DaoQin

道勤刀具

2023

金属切削刀具实用手册

Practical handbock

企业简介

Company profile

成都道勤数控刀具有限公司（四川道勤切削工具有限公司）是专业生产螺纹车削、螺纹铣削、切槽切断刀具的高新技术企业。工厂位于都江堰经济开发区，占地 30 亩，厂房 13000 平米，工厂现有全自动数控刀片磨床 100 多台、全自动周边磨床数十台，以及各种配套测量仪器 10 多台，年产达到 800 万片螺纹刀片与切槽切断刀片。道勤公司销售总部位于交通便利的西部航空枢纽城市成都市双流区，发货时效快！

公司从创业期初就一直坚持走专业路线：只生产螺纹车削刀片、螺纹铣削刀片、切槽切断刀片，坚持在这一细分领域中做到最大最强，是道勤公司坚定不移的发展路线。不忘初心，方得始终！

Daoqin tools Ltd. is a professional tech company which is specialized inmanufacturing threading,thread milling,grooving,parting tools,Our factory is located in Dujiangyan economic development zone, covering an area of 17,333 square meters, with a workshop of 13,000 square meters,we have more than 100 sets grinders for automatic CNC inserts ,Dozens sets grinders for Full-automatic peripheral grinding tools,and more than 10 sets variety of supporting measuring instruments ,Annual output for threading,grooving inserts reaches more than 8 million.

Company headquarters is located in Shuangliu,chengdu city which is convenient traffic,fast delivery time!We always insist on taking the professional route: only manufacturing threading,threading milling,grooving ,parting tools,Becoming the biggest and strongest is our unswerving development line!

Never forget why you started, and your mission can be accomplished!

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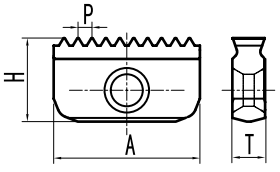
螺纹铣刀片 Thread Milling Inserts

型号 Model	A (mm)	H (mm)	T (mm)
12N**	12	6	2.38
14**	14	7.5	3.1
21**	21	12	4.7
30**	30	16	5.5
40**	40	20	6.3

☺ 优先推荐 Good recommendation

☹ 一般推荐 General recommendation

材质推荐 material recommended						
钢	P	☺				
不锈钢	M	☺				
铸铁	K	☺				
有色金属	N		☺			



图示为双面使用

刀片 Insert	内螺纹刀片 Internal	外螺纹刀片 External	螺距 pitch mm	BR215 N	BR215 E	DK110 N	DK110 E					配套 刀杆/刀盘 Insert Toolholder
单面使用 SINGLE SIDE USE	12N0.5ISO		0.5	●		○						SR0010H12（单刃）
	12N0.75ISO		0.75	●		○						
	12N1.0ISO		1.0	●		●						
	12N1.25ISO		1.25	●		○						
	12N1.5ISO		1.5	●		●						
双面使用 DOUBLE-SIDE USE	14N0.5ISO	14E0.5ISO	0.5	●	●	○						SR0012F14（单刃） SR0014H14（单刃） SR0017H14（单刃） SR0020G14-2（双刃） SR0020J14-2（双刃）
	14N0.75ISO	14E0.75ISO	0.75	●	●	○						
	14N1.0ISO	14E1.0ISO	1.0	●	●	●						
	14N1.25ISO	14E1.25ISO	1.25	●	●	○						
	14N1.5ISO	14E1.5ISO	1.5	●	●	●						
	14N2.0ISO	14E2.0ISO	2.0	●	●	●						
	14N2.5ISO	14E2.5ISO	2.5	●	●	●						
	21N1.0ISO	21E1.0ISO	1.0	●	●	○						SR0018H21（单刃） SR0021H21（单刃） SR0025K21（单刃） SR0030J21-2（双刃） SR0030L21-2（双刃） SR0063C21-5（刀盘）
	21N1.5ISO	21E1.5ISO	1.5	●	●	●						
	21N1.75ISO	21E1.75ISO	1.75	●	○	○						
	21N2.0ISO	21E2.0ISO	2.0	●	●	●						
	21N2.5ISO	21E2.5ISO	2.5	●	●	●						
	21N3.0ISO	21E3.0ISO	3.0	●	●	●						
	21N3.5ISO		3.5	●		○						
	30N1.5ISO	30E1.5ISO	1.5	●	●	○						SR0029J30（单刃） SR0031M30（单刃） SR0038M30（单刃） SR0040L30-2（双刃） SR0040P30-2（双刃） SR0063C30-4（刀盘）
	30N2.0ISO	30E2.0ISO	2.0	●	●	○						
	30N2.5ISO	30E2.5ISO	2.5	●	●	○						
	30N3.0ISO	30E3.0ISO	3.0	●	●	○						
	30N3.5ISO	30E3.5ISO	3.5	●	○	○						
	30N4.0ISO	30E4.0ISO	4.0	●	○	○						
	30N4.5ISO		4.5	●		○						
	30N5.0ISO		5.0	●	○	○						
	40N1.5ISO	40E1.5ISO	1.5	●	○	○						SR0040M40（单刃） SR0038Q40（单刃） SR0048R40（单刃） SR0050M40-2（双刃）
	40N2.0ISO	40E2.0ISO	2.0	●	○	●						
	40N3.0ISO	40E3.0ISO	3.0	●		○						
	40N3.5ISO		3.5	●	○	○						
	40N4.0ISO	40E4.0ISO	4.0	●		○						
	40N4.5ISO		4.5	●	○	○						
	40N5.0ISO	40E5.0ISO	5.0	●		○						
	40N5.5ISO		5.5	●		○						
	40N6.0ISO		6.0	●								

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

螺纹铣刀片 Thread Milling Inserts

型号 Model	A (mm)	H (mm)	T (mm)
12**	12	6	2.38
14**	14	7.5	3.1
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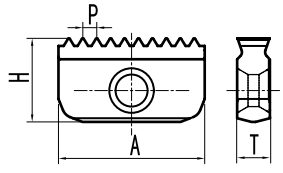
材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	☺		
有色金属	N		☺	



图示为双面使用

刀片 Insert	内螺纹刀片 Internal	外螺纹刀片 External	螺距 pitch tpi	BR215 N	BR215 E	DK110 N	DK110 E	配套 刀杆/刀盘 Insert Toolholder
单面使用 SINGLE SIDE USE	12N32UN		32	○		○		SR0010H12（单刃）
	12N28UN		28	○		○		
	12N24UN		24	○		○		
	12N20UN		20	○		○		
	12N18UN		18	●		○		
	12N16UN		16	○		○		
双面使用 DOUBLE-SIDE USE	14N32UN	14E32UN	32	○		○		SR0012F14（单刃） SR0014H14（单刃） SR0017H14（单刃） SR0020G14-2（双刃） SR0020J14-2（双刃）
	14N28UN		28	○		○		
	14N27UN		27	○		○		
	14N24UN	14E24UN	24	●	○	○		
	14N20UN	14E20UN	20	●	○	○		
	14N18UN	14E18UN	18	●	○	○		
	14N16UN	14E16UN	16	●	○	○		
	14N14UN	14E14UN	14	●	○	○		
	14N12UN	14E12UN	12	●	○	○		
	14N11UN		11	○		○		
	14N10UN		10	○		○		
	21N24UN	21E24UN	24	●	○	○		SR0018H21（单刃） SR0021H21（单刃） SR0025K21（单刃） SR0030J21-2（双刃） SR0030L21-2（双刃） SR0063C21-5（刀盘）
	21N20UN	21E20UN	20	●	○	○		
	21N18UN	21E18UN	18	●	○	○		
	21N16UN	21E16UN	16	●	○	○		
	21N14UN	21E14UN	14	●	○	○		
	21N12UN	21E12UN	12	●	○	○		
	21N10UN	21E10UN	10	●	○	○		
	21N8UN		8	●		○		
	21N7UN		7	●		○		
	30N20UN	30E20UN	20	○	○	○		SR0029J30（单刃） SR0031M30（单刃） SR0038M30（单刃） SR0040L30-2（双刃） SR0040P30-2（双刃） SR0063C30-4（刀盘）
	30N18UN	30E18UN	18	○	○	○		
	30N16UN	30E16UN	16	○	○	○		
	30N14UN	30E14UN	14	○	○	○		
	30N12UN	30E12UN	12	○	○	○		
	30N10UN	30E10UN	10	○	○	○		
	30N8UN	30E8UN	8	●	○	○		
	30N6UN	30E6UN	6	○	○	○		
	30N5UN	30E5UN	5	○	○	○		
	40N16UN	40E16UN	16	○	○	○		SR0040M40（单刃） SR0038Q40（单刃） SR0048R40（单刃） SR0050M40-2（双刃）
	40N14UN	40E14UN	14	○	○	○		
	40N12UN	40E12UN	12	○	○	○		
	40N10UN	40E10UN	10	○	○	○		
	40N8UN	40E8UN	8	●	○	○		
	40N6UN	40E6UN	6	○	○	○		
	40N4.5UN		4.5	○		○		
	40N4UN		4	○		○		

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

螺纹铣刀片 Thread Milling Inserts

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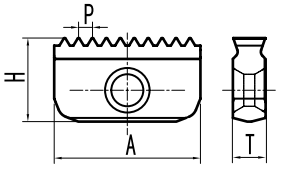
材质推荐 material recommended						
钢	P	☺				
不锈钢	M	☺				
铸铁	K	☺				
有色金属	N		☺			



图示为双面使用

刀片 Insert		内/外螺纹刀片 INDISCRIMINATE INTERNAL AND EXTERNAL	螺距 pitch tpi	BR215	DK110			配套 刀杆/刀盘 Insert Toolholder
单面使用 SINGLE SIDE USE	内、外螺纹都是用同样型号刀片加工 same insert to process external and internal thread	12-19W	19	●	○			SR0010H12（单刃）
双面使用 DOUBLE-SIDE USE		14-24W	24	●	○			SR00**14（单刃） SR0020*14-2（双刃）
		14-20W	20	●	○			
		14-19W	19	●	○			
		14-16W	16	●	○			
		14-14W	14	●	○			
		14-11W	11	●	○			
		21-20W	20	○	○			SR00**21（单刃） SR0030*21-2（双刃） SR0063C21-5（刀盘）
		21-19W	19	●	○			
		21-16W	16	●	○			
		21-14W	14	●	○			
		21-11W	11	●	○			
		30-16W	16	○	○			SR00**30（单刃） SR0040*30-2（双刃） SR00**30-4（刀盘）
		30-14W	14	○	○			
		30-11W	11	●	○			
		40-11W	11	○	○			SR00**40（单刃） SR0050M40-2（双刃） SR00**40-4（刀盘）
		40-8W	8					

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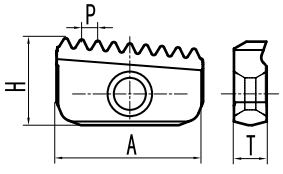

刀片 Insert		内/外螺纹刀片 INDISCRIMINATE INTERNAL AND EXTERNAL	螺距 pitch tpi	BR215	DK110			配套 刀杆/刀盘 Insert Toolholder
单面使用 SINGLE SIDE USE	内、外螺纹都是用同样型号刀片加工 same insert to process external and internal thread	12-19BSPT	19	○	○			SR00**12（单刃）
		14-19BSPT	19	●	○			SR00**14（单刃）
		14-14BSPT	14	●	○			SR0020*14-2（双刃）
		21-14BSPT	14	●	○			SR00**21（单刃）
		21-11BSPT	11	●	○			SR0030*21-2（双刃）
								SR0063C21-5（刀盘）
		30-11BSPT	11	●	○			SR00**30（单刃）
								SR0040*30-2（双刃）
								SR00**0-4（刀盘）
		40-11BSPT	11					SR00**40（单刃）
								SR0050M40-2（双刃）
								SR00**40-4（刀盘）

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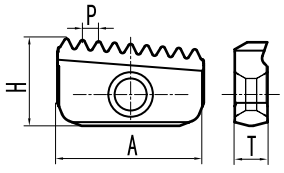
铸铁	K	☺				
有色金属	N		☺			



刀片 Insert		内/外螺纹刀片 INDISCRIMINATE INTERNAL AND EXTERNAL	螺距 pitch tpi	BR215	DK110			配套 刀杆/刀盘 Insert Toolholder
单面使用 SINGLE SIDE USE	内、外螺纹都是用同样型号刀片加工 same insert to process external and internal thread	12-18NPT	18	●	○			SR00**12（单刃）
		14-18NPT	18	●	○			SR00**14（单刃） SR0020*14-2（双刃）
		14-14NPT	14	●	○			
		21-14NPT	14	●	○			SR00**21（单刃） SR0030*21-2（双刃） SR0063C21-5（刀盘）
		21-11.5NPT	11.5	●	○			
		30-11.5NPT	11.5	●	○			SR00**30（单刃） SR0040*30-2（双刃） SR00**30-4（刀盘）
		30-8NPT	8	●	○			
		40-11.5NPT	11.5					SR00**40（单刃） SR0050M40-2（双刃） SR00**40-4（刀盘）
		40-8NPT	8					

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

螺纹铣刀片 Thread Milling Inserts

DIN40430

型号 Model	A (mm)	H (mm)	T (mm)
12**	12	6	2.38
14**	14	7.5	3.1
21**	21	12	4.7
30**	30	16	5.5
40**	40	20	6.3

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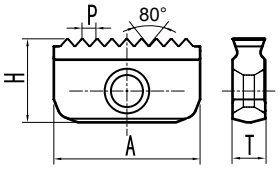
😐 一般推荐 General recommendation

材质推荐 material recommended						
钢	P	☺				
不锈钢	M	☺				
铸铁	K	☺				
有色金属	N		☺			



刀片 Insert		内/外螺纹刀片 Internal & External	螺距 pitch tpi	BR215	DK110			配套 刀杆/刀盘 Insert Toolholder
双面使用 DOUBLE-SIDE USE	内、外螺纹都是用同样型号刀片加工 same insert to process external and internal thread	14-18Pg	18	●				SR00**14（单刃） SR0020*14-2（双刃）
		21-18Pg	18					SR00**21（单刃） SR0030*21-2（双刃） SR0063C21-5（刀盘）
		21-16Pg	16	●				
		30-16Pg	16					SR00**30（单刃） SR0040*30-2（双刃） SR00**30-4（刀盘）

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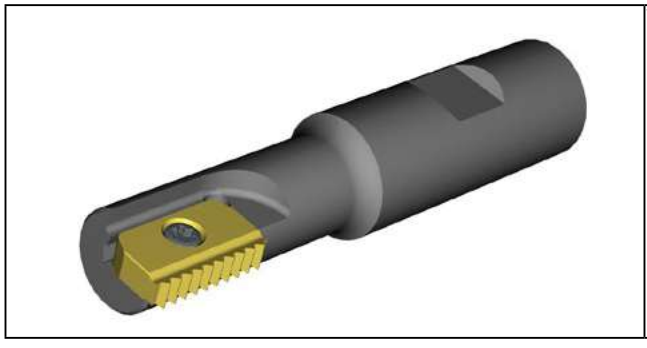
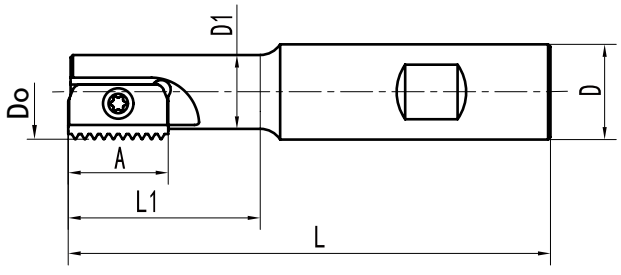
螺纹铣刀杆 - 单刃型 Single insert toolholders



削平型刀具形式 （DIN1835-B） 见 P18

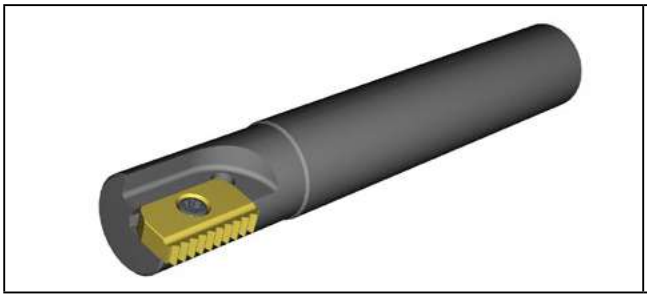


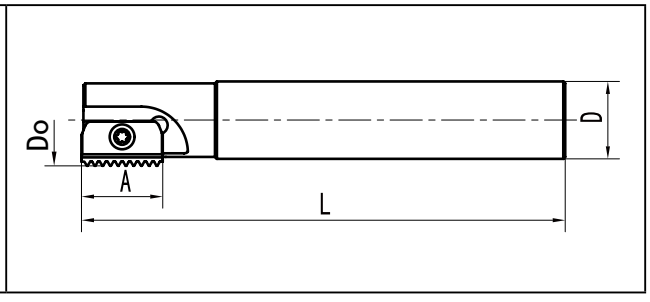
刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)						刀片螺钉 Insert Screw	扳手 Torx Key
		Do	L1	D	D1	L	A		
SR0010H12	12N**	9.5	20	16	7.6	85	12	L60M2.5x6	T-8
SR0012F14	14N/E**	12	23	20	8.9	80	14	L60M3*6.5	T-8
SR0014H14		14.5	26	20	11.2	85	14	L60M3*8	T-10
SR0017H14		17	35	20	13.4	85	14	L60M3*8	T-10
SR0018H21	21N/E**	18	35	20	13.8	85	21	L60M3.5*8	T-15
SR0021H21		21	44	20	15.5	94	21	L60M3.5*10	T-15
SR0029J30	30N/E**	29	52	25	22	110	30	L60M4*0.5*11.5	T-15
SR0048M40	40N/E**	48	83	40	35	153	40	L60M5*0.8*14	T-20

*SR0018H21 刀杆不能装配 :21N/E3.5ISO、21N/E7UN、21N/E8UN、21-11BSPT、21-11.5NPT

可以订购内却孔刀杆，在刀杆型号后面加“-OH”，如 SR0017H14-OH

加长螺纹铣刀杆 – 单刃型 Single insert toolholders-extra lengthen

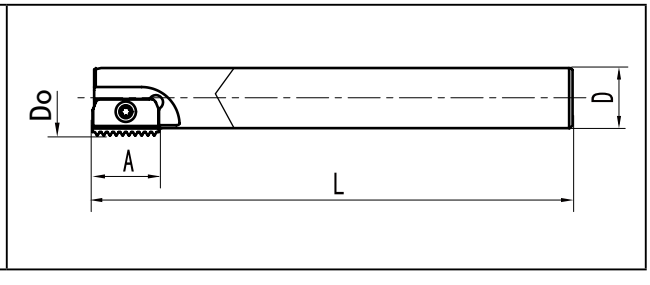




刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)				刀片螺钉 Insert Screw	扳手 Torx Key
		Do	D	L	A		
SR0025K21	21N/E**	25	20	125	21	L60M3.5x10	T-15
SR0031M30	30N/E**	31	25	150	30	L60M4*0.5*11.5	T-15
SR0038M30		38	32	150	30	L60M4*0.5*11.5	T-15
SR0038Q40	40N/E**	38	32	180	40	L60M5*0.8*14	T-20
SR0048R40		48	40	210	40	L60M5*0.8*14	T-20

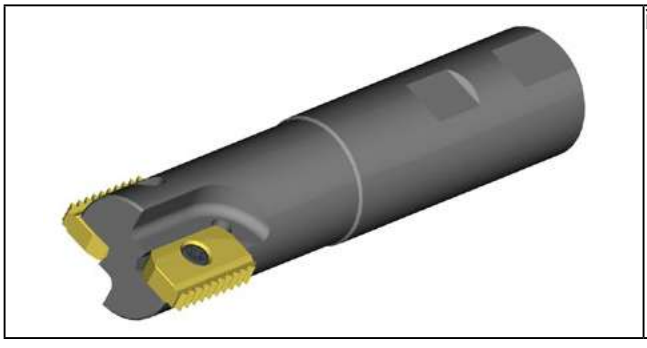
可以订购内却孔刀杆，在刀杆型号后面加“-OH”，如 SR0025K21-OH

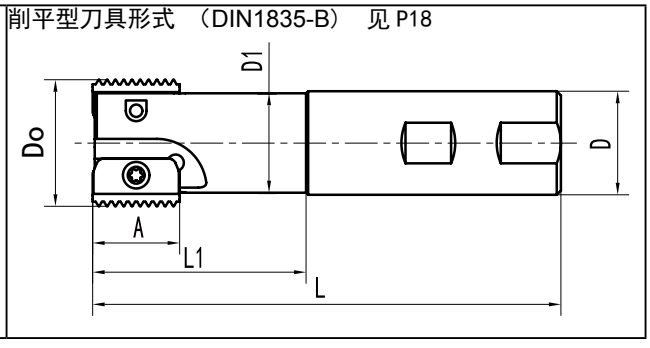
螺纹铣刀杆 – 硬质合金抗震型 Carbide anti-seismic style



刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)				刀片螺钉 Insert Screw	扳手 Torx Key
		Do	D	L	A		
SR0010K12-WH	12N**	9.9	8	125	12	L60M2.5x6	T-8
SR0013J14-WH	14N**	13.2	10	110	14	L60M3*6.5	T-10
SR0013M14-WH		13.2	10	150	14	L60M3*6.5	T-10
SR0015P14-WH		15.2	12	175	14	L60M3*8	T-10
SR0021R21-WH	21N**	21.0	16	200	21	L60M3.5*10	T-15
SR0027Q30-WH	30N/E**	27.0	20	180	30	L60M4*0.5*11.5	T-15
SR0027S30-WH		27.0	20	270	30	L60M4*0.5*11.5	T-15

螺纹铣刀杆 - 双刃型 Twin insert toolholders

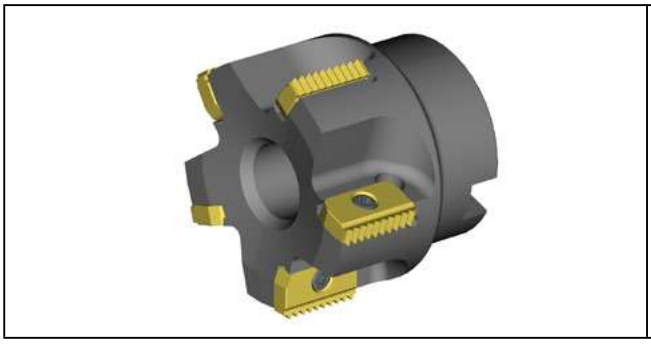


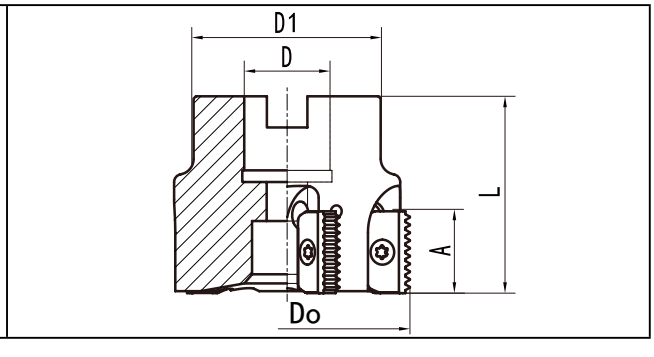


刀杆型号 Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)						刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L1	D	D1	L	A		
SR0020G14-2	14N/E**	2	20	37	20	16	93	14	L60M3x7	T-10
SR0020J14-2		2	20	57	20	16	113	14	L60M3*7	T-10
SR0030J21-2	21N/E**	2	30	52	25	24	113	21	L60M3.5*10	T-15
SR0030L21-2		2	30	80	25	24	140	21	L60M3.5*10	T-15
SR0040L30-2	30N/E**	2	40	70	32	30	135	30	L60M4*0.5*11.5	T-15
SR0040P30-2		2	40	103	32	30	170	30	L60M4*0.5*11.5	T-15
SR0050M40-2	40N/E**	2	50	80	40	38	153	40	L60M5*0.8*14	T-20

可以订购内却孔刀杆，在刀杆型号后面加“-OH”，如 SR0030L21-2-OH

螺纹铣刀盘 Threading milling toolholders





刀杆型号 Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
			Do	D	D1	L	A		
SR0063C21-5	21N/E**	5	63	22	48	50	21	L60M3.5x10	T-15
SR0063C30-4	30N/E**	4	63	22	48	50	30	L60M4*0.5*11.5	T-15
SR0080D30-4		4	80	27	60	55	30	L60M4*0.5*11.5	T-15
SR0100D30-4		4	100	32	78	60	30	L60M4*0.5*11.5	T-15
SR0080D40-4	40N/E**	4	80	27	60	65	40	L60M5*0.8*14	T-20
SR0100E40-4		4	100	32	78	70	40	L60M5*0.8*14	T-20

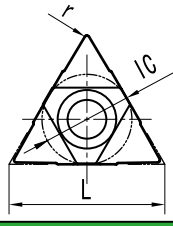
可以订购内却孔刀盘，在刀杆型号后面加“-OH”，如 SR0063C21-5-OH

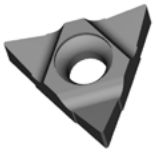
60° – 深孔螺纹铣刀片 Thread Milling Inserts (U-Style)

型号 Model	L (mm)	IC (mm)
11**	11	6.35
16**	16	9.525
22**	22	12.7

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐					
钢	P	☺			
不锈钢	M	☺			
铸铁	K	😐			
有色金属	N		☺		



刀片 Insert	内螺纹刀片 Internal	螺距 pitch mm	螺距 pitch tpi	圆弧 r	DM215	DK110		配套 刀杆/刀盘 Insert Toolholder
	11UIDA60	0.5-2.0	48-12	0.04	○			SMT**-**11U-*
	11UIDD60	1.5-3.0	16-8	0.11	○			
	11UIDC60	2.0-4.0	12-6	0.14	●	○		
	16UIDE60	1.75-3.5	16-7	0.11	●	○		SMT**-**16U-*
	16UIDH60	3.0-6.0	8-4	0.24	●	○		
	22UIDK60	6.0-8.0	4-3		●	○		SMT**-**22U-*
	11UIDC60-N	2.0-4.0	12-6	0.14	●	●		SMT**-**11U-*
	16UIDH60-N	3.0-6.0	8-4	0.24	●	●		SMT**-**16U-*

* 其他螺纹标准接受订制：标准牙距、梯形螺纹、圆螺纹等

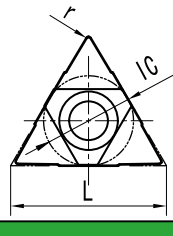
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

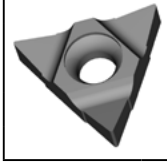
55° – 深孔螺纹铣刀片 Thread Milling Inserts (U-Style)

型号 Model	L (mm)	IC (mm)
11**	11	6.35
16**	16	9.525
22**	22	12.7

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐					
钢	P	☺			
不锈钢	M	☺			
铸铁	K	😐			
有色金属	N		😐		

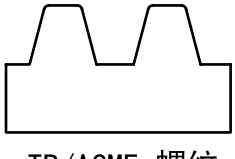


刀片 Insert	内螺纹刀片 Internal	螺距 pitch mm	螺距 pitch tpi	圆弧 r	DM215	DK110		配套 刀杆/刀盘 Insert Toolholder
	11UIDL55	1.5-3.5	28-7	0.13	●	○		SMT**-**11U-*
	16UIDL55	2.5-3.5	11-7	0.24	●	○		SMT**-**16U-*
	16UIDH55	3.5-6.0	14-4.5	0.25	●	○		SMT**-**16U-*
	22UIDK55	6.0-8.5	5-3					SMT**-**22U-*

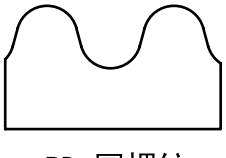
* 其他螺纹标准接受订制：标准牙距、梯形螺纹、圆螺纹等

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

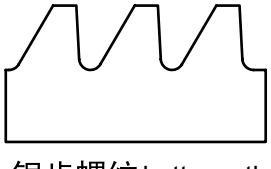
可以定制其他形式螺纹：
Other thread type can be customized:



TR/ACME 螺纹



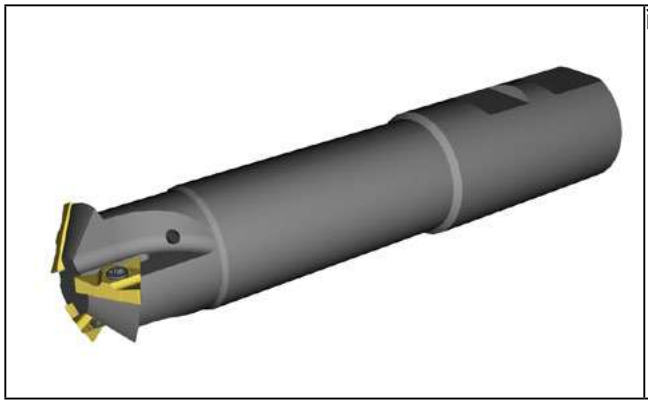
RD 圆螺纹

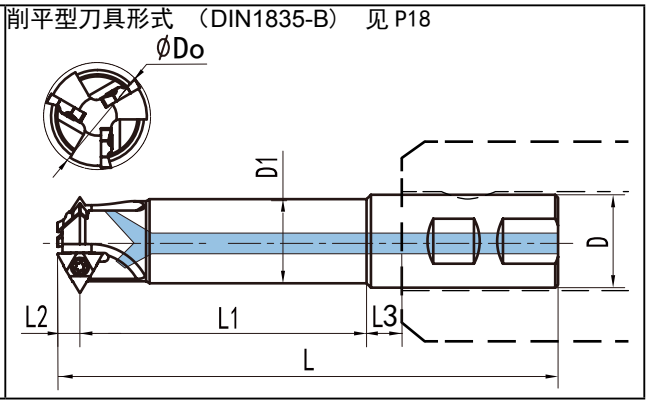


锯齿螺纹 buttress thread

● ● ●

深孔螺纹铣刀杆 – 标准型（内冷） Threading milling toolholders



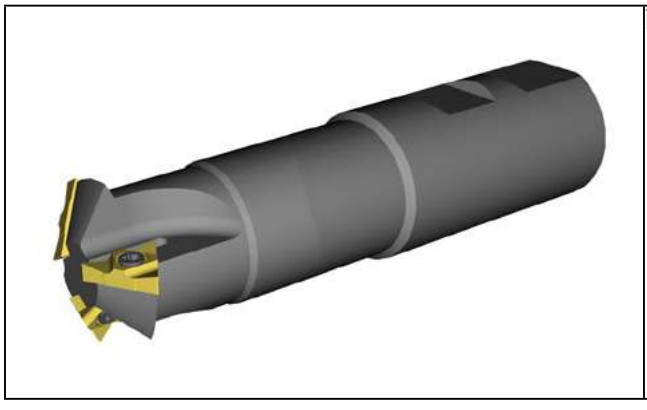


刀杆型号 New Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L1	L2	L3	D	D1	L		
SMT15-16H11U-1C	11UI**	1	14.75	40	5.4	7.6	16	11	100	L60M2.5*8	T-8
SMT17-16H11U-1C	11UI**		17	50		5.6	16	13	108		
SMT19-20K11U-1C	11UI**		19	58		8.6	20	14	121		
SMT21-25K11U-2C	11UI**	2	21	60		5.6	25	16	125		
SMT23-25L11U-2C	11UI**		23	70		10.6		17.7	140		
SMT26-25M11U-3C	11UI**	3	26	80		10.6		20	150		
SMT26-25P11U-3C	11UI**			110		0.6			170		
SMT29-25M11U-3C	11UI**		29	90		0.6		23	150		
SMT31-32P11U-4C	11UI**	4	31	95		11.6	32	25	170		
SMT36-32P16U-3C	16UI**	3	36.5	95	8	9		29	170	L60M3.5*10	T-15
SMT42-40R16U-4C	16UI**	4	42	120		4	40	34.2	200		
SMT42-40S16U-4C	16UI**			160		14			250		
SMT48-40T16U-4C	16UI**		48	190		34		39.2	300		
SMT50-40T22U-4C	22UI**	4	50	190	11	41	40	39	300	L60M4.5*14	T-20

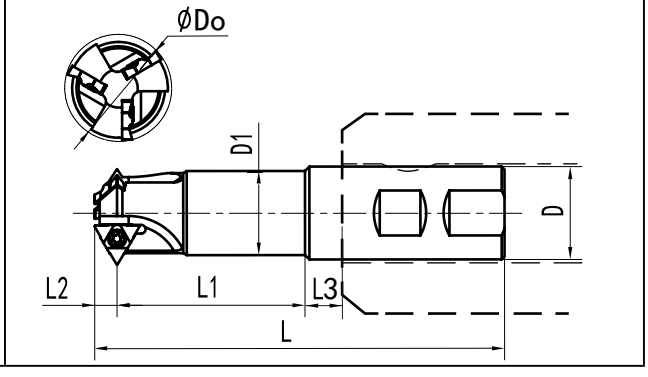
注：可以定制不带冷却水孔的刀杆，刀杆型号为去掉末尾字符“C”

Note: the tool bar without cooling water hole can be customized. The tool bar model is to remove the end character "C".

