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# **КАТАЛОГ ПРОДУКЦИИ**

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**РЕЗЬБОВЫЕ СМЕННЫЕ  
ПЛАСТИНЫ  
ИНСТРУМЕНТ ДЛЯ ЧПУ**

**5-е издание**



Ссылка  
на сайт ИПК

Компания Chengdu Fengyi Precision Tool Manufacturing Co., Ltd. была основана в 1997 году. На протяжении многих лет она непрерывно проводила исследования и вела разработки в области резьбонарезного инструмента, в том числе для обработки резьб нефтяного сортамента, резьбофрез с гребенками, а также специальных профильных фрез. Компания имеет производственные мощности, позволяющие вести крупносерийное производство. В последние годы компания успешно разработала серию сверл со сменной твердосплавной головкой «QuickDrill», тем самым подтвердив свою инновационность в проектировании, исследованиях и разработках. Компания уделяет особое внимание сложным прецизионным инструментам для фрезерования и инструментам для обработки отверстий. Серия «QuickDrill» постепенно получила признание на рынке, а качество достигло международного передового уровня.

В апреле 2006 года компания успешно прошла сертификацию системы менеджмента качества ISO9001:2000 и была признана высокотехнологичным предприятием в 2010 году. В 2020 году была основана компания Fengui Yinhu (ChengDu) CNC Tool Co., Ltd., которая является базой для исследований и разработок, производства, продаж и обслуживания инструментов марки «FENGYI».

Компания расположена в районе Цинбайцзян, город Чэнду, провинция Сычуань. Она занимает площадь 23 гектара и находится рядом с международным железнодорожным терминалом Чэнду. Компания имеет превосходное географическое расположение и удобную транспортную развязку. В настоящее время в компании работает более 180 сотрудников и имеется более 200 комплексов различного прецизионного обрабатывающего и измерительного оборудования. Станочный парк включает высокоточные пятикоординатные шлифовальные станки с ЧПУ, станки для измерения геометрии инструмента, обрабатывающие центры, токарные станки с ЧПУ, полностью автоматическое оборудование для нанесения покрытия. Оборудование было импортировано из Швейцарии, Германии, США, Японии, Великобритании и других стран. Используется и другое самое современное оборудование, такое как камеры для нанопокровтий, оптического контроля, а также более 100 китайских пятикоординатных шлифовальных станков с ЧПУ, круглошлифовальных станков с ЧПУ, профишлифовальных станков, обрабатывающих центров, токарно-фрезерных центров с ЧПУ и др.

В 2017 году компания внедрила и переработала цифровую систему управления производством IBD. В 2018 году было внедрено цифровое управление на местах. Это заложило хорошую основу для дальнейшего улучшения и обеспечения надежного качества продукции, дальнейшего повышения конкурентоспособности. Компания имеет годовую производственную мощность более двух миллионов штук различных резьбонарезных пластин, резьбонарезных гребенок, корпусных и цельных резьбофрез.

Компания зарекомендовала себя как производитель резьбофрез, в том числе резьбофрез для глубоких отверстий, и резьбонарезных гребенок для труб, применяемых в нефтяной и химической промышленности. Является поставщиком самого полного ассортимента резьбонарезных инструментов в Китае. Производственные мощности по инструменту для обработки отверстий составляют более одного миллиона сменных головок «QuickDrill». Продукция компании широко используется на станках с ЧПУ в автомобильной промышленности, машиностроении, энергетике, транспорте и других отраслях.

Инструменты компании получили признание на международном рынке и экспортируются в Европу, Америку, Россию, Ближний Восток, Южную Америку, Японию, Южную Корею, страны Юго-Восточной Азии и Тайвань, горячо приветствуются новыми и старыми клиентами.

В условиях рыночной конкуренции компания Fengyi применяет свой новаторский дух, самодисциплину и решительность и неустанно стремится к совершенству, чтобы достичь своей цели - превосходства в области производства резьбонарезных инструментов. Компания Fengyi постоянно разрабатывает инновационные продукты и улучшает их качество, чтобы соответствовать спросу и ожиданиям клиентов. Мы уверены, что Fengyi будет хорошим деловым партнером, и с нетерпением ждем возможности сотрудничать с вами.

Chengdu Fengyi Precision Tool Manufacture Co.,Ltd was founded in 1997. The company has constantly devoted to the research and development of threading tools, oil pipe thread Chasers, worm whirling milling tools, bearing profile cutting tools and customized profile tools. and also has developed the latest drill line-“QuickDrill” ,a self-locked modular drill for the past few years. Then it has stepped on to the innovation driven road of business model with focusing on research,design, producing,marketing and service of the complicated & precise profile cutting tools & hole-making tools, and gradually approved by the market. Its product quality and performance have ensured international market standards and presence. The company was awarded ISO9001:2000 certificate in 2006 and Hi-Tech enterprise certificate in 2010 in China. Fengyi Yinhu(ChengDu) CNC tool Co.,Ltd was founded in 2020,which is the center of the research ,manufacture and marketing and service of “FENGYI” tools .

Fengyi is located in the Qinbaijiang district Europe Industry City of Chengdu, Sichuan. it occupies over 15731 square meters, adjacent to the Chengdu Sino-Euro international Railway Port, Situated in natural geographical surrounding and convenient transportation. It has employs 180 employees and owns more than 200 sets of precision machining and test equipment including most advanced 5 axis CNC grinding machines, optical profile grinding machines ,machining centers , CNC lathes ,automatic insert honing machines, PVD coating units , insert honing inspection device,coating thin film micro-nano indentation device and coating film adhesion scratch tester, optical checking instrument from Switzerland, Germany, US, Japan, UK ,and more than 100 advanced domestic automatic periphery grinding machines ,5 axis CNC grinding machines, machining centers , form grinding machines etc.

In terms of production management, the company introduced and redeveloped IBD digital factory management system in 2017. The merit point management system was introduced in 2018, which greatly enhanced the soft power of enterprise management. It lays a good foundation for further improving and ensuring product quality and further enhancing competitiveness.

The company has an annual production capacity of more than two million pieces of various threading inserts, thread chasers, worm whirling milling inserts, and thread milling tools etc. It is an excellent supplier of domestic thread turning inserts, thread milling inserts, solid carbide thread milling cutters, deep hole thread milling tools and oil pipe thread Chasers. Fengyi uniquely offers a full product line of whole kinds of thread inserts, tool holders and accessories in China and It has the production capacity of more than one million pieces of carbide self-locked modular drills. In the domestic market, it occupies the largest market share of the domestic those .

Our products are widely used in CNC manufacturing workshops in automobile, engineering machinery, energy, transportation and other industries, which have been recognized by the market and exported to Europe, North America, Russia , Middle East, South America, Southeast Asian countries, South Korean , Japan etc. and are well received by new and old customers.

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

## Содержание

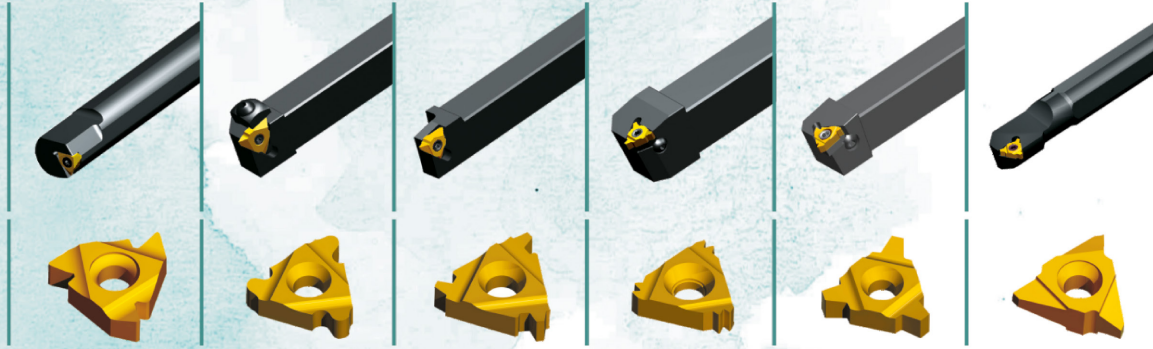
### Резьбонарезной токарный инструмент

Резьбовые пластины . . . . .	3-37
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# 螺纹车削刀具

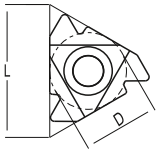
# THREADING TURNING TOOLS



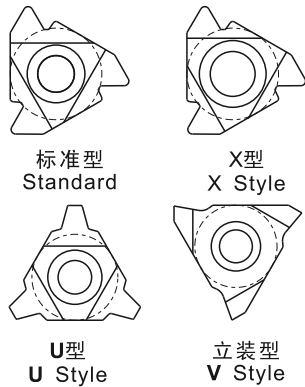
## 可转位螺纹车刀刀片型号说明 Threading Turning Insert Ordering Code System

### 1、刀片尺寸 Insert Size

L(mm)	D
06	5/32"
08	3/16" (φ5)
11	1/4"
16	3/8"
22	1/2"
27	5/8"

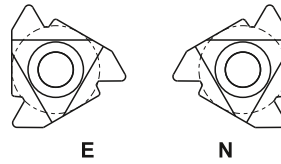


### 2、刀片形式 Insert Style



### 3、刀片类型 Type of Insert

**E** 外螺纹 External  
**N** 内螺纹 Internal



### 4、螺纹旋向 RH/LH Insert

**R** 右旋螺纹 Right Hand Insert  
**L** 左旋螺纹 Left Hand Insert

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

### 5、螺距 Pitch

完全形  
Full Profile Pitch Range

mm TPI  
0.5~6 48~4

局部面截顶形  
Partial Profile Pitch Range

A	0.5~1.5	48~16
AG	0.5~3.0	48~8
G	1.75~3.0	14~8
N	3.5~5.0	7~5
Q	5.5~6.0	4.5~4
V	6.0~10	4~2.5

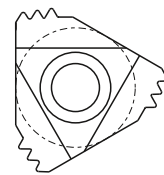
### 6、螺纹标准 Thread Standard

60° —— 60° 通用型螺纹 Partial profile 60°  
55° —— 55° 通用型螺纹 Partial profile 55°  
ISO —— ISO 标准型螺纹 ISO Metric  
UN —— 60° 美制统一标准型螺纹 American UN  
UNJ —— 60° 美制航空航天螺纹 Aviation thread  
W —— 55° 英国惠氏螺纹 Whitworth for BSW BSP  
NPT —— 60° 美国标准锥管螺纹 NPT  
NPTF —— 60° 美制干密封螺纹 NPTF  
BSPT —— 55° 英制标准锥管螺纹 British Standard Pipe Thread  
ACME —— 美制29° 梯形螺纹 American ACME  
STACME —— 美制29° 短齿梯形螺纹 American Stub ACME  
TR —— 30° 标准梯形螺纹 Trapez DIN 103  
ABUT —— 美制锯齿形螺纹 American Buttress  
BBUT —— 英制锯齿形螺纹 British Buttress  
RD —— 消防食品机械圆螺纹 Round DIN 405  
RD20400 —— 消防食品机械圆螺纹 Round DIN 20400  
APIRD —— API 圆螺纹 API Round Casing & Tubing  
BUT —— API 偏梯扣螺纹 API Buttress Casing  
Pg —— Pg 螺纹

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

2 3 5 6 8

### 8、梳齿的刀片型式 Insert Style of Multitooth



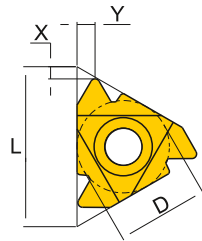
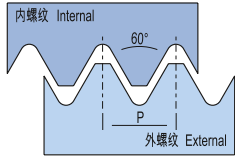
M



