M4×0.7	—	0.7	R04028I0.7 ISO	4	2.8	45	8.4	3	12	3.3
—	M6×0.75	0.75	R04039I0.7 ISO	4	3.9	45	12	3	16	5.3
M5×0.8	—	0.8	R04035I0.8 ISO	4	3.5	45	10.4	3	13	4.2
M6×1.0	M8-M40×1.0	1.0	R04039I1.0 ISO	4	3.9	45	12	3	12	5
—	M8×1.0	1.0	R06059I1.0 ISO	6	5.9	57	16	3	16	7
—	M10×1.0	1.0	R08079I1.0 ISO	8	7.9	63	20	3	20	9
—	M12×1.0	1.0	R10099I1.0 ISO	10	9.9	73	24	4	24	11
M8×1.25	—	1.25	R06058I1.25 ISO	6	5.8	57	16.25	3	13	6.8
—	M10×1.25	1.25	R08077I1.25 ISO	8	7.7	63	20	3	16	8.8
M10×1.5	M12-M48×1.5	1.5	R08077I1.5 ISO	8	7.7	63	21	3	14	8.5
—	M12×1.5	1.5	R10094I1.5 ISO	10	9.4	73	24	4	16	10.5
—	M14×1.5	1.5	R12112I1.5 ISO	12	11.2	83	28.5	4	19	12.5
—	M16×1.5	1.5	R12119I1.5 ISO	12	11.9	83	33	4	22	14.5
M12×1.75	—	1.75	R10087I1.75 ISO	10	8.7	73	24.5	4	14	10.2
M14×2.0	M17-M80×2.0	2.0	R10099I2.0 ISO	10	9.9	73	28	4	14	12
M16×2.0	M17-M80×2.0	2.0	R12119I2.0 ISO	12	11.9	83	32	4	16	14
M18-M22×2.5	—	2.5	R16139I2.5 ISO	16	13.9	92	40	5	16	15.5
M24×3.0	—	3.0	R16159I3.0 ISO	16	15.9	92	42	4	16	21

UN-60°美制统一螺纹 UN-60° American UN Full Profile

外螺纹 External



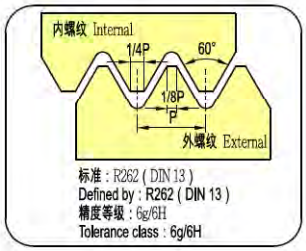
螺旋槽无冷却孔外螺纹铣刀 Helical Flutes Without Coolant Thru-External

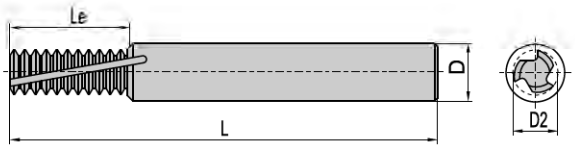
2×D0（Le≤2×螺纹直径）
2×D0（Le≤2×Thread Diameter）

螺纹 Thread		螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
UNC	UNF	TPI	外螺纹刀 External	D	D2	L	Le	Z	Zt
NO.8-32		32	R04039E32 UN	4	3.9	45	8.7	3	11
	NO.12-28	28	R04039E28 UN	4	3.9	45	11.8		13
NO.12-24		24	R04039E24 UN	4	3.9	45	11.6		11
1/4″-20		20	R04039E20 UN	4	3.9	45	12.7		10
5/16″-18		18	R06059E18 UN	6	5.9	57	16.9		12
3/8″-16		16	R08079E16 UN	8	7.9	63	19.1		12
9/16″-12		12	R12119E12 UN	12	11.9	83	29.6	4	14

ISO标准螺纹 ISO Metric Full Profile

外螺纹 External





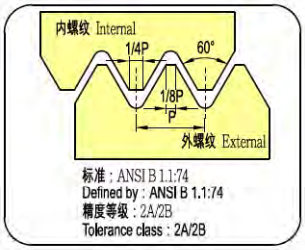
螺旋槽无冷却孔外螺纹铣刀 Helical Flutes Without Coolant Thru-External

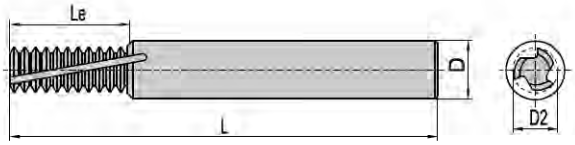
2×D0（Le≤2×螺纹直径）
2×D0（Le≤2×Thread Diameter）

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
粗牙 Coarse	mm	外螺纹刀 External	D	D2	L	Le	Z	Zt
M3×0.5	0.50	R04039E0.50 ISO	4	3.9	45	6	3	12
M4.5×0.75	0.75	R04039E0.75 ISO	4	3.9	45	9		12
M6×1.0	1.00	R04039E1.00 ISO	4	3.9	45	12		12
M8×1.25	1.25	R06059E1.25 ISO	6	5.9	57	16.25		13
M10×1.5	1.50	R08079E1.50 ISO	8	7.9	63	21		14
M14×2.0	2.00	R10099E2.00 ISO	10	9.9	73	28	4	14

UN-60°美制统一螺纹 UN-60° American UN Full Profile

内螺纹 Internal





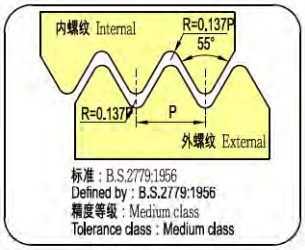
螺旋槽无冷却孔内螺纹铣刀 Helical Flutes Without Coolant Thru-Internal

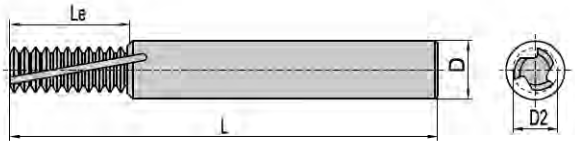
2×D0（Le≤2×螺纹直径）
2×D0（Le≤2×Thread Diameter）

螺纹 Thread			螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth	加工孔径 Bore Dia.
UNC	UNF	UNEF	TPI	内螺纹刀 Internal	D	D2	L	Le	Z	Zt	mm
	NO.8-32		36	R04030I36 UN	4	3	45	8.5	3	12	3.5
	NO.10-32	NO.12，3/8″-32	32	R04033I32 UN	4	3.3	45	11.1	3	14	4
	NO.12-28，1/4″-28	7/16″,1/2″-28	28	R04038I28 UN	4	3.8	45	11.8	3	13	4.6
	1/4″-28	7/16″,1/2″-28	28	R06046I28 UN	6	4.6	57	12.7	3	14	5.5
		7/16″,1/2″-28	28	R10092I28 UN	10	9.2	73	22.7	4	25	10.2
NO.10-24	5/16″,3/8″-24	9/16″,11/16″-24	24	R04029I24 UN	4	2.9	45	10.6	3	10	3.8
NO.12-24	5/16″,3/8″-24	9/16″,11/16″-24	24	R04035I24 UN	4	3.5	45	11.6	3	11	4.5
	5/16″,3/8″-24	9/16″,11/16″-24	24	R06057I24 UN	6	5.7	57	15.9	3	15	6.8
	3/8″-24	9/16″,11/16″-24	24	R08074I24 UN	8	7.4	63	19.1	3	18	8.5
		9/16″,11/16″-24	24	R12119I24 UN	12	11.9	83	28.6	4	27	13.2
1/4″-20	7/16″,1/2″-20	3/4″,1″-20	20	R04039I20 UN	4	3.9	45	12.7	3	10	5.2
	7/16″,1/2″-20	3/4″,1″-20	20	R10085I20 UN	10	8.5	73	22.9	4	18	9.8
	1/2″-20	3/4″,1″-20	20	R10099I20 UN	10	9.9	73	25.4	4	20	11.5
		3/4″,1″-20	20	R16159I20 UN	16	15.9	92	38.1	5	30	17.8
5/16″-18	9/16″,5/8″-18	11/16″,1 11/16″-18	18	R06052I18 UN	6	5.2	57	16.9	3	12	6.5
	9/16″,5/8″-18	11/16″,1 11/16″-18	18	R12113I18 UN	12	11.3	83	29.6	4	21	12.8
	5/8″-18	11/16″,1 11/16″-18	18	R12119I18 UN	12	11.9	83	32.5	4	23	14.5
3/8″-16	3/4″-16		16	R08067I16 UN	8	6.7	63	19.1	3	12	8
	3/4″-16		16	R16159I16 UN	16	15.9	92	38.1	4	24	17.5
7/16″-14	7/8″-14		14	R08076I14 UN	8	7.6	63	23.6	4	13	9.3
	7/8″-14		14	R20187I14 UN	20	18.7	104	44.4	4	24	20.5
1/2″-13			13	R10089I13 UN	10	8.9	73	25.4	4	13	10.8
9/16″-12	1″,1 1/2″-12		12	R12103I12 UN	12	10.3	83	29.6	4	14	12.3
	1″,1 1/2″-12		12	R20199I12 UN	20	19.9	104	5.08	5	24	23.5
5/8″-11			11	R12110I11 UN	12	11	83	32.3	4	14	13.5
3/4″-10			10	R16135I10 UN	16	13.5	92	38.1	5	15	16.5
7/8″-9			9	R16152I9 UN	16	15.2	92	45.2	4	16	19.5
1″-8			8	R20170I8 UN	20	17	104	50.8	4	16	22

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

内螺纹 Internal 外螺纹 External





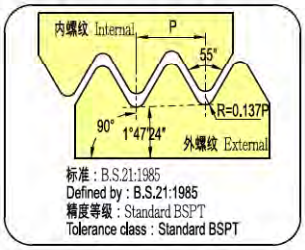
螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru-Internal and External

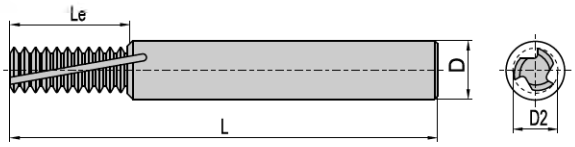
2×D0（Le≤2×螺纹直径）
2×D0（Le≤2×Thread Diameter）