螺纹铣刀杆 – 高刚性　Threading milling toolholders



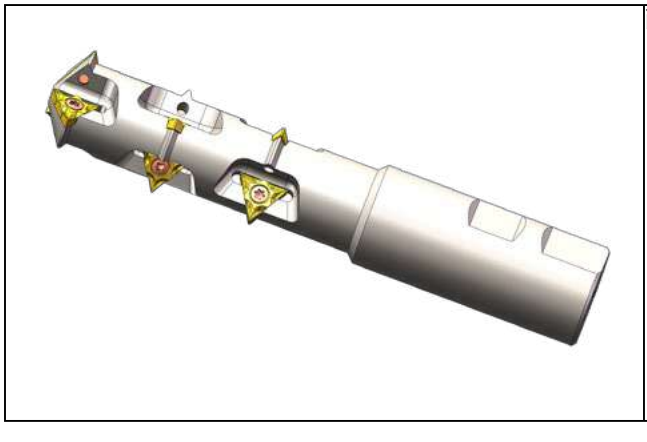
削平型刀具形式 （DIN1835-B） 见 P18



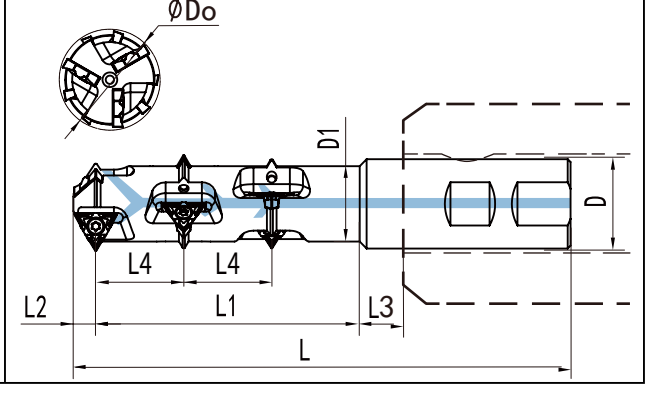
刀杆型号 New Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L1	L2	L3	D	D1	L		
SMT15-16H11U-1	11UI**	1	14.75	40	5.4	7.6	16	11	100	L60M2.5*8	T-8
SMT17-16H11U-1	11UI**	1	17	50		5.6	16	13	108		
SMT21-25H11U-2	11UI**	2	21	40		5.6	25	16	105		
SMT26-25K11U-3	11UI**	3	26	60		5.6	25	20	125		
SMT26-25M11U-3	11UI**	3	26	80		10.6	25	20	150		
SMT31-32M11U-4	11UI**	4	31	75		11.6	32	25	150		
SMT36-32M16U-3	16UI**	3	36.5	75	8	9	32	29	150	L60M3.5*10	T-15
SMT42-40P16U-4	16UI**	4	42	90		4	40	34.2	170		

此系列刀杆无内通水冷却功能 No internal water hole

深孔螺纹铣刀杆 – 多排齿系列　Threading milling toolholders



削平型刀具形式 （DIN1835-B） 见 P18

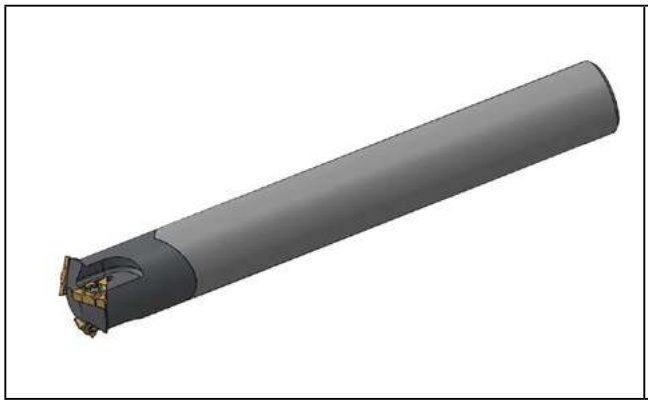


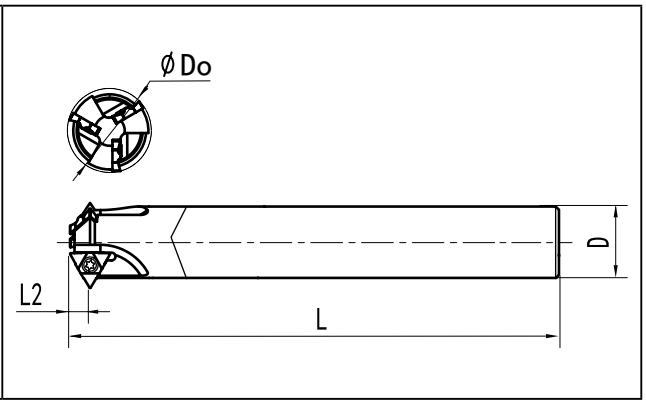
刀杆型号 New Toolholder Type	刀片型号 Insert Type	螺距 TPI	排数	刃数 No. of insert	尺寸 Dimensions (mm)								刀片螺钉 Insert Screw	扳手 Torx Key
					Do	L1	L2	L3	L4	D	D1	L		
SMT26-25P11U-24/3-2*3C	11UI**	3	2	3	26	80	5.4	34.6	24	25	20	170	L60M2.5*8	T-8
SMT36-32P16U-32/4-3*3C	16UI**	4	3	3	36.5	100	8	4	32	32	29	170	L60M3.5*10	T-15

此系列刀杆按需定制生产，不作常备库存，可根据需求定制各项尺寸

This series of tool bars are not in stock and can be customized according to the order requirements

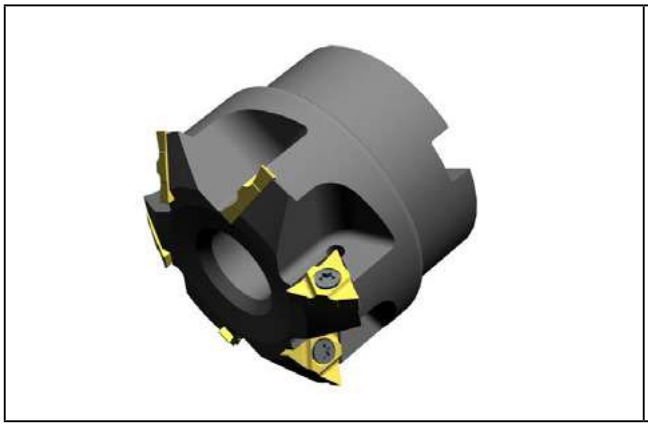
螺纹铣刀杆 – 硬质合金杆 carbide anti-seismic style

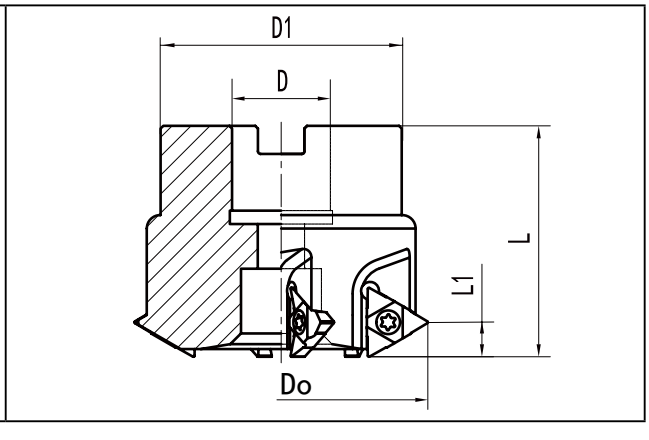




刀杆型号 New Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)				刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L2	D	L		
SMT21-14L11U-2-WH	11UI**	2	21	5.4	14	136	L60M2.5*8	T-8
SMT26-20P11U-3-WH	11UI**	3	26		20	175		

螺纹铣刀盘 Threading milling toolholders

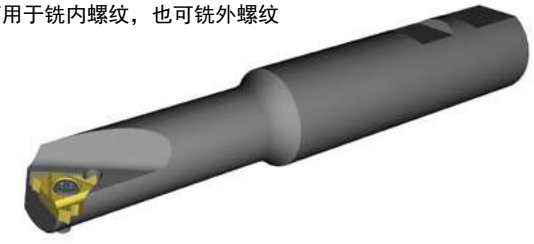




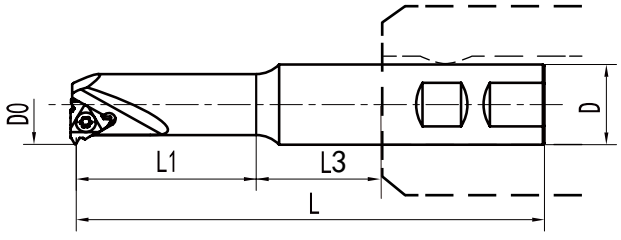
刀盘型号 Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L1	D	D1	L		
SMT48-22C16U-4	16UI**	4	48	8	22	40	50	L60M3.5*10	T-15
SMT50-22C16U-4		4	50	8	22	42	50		
SMT56-22C16U-6		6	56	8	22	48	50		
SMT63-22C16U-6		6	63	8	22	50	50		
SMT68-22C16U-6		6	68	8	22	54	50		
SMT68-22C22U-5	22UI**	5	68	11	22	54	50	L60M4.5*14	T-20

单刃铣刀杆 Single insert toolholders

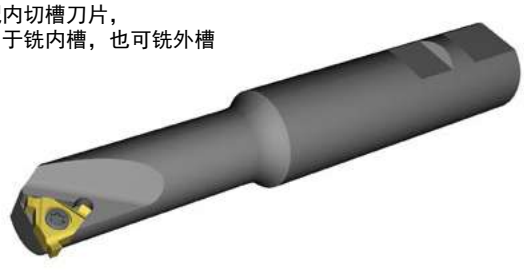
形式一、铣螺纹
装配内螺纹车刀片，
可用于铣内螺纹，也可铣外螺纹



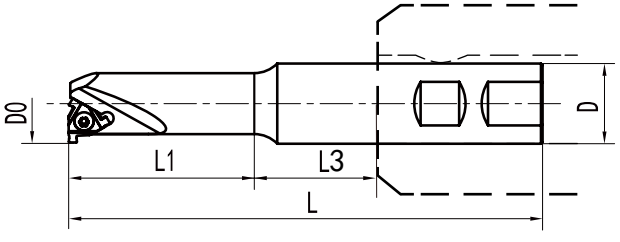
削平型刀具形式 （DIN1835-B） 见 P18



形式二、铣槽
装配内切槽刀片，
可用于铣内槽，也可铣外槽



削平型刀具形式 （DIN1835-B） 见 P18



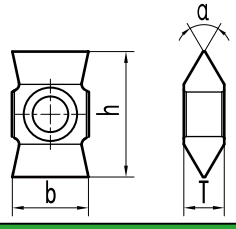
刀杆型号 Toolholder Type	刀片型号 Insert Type		尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
	铣螺纹	铣槽	Do	L1	L3	D	L		
SMT09-12F08	08NR**	-	8.2	12	24	12	80	L60M2.0*6	T-6
SMT12-12F11	11NR**	T11N**	12	25	11	12	80	L60M2.5*6	T-8
SMT18-20K16	16NR**	T16N**	18	35	41	20	125	L60M3.5*8	T-15
SMT25-25M16			25	65	31	25	150		
SMT35-32S22	22NR**	T22N**	35	110	82	32	250	L60M4.5*12	T-20

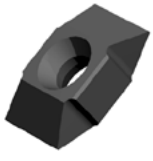
旋风铣螺纹刀片 Thread Milling Inserts

型号 Model	h (mm)	b (mm)	T (mm)
DV07**	7	5	3.18
DV09**	9.52	6.35	3.18
DV13**	13.5	8.5	3.98
DV15**	15.5	9.5	5
DV19**	19	12.5	6.4

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

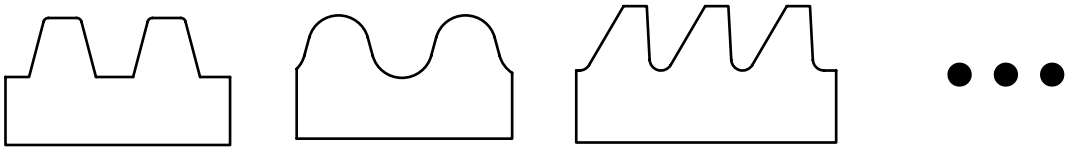
材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N		☺	



刀片 Insert	内螺纹刀片 Internal	螺距 pitch mm	螺距 pitch tpi	角度 α	BR215	DK110		配套 刀杆/刀盘 Insert Toolholder
	DV076001	1.0-3.0	24-8	60				SMT**V07-**
	DV096001	1.0-3.0	24-8	60				SMT**V09-**
	DV136001	1.5-4.0	16-6	60				SMT**V13-**
	DV156001	1.5-4.5	16-6	60	●			SMT**V15-**
	DV156002	3.5-6.0	7-4	60	●			
	DV196002	3.0-6.5	8-4	60	●			SMT**V19-**
	DV155501	2.0-5.0	7-4	55	○			SMT**V15-**
	DV195502	3.0-6.5	8-4	55	○			SMT**V19-**

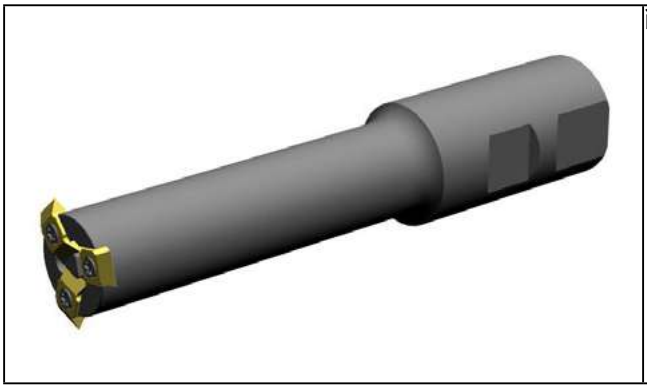
* 其他螺纹标准接受订制：标准牙距、梯形螺纹、圆螺纹等
* Other standard thread whirling tools can be customized
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

可以定制其他形式螺纹：
Other thread type can be customized:

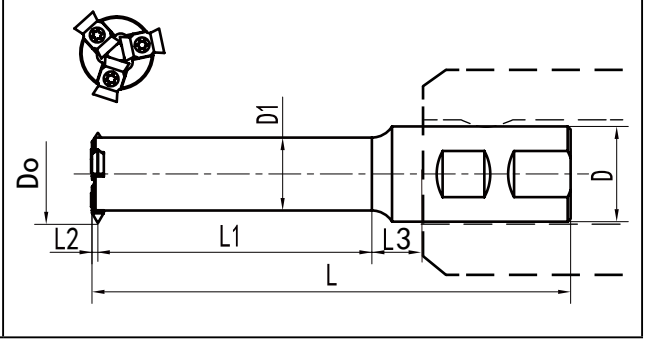


TR/ACME 螺纹　　RD 圆螺纹　　锯齿螺纹 buttress thread　　●●●

旋风螺纹铣刀杆 Threading milling toolholders



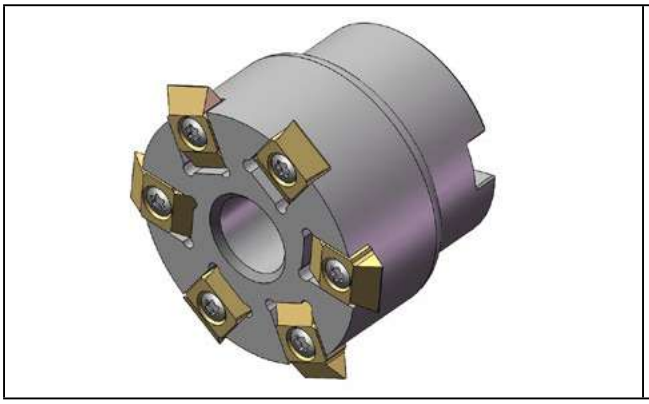
削平型刀具形式 （DIN1835-B） 见 P18

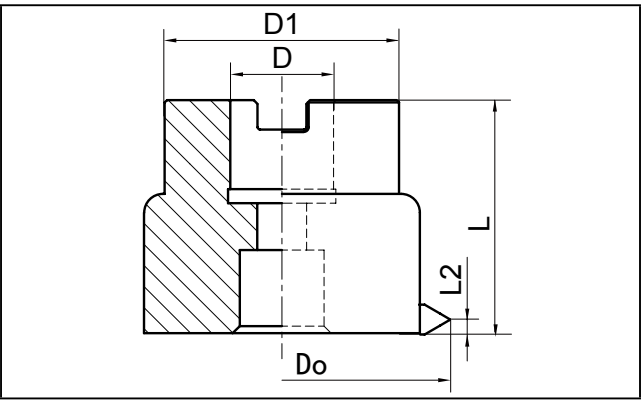


刀杆型号 New Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	52.55 尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L1	L2	L3	D	D1	L		
SMT17-20GV07-2	DV07**	2	17	37	1.4	4.6	16	12	90	L60M2.5*8	T-7
SMT21-25HV07-3		3	20.5	45	1.4	4.6	20	15.9	100		
SMT24-25LV09-3	DV09**		23.85	75	1.4	9.6	25	19	140		
SMT33-32NV13-3	DV13**		32.85	90	2.2	7.8	32	24.5	158	L60M3.5*12	T-9
SMT40-32LV15-4	DV15**	4	40	70	2.6	4.4	32	30.5	135	L60M4*14	T-15
SMT40-32QV15-4			40	110	2.6	9.4	32	31	180		
SMT40-32RV15-4			40	145	2.6	4.4	32	31	210		
SMT48-40TV15-6		6	47.55	205	2.6	4.4	40	38	280		
SMT53-40RV19-4	DV19**	4	52.55	130	3.3	-	40	40	200	L60M5*14	T-20

* 可以订制内通水型刀杆，订货型号加“C” 例如“SMT40-32QV15-4C”

旋风螺纹铣刀盘 Threading milling toolholders

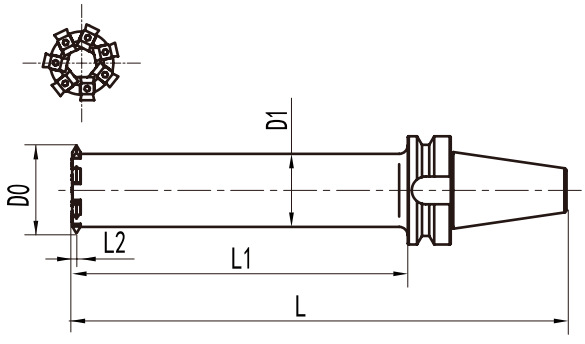




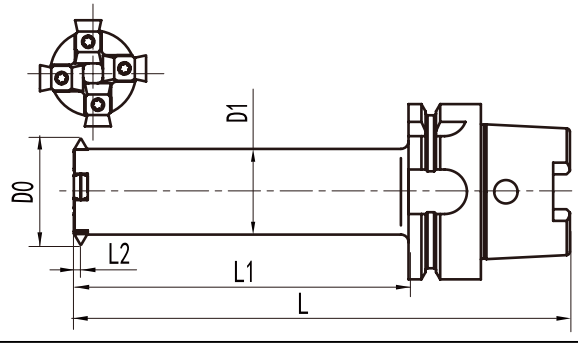
刀杆型号 New Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L2	D	D1	L		
SMT57-22CV15-6	DV15**	6	57	2.5	22	48	50	L60M4*13	T-15
SMT57-22CV15-8	DV15**	8	57	2.5	22	48	50	L60M4*13	T-15
SMT72-22CV19-6	DV19**	6	71.5	3.2	22	50	50	L60M5*15	T-20
SMT95-27CV19-8	DV19**	8	95	3.2	27	68	50	L60M5*15	T-20

旋风螺纹铣刀杆 Threading milling toolholders

BT 刀柄



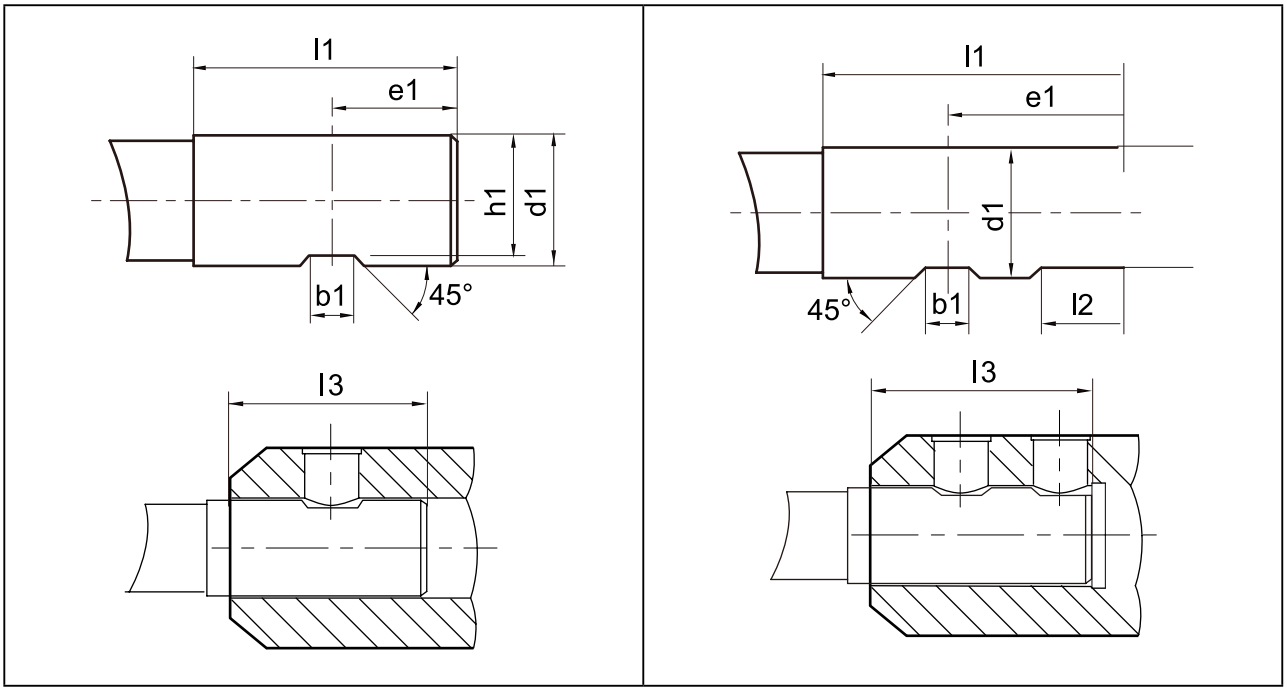
HSK 刀柄



刀杆型号 Toolholder Type	刀片型号 Insert Type	刃数 No. of insert	尺寸 Dimensions (mm)					锥柄标准	刀片螺钉 Insert Screw	扳手 Torx Key
			Do	L1	L2	D1	L			
HSK63A-MT40QV15-4	DV15**	4	52.55	120	2.5	30.8	178	HSK63A	L60M4*14	T-15
BT40-MT53TV15-7		7	52.55	195	2.5	42.5	290	BT40		
BT50-MT63VV15-9		9	63	250	2.5	53	390	BT50		
BT40-MT58TV19-5	DV19**	5	57.5	200	3.2	45.5	295	BT40	L60M5*14	T-20
BT50-MT67VV19-7		7	66.55	250	3.2	54.4	390	BT50		
BT50-MT72WV19-8		8	71.5	300	3.2	59.5	450	BT50		

其他锥柄标准的旋风铣刀接受预订

削平柄刀具形式 Flatted parallel shank（DIN1835-B）



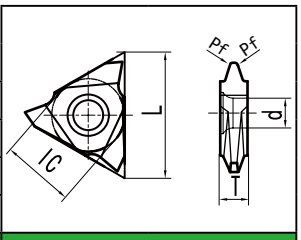
尺寸 Dimensions (mm)						
d1	l1 ($^{+2}_{0}$)	b1 ($^{+0.1}_{0}$)	l2 ($^{+1}_{0}$)	e1 ($^{0}_{-1}$)	h1	l3 (±1)
6	36	4.2	–	18.0	4.8	35
8	36	5.5	–	18.0	6.6	35
10	40	7.0	–	12.0	8.4	39
12	45	8.0	–	22.5	10.4	44
14	45	8.0	–	22.5	12.7	44
16	48	10.0	–	24.0	14.2	47
18	48	10.0	–	24.0	16.2	47
20	50	11.0	–	25.0	18.2	49
25	56	12.0	17	32.0	23.0	54
32	60	14.0	19	36.0	30.0	58
40	70	14.0	19	40.0	38.0	68

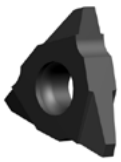
40° 蜗杆刀片 Worm milling inserts

型号 Model	L (mm)	IC (mm)	d (mm)
22**	22	12.7	5.1
27**	27	15.87	6.35
35**	35	20	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

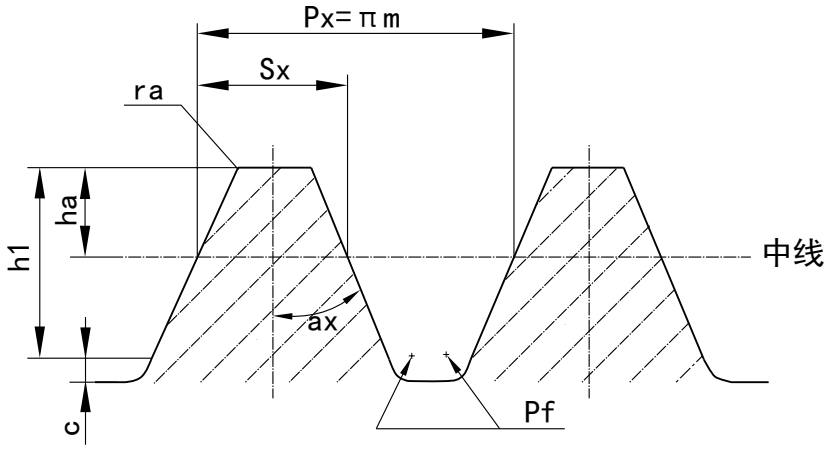
材质推荐 material recommended						
钢	P	☺	☺	☺		
不锈钢	M	☺	☺			
铸铁	K	😐	😐			
有色金属	N				☺	



刀片 Insert	型号 Model	模数 Module	齿距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) Pf	T
	22VER1.57-M0.5	0.5	1.57	●				○				0.15	4.9
	22VER1.88-M0.6	0.6	1.88	●				○				0.18	4.9
	22VER2.20-M0.7	0.7	2.20	●				○				0.21	4.9
	22VER2.36-M0.75	0.75	2.36	●				○				0.23	4.9
	22VER2.51-M0.8	0.8	2.51	●				○				0.24	4.9
	22VER2.83-M0.9	0.9	2.83	●				○				0.27	4.9
	22VER3.14-M1.0	1.0	3.14	●				○				0.3	4.9
	22VER3.93-M1.25	1.25	3.93	●				○				0.38	4.9
	22VER4.71-M1.5	1.5	4.71	●				○				0.45	4.9
	22VER5.03-M1.6	1.6	5.03	●				○				0.48	4.9
	22VER5.50-M1.75	1.75	5.50	●				○				0.53	4.9
	22VER6.28-M2.0	2.0	6.28	●				○				0.6	4.9
	27VER6.28-M2.0	2.0	6.28	●				○				0.6	6.4
	27VER7.07-M2.25	2.25	7.07	●				○				0.68	6.4
	27VER7.85-M2.5	2.5	7.85	●				○				0.75	6.4
	27VER8.64-M2.75	2.75	8.64	●								0.83	8.7
	27VER9.42-M3.0	3.0	9.42	●								0.9	8.7
	27VER9.90-M3.15	3.15	9.90	●								0.95	8.7
	27VER10.21-M3.25	3.25	10.21	●								0.98	8.7
	27VER11.00-M3.5	3.5	11.0	●								1.05	10.0
	35VER12.57-M4.0	4.0	12.57	●								1.2	10.7
	35VER14.14-M4.5	4.5	14.14	●								1.35	12.5
	35VER15.71-M5.0	5.0	15.71	●								1.5	12.5
	35VER17.28-M5.5	5.5	17.28									1.65	15.2
	35VER18.85-M6.0	6.0	18.85									1.8	15.2

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

40° 蜗杆基本齿廓和标记



1. 模数 m
2. 轴向齿距 Px, Px= π m
3. 齿顶高 ha，ha=m, 短齿 ha=0.8m
4. 齿顶间隙 c, c=0.2m, 允许减少到 0.15m，增大到 0.35m
5. 轴向齿厚 Sx, Sx=0.5Px=0.5 π m
6. 齿根圆角半径 Pf, Pf=0.3m, 允许减小到 0.2m，增大到 0.4m，也允许成单圆弧
7. 齿顶倒圆半径 ra，ra ≤ 0.2m
8. 压力角或产形角

阿基米德蜗杆（ZA 蜗杆）的轴向压力角 a=20° ；法向直廓蜗杆（ZN 蜗杆）的法向压力角 ax =20° ；渐开线蜗杆（ZI 蜗杆）的法向压力角 αn =20° ；锥面包络圆柱蜗杆（ZK 蜗杆）的锥形刀具产形角 a0=20° 。在动力传动中，允许增大压力角，推荐采用 25° ，在分度传动中，允许减小压力角，推荐采用 15° 或 12° 。

刀具型号表示方法 Representation method

H	MT	06	0430	D	11	-0.50	ISO	BR205
①	②	③	④	⑤	⑥	⑦	⑧	⑨

①－刀具类型 type of tools	②－加工方式 System	③－柄径 Shank Dia.	④－刃径 Cutting Dia.	⑤－沟槽数 No. of Flutes	⑥－刃长 Cutting length
H- 螺旋槽 H-Helical S- 直槽 S-Straight Flutes D- 单齿 D-One tooth D3- 三齿 D3-Three teeth	MT- 铣削加工 MT-Thread Milling	06 - 6mm 08 - 8mm 10 - 10mm 12 - 12mm 14 - 14mm 16 - 16mm 18 - 18mm	0330-0.33mm 0430-0.43mm 0315-0.315mm ...	C-3 D-4 E-5 F-6	09 - 9mm 11 - 11mm 13 - 13mm ...

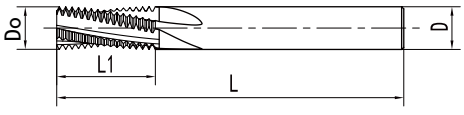
⑦－螺距 Pitch	⑧－螺纹标准 Pitch	⑨－材质代号 Arbide Grade
米制螺距（mm） 0.50 - 0.5mm 0.75 - 0.75mm 0.80 - 0.7mm ... 英制螺距（tpi） 11 - 11 tpi 14 - 14 tpi 18 - 18 tpi ...	ISO - 米制 ISO 螺纹 UN - 美制 UN 螺纹 W - 英制惠氏螺纹 NPT - 美制锥管螺纹 BSPT - 英制椎管螺纹 TR -30° 梯形螺纹 ...	BR205 - 适合不锈钢和钢 BR205 -apply to stainless steel and steel DK110 - 适合铝合金等有色金属 DK110 -apply to aluminium alloy and non-ferrous

ISO-60° 整体合金螺纹铣刀 Solid carbide thread milling cutter

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



螺距 pitch	最小加工规格		型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm)				
mm	粗牙	细牙				Do	D	L1	L	沟槽 Flutes
0.50		M4x0.5	HMT060330D09-0.50ISO	●	○	3.3	6	9	50	4
0.50		M5x0.5	HMT060430D11-0.50ISO	●	○	4.3	6	11	50	4
0.70	M4x0.7		HMT060315D09-0.70ISO	●	○	3.15	6	9	50	4
0.75		M6x0.75	HMT060500D13-0.75ISO	●	○	5.0	6	13	50	4
0.80	M5x0.8		HMT060400D11-0.80ISO	●	○	4.0	6	11	50	4
1.00	M6x1		HMT060480D13-1.00ISO	●	○	4.8	6	13	50	4
1.00		M8x1	HMT080670D17-1.00ISO	●	○	6.7	8	17	60	4
1.00		M10x1	HMT100870D21-1.00ISO	●	○	8.7	10	21	75	4
1.00		M12x1	HMT121070D25-1.00ISO	●	○	10.7	12	25	75	4
1.25	M8x1.25		HMT080650D17-1.25ISO	●	○	6.5	8	17	60	4
1.25		M10x1.25	HMT100850D21-1.25ISO	●	○	8.5	10	21	75	4
1.25		M12x1.25	HMT101000D25-1.25ISO	●	○	10.0	10	25	75	4
1.50	M10x1.5		HMT100820D21-1.50ISO	●	○	8.2	10	21	75	4
1.50		M12x1.5	HMT101000D25-1.50ISO	●	○	10.0	10	25	75	4
1.50		M14x1.5	HMT121200D29-1.50ISO	●	○	12.0	12	29	75	4
1.50		M16x1.5	HMT141400D33-1.50ISO	●	○	14.0	14	33	84	4
1.50		M18x1.5	HMT161600F37-1.50ISO	●	○	16.0	16	37	100	6
1.50		M20x1.5	HMT181800F41-1.50ISO	●	○	18.0	18	41	100	6
1.75	M12x1.75		HMT101000D25-1.75ISO	●	○	10.0	10	25	75	4
2.00	M14x2.0		HMT121160D29-2.00ISO	●	○	11.6	12	29	75	4
2.00	M16x2.0		HMT141360D33-2.00ISO	●	○	13.6	14	33	84	4
2.50	M18x2.5		HMT161500F37-2.50ISO	○	○	15.0	16	37	100	6
2.50	M20x2.5		HMT181710F41-2.50ISO	○	○	17.1	18	41	105	6

“L”和“L1”可以根据需求定制 “L”&“L1” can be customized according to the actual demand

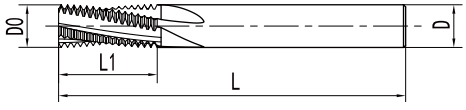
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

UN-60° 整体合金螺纹铣刀 Solid carbide thread milling cutter

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



螺距 pitch	最小加工规格		型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm)				
tpi	粗牙	细牙				Do	D	L1	L	沟槽 Flutes
32		NO. 10-32	HMT040380D10-32UN	○	○	3.8	4	10	50	4
32		NO. 10-32	HMT060380D10-32UN	○	○	3.8	6	10	50	4
32		NO. 12-32	HMT060440D11-32UN	○	○	4.4	6	11	50	4
28		NO. 12-28	HMT060430D11-28UN	○	○	4.3	6	11	50	4
28		1/4"-28	HMT060520D13-28UN	○	○	5.2	6	13	50	4
28		7/16, 1/2"-28	HMT100990D22-28UN	○	○	9.9	10	22	75	4
24	NO. 10-24		HMT040350D10-24UN	○	○	3.5	4	10	50	4
24	NO. 10-24		HMT060350D10-24UN	○	○	3.5	6	10	50	4
24	NO. 10-24		HMT060420D11-24UN	○	○	4.2	6	11	50	4
24		5/16"-24	HMT080670D16-24UN	○	○	6.7	8	16	60	4
24		3/8"-24	HMT100820D19-24UN	○	○	8.2	10	19	75	4
24		9/16", 11/16"-24	HMT141290D29-24UN	○	○	12.9	14	29	75	4
20	1/4"-20		HMT060480D13-20UN	○	○	4.8	6	13	60	4
20	1/4"-20		HMT060480E13-20UN	○	○	4.8	6	13	60	5
20		7/16"-20	HMT100960D23-20UN	○	○	9.6	10	23	75	4
20		1/2"-20	HMT121110D26-20UN	○	○	11.1	12	26	75	4
20		3/4", 1"-20	HMT181710D38-20UN	○	○	17.1	18	38	100	4
18	5/16"-18		HMT080635D16-18UN	○	○	6.35	8	16	60	4
18		9/16"-18	HMT141250D28-18UN	○	○	12.5	14	28	75	4
18		5/8", 11/16"-18	HMT161410D31-18UN	○	○	14.1	16	31	90	4
16	3/16"-16		HMT080760D19-16UN	○	○	7.6	8	19	60	4
16		3/4"-16	HMT181700D38-16UN	○	○	17.0	18	38	100	4
14	7/16"-14		HMT100900D22-14UN	○	○	9.0	10	22	75	4
14		7/8"-14	HMT202000D45-14UN	○	○	20.0	20	45	105	4
14		7/8"-14	HMT202000F45-14UN	○	○	20.0	20	45	105	6
13	1/2"-13		HMT121040D26-13UN	○	○	10.4	12	26	75	4
12	9/16"-12		HMT121180D29-12UN	○	○	11.8	12	29	75	4
12		1", 1-1/2"-12	HMT202000D51-12UN	○	○	20.0	20	51	108	4
12		1", 1-1/2"-12	HMT202000F51-12UN	○	○	20.0	20	51	108	6
12		1", 1-1/2"-12	HMT202000G51-12UN	○	○	20.0	20	51	108	8
11	5/8"-11		HMT141310D33-11UN	○	○	13.1	14	33	90	4
10	3/4"-10		HMT161600D39-10UN	○	○	16.0	16	39	100	4
9	7/8"-9		HMT201900D46-9UN	○	○	19.0	20	46	105	4
9	7/8"-9		HMT201900F46-9UN	○	○	19.0	20	46	105	6
9	7/8"-9		HMT201900G46-9UN	○	○	19.0	20	46	105	8
8	1"-8		HMT202000D52-8UN	○	○	20.0	20	52	108	4
8	1"-8		HMT202000F52-8UN	○	○	20.0	20	52	108	6
8	1"-8		HMT202000G52-8UN	○	○	20.0	20	52	108	8

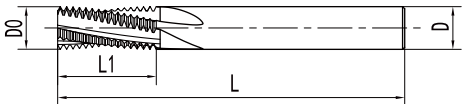
"L" 和 "L1" 可以根据需求定制 "L" & "L1" can be customized according to the actual demand