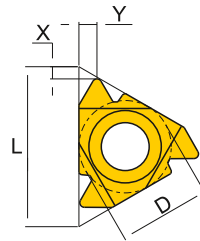
# 螺纹车削刀具 THREADING TURNING TOOLS

## 60° 通用型螺纹刀片 Partial Profile 60°

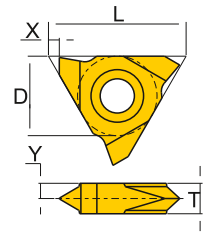
### 外螺纹 External



标准型 Standard



X型\* X Style\*



立装型 V Style

	内接圆直径D	加工螺距范围 Pitch		刀片型号 Ordering Code		刀片尺寸 Dimension			
		mm	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	0.5~1.5	48~16	11ER A60	11EL A60	11	0.80	0.90	3.20
		0.5~1.5	48~16	16ER A60	16ER A60	16	0.80	0.90	3.65
	3/8"	0.5~3.0	48~8	16ER AG60	16EL AG60	16	1.20	1.70	3.65
		1.75~3.0	14~8	16ER G60	16EL G60	16	1.20	1.70	3.65
	1/2"	3.5~5.0	7~5	22ER N60	22EL N60	22	1.70	2.50	4.76
5/8"	5.5~6.0	4.5~4	27ER Q60	27EL Q60	27	2.10	3.10	6.35	
X型* X style	3/8"	0.5~1.5	48~16	16XER A60	16XEL A60	16	0.80	0.90	4.30
		0.5~3.0	48~8	16XER AG60	16XEL AG60	16	1.20	1.70	4.30
	1/2"	1.75~3.0	14~8	16XER G60	16XEL G60	16	1.20	1.70	4.30
		3.5~5.0	7~5	22XER N60	22XEL N60	22	1.70	2.50	5.90
立装型 V style	5/8"	6.0~10	4~2.5	27VER V60	27VEL V60	27	0.6	5.2	10.0

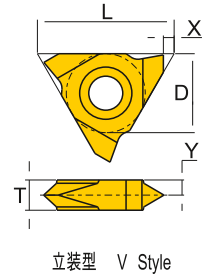
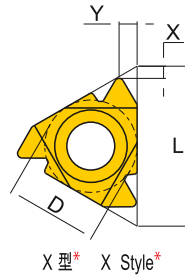
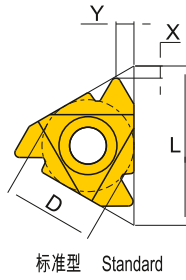
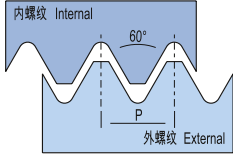
\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

# 螺纹车削刀具 THREADING TURNING TOOLS

## 60° 通用型螺纹刀片 Partial Profile 60°

### 内螺纹 Internal



	内接圆直径D	加工螺距范围 Pitch		刀片型号 Ordering Code		刀片尺寸 Dimension			
		mm	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	5/32"	0.5~1.25	48~20	06NR A60	06NL A60	6	0.6	0.6	1.90
	3/16"	0.5~1.5	48~16	08NR A60	08NL A60	8	0.6	0.7	2.20
	1/4"	0.5~1.5	48~16	11NR A60	11NL A60	11	0.8	0.9	3.20
		0.5~1.5	48~16	16NR A60	16NL A60	16	0.8	0.9	3.65
	3/8"	0.5~3.0	48~8	16NR AG60	16NL AG60	16	1.2	1.7	3.65
		1.75~3.0	14~8	16NR G60	16NL G60	16	1.2	1.7	3.65
	1/2"	3.5~5.0	7~5	22NR N60	22NL N60	22	1.7	2.5	4.76
X型* X style	5/8"	5.5~6.0	4.5~4	27NR Q60	27NL Q60	27	1.8	2.7	6.35
	1/4"	0.5~1.5	48~16	11XNR A60	11XNL A60	11	0.8	0.9	3.39
		0.5~1.5	48~16	16XNR A60	16XNL A60	16	0.8	0.9	4.30
	3/8"	0.5~3.0	48~8	16XNR AG60	16XNL AG60	16	1.2	1.7	4.30
		1.75~3.0	14~8	16XNR G60	16XNL G60	16	1.2	1.7	4.30
1/2"	3.5~5.0	7~5	22XNR N60	22XNL N60	22	1.7	2.5	5.90	
立装型 V style	5/8"	6.0~10	4~2.5	27VNR V60	27VNL V60	27	0.6	5.2	8.70

\* 可装在Sandvik Coromat刀杆上

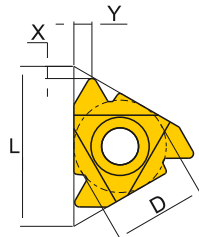
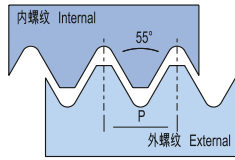
\* Can be fixed in the toolholders of Sandvik Coromat.



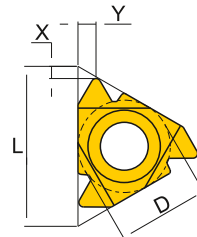
# 螺纹车削刀具 THREADING TURNING TOOLS

## 55° 通用型螺纹刀片 Partial Profile 55°

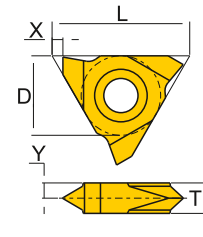
### 外螺纹 External



标准型 Standard



X型\* X Style\*



立装型 V Style

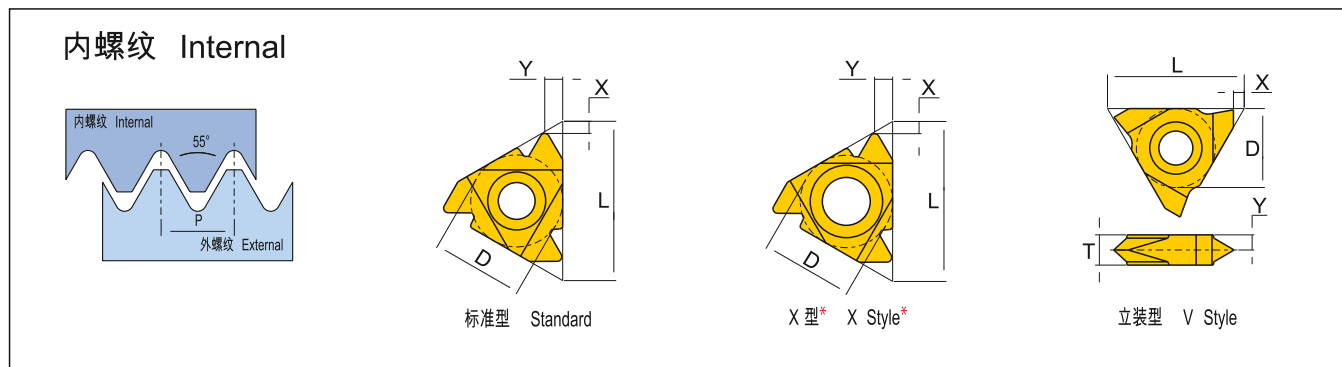
	内接圆直径D	加工螺距范围 Pitch		刀片型号 Ordering Code		刀片尺寸 Dimension			
		mm	TPI	右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	0.5~1.5	48~16	11ER A55	11EL A55	11	0.8	0.9	3.20
		0.5~1.5	48~16	16ER A55	16EL A55	16	0.8	0.9	3.65
	3/8"	0.5~3.0	48~8	16ER AG55	16EL AG55	16	1.2	1.7	3.65
		1.75~3.0	14~8	16ER G55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

\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

# 螺纹车削刀具 THREADING TURNING TOOLS

## 55° 通用型螺纹刀片 Partial Profile 55°



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

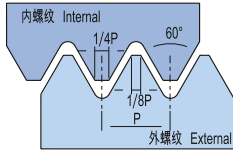
\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

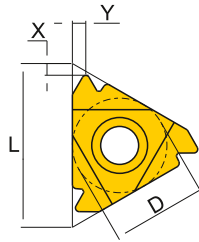


## ISO标准型螺纹刀片 ISO Metric Full Profile

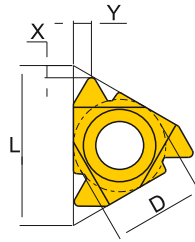
### 外螺纹 External



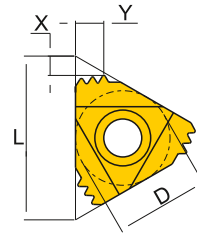
标准: R262 (DIN 13)  
Defined by: R262 (DIN 13)  
精度等级: 6g/6H  
Tolerance class: 6g/6H



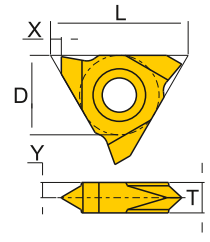
标准型 Standard



X型\* X Style\*



M型 M Style



立装型 V Style

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

\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

# 螺纹车削刀具 THREADING TURNING TOOLS

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

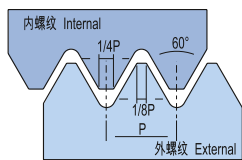
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
	1/2"	3.5	22XER3.50 ISO	22XEL3.50 ISO	22	1.6	2.3	5.90
		4	22XER4.00 ISO	22XEL4.00 ISO	22	1.6	2.3	5.90
		4.5	22XER4.50 ISO	22XEL4.50 ISO	22	1.7	2.4	5.90
		5	22XER5.00 ISO	22XEL5.00 ISO	22	1.7	2.5	5.90
立装型 V Style	3/8"	0.50	16VER0.50 ISO	16VEL0.50 ISO	16	1.1	3.0	3.65
		0.75	16VER0.75 ISO	16VEL0.75 ISO	16	1.1	3.0	3.65
		1.00	16VER1.00 ISO	16VEL1.00 ISO	16	1.1	2.9	3.65
		1.25	16VER1.25 ISO	16VEL1.25 ISO	16	1.1	2.7	3.65
		1.50	16VER1.50 ISO	16VEL1.50 ISO	16	1.1	2.6	3.65
		1.75	16VER1.75 ISO	16VEL1.75 ISO	16	1.1	2.5	3.65
	5/8"	2.00	16VER2.00 ISO	16VEL2.00 ISO	16	1.1	2.3	3.65
		2.50	16VER2.50 ISO	16VEL2.50 ISO	16	1.1	2.1	3.65
		3.00	16VER3.00 ISO	16VEL3.00 ISO	16	1.1	2.0	3.65
		6.00	27VER6.00 ISO	27VEL6.00 ISO	27	1.0	3.3	6.35
	5/8"	8.00	27VER8.00 ISO	27VEL8.00 ISO	27	1.0	4.3	8.70
		10.0	27VER10.0 ISO	27VEL10.0 ISO	27	1.0	5.2	10.0
梳齿型 M Style	3/8"	1.00	16ER1.0 ISO3M		16	1.7	2.6	3.65
		1.50	16ER1.5 ISO2M		16	1.6	2.4	3.65
	1/2"	1.50	22ER1.5 ISO3M		22	2.4	3.8	4.76
		2.00	22ER2.0 ISO2M		22	2.0	3.0	4.76
	5/8"	2.00	22ER2.0 ISO3M		22	3.1	4.9	4.76
		3.00	27ER3.0 ISO2M		27	2.7	4.3	6.35



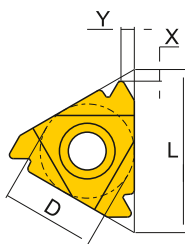
# 螺纹车削刀具 THREADING TURNING TOOLS

## ISO标准型螺纹刀片 ISO Metric Full Profile

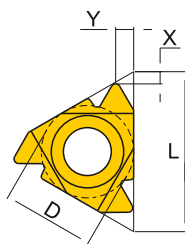
### 内螺纹 Internal



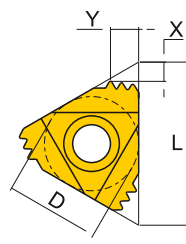
标准: R262 (DIN 13)  
Defined by: R262 (DIN 13)  
精度等级: 6g/6H  
Tolerance class: 6g/6H



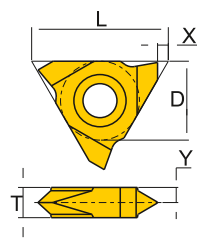
标准型 Standard



X型\* X Style\*



M型 M Style

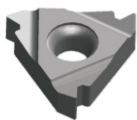


立装型 V Style

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



标准型 Standard



# 螺纹车削刀具 THREADING TURNING TOOLS

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

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

\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.