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
(1/16″,1/8″)-28	28	R06058EI28 BSP	6	5.8	57	16.3	3	18	6.7
1/8″-28	28	R08077EI28 BSP	8	7.7	63	20	3	22	8.7
(1/4″,3/8″)-19	19	R10099EI19 BSP	10	9.9	73	26.7	4	20	11.8
3/8″-19	19	R16134EI19 BSP	16	13.4	92	33.4	4	25	15.2
(1/2″,3/4″)-14	14	R16157EI14 BSP	16	15.7	92	43.5	5	24	19
(1″,1 1/2″,2″,2 1/2″)-11	11	R20199EI11 BSP	20	19.9	104	41.6	5	18	30.7

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

内螺纹 Internal 外螺纹 External





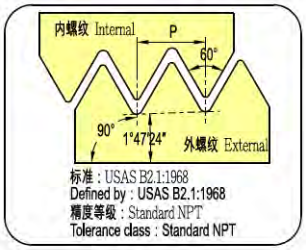
螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru-Internal and External

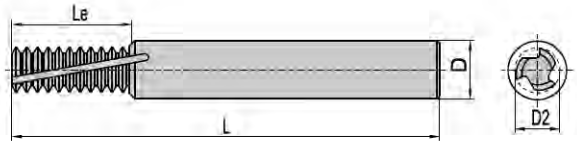
2×D0（Le≤2×螺纹直径）
2×D0（Le≤2×Thread Diameter）

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
1/16″-28	28	R06058EI28 BSPT	6	5.8	57	16.3	3	18	6.7
1/8″-28	28	R08077EI28 BSPT	8	7.7	63	20	3	22	8.7
1/4″-19	19	R10099EI19 BSPT	10	9.9	73	26.7	4	20	11.8
3/8″-19	19	R16134EI19 BSPT	16	13.4	92	33.4	4	25	15.2
(1/2″,3/4″)-14	14	R16157EI14 BSPT	16	15.7	92	43.5	5	24	19
(1″,1 1/2″,2″,2 1/2″)-11	11	R20199EI11 BSPT	20	19.9	104	41.6	5	18	30.7

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

内螺纹 Internal 外螺纹 External



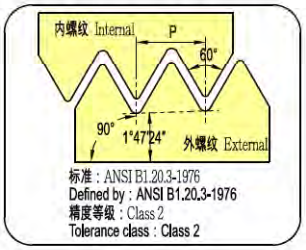


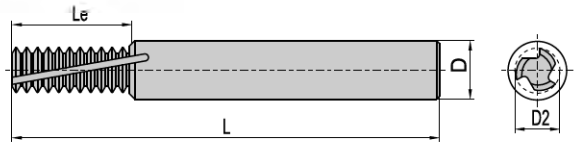
螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru-Internal and External

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
1/16″-27	27	R06053EI27 NPT	6	5.3	57	9.4	3	10	6.3
1/8″-27	27	R08075EI27 NPT	8	7.5	63	9.4		10	8.5
1/4″-18	18	R10094EI18 NPT	10	9.4	73	14.1	4	10	11.1
3/8″-18	18	R12119EI18 NPT	12	11.9	83	14.1		10	14.5
(1/2″,3/4″)-14	14	R16155EI14 NPT	16	15.5	92	25.4	5	14	17.7，23.0
(1″,2″)-11.5	11.5	R20199EI11.5 NPT	20	19.9	104	33.1	5	15	29.0-56.0
(2 1/2″,3″)-8	8	R20199EI8 NPT	20	19.9	104	38.1	4	12	66.5

NPTF美制干密封锥管螺纹 American NPTF

内螺纹 Internal 外螺纹 External



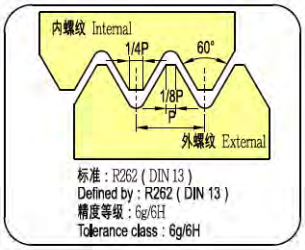


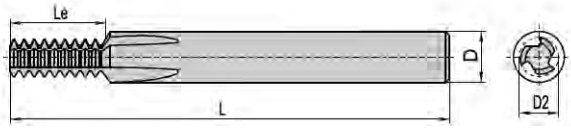
螺旋槽无冷却孔内、外螺纹铣刀 Helical Flutes Without Coolant Thru-Internal and External

螺纹 Thread	螺距 Pitch TPI	订货号 Order No. 内外通用 Internal+External	尺寸(mm) Dimensions(mm) D	D2	L	Le	槽数 No.of Flutes Z	齿数 Teeth Zt	加工孔径 Bore Dia. mm
1/16″-27	27	R06053EI27 NPTF	6	5.3	57	9.4	3	10	6.3
1/8″-27	27	R08075EI27 NPTF	8	7.5	63	9.4		10	8.5
1/4″-18	18	R10094EI18 NPTF	10	9.4	73	14.1	4	10	11.1
3/8″-18	18	R12119EI18 NPTF	12	11.9	83	14.1		10	14.5
(1/2″,3/4″)-14	14	R16155EI14 NPTF	16	15.5	92	25.4	5	14	17.7，23.0
(1″,2″)-11.5	11.5	R20199EI11.5 NPTF	20	19.9	104	33.1	5	15	29.0-56.0
(2 1/2″,3″)-8	8	R20199EI8 NPTF	20	19.9	104	38.1	4	12	66.5

ISO标准螺纹 ISO Metric Full Profile

外螺纹 External



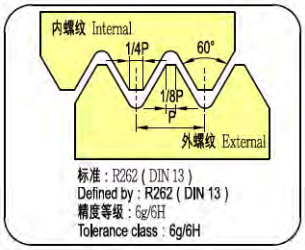


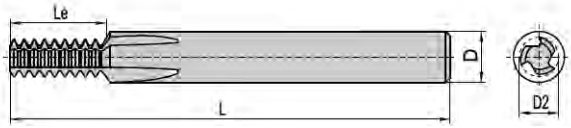
标准直槽外螺纹铣刀 Standard Straight Flutes-External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	mm	外螺纹刀 External	D	D2	L	Le	Z	Zt
M3	0.50	RS06059E0.50 ISO	6.0	5.9	57	15.0	3	30
M4.5	0.75	RS08079E0.75 ISO	8.0	7.9	63	19.5	3/5	26
M6	1.00	RS10099E1.00 ISO	10.0	9.9	72	24.0	5	24
M10	1.50	RS12119E1.50 ISO	12.0	11.9	83	30.0		20
M14	2.00	RS12119E2.00 ISO	12.0	11.9	83	30.0		15
M24	3.00	RS16159E3.00 ISO	16.0	15.9	92	36.0		12
M36	4.00	RS16159E4.00 ISO	16.0	15.9	92	40.0		10
M64	6.00	RS20199E6.00 ISO	20.0	19.9	104	36.0		6

ISO标准螺纹 ISO Metric Full Profile

内螺纹 Internal



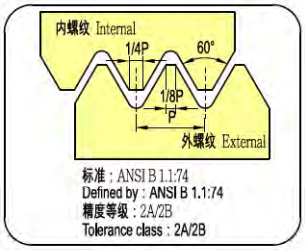


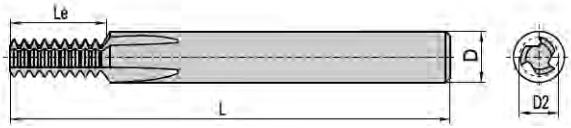
标准直槽内螺纹铣刀 Standard Straight Flutes-Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	mm	内螺纹刀 Internal	D	D2	L	Le	Z	Zt
M4.5	0.75	RS04030I0.75 ISO	4.0	3.0	42	6.7	3	9
M8	0.75	RS06059I0.75 ISO	6.0	5.9	57	15.0	3	20
M5	0.80	RS04036I0.80 ISO	4.0	3.6	42	8.0	3	10
M6	1.00	RS06040I1.00 ISO	6.0	4.0	57	9.0	3	9
M12	1.00	RS08079I1.00 ISO	8.0	7.9	63	20.0	3/5	20
M8	1.25	RS06050I1.25 ISO	6.0	5.0	57	12.5	3	10
M10	1.50	RS06059I1.25 ISO	6.0	5.9	57	15.0	3	10
M14	1.50	RS10099I1.50 ISO	10.0	9.9	72	24.0	5	16
M18	1.50	RS12119I1.50 ISO	12.0	11.9	83	30.0	5	20
M12	1.75	RS08079I1.75 ISO	8.0	7.9	63	19.2	3/5	11
M16	2.00	RS10099I2.00 ISO	10.0	9.9	72	24.0	5	12
M18	2.00	RS12119I2.00 ISO	12.0	11.9	83	30.0	5	15
M20	2.50	RS12119I2.50 ISO	12.0	11.9	83	30.0	5	12
M24	3.00	RS16159I3.00 ISO	16.0	15.9	92	36.0	5	12
M30	3.50	RS16159I3.50 ISO	16.0	15.9	92	38.5	5	11
M36	4.00	RS16159I4.00 ISO	16.0	15.9	92	40.0	5	10
M48	5.00	RS20199I5.00 ISO	20.0	19.9	104	40.0	5	8
M64	6.00	RS20199I6.00 ISO	20.0	19.9	104	36.0	5	6

UN-60°美制统一螺纹 UN-60° American UN Full Profile

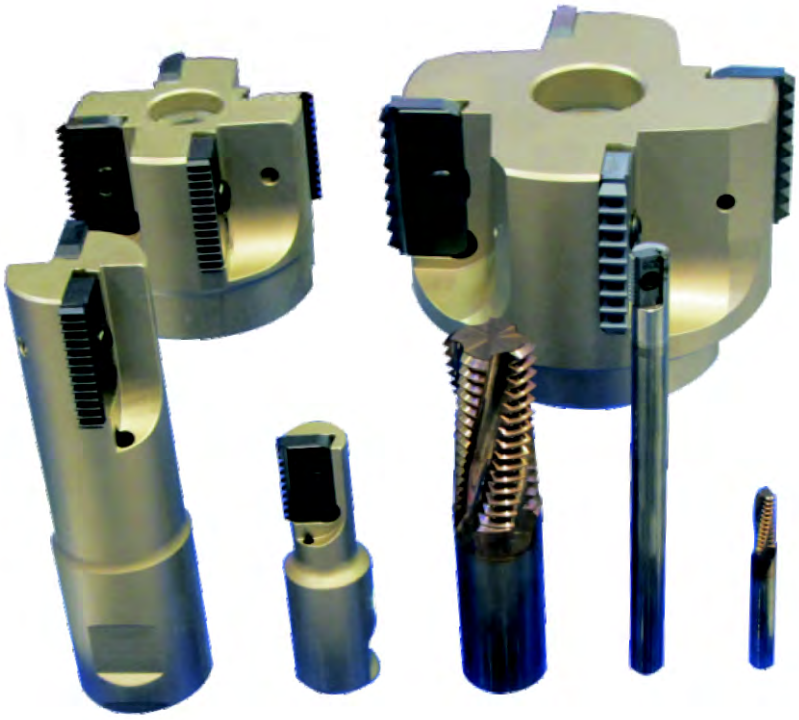
外螺纹 External





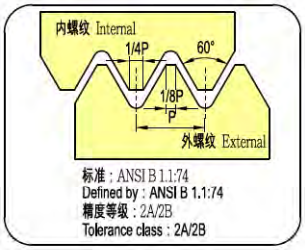
标准直槽外螺纹铣刀 Standard Straight Flutes-External