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

NPT-60° 整体合金螺纹铣刀 Solid carbide thread milling cutter

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



螺距 pitch tpi	最小加工规格	型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm) Do	D	L1	L	沟槽 Flutes
27	1/16"-27	HMT060590D10-27NPT	○	○	5.9	6	10	50	4
27	1/8"-27	HMT080760D10-27NPT	○	○	7.6	8	10	60	4
18	1/4"-18	HMT100990D15-18NPT	○	○	9.9	10	15	75	4
18	3/8"-18	HMT121110D15-18NPT	○	○	11.1	12	15	75	4
14	1/2、3/4"-14	HMT161550F19-14NPT	○	○	15.5	16	19	90	6
11.5	1"、1 1/4"-11.5	HMT201960F23-11.5NPT	○	○	19.6	20	23	100	6
8	2 1/2"、3"-8	HMT201960F33-8NPT	○	○	19.6	20	33	100	6

“L”和“L1”可以根据需求定制 “L”&“L1” can be customized according to the actual demand

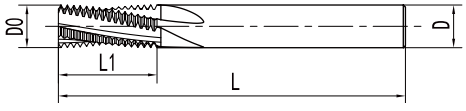
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

W-55° 整体合金螺纹铣刀 Solid carbide thread milling cutter

☺ 优先推荐 Good recommendation

☹ 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	☹		
有色金属	N		☺	



螺距 pitch	最小加工规格		型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm)				
tpi	粗牙	细牙				Do	D	L1	L	沟槽 Flutes
26		1/4"-26	HMT060500D13-26W	○	○	5.0	6	13	50	4
22		5/16"-22	HMT080630D16-22W	○	○	6.3	8	16	60	4
20	1/4"-20		HMT060440D13-20W	○	○	4.4	6	13	50	4
20		3/8"-20	HMT080760D19-20W	○	○	7.6	8	19	60	4
19	G1/4"-19		HMT121100F28-19W	○	○	11.0	12	28	75	6
19	G3/8"-19		HMT161450F34-19W	○	○	14.5	16	34	90	6
18	5/16"-18		HMT060580D16-18W	○	○	5.8	6	16	50	4
18		7/16"-18	HMT100920D23-18W	○	○	9.2	10	23	75	4
18		7/16"-18	HMT100920F23-18W	○	○	9.2	10	23	75	6
16	3/8"-16		HMT080720D19-16W	○	○	7.2	8	19	60	4
16		1/2"-16	HMT121050D26-16W	○	○	10.5	12	26	75	4
16		1/2"-16	HMT121050F26-16W	○	○	10.5	12	26	75	6
16		9/16"-16	HMT141220D29-16W	○	○	12.2	14	29	80	4
16		9/16"-16	HMT141220F29-16W	○	○	12.2	14	29	80	6
14	7/16"-14		HMT100850D22-14W	○	○	8.5	10	22	75	4
14		5/8"-14	HMT141340D31-14W	○	○	13.4	14	31	100	4
14		5/8"-14	HMT141340F31-14W	○	○	13.4	14	31	100	6
14		11/16"-14	HMT161500D35-14W	○	○	15.0	16	35	100	4
14		11/16"-14	HMT161500F35-14W	○	○	15.0	16	35	100	6
12	1/2"-12		HMT100960D26-12W	○	○	9.6	10	26	75	4
12	1/2"-12		HMT100960F26-12W	○	○	9.6	10	26	75	6
12	9/16"-12		HMT121130D28-12W	○	○	11.3	12	28	75	4
12	9/16"-12		HMT121130F28-12W	○	○	11.3	12	28	75	6
12		3/4"-12	HMT181620D39-12W	○	○	16.2	18	39	100	4
12		3/4"-12	HMT181620F39-12W	○	○	16.2	18	39	100	6
11	5/8"-11	7/8"-11	HMT141260D33-11W	○	○	12.6	14	33	90	4
11	5/8"-11	7/8"-11	HMT141260F33-11W	○	○	12.6	14	33	90	6
11	11/16"-11		HMT161420D35-11W	○	○	14.2	16	35	100	4
11	11/16"-11		HMT161420F35-11W	○	○	14.2	16	35	100	6

“L”和“L1”可以根据需求定制 “L”&“L1”can be customized according to the actual demand

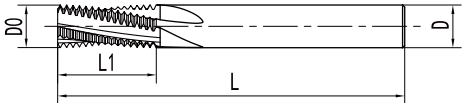
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

BSPT-55° 整体合金螺纹铣刀 Solid carbide thread milling cutter

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺

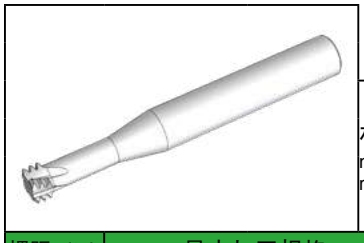


螺距 pitch tpi	最小加工规格	型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm) Do	D	L1	L	沟槽 Flutes
28	1/16"-28	HMT060580D16-28BSPT	○	○	5.8	6	16	50	4
28	1/8"-28	HMT080770D20-28BSPT	○	○	7.7	8	20	60	4
19	1/4"-19	HMT100990E27-19BSPT	○	○	9.9	10	26.7	75	5
19	3/8"-19	HMT141340E33-19BSPT	○	○	13.4	14	33.4	90	5
14	1/2、3/4"-14	HMT161570F44-14BSPT	○	○	15.7	16	43.5	100	6
11.5	1"、1 1/2"、2"-11	HMT201990F42-11BSPT	○	○	19.9	20	41.6	100	6

“L”和“L1”可以根据需求定制 “L” & “L1” can be customized according to the actual demand

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

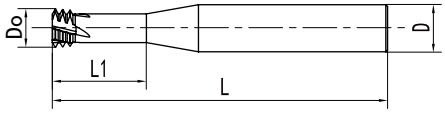
D3MT-ISO 三刃型整体合金螺纹铣刀 Solid carbide thread milling cutter



☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
	钢	P	☺	
	不锈钢	M	☺	
	铸铁	K	😐	
	有色金属	N		☺

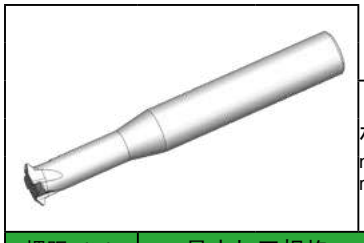


螺距 pitch	最小加工规格		型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm)				
mm	粗牙	细牙				Do	D	L1	L	沟槽 Flutes
0.5	M3x0.5		D3MT060240D07-0.5ISO	○	○	2.4	6	7	50	4
0.6	M3.5x0.6		D3MT060270D08-0.6ISO	○	○	2.7	6	8	50	4
0.7	M4x0.7		D3MT060315D09-0.7ISO	○	○	3.15	6	9	50	4
0.75		M6x0.75	D3MT060500D13-0.75ISO	○	○	5.0	6	13	50	4
0.8	M5x0.8		D3MT060400D11-0.8ISO	○	○	4.0	6	11	50	4
1.0	M6x1.0		D3MT060480D13-1.0ISO	○	○	4.8	6	13	50	4
1.0		M8x1.0	D3MT080670D17-1.0ISO	○	○	6.7	8	17	60	4
1.0		M10x1.0	D3MT100870D21-1.0ISO	○	○	8.7	10	21	75	4
1.0		M12x1.0	D3MT121070D25-1.0ISO	○	○	10.7	12	25	80	4
1.25	M8x1.25		D3MT080650D17-1.25ISO	○	○	6.5	8	17	60	4
1.25		M10x1.25	D3MT100850D21-1.25ISO	○	○	8.5	10	21	75	4
1.5	M10x1.5		D3MT100820D21-1.5ISO	○	○	8.2	10	21	75	4
1.5		M12x1.5	D3MT101000D25-1.5ISO	○	○	10.0	10	25	75	4
1.5		M14x1.5	D3MT121200D29-1.5ISO	○	○	12.0	12	29	75	4
1.5		M14x1.5	D3MT121200F29-1.5ISO	○	○	12.0	12	29	75	6
1.5		M16x1.5	D3MT141400D33-1.5ISO	○	○	14.0	14	33	80	4
1.5		M16x1.5	D3MT141400F33-1.5ISO	○	○	14.0	14	33	80	6
1.75	M12x1.75		D3MT101000D25-1.75ISO	○	○	10.0	10	25	75	4
1.75	M12x1.75		D3MT101000F25-1.75ISO	○	○	10.0	10	25	75	6
2.0	M14x2		D3MT121160D29-2.0ISO	○	○	11.6	12	29	75	4
2.0	M14x2		D3MT121160F29-2.0ISO	○	○	11.6	12	29	75	6
2.0	M16x2		D3MT141360D33-2.0ISO	○	○	13.6	14	33	80	4
2.0	M16x2		D3MT141360F33-2.0ISO	○	○	13.6	14	33	80	6
2.5	M20x2.5		D3MT181710D41-2.5ISO	○	○	17.1	18	41	105	4
2.5	M20x2.5		D3MT181710F41-2.5ISO	○	○	17.1	18	41	105	6

“L”和“L1”可以根据需求定制 “L”&“L1”can be customized according to the actual demand

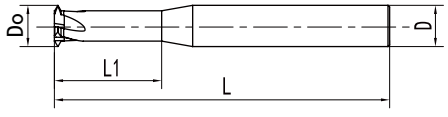
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

D1MT-60° 通用型整体合金螺纹铣刀 Solid carbide thread milling cutter



☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



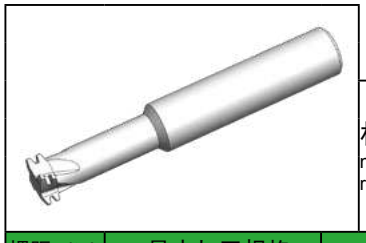
螺距 pitch	最小加工规格		型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm)				
mm	粗牙	细牙				Do	D	L1	L	沟槽 Flutes
0.5-1.0	M4x0.7		D1MT060310C13-60	○	○	3.1	6	13	50	3
0.5-1.0	M6x1		D1MT060480C14-60	●	○	4.8	6	14	50	3
0.75-1.5	M8x1.25		D1MT060600C16-60	●	○	6.0	6	16	50	3
1.0-1.75	M10x1.5		D1MT080800D18-60	●	○	8.0	8	18	60	4
1.25-2.0	M12x1.75		D1MT101000D26-60	○	○	10.0	10	26	75	4
1.5-2.5	M16x2		D1MT121200D30-60	○	○	12.0	12	30	75	4

“L”和“L1”可以根据需求定制 “L”&“L1”can be customized according to the actual demand

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

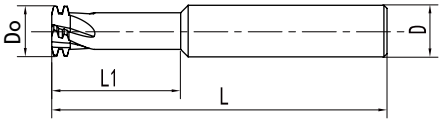
注：55° 牙型角的螺纹铣刀可以接受定制，尺寸和型号参考以上型号

D2MT-TR30° 整体合金螺纹铣刀 Solid carbide thread milling cutter



☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended				
	钢	P	☺	
	不锈钢	M	☺	
	铸铁	K	😐	
	有色金属	N		☺



螺距 pitch mm	最小加工规格 粗牙	型号 Ordering Code	BR205	DK110	尺寸 Dimensions (mm) Do	D	L1	L	沟槽 Flutes
1.5	TR8x1.5	D2MT060550D17-1.5TR	○	○	5.5	6	17	60	4
1.5	TR9x1.5	D2MT080700D19-1.5TR	○	○	7.0	8	19	60	4
2.0	TR10x2.0	D2MT080760D21-2.0TR	○	○	7.6	8	21	60	4
2.0	TR12x2.0	D2MT100960D25-2.0TR	○	○	9.6	10	25	75	4
2.0	TR14x2.0	D2MT121160F29-2.0TR	○	○	11.6	12	29	75	4
3.0	TR12x3.0	D2MT100860D25-3.0TR	○	○	8.6	10	25	75	4
3.0	TR14x3.0	D2MT101000F29-3.0TR	○	○	10.0	10	29	75	4
3.0	TR22x3.0	D2MT181800F45-3.0TR	○	○	18.0	18	45	105	4
4.0	TR16x4.0	D2MT121160F33-4.0TR	○	○	11.6	12	33	75	4
4.0	TR18x4.0	D2MT141360F37-4.0TR	○	○	13.6	14	37	90	4
4.0	TR20x4.0	D2MT161560F41-4.0TR	○	○	15.6	16	41	100	4

“L”和“L1”可以根据需求定制 “L”&“L1” can be customized according to the actual demand

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

应用资料 Application data

关于螺纹铣削

为了实现螺纹的铣削，机床必须具备三轴联动的功能。而螺旋插补是 CNC 机床的功能，由机床控制刀具实现螺旋轨迹，螺旋插补由平面圆弧插补和垂直于该平面的线性运动联动形成。例如：从 A 点到 B 点（图 1）的螺旋轨迹是由 X-Y 的平面圆弧插补运动和 Z 轴的线性直线运动联动而成。

对于大多数 CNC 系统，可以通过如下两种不同的指令实现该功能。

G02：顺时针圆弧插补指令

G03：逆时针圆弧插补指令

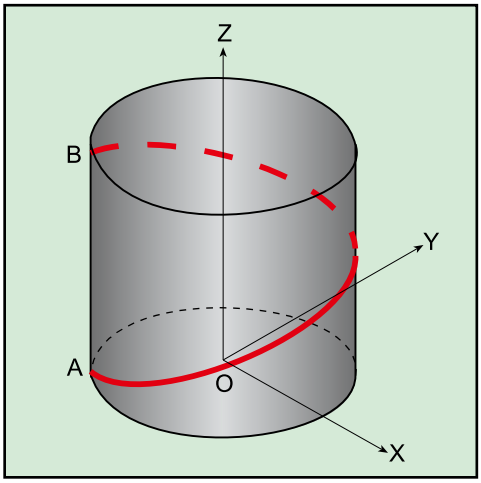


图1

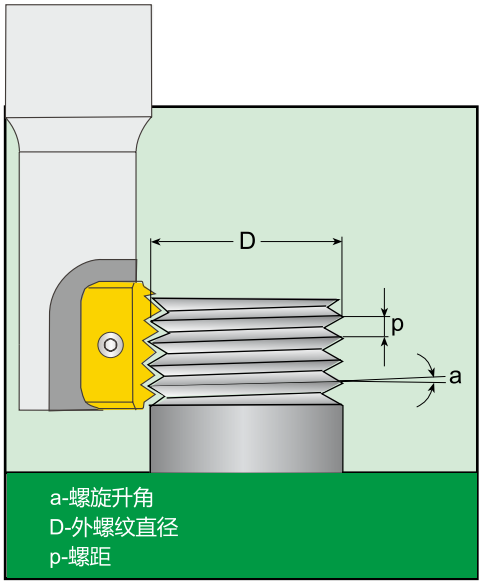


图2

螺纹铣削运动（图 2）显示是由刀具的自身旋转和机床的螺旋插补运动形成。在一个圆周的插补过程中，利用道具的几何形式，并结合刀具沿 Z 轴方向移动一个螺距的运动，加工出所需要的螺纹。螺纹铣削可以采用以下三种切入方法。

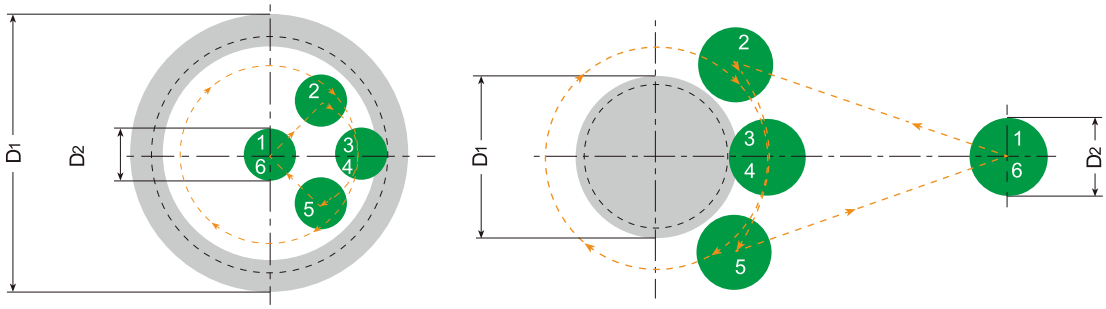
①圆弧切入法

②径向切入法

③切向切入法

①圆弧切入法

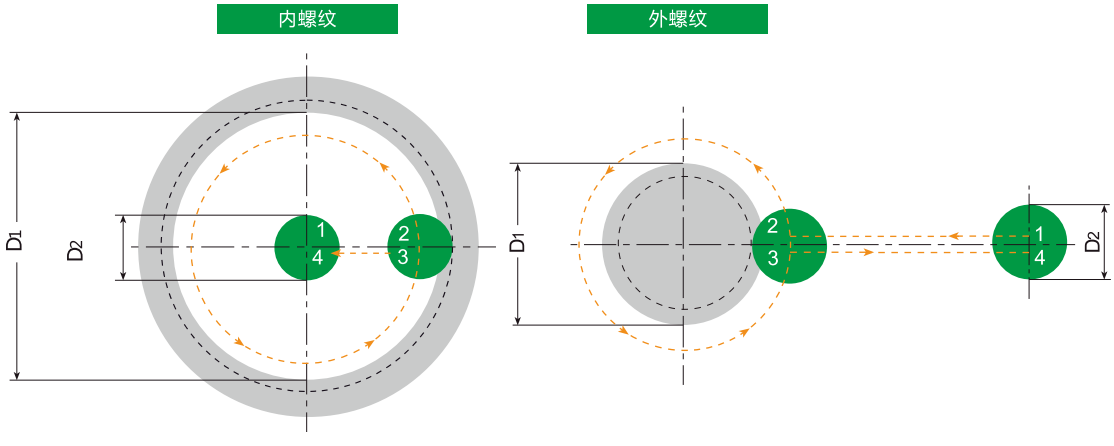
采用该方法刀具切入，切除平稳，不留切削痕迹，不产生振动，即使是加工硬材料时也是如此。该方法的程序编制比径向切入法复杂一些，建议在加工精密螺纹时推荐使用该方法。



1-2：快速定位
2-3：刀具沿圆弧进给切向切入，同时沿 Z 轴插补进给
3-4：360° 整圆做螺纹插补运动，轴向移动一个导程
4-5：刀具沿圆弧进给切向切入，同时沿 Z 轴做插补运动
5-6：快速退回

②径向切入法

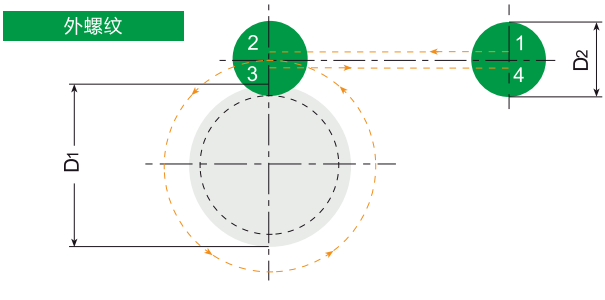
采用该方法最简单，但有时会出现以下两种状况
一、在切入和切出点会留下很小的垂直痕迹，但不会影响螺纹的质量
二、在加工非常硬的材料时，当切入接近全牙型时，由于刀具与工件接触面积增大，有可能产生振刀现象。为了避免当切入接近全牙型时的振动，进给量应尽量降低到螺旋插补补给的 1/3



1-2：快速定位
2-3：360° 整圆做螺旋插补运动，轴向移动一个导程
3-4：径向退回

③切向切入法

采用该方法非常简单，并具有圆弧切入法的优点，不过它仅适用于外螺纹的铣削加工



1-2：快速定位
2-3：360° 整圆做螺纹插补运动，轴向移动一个导程
3-4：快速退回

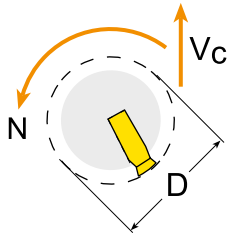
螺纹铣削数据计算

①计算刀具的进给速度和进给量

$$n = \frac{1000 \times V_c}{\pi \times D}$$

$$V_f = fz \times n \times Z$$

Vc= 切削线速度（m/min）
n= 刀具转速（R.P.M）
D= 刀具切削直径（mm）
Vf= 刀具切削刃进给速度（mm）
Z= 刀具切削刃数量
fz= 每转每齿进给量（mm/r）



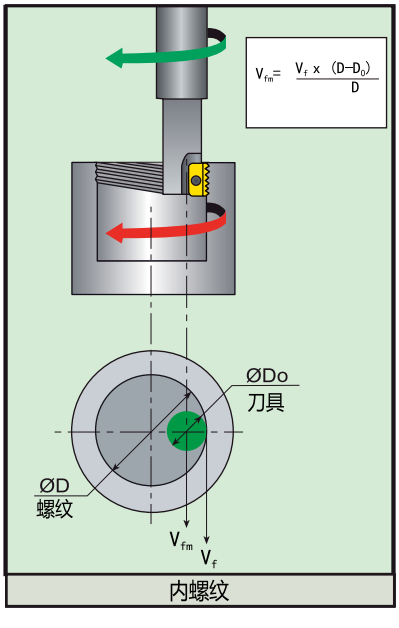
螺纹铣削数据计算实例
1、主轴转速（n）计算
应用公式　n=(1000*Vc)/(π*D)
Vc：线速度（m/min）　　π：圆周率 3.14159　　D：刀具直径（mm）　　n：转速（rpm）
示例：使用直径 25mm 的螺纹铣刀，推荐线速度为 100m/min

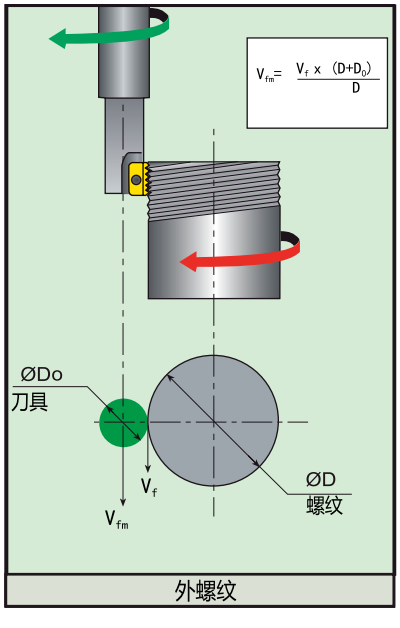
n=1000*100/π*25=1280rpm

2、刀具切削进给速度 Vf 计算
应用公式　Vf=fz*n*Z
Vf：进给量（mm/min）　　n：转速（rpm）　　Z：刃数　　fz：每刃进给
示例：单刃螺纹梳刀以转速 1500rpm 切削工件，求刀具切削进给速度（Vf 值）为多少？　f 推荐值 0.05mm

Vf=0.05*1500*1=75mm/min

②计算刀具中心进给量





大多数 CNC 机床，在编程时要求采用刀具中心进给编程。刀具的进给速度是由刀具中心进给速度的大小决定的，而刀具中心的进给速度没有直接给出，但可由刀具进给速度与刀具中心进给速度的关系方程式计算得出。

Vfm= 中心进给速度 mm/min
Vf= 进给量 mm/min
D= 螺纹公称直径 mm
DO= 螺纹铣刀直径 mm

应用资料 Application data

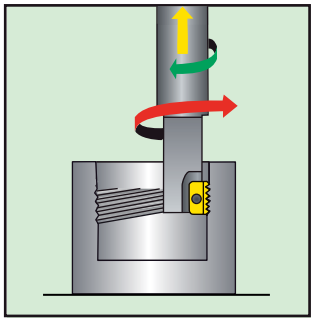
常见铣削方式

— 走刀路径　— 主轴旋转方向　— 走刀方向

加工内螺纹
Internal

右旋螺纹
Right Hand

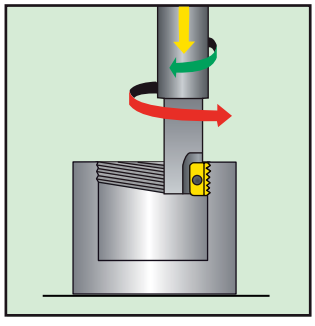
逆时针进给 顺铣
CCW.Feed and CW.Milling



加工内螺纹
Internal

左旋螺纹
Right Hand

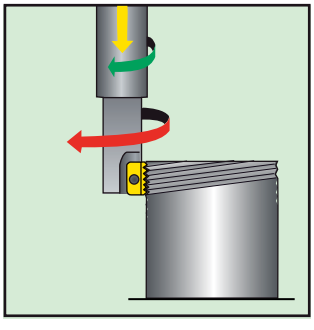
顺时针进给 顺铣
CW.Feed and CW.Milling



加工外螺纹
External

右旋螺纹
Right Hand

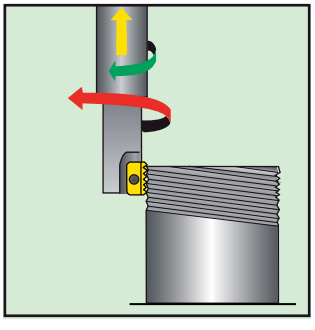
顺时针进给 顺铣
CW.Feed and CW.Milling



加工外螺纹
External

左旋螺纹
Right Hand

顺时针进给 顺铣
CCW.Feed and CW.Milling

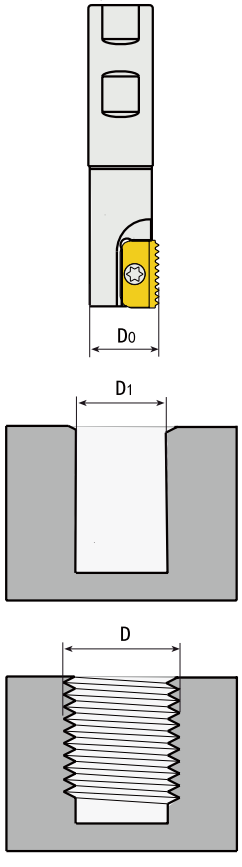


用于 CNC 程序的“G”代码（ISO）

代码	功能	代码	功能
%	识别代码（ISO 或者 EIA），+ 磁带结束	H	刀具长度补偿号
G00	快速识别指令	D	刀具半径补偿号
G01	直线插补指令	X	X 轴坐标
G02	顺时针圆弧 / 螺旋插补指令 CW	Y	Y 轴坐标
G03	逆时针圆弧 / 螺旋插补指令 CCW	Z	X 轴坐标
G40	刀具半径补偿撤销指令	R	圆弧插补半径
G41	左偏刀具半径补偿指令	I	圆弧起点相对圆心的 X 轴的增量尺寸
G42	右偏刀具半径补偿指令	J	圆弧起点相对圆心的 Y 轴的增量尺寸
G43	刀具长度补偿指令	M3	主轴正转
G49	刀具长度补偿侧销指令	M5	主轴停止
G57	工作坐标系统选择	M30	主程序结束 / 复位
G90	绝对坐标 - 相对工件坐标系的原点给出	O	程序号
G91	增量坐标 - 相对于刀具位置给出	N	程序段号
F	进给量 mm/min	(	注释开始
S	主轴转速 RPM	)	注释结束

示例①：螺纹梳刀的编程方法

螺纹尺寸 Thead dimension	M30X1.5-6H	
螺纹公称直径 D Nominal thread diameter D	30.000mm	
螺纹螺距 P Thead pitch P	1.500mm	
预钻孔直径 D1 Drilled hole diameter D1	28.500mm	
螺纹深度 b Thead length b	20.000mm	
材料 Material	SUS 304	
涂层 Coating	TIN	
订货代码 Article NO.	刀片 21N1.5ISO	刀杆 SR0025K21
刃数 Z NO. of teeth Z	1	
刀具直径 D0 Cutter diameter D0	25.000mm	
切削长度 l2 Cutting length l2	21.000mm	
刀具补偿半径 K 1) Cutter radius compensation K 1)	0.075mm	0.05*P
刀具编程补偿半径 2) Cutter radius to be programmed 2)	7.925mm	0.5*d1-k1
切削速度 Vc Cutting speed Vc	86.35m/min	
每齿进给量（刀具） fz Feed per tooth(miilling)	0.050mm	
转速 n Speed n	S=1100r/min	n=(Vc*1000)/(D0*π)
进给速度（轮廓）Vf Feed speed (contour) Vf	Vf=55mm/min	Vf=fz*Z*n
进给速度 （中心） Vfm Feed speed (centrepoint) Vfm	Vfm=2.75mm/min	Vfm=Vf*(D-D1)/D



参考编程：
Recommended program：

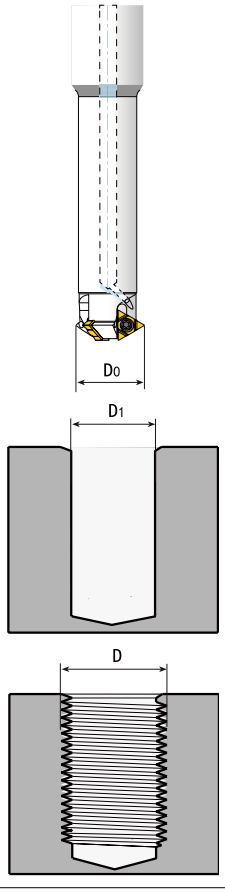
```
G00   G90    G55   X0.0   Y0.0   S1100  M03
G43   Z130   H01
M08
Z0.0
G01   Y2.5   F55
G02   X0.0   Y2.5  Z-1.5  I0.0   J-2.5
X0.0  Y2.5   Z-3.   I0.0   J-2.5
X0.0  Y2.5   Z-4.5  I0.0   J-2.5
X0.0  Y2.5   Z-6.   I0.0   J-2.5
X0.0  Y2.5   Z-7.5  I0.0   J-2.5
X0.0  Y2.5   Z-9    I0.0   J-2.5
X0.0  Y2.5   Z-10.5 I0.0   J-2.5
X0.0  Y2.5   Z-12.  I0.0   J-2.5
X0.0  Y2.5   Z-13.5 I0.0   J-2.5
X0.0  Y2.5   Z-15.  I0.0   J-2.5
X0.0  Y2.5   Z-55.  I0.0   J-2.5
X0.0  Y2.5   Z-16.5 I0.0   J-2.5
X0.0  Y2.5   Z-18.  I0.0   J-2.5
X0.0  Y2.5   Z-19.5 I0.0   J-2.5
X2.165 Y-1.25 Z-20. I0.0   J-2.5
G0.1  X0.0   Y0.0
G00   Z130
M05
M09
G91   G28    Z0.0
G28
M30
```

①沿着螺纹部分齿顶测量。刀具半径必须减去刀具半径补偿值，这对于取得 6H/ISO2 螺母公差的中间值的切深很有必要。请注意，不管怎样，这同样取决于刀具的径向偏差（材料抗拉强度，刀具的悬长）。
②一般来说，编程的刀具半径应写入机床储存器。
③如果你的控制系统不能自动计算中心进给，请用括号内的数值
④根据重复的次数来复制 N30 到 N90 的程序

① The cutter radius measured over the tooth crests of the threaded part must be reduced by the amount of the cutterradius compensation.this is necessary to achieve a depth ofcut to the middle of the 6H/ISO2 nut tolerance,please note.however,that this also depends on the radial deflection of the tool (tensile strength of the material,projection length of the tool).
② The cutter radius to be programmed is normally includedin the tool memory
③ If your control does not calculate the centre pointfeed automatically please use the feed values printed inbrackets.
④ The block numbers N 30 to N 90 must be called up anewaccording to the number of repetitions.

示例①：深孔螺纹铣刀的编程方法

螺纹尺寸 Thead dimension	M48-6H	
螺纹公称直径 D Nominal thread diameter D	48.000mm	
螺纹螺距 P Thead pitch P	5.000mm	
预钻孔直径 D1 Drilled hole diameter D1	43.000mm	
螺纹深度 b Thead length b	63.000mm	
材料 Material	2Cr13	
涂层 Coating	TIN	
订货代码 Article NO.	刀片 16UIDH60	刀杆 SMT36-32P16U-3C
刃数 Z NO. of teeth Z	3	
刀具直径 D0 Cutter diameter D0	36.500mm	
刀具补偿半径 K 1) Cutter radius compensation K 1)	0.174mm	根据应用程序 acc.werk case
刀具编程补偿半径 2) Cutter radius to be programmed 2)	16.251mm	0.5*d1-k1
切削速度 Vc Cutting speed Vc	91.7m/min	
每齿进给量（刀具） fz Feed per tooth(miilling)	0.050mm	
转速 n Speed n	S=800r/min	n=(Vc*1000)/(D0*π)
进给速度（轮廓）Vf Feed speed (contour) Vf	Vf=120mm/min	Vf=fz*Z*n
进给速度 （中心） Vfm Feed speed (centrepoint) Vfm	Vfm=12.5mm/min	Vfm=Vf*(D-D1)/D



参考编程：
Recommended program：

```
G00    G90     G55    X0.0   Y0.0   S800   M03
G43    Z130    H01
M08
Z0.0
G01    Y5.75   F120
G02    X0.0    Y5.75  Z-5.   I0.0   J-5.75
X0.0   Y5.75   Z-10.  I0.0   J5.75
X0.0   Y5.75   Z-15.  I0.0   J5.75
X0.0   Y5.75   Z-20.  I0.0   J5.75
X0.0   Y5.75   Z-25.  I0.0   J5.75
X0.0   Y5.75   Z-30.  I0.0   J5.75
X0.0   Y5.75   Z-35.  I0.0   J5.75
X0.0   Y5.75   Z-40.  I0.0   J5.75
X0.0   Y5.75   Z-45.  I0.0   J5.75
X0.0   Y5.75   Z-50.  I0.0   J5.75
X0.0   Y5.75   Z-55.  I0.0   J5.75
X0.0   Y5.75   Z-60.  I0.0   J5.75
X-3.38 Y-4.652 Z-63.  I0.0   J-5.75
G0.1   X0.0    Y0.0
G00    Z130
M05
M09
G91    G28     Z0.0
G28
M30
```

①编程的刀具半径必须根据工作条件纠正，直到获得要求的螺母公差，如 6H/ISO2。请注意，不管怎样，这同样取决于刀具的径向偏差（材料抗拉强度，刀具的悬长）
②一般来说，编程的刀具半径应写入机床储存器。
③螺纹深度 b 必须能被螺距 P 整除
④如果你的控制系统不能自动计算刀具中心进给，请用括号内的数值。
⑤必须重复 N40 直到所需螺纹深度

① The cutter radius to be programmed must be corrected,depending on the work case,until the thread achieves the required nut tolerance ,e.g. 6H/ISO2.please note,however,that this also depends on the radial deflection of the tool (tensile strength of the material,projecttionlength of the tool)
② The cutter radius to be programmed is normally included in the tool memory
③ The thread depth b as entered must be divisible by the pitch P.
④ If you control does not calculate the centre piont feed automatically please use the feed values printed in brackets.
⑤ The block numbers N 30 to N 90 must be called up anew according to the number of repetitions.