# 螺纹车削刀具 THREADING TURNING TOOLS

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

**外螺纹 External**  
UNC UNF UNEF UNS

标准: ANSI B 1.1:74  
Defined by: ANSI B 1.1:74  
精度等级: 2A/2B  
Tolerance class: 2A/2B

标准型 Standard      X型\* X Style\*      M型 M Style      立装型 V Style

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

# 螺纹车削刀具 THREADING TURNING TOOLS

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

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

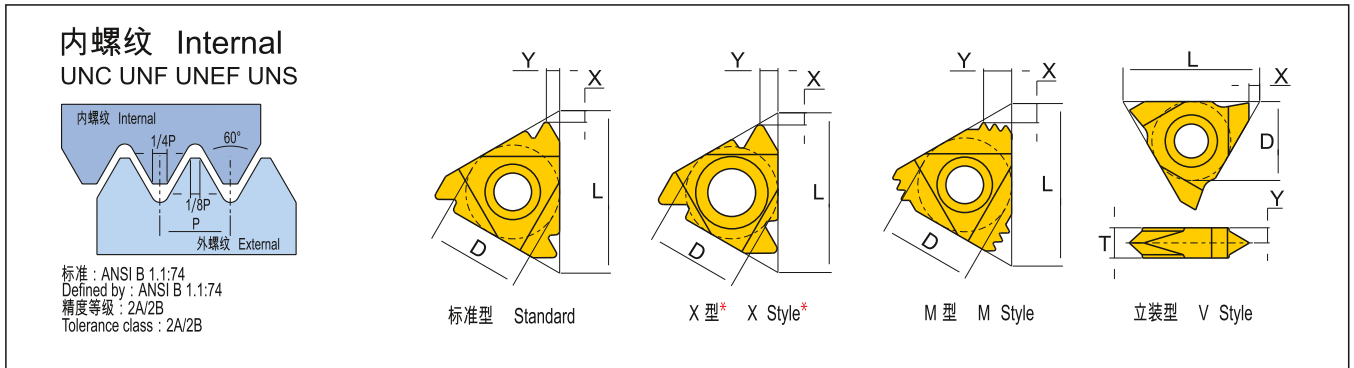
\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

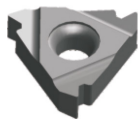


# 螺纹车削刀具 THREADING TURNING TOOLS

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



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



标准型 Standard

# 螺纹车削刀具 THREADING TURNING TOOLS

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

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

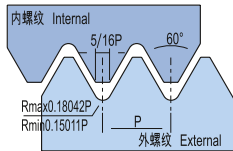
\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

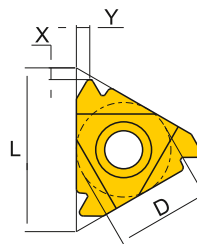


## UNJ美制航空航天机械螺纹刀片 UNJ Aviation Thread

### 外螺纹 External UNJC UNJF UNJEF UNJS



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



标准型 Standard

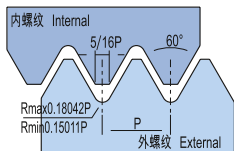
	内接圆直径D	加工螺距范围 Pitch TPI	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
 标准型 Standard	1/4"	28	11ER28 UNJ	11EL28 UNJ	11	0.7	0.7	3.20
		24	11ER24 UNJ	11EL24 UNJ	11	0.7	0.8	3.20
		20	11ER20 UNJ	11EL20 UNJ	11	0.8	0.9	3.20
		18	11ER18 UNJ	11EL18 UNJ	11	0.8	1.0	3.20
		16	11ER16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

# 螺纹车削刀具 THREADING TURNING TOOLS

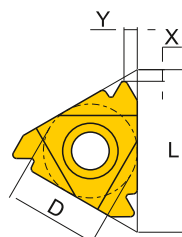
## UNJ美制航空航天机械螺纹刀片 UNJ Aviation Thread

### 内螺纹 Internal

UNJC UNJF UNJEF UNJS



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



标准型 Standard

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

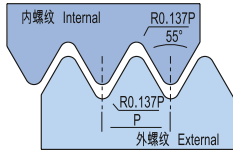


# 螺纹车削刀具 THREADING TURNING TOOLS

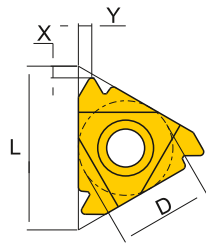
W-55° 英国惠氏螺纹刀片 W-55° Whitworth Full Profile

## 外螺纹 External

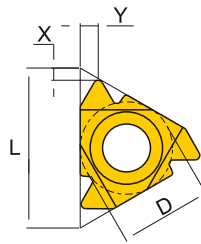
BSW BSF BSP BSB



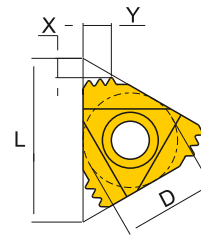
标准 : B.S.84:1956, DIN 259, ISO 228/1:1982  
 Defined by : B.S.84:1956, DIN 259, ISO 228/1:1982  
 精度等级 : Medium class A  
 Tolerance class : Medium class A



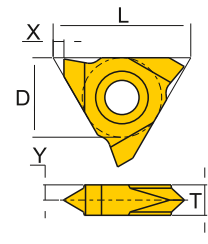
标准型 Standard



X型\* X Style\*



M型 M Style



立装型 V Style

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









标准型 Standard



# 螺纹车削刀具 THREADING TURNING TOOLS

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

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

\* 可装在Sandvik coromat刀杆上

\* Can be fixed in the toolholders of Sandvik coromat.



# 螺纹车削刀具 THREADING TURNING TOOLS

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

**内螺纹 Internal**  
BSW BSF BSP BSB

标准 : B.S.84:1956, DIN 259, ISO 228/1:1982  
Defined by : B.S.84:1956, DIN 259, ISO 228/1:1982  
精度等级 : Medium class A  
Tolerance class : Medium class A

标准型 Standard      X型\* X Style\*      M型 M Style      立装型 V Style

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	5/32"	TPI						
		26	06NR26 W	06NL26 W	6	0.7	0.6	1.90
		22	06NR22 W	06NL22 W	6	0.6	0.6	1.90
		20	06NR20 W	06NL20 W	6	0.6	0.7	1.90
	3/16"	18	06NR18 W	06NL18 W	6	0.6	0.7	1.90
		28	08NR28 W	08NL28 W	8	0.6	0.6	2.20
		24	08NR24 W	08NL24 W	8	0.6	0.6	2.20
		20	08NR20 W	08NL20 W	8	0.6	0.7	2.20
	1/4"	19	08NR19 W	08NL19 W	8	0.6	0.7	2.20
		18	08NR18 W	08NL18 W	8	0.6	0.7	2.20
		16	08NR16 W	08NL16 W	8	0.6	0.7	2.20
		28	11NR28 W	11NL28 W	11	0.6	0.6	3.20
26		11NR26 W	11NL26 W	11	0.6	0.7	3.20	
20		11NR20 W	11NL20 W	11	0.7	0.9	3.20	
3/8"	19	11NR19 W	11NL19 W	11	0.8	1	3.20	
	18	11NR18 W	11NL18 W	11	0.8	1	3.20	
	16	11NR16 W	11NL16 W	11	0.9	1.1	3.20	
	14	11NR14 W	11NL14 W	11	1.0	1.2	3.20	
	28	16NR28 W	16NL28 W	16	0.6	0.7	3.65	
	26	16NR26 W	16NL26 W	16	0.7	0.8	3.65	
	20	16NR20 W	16NL20 W	16	0.8	0.9	3.65	
	19	16NR19 W	16NL19 W	16	0.8	1	3.65	
	18	16NR18 W	16NL18 W	16	0.8	1	3.65	
	16	16NR16 W	16NL16 W	16	0.9	1.1	3.65	
	14	16NR14 W	16NL14 W	16	1.0	1.2	3.65	
		12	16NR12 W	16NL12 W	16	1.1	1.4	3.65
	11	16NR11 W	16NL11 W	16	1.1	1.5	3.65	
	10	16NR10 W	16NL10 W	16	1.1	1.5	3.65	
	9	16NR9 W	16NL9 W	16	1.2	1.5	3.65	
	8	16NR8 W	16NL8 W	16	1.2	1.7	3.65	

# 螺纹车削刀具 THREADING TURNING TOOLS

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

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

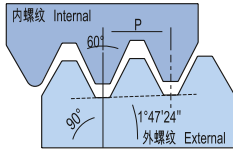
\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

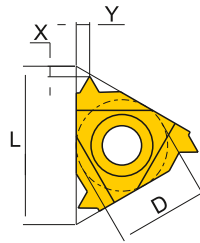


## NPTF美制干密封锥管螺纹刀片 NPTF(Dry seal)

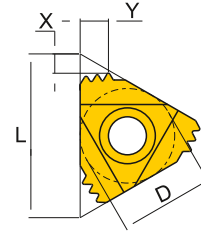
### 外螺纹 External



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



标准型 Standard



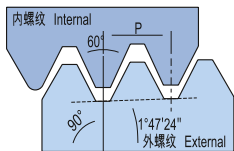
M型 M Style

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

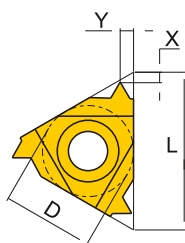
# 螺纹车削刀具 THREADING TURNING TOOLS

## NPTF美制干密封锥管螺纹刀片 NPTF(Dry seal)

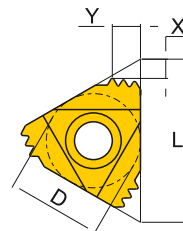
### 内螺纹 Internal



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



标准型 Standard



M型 M Style

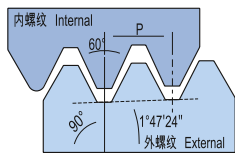
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	5/32"	TPI						
		27	06NR27 NPTF	06NL27 NPTF	6	0.7	0.6	1.90
	3/16"	27	08NR27 NPTF	08NL27 NPTF	8	0.6	0.6	2.20
		18	08NR18 NPTF	08NL18 NPTF	8	0.6	0.6	2.20
	1/4"	27	11NR27 NPTF	11NL27 NPTF	11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