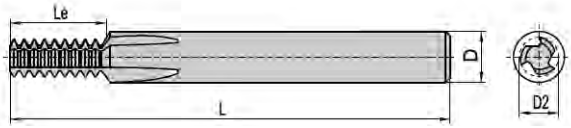
螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	外螺纹刀 External	D	D2	L	Le	Z	Zt
NO.6	32	RS06059E32 UN	6.0	5.9	57	14.3	3	18
NO.12	28	RS08079E28 UN	8.0	7.9	63	19.9	3/5	22
1/4"	20	RS10099E20 UN	10.0	9.9	72	22.9	5	18
5/16"	18	RS10099E18 UN	10.0	9.9	72	24.0	5	17
3/8"	16	RS12119E16 UN	12.0	11.9	83	28.6	5	18
9/16"	12	RS12119E12 UN	12.0	11.9	83	29.6	5	14
1"	8	RS16159E8 UN	16.0	15.9	92	38.1	5	12
1 3/8"	6	RS20199E6 UN	20.0	19.9	104	38.1	5	9



UN-60°美制统一螺纹 UN-60° American UN Full Profile

内螺纹 Internal



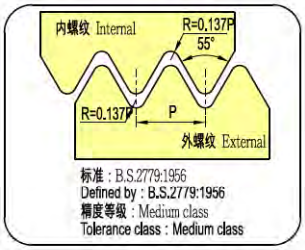


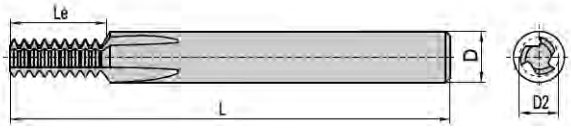
标准直槽内螺纹铣刀 Standard Straight Flutes-Internal

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	内螺纹刀 Internal	D	D2	L	Le	Z	Zt
NO.8	36	RS04030I36 UN	4.0	3.0	42	6.3	3	9
NO.8	32	RS04030I32 UN	4.0	3.0	42	6.3	3	8
5/16"	32	RS06059I32 UN	6.0	5.9	57	14.3	3	18
NO.12	28	RS04036I28 UN	4.0	3.6	42	8.2	3	9
7/16"	28	RS08079I28 UN	8.0	7.9	63	19.9	3/5	22
NO.12	24	RS06040I24 UN	6.0	4.0	57	8.5	3	8
1/4"	20	RS06040I20 UN	6.0	4.0	57	10.2	3	8
9/16"	20	RS10099I20 UN	10.0	9.9	72	22.9	5	18
5/16"	18	RS06050I18 UN	6.0	5.0	57	12.7	3	9
9/16"	18	RS10099I18 UN	10.0	9.9	72	24.0	5	17
3/8"	16	RS06059I16 UN	6.0	5.9	57	14.3	3	9
13/16"	16	RS12119I16 UN	12.0	11.9	83	28.6	5	18
7/16"	14	RS08079I14 UN	8.0	7.9	63	18.1	3/5	10
1/2"	13	RS08079I13 UN	8.0	7.9	63	19.5	3/5	10
9/16"	12	RS10099I12 UN	10.0	9.9	72	23.3	5	11
1"	12	RS12119I12 UN	12.0	11.9	83	29.6	5	14
5/8"	11	RS10099I11 UN	10.0	9.9	72	23.1	5	10
3/4"	10	RS12119I10 UN	12.0	11.9	83	27.9	5	11
7/8"	9	RS16159I9 UN	16.0	15.9	92	33.3	5	12
1"	8	RS16159I8 UN	16.0	15.9	92	38.1	5	12
1 1/8"	7	RS16159I7 UN	16.0	15.9	92	36.3	5	10
1 3/8"	6	RS20199I6 UN	20.0	19.9	104	38.1	5	9
1 3/4"	5	RS20199I5 UN	20.0	19.9	104	40.6	5	8
2"	4.5	RS20199I4.5 UN	20.0	19.9	104	39.5	5	7

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

内螺纹 Internal 外螺纹 External



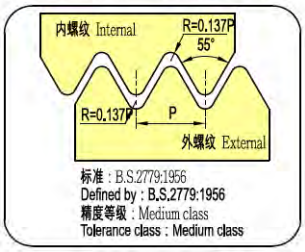


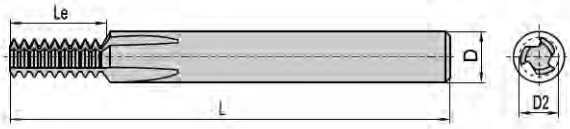
标准直槽内、外螺纹铣刀 Standard Straight Flutes-Internal and External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	内外通用 Internal+External	D	D2	L	Le	Z	Zt
1/4"	20	RS06040EI20 BSW	6.0	4.0	57	10.2	3	8
5/16"	18	RS06050EI18 BSW	6.0	5.0	57	11.3	3	8
3/8"	16	RS06059EI16 BSW	6.0	5.9	57	14.3	3	9
7/16"	14	RS08079EI14 BSW	8.0	7.9	63	18.1	3/5	10
1/2"	12	RS08079EI12 BSW	8.0	7.9	63	19.1	3/5	9
5/8"	11	RS10099EI11 BSW	10.0	9.9	72	23.1	5	10
3/4"	10	RS12119EI10 BSW	12.0	11.9	83	27.9	5	11
7/8"	9	RS12119EI9 BSW	12.0	11.9	83	28.2	5	10
1"	8	RS16159EI8 BSW	16.0	15.9	92	38.1	5	12
1 1/8"	7	RS16159EI7 BSW	16.0	15.9	92	36.3	5	10
1 3/8"	6	RS16159EI6 BSW	16.0	15.9	92	38.1	5	9
1 5/8"	5	RS20199EI5 BSW	20.0	19.9	104	40.6	5	8
1 7/8"	4.5	RS20199EI4.5 BSW	20.0	19.9	104	39.5	5	7

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

内螺纹 Internal 外螺纹 External



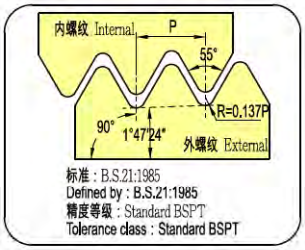


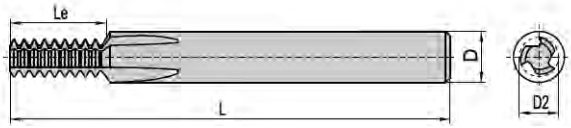
标准直槽内、外螺纹铣刀 Standard Straight Flutes-Internal and External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	内外通用 Internal+External	D	D2	L	Le	Z	Zt
1/16"	28	RS06059EI28 BSP	6.0	5.9	57	14.5	3	16
1/4"	19	RS08079EI19 BSP	8.0	7.9	63	18.7	3/5	14
1/2"	14	RS12119EI14 BSP	12.0	11.9	83	29.0	5	16
1"	11	RS16159EI11 BSP	16.0	15.9	92	34.6	5	15

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

内螺纹 Internal 外螺纹 External



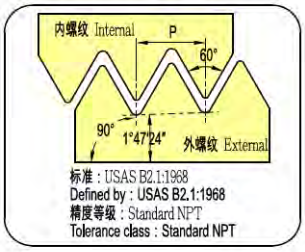


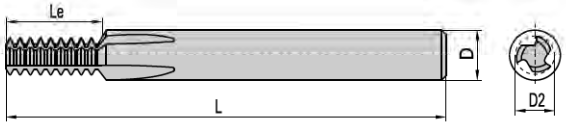
标准直槽内、外螺纹铣刀 Standard Straight Flutes-Internal and External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	内外通用 Internal+External	D	D2	L	Le	Z	Zt
1/16"	28	RS06059EI28 BSPT	6.0	5.9	57	14.5	3	16
1/4"	19	RS08079EI19 BSPT	8.0	7.9	63	18.7	3/5	14
1/2"	14	RS12119EI14 BSPT	12.0	11.9	83	29.0	5	16
1"	11	RS16159EI11 BSPT	16.0	15.9	92	34.6	5	15

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

内螺纹 Internal 外螺纹 External



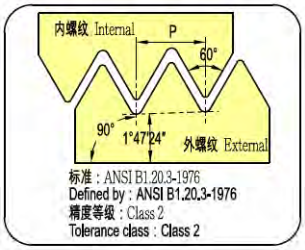


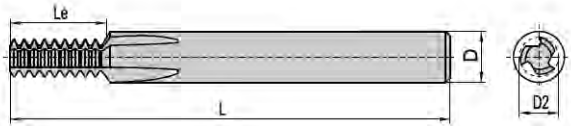
标准直槽内、外螺纹铣刀 Standard Straight Flutes-Internal and External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	内外通用 Internal+External	D	D2	L	Le	Z	Zt
1/16"	27	RS06059EI27 NPT	6.0	5.9	57	9.4	3	10
1/4"	18	RS08079EI18 NPT	8.0	7.9	63	14.1	3/5	10
1/2"	14	RS12119EI14 NPT	12.0	11.9	83	20.0	5	11
1"	11.5	RS16159EI11.5 NPT	16.0	15.9	92	26.5	5	12
2 1/2"	8	RS1615.9EI8 NPT	16.0	15.9	92	38.1	5	12