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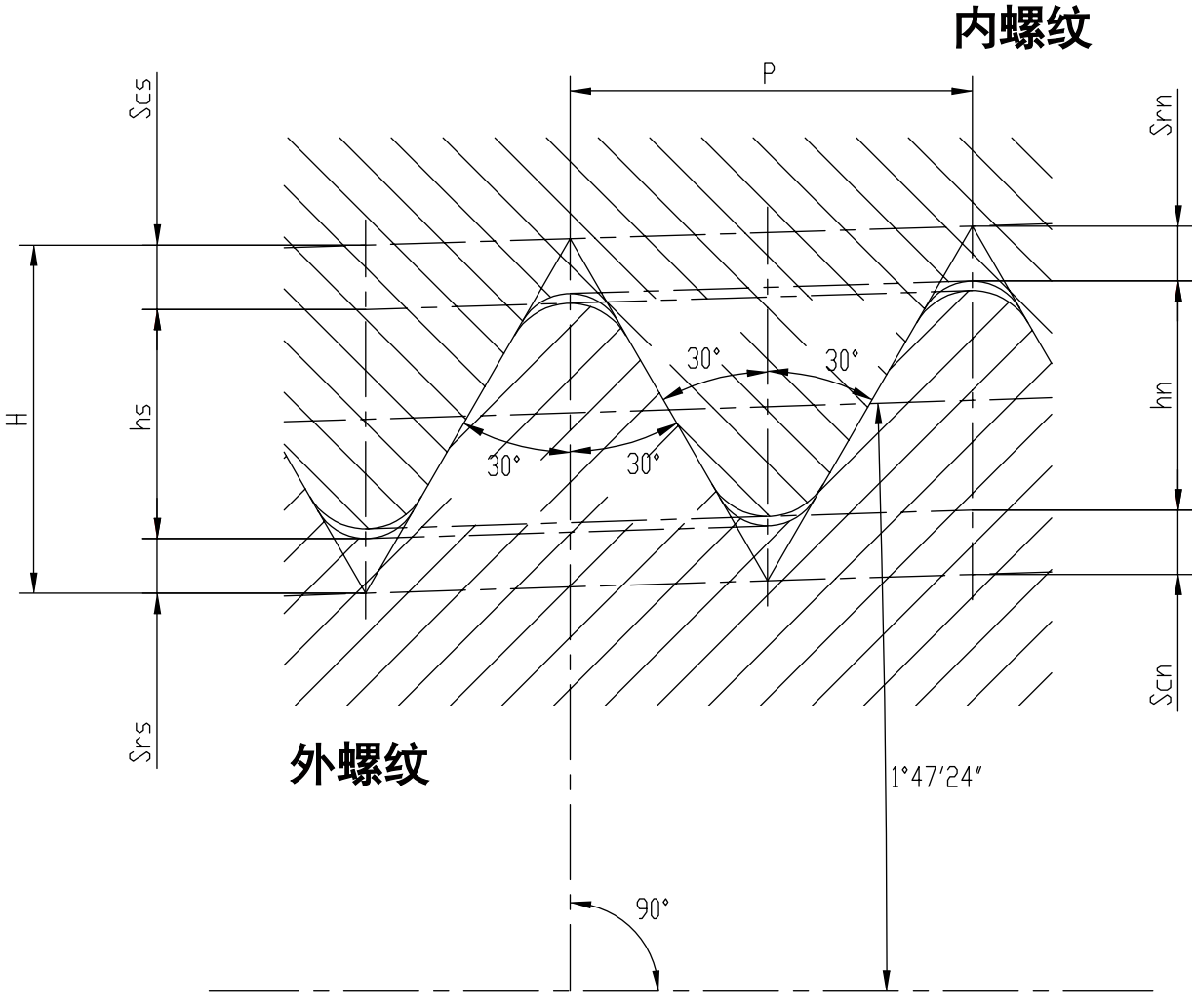
美制 API 油管圆螺纹设计牙型以及参数

Tooth profile and parameter of american api petroleum RD threading

API SPEC 5B

GB/T 9253



油管圆螺纹设计参数		
螺纹规格	1/8"	1/10"
螺距	3.175	2.54
原始三角形高度 H=0.866P	2.75	2.20
牙型高度 hs=hn=0.626P-0.178	1.81	1.412
牙顶削平高度 Scs=Scn=0.120P+0.051	0.508	0.432
牙顶削平高度 Srs=Srn=0.120P+0.127	0.432	0.356

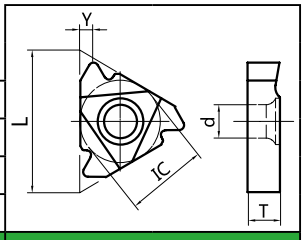
外螺纹刀片 External Threading Insert

API SPEC 5B
GB/T 9253

型号 Model	L (mm)	IC (mm)
16**	16	9.525

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DM215	DP220	尺寸 Dimensions (mm) d	T
	16ER10APIRD	API 圆螺纹	10	1:16	1.5	●	○	4.0	3.65
	16ER8APIRD	API 圆螺纹	8	1:16	1.6	●	○	4.0	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

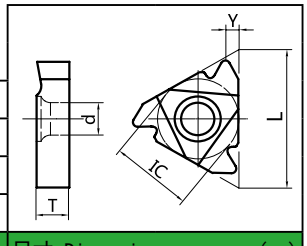
内螺纹刀片 Internal Threading Insert

API SPEC 5B
GB/T 9253

型号 Model	L (mm)	IC (mm)
16**	16	9.525

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DM215	DP220	尺寸 Dimensions (mm) d	T
	16NR10APIRD	API 圆螺纹	10	1:16	1.5	●	○	4.0	3.65
	16NR8APIRD	API 圆螺纹	8	1:16	1.6	●	○	4.0	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

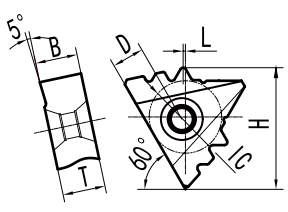
外螺纹刀片 External Threading Insert

API SPEC 5B
GB/T 9253

IC (mm)	D (mm)	B (mm)
10.17	4.5	5.92

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	旧型号 Old Type	螺距 pitch tpi	锥度 IPF	齿数	BR402	BR405	尺寸 Dimensions (mm) d	T
	22ER10APIRD-4	B10W2-4	10	1:16	4			4.0	6.0
	22ER8APIRD-3	B8W2-3	8	1:16	3	●	○	4.0	6.0

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

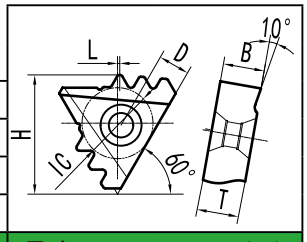
内螺纹刀片 Internal Threading Insert

API SPEC 5B
GB/T 9253

IC (mm)	D (mm)	B (mm)
10.17	4.5	5.92

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	旧型号 Old Type	螺距 pitch tpi	锥度 IPF	齿数	BR402	BR405	尺寸 Dimensions (mm) d	T
	22NR10APIRD-4	B10N2-4	10	1:16	4			4.0	6.0
	22NR8APIRD-3	B8N2-3	8	1:16	3	●	○	4.0	6.0

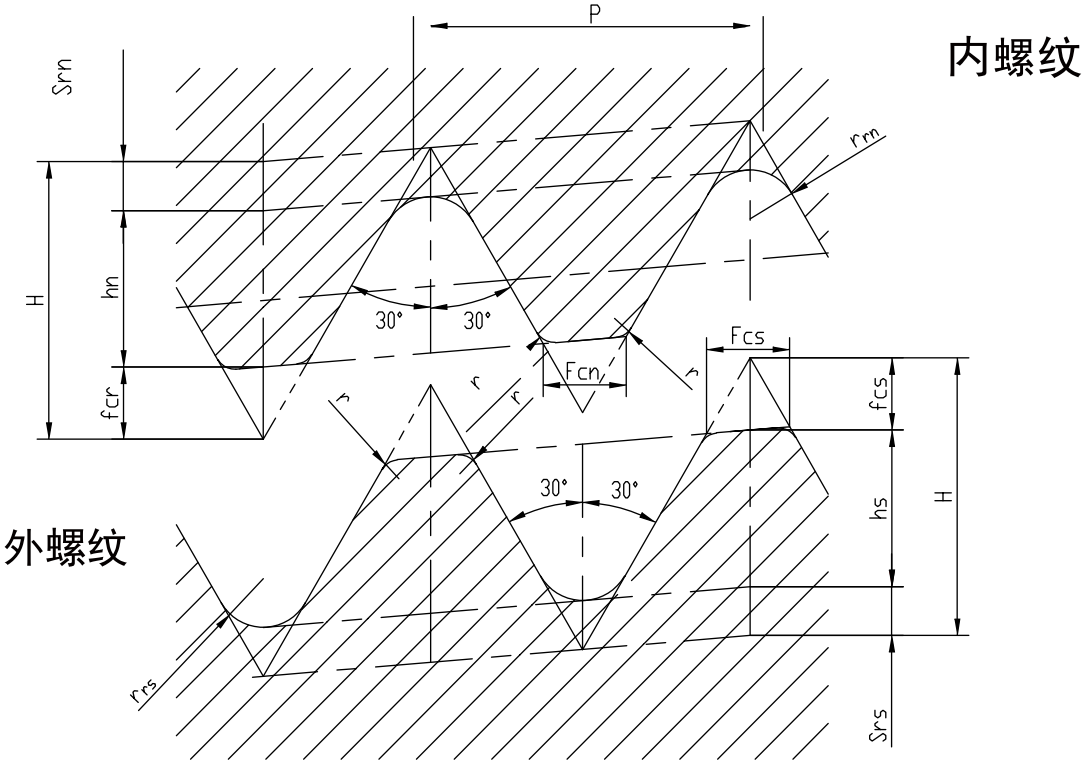
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

美制 API 石油钻杆螺纹设计牙型以及参数：

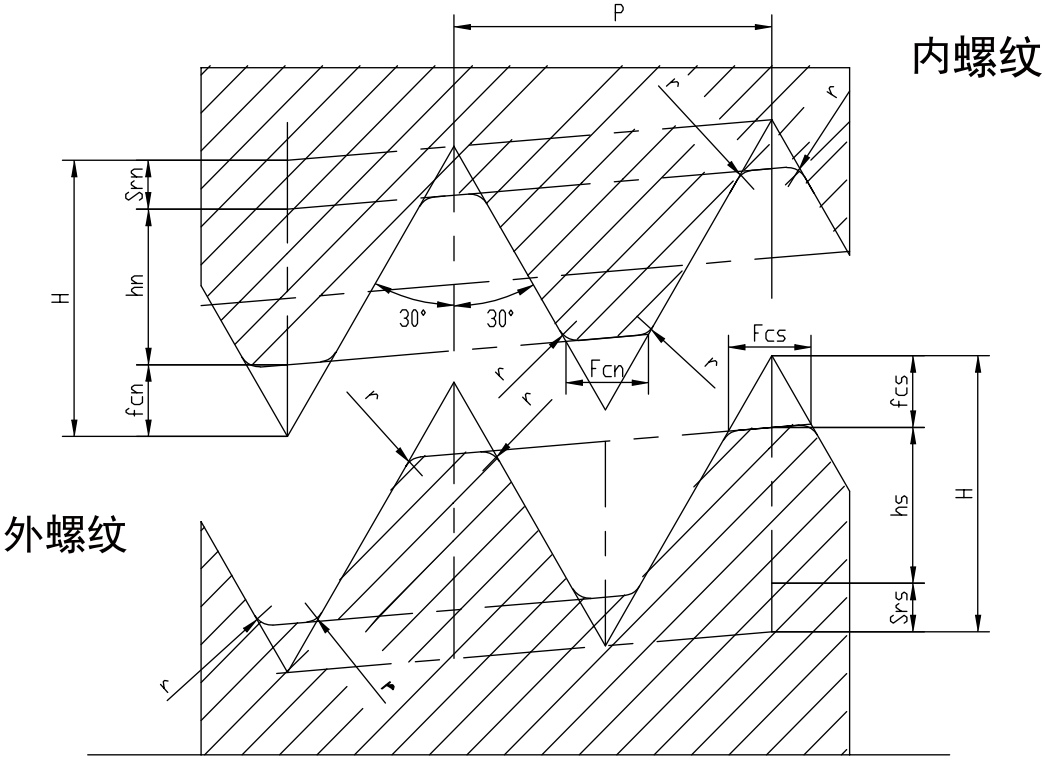
Tooth profile and parameter of american api oil drill pipe threading:

API SPEC 5B

GB/T 9253



V-0.038R V-0.040和V0.050螺纹牙型



V-0.055 V-0.065和V0.076螺纹牙型

螺纹管规格	NC23-NC50	NC56-NC77	2-3/8"～4-1/2"REG 3-1/2"FH 4-1/2"FH	6-5/8REG 5-1/2"FH 6-5/8F	5-1/2"REG 7-5/8REG 8-5/8"REG	NC10～NC16	4"FH 2-3/8"～5-1/2"FH
螺纹牙型	V-0.038R	V-0.038R	V-0.040	V-0.050	V-0.050	V-0.055	V-0.065
每英寸牙数 Tpi	4	4	5	4	4	6	4
螺距 P	6.35mm	6.35mm	5.08mm	6.35mm	6.35mm	4.23mm	6.35mm
牙侧角	30°/30°	30°/30°	30°/30°	30°/30°	30°/30°	30°/30°	30°/30°
锥度 2tgQ	1:6	1:4	1:4	1:6	1:4	1:8	1:8
牙顶宽度 (Fcn/fcs)	1.65mm	1.65mm	1.02mm	1.27mm	1.27mm	1.4mm	1.65mm
牙底圆弧半径 rrn	0.97mm	0.97mm	0.51mm	0.64mm	0.64mm	-	0.38
牙底宽度 Frn=Frs	-	-	-	-	-	1.19	1.42
截顶前的螺纹参考高度 H	5.487mm	5.471mm	4.376mm	5.487mm	5.471mm	3.660mm	5.487mm
牙顶削平高度 fcn/fcs	1.426mm	1.423mm	0.875mm	1.097mm	1.094mm	1.209mm	1.426mm
牙底削平高度 Srn/Srs	-	-	-	-	-	1.19	1.42
截顶后的螺纹参考高度 Hh/Hs	3.095mm	3.083mm	2.993mm	3.755mm	3.743mm	1.420mm	2.831mm
牙顶圆角半径 r	0.38mm	0.38mm	0.38mm	0.38mm	0.38mm	0.38mm	0.38mm

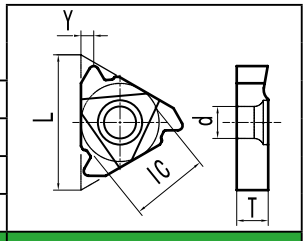
外螺纹刀片 External Threading Insert

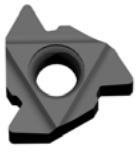
API SPEC 5B
GB/T 9253

型号 Model	L (mm)	IC (mm)	T (mm)	d (mm)
22ER**	22	12.7	4.9	5
27ER**	27	15.875	6.4	6.5

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺	😐
不锈钢	M		☺
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DP220	DM215	螺纹管规格
	22ER4API382	V-0.038R	4	1:6	2.5	●	○	NC23～NC50
	22ER4API383	V-0.038R	4	1:4	2.6	●	○	NC56～NC77
	22ER4API502	V-0.050	4	1:6	2.8	●	○	6-5/8REG, 5-1/2FH", 6-5/8FH"
	22ER4API503	V-0.050	4	1:4	2.8	●	○	5-1/2", 7-5/8", 8-5/8"REG
	22ER5API403	V-0.040	5	1:4	2.3	●	○	2-3/8"～4-1/2"REG 3-1/2"FH, 4-1/2"FH
	22ER6API551	V-0.055	6	1:8	1.5	●	○	NC10～NC16
	27ER4API382	V-0.038R	4	1:6	2.6	●	○	NC23～NC50
	27ER4API383	V-0.038R	4	1:4	2.8	●	○	NC56～NC77
	27ER4API502	V-0.050	4	1:6		●	○	6-5/8REG, 5-1/2FH", 6-5/8FH"
	27ER4API503	V-0.050	4	1:4	2.8	●	○	5-1/2", 7-5/8", 8-5/8"REG
	27ER5API403	V-0.040	5	1:4	2.3	●	○	2-3/8"～4-1/2"REG

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

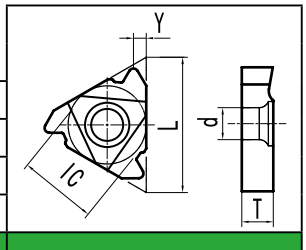
内螺纹刀片 Internal Threading Insert

API SPEC 5B
GB/T 9253

型号 Model	L (mm)	IC (in)	T (mm)	d (mm)
22NR**	22	12.7	4.9	5
27NR**	27	15.875	6.4	6.5

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺	😐
不锈钢	M		☺
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DP220	DM215	螺纹管规格
	22NR4API382	V-0.038R	4	1:6	2.5	●	○	NC23～NC50
	22NR4API383	V-0.038R	4	1:4	2.6	●	○	NC56～NC77
	22NR4API502	V-0.050	4	1:6	2.8	●	○	6-5/8REG, 5-1/2"FH, 6-5/8FH
	22NR4API503	V-0.050	4	1:4	2.8	●	○	5-1/2", 7-5/8", 8-5/8"REG
	22NR5API403	V-0.040	5	1:4	2.3	●	○	2-3/8"～4-1/2"REG 3-1/2"FH 4-1/2"FH
	22NR6API551	V-0.055	6	1:8	1.5	●	○	NC10～NC16
	27NR4API382	V-0.038R	4	1:6	2.6	●	○	NC23～NC50
	27NR4API383	V-0.038R	4	1:4	2.8	●	○	NC56～NC77
	27NR4API502	V-0.050	4	1:6		●	○	6-5/8REG, 5-1/2FH", 6-5/8FH"
	27NR4API503	V-0.050	4	1:4	2.8	●		5-1/2", 7-5/8", 8-5/8"REG
	27NR5API403	V-0.040	5	1:4	2.3	●	○	2-3/8"～4-1/2"REG

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

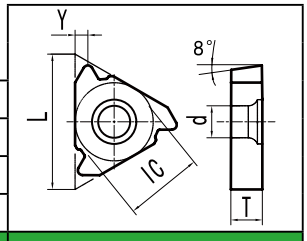
外螺纹刀片 External Threading Insert

API SPEC 5B
GB/T 9253

L (mm)	IC (mm)	T (mm)	d (mm)
29	17	5.5	6.2

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺	😐
不锈钢	M		😐
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DP220	BR402	螺纹管规格
	4Y1W3	V-0.038R	4	1:6	3.7	●	●	NC23～NC50
	4Y2W3	V-0.038R	4	1:4	3.7	●	●	NC56～NC77
	5Y3W3	V-0.040	5	1:4	3.7	●	●	2-3/8"～4-1/2"REG 3-1/2"FH 4-1/2"FH
	4Y4W3	V-0.050	4	1:4	3.7	●	●	5-1/2", 7-5/8", 8-5/8"REG
	4Y5W3	V-0.050	4	1:6	3.7	●	●	6-5/8REG, 5-1/2FH", 6-5/8FH"
	4Y5W3-1T	V-0.050	4	1:12	3.7			6-5/8REG, 5-1/2FH", 6-5/8FH"
	4Y7W3	V-0.065	4	1:6	3.7			4"FH 2-3/8"～5-1/2"IF
	MZ4Y1W3	V-0.038R	4	1:16	3.7			NC23～NC50

● 常备库存（主推） Standing stock ◯ 非常备库存 Extraordinary stock

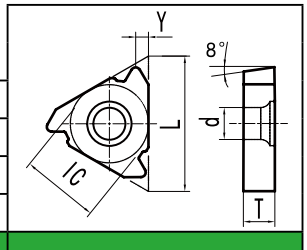
内螺纹刀片 Internal Threading Insert

API SPEC 5B
GB/T 9253

L (mm)	IC (mm)	T (mm)	d (mm)
29	17	5.5	6.2

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺	😐
不锈钢	M		😐
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DP220	BR402	螺纹管规格
	4Y1N3	V-0.038R	4	1:6	3.7	●	●	NC23～NC50
	4Y2N3	V-0.038R	4	1:4	3.7	●	●	NC56～NC77
	5Y3N3	V-0.040	5	1:4	3.7	●	●	2-3/8"～4-1/2"REG 3-1/2"FH 4-1/2"FH
	4Y4N3	V-0.050	4	1:4	3.7	●	●	5-1/2", 7-5/8", 8-5/8"REG
	4Y5N3	V-0.050	4	1:6	3.7	●	●	6-5/8REG, 5-1/2FH", 6-5/8FH"
	4Y5N3-1T	V-0.050	4	1:12	3.7			6-5/8REG, 5-1/2FH", 6-5/8FH"
	4Y7N3	V-0.065	4	1:6	3.7			4"FH 2-3/8"～5-1/2"IF
	MZ4Y1N3	V-0.038R	4	1:16	3.7			NC23～NC50

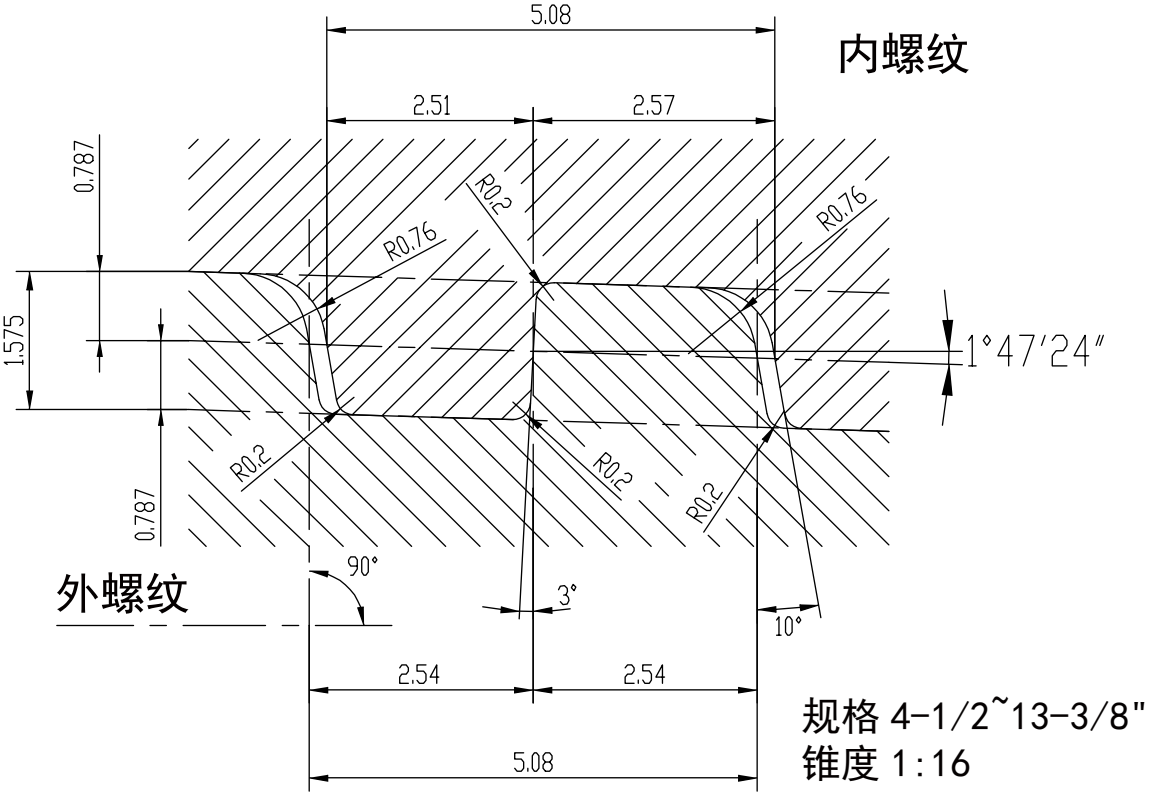
● 常备库存（主推） Standing stock ◯ 非常备库存 Extraordinary stock

美制 API 偏梯形套管螺纹设计牙型以及参数：

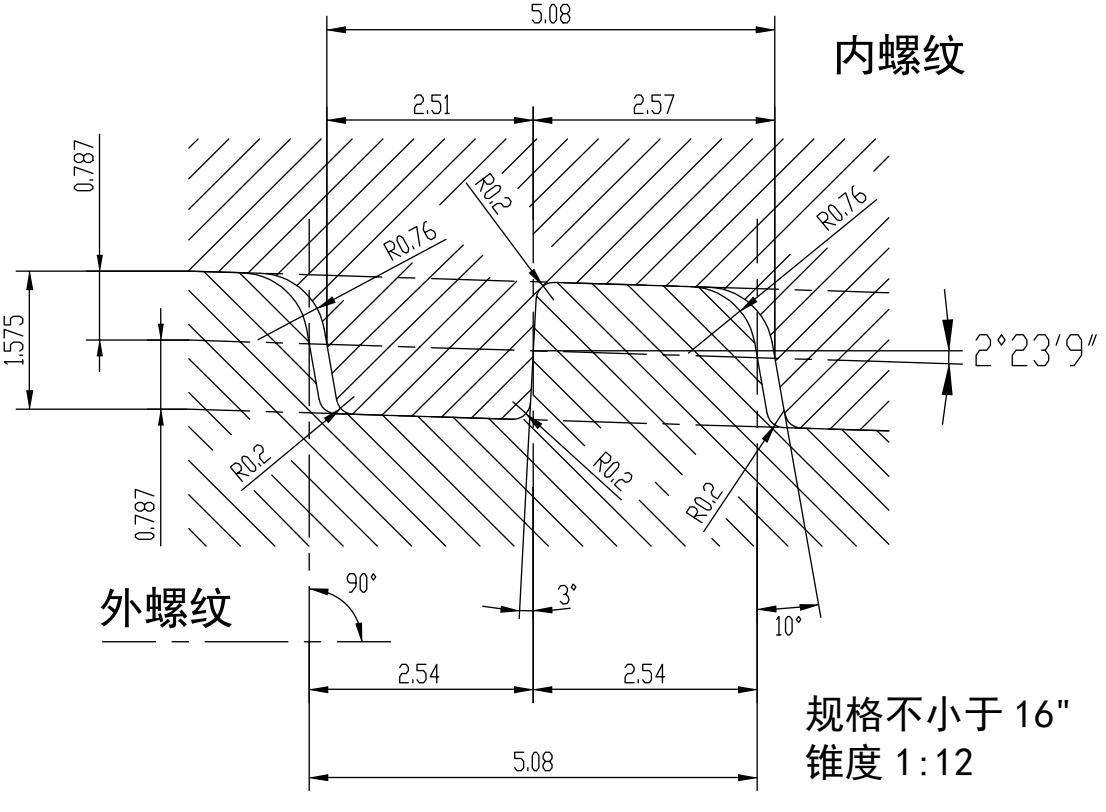
Tooth profile and parameter of american api buttress casing threading:

API SPEC 5B

GB/T 9253



规格 4-1/2~13-3/8"
锥度 1:16



规格不小于 16"
锥度 1:12

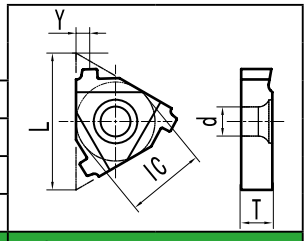
外螺纹刀片 External Threading Insert

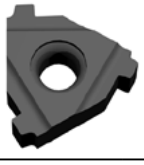
API SPEC 5B
GB/T 9253

型号 Model	L (mm)	IC (mm)
22**	22	12.7

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DM215	DP220	尺寸 Dimensions (mm) d	T
	22ER5BUT75	API 偏梯形螺纹	5	1:16	1.9	●	●	5.0	4.9
	22ER5BUT1	API 偏梯形螺纹	5	1:12	1.9			5.0	4.9

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

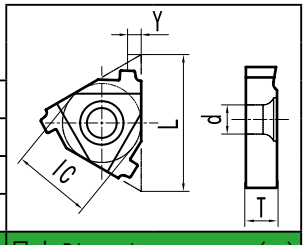
内螺纹刀片 Internal Threading Insert

API SPEC 5B
GB/T 9253

型号 Model	L (mm)	IC (mm)
22**	22	12.7

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DM215	DP220	尺寸 Dimensions (mm) d	T
	22NR5BUT75	API 偏梯形螺纹	5	1:16	1.9	●	●	5.0	4.9
	22NR5BUT1	API 偏梯形螺纹	5	1:12	1.9			5.0	4.9

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

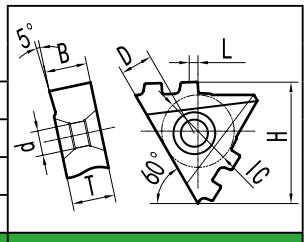
外螺纹刀片 External Threading Insert

API SPEC 5B
GB/T 9253

L (mm)	H (mm)	T (mm)	d (mm)
22	17.09	6	4.2

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	旧型号 Old Type	螺距 pitch tpi	锥度 IPF	齿数	DM215	DP220	螺纹管尺寸
	22ER5BUT75-2	B5BW2-2	5	1:16	2			4-1/2"~13-3/8"

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

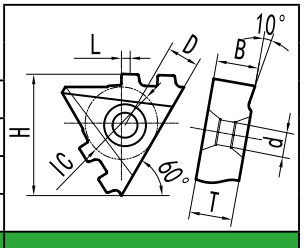
内螺纹刀片 Internal Threading Insert

API SPEC 5B
GB/T 9253

L (mm)	H (mm)	T (mm)	d (mm)
22	17.09	6	4.2

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	😐
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	旧型号 Old Type	螺距 pitch tpi	锥度 IPF	齿数	DM215	DP220	螺纹管尺寸
	22NR5BUT75-2	B5BN2-2	5	1:16	2			4-1/2"~13-3/8"
	27NR5BUT75-3	B5BN2-3	5	1:16	3			

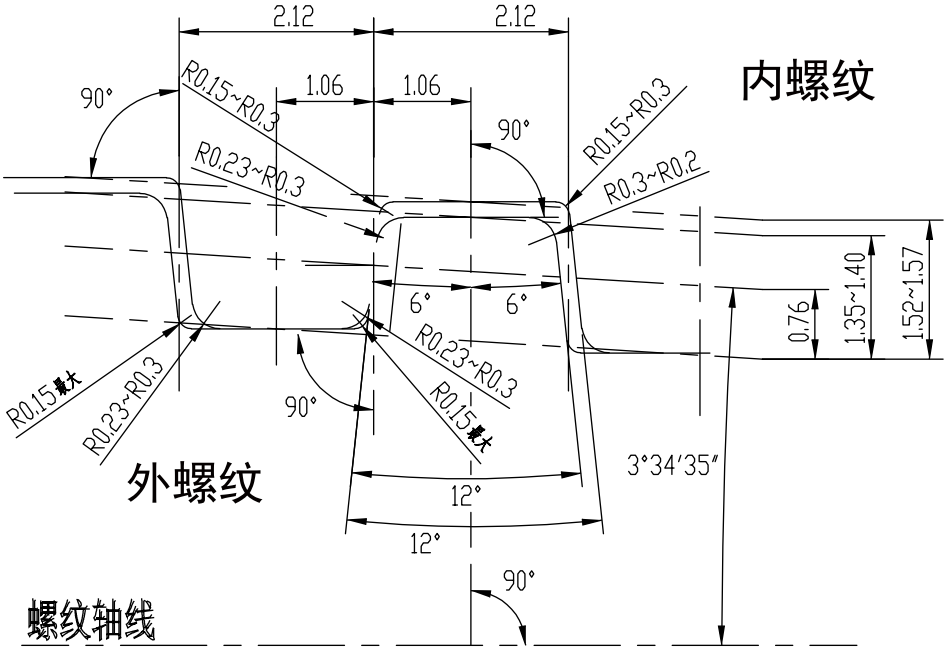
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

美制 API 直连型套管螺纹设计牙型以及参数：

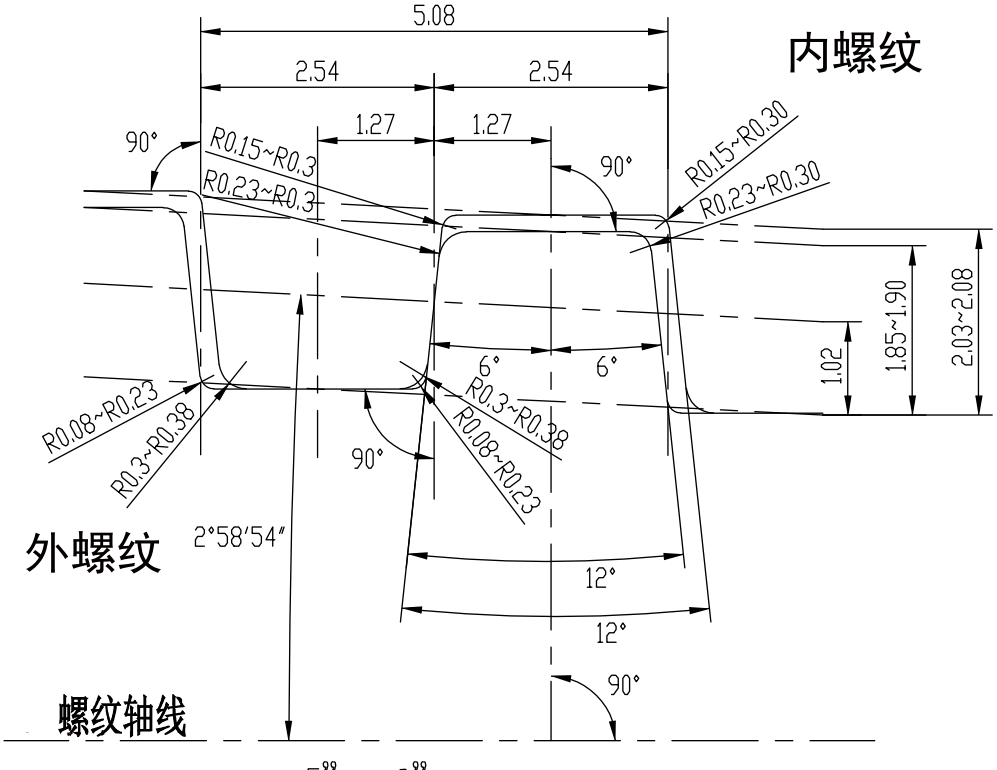
Tooth profile and parameter of american api directly-connected casing threading:

API SPEC 5B

GB/T 9253



（规格5″~7 5/8″，6牙/25.4mm，锥度1:16）



（规格 8 5/8″~10 3/4″，5牙/25.4mm，锥度1:9.6）

外螺纹刀片 External Threading Insert

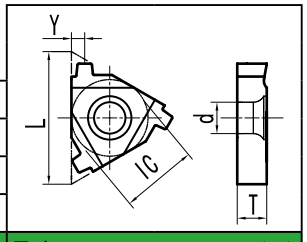
API SPEC 5B GB/T 9253

型号 Model	L (mm)	IC (mm)
22**	22	12.7

☺ 优先推荐 Good recommendation

☹ 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	☹
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DM215	DP220	尺寸 Dimensions (mm) d	T
	22ER6EL	直连型套管螺纹	6	1:16	1.9			5.0	4.9
	22ER5EL	直连型套管螺纹	5	1:9.6	1.9			5.0	4.9

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

内螺纹刀片 Internal Threading Insert

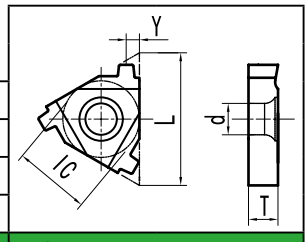
API SPEC 5B GB/T 9253

型号 Model	L (mm)	IC (mm)
22**	22	12.7

☺ 优先推荐 Good recommendation

☹ 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	☹
不锈钢	M	☺	
铸铁	K		
有色金属	N		



刀片 Insert	刀片型号 Type	扣型 Theard Standard	螺距 pitch tpi	锥度 IPF	齿边距 Y	DM215	DP220	尺寸 Dimensions (mm) d	T
	22NR6EL	直连型套管螺纹	6	1:16	1.9			5.0	4.9
	22NR5EL	直连型套管螺纹	5	1:9.6	1.9			5.0	4.9

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

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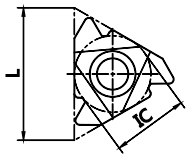
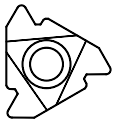
1. 刀片尺寸 Insert size	
L(mm)	IC
06	5/32"
08	3/16"
11	1/4"
16	3/8"
22	1/2"
27	5/8"



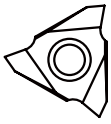
2. 刀片形式 Insert style

无标记 -



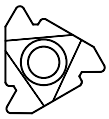
U 型 -

V 型 -



3. 刀片类型 Type of insert

E 外螺纹 External
N 内螺纹 Internal



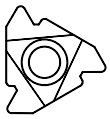
E

N

图片为右手刀片
Right insert(see picture)

4. 螺纹导向 RH/LH insert

R 右手刀片 Right hand
L 左手刀片 Left hand



R

L

图片为外螺纹刀片
External insert(see picture)

16		E	R	1.50	ISO	-M	DM215
1	2	3	4	5	6	7	8

5. 螺距 Pitch		
全牙型（定螺距）		
Full profile pitch range		
mm	tpi	
0.6-6.0	48-4	
通用牙距（泛用型）		
Partial profile pitch range		
	mm	tpi
A	0.5-1.5	48-16
AG	0.5-3.0	48-8
G	1.75-3.0	14-8
N	3.5-5.0	7-5
Q	5.5-6.0	4.5-4
V	6.0-10.0	4-2.5

6. 螺纹标准 Standard
60-60° 通用型螺纹 Partial profile 60°
55-55° 通用型螺纹 Partial profile 55°
ISO-ISO 标准型螺纹 ISO metric
UN-60° 美制统一标准型螺纹 American UN
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
TR-30° 标准梯形螺纹 Trapeze DIN103
ACME-29° 美制梯形螺纹 American ACME
STACME-29° 美制短齿梯形螺纹刀片 American STUB ACME
RD-30° 消防食品机械圆螺纹 Round DIN403
SAGE- 德标锯齿形螺纹 DIN513

7. 槽型 Groove type
M- 压制槽型、断屑槽
chip breaker
无 - 精磨槽型
polished groove type

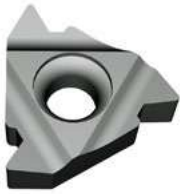
8. 材质 material code
DM215- 通用材质，不锈钢首选 general meterial, stainless steel prefered
DM415- 不锈钢首选 stainless steel prefered
DP220- 钢件，铸铁 steel, cast iron
DK110- 铝合金，有色金属 aliuminum alloy, nonferrous metal

刀片材质说明

Instruction for insert material

← Wear resistance　　Toughness →

	01	10	20	30	40
P 钢 steel		DP220	DM415 / DM215		
M 不锈钢 stainless steel			DM415 / DM215		
K 铸铁 cast iron			DM415 / DM215		
N 有色金属 non-ferrous matals			DK110		

			
DM215 Layer system:PVD TiAlN	DM415 Layer system:PVD TiAlN	DP220(P30,M40) Layer system:PVD TiN	DK110(K15) 颗粒度 :0.6μm Grain size:0.6μm 硬度：HV1670 Hardness:HV1670
不锈钢和钢件通用材质，耐高温性能提升，适应更高转速的加工场合。加工不锈钢时推荐使用线速度 Vc=80~140m/min，加工钢件时推荐使用线速度 Vc=120~180m/min. DM215 is the first choice in stainless steels,superior toother steels maching high speed.Recommended parameter Vc:60~120m/min for stainless steel;Vc=100~180m/min for steel	不锈钢和钢件通用材质，耐高温性能优越，加工不锈钢和普通钢件更高的耐用度。加工不锈钢 时推荐使用线速度 Vc=80~140m/min，加工钢件时推荐使用线速度 Vc=120~180m/min. DM415 is the better choice in stainlesssteels,superior to other steels maching highspeed.Recommended parameter Vc:60~120m/min for stainless steel;Vc=100~180m/min for steel	适合加工各种钢件，具有好的韧性，推荐使用线速度 Vc=90~180mm/min。 DP220 is good at all application with perfect toughness. Recommended paraneter Vc=90~180m/min.	铝合金等有色金属首选！推荐使用线速度 Vc=100~300m/min DK110 is the top choice in Aluminium alloy and non-ferrous metals(e.g.aluminum alloy)maching. Recommended parameter Vc=100~300m/min.