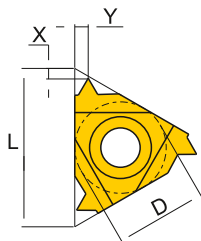
# 螺纹车削刀具 THREADING TURNING TOOLS

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

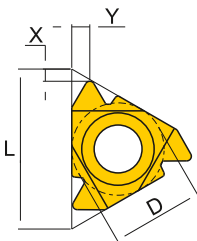
### 外螺纹 External



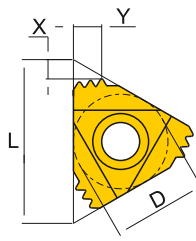
标准 : USAS B2.1:1968  
 Defined by : USAS B2.1:1968  
 精度等级 : Standard NPT  
 Tolerance class : Standard NPT



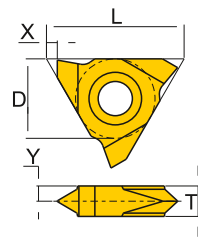
标准型 Standard



X型\* X Style\*



M型 M Style



立装型 V Style

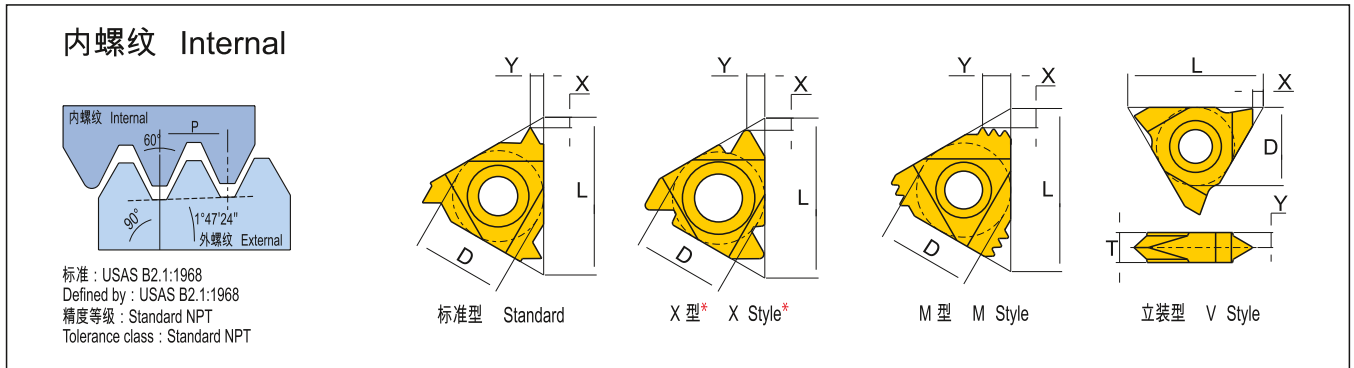
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	27	11ER27 NPT	11EL27 NPT	11	0.7	0.8	3.20
		18	11ER18 NPT	11EL18 NPT	11	0.8	1.0	3.20
		14	11ER14 NPT	11EL14 NPT	11	0.8	1.0	3.20
	3/8"	27	16ER27 NPT	16EL27 NPT	16	0.7	0.8	3.65
		18	16ER18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

\* 可装在Sandvik Coromat刀杆上

\* Can be fixed in the toolholders of Sandvik Coromat.

# 螺纹车削刀具 THREADING TURNING TOOLS

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



	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	5/32"	27	06NR27 NPT	06NL27 NPT	6	0.6	0.6	1.90
			3/16"	27	08NR27 NPT	08NL27 NPT	8	0.6
	18	08NR18 NPT		08NL18 NPT	8	0.6	0.6	2.20
	1/4"	27		11NR27 NPT	11NL27 NPT	11	0.7	0.8
		18	11NR18 NPT	11NL18 NPT	11	0.8	1.0	3.20
	3/8"	14	11NR14 NPT	11NL14 NPT	11	0.8	1.0	3.20
		27	16NR27 NPT	16NL27 NPT	16	0.7	0.8	3.65
		18	16NR18 NPT	16NL18 NPT	16	0.8	1.0	3.65
		14	16NR14 NPT	16NL14 NPT	16	0.8	1.0	3.65
		11.5	16NR11.5 NPT	16NL11.5 NPT	16	1.1	1.5	3.65
X型* X style	1/4"	8	16NR8 NPT	16NL8 NPT	16	1.2	1.8	3.65
		27	11XNR27 NPT	11XNL27 NPT	11	0.7	0.8	3.39
		18	11XNR18 NPT	11XNL18 NPT	11	0.8	1.0	3.39
	3/8"	14	11XNR14 NPT	11XNL14 NPT	11	0.8	1.0	3.39
		27	16XNR27 NPT	16XNL27 NPT	16	0.7	0.8	4.30
		18	16XNR18 NPT	16XNL18 NPT	16	0.8	1.0	4.30
		14	16XNR14 NPT	16XNL14 NPT	16	0.8	1.0	4.30
		11.5	16XNR11.5 NPT	16XNL11.5 NPT	16	1.1	1.5	4.30
梳齿型 M Style	1/2"	8	16XNR8 NPT	16XNL8 NPT	16	1.2	1.8	4.30
		11.5	22NR11.5 NPT2M		22	3.4	2.2	4.76
	5/8"	11.5	27NR11.5 NPT3M		27	3.5	5.6	6.35
		8	27NR8 NPT2M		27	2.9	4.7	6.35

\* 可装在Sandvik Coromat刀杆上

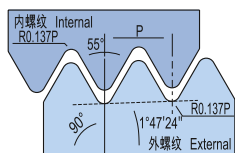
\* Can be fixed in the toolholders of Sandvik Coromat.



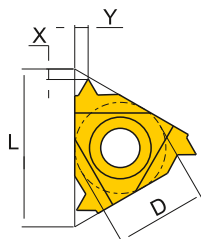
# 螺纹车削刀具 THREADING TURNING TOOLS

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

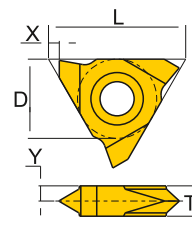
### 外螺纹 External



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



标准型 Standard

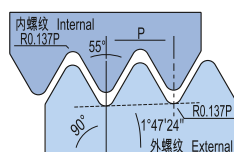


立装型 V Style

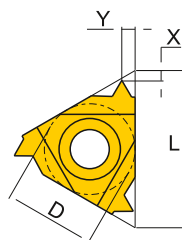
	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	1/4"	TPI						
		28	11ER28 BSPT	11EL28 BSPT	11	0.6	0.6	3.20
		19	11ER19 BSPT	11EL19 BSPT	11	0.8	0.9	3.20
	3/8"	14	11ER14 BSPT	11EL14 BSPT	11	0.9	1.0	3.20
		28	16ER28 BSPT	16EL28 BSPT	16	0.6	0.6	3.65
		19	16ER19 BSPT	16EL19 BSPT	16	0.8	0.9	3.65
立装型 V Style	3/8"	14	16ER14 BSPT	16EL14 BSPT	16	1.0	1.2	3.65
		11	16ER11 BSPT	16EL11 BSPT	16	1.1	1.5	3.65
		28	16VER28 BSPT	16VEL28 BSPT	16	1.1	3.0	3.65
	3/8"	19	16VER19 BSPT	16VEL19 BSPT	16	1.1	2.7	3.65
		14	16VER14 BSPT	16VEL14 BSPT	16	1.1	2.4	3.65
		11	16VER11 BSPT	16VEL11 BSPT	16	1.1	2.1	3.65

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

### 内螺纹 Internal



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



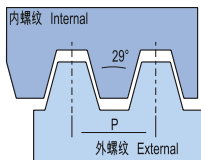
标准型 Standard

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	5/32"	TPI						
		28	06NR28 BSPT	06NL28 BSPT	6	0.7	0.6	1.90
	3/16"	28	08NR28 BSPT	08NL28 BSPT	8	0.6	0.6	2.20
		19	08NR19 BSPT	08NL19 BSPT	8	0.6	0.6	2.20
	1/4"	28	11NR28 BSPT	11NL28 BSPT	11	0.6	0.8	3.20
		19	11NR19 BSPT	11NL19 BSPT	11	0.8	0.9	3.20
	3/8"	14	11NR14 BSPT	11NL14 BSPT	11	0.9	1.0	3.20
		28	16NR28 BSPT	16NL28 BSPT	16	0.6	0.6	3.65
		19	16NR19 BSPT	16NL19 BSPT	16	0.8	0.9	3.65
		14	16NR14 BSPT	16NL14 BSPT	16	1.0	1.2	3.65
		11	16NR11 BSPT	16NL11 BSPT	16	1.1	1.5	3.65

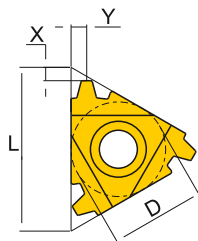
# 螺纹车削刀具 THREADING TURNING TOOLS

## ACME-29° 美制ACME梯形螺纹刀片 American ACME

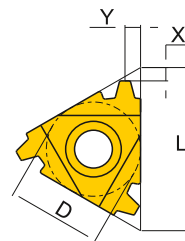
### 标准型 Standard



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



标准型 Standard



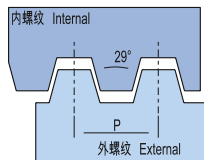
标准型 Standard

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
外螺纹 External	3/8"	TPI						
		16	16ER16 ACME	16EL16 ACME	16	1.0	1.1	3.65
		14	16ER14 ACME	16EL14 ACME	16	1.0	1.2	3.65
		12	16ER12 ACME	16EL12 ACME	16	1.1	1.2	3.65
		10	16ER10 ACME	16EL10 ACME	16	1.3	1.3	3.65
5/8"	8	16ER8 ACME	16EL8 ACME	16	1.4	1.5	3.65	
	6	22ER6 ACME	22EL6 ACME	22	1.8	2.1	4.76	
	5	22ER5 ACME	22EL5 ACME	22	2.0	2.3	4.76	
内螺纹 Internal	3/8"	4	27ER4 ACME	27EL4 ACME	27	2.4	2.7	6.35
		16	16NR16 ACME	16NL16 ACME	16	1.0	1.1	3.65
		14	16NR14 ACME	16NL14 ACME	16	1.0	1.2	3.65
		12	16NR12 ACME	16NL12 ACME	16	1.1	1.2	3.65
	1/2"	10	16NR10 ACME	16NL10 ACME	16	1.3	1.3	3.65
		8	16NR8 ACME	16NL8 ACME	16	1.4	1.5	3.65
		6	22NR6 ACME	22NL6 ACME	22	1.8	2.1	4.76
5/8"	5	22NR5 ACME	22NL5 ACME	22	2.0	2.3	4.76	
	4	27NR4 ACME	27NL4 ACME	27	2.4	2.7	6.35	

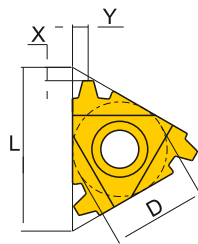


## STACME-29° 美制ACME梯形螺纹刀片 Stub ACME

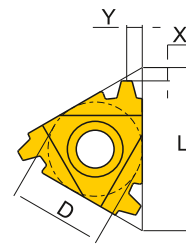
### 标准型 Standard



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



标准型 Standard



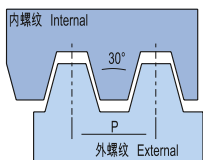
标准型 Standard

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

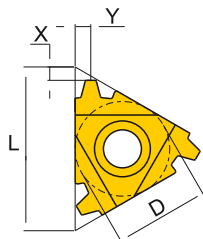
# 螺纹车削刀具 THREADING TURNING TOOLS

## TR-30° 标准梯形螺纹刀片 Trapeze

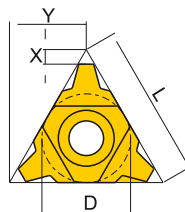
### 外螺纹 External



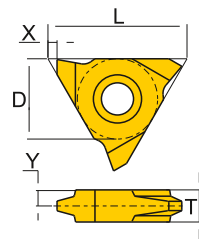
标准 : DIN 103  
Defined by : DIN 103  
精度等级 : 7e/7H  
Tolerance class : 7e/7H