NPTF美制干密封锥管螺纹 American NPTF

内螺纹 Internal 外螺纹 External



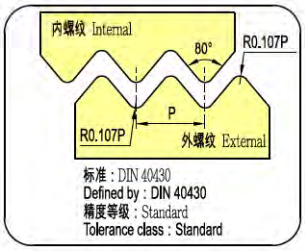


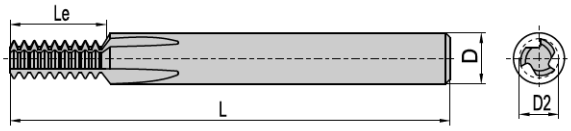
标准直槽内、外螺纹铣刀 Standard Straight Flutes-Internal and External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	内外通用 Internal+External	D	D2	L	Le	Z	Zt
1/16"	27	RS06059EI27 NPTF	6.0	5.9	57	9.4	3	10
1/4"	18	RS08079EI18 NPTF	8.0	7.9	63	14.1	3/5	10
1/2"	14	RS12119EI14 NPTF	12.0	11.9	83	20.0	5	11
1"	11.5	RS16159EI11.5 NPTF	16.0	15.9	92	26.5	5	12
2 1/2"	8	RS1615.9EI8 NPTF	16.0	15.9	92	38.1	5	12

Pg螺纹 Pg

内螺纹 Internal 外螺纹 External





标准直槽内、外螺纹铣刀 Standard Straight Flutes-Internal and External

螺纹 Thread	螺距 Pitch	订货号 Order No.	尺寸(mm) Dimensions(mm)				槽数 No.of Flutes	齿数 Teeth
最小直径 Min Dia.	TPI	内外通用 Internal+External	D	D2	L	Le	Z	Zt
Pg7	20	RS08079EI20 PG	8.0	7.9	63	19.1	3/5	15
Pg9,11,13.5,16	18	RS10099EI18 PG	10.0	9.9	72	24.0	5	17
Pg21,29,36,42,48	16	RS12119EI16 PG	12.0	11.9	83	28.6	5	18

成都戴梦迪超硬工具有限责任公司
CHENGDU DIAMOND TOOLS CO., LTD.

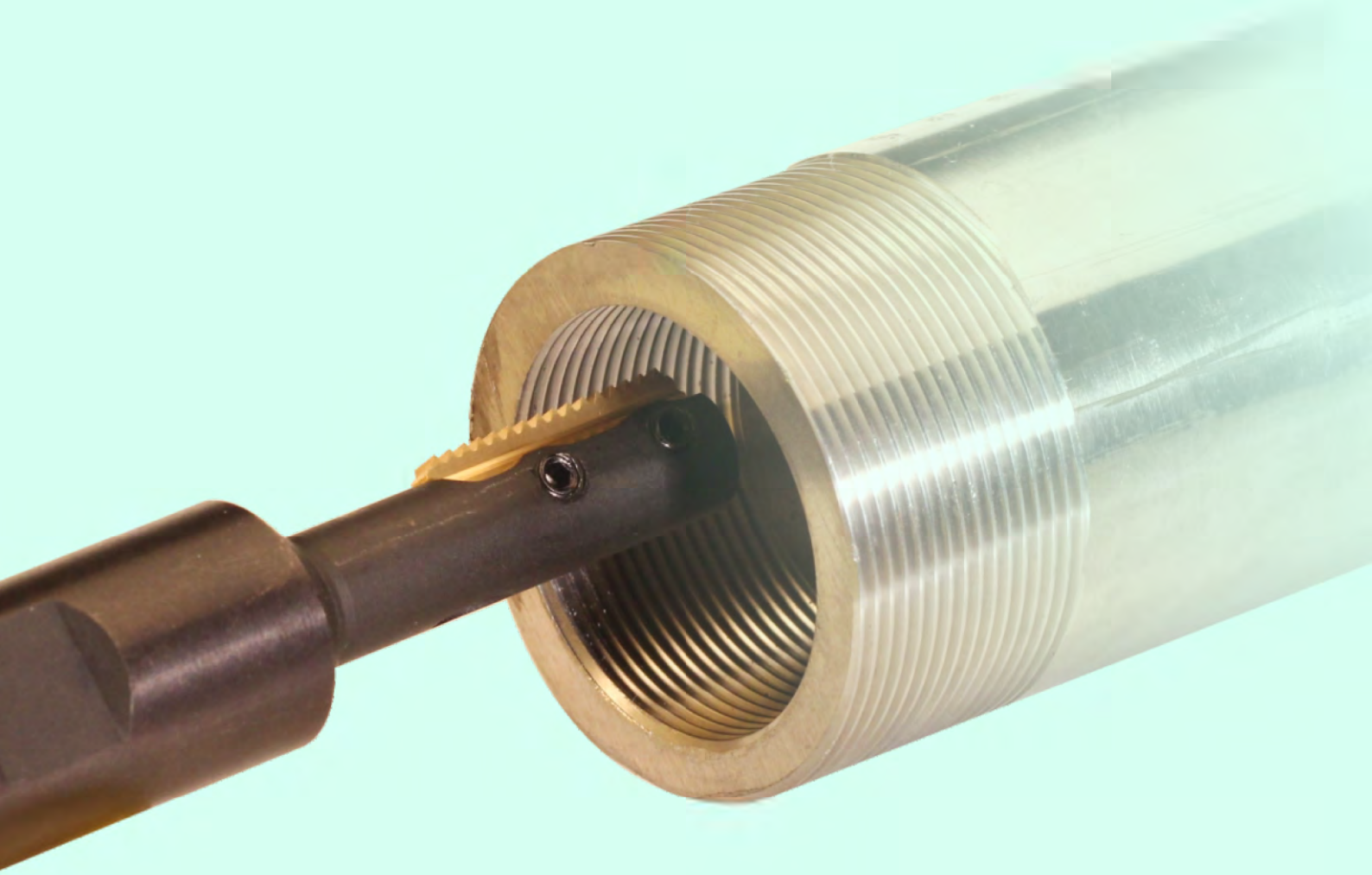
技术资料

Technical Parameters/Documentation

成都戴梦迪超硬工具有限责任公司
CHENGDU DIAMOND TOOLS CO., LTD.

技术资料

Technical Parameters/Documentation



螺纹铣削加工原理 Principle Threading Milling

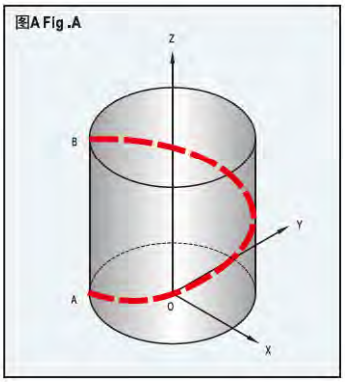
为了实现螺纹铣削加工，需要一台具备螺旋插补功能的三轴联动的CNC加工中心，螺旋插补是一种沿螺旋线方向产生刀具移动的数控功能。这种螺旋运动是在一个平面内的圆周运动与垂直于该平面的直线运动的连续组合运动。例如：图A中，在一个圆柱的外表面上，从A点到B点的轨迹是在XY平面上的圆周运动与Z方向直线运动的组合。

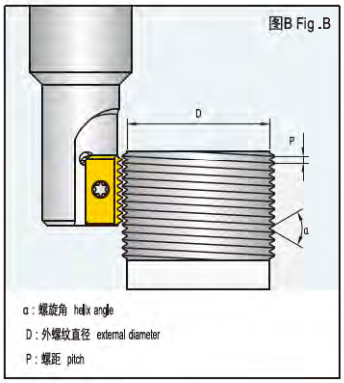
In order to perform a thread milling operation, a milling machine with three-axis control capable of helical Interpolation is required. Helical interpolation is a CNC function producing tool movement along a heclical path. This helical motion combines circular movement in one plane with a simultaneous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

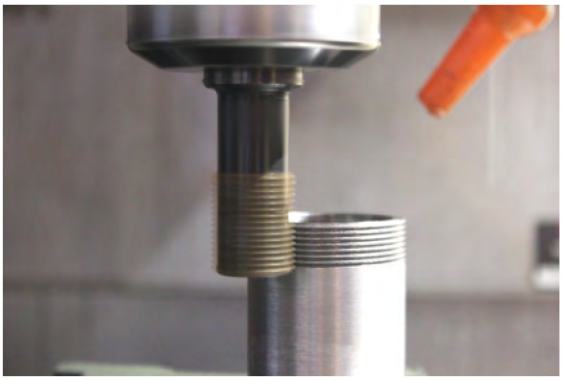
在大多数的CNC系统中，这种功能有两种方式实现：
On most CNC systems this function can be executed in two different ways:

G02：顺时针方向的螺旋插补
G03：逆时针方向的螺旋插补

G02: Helical interpolation in a clockwise direction
G03: Helical interpolation in a counter-clockwise direction







螺纹的铣削加工（图B）由刀具绕自身的轴线旋转运动与沿工件内外圆表面的螺旋轨道运动组成。
在一个这样的运动轨迹中，刀具将垂直移动一个螺距长度，就由螺纹铣刀的运动生产出所需要的螺纹形式。
为开始加工螺纹，这里有三种刀具切入工件的方法：
1、圆弧切线切入法。
2、径向切入法。
3、直线切线切入法。

The thread milling operation (Fig.B) consists of circular rotation of the tool around its own axis togeter with an orbiting motion along the bore or workpiece circumference. During one such orbit, the tool will shift vertically one pitch length. These movements combined with the insert geometry create the required thread form.
There are three acceptable ways of approaching the workpiece with the tool to initiate production of the thread:
1、Tangential Arc Approach
2、Radial Approach
3、Tangential Line Approach