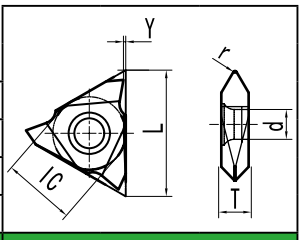
MTTR 系列螺纹刀片 Partial Profile V-style Insert

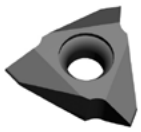
型号 Model	L (mm)	IC (mm)	d (mm)
MTTR4360**	22	12.7	5
MTTR4355**	22	12.7	5

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

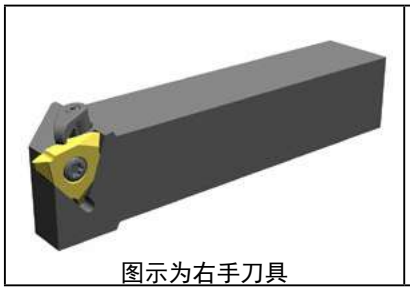
材质推荐 material recommended					
钢	P	☺	☺		
不锈钢	M	☺			
铸铁	K	😐			
有色金属	N			☺	

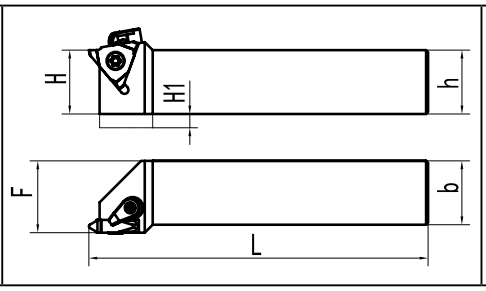


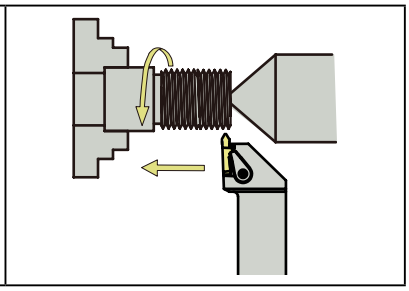
刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch		DM215		DP220		DK110		尺寸 Dimensions (mm)		
			mm	tpi	R	L	R	L	R	L	r	Y	T
	MTTR436001	MTTL436001	1.0-1.75	24-14	●	○	●	○	●		0.1	0.4	4.76
	MTTR436002	MTTL436002	2.0-2.5	13-10	●	○	●	○	●		0.2	0.4	4.76
	MTTR436003	MTTL436003	3.0-3.5	9-7	●	○	●	○	●		0.3	0.4	4.76
	MTTR436004	MTTL436004	4.0-5.0	6-5	●	○	●	○	●		0.4	0.4	4.76
	MTTR435501	MTTL435501	-	24-14	●	○	●	○	○		0.1	0.4	4.76
	MTTR435502	MTTL435502	-	13-10	●	○	●	○	○		0.2	0.4	4.76
	MTTR435503	MTTL435503	-	9-7	●	○	●	○	○		0.3	0.4	4.76
	MTTR435504	MTTL435504	-	6-5	●	○	●	○	○		0.4	0.4	4.76

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀杆 - 立装型

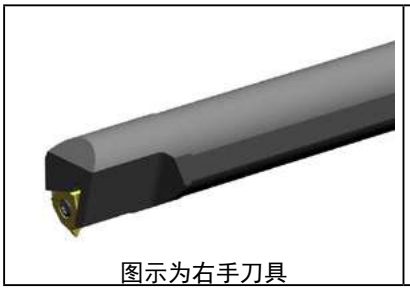

图示为右手刀具

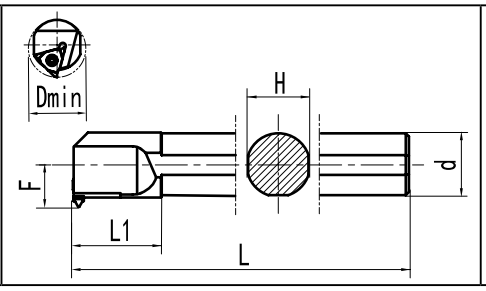


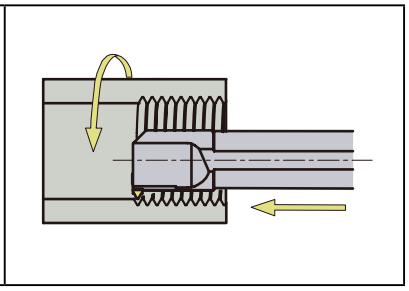


刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)						刀片螺钉 Insert Screw	扳手 Torx Key	压板 Clamp	压板螺钉 Clamp Screw	扳手 Hex Wrench
			h	b	H	F	L	H1					
MTHR	1616H43	MTTR43**	16	16	16	20	100	3	L60M4.5*12	T-20	HL1814	ML0620	L3
	2020K43		20	20	20	25	125	-	L60M4.5*12	T-20	HL1814	ML0620	L3
	2525M43		25	25	25	32	150	-	L60M4.5*12	T-20	HL1814	ML0620	L3
	3225P43		32	25	32	32	170	-	L60M4.5*12	T-20	HL1814	ML0620	L3
	3232P43		32	32	32	40	170	-	L60M4.5*12	T-20	HL1814	ML0620	L3
MTHL	1616H43	MTTL43**	16	16	16	20	100	3	L60M4.5*12	T-20	HL1814	ML0620	L3
	2020K43		20	20	20	25	125	-	L60M4.5*12	T-20	HL1814	ML0620	L3
	2525M43		25	25	25	32	150	-	L60M4.5*12	T-20	HL1814	ML0620	L3
	3225P43		32	25	32	32	170	-	L60M4.5*12	T-20	HL1814	ML0620	L3
	3232P43		32	32	32	40	170	-	L60M4.5*12	T-20	HL1814	ML0620	L3

内螺纹刀杆 - 立装型


图示为右手刀具





刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)						刀片螺钉 Insert Screw	扳手 Torx Key
			Dmin	h	l1	d	F	L		
SVNR	0025R-T43	MTTL43**	32	23	20	25	17.5	220	L60M4.5*12	T-20
	0032S-T43		41	30	30	30	22.5	250	L60M4.5*12	T-20
	0040S-T43		48	38	38	40	25	250	L60M4.5*12	T-20

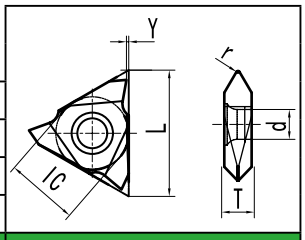
TT 系列螺纹刀片 Partial Profile V-style Insert

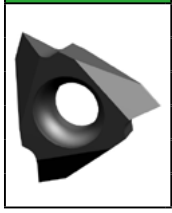
型号 Model	L (mm)	IC (mm)	d (mm)
TT32R60**	16	9.525	4.5
TT32R55**	16	9.525	4.5

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N		☺	



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	螺距 pitch tpi	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	尺寸 Dimensions (mm) T
	TT32R6000	TT32L6000	0.5-1.0	48-32	○	○	○		0	3.18
	TT32R6001	TT32L6001	1.0-2.5	28-14	●	○	●		0.1	3.18
	TT32R6002	TT32L6002	1.5-2.5	16-10	●	○	●		0.2	3.18
	TT32R6003	TT32L6003	2.5	11-10	○	○	○		0.3	3.18
	TT32R5501	TT32L5501	-	28-10	○	○	○		0.1	3.18
	TT32R5502	TT32L5502	-	14-10	○	○	○		0.2	3.18

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

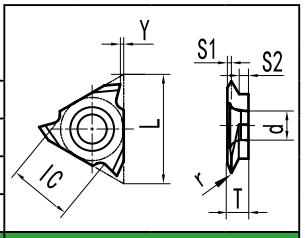
TTX 系列螺纹刀片 Partial Profile V-style Insert

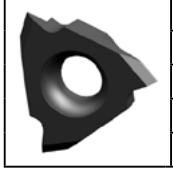
型号 Model	L (mm)	IC (mm)	d (mm)
TTX32R60**	16	9.525	4.5
TTX32R55**	16	9.525	4.5

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N		☺	

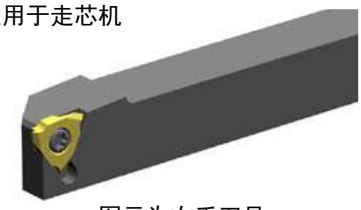


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	螺距 pitch tpi	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	尺寸 Dimensions (mm) S1	尺寸 Dimensions (mm) S2	尺寸 Dimensions (mm) T
	TTX32R60003	TTX32L60003	0.5-1.0	48-32	●	○	●		0.03	0.6	1.4	3.18
	TTX32R60005	TTX32L60005	0.5-1.0	48-32	●	○	●		0.05	0.6	1.4	3.18
	TTX32R6001	TTX32L6001	1.0-2.5	28-14	●	○	●		0.1	1.1	0.53	3.18
	TTX32R5501	TTX32L5501	-	28-9	●	○	●		0.1	1.1	0.5	3.18

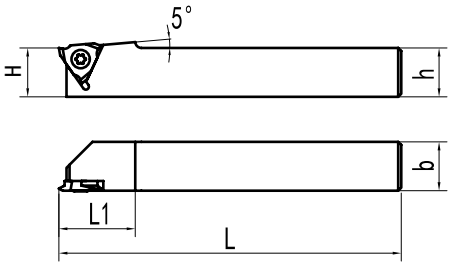
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

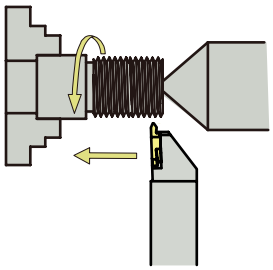
TT32 系列螺纹刀杆

形式一、直头型
适用于走芯机



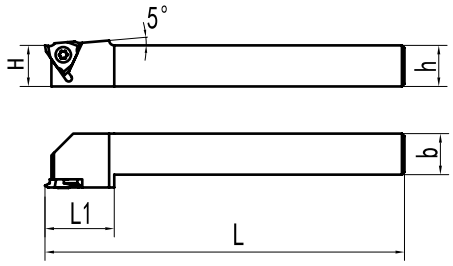
图示为右手刀具

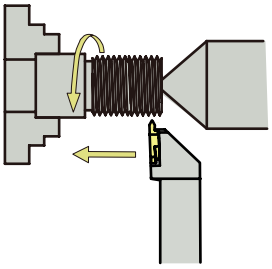




形式二、偏头型

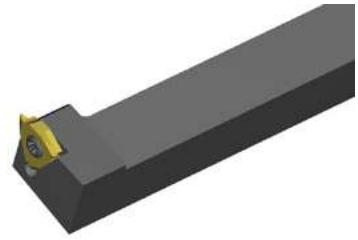
图示为右手刀具



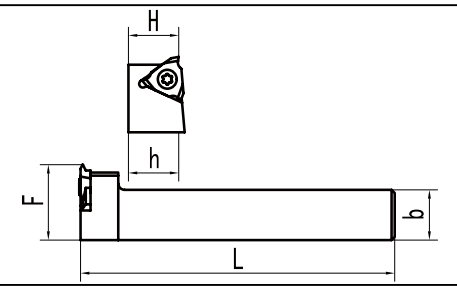


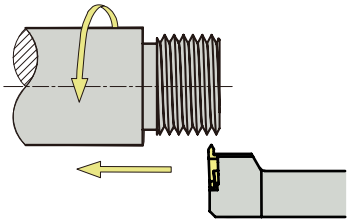
刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)					形式 Type	刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	L1	L			
KTTR	1010K-16F	TT32R** TTX32R**	10	10	10	20	125	形式一	L60M4*8	T-15
	1212K-16F		12	12	12	25	125		L60M4*8	T-15
	1616M-16F		16	16	16	30	150		L60M4*8	T-15
	2020K-16		20	20	20	20	125	形式二	L60M4*8	T-15
	2525M-16		25	25	25	30	150		L60M4*8	T-15
KTTL	1010K-16F	TT32L** TTX32L**	10	10	10	20	125	形式一	L60M4*8	T-15
	1212K-16F		12	12	12	25	125		L60M4*8	T-15
	1616M-16F		16	16	16	30	150		L60M4*8	T-15
	2020K-16		20	20	20	20	125	形式二	L60M4*8	T-15
	2525M-16		25	25	25	30	150		L60M4*8	T-15

TT32 系列螺纹刀杆 - 排刀机专用



图示为左手刀具





刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L		
KTTL	1010H16-A90	TT32R** TTX32R**	10	10	10	18	100	L60M4*8	T-15
	1212H16-A90		12	12	12	20	100	L60M4*8	T-15
	1616K16-A90		16	16	16	24	125	L60M4*8	T-15
	2020K16-A90		20	20	20	28	125	L60M4*8	T-15

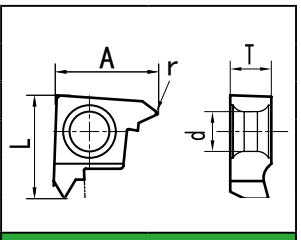
GE 系列螺纹刀片 GE Threading Insert

型号 Model	L (mm)	A (mm)	d (mm)
GER**-A	6.5	6.69	2.5
GER**-B	8.2	8.46	3
GER**-C	11.5	5.8	3
GER**-D	16.5	6.8	3.5

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

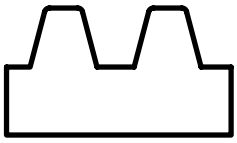
材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



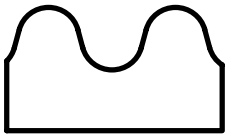
刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	螺距 pitch tpi	PM125 R	PM125 L	DK110 R	DK110 L	刀杆 toolholder	尺寸 Dimensions (mm) r	尺寸 Dimensions (mm) T
	GER6001-A	GEL6001-A	0.5-1.5	48-16	○		○		SIGER*A	0.1	2.58
	GER5501-A	GEL5501-A	-	48-16	○		○			0.1	2.58
	GER6001-B	GEL6001-B	0.5-1.5	48-16	●		○		SIGER*B	0.1	3.18
	GER6002-B	GEL6002-B	1.0-2.5	25-10	●		○			0.2	3.18
	GER5501-B	GEL5501-B	-	48-16	○		○			0.1	3.18
	GER2.0TR-B	GEL2.0TR-B	2.0	-						0.1	3.18
	GER3.0TR-B	GEL3.0TR-B	3.0	-						0.1	3.18
	GER4.0TR-B	GEL4.0TR-B	4.0	-						0.1	3.18
	GER3.0TR-C	GEL3.0TR-C	3.0	-					SIGER*C	0.1	4.0
	GER4.0TR-C	GEL4.0TR-C	4.0	-						0.2	4.0
	GER4.0TR-D	GEL4.0TR-D	4.0	-					SIGER*D	0.2	5.0
	GER5.0TR-D	GEL5.0TR-D	5.0	-						0.2	5.0
	GER6.0TR-D	GEL6.0TR-D	6.0	-						0.2	5.0

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

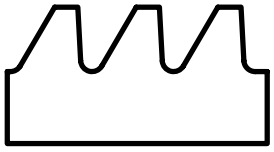
可以定制其他形式螺纹：
Other thread type can be customized:



TR/ACME 螺纹



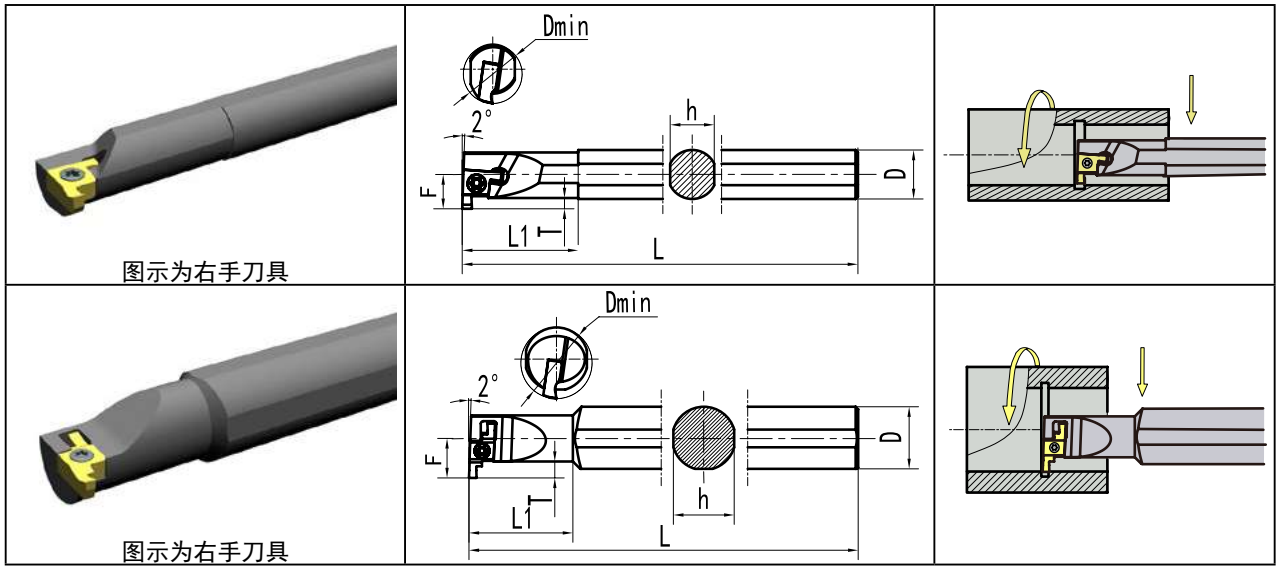
RD 圆螺纹



锯齿螺纹 buttress thread

...

SIGE 系列刀杆 Internal Grooving Tools



刀杆型号 Toolholder Type		刀片型号 Insert Type	最小加工直径 Dmin	尺寸 Dimensions (mm) T	L1	D	F	h	L	刀片螺钉 Insert Screw	扳手 Torx Key
SIGER	0808A	GER**-A	8	1.5	20	8	4.8	7.2	100	L60M2.2*5	T-6
*	0808A-WH		8		28	8	4.8	7.2	125		
	1010B	GER**-B	10	2.2	25	10	6.2	9	125	L60M2.5*6	T-8
*	1010B-WH		10		35	10	6.2	9	125		
	1210B		12		30	10	7	9	125		
	1412C	GER**-C	14	2.5	33	12	8	11.4	150	L60M2.5*6	T-8
	1612C		16		20	12	8.5	11.4	150		
	1616C		16		36	16	9	15	160		
	2020D	GER**-D	20	4.5	40	20	12.1	19	180	L60M3*8	T-10
	2525D		25	4.2	45	25	12.3	24	200		
SIGEL	0808A	GEL**-A	8	1.5	20	8	4.8	7.2	100	L60M2.2*5	T-6
	0808A-WH		8		20	8	4.8	7.2	100		
	1010B	GEL**-B	10	2.2	25	10	6.2	9	125	L60M2.5*6	T-8
	1010B-WH		10		25	10	6.2	9	125		
	1210B		12		30	10	7	9	125		
	1412C	GEL**-C	14	2.5	33	12	8	11.4	150	L60M2.5*6	T-8
	1612C		16		20	12	8.5	11.4	150		
	1616C		16		36	16	9	15	160		
	2020D	GEL**-D	20	4.5	40	20	12.1	19	180	L60M3*8	T-10
	2525D		25	4.2	45	25	12.3	24	200		

* SIGER0808A-WH 与 SIGER1010B-WH 为硬质合金抗震型刀杆

* SIGER4032E 与 SIGEL4032E 刀杆有效长度 L1 为省略值，该刀杆是直柄，无台阶，可按需求调整有效长度

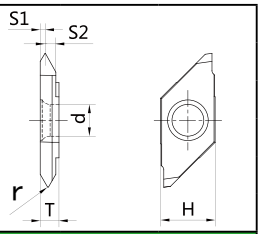
TKFT 系列螺纹刀片　TKFT Threading Insert

型号 Model	H (mm)	T (mm)	d (mm)
TKFT12R**	8.7	3.0	5
TKFT16R**	9.5	4.0	5

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended					
钢	P	☺			
不锈钢	M	☺			
铸铁	K	😐			
有色金属	N		☺		



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	螺距 pitch tpi	PM125 R	PM125 L	DK110 R	DK110 L	刀杆 toolholder	尺寸 Dimensions (mm) r	S1	S2
	TKFT12RA60005	TKFT12LA60005	0.5-1.25	48-24	●		○		KTKF*12	0.05	0.8	1.7
	TKFT12RB60005	TKFT12LB60005	0.5-1.25	48-24	●		○			0.05	1.7	0.8
	TKFT12RN6001	TKFT12LN6001	1.0-2.0	24-12	●		○			0.1	1.25	1.25
	TKFT12RA55005	TKFT12LA55005	-	48-24	●		○			0.05	0.8	1.7
	TKFT12RB55005	TKFT12LB55005	-	48-24	●		○			0.05	1.7	0.8
	TKFT12RN5501	TKFT12LN5501	-	24-18	●		○			0.1	1.25	1.25
	TKFT16RA60005	TKFT16RA60005							KTKF*16			
	TKFT16RB60005	TKFT16RB60005										
	TKFT16RN6001	TKFT16RN6001										
	TKFT16RA6001	TKFT16RA6001										
	TKFT16RB6001	TKFT16RB6001										
	TKFT16RA55005	TKFT16RA55005										
	TKFT16RB55005	TKFT16RB55005										
	TKFT16RN550051	TKFT16RN550051										

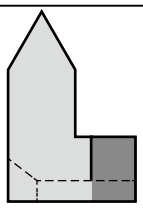
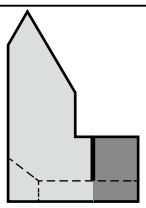
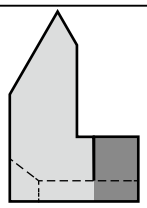
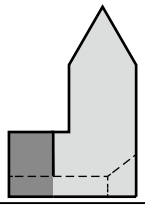
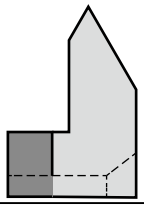
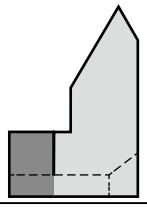
● 常备库存（主推） Standing stock　○ 非常备库存 Extraordinary stock

刀片型号表示方法　Representation method for blade type:

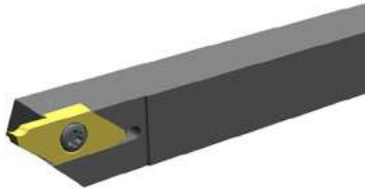
TKFT 12 R N 60 005

- TKFT：刀片名称
- 12：刀片大小
- R：刀片左右手 R：右手刀 L：左手刀
- N：刀尖位置 见下图
- 60：牙型角度 60=60° 55=55°
- 005：刀尖圆弧角 01=R0.1 005=R0.05

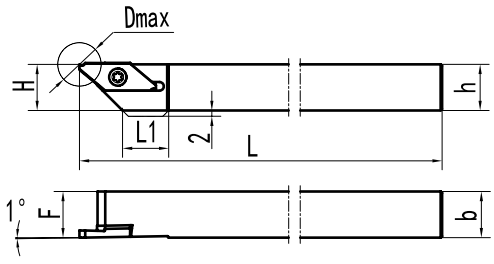
刀片型号示例

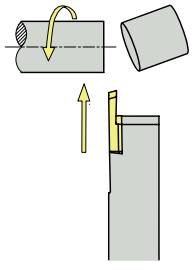
右手刀片 -R	右手刀片 -R	右手刀片 -R
TKFT12RN	TKFT12RA	TKFT12RB
		
左手刀片 -L	左手刀片 -L	左手刀片- L
TKFT12LN	TKFT12LA	TKFT12LB
		

TKF 系列刀杆　TKF Toolholder



图示为右手刀具





刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L	Dmax	L1		
KTKFR	1010K-12	TKF12R**（切槽 / 断） TKFB12R**（后扫） TKFT12R**（螺纹）	10	10	10	10	125	12	15	L60M4*10	T-15
	1212K-12		12	12	12	12			–		
	1212M-12		12	12	12	12	150				
	1616M-12		16	16	16	16					
	2020M-12		20	20	20	20					
	2525M-12		25	25	25	25					
KTKFR	1010K-16	TKF16R**（切槽 / 断） TKFB16R**（后扫） TKFT16R**（螺纹）	10	10	10	10	125	16	20	L60M4*10	T-15
	1212K-16		12	12	12	12			–		
	1212M-16		12	12	12	12	150				
	1616M-16		16	16	16	16					
	2020M-16		20	20	20	20					
	2525M-16		25	25	25	25					
KTKFL	1010K-12	TKF12L**（切槽 / 断） TKFB12L**（后扫） TKFT12L**（螺纹）	10	10	10	10	125	12	15	L60M4*10	T-15
	1212K-12		12	12	12	12			–		
	1212M-12		12	12	12	12	150				
	1616M-12		16	16	16	16					
	2020M-12		20	20	20	20					
	2525M-12		25	25	25	25					
KTKFL	1010K-16	TKF16L**（切槽 / 断） TKFB16L**（后扫） TKFT16L**（螺纹）	10	10	10	10	125	16	20	L60M4*10	T-15
	1212K-16		12	12	12	12			–		
	1212M-16		12	12	12	12	150				
	1616M-16		16	16	16	16					
	2020M-16		20	20	20	20					
	2525M-16		25	25	25	25					

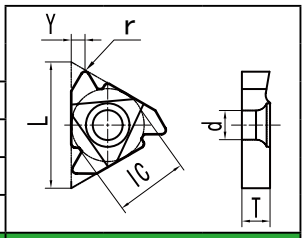
外螺纹刀片 External Partial Profile 60° Threading Insert

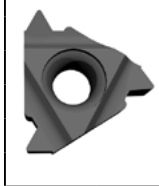
型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16ERAG60-M		0.5-3.0	●		○						0.07	1.7	3.65
	16ERG60-M		1.75-3.0	●		○						0.25	1.7	3.65
	22ERN60-M		3.5-5.0	●		○						0.4	1.7	3.65
	11ERA60	11ELA60	0.5-1.5	●	○			●		●		0.07	0.9	3.18
	16ERA60	16ELA60	0.5-1.5	●	○			●		●		0.07	0.9	3.65
	16ERAG60	16ELAG60	0.5-3.0	●	○			●		●		0.07	1.7	3.65
	16ERG60	16ELG60	1.75-3.0	●	○			●		●		0.25	1.7	3.65
	22ERN60	22ELN60	3.5-5.0	●	○			●		●		0.4	2.5	4.9
	27ERQ60	27ELQ60	5.5-6.0	○	○			○		○		0.79		6.4
	16VERAG60	16VELAG60	0.5-3.0	●	○			○		○		0.07		3.65
	27VERV60	27VELV60	6.0-9.0	○	○			○		○		0.87		8.7

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

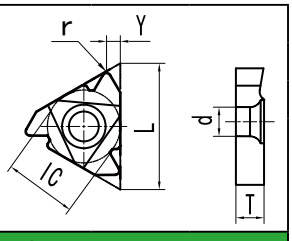
内螺纹刀片 Internal Partial Profile 60° Threading Insert

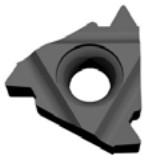
型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			DM215	DM415	DP220	DK110
	钢	P	☺	☺	☺	
	不锈钢	M	☺	☺		
	铸铁	K	😐	😐		
	有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NRA60-M		0.5-1.5	●		○						0.07	0.9	3.18
	16NRAG60-M		0.5-3.0	●		○						0.07	1.7	3.65
	16NRG60-M		1.75-3.0	●		○						0.13	1.7	3.65
	22NRN60-M		4.0-5.0	●		○						0.4	1.7	3.65
	06NRA60	06NLA60	0.5-1.5	○	○			○		○		0.07		1.91
	08NRA60	08NLA60	0.5-1.5	●	○			●		●		0.07	0.9	2.38
	11NRA60	11NLA60	0.5-1.5	●	○			●		●		0.07	0.9	3.18
	16NRA60	16NLA60	0.5-1.5	●	○			●		●		0.07	0.9	3.65
	16NRAG60	16NLAG60	0.5-3.0	●	○			●		●		0.07	1.7	3.65
	16NRG60	16NLG60	1.75-3.0	●	○			●		●		0.13	1.7	3.65
	22NRN60	22NLN60	4.0-5.0	●	○			○		○		0.4	2.5	4.9
	27NRQ60	27NLQ60	5.5-6.0	○	○			○		○		0.4		6.4
	16VNRAG60	16VNLAG60	0.5-3.0	●	○			○		○		0.07		3.65
	27VNRV60	27VNLV60	6.0-9.0	○	○			○		○		0.43		8.7

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

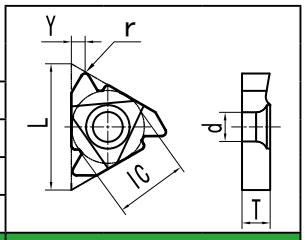
外螺纹刀片 External Partial Profile 55° Threading Insert

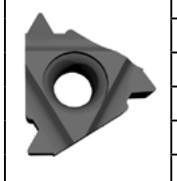
型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16ERAG55-M		48-8	●		○						0.07	1.5	3.65
	11ERA55	11ELA55	48-16	●	○			●		●		0.07	0.9	3.18
	16ERA55	16ELA55	48-16	●	○			●		●		0.07	0.9	3.65
	16ERAG55	16ELAG55	48-8	●	○			●		●		0.07	1.5	3.65
	16ERG55	16ELG55	14-8	●	○			●		●		0.25	1.5	3.65
	22ERN55	22ELN55	9-5	●	○			●		●		0.4	2.5	4.9
	27ERQ55	27ELQ55	4.5-4	○	○			○		○		0.78		6.4
	16VERAG55	16VELAG55	48-8	○	○			○		○		0.07		3.65
	27VERV55	27VELV55	4-2.5	○	○			○		○		0.88		8.7

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

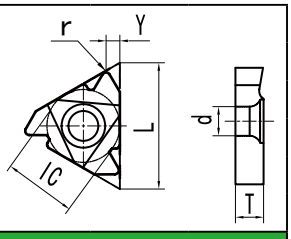
内螺纹刀片 Internal Partial Profile 55° Threading Insert

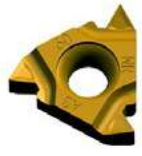
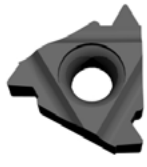
型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16NRAG55-M		48-8	●		○						0.06	1.5	3.65
	06NRA55	06NLA55	48-19	○	○			○		○		0.07		1.91
	08NRA55	08NLA55	48-16	●	○			●		●		0.07	0.9	2.38
	11NRA55	11NLA55	48-16	●	○			●		●		0.07	0.9	3.18
	16NRA55	16NLA55	48-16	●	○			●		●		0.07	1.5	3.65
	16NRAG55	16NLAG55	48-8	●	○			●		●		0.07	1.5	3.65
	16NRG55	16NLG55	28-8	●	○			●		●		0.13	1.5	3.65
	22NRN55	22NLN55	9-5	●	○			●		●		0.4	2.5	4.9
	27NRQ55	27NLQ55	4.5-4	○	○			○		○		0.79		6.4
	16VNRAG55	16VNLAG55	48-8	○	○			○		○		0.06		3.65
	27VNRV55	27VNLV55	4-2.5									0.89		8.7