标准型 Standard



U型 U Style



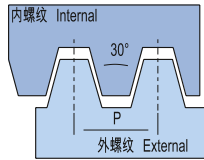
立装型 V Style

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	3/8"	1.5	16ER1.5 TR	16EL1.5 TR	16	1.0	1.1	3.65
		2.0	16ER2.0 TR	16EL2.0 TR	16	1.1	1.3	3.65
		3.0	16ER3.0 TR	16EL3.0 TR	16	1.3	1.5	3.65
	1/2"	4.0	22ER4.0 TR	22EL4.0 TR	22	1.7	1.9	4.76
		5.0	22ER5.0 TR	22EL5.0 TR	22	2.1	2.5	4.76
		5/8"	6.0	27ER6.0 TR	27EL6.0 TR	27	2.2	2.6
7.0	27ER7.0 TR		27EL7.0 TR	27	2.3	2.7	6.35	
立装型 V Style	5/8"	6.0	27VER6.0 TR	27VEL6.0 TR	27	1.0	3.3	6.35
		7.0	27VER7.0 TR	27VEL7.0 TR	27	1.0	3.3	6.35
		8.0	27VER8.0 TR	27VEL8.0 TR	27	1.0	3.3	6.35
		9.0	27VER9.0 TR	27VEL9.0 TR	27	1.0	4.3	8.70
		10.0	27VER10.0 TR	27VEL10.0 TR	27	1.0	4.3	8.70
		12.0	27VER12.0 TR	27VEL12.0 TR	27	1.0	5.2	10.0
U型 U Style	5/8"	8.0	27UE8.0 TR		27	2.6	13.7	6.35
		9.0	27UE9.0 TR		27	3.0	13.7	6.35

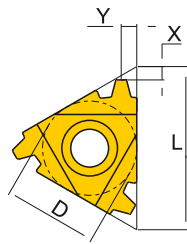


## TR-30° 标准梯形螺纹刀片 Trapeze

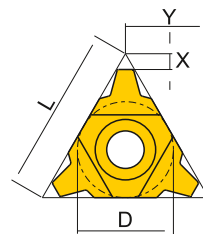
### 内螺纹 Internal



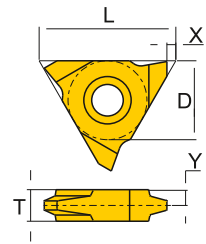
标准: DIN 103  
Defined by: DIN 103  
精度等级: 7e/7H  
Tolerance class: 7e/7H



标准型 Standard



U型 U Style



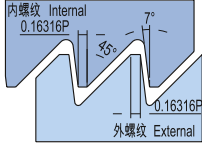
立装型 V Style

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
标准型 Standard	3/8"	1.5	16NR1.5 TR	16NL1.5 TR	16	1.0	1.1	3.65
		2.0	16NR2.0 TR	16NL2.0 TR	16	1.1	1.3	3.65
		3.0	16NR3.0 TR	16NL3.0 TR	16	1.3	1.5	3.65
	1/2"	4.0	22NR4.0 TR	22NL4.0 TR	22	1.7	1.9	4.76
		5.0	22NR5.0 TR	22NL5.0 TR	22	2.1	2.5	4.76
		6.0	27NR6.0 TR	27NL6.0 TR	27	2.2	2.6	6.35
5/8"	7.0	27NR7.0 TR	27NL7.0 TR	27	2.3	2.7	6.35	
立装型 V Style	5/8"	6.0	27VNR6.0 TR	27VNL6.0 TR	27	1.0	3.3	6.35
		7.0	27VNR7.0 TR	27VNL7.0 TR	27	1.0	3.3	6.35
		8.0	27VNR8.0 TR	27VNL8.0 TR	27	1.0	3.3	6.35
		9.0	27VNR9.0 TR	27VNL9.0 TR	27	1.0	4.3	8.70
		10.0	27VNR10.0 TR	27VNL10.0 TR	27	1.0	4.3	8.70
		12.0	27VNR12.0 TR	27VNL12.0 TR	27	1.0	5.2	10.0
U型 U Style	5/8"	8.0	27UN8.0 TR		27	2.6	13.7	6.35
		9.0	27UN9.0 TR		27	3.0	13.7	6.35

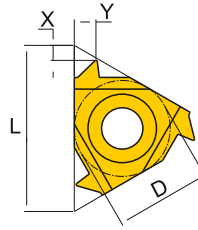
# 螺纹车削刀具 THREADING TURNING TOOLS

## ABUT美制锯齿形螺纹刀片 American Buttress

### 外螺纹 External



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

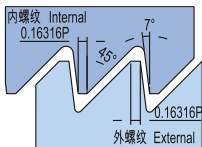


标准型 Standard

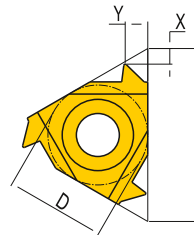


标准型 Standard	内接圆直径D	加工螺距范围 Pitch TPI	刀片型号 Ordering Code		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
			11ER20 ABUT	11EL20 ABUT	11	1.0	1.4	3.20
1/4"		20	11ER20 ABUT	11EL20 ABUT	11	1.0	1.4	3.20
		16	11ER16 ABUT	11EL16 ABUT	11	1.3	1.9	3.20
3/8"		20	16ER20 ABUT	16EL20 ABUT	16	1.0	1.4	3.65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

### 内螺纹 Internal



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



标准型 Standard

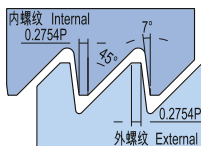


标准型 Standard	内接圆直径D	加工螺距范围 Pitch TPI	刀片型号 Designation		刀片尺寸 Dimension			
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
			11NR20 ABUT	11NL20 ABUT	11	1.0	1.4	3.20
1/4"		20	11NR20 ABUT	11NL20 ABUT	11	1.0	1.4	3.20
		16	11NR16 ABUT	11NL16 ABUT	11	1.3	1.9	3.20
3/8"		20	16NR20 ABUT	16NL20 ABUT	16	1.0	1.4	3.65
		16	16NR16 ABUT	16NL16 ABUT	16	1.3	1.9	3.65
		12	16NR12 ABUT	16NL12 ABUT	16	1.4	2.0	3.65
		10	16NR10 ABUT	16NL10 ABUT	16	1.5	2.3	3.65
1/2"		8	22NR8 ABUT	22NL8 ABUT	22	2.0	3.2	4.76
		6	22NR6 ABUT	22NL6 ABUT	22	2.2	3.5	4.76

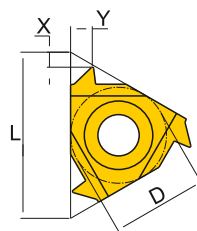


## BBUT英制锯齿形螺纹刀片 British Buttress

### 外螺纹 External



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



标准型 Standard

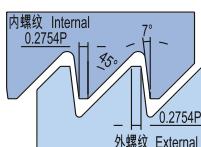


标准型  
Standard

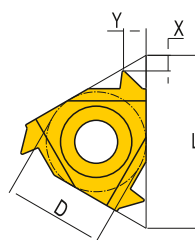


内接圆直径D	加工螺距范围 Pitch TPI	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	16	16ER16 BBUT	16EL16 BBUT	16	1.1	1.6	3.65
	12	16ER12 BBUT	16EL12 BBUT	16	1.4	2.1	3.65
	10	16ER10 BBUT	16EL10 BBUT	16	1.4	2.2	3.65
	8	16ER8 BBUT	16EL8 BBUT	16	1.6	2.5	3.65
1/2"	8	22ER8 BBUT	22EL8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

### 内螺纹 Internal



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



标准型 Standard



标准型  
Standard

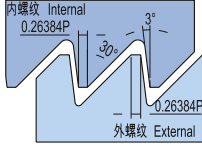


内接圆直径D	加工螺距范围 Pitch TPI	刀片型号 Designation		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	16	16NR16 BBUT	16NL16 BBUT	16	1.1	1.6	3.65
	12	16NR12 BBUT	16NL12 BBUT	16	1.4	2.1	3.65
	10	16NR10 BBUT	16NL10 BBUT	16	1.4	2.2	3.65
	8	16NR8 BBUT	16NL8 BBUT	16	1.6	2.5	3.65
1/2"	8	22NR8 BBUT	22NL8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

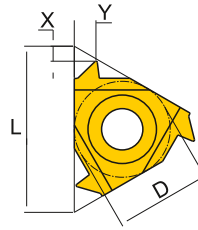
# 螺纹车削刀具 THREADING TURNING TOOLS

## SAGE公制锯齿形螺纹刀片 Sagèngewinde

### 外螺纹 External



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



标准型 Standard

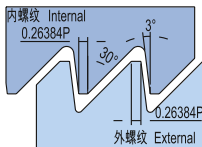


标准型  
Standard

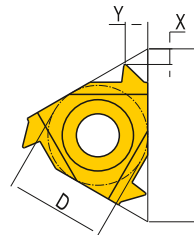


内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	2.0	16ER2.0 SAGE	16EL2.0 SAGE	16	1.47	2.08	3.65
1/2"	2.0	22ER2.0 SAGE	22EL2.0 SAGE	22	1.47	2.08	4.76
	3.0	22ER3.0 SAGE	22EL3.0 SAGE	22	1.79	2.60	4.76
5/8"	4.0	27ER4.0 SAGE	27EL4.0 SAGE	27	1.93	3.20	6.35

### 内螺纹 Internal



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



标准型 Standard



标准型  
Standard

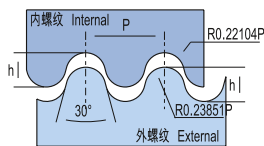


内接圆直径D	加工螺距范围 Pitch	刀片型号 Designation		刀片尺寸 Dimension			
		右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	T
3/8"	2.0	16NR2.0 SAGE	16NL2.0 SAGE	16	1.52	2.20	3.65
1/2"	3.0	22NR3.0 SAGE	22NL3.0 SAGE	22	1.66	2.90	4.76
	4.0	27NR4.0 SAGE	27NL4.0 SAGE	27	2.12	3.20	6.35

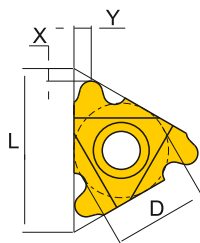


## RD消防食品机械螺纹刀片 Round DIN 405

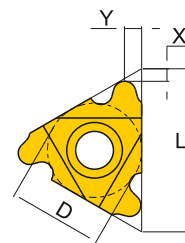
### 标准型 Standard



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



标准型 Standard



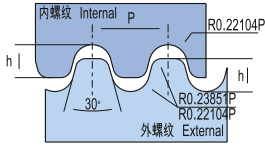
标准型 Standard

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

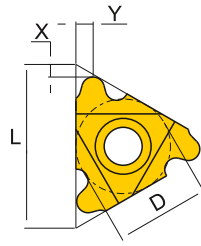
# 螺纹车削刀具 THREADING TURNING TOOLS

## RD消防食品机械螺纹刀片 Round 20400

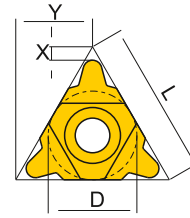
### 外螺纹 External



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



标准型 Standard



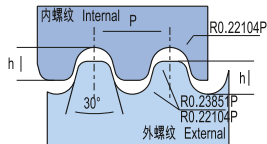
U型 U Style

	内接圆直径D	加工螺距范围 Pitch mm	刀片型号 Ordering Code		刀片尺寸 Dimension				
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	hmin	T
标准型 Standard	1/2"	3.0	22ER3.00 RD	22EL3.0 RD	22	1.28	1.70	1.65	4.76
		4.0	22ER4.00 RD	22EL4.0 RD	22	1.60	2.20	2.20	4.76
		5.0	22ER5.00 RD	22EL5.0 RD	22	1.36	1.75	2.75	4.76
		6.0	22ER6.00 RD	22EL6.0 RD	22	1.70	2.10	3.30	4.76
U型 U Style	5/8"	8.0	27UE8.00 RD		27	2.95	13.5	4.40	6.35