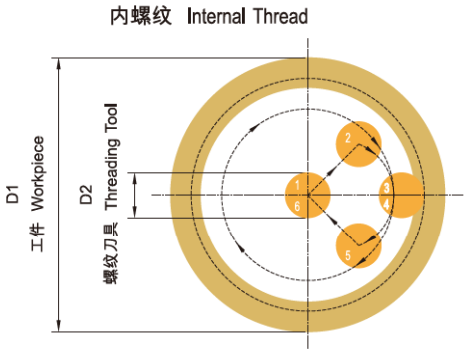
螺纹铣削加工原理 Principle Threading Milling

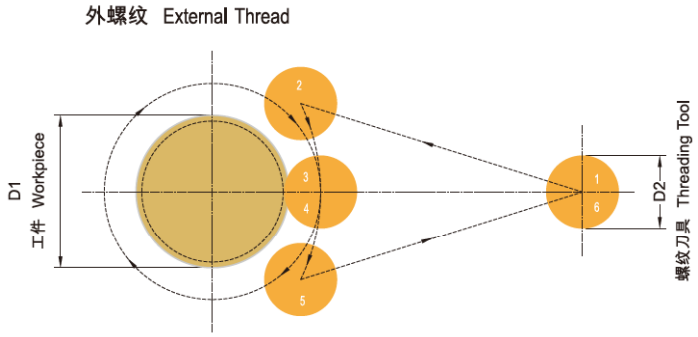
1. 圆弧切线切入法 Tangential Arc Approach

利用这种方法，刀具切入切出工件很平滑，没有痕迹留在工件上，且无振动，甚至对淬硬的材料也很好。
尽管此径向切入法需要编制更复杂的程序，但这种方法还是不失为加工高质量螺纹的首选。

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

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



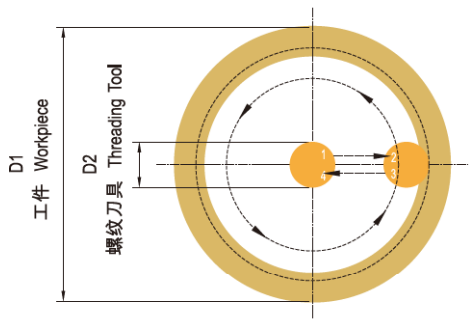


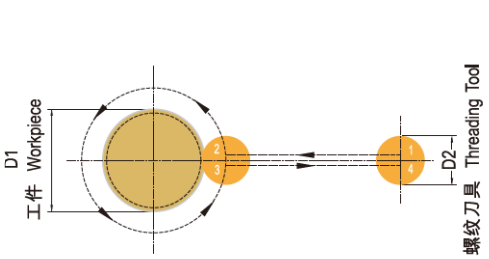
1-2：快进
Rapid approach
2-3：刀具沿圆弧切线切入，同时沿Z轴同步进给
Tool entry along tangential arc, with simultaneous feed along z-axis
3-4：在完整的运动轨迹中（360°），实现螺旋运动
Helical movement during one full orbit（360°）
4-5：刀具沿圆弧切线切出，同时沿Z轴同步进给
Tool exit along tangential arc, with comtinuing feed along z-axis
5-6：快退
Rapid return

2. 进向切入法 Radial approach

这是一个最简单的方法，关于径向切入法有两个缺点值得注意：
A、一个小的垂直痕迹线可能会留在切入（切出）点上，这对螺纹本身无关大碍。
B、当用这种方法加工很硬的材料时，刀具可能有产生振动，因为刀具以全牙深切入。
注意：当全牙深切入时，其径向进给量只能取螺旋运动进给量的1/3。

This is the simplest method. There are two characteristics worth noting about the radial approach;
A、A small vertical mark may be left at the entry （and exit） point. This is of no significance to the thread itself.
B、When using this method with very hard materials, there may be a tendency of thetool to vibrate as it approaches the full cutting depth.
Note：Radial feed during entry to the full profile depth should only be 1/3 of the subsequent circular feed!



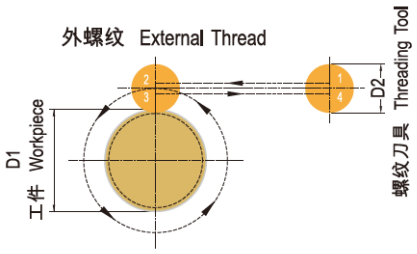


螺纹铣削加工原理 Principle Threading Milling

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

3. 直线切线切入法 Tangential Line Approach

这种方法非常简单，具有圆弧切线切入法的所有优点，但仅适用于外螺纹加工
This method is very simple, and has all of advantages of tangential arc method. However, it is applicable only with external threads



1-2：沿切线方向切入，同时沿Z轴进给
Radial entry with simultaneous feed along Z axis
2-3：在完整的运动轨迹中（360°），实现螺旋运动
Helical movement during one full orbit（360°）
3-4：沿切线方向切出
Radial exit

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

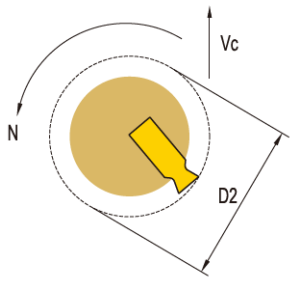
1、计量转速和进给量 Calculation of rotational velocity and feed at the cutting edge

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

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

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

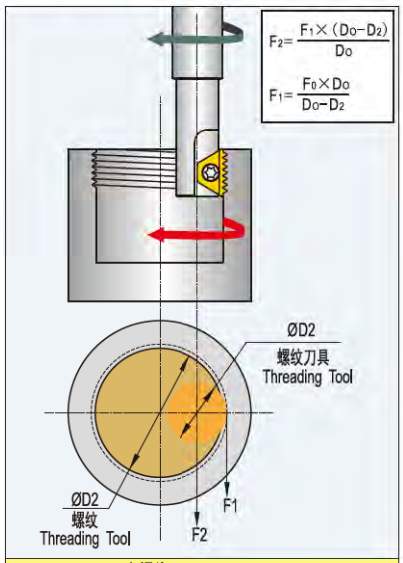
N—转速 Rotational Velocity [R.P.M]
V—切削速度 Cutting speed [m/min]
D_2—刀具切削刃直径 Toolholder Cutting Dia [mm]
F_1—切削刃上的刀具进给量 Tool Feed Rate at the cutting Edge [mm/min]
Z—切削刃数 Number of cutting Edges
f—每转每齿进给量 Feed per tooth per rotation [mm/rev]



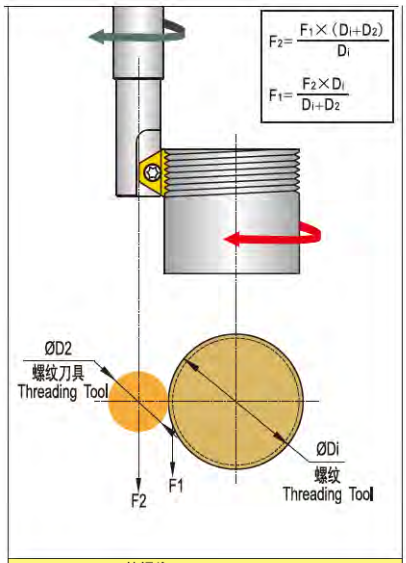
2、刀具中心线的进给量的计算 Calculation of feed rates at the tool center line

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

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



内螺纹 Internal Thread



外螺纹 External Thread

（T、S、K）系列螺纹铣刀推荐切削速度及进给量
The recommended cutting speed and feed rate of T/S/K series threading tools

材料类别 Material Category	工件材料 Workpiece Material		工件硬度 Hardness Brinell HB	切削速度 Cutting speed Vc[m/min]	进给量(mm/齿) Feed(mm/tooth) f
P 钢 Steel	碳钢 Unalloyed steel	低碳钢（C=0.1-0.025%）Low carbon	125	90-210	0.1-0.35
		中碳钢（C=0.25-0.55%）Medium carbon	150	90-180	0.1-0.4
		高碳钢（C=0.55-0.85%）High carbon	170	90-170	0.1-0.35
	低合金钢（合金元素≤5%）Low alloy steel	未硬化处理 Non hardened	180	90-160	0.1-0.4
		淬硬化处理 Hardened	275	80-160	0.1-0.35
		淬硬化处理 Hardened	350	70-150	0.1-0.3
	高合金钢（合金元素大于5%）High alloy steel	退火处理 Annealed	200	60-130	0.1-0.35
		淬硬化处理 Hardened	325	60-110	0.1-0.2
	铸钢 Cast steel	低合金（合金元素≤5%）Low alloy（alloying elements≤5%）	200	100-170	0.1-0.3
		高合金（合金元素>5%）High alloy（alloying elements>5%）	225	70-130	0.1-0.2
M 不锈钢 Stainless Steel	铁素体不锈钢 Stainless steel feritic	未硬化处理 Non hardened	200	100-180	0.1-0.3
		淬硬化处理 Hardened	330	100-180	0.1-0.2
	奥氏体不锈钢 Stainless steel Austenitic	奥氏体 Austenitic	180	70-140	0.1-0.3
		超级奥氏体 Super Austenitic	200	70-140	0.1-0.2
	铁素体铸造不锈钢 Stainless steel Cast feritic	未硬化处理 Non hardened	200	70-140	0.1-0.3
		淬硬化处理 Hardened	330	70-140	0.1-0.2
	奥氏体铸造不锈钢 Stainless steel Cast Austenitic	奥氏体 Austenitic	200	70-120	0.1-0.3
		淬硬化处理 Hardened	330	70-120	0.1-0.2
K 铸铁 Cast Iron	可锻铸铁 Malleable cast iron	铁素体（短屑）Ferritic(short chips)	130	60-130	0.05-0.16
		珠光体（长屑）Pearlitic(long chips)	230	60-120	0.04-0.10
	灰口铸铁 Grey cast iron	低抗拉强度 Low tensile strength	180	60-130	0.1-0.3
		高抗拉强度 High tensile strength	260	60-100	0.1-0.2
	球墨铸铁 Nodular SG iron	铁素体（短屑）Ferritic(short chips)	160	60-125	0.1-0.3
		珠光体（长屑）Pearlitic(long chips)	260	50-90	0.1-0.2
N（K）有色金属 Non-ferrous Metals	锻造铝合金 Forged aluminum	未时效 Non aging	60	100-250	0.15-0.55
		时效 Aged	100	100-180	0.15-0.5
	铝合金 Aluminum alloys	铸造 Cast	75	150-400	0.15-0.5
		铸造+时效 Cast & aged	90	150-280	0.1-0.4
		铸造Si 13-22% Cast Si 13-22%	130	80-150	0.15-0.5
	铜和铜合金 Copper and copper alloys	黄铜 Brass	90	100-210	0.15-0.5
		青铜和无铅铜 Bronze and non leaded copper	100	100-210	0.1-0.4
S（M）耐高温材料 High Temperature Materials	高温合金 High temperature alloys	退火处理（铁基）Annealed (Iron based)	200	20-45	0.1-0.2
		时效（铁基）Aged（Ironbased）	280	20-30	0.04-0.10
		退火（镍或含钴材料）Annealed（Nickel or Cobalt based）	250	15-20	0.04-0.10
		时效（镍或钴基合金）Aged（Nickel or Cobalt based）	350	10-15	0.04-0.10
	钛合金 Titanium alloys	纯度99.5 Ti Pure 99.5 Ti	400Rm	70-140	0.04-0.10
		α+β合金 α+βalloys	1050Rm	20-50	0.04-0.10
H（K）硬材料 Hard Materials	超硬钢 Extra hard steel	淬硬化处理 & 热处理Hardened	45-50HRC	15-45	0.06-0.12
			51-55HRC	15-40	0.04-0.08