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

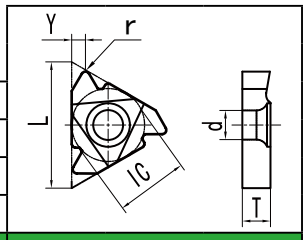
外螺纹刀片 External ISO Metric Threading Insert

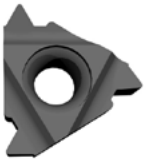
ISO 68-1
GB/T 192

型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
☺ 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	☺	☺		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16ER1.00ISO-M		1.0	●		○		○				0.14	0.7	3.65
	16ER1.50ISO-M		1.5	●		○		○				0.22	1.0	3.65
	16ER2.00ISO-M		2.0	●		○		○				0.29	1.3	3.65
	16ER2.50ISO-M		2.5	●		○		○				0.36	1.5	3.65
	16ER3.00ISO-M		3.0	●		○		○				0.43	1.6	3.65
	22ER3.50ISO-M		3.5	●		○		○				0.51	2.0	4.9
	22ER4.00ISO-M		4.0	●		○		○				0.58	2.0	4.9
	22ER5.00ISO-M		5.0	●		○		○				0.72	2.4	4.9
	22ER6.00ISO-M		6.0	●		○		○				0.87	2.7	4.9
	11ER0.50ISO	11EL0.50ISO	0.5	●	○			○		●		0.07	0.6	3.18
	11ER0.75ISO	11EL0.75ISO	0.75	●	○			○		●		0.11	0.6	3.18
	11ER1.00ISO	11EL1.00ISO	1.0	●	○			○		●		0.14	0.7	3.18
	11ER1.25ISO	11EL1.25ISO	1.25	●	○			○		●		0.18	0.9	3.18
	11ER1.50ISO	11EL1.50ISO	1.5	●	○			○		●		0.22	1.0	3.18
	11ER1.75ISO	11EL1.75ISO	1.75	●	○			○		●		0.25	1.1	3.18
	11ER2.00ISO	11EL2.00ISO	2.0	●	○			○		●		0.29	1.0	3.18
	16ER0.50ISO	16EL0.50ISO	0.5	●	○			○		●		0.07	0.6	3.65
	16ER0.75ISO	16EL0.75ISO	0.75	●	○			○		●		0.11	0.6	3.65
	16ER1.00ISO	16EL1.00ISO	1.0	●	○			○		●		0.14	0.7	3.65
	16ER1.25ISO	16EL1.25ISO	1.25	●	○			○		●		0.18	0.9	3.65
	16ER1.50ISO	16EL1.50ISO	1.5	●	○			○		●		0.22	1.0	3.65
	16ER1.75ISO	16EL1.75ISO	1.75	●	○			○		●		0.25	1.2	3.65
	16ER2.00ISO	16EL2.00ISO	2	●	○			○		●		0.29	1.3	3.65
	16ER2.50ISO	16EL2.50ISO	2.5	●	○			○		●		0.36	1.5	3.65
	16ER3.00ISO	16EL3.00ISO	3.0	●	○			○		●		0.43	1.6	3.65
	16ER3.50ISO	16EL3.50ISO	3.5	●	○			○		●		0.51	1.6	3.65
	22ER3.00ISO	22EL3.00ISO	3.0	●	○			○		●		0.43	2.0	4.9
	22ER3.50ISO	22EL3.50ISO	3.5	●	○			○		●		0.51	2.0	4.9
	22ER4.00ISO	22EL4.00ISO	4.0	●	○			○		●		0.58	2.0	4.9
	22ER4.50ISO	22EL4.50ISO	4.5	●	○			○		●		0.65	2.2	4.9
	22ER5.00ISO	22EL5.00ISO	5.0	●	○			○		●		0.72	2.4	4.9
	22ER5.50ISO	22EL5.50ISO	5.5	●	○			○		●		0.79	2.5	4.9
	22ER6.00ISO	22EL6.00ISO	6.0	●	○			○		●		0.87	2.7	4.9
	27ER5.50ISO	27EL5.50ISO	5.5	●	○			○		●		0.79		6.4
	27ER6.00ISO	27EL6.00ISO	6.0	●	○			○		●		0.87		6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

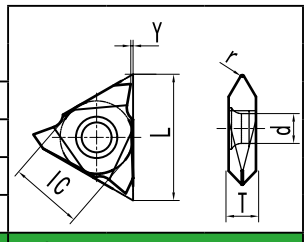
外螺纹刀片 - 立装型 External ISO Metric V-style

ISO 68-1
GB/T 192

型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16VER1.00ISO	–	1.0	●		○		○				0.07	0.7	3.65
	16VER1.50ISO	–	1.5	●		○		○				0.11	1.0	3.65
	16VER2.00ISO	–	2.0	●		○		○				0.14	1.3	3.65
	16VER2.50ISO	–	2.5	●		○		○				0.18	1.5	3.65
	16VER3.00ISO	–	3.0	●		○		○				0.22	1.6	3.65
	22VER4.00ISO	–	4.0	●		○		○				0.29	2.0	4.76
	22VER5.00ISO	–	5.0	●		○		○				0.36	2.4	4.76
	27VER6.00ISO	–	6.0	●		○		○				0.43	2.7	6.4
	27VER8.00ISO	–	8.0											8.7
	27VER10.0ISO	–	10.0											10.0

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

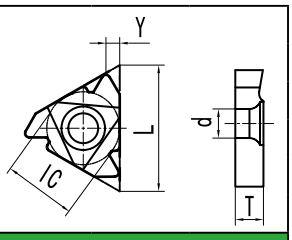
内螺纹刀片 Internal ISO Metric Threading Insert

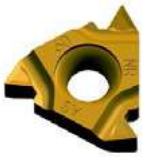
ISO 68-1
GB/T 192

型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
☺ 一般推荐 General recommendation

材质推荐 material recommended						
钢	P	☺	☺	☺		
不锈钢	M	☺	☺			
铸铁	K	☺	☺			
有色金属	N					☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR1.00ISO-M		1.0									0.07	0.7	3.18
	11NR1.50ISO-M		1.5									0.11	1.0	3.18
	11NR2.00ISO-M		2.0									0.14	1.0	3.18
	16NR1.00ISO-M		1.0	●		○		○				0.07	0.7	3.65
	16NR1.50ISO-M		1.5	●		○		○				0.11	1.0	3.65
	16NR2.00ISO-M		2.0	●		○		○				0.14	1.3	3.65
	16NR2.50ISO-M		2.5	●		○		○				0.18	1.5	3.65
	16NR3.00ISO-M		3.0	●		○		○				0.22	1.6	3.65
	22NR3.50ISO-M		3.5	●		○		○				0.25	2.0	4.9
	22NR4.00ISO-M		4.0	●		○		○				0.29	2.0	4.9
	22NR5.00ISO-M		5.0	●		○		○				0.36	2.4	4.9
	22NR6.00ISO-M		6.0	●		○		○				0.43	2.7	4.9
	06NR0.50ISO	06NL0.50ISO	0.5	●								0.04		2.38
	06NR0.75ISO	06NL0.75ISO	0.75	●								0.05		2.38
	06NR1.00ISO	06NL1.00ISO	1.0	●								0.07		2.38
	06NR1.25ISO	06NL1.25ISO	1.25	●								0.09		2.38
	06NR1.50ISO	06NL1.50ISO	1.5	●								0.11		2.38
	08NR1.75ISO	08NL1.75ISO	0.5	●	○			○		●		0.04		2.38
	08NR0.75ISO	08NL0.75ISO	0.75	●	○			○		●		0.05		2.38
	08NR1.00ISO	08NL1.00ISO	1.0	●	○			○		●		0.07		2.38
	08NR1.25ISO	08NL1.25ISO	1.25	●	○			○		●		0.09		2.38
	08NR1.50ISO	08NL1.50ISO	1.5	●	○			○		●		0.11		2.38
	08NR1.75ISO	08NL1.75ISO	1.75	●	○			○		●		0.13		2.38
	11NR0.50ISO	11NL0.50ISO	0.5	●	○			○		●		0.04	0.6	3.18
	11NR0.75ISO	11NL0.75ISO	0.75	●	○			○		●		0.05	0.6	3.18
	11NR1.00ISO	11NL1.00ISO	1.0	●	○			○		●		0.07	0.7	3.18
	11NR1.25ISO	11NL1.25ISO	1.25	●	○			○		●		0.09	0.9	3.18
	11NR1.50ISO	11NL1.50ISO	1.5	●	○			○		●		0.11	1.0	3.18
	11NR1.75ISO	11NL1.75ISO	1.75	●	○			○		●		0.13	1.1	3.18
	11NR2.00ISO	11NL2.00ISO	2.0	●	○			○		●		0.14	1.0	3.18
	11NR2.50ISO	11NL2.50ISO	2.5	●	○			○		●		0.18	1.0	3.18
	16NR0.50ISO	16NL0.50ISO	0.5	●	○			○		●		0.04	0.6	3.65
	16NR0.75ISO	16NL0.75ISO	0.75	●	○			○		●		0.05	0.6	3.65
	16NR1.00ISO	16NL1.00ISO	1	●	○			○		●		0.07	0.7	3.65
	16NR1.25ISO	16NL1.25ISO	1.25	●	○			○		●		0.09	0.9	3.65
	16NR1.50ISO	16NL1.50ISO	1.5	●	○			○		●		0.11	1.0	3.65
	16NR1.75ISO	16NL1.75ISO	1.75	●	○			○		●		0.13	1.2	3.65
	16NR2.00ISO	16NL2.00ISO	2	●	○			○		●		0.14	1.3	3.65
	16NR2.50ISO	16NL2.50ISO	2.5	●	○			○		●		0.18	1.5	3.65
	16NR3.00ISO	16NL3.00ISO	3.0	●	○			○		●		0.22	1.6	3.65
	16NR3.50ISO	16NL3.50ISO	3.5	●	○			○		●		0.25	1.6	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

接上页

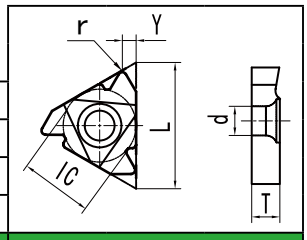
内螺纹刀片 Internal ISO Metric Threading Insert

ISO 68-1
GB/T 192

型号 Model	L (mm)	IC (mm)	d (mm)
08**	8	4.76	2.1
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	22NR3.00ISO	22NL3.00ISO	3.0	●	○	○		○		●		0.22	2.0	4.9
	22NR3.50ISO	22NL3.50ISO	3.5	●	○	○		○		●		0.25	2.0	4.9
	22NR4.00ISO	22NL4.00ISO	4.0	●	○	○		○		●		0.29	2.0	4.9
	22NR4.50ISO	22NL4.50ISO	4.5	●	○	○		○		●		0.32	2.2	4.9
	22NR5.00ISO	22NL5.00ISO	5.0	●	○			○		●		0.36	2.4	4.9
	22NR5.50ISO	22NL5.50ISO	5.5									0.4	2.5	4.9
	22NR6.00ISO	22NL6.00ISO	6.0									0.43	2.7	4.9
	27NR5.50ISO	27NL5.50ISO	5.5									0.4		6.4
	27NR6.00ISO	27NL6.00ISO	6.0									0.43		6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

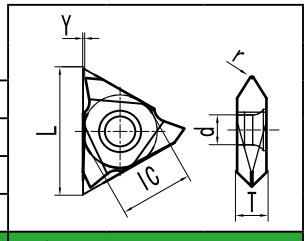
内螺纹刀片 - 立装型 Internal ISO Metric V-style

ISO 68-1
GB/T 192

型号 Model	L (mm)	IC (mm)	d (mm)
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16VNR1.00ISO	–	1.0	●		○		○				0.07		3.65
	16VNR1.50ISO	–	1.5	●		○		○				0.11		3.65
	16VNR2.00ISO	–	2.0	●		○		○				0.14		3.65
	16VNR2.50ISO	–	2.5	●		○		○				0.18		3.65
	16VNR3.00ISO	–	3.0	●		○		○				0.22		3.65
	22VNR4.00ISO	–	4.0	●		○		○				0.29		4.76
	22VNR5.00ISO	–	5.0	●		○		○				0.36		4.76
	27VNR6.00ISO	–	6.0	●		○		○				0.43		6.4
	27VNR8.00ISO	–	8.0											8.7
	27VNR10.0ISO	–	10.0											10.0

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

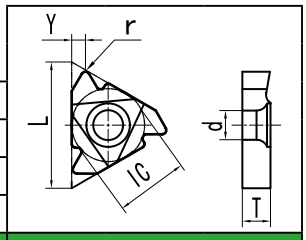
外螺纹刀片 External 60° American UN UNC UNF UNEF UNS

ISO 68
GB/T 20667~20670

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
☺ 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	☺	☺		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11ER32UN	11EL32UN	32									0.11	0.8	3.18
	11ER28UN	11EL28UN	28									0.13	0.8	3.18
	11ER24UN	11EL24UN	24									0.16	0.8	3.18
	11ER20UN	11EL20UN	20									0.18	0.8	3.18
	11ER18UN	11EL18UN	18									0.2	0.8	3.18
	11ER16UN	11EL16UN	16									0.23	1.0	3.18
	11ER14UN	11EL14UN	14									0.26	1.0	3.18
	11ER12UN	11EL12UN	12									0.3	1.1	3.18
	16ER32UN	16EL32UN	32									0.11	0.8	3.65
	16ER28UN	16EL28UN	28									0.13	0.8	3.65
	16ER24UN	16EL24UN	24	●	○			○		○		0.16	0.8	3.65
	16ER20UN	16EL20UN	20	●	○			○		○		0.18	0.8	3.65
	16ER18UN	16EL18UN	18	●	○			○		○		0.2	0.8	3.65
	16ER16UN	16EL16UN	16	●	○			○		○		0.23	1.0	3.65
	16ER14UN	16EL14UN	14	●	○			○		○		0.26	1.2	3.65
	16ER12UN	16EL12UN	12	●	○			○		○		0.3	1.2	3.65
	16ER11UN	16EL11UN	11									0.33	1.4	3.65
	16ER10UN	16EL10UN	10	●	○			○		○		0.36	1.4	3.65
	16ER9UN	16EL9UN	9									0.41	1.6	3.65
	16ER8UN	16EL8UN	8	●	○			○		○		0.46	1.6	3.65
	22ER7UN	22EL7UN	7									0.52	2.3	4.9
	22ER6UN	22EL6UN	6	○	○							0.61	2.3	4.9
	22ER5UN	22EL5UN	5									0.75	2.5	4.9
	22ER4.5UN	22EL4.5UN	4.5									0.83	2.6	4.9
	22ER4UN	22EL4UN	4	○	○			○				0.93	2.9	4.9
	27ER4.5UN	27EL4.5UN	4.5										2.6	6.4
	27ER4UN	27EL4UN	4										2.9	6.4
	27VER4UN	27VEL4UN	4										4.35	8.7
	27VER3UN	27VEL3UN	3										5.0	10.0

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

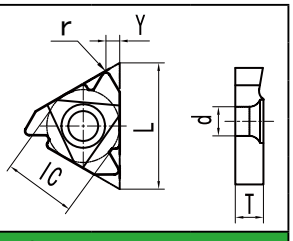
内螺纹刀片 Internal 60° American UN UNC UNF UNEF UNS

ISO 68
GB/T 20667~20670

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
☹ 一般推荐 General recommendation

材质推荐 material recommended			DM215	DM415	DP220	DK110
钢	P		☺	☺	☺	
不锈钢	M		☺	☺		
铸铁	K		☹	☹		
有色金属	N					☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR32UN	11NL32UN	32	○				○		○		0.05	0.8	3.18
	11NR28UN	11NL28UN	28	○				○		○		0.07	0.8	3.18
	11NR24UN	11NL24UN	24	●				○		○		0.08	0.8	3.18
	11NR20UN	11NL20UN	20	●				○		○		0.09	0.8	3.18
	11NR18UN	11NL18UN	18	●				○		○		0.1	0.8	3.18
	11NR16UN	11NL16UN	16	●				○		○		0.11	1.0	3.18
	11NR14UN	11NL14UN	14	●				○		○		0.13	1.0	3.18
	11NR12UN	11NL12UN	12	●				○		○		0.15	1.1	3.18
	16NR32UN	16NL32UN	32									0.05	0.8	3.65
	16NR28UN	16NL28UN	28									0.07	0.8	3.65
	16NR24UN	16NL24UN	24	●				○		○		0.08	0.8	3.65
	16NR20UN	16NL20UN	20	●				○		○		0.09	0.8	3.65
	16NR18UN	16NL18UN	18	●				○		○		0.1	0.8	3.65
	16NR16UN	16NL16UN	16	●				○		○		0.11	1.0	3.65
	16NR14UN	16NL14UN	14	●				○		○		0.13	1.2	3.65
	16NR12UN	16NL12UN	12	●				○		○		0.15	1.2	3.65
	16NR11UN	16NL11UN	11									0.16	1.4	3.65
	16NR10UN	16NL10UN	10	●				○		○		0.18	1.4	3.65
	16NR9UN	16NL9UN	9									0.2	1.4	3.65
	16NR8UN	16NL8UN	8	●				○		○		0.23	1.4	3.65
	22NR7UN	22NL7UN	7									0.26	2.3	4.9
	22NR6UN	22NL6UN	6									0.32	2.3	4.9
	22NR5UN	22NL5UN	5									0.38	2.5	4.9
	22NR4.5UN	22NL4.5UN	4.5									0.41	2.5	4.9
	22NR4UN	22NL4UN	4									0.46	2.5	4.9
	27NR4.5UN	27NL4.5UN	4.5										2.5	6.4
	27NR4UN	27NL4UN	4										2.5	6.4
	27VNR4UN	27VNL4UN	4											8.7
	27VNR3UN	27VNL3UN	3											10.0

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

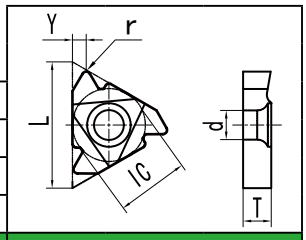
外螺纹刀片 55° External Whitworth Full Profile

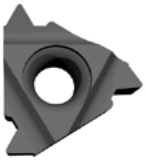
BS 84
GB/T 7307

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
☺ 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	☺	☺		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16ER14W-M		14	●		○		○				0.25	1.1	3.65
	16ER11W-M		11	●		○		○				0.32	1.4	3.65
	11ER28W	11EL28W	28					○		○		0.13	0.8	3.18
	11ER26W	11EL26W	26					○		○		0.14	0.8	3.18
	11ER24W	11EL24W	24					○		○		0.15	0.8	3.18
	11ER20W	11EL20W	20					○		○		0.18	1.0	3.18
	11ER19W	11EL19W	19					○		○		0.19	1.0	3.18
	11ER18W	11EL18W	18					○		○		0.2	1.0	3.18
	11ER16W	11EL16W	16					○		○		0.22	1.0	3.18
	11ER14W	11EL14W	14					○		○		0.25	1.0	3.18
	16ER28W	16EL28W	28	●				○		○		0.13	0.9	3.65
	16ER26W	16EL26W	26									0.14	0.9	3.65
	16ER24W	16EL24W	24	●				○		○		0.15	0.9	3.65
	16ER20W	16EL20W	20	●				○		○		0.18	0.9	3.65
	16ER19W	16EL19W	19	●				○		○		0.19	0.9	3.65
	16ER18W	16EL18W	18	●				○		○		0.2	0.9	3.65
	16ER16W	16EL16W	16	●				○		○		0.22	0.9	3.65
	16ER14W	16EL14W	14	●				○		○		0.25	1.1	3.65
	16ER12W	16EL12W	12	●				○		○		0.29	1.4	3.65
	16ER11W	16EL11W	11	●				○		○		0.32	1.4	3.65
	16ER10W	16EL10W	10	●				○		○		0.35	1.4	3.65
	16ER9W	16EL9W	9	●				○		○		0.39	1.7	3.65
	16ER8W	16EL8W	8	●				○		○		0.44	1.7	3.65
	16ER7W	16EL7W	7									0.5	1.7	3.65
	22ER7W	22EL7W	7									0.5	2.4	3.65
	22ER6W	22EL6W	6	●				○		○		0.59	2.4	4.9
	22ER5W	22EL5W	5	●				○		○		0.7	2.6	4.9
	22ER4.5W	22EL4.5W	4.5									0.79	2.7	4.9
	22ER4W	22EL4W	4	●				○		○		0.89	2.7	4.9
	27ER4.5W	27EL4.5W	4.5									0.79		6.4
	27ER4W	27EL4W	4									0.89		6.4
	27VER4W	27VEL4W	4											
	27VER3W	27VEL3W	3											
	27VER2.5W	27VEL2.5W	2.5											

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

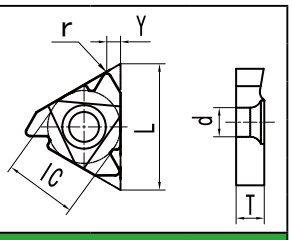
内螺纹刀片 55° Internal Whitworth Full Profile

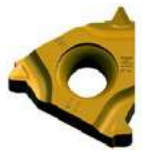
BS 84
GB/T 7307

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16NR14W-M		14	●		○		○				0.25	0.9	3.65
	16NR11W-M		11	●		○		○				0.32	1.1	3.65
	11NR28W	11NL28W	28	○				○		○		0.13	0.8	3.18
	11NR26W	11NL26W	26	○				○		○		0.14	0.8	3.18
	11NR24W	11NL24W	24	○				○		○		0.15	0.8	3.18
	11NR20W	11NL20W	20	○				○		○		0.18	1.0	3.18
	11NR19W	11NL19W	19	●				○		○		0.19	1.0	3.18
	11NR18W	11NL18W	18	○				○		○		0.2	1.0	3.18
	11NR16W	11NL16W	16	○				○		○		0.22	1.0	3.18
	11NR14W	11NL14W	14	●				○		○		0.25	1.0	3.18
	16NR28W	16NL28W	28	●				○		○		0.13	0.9	3.65
	16NR26W	16NL26W	26					○		○		0.14	0.9	3.65
	16NR24W	16NL24W	24	●				○		○		0.15	0.9	3.65
	16NR20W	16NL20W	20	●				○		○		0.18	0.9	3.65
	16NR19W	16NL19W	19	●				○		○		0.19	0.9	3.65
	16NR18W	16NL18W	18	●				○		○		0.2	0.9	3.65
	16NR16W	16NL16W	16	●				○		○		0.22	0.9	3.65
	16NR14W	16NL14W	14	●				○		○		0.25	1.1	3.65
	16NR12W	16NL12W	12	●				○		○		0.29	1.4	3.65
	16NR11W	16NL11W	11	●				○		○		0.32	1.4	3.65
	16NR10W	16NL10W	10	●				○		○		0.35	1.4	3.65
	16NR9W	16NL9W	9	●				○		○		0.39	1.7	3.65
	16NR8W	16NL8W	8	●				○		○		0.44	1.7	3.65
	16NR7W	16NL7W	7									0.51	1.7	3.65
	22NR7W	22NL7W	7									0.51	2.4	3.65
	22NR6W	22NL6W	6	●				○		○		0.59	2.4	4.9
	22NR5W	22NL5W	5	●				○		○		0.71	2.6	4.9
	22NR4.5W	22NL4.5W	4.5									0.79	2.7	4.9
	22NR4W	22NL4W	4	●				○		○		0.89	2.7	4.9
	27NR4.5W	27NL4.5W	4.5									0.79		6.4
	27NR4W	27NL4W	4									0.89		6.4
	27VNR4W	27VNL4W	4											
	27VNR3W	27VNL3W	3											
	27VNR2.5W	27VNL2.5W	2.5											

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

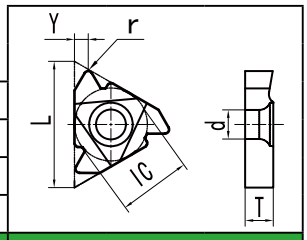
外螺纹刀片 External NPT-60°

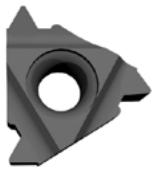
ASME B.20.1
GB/T 12716

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended						
钢	P	☺	☺	☺		
不锈钢	M	☺	☺			
铸铁	K	😐	😐			
有色金属	N					☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11ER27NPT	11EL27NPT	27	●	○			○		○			1.0	3.18
	11ER18NPT	11EL18NPT	18	●	○			○		○		0.03	1.0	3.18
	11ER14NPT	11EL14NPT	14	●	○			○		○		0.04	1.1	3.18
	16ER27NPT	16EL27NPT	27	●	○			○		○			1.0	3.65
	16ER18NPT	16EL18NPT	18	●	○			○		○		0.03	1.0	3.65
	16ER14NPT	16EL14NPT	14	●	○			○		○		0.04	1.3	3.65
	16ER11.5NPT	16EL11.5NPT	11.5	●	○			○		○		0.05	1.5	4.9
	16ER8NPT	16EL8NPT	8	●	○			○		○		0.07	1.8	4.9

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

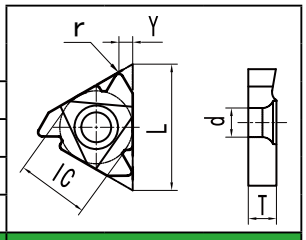
内螺纹刀片 Internal NPT-60°

ASME B.20.1
GB/T 12716

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR27NPT	11NL27NPT	27	●				○		○			1.0	3.18
	11NR18NPT	11NL18NPT	18	●	○			○		○		0.03	1.0	3.18
	11NR14NPT	11NL14NPT	14	●	○			○		○		0.04	1.1	3.18
	16NR27NPT	16NL27NPT	27	●	○			○		○			1.0	3.65
	16NR18NPT	16NL18NPT	18	●	○			○		○		0.03	1.0	3.65
	16NR14NPT	16NL14NPT	14	●	○			○		○		0.04	1.3	3.65
	16NR11.5NPT	16NL11.5NPT	11.5	●	○			○		○		0.05	1.5	3.65
	16NR8NPT	16NL8NPT	8	●	○			○		○		0.07	1.8	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

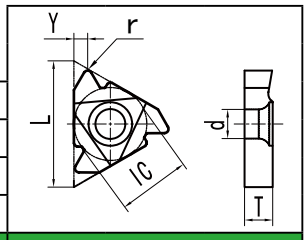
外螺纹刀片 External BSPT-55°

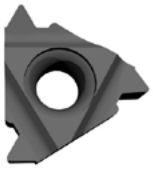
BS 21
GB/T 7306.1~7306.2

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended						
钢	P	☺	☺	☺		
不锈钢	M	☺	☺			
铸铁	K	😐	😐			
有色金属	N				☺	



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11ER28BSPT	11EL28BSPT	28	●	○			○		○		0.13	0.8	3.18
	11ER19BSPT	11EL19BSPT	19	●	○			○		○		0.19	1.0	3.18
	11ER14BSPT	11EL14BSPT	14	●	○			○		○		0.25	1.0	3.18
	16ER28BSPT	16EL28BSPT	28	●	○			○		○		0.13	1.0	3.65
	16ER19BSPT	16EL19BSPT	19	●	○			○		○		0.19	1.0	3.65
	16ER14BSPT	16EL14BSPT	14	●	○			○		○		0.25	1.0	3.65
	16ER11BSPT	16EL11BSPT	11	●	○			○		○		0.32	1.0	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

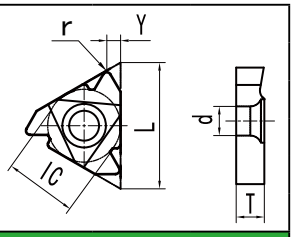
内螺纹刀片 Internal BSPT-55°

BS 21
GB/T 7306.1~7306.2

型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.535	4.0

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended						
钢	P	☺	☺	☺		
不锈钢	M	☺	☺			
铸铁	K	😐	😐			
有色金属	N					☺

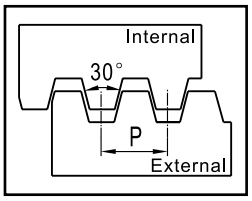


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR28BSPT	11NL28BSPT	28	●				○		○		0.13	0.8	3.18
	11NR19BSPT	11NL19BSPT	19	●	○			○		○		0.19	1.0	3.18
	11NR14BSPT	11NL14BSPT	14	●	○			○		○		0.25	1.0	3.18
	16NR28BSPT	16NL28BSPT	28	●	○			○		○		0.13	1.0	3.65
	16NR19BSPT	16NL19BSPT	19	●	○			○		○		0.19	1.0	3.65
	16NR14BSPT	16NL14BSPT	14	●	○			○		○		0.25	1.0	3.65
	16NR11BSPT	16NL11BSPT	11	●	○			○		○		0.32	1.0	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀片 External Trapez DIN103

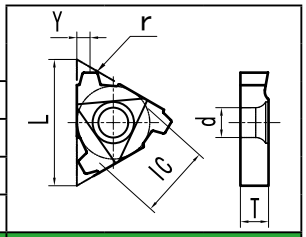
ISO 2901~2904
GB/T 5796;GB/T 12359

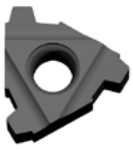
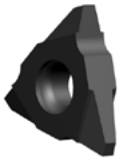


型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended					
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

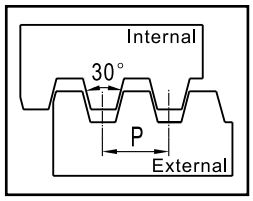


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 mm	DM215		DM415		DP220		DK110		尺寸 Dimensions (mm)		
			mm	R	L	R	L	R	L	R	L	r	Y	T
	16ER1.5TR	16EL1.5TR	1.50	●				○		○		0.1	1.1	3.65
	16ER2.0TR	16EL2.0TR	2.00	●				○		○		0.1	1.3	3.65
	16ER3.0TR	16EL3.0TR	3.00	●				○		○		0.1	1.5	3.65
	22ER4.0TR	22EL4.0TR	4.00	●				○				0.1	1.9	4.9
	22ER5.0TR	22EL5.0TR	5.00	●				○				0.1	2.2	4.9
	22ER6.0TR	22EL6.0TR	6.00	●				○				0.25	2.3	4.9
	27ER6.0TR	27EL6.0TR	6.00	●				○				0.25	2.5	6.4
	27ER7.0TR	27EL7.0TR	7.00	●				○				0.3	2.7	6.4
	22VER4.0TR	22VEL4.0TR	4.00	●				○				0.1		4.76
	22VER5.0TR	22VEL5.0TR	5.00	●				○				0.1		4.76
	22VER6.0TR	22VEL6.0TR	6.00	●				○				0.25		4.76
	27VER6.0TR	27VEL6.0TR	6.00	●				○				0.25		6.4
	27VER7.0TR	27VEL7.0TR	7.00	●				○				0.25		6.4
	27VER8.0TR	27VEL8.0TR	8.00	●				○				0.25		6.4
	27VER9.0TR	27VEL9.0TR	9.00	●				○				0.25		6.4
	27VER10TR	27VEL10TR	10.00	●								0.3		8.7
	27VER12TR	27VEL12TR	12.00	●								0.5		8.7
	22UER7.0TR	22UEL7.0TR	7.00	○								0.3		4.9
	27UER8.0TR		8.0	●								0.25		6.4
	27UER10TR		10.0									0.3		6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

内螺纹刀片 Internal Trapez DIN103

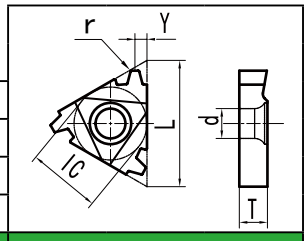
ISO 2901~2904
GB/T 5796;GB/T 12359



型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			DM215	DM415	DP220	DK110
	钢	P	☺	☺	☺	
	不锈钢	M	☺	☺		
	铸铁	K	😐	😐		
	有色金属	N				☺

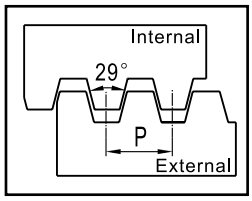


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 mm	DM215		DM415		DP220		DK110		尺寸 Dimensions (mm)		
			mm	R	L	R	L	R	L	R	L	r	Y	T
	11NR1.5TR	11NL1.5TR	1.5	●				○		○		0.1		3.18
	11NR2.0TR	11NL2.0TR	2.0	●				○		○		0.1		3.18
	16NR1.5TR	16NL1.5TR	1.50	●				○		○		0.1	1.1	3.65
	16NR2.0TR	16NL2.0TR	2.00	●				○		○		0.1	1.3	3.65
	16NR3.0TR	16NL3.0TR	3.00	●				○		○		0.1	1.5	3.65
	22NR4.0TR	22NL4.0TR	4.00	●				○		○		0.1	1.9	4.9
	22NR5.0TR	22NL5.0TR	5.00	●				○		○		0.1	2.2	4.9
	22NR6.0TR	22NL6.0TR	6.00	●				○		○		0.25	2.3	4.9
	27NR6.0TR	27NL6.0TR	6.00	●				○		○		0.25	2.5	6.4
	27NR7.0TR	27NL7.0TR	7.00	●				○		○		0.3	2.7	6.4
	22VNR4.0TR	22VNL4.0TR	4.00	●				○		○		0.1		4.76
	22VNR5.0TR	22VNL5.0TR	5.00	●				○		○		0.1		4.76
	22VNR6.0TR	22VNL6.0TR	6.00	●				○		○		0.25		4.76
	27VNR6.0TR	27VNL6.0TR	6.00	●				○		○		0.25		6.4
	27VNR7.0TR	27VNL7.0TR	7.00	●				○		○		0.25		6.4
	27VNR8.0TR	27VNL8.0TR	8.00	●				○		○		0.25		6.4
	27VNR9.0TR	27VNL9.0TR	9.00	●				○		○		0.25		6.4
	27VNR10TR	27VNL10TR	10.00	●								0.3		8.7
	27VNR12TR	27VNL12TR	12.00	●								0.5		8.7
	22UNR7.0TR	22UNL7.0TR	7.00	○								0.3		4.9
	27UNR8.0TR		8.0									0.25		6.4
	27UNR10.0TR		10.0									0.3		6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀片 External American ACME

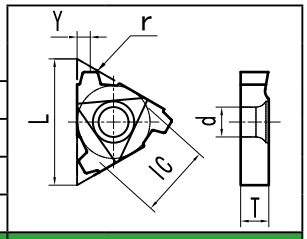
ASME B1.5
BS 1104

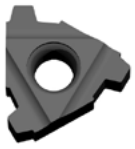
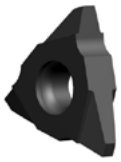


型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

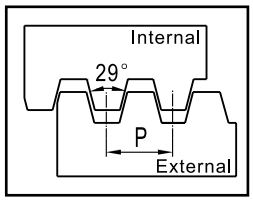


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16ER16ACME	16EL16ACME	16	●	○			○		○		0.08	1.1	3.65
	16ER14ACME	16EL14ACME	14	●	○			○		○		0.08	1.2	3.65
	16ER12ACME	16EL12ACME	12	●	○			○		○		0.1	1.2	3.65
	16ER10ACME	16EL10ACME	10	●	○			○		○		0.12	1.4	3.65
	16ER8ACME	16EL8ACME	8	●	○			○		○		0.12	1.5	3.65
	16ER6ACME	16EL6ACME	6	●	○			○		○		0.2	1.5	3.65
	22ER6ACME	22EL6ACME	6	●	○			○		○		0.2	2.1	4.9
	22ER5ACME	22EL5ACME	5	●	○			○		○		0.25	2.1	4.9
	22ER4ACME	22EL4ACME	4	●	○			○		○		0.3	2.3	4.9
	27ER4ACME	27EL4ACME	4	●	○			○		○		0.3	2.1	6.4
	22VER6ACME	22VEL6ACME	6	●	○			○		○		0.2		4.76
	22VER5ACME	22VEL5ACME	5	●								0.25		4.76
	22VER4ACME	22VEL4ACME	4	●								0.3		4.76
	27VER3.5ACME	27VEL3.5ACME	3.5									0.3	2.4	6.4
	27VER3ACME	27VEL3ACME	3	●								0.3	2.4	6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