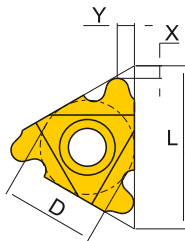


## RD消防食品机械螺纹刀片 Round 20400

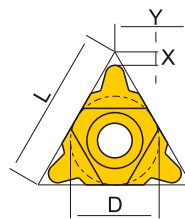
### 内螺纹 Internal



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



标准型 Standard

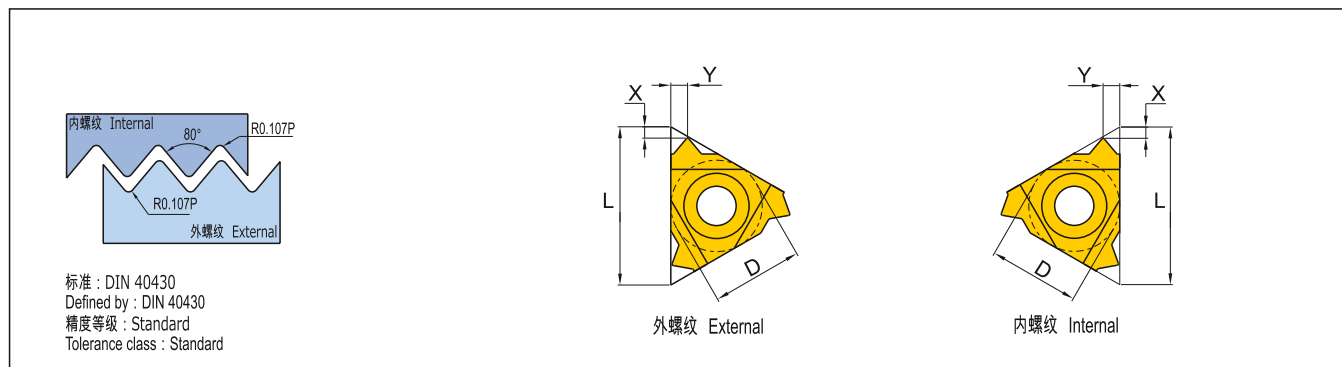


U型 U Style

	内接圆直径D	加工螺距范围 Pitch	刀片型号 Ordering Code		刀片尺寸 Dimension				
			右旋螺纹 Right Hand	左旋螺纹 Left Hand	L	X	Y	h <sub>min</sub>	T
标准型 Standard	1/2"	3.0	22ER3.00 RD	22NL3.0 RD	22	1.32	1.70	1.65	4.76
		4.0	22ER4.00 RD	22NL4.0 RD	22	1.64	2.20	2.20	4.76
		5.0	22ER5.00 RD	22NL5.0 RD	22	1.41	1.75	2.75	4.76
		6.0	22ER6.00 RD	22NL6.0 RD	22	1.75	2.10	3.30	4.76
U型 U Style	5/8"	8.0	27UN8.00 RD		27	2.95	13.50	4.40	6.35

# 螺纹车削刀具 THREADING TURNING TOOLS

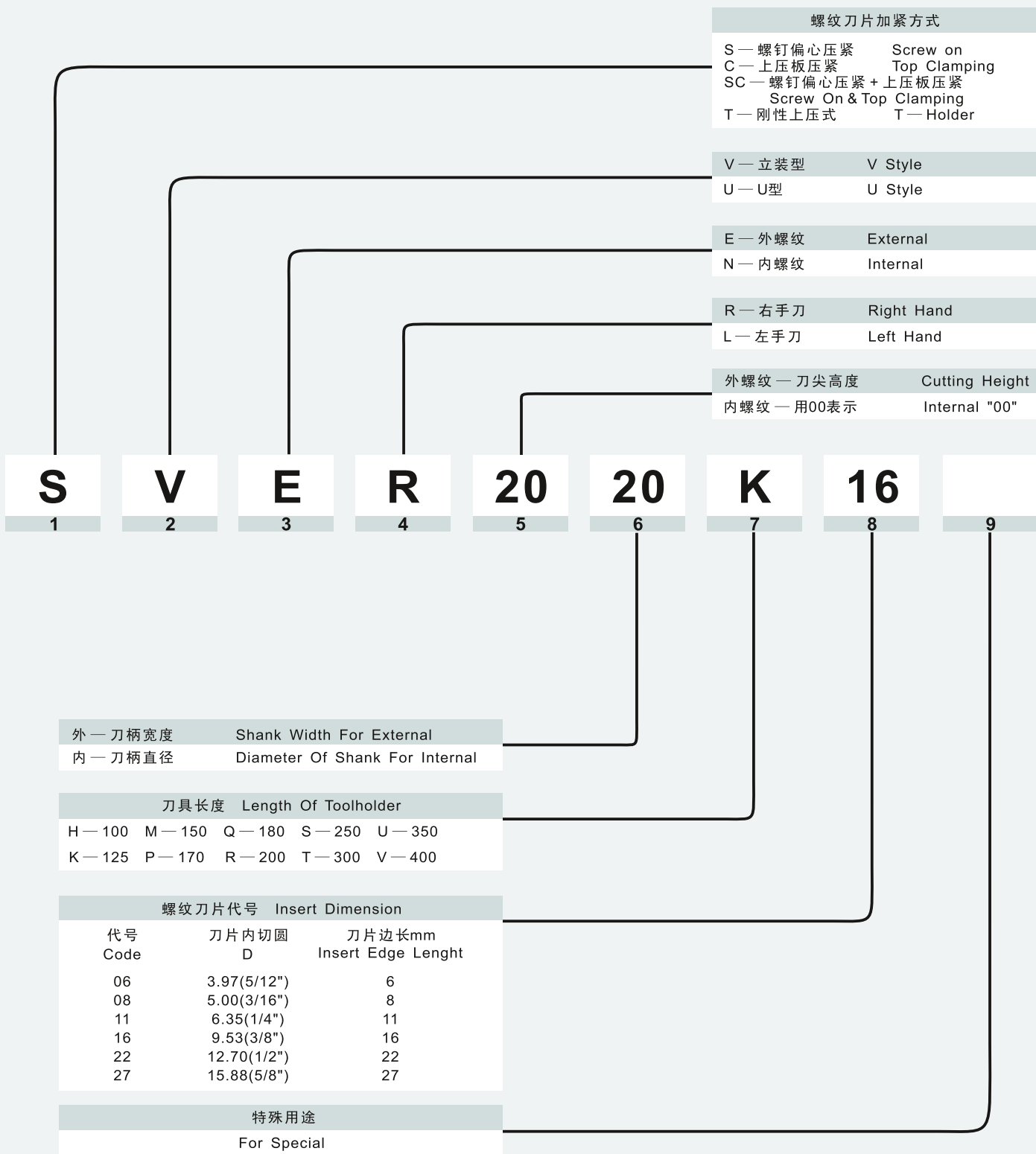
## Pg 螺纹刀片 Pg



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

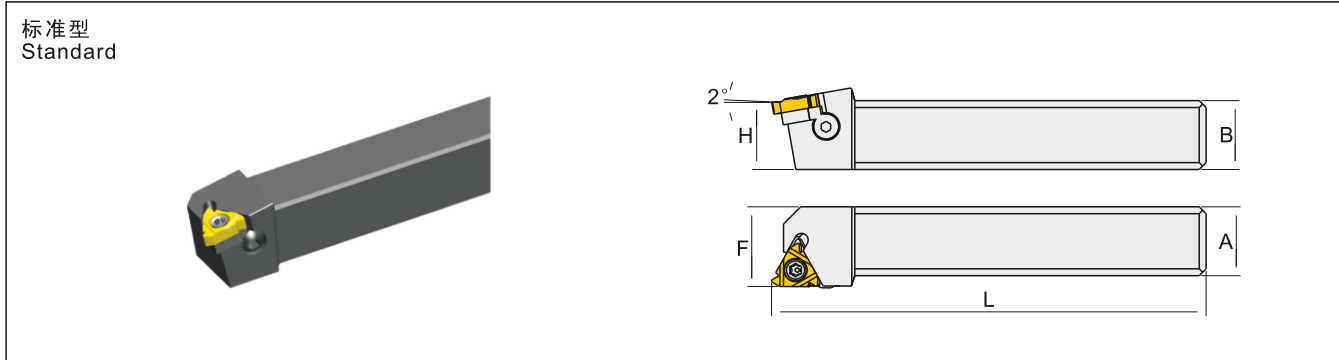


## 可转位螺纹车刀刀柄型号说明 Threading Turning Toolholder Ordering Code System



# 螺纹车削刀具 THREADING TURNING TOOLS

## 外螺纹刀杆 External Threading Toolholders



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

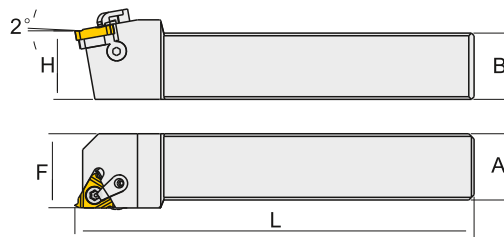
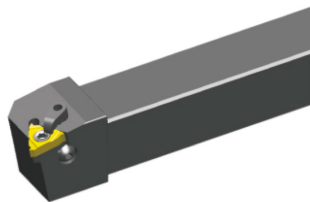
\* 刀杆带1.5°螺旋升角。如需其它螺旋升角，可以更换刀垫或订制其它相应螺旋升角的刀杆。

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



## 外螺纹刀杆 External Threading Toolholders

标准型（带压板）  
Standard with a clamp

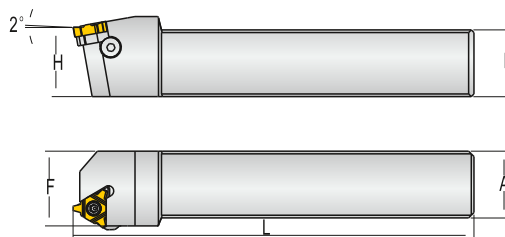
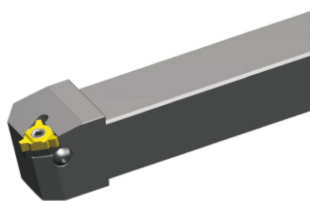


订货号 Order No.		尺寸 Dimensions (mm)											
右刀 Right	左刀 Left	H	A	B	L	F	刀片 Insert	勾头压板 Clamp	梅花扳手 Torx Key	双头螺钉 Screw	刀垫 右 R 左 L Anvil	刀垫螺钉 Anvil Screw	扳手 Wrench
CER 2020K16	CEL 2020K16	20	20	20	125	25	16ER□□□□ 16EL□□□□	CL-20	T15	XNS-48	Y16E Y16N	M3×5	1/8 S2.5
CER 2525M16	CEL 2525M16	25	25	25	150	30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