深孔系列螺纹铣刀推荐切削速度及进给量
The recommended cutting speed and feed rate of deep series threading tools

材料类别 Material Category	工件材料 Workpiece Material		工件硬度 Hardness Brinell HB	切削速度 Cutting speed Vc[m/min]	不同D2下的进给f[mm/齿] Different D2 under feeding f[mm/tooth] 13-23	24-42	刀盘
P 钢 Steel	碳钢 Unalloyed steel	低碳钢（C=0.1-0.025%）Low carbon	125	90-210	0.20-0.32	0.30-0.50	0.30-0.75
		中碳钢（C=0.25-0.55%）Medium carbon	150	90-180	0.20-0.32	0.30-0.50	0.30-0.75
		高碳钢（C=0.55-0.85%）High carbon	170	90-170	0.15-0.23	0.25-0.35	0.25-0.52
	低合金钢（合金元素≤5%）Low alloy steel	未硬化处理 Non hardened	180	90-160	0.17-0.28	0.28-0.45	0.28-0.67
		淬硬化处理 Hardened	275	80-150	0.15-0.28	0.25-0.45	0.25-0.67
		淬硬化处理 Hardened	350	70-150	0.15-0.25	0.25-0.40	0.25-0.60
	高合金钢（合金元素大于5%）High alloy steel	退火处理 Annealed	200	60-130	0.15-0.22	0.20-0.30	0.20-0.45
		淬硬化处理 Hardened	325	60-110	0.13-0.21	0.18-0.30	0.18-0.45
	铸钢 Cast steel	低合金（合金元素≤5%）Low alloy（alloying elements≤5%）	200	100-170	0.15-0.22	0.20-0.30	0.20-0.45
		高合金（合金元素>5%）High alloy（alloying slements>5%）	225	70-130	0.12-0.22	0.17-0.30	0.17-0.45
M 不锈钢 Stainless Steel	铁素体不锈钢 Stainless steel feritic	未硬化处理Non hardened	200	100-180	0.15-0.22	0.22-0.34	0.22-0.50
		淬硬化处理Hardened	330	100-180	0.16-0.23	0.21-0.32	0.21-0.48
	奥氏体不锈钢 Stainless steel Austenitic	奥氏体Austenitic	180	70-140	0.15-0.25	0.25-0.40	0.25-0.60
		超级奥氏体Super Austenitic	200	70-140	0.12-0.20	0.17-0.26	0.17-0.39
	铁素体铸造不锈钢 Stainless steel Cast feritic	未硬化处理Non hardened	200	70-140	0.16-0.24	0.25-0.37	0.25-0.55
		淬硬化处理Hardened	330	70-140	0.12-0.20	0.17-0.26	0.17-0.39
	奥氏体铸造不锈钢 Stainless steel Cast Austenitic	奥氏体Austenitic	200	70-120	0.15-0.22	0.20-0.30	0.20-0.45
		淬硬化处理Hardened	330	70-120	0.12-0.20	0.17-0.26	0.17-0.39
K 铸铁 Cast Iron	可锻铸铁 Malleable cast iron	铁素体（短屑）Ferritic(short chips)	130	60-130	0.16-0.24	0.25-0.37	0.25-0.55
		珠光体（长屑）Pearlitic(long chips)	230	60-120	0.15-0.22	0.20-0.30	0.20-0.45
	灰口铸铁 Grey cast iron	低抗拉强度 Low tensile strength	180	60-130	0.15-0.22	0.22-0.34	0.22-0.50
		高抗拉强度High tensile strength)	260	60-100	0.15-0.22	0.20-0.30	0.20-0.45
	球墨铸铁 Nodular SG iron	铁素体（短屑）Ferritic(short chips)	160	60-125	0.10-0.20	0.15-0.25	0.15-0.37
		珠光体（长屑）Pearlitic(long chips)	260	50-90	0.15-0.22	0.20-0.30	0.20-0.45
N（K）有色金属 Non-ferrous Metals	锻造铝合金 Forged aluminum	未时效Non aging	60	100-250	0.30-0.50	0.60-1.00	0.60-1.50
		时效Aged	100	100-180	0.28-0.50	0.50-0.90	0.50-1.20
	铝合金 Aluminum alloys	铸造Cast	75	150-400	0.28-0.50	0.50-0.90	0.50-1.20
		铸造+时效 Cast & aged	90	150-280	0.25-0.40	0.40-0.60	0.40-0.90
		铸造Si 13-22% Cast Si 13-22%	130	80-150	0.28-0.50	0.50-0.90	0.50-1.20
	铜和铜合金 Copper and copper alloys	黄铜 Brass	90	100-210	0.30-0.50	0.60-1.00	0.60-1.50
		青铜和无铅铜 Bronze and non leaded copper	100	100-210	0.28-0.50	0.50-0.90	0.50-1.20
S（M）耐高温材料 High Temperature Materials	高温合金 High temperature alloys	退火处理（铁基）Annealed (Iron based)	200	20-45	0.09-0.15	0.12-0.22	0.12-0.33
		时效（铁基）Aged（Ironbased）	280	20-30	0.07-0.13	0.10-0.20	0.10-0.30
		退火（镍或含钴材料）Annealed（Nickel or Cobalt based）	250	15-20	0.08-0.15	0.08-0.20	0.08-0.30
		时效（镍或钴基合金）Aged（Nickel or Cobalt based）	350	10-15	0.08-0.15	0.08-0.20	0.08-0.30
	钛合金 Titanium alloys	纯度99.5 Ti Pure 99.5 Ti	400Rm	70-140	0.07-0.13	0.10-0.20	0.10-0.30
		α+β合金 α+βalloys	1050Rm	20-50	0.07-0.13	0.10-0.20	0.10-0.30
H（K）硬材料 Hard Materials	超硬钢 Extra hard steel	淬硬化处理 & 热处理 Hardened	45-50HRC	15-45	0.05-0.12	0.05-0.18	0.05-0.27
			51-55HRC	15-40	0.05-0.12	0.05-0.18	0.05-0.27

整体硬质合金系列螺纹铣刀推荐切削速度及进给量
The recommended cutting speed and feed rate of overall series threading tools

材料类别 Material Category	工件材料 Workpiece Material		工件硬度 Hardness Brinell HB	切削速度 Cutting speed Vc[m/min]	进给量(mm/齿) Feed(mm/tooth) 螺旋槽 Solid Helical Flute	直槽 Solid Straight Flute
P 钢 Steel	碳钢 Unalloyed steel	低碳钢 (C=0.1-0.025%) Low carbon	125	50-250	0.03-0.15	0.01-0.1
		中碳钢 (C=0.25-0.55%) Medium carbon	150	50-230	0.03-0.1	0.01-0.08
		高碳钢 (C=0.55-0.85%) High carbon	170	50-200	0.05-0.08	0.01-0.05
	低合金钢 (合金元素≤5%) Low alloy steel	未硬化处理Non hardened	180	60-180	0.03-0.1	0.03-0.07
		淬硬化处理Hardened	275	60-170	0.03-0.07	0.03-0.07
		淬硬化处理Hardened	350	60-160	0.01-0.03	0.05-0.01
	高合金钢 (合金元素大于5%) High alloy steel	退火处理Annealed	200	40-100	0.03-0.05	0.01-0.03
		淬硬化处理Hardened	325	30-80	0.01-0.03	0.005-0.01
	铸钢 Cast steel	低合金 (合金元素≤5%) Low alloy (alloying elements≤5%)	200	70-250	0.03-0.1	0.01-0.03
		高合金 (合金元素>5%) High alloy (alloying elements>5%)	225	60-170	0.01-0.03	0.005-0.01
M 不锈钢 Stainless Steel	铁素体不锈钢 Stainless steel feritic	未硬化处理Non hardened	200	50-150	0.04-0.1	0.01-0.05
		淬硬化处理Hardened	330	60-120	0.01-0.05	0.005-0.01
	奥氏体不锈钢 Stainless steel Austenitic	奥氏体Austenitic	180	60-140	0.04-0.1	0.007-0.02
		超级奥氏体Super Austenitic	200	50-130	0.01-0.1	0.007-0.02
	铁素体铸造不锈钢 Stainless steel Cast feritic	未硬化处理Non hardened	200	50-160	0.04-0.1	0.01-0.03
		淬硬化处理Hardened	330	50-110	0.03-0.05	0.005-0.01
	奥氏体铸造不锈钢 Stainless steel Cast Austenitic	奥氏体Austenitic	200	50-150	0.04-0.1	0.01-0.03
		淬硬化处理Hardened	330	50-100	0.03-0.05	0.005-0.01
K 铸铁 Cast Iron	可锻铸铁 Malleable cast iron	铁素体 (短屑)Ferritic(short chips)	130	60-160	0.01-0.03	0.007-0.02
		珠光体 (长屑) Pearlitic(long chips)	230	60-150	0.03-0.05	0.005-0.01
	灰口铸铁 Grey cast iron	低抗拉强度Low tensile strength	180	50-160	0.05-0.1	0.007-0.02
		高抗拉强度High tensile strength	260	40-120	0.03-0.05	0.005-0.01
	球墨铸铁 Nodular SG iron	铁素体 (短屑) Ferritic(short chips)	160	40-110	0.05-0.1	0.007-0.02
		珠光体 (长屑) Pearlitic(long chips)	260	40-100	0.03-0.05	0.005-0.01
N (K) 有色金属 Non-ferrous Metals	锻造铝合金 Forged aluminum	未时效Non aging	60	150-300	0.1-0.25	0.05-0.15
		时效Aged	100	100-250	0.1-0.2	0.03-0.1
	铝合金 Aluminum alloys	铸造Cast	75	80-200	0.1-0.2	0.05-0.15
		铸造+时效Cast & aged	90	90-220	0.1-0.15	0.03-0.1
		铸造Si 13-22% Cast Si 13-22%	130	150-300	0.1-0.2	0.05-0.15
	铜和铜合金 Copper and copper alloys	黄铜Brass	90	150-300	0.1-0.25	0.05-0.15
		青铜和无铅铜 Bronze and non leaded copper	100	100-250	0.1-0.2	0.03-0.1
S (M) 耐高温材料 High Temperature Materials	高温合金 High temperature alloys	退火处理 (铁基) Annealed (Iron based)	200	30-60	0.04-0.1	0.007-0.02
		时效 (铁基) Aged (Ironbased)	280	20-50	0.01-0.03	0.005-0.01
		退火 (镍或含钴材料) Annealed (Nickel or Cobalt based)	250	15-35	0.01-0.03	0.005-0.01
		时效 (镍或钴基合金) Aged (Nickel or Cobalt based)	350	15-30	0.01-0.03	0.005-0.01
	钛合金 Titanium alloys	纯度99.5 Ti Pure 99.5 Ti	400Rm	30-80	0.03-0.05	0.007-0.02
		α+β合金 α+βalloys	1050Rm	20-50	0.03-0.05	0.007-0.02
H (K) 硬材料 Hard Materials	超硬钢 Extra hard steel	淬硬化处理 & 热处理Hardened	45-50HRC	15-50	0.005-0.015	0.003-0.01
			51-55HRC	15-45	0.005-0.01	0.003-0.006