内螺纹刀片 Internal American ACME

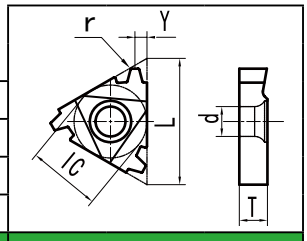
ASME B1.5
BS 1104



型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

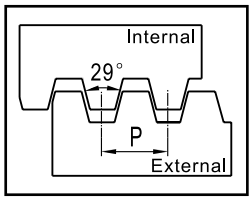


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR16ACME	11NL16ACME	16	●	○			○		○		0.06		3.18
	11NR14ACME	11NL14ACME	14	●	○			○		○		0.08		3.18
	16NR16ACME	16NL16ACME	16	●	○			○		○		0.08	1.1	3.65
	16NR14ACME	16NL14ACME	14	●	○			○		○		0.08	1.2	3.65
	16NR12ACME	16NL12ACME	12	●	○			○		○		0.1	1.2	3.65
	16NR10ACME	16NL10ACME	10	●	○			○		○		0.12	1.4	3.65
	16NR8ACME	16NL8ACME	8	●	○			○		○		0.12	1.5	3.65
	16NR6ACME	16NL6ACME	6	●	○			○		○		0.2	1.5	3.65
	22NR6ACME	22NL6ACME	6	●	○			○		○		0.2	2.1	4.9
	22NR5ACME	22NL5ACME	5	●	○			○		○		0.25	2.1	4.9
	22NR4ACME	22NL4ACME	4	●	○			○		○		0.3	2.3	4.9
	27NR4ACME	27NL4ACME	4	●	○			○		○		0.3	2.1	6.4
	22VNR6ACME	22VNL6ACME	6	●	○			○		○		0.2		4.76
	22VNR5ACME	22VNL5ACME	5	●								0.25		4.76
	22VNR4ACME	22VNL4ACME	4	●								0.3		4.76
	27VNR3.5ACME	27VNL3.5ACME	3.5									0.3	2.4	6.4
	27VNR3ACME	27VNL3ACME	3	●								0.3	2.4	6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀片 External American Stub ACME

ANSI B1.8

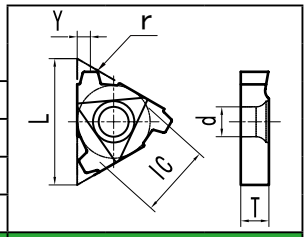


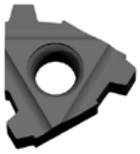
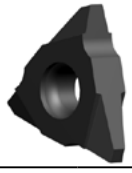
型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

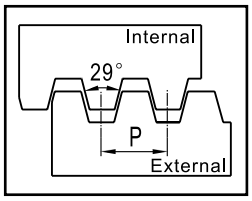


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16ER16STACME	16EL16STACME	16	●	○			○		○		0.08	1.0	3.65
	16ER14STACME	16EL14STACME	14	●	○			○		○		0.08	1.1	3.65
	16ER12STACME	16EL12STACME	12	●	○			○		○		0.1	1.2	3.65
	16ER10STACME	16EL10STACME	10	●	○			○		○		0.1	1.3	3.65
	16ER8STACME	16EL8STACME	8	●	○			○		○		0.16	1.5	3.65
	16ER6STACME	16EL6STACME	6	●	○			○		○		0.2	1.5	3.65
	22ER6STACME	22EL6STACME	6	●	○			○		○		0.2	1.8	4.9
	22ER5STACME	22EL5STACME	5	●	○			○		○		0.25	2.3	4.9
	22ER4STACME	22EL4STACME	4	●	○			○		○		0.3	2.3	4.9
	27ER4STACME	27EL4STACME	4	●	○			○		○		0.3	2.5	6.4
	27VER3STACME	27VEL3STACME	3	●	○			○		○		0.3		6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

内螺纹刀片 Internal American Stub ACME

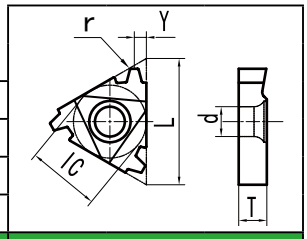
ANSI B1.8

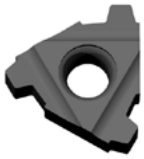


型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

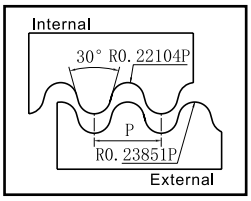


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR16STACME	11NL16STACME	16	●				○		○		0.06		3.18
	11NR14STACME	11NL14STACME	14	●	○			○		○		0.08		3.18
	16NR16STACME	16NL16STACME	16	●	○			○		○		0.06	1.0	3.65
	16NR14STACME	16NL14STACME	14	●	○			○		○		0.08	1.1	3.65
	16NR12STACME	16NL12STACME	12	●	○			○		○		0.1	1.2	3.65
	16NR10STACME	16NL10STACME	10	●	○			○		○		0.1	1.3	3.65
	16NR8STACME	16NL8STACME	8	●	○			○		○		0.16	1.5	3.65
	16NR6STACME	16NL6STACME	6	●	○			○		○		0.2	1.5	3.65
	22NR6STACME	22NL6STACME	6	●	○			○		○		0.2	1.8	4.9
	22NR5STACME	22NL5STACME	5	●	○			○		○		0.25	2.3	4.9
	22NR4STACME	22NL4STACME	4	●	○			○		○		0.3	2.3	4.9
	27NR4STACME	27NL4STACME	4	●	○			○		○		0.3	2.5	6.4
	27VNR3STACME	27VNL3STACME	3	●	○			○		○		0.3		6.4

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀片 External RD-DIN405

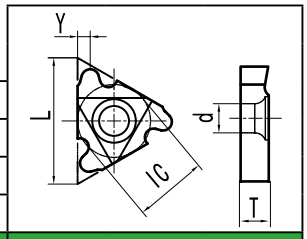
DIN405 T1~T2



型号 Model	L (mm)	IC (mm)	d (mm)
16**	16	9.525	4.0
22**	22	12.7	5.1

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation



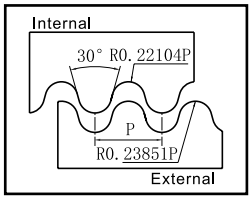
材质推荐 material recommended						
钢	P	☺	☺	☺		
不锈钢	M	☺	☺			
铸铁	K	😐	😐			
有色金属	N				☺	

刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch	DM215		DM415		DP220		DK110		尺寸 Dimensions (mm)		
			tpi	R	L	R	L	R	L	R	L	r	Y	T
	16ER10RD	16EL10RD	10	●								0.61	1.2	3.65
	16ER8RD	16EL8RD	8	●								0.76	1.3	3.65
	16ER6RD	16EL6RD	6	●								1.01	1.7	3.65
	22ER6RD	22EL6RD	6	●								1.01	2.0	4.9
	22ER5RD	22EL5RD	5	●								1.21	2.0	4.9
	22ER4RD	22EL4RD	4	●								1.51	2.3	4.9

● 常备库存（主推） Standing stock ◯ 非常备库存 Extraordinary stock

内螺纹刀片 Internal RD-DIN405

DIN405 T1~T2

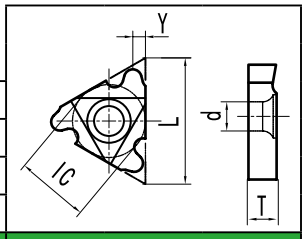


型号 Model	L (mm)	IC (mm)	d (mm)
16**	16	9.525	4.0
22**	22	12.7	5.1

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

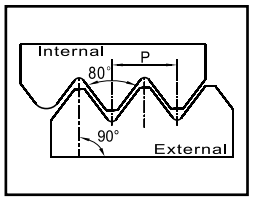


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16NR10RD	16NL10RD	10	●								0.56	1.2	3.65
	16NR8RD	16NL8RD	8	●								0.7	1.3	3.65
	16NR6RD	16NL6RD	6	●								0.94	1.7	3.65
	22NR6RD	22NL6RD	6	●								0.94	2.0	4.9
	22NR5RD	22NL5RD	5	●								1.12	2.0	4.9
	22NR4RD	22NL4RD	4	●								1.4	2.3	4.9

● 常备库存（主推） Standing stock ◯ 非常备库存 Extraordinary stock

外螺纹刀片 External Pg DIN40430

DIN40430

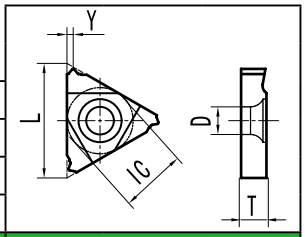


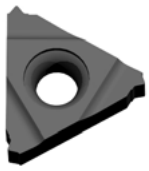
型号 Model	L (mm)	IC (mm)	d (mm)
16**	16	9.525	4.0
22**	22	12.7	5.1

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			DM215	DM415	DP220	DK110
钢	P		☺	☺	☺	
不锈钢	M		☺	☺		
铸铁	K		😐	😐		
有色金属	N					☺

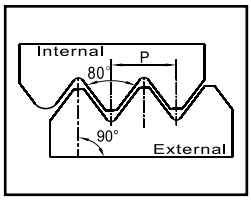


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11ER20Pg	11EL20Pg	20	○				○					0.9	3.18
	11ER18Pg	11EL18Pg	18	○				○					1	3.18
	11ER16Pg	11EL16Pg	16	●				○					1.1	3.18
	16ER20Pg	16EL20Pg	20	○				○					0.9	3.65
	16ER18Pg	16EL18Pg	18	●				○					1	3.65
	16ER16Pg	16EL16Pg	16	●				○					1.1	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

内螺纹刀片 Internal Pg DIN40430

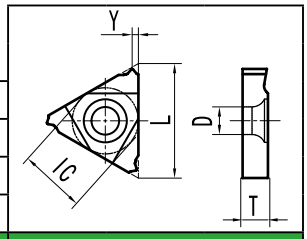
DIN40430

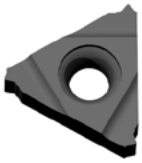


型号 Model	L (mm)	IC (mm)	d (mm)
16**	16	9.525	4.0
22**	22	12.7	5.1

☺ 良好推荐 ☺ 一般推荐

材质推荐 material recommended			DM215	DM415	DP220	DK110
钢	P		☺	☺	☺	
不锈钢	M		☺	☺		
铸铁	K		☺	☺		
有色金属	N					☺

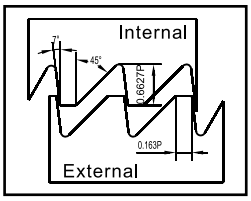


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR20Pg	11NL20Pg	20	○				○					0.9	3.18
	11NR18Pg	11NL18Pg	18	○				○					1.0	3.18
	11NR16Pg	11NL16Pg	16	●				○					1.1	3.18
	16NR20Pg	16NL20Pg	20	○				○					0.9	3.65
	16NR18Pg	16NL18Pg	18	●				○					1.0	3.65
	16NR16Pg	16NL16Pg	16	●				○					1.1	3.65

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀片 External American Buttress

ANSI/ASME B1.9

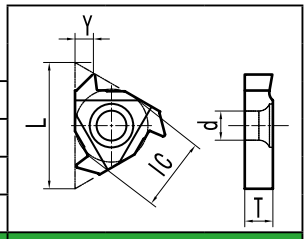


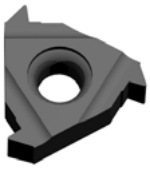
型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended					
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

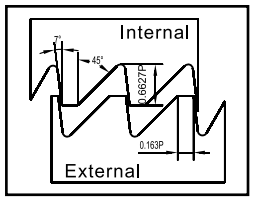


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch	DM215		DM415		DP220		DK110		尺寸 Dimensions (mm)		
			tpi	R	L	R	L	R	L	R	L	r	Y	T
	11ER20ABUT	11EL20ABUT	20	○				○					0.9	3.18
	11ER16ABUT	11EL16ABUT	16	○				○					0.9	3.18
	16ER20ABUT	16EL20ABUT	20	○				○					0.9	3.65
	16ER16ABUT	16EL16ABUT	16	●				○					0.9	3.65
	16ER12ABUT	16EL12ABUT	12	●				○					1.0	3.65
	16ER10ABUT	16EL10ABUT	10	●				○					1.2	3.65
	22ER8ABUT	22EL8ABUT	8	○				○					1.3	4.9
	22ER6ABUT	22EL6ABUT	6	○				○					1.5	4.9

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

内螺纹刀片 Internal American Buttress

ANSI/ASME B1.9

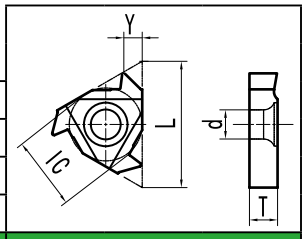


型号 Model	L (mm)	IC (mm)	d (mm)
11**	11	6.35	3.0
16**	16	9.525	4.0
22**	22	12.7	5.1

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			DM215	DM415	DP220	DK110
钢	P		☺	☺	☺	
不锈钢	M		☺	☺		
铸铁	K		😐	😐		
有色金属	N					☺

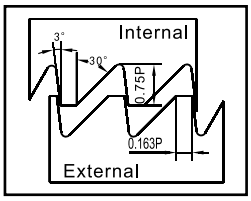


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch tpi	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	11NR20ABUT	11NL20ABUT	20	○				○					0.9	3.18
	11NR16ABUT	11NL16ABUT	16	○				○					0.9	3.18
	16NR20ABUT	16NL20ABUT	20	○				○					0.9	3.65
	16NR16ABUT	16NL16ABUT	16	●				○					0.9	3.65
	16NR12ABUT	16NL12ABUT	12	●				○					1.0	3.65
	16NR10ABUT	16NL10ABUT	10	●				○					1.2	3.65
	22NR8ABUT	22NL8ABUT	8	○				○					1.3	4.9
	22NR6ABUT	22NL6ABUT	6	○				○					1.5	4.9

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀片 External DIN513

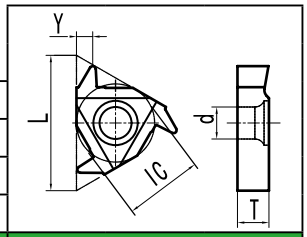
DIN 513
GB/T 13576
GOST 10177



型号 Model	L (mm)	IC (mm)	d (mm)
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

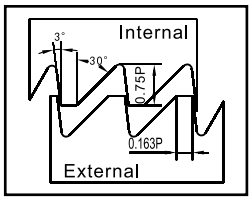


刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16ER2.0SAGE	16EL2.0SAGE	2.0	●				○				0.25	1.3	3.65
	22ER3.0SAGE	22EL3.0SAGE	3.0	○				○				0.37	1.9	4.9
	22ER4.0SAGE	22EL4.0SAGE	4.0	●				○				0.5	2.4	4.9
	27ER5.0SAGE	27EL5.0SAGE	5.0	○				○				0.62	3.3	6.4
	22UER5.0SAGE	22UEL5.0SAGE	5.0	○				○				0.62	11	4.9
	22UER6.0SAGE	22UEL6.0SAGE	6.0	○				○				0.75	11	4.9
	22VER2.0SAGE	22VEL2.0SAGE	2.0	○				○				0.25	–	4.9
	22VER3.0SAGE	22VEL3.0SAGE	3.0	○				○				0.37	–	4.9
	22VER4.0SAGE	22VEL4.0SAGE	4.0	○				○				0.5	–	4.9
	27VER5.0SAGE	27VEL5.0SAGE	5.0	○				○				0.62	–	6.4
	27VER6.0SAGE	27VEL5.0SAGE	6.0	●				○				0.75	2.0	6.4
	27VER7.0SAGE	27VEL7.0SAGE	7.0	●				○				0.87	2.5	6.4
	27VER8.0SAGE	27VEL8.0SAGE	8.0	○				○				0.99	3.0	8.7

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

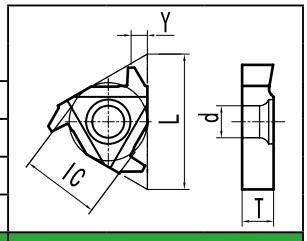
内螺纹刀片 Internal DIN513

DIN 513
GB/T 13576
GOST 10177



型号 Model	L (mm)	IC (mm)	d (mm)
16**	16	9.525	4.0
22**	22	12.7	5.1
27**	27	15.875	6.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation



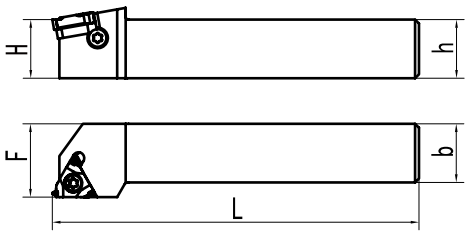
材质推荐 material recommended		DM215	DM415	DP220	DK110
钢	P	☺	☺	☺	
不锈钢	M	☺	☺		
铸铁	K	😐	😐		
有色金属	N				☺

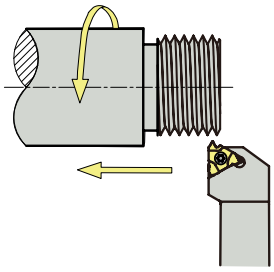
刀片 Insert	内螺纹刀片 Internal	外螺纹刀片 External	螺距 pitch mm	DM215 R	DM215 L	DM415 R	DM415 L	DP220 R	DP220 L	DK110 R	DK110 L	尺寸 Dimensions (mm) r	Y	T
	16NR2.0SAGE	16NL2.0SAGE	2.0	●				○				0.08	1.3	3.65
	22NR3.0SAGE	22NL3.0SAGE	3.0	○				○				0.1	1.9	4.9
	22NR4.0SAGE	22NL4.0SAGE	4.0	●				○				0.1	2.4	4.9
	27NR5.0SAGE	27NL5.0SAGE	5.0	○				○				0.1	3.3	6.4
	22UNR5.0SAGE	22UNL5.0SAGE	5.0	○				○				0.1	11	4.9
	22UNR6.0SAGE	22UNL6.0SAGE	6.0	○				○				0.2	11	4.9
	22VNR2.0SAGE	22VNL2.0SAGE	2.0	○				○				0.08	–	4.9
	22VNR3.0SAGE	22VNL3.0SAGE	3.0	●				○				0.1	–	4.9
	22VNR4.0SAGE	22VNL4.0SAGE	4.0	○				○				0.1	–	4.9
	27VNR5.0SAGE	27VNL5.0SAGE	5.0	○				○				0.1	–	6.4
	27VNR6.0SAGE	27VNL5.0SAGE	6.0	●				○				0.2	2.0	6.4
	27VNR7.0SAGE	27VNL7.0SAGE	7.0	●				○				0.2	2.5	6.4
	27VNR8.0SAGE	27VNL8.0SAGE	8.0	○				○				0.2	3.0	8.7

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

外螺纹刀杆平装型 – 偏头 External Threading Tool Holder

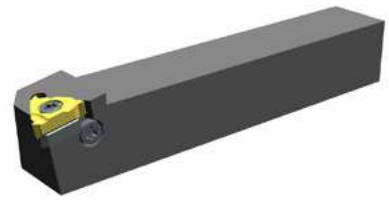
图示为右手刀具

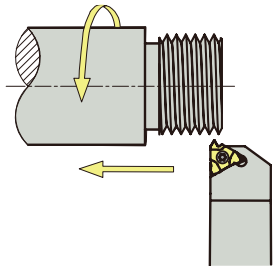




刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key	刀垫 Anvil	侧面螺钉 Anvil Screw	扳手 Hex Wrench
			h	b	H	F	L					
SER	1212F16	16ER**	12	12	12	16	80	L60M3.5*12	T-15	–	–	–
	1616H16		16	16	16	20	100	L60M3.5*12	T-15	–	–	–
	2020K16		20	20	20	25	125	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	2525M16		25	25	25	32	150	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	3225P16		32	32	32	32	170	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	3232P16		32	32	32	40	170	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	2020K22	22ER**	20	20	20	27	125	L60M4.5*14	T-20	EGM-22	MQ040080	S2.5
	2525M22		25	25	25	32	150	L60M4.5*14	T-20	EGM-22	MQ040080	S2.5
	3225P22		32	25	32	32	170	L60M4.5*14	T-20	EGM-22	MQ040080	S2.5
	3232P22		32	32	32	40	170	L60M4.5*14	T-20	EGM-22	MQ040080	S2.5
	4040R22		40	40	40	50	200	L60M4.5*14	T-20	EGM-22	MQ040080	S2.5
	2525M27	27ER**	25	25	25	32	150	L60M6*16	T-20	EGM-27	MQ040080	S2.5
	3232P27		32	32	32	32	170	L60M6*16	T-20	EGM-27	MQ040080	S2.5
	4040R27		40	40	40	40	200	L60M6*16	T-20	EGM-27	MQ040080	S2.5
	5050S27		50	50	50	50	250	L60M6*16	T-20	EGM-27	MQ040080	S2.5
SEL	1212F16	16EL**	12	12	12	16	80	L60M3.5*12	T-15	–	–	–
	1616H16		16	16	16	20	100	L60M3.5*12	T-15	–	–	–
	2020K16		20	20	20	25	125	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	2525M16		25	25	25	32	150	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	3225P16		32	25	32	32	170	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	3232P16		32	32	32	40	170	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	2020K22	22EL**	20	20	20	27	125	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	2525M22		25	25	25	32	150	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	3225P22		32	25	32	32	170	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	3232R22		32	32	32	40	200	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	4040R22		40	40	40	50	200	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	2525M27	27EL**	25	25	25	32	150	L60M6*16	T-20	NGM-27	MQ040080	S2.5
	3232P27		32	32	32	32	170	L60M6*16	T-20	NGM-27	MQ040080	S2.5
	4040R27		40	40	40	40	200	L60M6*16	T-20	NGM-27	MQ040080	S2.5
	5050S27		50	50	50	50	250	L60M6*16	T-20	NGM-27	MQ040080	S2.5

外螺纹刀杆平装型 - 直头 External Threading Tool Holder (b=F)

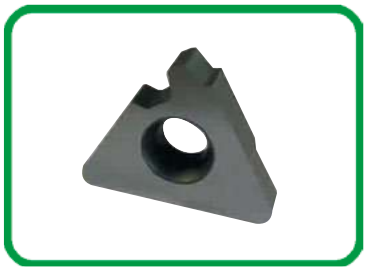

图示为右手刀具



刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key	刀垫 Anvil	侧面螺钉 Anvil Screw	扳手 Hex Wrench
			h	b	H	F	L					
SER	1010H11-A	11ER**	10	10	10	10	100	L60M2.5*6	T-08	-	-	-
	1212K11-A		12	12	12	12	125	L60M2.5*6	T-08	-	-	-
	1616H11-A		16	16	16	16	100	L60M2.5*6	T-08	-	-	-
	1616H16-A	16ER**	16	16	16	16	100	L60M3.5*12	T-15	-	-	-
	2020K16-A		20	20	20	20	125	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	2525M16-A		25	25	25	25	150	L60M3.5*12	T-15	EGM-16	MQ030080	T10
SEL	1010H11-A	11EL**	10	10	10	10	100	L60M2.5*6	T-08	-	-	-
	1212K11-A		12	12	12	12	125	L60M2.5*6	T-08	-	-	-
	1616H11-A		16	16	16	16	100	L60M2.5*6	T-08	-	-	-
	1616H16-A	16EL**	16	16	16	16	100	L60M3.5*12	T-15	-	-	-
	2020K16-A		20	20	20	20	125	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	2525M16-A		25	25	25	25	150	L60M3.5*12	T-15	EGM-16	MQ030080	T10

梯形螺纹专用刀垫

Anvil for trapezoidal threading inserts



订货型号NGM-22T

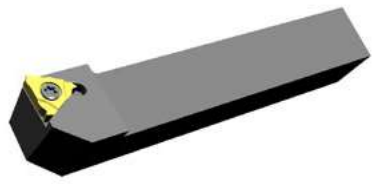
Ordering code: NGM-22T

订货型号EGM-22T

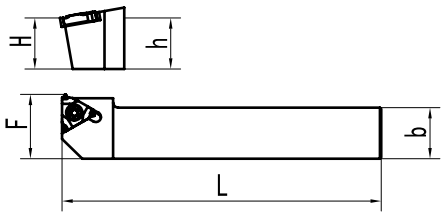
Ordering code: EGM-22T

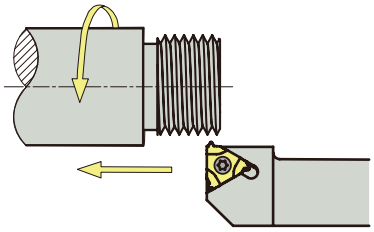
★ 梯形螺纹专用刀垫适用于22系列6.0TR，5.0TR，4ACME以及4STACME这几个型号
★ 需要单独订购

外螺纹刀杆 - 排刀机用 Gang-type External Threading Tool Holder



图示为左手刀具

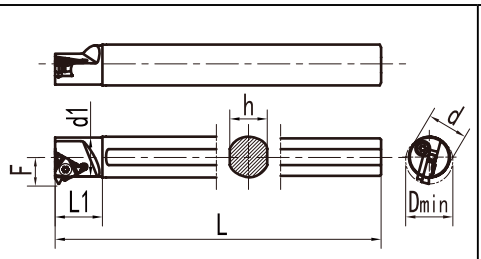


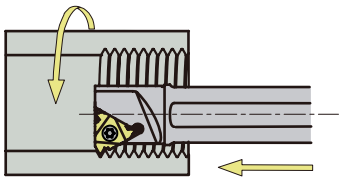


刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L		
SEL	1010K11-A90	11ER**	10	10	10	12	125	L60M2.5*6	T-08
	1212K11-A90		12	12	12	16	125	L60M2.5*6	T-08
	1616K11-A90		16	16	16	20	125	L60M2.5*6	T-08
	1616H16-A90	16ER**	16	16	16	20	100	L60M3.5*12	T-15
	2020K16-A90		20	20	20	25	125	L60M3.5*12	T-15
	2525M16-A90		25	25	25	32	150	L60M3.5*12	T-15
	2525M22-A90	22ER**	25	25	25	32	150	L60M4.5*14	T-20

内螺纹刀杆平装型 Internal Threading Tool Holder

图示为右手刀具

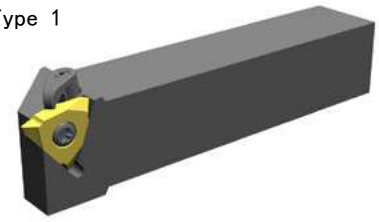




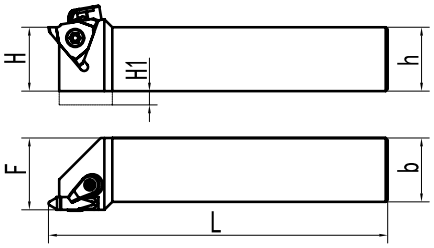
刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key	刀垫 Anvil	侧面螺钉 Anvil Screw	扳手 Hex Wrench
			Dmin	L1	d1	d	F	L	h					
SNR	0612H06	06NR**	6.5	16	5.3	12	3.65	100	11.4	L60M2*4	T-06	-	-	-
	0712H06		7.2	18	6	12	4	100	11.4	L60M2*4	T-06	-	-	-
	0912H06		8.8	24	7.6	12	4.8	100	11.4	L60M2*4	T-06	-	-	-
	0008H08	08NR**	8.5	15	7	8	5	100	7.4	L60M2*5	T-06	-	-	-
	0010H11	11NR** T11N**	12	12	10	10	7.4	100	9	L60M2.5*6	T-08	-	-	-
	0012K11		15	15	12	12	8.4	125	11	L60M2.5*6	T-08	-	-	-
	0013M11		15	25	13	13	8.9	150	12	L60M2.5*6	T-08	-	-	-
	0013M16	16NR** T16N**	16	25	13	16	10.2	150	15	L60M3.5*12	T-15	-	-	-
	0013M16-Z		16	25	13	13	10.2	150	12	L60M3.5*12	T-15	-	-	-
	0016M16		19	25	15	16	11.7	150	15	L60M3.5*12	T-15	-	-	-
	0020Q16		24	24	19	20	13.7	180	18	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0025R16		29	29	24	25	16.2	200	23	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0032S16		36	36	31	32	19.7	250	30	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0040T16		44	44	38	40	23.7	300	37	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0050U16		54	54	47	50	28.7	350	46	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0020Q22	22NR**	24	24	19	20	15.6	180	18	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0025R22		29	29	24	25	18.1	200	23	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0032S22		38	38	31	32	21.6	250	30	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0040T22		46	46	38	40	25.6	300	37	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0050U22		56	56	47	50	30.6	350	46	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0032T27	27NR**	37	65	30	32	21.6	300	30	L60M6*16	T-20	NGM-27	MQ040080	S2.5
	0040U27		46	70	38	40	26.6	350	38	L60M6*16	T-20	NGM-27	MQ040080	S2.5
SNL	0008H08	08NL**	8.5	15	7	8	5	100	7.4	L60M2*5	T-06	-	-	-
	0010H11	11NL**	12	12	10	10	7.4	100	9	L60M2.5*6	T-08	-	-	-
	0012K11		15	15	12	12	8.4	125	11	L60M2.5*6	T-08	-	-	-
	0013M11		15	25	13	16	8.9	150	15	L60M2.5*6	T-08	-	-	-
	0013M16	16NL**	16	25	13	16	10.2	150	15	L60M3.5*12	T-15	-	-	-
	0016M16		19	25	15	16	11.7	150	15	L60M3.5*12	T-15	-	-	-
	0020Q16		24	24	19	20	13.7	180	18	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0025R16		29	29	24	25	16.2	200	23	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0032S16		36	36	31	32	19.7	250	30	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0040T16		44	44	38	40	23.7	300	37	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0050U16		54	54	47	50	28.7	350	46	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0020Q22	22NL**	24	24	19	20	15.6	180	18	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0025R22		29	29	24	25	18.1	200	23	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0032S22		38	38	31	32	21.6	250	30	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0040T22		46	46	38	40	25.6	300	37	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0050U22		56	56	47	50	30.6	350	46	L60M4.5*14	T-20	NGM-22	MQ040080	S2.5
	0040T27	27NL**	48	46	38	40	25.6	300	37	L60M6*16	T-20	NGM-27	MQ040080	S2.5
	0050U27		58	56	47	50	30.6	350	46	L60M6*16	T-20	NGM-27	MQ040080	S2.5

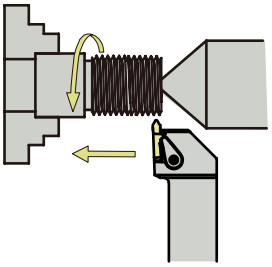
外螺纹刀杆立装型 External Threading Tool Holder (V-Style)

形式一
Type 1

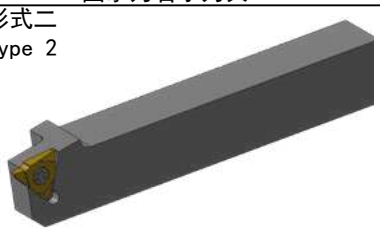


图示为右手刀具

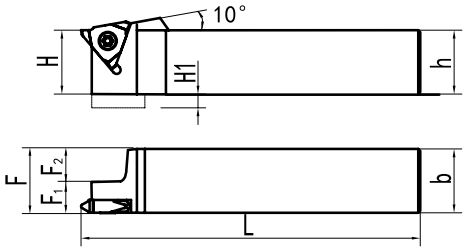


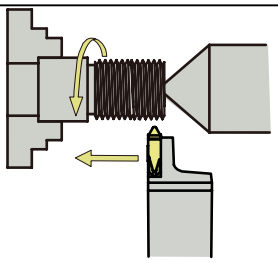


形式二
Type 2



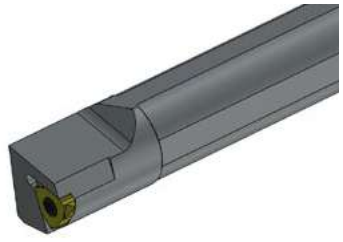
图示为右手刀具

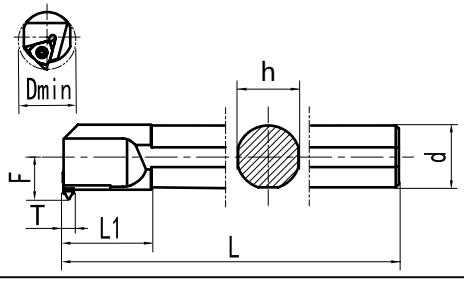


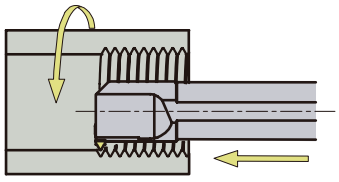


刀杆型号 Toolholder Type		刀片型号 Insert Type	刀杆形式 type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key	压板 Clamp	压板螺钉 Clamp Screw	扳手 Hex Wrench
				F1	F2	h	b	H	F	L					
SVER	1616H16	16VER**	形式一 Type 1	–	–	16	16	16	16	100	L60M3.5*12	T-15	–	–	–
	2020K16			–	–	20	20	20	20	125	L60M3.5*12	T-15	–	–	–
	2525M16			–	–	25	25	25	25	150	L60M3.5*12	T-15	–	–	–
	3232P16			–	–	32	32	32	32	170	L60M3.5*12	T-15	–	–	–
	2020K22	22VER**	形式一 Type 1	–	–	20	20	20	25	125	L60M4.5*14	T-20	HL1814	ML0620	L3
	2525M22			–	–	25	25	25	30	150	L60M4.5*14	T-20	HL1814	ML0620	L3
	2525M27-6	27VER**	形式一 Type 1	–	–	25	25	25	30	150	L60M6*20	T-20	HL1814	ML0620	L3
	3232P27-6			–	–	32	32	32	36	170	L60M6*20	T-20	HL1814	ML0620	L3
	3232P27-8			–	–	32	32	32	36	170	L60M6*20	T-20	HL1814	ML0620	L3
	3232P27-10			–	–	32	32	32	36	170	L60M6*20	T-20	HL1814	ML0620	L3
	4040R27-6			–	–	40	40	40	45	200	L60M6*20	T-20	HL1814	ML0620	L3
	4040R27-8			–	–	40	40	40	45	200	L60M6*20	T-20	HL1814	ML0620	L3
	4040R27-10			–	–	40	40	40	45	200	L60M6*20	T-20	HL1814	ML0620	L3
SVER	1616H16AH	16VER**	形式二 Type 2	8	8	16	16	16	16	100	L60M3.5*7	T-15	–	–	–
	2020K16AH			8	12	20	20	20	20	125	L60M3.5*7	T-15	–	–	–
	2525M16AH			8	17	25	25	25	25	150	L60M3.5*7	T-15	–	–	–
	3232P16AH			8	24	32	32	32	32	170	L60M3.5*7	T-15	–	–	–

内螺纹刀杆立装型 Internal Threading Tool Holder (V-Style)