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

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

U - 型  
U - Style



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

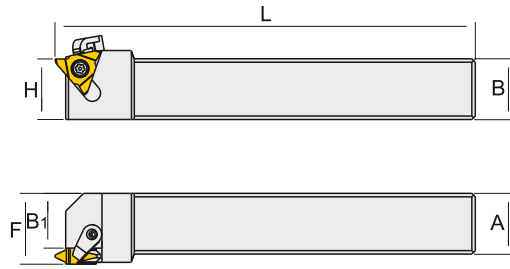
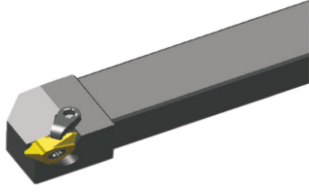
\* 刀杆带1.5°螺旋升角。如需其它螺旋升角，可以更换刀垫或订制其它相应螺旋升角的刀杆。

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

# 螺纹车削刀具 THREADING TURNING TOOLS

## 外螺纹刀杆 External Threading Toolholders

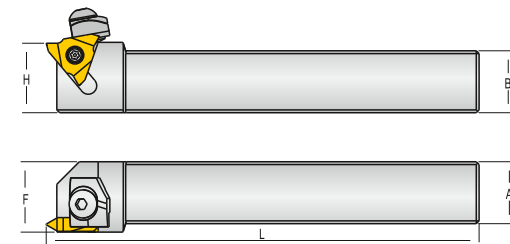
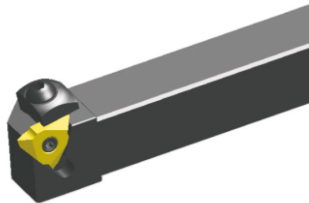
立装型  
V - Style



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

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

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

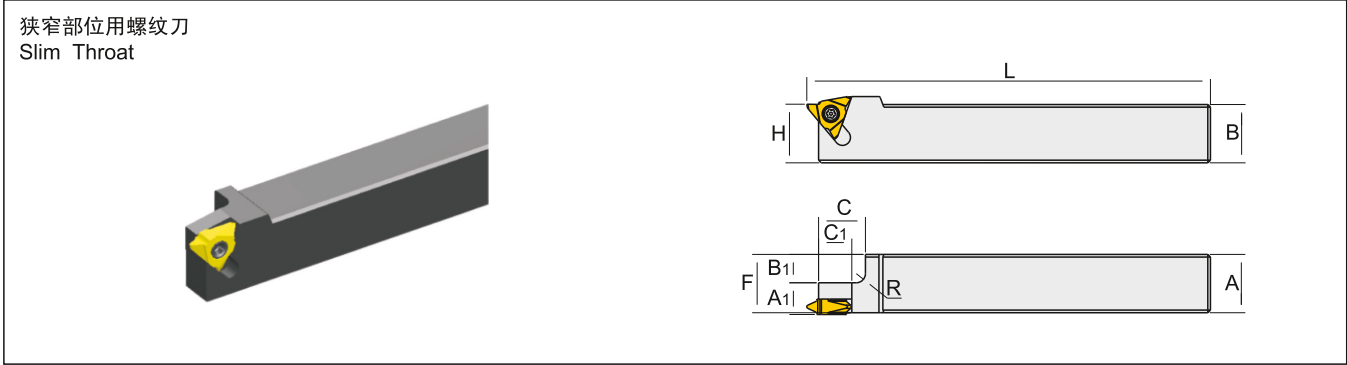





订货号 Order No.		尺寸 Dimensions (mm)											
右刀 Right	左刀 Left	H	A	B	L	F	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	压板 Clamp	弹簧 Spring	扳手 Wrench	
MTHR2525M4	MTHL2525M4	25	25	25	150	30	MTTR43□□□□	M6×16	T15	MTK1R MTK1L	MES3	S4	
MTHR3232P4	MTHL3232P4	32	32	32	170	37							
MTHR4040R4	MTHL4040R4	40	40	40	200	45							

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



## 外螺纹刀杆 External Threading Toolholders

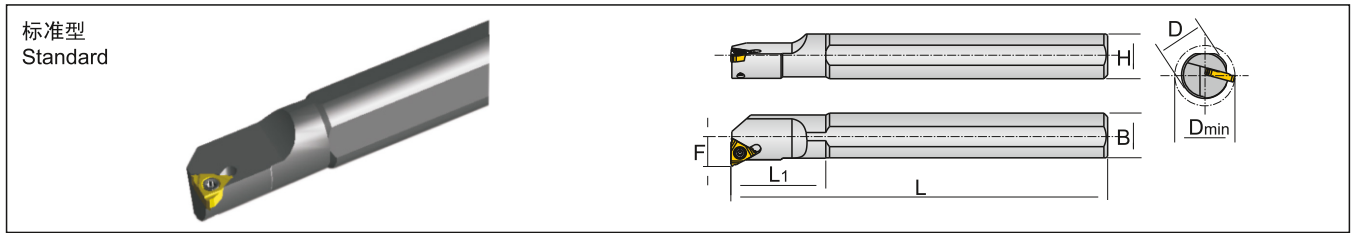


订货号 Order No.		尺寸 Dimensions (mm)												
右刀 Right	左刀 Left	H	A	B	L	F	B <sub>1</sub>	C	C <sub>1</sub>	R	A <sub>1</sub>	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key
S ER1010H16S	SEL1010H16S	14	10	10	100	10	6.4	14.5	11.5	3	7	16VER□□□□ 16VEL□□□□	M3.5×12	T15
S ER1212H16S	SEL1212H16S	14	12	12	100	12	8.4	14.5	11.5	3	7			
S ER1616H16S	SEL1616H16S	16	16	16	100	16	12.4	14.5	11.5	3	7			
S ER2020K16S	SEL2020K16S	20	20	20	125	20	16.4	16.5	11.5	3	7			
S ER2525M16S	SEL2525M16S	25	25	25	150	25	21.4	16.5	11.5	3	7			
S ER3232P16S	SEL3232P16S	32	32	32	170	32	28.4	16.5	11.5	3	7			
S ER4040R16S	SEL4040R16S	40	40	40	200	40	36.4	16.5	11.5	3	7			

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

# 螺纹车削刀具 THREADING TURNING TOOLS

## 内螺纹刀杆 Internal Threading Toolholders



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

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

## 内螺纹刀杆 Internal Threading Toolholders

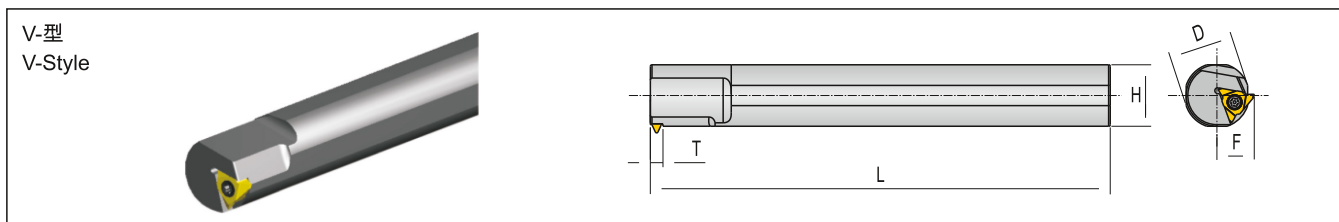


订货号 Order No.		尺寸 Dimensions (mm)										
右刀 Right	左刀 Left	D	F	L	D <sub>min</sub>	L <sub>1</sub>	刀片 Insert	梅花螺钉 Screw	梅花扳手 Torx Key	刀垫 Anvil	刀垫螺钉 Anvil Screw	扳手 Wrench
SUNR 0032S22	SUNL 0032S22	32	25.5	250	42	60	22UN□□□□	M4×14	T15	Y22U	M3×5	S2.5
SUNR 0040T22	SUNL 0040T22	40	29.5	300	51	60						
SUNR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

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



## 内螺纹刀杆 Internal Threading Toolholders



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

\* 刀杆带1.5°螺旋升角。

\* All tool holders have a 1.5° helix angle.

## 标准螺纹刀具套装 (Threading Kit)

标准螺纹刀具套装可以加工数量小但品种不同螺距的螺纹。

Threading Kits are versatile solution for users that cut a variety of thread types in limited quantity and do not want to sacrifice thread quality.

**ISO标准外螺纹套装**

**ISO External KIT Ordering**

订货号: KEG

Order NO:KEG

右刀 Right 左刀 Left

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

刀杆 TOOLHOLDER

SER 2020 K16

扳手 Wrench

T15

紧固螺钉 Screw

M3.5×12

**ISO标准内螺纹套装**

**ISO Internal KIT Ordering**

订货号: KNG

Order NO:KNG

右刀 Right 左刀 Left

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

刀杆 TOOLHOLDER

SNR 0020 P16

扳手 Wrench

T15

紧固螺钉 Screw

M3.5×12



如需25mm的刀杆, 请在订货号中加入“25”, 例如: KNG-25。

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

# 技术资料

# TECHNICAL INFORMATION

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

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

## 车削速度的选择 Choice of Cutting Speed

当选择了正确的材质后，必须再根据下表来设定其切削速度(m/min)，才能使刀片发挥应有的效果。  
右表中的切削速度是一个范围，在大多数情形下，最好先选择此范围的中间值来开始切削。

After choosing proper grade of insert, The cutting speed should be decided by the data on right form. On the right form, the cutting speed is a range. Generally We suggest. You'd better start with a mean speed.

螺纹刀片 Threading inserts	M20	P30	TP04	F605	F618
	低碳钢或中碳钢 Low,medium carbon steel	80~130	80~140	120~140	
高碳钢 High carbon steel	60~110	60~120	100~120		
合金钢或调制钢 Alloy steel or quenched and tempered steel	60~110	60~120	80~120		
不锈钢 Stainless steel	60~100		60~120		
铸钢 Cast steel	60~110	60~120	100~120		
铸铁 Cast iron	60~100		60~120		
铝合金或铜合金 Aluminium alloy,Copper alloy	90~280				
石油管螺纹刀片 Threading inserts for oil pipe	普通钢级 Low grade steel pipe J55、H40、K55、M65等			140~180	
	次高级钢级 Subhigh grade steel pipe N80、C75、L80等			120~160	140~180
	高级钢级 High grade steel pipe P110、C90、J95等				120~160

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



## 加工方法的选择 Guide to Chose Work Style

### 外螺纹加工方法 Work style of external thread

<p>右旋螺纹 Right thread</p> <p>右手刀具 Right tool</p>	<p>左旋螺纹 Left thread</p> <p>左手刀具 Left tool</p>
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### 内螺纹加工方法 Work style of internal thread

<p>右旋螺纹 Right thread</p> <p>右手刀具 Right tool</p>	<p>左旋螺纹 Left thread</p> <p>左手刀具 Left tool</p>
---	---

### 其它选项 Other option

右旋螺纹 Right thread      左旋螺纹 Left thread

下图方法用标准刀片无法修光

<p>右手刀具 Right tool</p>	<p>左手刀具 Left tool</p>
<p>左手刀具 Left tool</p>	<p>右手刀具 Right tool</p>

### 其它选项 Other option

右旋螺纹 Right thread      左旋螺纹 Left thread

下图方法用标准刀片无法修光

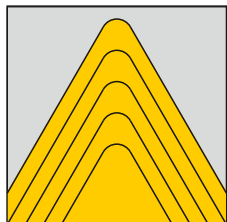
<p>左手刀具 Left tool</p>	<p>右手刀具 Right tool</p>
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注意：多数螺纹刀片，内、外刀片不能交换使用，即NR(L)一定用于内螺纹加工，ER(L)用于外螺纹加工，因为除两类刀片的牙高，刀尖圆弧不同外，内刀片为15°前角，而外刀片为10°前角。

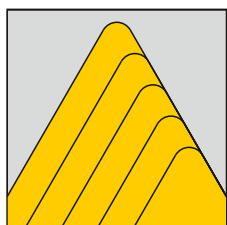
Note: Internal thread inserts must be used for machining of internal thread and external thread inserts for external thread. Don't exchange.