螺纹铣削的优点

高效率——目前螺纹铣刀的制造材料为硬质合金，加工线速度可达80~300m/min，但螺纹车削的加工线速度只能达到60~120m/min，而高速钢丝锥的加工线速度仅为10~30m/min，故螺纹铣刀适合高速切削，使生产效率最低提高2～8倍。现在螺纹铣刀已发展到钻孔、倒角、锪面、铣螺纹多工序集于一体；攻丝的另一个缺点与其设计的局限性相关，在攻丝结束时丝锥必须反转，因为它必须被“旋出”螺纹孔，但是螺纹铣刀只要离开切削部分就能快速退刀，这使得螺纹铣削的效率成倍的提高。

高寿命——螺纹铣刀用于断续切削，这样会降低刀具的磨损；螺纹铣削高速旋转，并且断屑切削，在加工过程中不易形成粘屑的现象；对于不稳定切削，螺纹铣刀因其切削原理本身就是断续铣削，所以完全能适应这种不稳定切削条件的加工。还有就是一片螺纹铣刀片有两面切削刃，同一片螺纹铣刀片的一面切削刃磨损后还可以翻面使用另一面的切削刃；而整体硬质合金螺纹铣刀将后刀面设计成阿基米德螺旋面，当刀具磨损后还可以重复修磨再次使用。因此螺纹铣刀的寿命是丝攻的十多倍甚至数十倍，可减少换刀和调机的时间。

高精度——螺纹铣削以刀补实现精度，客户随意选择自己需要的螺纹精度。

高光洁度——因螺纹铣削是通过刀具高速旋转、主轴插补的方式加工完成。其切削方式是铣削，切削速度高，加工出来的螺纹漂亮；而丝锥切削速度低，并且切屑长，容易损坏内孔表面。

高经济性——对于相同螺距、不同直径的螺纹孔，采用丝锥加工需要多把刀具才能完成，但如采用螺纹铣刀加工，一把螺纹铣刀可以加工直径不同、牙型相同的螺纹。如M15×1、M18×1、M20×1三种螺纹，用一把螺纹铣刀通过改变插补半径来加工，可减少刀具数量，节省换刀时间，提高加工效率，方便刀具管理。在丝锥磨损、加工螺纹尺寸小于公差后则无法继续使用，只能报废；而当螺纹铣刀磨损、加工螺纹孔尺寸小于公差时，可通过数控系统进行必要的刀具半径补偿调整后，就可继续加工出尺寸合格的螺纹。同样，为了获得高精度的螺纹孔，采用螺纹铣刀调整刀具半径的方法，比生产高精度丝锥要容易得多。丝锥仅能加工该丝锥本身所确定的左旋或右旋螺纹，但是对于螺纹铣刀而言,只要简单地改变CNC编程就能加工出左旋或右旋螺纹。同一把螺纹铣刀杆可更换公制、美制、英制等螺纹铣刀片，经济性固然更好。

更能加工高硬度材料的工件螺纹——高硬度材料和高温合金材料，如钛合金、镍基合金的螺纹加工一直是一个比较困难的问题，主要是因为其它方式加工这些材料的螺纹工件时，刀具寿命较短，但如果采用硬质合金螺纹铣刀对硬材料螺纹加工则是效果比较理想的解决方案．可加工硬度为HRC58~62。对高温合金材料的螺纹加工，螺纹铣刀同样显示出非常优异的加工性能和超乎预期的长寿命。

不怕刀具折断——对于小直径螺纹加工，特别是高硬度材料和高温材料的螺纹加工中，丝锥有时会折断，堵塞螺纹孔，甚至使零件报废；采用螺纹铣刀，由于刀具直径比加工的孔小，即使折断也不会堵塞螺纹孔，不会导致零件报废。

不受螺纹结构的限制——对于不允许有过渡扣或退刀槽结构的螺纹，采用传统的车削方法或丝锥、板牙根本无法加工，但采用数控铣削却十分容易实现。当加工盲孔螺纹时，丝锥只能达到一定的深度，丝锥头部的“锥点”将到达最低点，对于这部分孔深只能加工出不完整的螺纹；如果采用螺纹刀片车削螺纹的话，同样需要一定长度的退刀槽，但是具有平底部的螺纹铣刀没有这样的问题，它能加工出更深的完整螺纹，更接近相同盲孔的底部。

更加良好的排屑——有时对某种材料攻丝所产生的连续长切屑会被缠在孔内并折断刀具，并且丝锥直径和被加工孔一样大，因此排屑困难；而车削螺纹时切屑极易缠住车刀，会让刀片崩刃并使工件报废。相对于这两点而言，螺纹铣削就不存在问题，像任何铣削加工那样，螺纹铣削生成短而碎的切屑，另外加工刀具直径比加工螺纹孔小，所以排屑通畅，切屑的处理正是为什么工厂选择螺纹铣削的常见原因。

能加工有特殊要求的密封螺纹——螺纹铣削可以避免丝锥反转形成的回转线(在密封要求高的情况下是不允许的)。因为加工原理不同，螺纹铣刀根本不存在回转线，而丝锥无法避免。

目前螺纹铣刀主要运用于哪些方面

箱体类零件——如，汽车发动机箱体、摩托车发动机箱体、汽车发动机箱盖、摩托车发动机箱盖等，这些非旋转体类或非对称型零件因零件形状不对称，用螺纹车削的方法首先遇到的困难是无法装夹，加工的精度也无法保证。

模具制造——模具为精密机械，生产成本高。正因此，大型模具中的螺纹为了保证精确的孔心距和丰满的螺纹牙形，用螺纹铣刀加工保证工件的质量。

复杂大型零件的螺纹加工——如发电机缸体、大型模具、大型发动机、机床、风电行业中所要加工的大螺距、大直径、深螺纹，如27×3、M27×3、M30×3.5、M33×3.5、M36×4、M42×4.5、M45×4.5、M45×5、M50、M60、M80、M100、M120等螺纹工件很大，在车床上装不方便；如果在车床上面车削螺纹的话，则需要车床主轴具备非常大的功率，并且在车削螺纹时效率也非常低。

高硬度材料的加工(硬度>50HRC)——适于采用螺纹铣削，因为铣削是断屑切削，局部接触刀具受力小，刀片都是硬质合金加涂层，所以磨损小、寿命长；而一般的高速钢丝锥根本无法加工，如采用整体硬质合金丝锥其价格也不菲，与螺纹铣刀价格差不多。据我们现有加工经验，螺纹铣削加工效率、经济性绝对高于丝锥。

希望钻孔及加工螺纹一次完成的大量流水线生产时——多功能螺纹铣刀可集钻孔、倒角、锪面、铣螺纹多工序于一体。

机床动力不足时。可采用螺纹铣削加工螺纹。

有排屑问题时——螺纹铣削生成短而碎的切屑，另外加工刀具直径比加工螺纹孔小，所以排屑通畅。

螺纹加工精度和表面质量要求高时——因螺纹铣削线速度高，排屑好，螺纹精度及光洁度高，更适于采用螺纹铣削。

薄壁类零件的加工——适于采用螺纹铣削，螺纹铣刀加工受力小，因此变形小。另外，底孔可以做成平底，螺纹可以接近底部，因此所需空间小。

希望减少刀具费用时——在大多数情况下，螺纹铣削的经济性相比其它螺纹加工更好。

怎样选用一款合适的螺纹铣刀

（一）首先确定自己需要加工的螺纹要求

螺纹规格

螺纹长度

外螺纹/内螺纹

被加工材料，包括材料硬度

螺纹光洁度要求

工件数量

（二）明确了这些要求后，一般遵循以下原则选用螺纹铣刀

内螺纹还是外螺纹。螺纹铣刀有些规格内外是不能通用的，比如M和UN。

螺纹长度。尽量选择螺纹铣刀的切削刃长度大于等于被加工螺纹的有效长度；被加工螺纹的有效长度不超过3倍螺纹铣刀刃径的长度。

螺纹大小。一般来讲M12以下选用整体硬质合金螺纹铣刀，超过这个规格选择可转位螺纹铣刀；较理想的螺纹铣刀切削直径为被加工螺纹大径的2/3—3/4。加工粗牙螺纹的螺纹铣刀直径≤2/3螺纹大径；加工细牙螺纹的螺纹铣刀直径≤3/4螺纹大径。

被加工材料超过HRC40的话，就需要选用加工高硬度材料的螺纹铣刀。

工件批量大小。打样比较多，散单较多，螺纹规格较杂，这样的情况应选用单齿泛用型的螺纹铣刀，这种螺纹铣刀的螺距是通过CNC程序中的螺旋插补实现的；工件批量大的选用机夹式可转位螺纹铣刀，工件数量一般的选用整体硬质合金螺纹铣刀。

选择内冷却螺纹铣刀还是外冷却螺纹铣刀。高硬度材料、难加工材料、深孔螺纹或者要求高光洁度的螺纹推荐使用内冷却。

选择螺纹铣削需要注意的问题

由于螺纹铣削是通过主轴高速旋转并螺旋插补来实现，所以如果想享受新技术的乐趣，必须配备加工中心(至少三轴联动)，如果设备落后，没有加工中心，则不适合使用螺纹铣削。

尽量选择被加工螺纹的有效长度不超过3倍螺纹铣刀刃径的长度，否则在铣削螺纹时容易产生刀具振动、螺纹会产生锥度、并且刀具容易折断。

较理想的螺纹铣刀切削直径为被加工螺纹大径的2/3—3/4。加工粗牙螺纹的螺纹铣刀直径≤2/3螺纹大径；加工细牙螺纹的螺纹铣刀直径≤3/4螺纹大径。

被加工材料超过HRC40的话，就需要选用加工高硬度材料的螺纹铣刀。

高硬度材料、难加工材料、深孔螺纹或者要求高光洁度的螺纹使用内冷却螺纹铣刀杆。

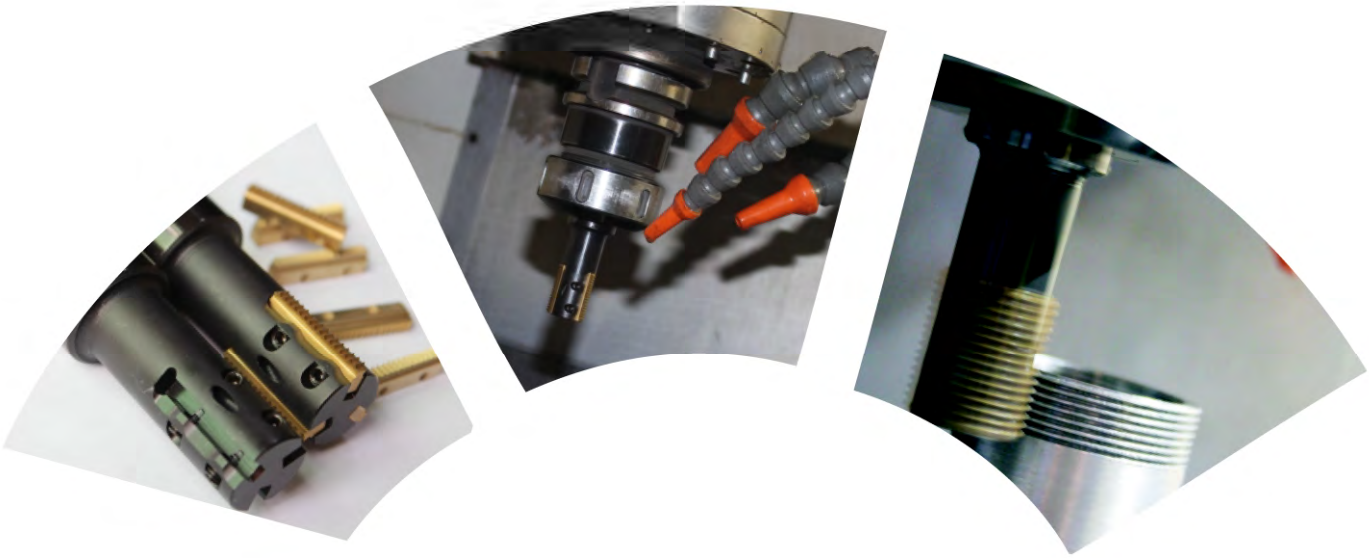
螺纹铣削经典加工案例分享

对于小直径螺纹加工应用。某航空企业需要在一个铝件上加工50个M1.6×0.35螺纹盲孔，客户遇到的问题是：由于是盲孔，排屑困难，采用丝锥加工时容易折断；由于攻丝为最后一道工序，如零件报废，则在该零件上花费的大量加工时间将全部损失。最后，客户选用加工M1.6×0.35螺纹的螺纹铣刀，线速度Vc=25m/min，转速S=4900r/min（机床极限），每转进给量fz=0.05mm/r。实际加工时间为4秒/螺纹，用一把刀具即完成了全部50件工件。

某刀体生产企业，由于刀体硬度一般为HRC44，对于压紧刀片的小直径螺纹孔，采用高速钢丝锥加工比较困难，刀具寿命较短，容易折断，对于M4×0.7的螺纹加工，客户选用整体硬质合金螺纹铣刀，Vc=60m/min，Fz=0.03mm/r，加工时间11秒/螺纹，刀具寿命达832个螺纹，螺纹光洁度非常好。

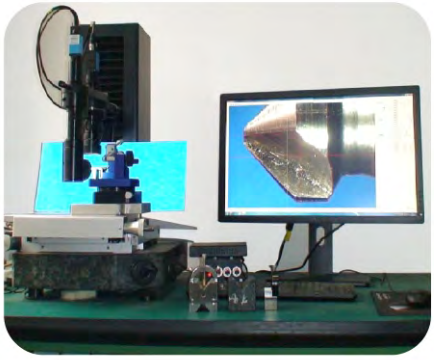
对于中等直径尺寸螺纹加工。某企业要加工的铝制零件上，有M12×0.5、M6×0.5、M7×0.5三个不同尺寸、相同螺距的螺纹孔，以前需要使用三种丝锥才能完成加工。现改用螺纹铣刀，切削条件：Vc=100m/min，S=8000r/min，fz=0.04mm/r，加工一个螺纹的时间分别为4秒、3秒、3秒，一把刀具可加工9000个螺纹，完成整批零件加工后，刀具还未损坏。

在大型发电、冶金设备加工行业、泵、阀加工行业，螺纹铣刀解决了大直径螺纹的加工问题，成为高效率、低成本的理想加工刀具。如某阀类零件加工企业，需要加工2″×11BSP-30螺纹，材料为铸钢，并希望提高加工效率。通过选用多排屑槽、多刀片机夹式螺纹铣刀，采用Vc=80m/min、S=850r/min、fz=0.07mm/r的切削参数，实现了加工时间2min/螺纹，刀片寿命620件，有效地提高了大直径螺纹的加工效率。



螺纹铣刀作为一种近年来快速发展的先进刀具，正越来越广泛地被企业所接受，并表现出卓越的加工性能，成为企业降低螺纹加工成本、提高效率、解决螺纹加工难题的有力武器。戴梦迪的工程师或销售团队在为全球各地的客户提供解决方案和技术支持，可根据客户要求提供非标解决方案。

公司设备 Advanced Machines



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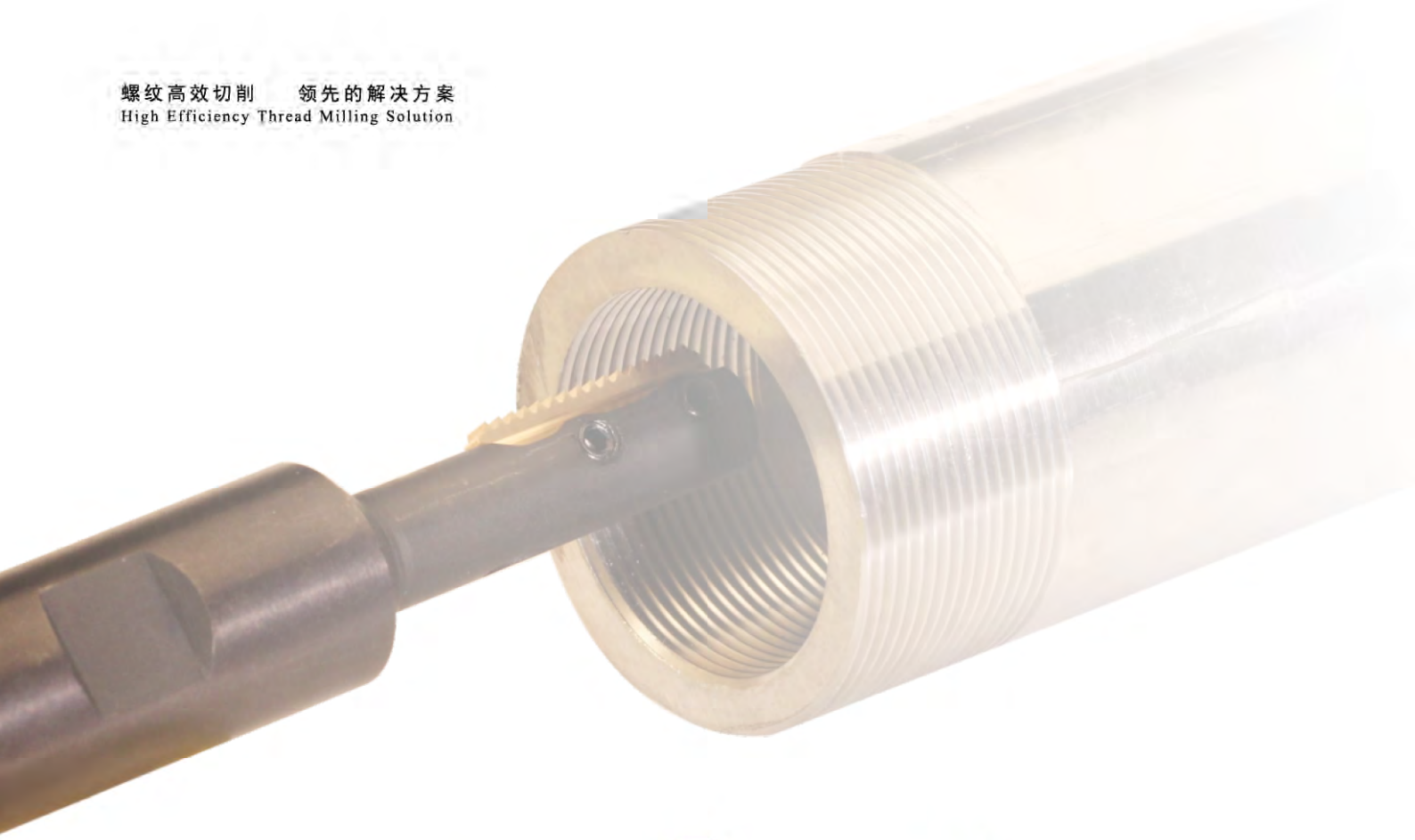
螺纹高效切削　领先的解决方案
High Efficiency Thread Milling Solution



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