## 螺纹切削进刀方式选择 Choice of Cutting Style

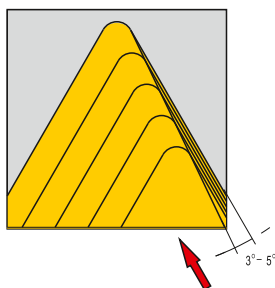
进刀方式 Cutting style



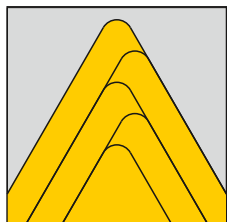
径向进刀  
Radial cutting



沿齿侧面进刀  
Cutting along side of teeth

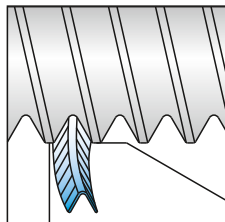


沿齿侧面进刀改进型  
Cutting along teeth side

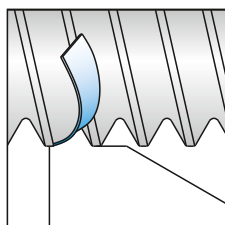


沿齿侧面交换式进刀  
Alternate cutting along teeth side

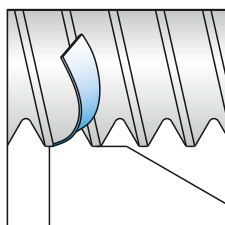
切削特征 Shape of chip



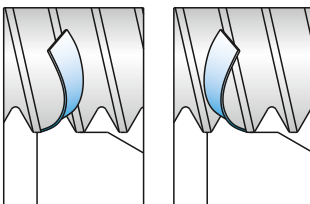
产生的V形切屑可能很难控制  
it is hard to control V shape chip



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



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



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



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

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

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

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

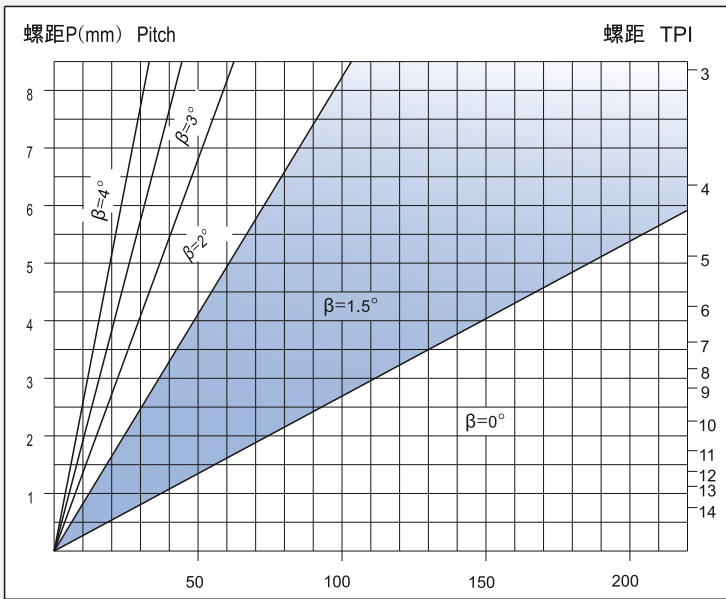
径向进给次数 Pass No.	螺距 Pitch(mm)												
	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0
14											0.07	0.07	0.08
13											0.07	0.10	0.10
12									0.06	0.07	0.08	0.10	0.10
11									0.06	0.07	0.10	0.10	0.15
10								0.06	0.07	0.08	0.10	0.10	0.15
9								0.06	0.10	0.10	0.10	0.15	0.20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

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

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

# 螺纹车削刀具 THREADING TURNING TOOLS

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



螺距中径d(mm)  
Major diameter(mm)

图1 Fig.1

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

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

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

在螺纹加工中，要求刀片的安装一定要顺着螺旋升角的方向倾斜同样的角度，如图2所示，使刀片侧后角  $\alpha_1$  尽量等于  $\alpha_2$ ，这样尽可能避免侧后刀片面与螺纹一侧的剧烈磨损而缩短刀片寿命。

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

In machining thread, the thread inserts must be fixed at an angle in the toolholder along helix angle as Fig 2. In order to improve life of the insert,  $\alpha_1$  equals  $\alpha_2$  as same as possible.

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

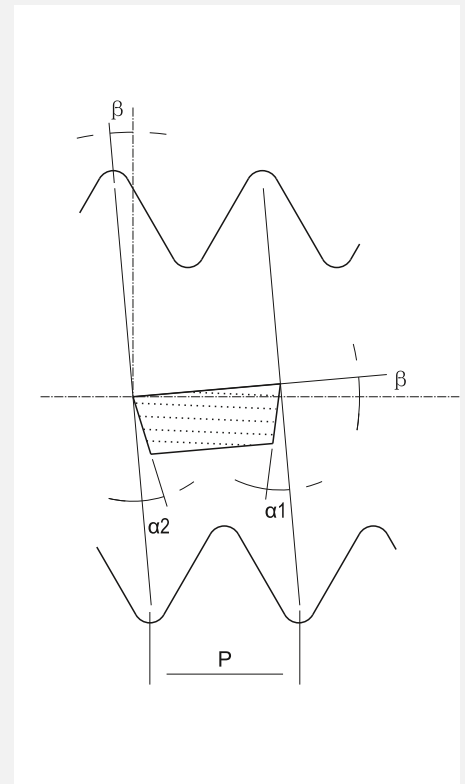
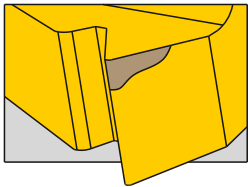
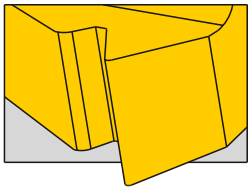
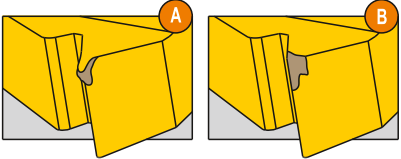


图2 Fig.2



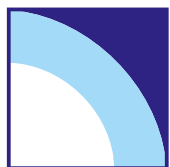
## 螺纹加工中常出现的问题及解决对策 About problems and solutions with machining thread

问题 Problems	原因 Causes	措施 Solutions
<p>侧后刀面磨损过大 Side flank wear</p> <p>螺纹侧面质量差 Bad quality of tooth side of thread</p> 	<ul style="list-style-type: none"> <li>— 侧向进刀方法不正确</li> <li>— Incorrect cutting along side of teeth</li> </ul>	<p>改变侧向进刀方法，离侧面3-5° Change to cutting along teeth side at 3-5°</p>
	<ul style="list-style-type: none"> <li>— 刀片倾斜角和螺纹螺旋角不一致</li> <li>— Incorrect helix angle of insert</li> </ul>	<p>订做相应螺旋升角的刀杆或更换带倾斜角的刀垫。 Order correct toolholder with proper helix angle and change shim with helix angle</p>
<p>振动 Vibration</p> 	<ul style="list-style-type: none"> <li>— 工作装夹不正确</li> <li>— Incorrect setting of workpiece</li> </ul>	<p>选择较软的夹头 Use soft jaws</p>
	<ul style="list-style-type: none"> <li>— 刀具安装不正确</li> <li>— Incorrect setting of toolholder</li> </ul>	<p>减少刀具悬伸长度 Reduce overhanging part of toolholder 检查刀柄夹套是否磨损 Check jacket of tool shank 使用防振刀柄 Use anti-vibration toolholder</p>
	<ul style="list-style-type: none"> <li>— 切削参数不正确</li> <li>— Incorrect cutting parameters</li> </ul>	<p>提高切削速度，如果仍不可则大大降低速度 Up or down cutting speed 使用连续恒定进刀量0.1-0.16 Chose constant cutting depth 0.1-0.16</p>
	<ul style="list-style-type: none"> <li>— 中心高不正确</li> <li>— Incorrect insert height</li> </ul>	<p>调整中心高 Change insert height</p>
<p>塑性变形 Plastic deformation</p>  <p>塑性变形开始 (A) 它将导致塑性断裂 (B) Plastic deformation (A) Will cause break (B)</p>	<ul style="list-style-type: none"> <li>— 切削区温度过高</li> <li>— Much higher temperature of cutting area</li> </ul>	<p>降低切削速度 Reduce cutting speed 增加进刀次数 Add passes 减小最大切深 Reduce cutting depth</p>
	<ul style="list-style-type: none"> <li>— 切削液不足</li> <li>— Not enough cooling</li> </ul>	<p>增加切削液 Full cooling</p>
	<ul style="list-style-type: none"> <li>— 错误的刀片材质</li> <li>— Incorrect grade of insert</li> </ul>	<p>选择耐塑性变形的刀片材料 Chose correct grade of insert</p>

# 螺纹车削刀具 THREADING TURNING TOOLS

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

问题 Problems	原因 Causes	措施 Solutions
<p>积屑瘤 (BUE) Built-up edge (BUE)</p>  <p>积屑瘤 (A) 和刃边剥落 (B) 经常混合产生，积屑瘤累积后会带着刀片材料剥落。 BUE(A) and breaks often occur together, it makes breaks on the insert edges while it comes off the insert</p>	<ul style="list-style-type: none"> <li>一切削刀具温度太低 — Too low temperature on the insert edge</li> <li>— 经常产生于不锈钢材料 — Often occur while cutting stainless steel</li> <li>— 经常产生于低碳钢材料 — Often occur while cutting low carbon Steel</li> </ul>	<p>提高切削温度 Raise cutting temperature (raise cutting speed)</p>
<p>刀片崩刃 Break of insert edge</p> 	<ul style="list-style-type: none"> <li>— 车螺纹之前的余量太大 — Too much machining allowance before cutting thread</li> </ul>	<p>正确的余量应大于最大外螺纹大径和小于内螺纹小径 (0.03-0.07mm) The proper allowance should be bigger than major diameter of external thread or smaller than minor diameter of internal thread 0.05-0.1mm</p>
	<ul style="list-style-type: none"> <li>— 进刀量过大 — Too much cutting depth</li> </ul>	<p>选择韧性更好的刀片材质 Chose better toughness grade</p>
	<ul style="list-style-type: none"> <li>— 刀片材质选错 — Incorrect grade of insert</li> <li>— 中心高不正确 — Incorrect insert height</li> </ul>	<p>增加进刀次数减少最大切深 Add passes and reduce cutting depth</p> <p>使用正确的中心高 Adjust insert height</p>
<p>后刀面磨损 Flank wear</p> 	<ul style="list-style-type: none"> <li>— 刀片不磨损 — Bad wear resistance of insert</li> </ul>	<p>选择更耐磨的刀片材质或更好的涂层 Choes better wear resistance or coated insert</p>
	<ul style="list-style-type: none"> <li>— 切削速度太高 — Too high cutting speed</li> </ul>	<p>减小切削速度 Reduce cutting speed</p>
	<ul style="list-style-type: none"> <li>— 切深太浅 — Too small cutting depth</li> <li>— 刀片中心高偏高 — Much higher insert height</li> </ul>	<p>减小进刀次数，增加每次切深 Reduce passes, increase cutting depth</p> <p>调整中心高 Adjust insert height</p>



**ИНСТРУМЕНТАЛЬНО  
ПОДШИПНИКОВАЯ  
КОМПАНИЯ**

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