图示为右手刀具





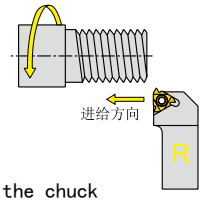
刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
			T	Dmin	h	l1	d	F	L		
SVNR	0020Q16	16VNR**	3.65	24	18	20	20	13.6	180	L60M3.5*12	T-15
	0025R16		3.65	29	23	20	25	16.1	200	L60M3.5*12	T-15
	0032S16		3.65	36	30	32	32	19.6	250	L60M3.5*12	T-15
	0025R22	22VNR**	4.76	32	23	20	25	17.5	220	L60M4.5*14	T-20
	0032S27-6	27VNR**	6.4	41	30	32	32	22.5	250	L60M6*20	T-20
	0040T27-6		6.4	50	38	40	40	28.5	300	L60M6*20	T-20
	0040T27-8		8.7	50	38	40	40	28.5	300	L60M6*20	T-20
	0040U27-10		-	50	38	40	40	28.5	350	L60M6*20	T-20
	0050U27-8		8.7	60	48	50	50	33.5	350	L60M6*20	T-20
	0050U27-10		-	60	48	50	50	33.5	350	L60M6*20	T-20

螺纹车削加工方案对照表

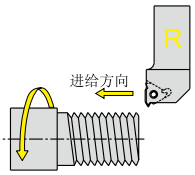
Comparison table of threading cutting maching

外螺纹（右旋螺纹） external(right hand)

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

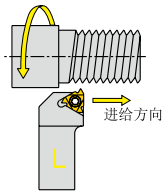


铁屑向下排－刀杆反向安装
主轴正转（M03）
进给方向－向卡盘方向进给
Scrap iron displaced downward-tool holders installed backward
Spindle turned forward-M03
Feed direction-Feed direction-feed to the chuck

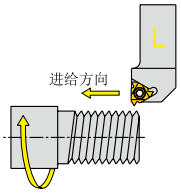


外螺纹（左旋螺纹） external(left hand)

铁屑向上排－刀杆正向安装
主轴正转（M03）
进给方向－向尾座方向进给
Scrap iron displaced upward-tool holders installed forward
Spindle turned forward-M03
Feed direction-Feed direction-tail seat direction feed

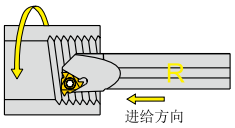


铁屑向下排－刀杆正向安装
主轴反转（M04）
进给方向－向卡盘方向进给
Scrap iron displaced upward-tool holders installed forward
Spindle turned forward-M04
Feed direction-Feed direction-feed to the chuck

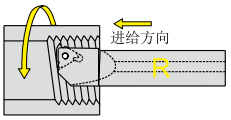


内螺纹（右旋螺纹） internal(right hand)

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

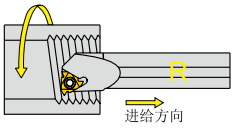


铁屑向下排－刀杆反向安装
主轴正转（M03）
进给方向－向卡盘方向进给
Scrap iron displaced downward-tool holders installed backward
Spindle turned forward-M03
Feed direction-Feed direction-feed to the chuck

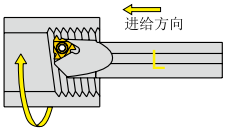


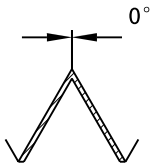
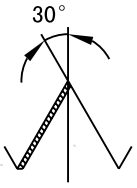
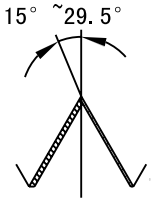
内螺纹（左旋螺纹） internal(left hand)

铁屑向上排－刀杆正向安装
主轴正转（M03）
进给方向－向尾座方向进给
Scrap iron displaced upward-tool holders installed forward
Spindle turned forward-M03
Feed direction-Feed direction-tail seat direction feed



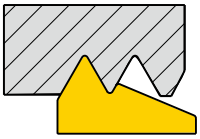
铁屑向上排－刀杆正向安装
主轴反转（M04）
进给方向－向卡盘方向进给
Scrap iron displaced upward-tool holders installed forward
Spindle turned forward-M04
Feed direction-Feed direction-feed to the chuck



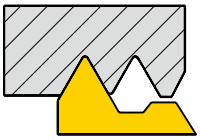
常见的几种进刀方式			
一般推荐修正齿侧进刀和齿侧交替进刀			
修正齿侧进刀	齿侧交替进刀	径向对中（0°）进刀	齿侧 30° 进刀
对于 60° 牙型角的螺纹切削，轴向进刀量可以简单地按 0.5* 径向进刀量来计算。对于 55° 的牙型角，则应以 0.42* 径向进刀量来计算。这便可得到一个比螺纹的牙型角小 5° 的进刀角。	主要是用于切削大牙形时，此方法可获得均匀的刀片磨损和长刀具寿命 需要在CNC机床上进行特定编程。实际上，由机床、工件材料、刀片槽型和螺距共同决定了进刀方式的选择。	许多机床上常用也只能使用的方法。可获得软的断屑和使刀片磨损更均匀。适合于小螺距。当用于疏齿距时具有振动风险和较差的切屑控制。加工硬化材料（例如奥氏体不锈钢）的首选 推荐使用表中给定的径向进给	
15° ~29.5° 进刀角度 		0° 进刀角度 	30° 进刀角度
优点： 刀片同时切削螺纹牙型两侧，防止像 0° 进刀时容易发生的崩刃。虽然也会形成排屑沟槽，但是由于切削厚度不平均有利于排屑，犹如齿侧进刀，这是比较好的进刀方法，尤其是使用有断屑槽的刀片	优点： 由于两侧切削刃平均使用，提高了刀片的寿命。注：采用这种进刀方法对一些机床可能需要特殊的编程技术	优点： 刀片全部刀刃对螺纹牙型两侧同时切削，防止刀刃崩刃	优点： 利用刀片侧刃进给切削，使切屑容易排出切削区域，这就减少刀片后沿形成毛刺的问题，为了避免由于刀刃后沿摩擦而降低表面光洁度、崩刃或齿侧面过度的磨损，横向进刀的角度应小于螺纹齿形角 3° -5° 这是一种齿侧面修正类型。
缺点： 和径向对中进刀的缺点相同，但是在降低切削力方面比较明显，同时排屑的问题也得到解决。	缺点： 在传统机床上加工困难	缺点： 排屑困难，在切削高强度材料时容易崩刃。产生毛刺的可能性增大。由于在精车螺纹时整个切削刃全部切入，荣誉引起振刀。	缺点： 刀片可能有拖拽或者摩擦的现象而使刃口崩刃。在切削软而粘性的金属，如低碳钢，铝和不锈钢时，会破坏表面光洁度
如何控制铁屑： 当排屑通畅时，可获得良好的表面质量。当排屑不通畅和发生振动时，适合于粗牙螺纹和内螺纹。为避免表面粗糙度或由于后缘的摩擦而导致过度的后刀面磨损，应使进刀角保持为 3° ~5°，且比螺旋角要小。			

定螺距刀片牙形与泛螺距刀片牙形比较

定螺距刀片



泛螺距刀片



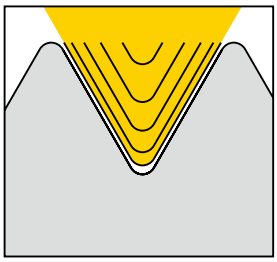
定螺距刀片
螺纹尺寸是按照已制定的螺纹标准确定
由于螺纹外径和底径同时加工，因此可以得到同心度的螺纹。
由最后一刀加工出准确的螺纹牙型，减少额外的操作或者去毛刺操作，
因此降低加工成本

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

走刀次数和进刀量

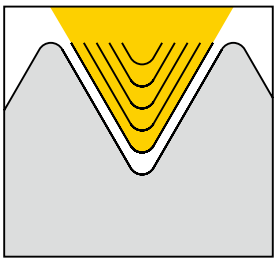
走刀次数和进刀量
走刀次数和进刀量对于螺纹切削工序具有决定性影响。在大多数现代机床上，应在螺纹切削周期中给定总螺纹深度和第一次或者最后一次切深。
为了提高螺纹切削质量，应使用下面推荐的进刀量。对于多齿刀片，坚持使用进刀量推荐值是极为重要的
可作为初始值的推荐值。合适的走刀次数必须通过实验来决定。
为优化刀具寿命，工件直径应不超过螺纹的最大直径 0.14mm
应避免进刀量低于 0.05mm
对于奥氏体不锈钢，进刀量应避免低于 0.08mm

①连续递减 - 可获得不变的切屑面积。
这包括相对较大的初始值（0.2-0.35mm），并且与螺纹牙型的具体深度有关。此值会逐渐降低且以 0.02-0.09mm 的进给进行精加工。最后一次走刀可以是不进刀的空走刀，这是用于消除切削过程中的反弹。
这种走刀方式是现代 CNC 机床上常用的方法。



切屑面积 + 跳跃走刀

②恒定的进刀量 - 可获得最佳的切屑控制和长的刀具寿命。
在新型机床上正变得越来越通用的加工方法。通过固定螺纹切削周期中的某一个参数，而使切屑厚度恒定，进而可以形成最佳切屑。初始值大约为 0.18-0.12mm，实际值应由上一次走刀（至少应为 0.08mm）的具体值确定。



恒定的走刀量

用于部分牙型刀片（V 形 55° 和 60° ）的切削参数
使用部分牙形刀片进行螺纹切削时，可使用推荐的走刀次数。但是，当使用小螺距的刀片时，每次走刀量不能超过最大推荐值。
注意！当螺纹要去小公差时，最后一次走刀可不进刀（空走刀）。对于硬材料，则需要相应的增加走刀次数。当螺纹切削加工淬硬材料（例如奥氏体不锈钢）时，进刀量应不得超过 0.08mm

进刀量计算公式

按公式以连续递减方式计算每次走刀量

$$\triangle apx = \frac{h}{\sqrt{nap-1}} \times \sqrt{n}$$

△ apx 径向进给
x 实际走刀（从 1 到 nap 的系列值）
ap 螺纹总深度
nap 走刀次数
n 第一次走刀 =0. 3
第二次走刀 =1
第三次走刀 =x-1

示例：

工况：

外螺纹切削：
螺距：1. 5mm
ap：0. 94mm
nap：6 次走刀

计算：

$$\triangle ap1 = \frac{0.94}{\sqrt{5}} \times \sqrt{0.3} = 0.23$$

结果：

第一次走刀，进刀量 =0. 23mm

$$\triangle ap2 = \frac{0.94}{\sqrt{5}} \times \sqrt{1} = 0.42$$

第二次走刀，进刀量 0. 42-0. 23=0. 19mm

$$\triangle ap1 = \frac{0.94}{\sqrt{5}} \times \sqrt{2} = 0.59$$

第三次走刀，进刀量 0. 59-0. 42=0. 17mm

$$\triangle ap1 = \frac{0.94}{\sqrt{5}} \times \sqrt{3} = 0.73$$

第四次走刀，进刀量 0. 73-0. 59=0. 14mm

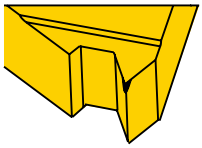
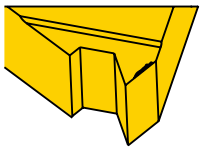
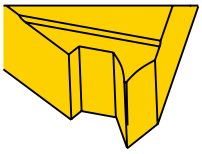
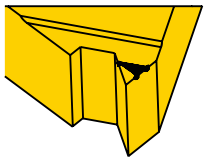
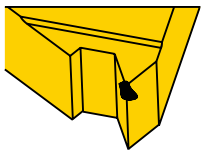
$$\triangle ap1 = \frac{0.94}{\sqrt{5}} \times \sqrt{4} = 0.84$$

第五次走刀，进刀量 0. 84-0. 73=0. 11mm

$$\triangle ap1 = \frac{0.94}{\sqrt{5}} \times \sqrt{5} = 0.94$$

第六次走刀，进刀量 0. 94-0. 84=0. 1mm

疑难解析 FAQ

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

螺距以及底孔直径对照表

theading insert cutting times within definite depth for reference

公制粗螺纹

规格	标准径	底孔直径	
		最大	最小
M10 1.5	8.5	8.676	8.376
M11 1.5	9.5	9.676	9.376
M12 1.75	10.3	10.411	10.106
M14 2.0	12.0	12.210	11.835
M16 2.0	14.0	14.210	13.835
M18 2.5	15.5	15.744	15.294
M20 2.5	17.5	17.744	17.294
M22 2.5	19.5	19.744	19.294
M24 3.0	21.0	21.252	20.752
M27 3.0	24.0	24.252	23.752
M30 3.5	26.5	26.771	26.211
M33 3.5	29.5	29.771	29.221
M36 4.0	32.0	32.270	31.670
M39 4.0	35.0	35.270	34.670
M42 4.5	37.5	37.799	37.129
M45 4.5	40.5	40.799	40.129
M48 5.0	43.0	43.297	42.587
M56 5.5	50.5	50.796	50.046
M64 6.0	58.0	58.305	57.505

美制粗螺纹

规格（UNC）	标准径	底孔直径	
		最大	最小
1/4 -20	5.10	5.257	4.979
5/16 -18	6.60	6.731	6.401
3/8 -16	8.00	8.153	7.798
7/16 -14	9.40	9.550	9.144
1/2 -13	10.90	11.023	10.592
9/16 -12	12.20	12.446	11.989
5/8 -11	13.60	13.868	13.386
3/4 -10	16.60	16.840	16.307
7/8 -9	19.60	19.761	19.177
1 -8	22.30	22.606	21.971
1-1/8 -7	25.00	25.349	24.638
1-1/4 -7	28.20	28.524	27.813
1-3/8 -6	30.80	31.115	30.353
1-1/2 -6	34.00	34.290	33.528
1-3/4 -5	39.50	39.827	38.964
2 -4.5	45.20	45.593	44.679

公制细螺纹

规格	标准径	底孔直径	
		最大	最小
M12 1.5	10.5	10.676	10.376
M12 1.25	10.8	10.912	10.647
M12 1.0	11.0	11.153	10.917
M12 0.5	11.5	11.520	11.400
M14 1.5	12.5	12.676	12.376
M14 1.0	13.0	13.153	12.917
M15 1.5	13.5	13.676	13.376
M15 1.0	14.0	14.153	13.917
M16 1.5	14.5	14.676	14.376
M16 1.0	15.0	15.153	14.917
M17 1.5	15.5	15.676	15.376
M17 1.0	16.0	16.153	15.917
M18 2.0	16.1	16.210	15.835
M18 1.5	16.5	16.676	16.376
M18 1.0	17.0	17.153	16.917
M20 2.0	18.0	18.210	17.835
M20 1.5	18.5	18.676	18.376
M20 1.0	19.0	19.153	18.917
M22 2.0	20.0	20.210	19.835
M22 1.5	20.5	20.676	20.376
M22 1.0	21.0	21.153	20.917
M24 2.0	22.0	23.210	21.835
M24 1.5	22.5	22.676	22.376
M24 1.0	23.0	23.153	22.917
M25 2.0	23.0	23.210	22.835
M25 1.5	23.5	23.670	23.370
M25 1.0	24.0	24.153	23.917
M26 1.5	24.5	24.676	24.376
M27 2.0	25.0	25.210	24.835
M27 1.5	25.5	25.676	25.376
M27 1.0	26.0	26.153	25.917
M28 2.0	26.0	26.210	25.835
M28 1.5	26.5	26.676	26.376
M28 1.0	27.0	27.153	26.917
M30 3.0	27.0	27.252	26.752
M30 2.0	28.0	28.210	27.835
M30 1.5	28.5	28.676	28.376
M30 1.0	29.0	29.153	28.917
M32 2.0	30.0	30.210	29.835
M32 1.5	30.5	30.676	30.376
M33 3.0	30.0	30.252	29.752
M33 2.0	31.0	31.210	30.835
M33 1.5	31.5	31.676	31.376
M35 1.5	33.5	33.676	33.376
M36 3.0	33.0	33.252	32.752
M36 2.0	34.0	34.210	33.835
M36 1.5	34.5	34.676	34.376

螺距以及底孔直径对照表

theading insert cutting times within definite depth for reference

美制细螺纹

规格（UNF）	标准径	底孔直径	
		最大	最小
1/4 -28	5.10	5.588	5.360
5/16 -24	6.60	7.035	6.782
3/8 -24	8.00	8.636	8.382
7/16 -20	9.40	10.033	9.729
1/2 -20	10.90	11.607	11.329
9/16 -18	12.20	13.081	12.751
5/8 -18	13.60	14.681	14.351
3/4 -16	16.60	17.678	17.323
7/8 -14	19.60	20.675	20.270
1 -12	22.30	23.571	23.114
1-1/8 -12	25.00	26.746	26.289
1-1/4 -12	28.20	29.921	29.464
1-3/8 -12	30.80	33.096	32.639
1-1/2 -12	34.00	36.271	35.814

美制管螺纹

规格	NPT		NPSC
	使用铰刀时	不使用铰刀时	
1/16 -27	5.94	6.15	6.35
1/8 -27	8.33	8.43	8.74
1/4 -18	10.72	11.13	11.13
3/8 -18	14.27	14.27	14.68
1/2 -14	17.48	17.86	18.26
3/4 -14	22.63	23.01	23.42
1 -11.5	28.98	28.98	29.36
1-1/4 -11.5	37.31	37.69	38.10
1-1/2 -11.5	43.26	43.66	44.45
2 -11.5	55.17	55.58	58.36

美制特细牙螺纹

规格（UNEF）	标准径	底孔直径	
		最大	最小
NO.12 -32	4.70	4.826	4.623
1/4 -32	5.60	5.689	5.487
5/16 -32	7.10	7.264	7.087
3/8 -32	8.70	8.864	8.662
7/16 -28	10.20	10.337	10.135
1/2 -28	11.80	11.938	11.710
9/16 -24	13.2	13.385	13.132
5/8 -24	14.80	14.968	14.732
3/4 -20	17.80	17.957	17.679
7/8 -20	21.00	21.132	20.854
1 -20	24.10	24.307	24.029

英制管螺纹

PS 规格（新规格 RP）	标准径	底孔直径	
		最大	最小
1/16 -28	6.5	6.632	6.490
1/8 -28	8.5	8.637	8.495
1/4 -19	11.4	11.549	11.341
3/8 -19	14.9	15.045	14.846
1/2 -14	18.6	18.773	18.849
3/4 -14	24.0	24.259	23.975
1 -11	30.2	30.742	30.110
1-1/4 -11	38.8	39.133	38.771
1-1/2 -11	44.7	45.026	44.664
2 -11	56.5	56.837	56.475

德标钢导管螺纹 DIN40430

Pg 规格	标准径		
Pg7 -20	11.40		
Pg9 -18	14.00		
Pg11 -18	17.25		
Pg13.5 -18	19.00		
Pg16 -18	21.25		
Pg21 -16	26.75		
Pg29 -16	35.50		
Pg36 -16	45.50		

55° 英制密封圆锥内螺纹

ZG（国标）RC（英制）PT（日韩）	标准径	底孔直径	
		最大	最小
1/16 -28	6.1	6.244	6.384
1/8 -28	8.1	8.249	8.388
1/4 -19	10.7	10.962	11.174
3/8 -19	14.2	14.448	14.658
1/2 -14	17.6	17.979	18.263
3/4 -14	23.0	23.378	23.663
1 -11	29.0	29.459	29.822
1-1/4 -11	37.5	37.976	38.339
1-1/2 -11	43.4	43.869	44.232
2 -11	54.9	55.412	55.844

55° 英制非密封管螺纹

G（英制）PF（日韩）	标准径	底孔直径	
		最大	最小
1/16 -28	6.7	6.843	6.561
1/8 -28	8.7	8.848	8.566
1/4 -19	11.7	11.890	11.445
3/8 -19	15.2	15.395	14.950
1/2 -14	19.0	19.172	18.631
5/8 -14	21.0	21.128	20.587
3/4 -14	24.5	24.658	24.117
7/8 -14	28.2	28.418	27.877
1 -11	30.6	30.931	30.291
1-1/8 -11	35.2	35.579	34.939
1-1/4 -11	39.2	39.592	38.952
1-1/2 -11	45.0	45.485	44.845
1-3/4 -11	51.0	51.428	50.788
2 -11	57.0	57.296	56.656

常见螺纹代号	常见螺纹标注对应的刀片型号
R：英制一般密封管螺纹的统称 包含 Rp：英制密封圆柱内螺纹 Rc：英制密封圆锥内螺纹 R1、R2：英制密封圆锥外螺纹 英制密封螺纹的配合方式： ① Rp/R1：柱 / 锥 配合 ② Rc/R2：锥 / 锥 配合	Rp 3/4"=PS 3/4" 推荐选用 16NR14W 的刀片 Rc 3/4"=PT 3/4" 推荐选用 16NR14BSPT 的刀片 R1 和 R2 都选择 BSPT 系列刀片 PF 1"=G 1" 推荐选用 16ER11W（外） 16NR11W（内）的刀片
PF：日本和韩国的旧英制非密封圆柱管螺纹 PT：日本和韩国的旧英制密封圆锥管螺纹 PS：日本和韩国的旧英制密封圆柱内螺纹 日制密封螺纹的配合方式： ① PS/PT：柱 / 锥 配合 ② PT/PT：锥 / 锥 配合	
G：英制非密封管螺纹	
UN：美制统一螺纹 包含 UNC：美制粗牙螺纹 UNF：美制细牙螺纹 UNEF：美制超细牙螺纹	UNC UNF UNEF 都使用 11、16ER/NR**UN 系列的刀片 UNC 1" 推荐选用 16ER8UN（外） 16NR9UN（内）的刀片 UNF 1" 推荐选用 16ER12UN（外） 16NR12UN（内）的刀片 UNEF 1" 推荐选用 16ER20UN（外） 16NR20UN（内）的刀片
NPT：美制一般密封圆锥螺纹 NPSC：美制一般密封圆柱内螺纹 美制密封螺纹的配合方式： NPT/NPT：锥 / 锥 配合 NPSC/NPT：柱 / 锥 配合	NPT 3/4" 推荐选用 16ER14NPT（外） 16NR14NPT（内）的刀片

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

ISO-60° 公制螺纹 - 外螺纹　　ISO-60° Metric full profile-external

螺距（mm）Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
0.5	0.31	0.1	0.08	0.07	0.06												16ER0.50ISO	
0.75	0.46	0.16	0.14	0.1	0.06												16ER0.75ISO	
1.0	0.61	0.18	0.15	0.12	0.10	0.06											16ER1.00ISO	
1.25	0.77	0.19	0.17	0.14	0.11	0.1	0.06										16ER1.25ISO	
1.5	0.92	0.22	0.21	0.17	0.14	0.12	0.06										16ER1.50ISO	
1.75	1.07	0.22	0.21	0.16	0.13	0.11	0.09	0.09	0.06								16ER1.75ISO	
2.0	1.23	0.24	0.23	0.17	0.16	0.14	0.12	0.11	0.06								16ER2.00ISO	
2.5	1.53	0.26	0.23	0.19	0.17	0.15	0.13	0.12	0.11	0.11	0.06						16ER2.50ISO	
3.0	1.84	0.27	0.25	0.2	0.18	0.16	0.14	0.13	0.12	0.12	0.11	0.1	0.06				16ER3.00ISO	
3.5	2.15	0.33	0.3	0.24	0.21	0.18	0.17	0.15	0.14	0.14	0.12	0.11	0.06				16ER3.50ISO	
4.0	2.45	0.34	0.31	0.24	0.22	0.16	0.17	0.16	0.14	0.14	0.13	0.12	0.12	0.11	0.06		22ER4.00ISO	
4.5	2.76	0.38	0.34	0.28	0.24	0.22	0.2	0.18	0.16	0.16	0.15	0.14	0.13	0.12	0.06		22ER4.50ISO	
5.0	3.07	0.42	0.38	0.32	0.27	0.24	0.22	0.2	0.18	0.18	0.17	0.16	0.15	0.12	0.06		22ER5.00ISO	

UN-60° 美制螺纹 - 外螺纹　　UN-60° Full profile-external

螺距（TPI）Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
32	0.49	0.17	1.15	0.11	0.06												16ER32UN	
28	0.56	0.17	0.14	0.1	0.09	0.06											16ER28UN	
24	0.65	0.18	0.16	0.14	0.11	0.06											16ER24UN	
20	0.78	0.2	0.18	0.13	0.11	0.1	0.06										16ER20UN	
18	0.87	0.22	0.2	0.15	0.13	0.11	0.06										16ER18UN	
16	0.97	0.22	0.2	0.15	0.12	0.11	0.11	0.06									16ER16UN	
14	1.11	0.23	0.21	0.16	0.13	0.11	0.11	0.10	0.06								16ER14UN	
13	1.20	0.25	0.22	0.17	0.14	0.13	0.12	0.11	0.06								16ER13UN	
12	1.30	0.28	0.23	0.18	0.16	0.14	0.13	0.12	0.06								16ER12UN	
11	1.42	0.28	0.23	0.19	0.16	0.14	0.13	0.12	0.11	0.06							16ER11UN	
10	1.56	0.28	0.24	0.19	0.16	0.14	0.13	0.13	0.12	0.11	0.06						16ER10UN	
9	1.73	0.34	0.29	0.22	0.17	0.15	0.14	0.13	0.12	0.11	0.06						16ER9UN	
8	1.95	0.35	0.3	0.24	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					16ER8UN	
7	2.22	0.37	0.33	0.28	0.24	0.2	0.17	0.16	0.15	0.14	0.12	0.06					22ER7UN	
6	2.60	0.42	0.35	0.29	0.25	0.21	0.18	0.17	0.16	0.15	0.12	0.11	0.06				22ER6UN	
5	3.12	0.43	0.39	0.31	0.27	0.24	0.22	0.2	0.19	0.19	0.17	0.15	0.12	0.06			22ER5UN	

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

W-55° 惠氏螺纹 - 外螺纹　　W-55° Full profile-external

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
28	0.58	0.17	0.14	0.11	0.1	0.06											16ER28W	
26	0.63	0.18	0.15	0.13	0.11	0.06											16ER26W	
20	0.81	0.2	0.18	0.14	0.12	0.11	0.06										16ER20W	
19	0.86	0.21	0.19	0.15	0.13	0.12	0.06										16ER19W	
18	0.9	0.25	0.19	0.15	0.13	0.12	0.06										16ER18W	
16	1.02	0.21	0.18	0.15	0.13	0.11	0.09	0.09	0.06								16ER16W	
14	1.16	0.23	0.21	0.17	0.14	0.12	0.12	0.11	0.06								16ER14W	
12	1.36	0.27	0.25	0.2	0.16	0.15	0.14	0.13	0.06								16ER12W	
11	1.48	0.27	0.24	0.2	0.17	0.15	0.14	0.13	0.12	0.06							16ER11W	
10	1.63	0.27	0.25	0.2	0.17	0.15	0.15	0.13	0.13	0.12	0.06						16ER10W	
9	1.81	0.28	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.06					16ER9W	
8	2.03	0.3	0.27	0.22	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.06				16ER8W	
7	2.32	0.34	0.32	0.26	0.22	0.2	0.18	0.17	0.16	0.15	0.14	0.12	0.06				22ER7W	
6	2.71	0.35	0.33	0.27	0.23	0.21	0.2	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.06		22ER6W	
2	3.25	0.42	0.4	0.35	0.29	0.26	0.24	0.22	0.2	0.19	0.18	0.17	0.15	0.12	0.06		22ER5W	

BSPT-55° 英制管螺纹 - 外螺纹　　BSPT-55° -external

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
28	0.58	0.17	0.14	0.11	0.1	0.06											16ER28BSPT	
19	0.86	0.22	0.19	0.15	0.12	0.12	0.06										16ER19BSPT	
14	1.16	0.24	0.2	0.17	0.14	0.12	0.12	0.11	0.06								16ER14BSPT	
11	1.48	0.25	0.23	0.21	0.18	0.16	0.14	0.13	0.12	0.06							16ER11BSPT	

NPT-60° 美制管螺纹 - 外螺纹　　NPT-60° -External

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
27	0.753	0.15	0.13	0.1	0.1	0.09	0.06										16ER27NPT	
18	1.129	0.25	0.19	0.16	0.13	0.12	0.11	0.1	0.06								16ER18NPT	
14	1.451	0.28	0.22	0.18	0.16	0.13	0.12	0.11	0.1	0.09	0.06						16ER14NPT	
11.5	1.767	0.29	0.22	0.19	0.17	0.15	0.13	0.13	0.12	0.11	0.1	0.09	0.06				16ER11.5NPT	
8	2.54	0.38	0.31	0.25	0.21	0.19	0.16	0.15	0.14	0.13	0.12	0.12	0.11	.011	0.1	0.06	16ER8NPT	

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

TR-30° 梯形螺纹 - 外螺纹　　TR-30° -External

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
1.5	0.9	0.23	0.21	0.16	0.13	0.11	0.06										16ER1.5TR	
2	1.25	0.29	0.26	0.21	0.17	0.14	0.12	0.06									16ER2.0TR	
3	1.75	0.32	0.31	0.24	0.19	0.18	0.17	0.15	0.13	0.06							16ER3.0TR	
4	2.25	0.33	0.32	0.24	0.22	0.21	0.17	0.16	0.15	0.14	0.13	0.12	0.06				22ER4.0TR	
5	2.75	0.35	0.32	0.26	0.24	0.22	0.21	0.19	0.19	0.17	0.15	0.14	0.13	0.12	0.06		22ER5.0TR	
6	3	0.38	0.35	0.32	0.28	0.25	0.22	0.2	0.18	0.16	0.14	0.12	0.1	0.08	0.06	...	22ER6.0TR	
7	3.5	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	0.1	0.08	...	27VER7.0TR	
8	4	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	0.1	...	27VER8.0TR	
9	4.5	0.48	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	...	27VER9.0TR	
10	5	0.48	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	...	27VER10.0TR	
12	6	0.48	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	...	27VER12.0TR	

AMCE-29° 美制梯形螺纹 - 外螺纹　　ACME-29° -External

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
12	1.19	0.27	0.23	0.2	0.17	0.14	0.12	0.06	0.06								16ER12ACME	
10	1.52	0.29	0.25	0.21	0.18	0.16	0.14	0.12	0.11	0.06							16ER10ACME	
8	1.84	0.3	0.26	0.22	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					16ER8ACME	
6	2.37	0.34	0.3	0.27	0.24	0.21	0.19	0.16	0.14	0.12	0.12	0.11	0.11	0.06			22ER6ACME	
5	2.79	0.36	0.33	0.3	0.26	0.23	0.2	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.06		22ER5ACME	
4	3.43	0.4	0.36	0.33	0.3	0.26	0.23	0.2	0.18	0.17	0.16	0.15	0.14	0.13	0.12	...	22ER4ACME	

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

STACME-29° 美制梯形螺纹 - 外螺纹　　Stub ACME-29° -External

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
16	0.6	0.18	0.14	0.12	0.1	0.06											16ER16STACME	
14	0.67	0.18	0.14	0.12	0.1	0.07	0.06										16ER14STACME	
12	0.76	0.18	0.16	0.14	0.12	0.1	0.08	0.06									16ER12STACME	
10	1.02	0.22	0.18	0.16	0.14	0.12	0.12	0.1	0.06								16ER10STACME	
8	1.21	0.24	0.2	0.18	0.14	0.12	0.11	0.08	0.08	0.06							16ER8STACME	
6	1.52	0.3	0.24	0.2	0.18	0.14	0.12	0.12	0.08	0.08	0.06						22ER6STACME	
5	1.78	0.34	0.28	0.22	0.2	0.16	0.14	0.12	0.1	0.08	0.08	0.06					22ER5STACME	
4	2.16	0.37	0.34	0.28	0.22	0.2	0.16	0.14	0.12	0.1	0.08	0.08	0.06				22ER4STACME	

RD-30° 德标 DIN405 圆螺纹 - 外螺纹　　Round DIN405-30° -external

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
10	1.27	0.23	0.21	0.2	0.19	0.16	0.12	0.1	0.06								16ER10RD	
8	1.59	0.23	0.21	0.2	0.19	0.18	0.16	0.14	0.12	0.1	0.06						16ER8RD	
6	2.12	0.26	0.25	0.24	0.22	0.21	0.19	0.17	0.16	0.14	0.12	0.1	0.06				16ER6RD	
4	3.18	0.34	0.33	0.32	0.3	0.28	0.26	0.24	0.22	0.2	0.19	0.17	0.15	0.12	0.06		22ER4RD	

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

ISO-60° 公制螺纹 - 内螺纹　　ISO-60° Metric full profile-internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
0.5	0.29	0.09	0.07	0.07	0.06												11NR0.5ISO	16NR0.5ISO
0.75	0.43	0.15	0.13	0.09	0.06												11NR0.75ISO	16NR0.75ISO
1.0	0.58	0.17	0.15	0.11	0.09	0.06											11NR1.0ISO	16NR1.0ISO
1.25	0.72	0.18	0.16	0.12	0.11	0.09	0.06										11NR1.25ISO	16NR1.25ISO
1.5	0.87	0.21	0.2	0.16	0.13	0.11	0.06										11NR1.5ISO	16NR1.5ISO
1.75	1.01	0.21	0.2	0.15	0.12	0.1	0.09	0.08	0.06								11NR1.75ISO	16NR1.75ISO
2.0	1.15	0.24	0.22	0.18	0.14	0.12	0.1	0.09	0.06								11NR2.0ISO	16NR2.0ISO
2.5	1.44	0.25	0.24	0.21	0.15	0.13	0.12	0.1	0.09	0.09	0.06							16NR2.5ISO
3.0	1.73	0.26	0.25	0.22	0.17	0.14	0.13	0.12	0.11	0.1	0.09	0.08	0.06					16NR3.0ISO
3.5	2.02	0.32	0.3	0.23	0.19	0.17	0.15	0.14	0.13	0.12	0.11	0.1	0.06					16NR3.5ISO
4.0	2.31	0.33	0.31	0.24	0.22	0.18	0.15	0.14	0.13	0.12	0.12	0.11	0.1	0.1	0.06			22NR4.0ISO
4.5	2.3	0.36	0.33	0.28	0.24	0.21	0.19	0.16	0.15	0.14	0.13	0.12	0.12	0.11	0.06			22NR4.5ISO
5.0	2.89	0.41	0.38	0.32	0.27	0.24	0.21	0.18	0.16	0.15	0.14	0.13	0.13	0.12	0.06			22NR5.0ISO

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

UN-60° 美制螺纹 - 内螺纹　　UN-60° Full profile-internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
32	0.46	0.16	0.14	0.1	0.06												11NR32UN	16NR32UN
28	0.52	0.16	0.13	0.09	0.08	0.06											11NR28UN	16NR28UN
24	0.61	0.17	0.15	0.13	0.1	0.06											11NR24UN	16NR24UN
20	0.73	0.18	0.15	0.13	0.11	0.1	0.06										11NR20UN	16NR20UN
18	0.81	0.2	0.18	0.14	0.12	0.11	0.06										11NR18UN	16NR18UN
16	0.92	0.2	0.18	0.15	0.12	0.11	0.1	0.06									11NR16UN	16NR16UN
14	1.05	0.21	0.18	0.15	0.13	0.11	0.11	0.1	0.06								11NR14UN	16NR14UN
13	1.13	0.22	0.19	0.16	0.14	0.13	0.12	0.11	0.06									16NR13UN
12	1.22	0.24	0.22	0.18	0.16	0.13	0.12	0.11	0.06									16NR12UN
11	1.33	0.24	0.22	0.2	0.15	0.12	0.12	0.11	0.11	0.06								16NR11UN
10	1.47	0.25	0.22	0.21	0.14	0.13	0.12	0.12	0.11	0.11	0.06							16NR10UN
9	1.63	0.31	0.23	0.21	0.17	0.15	0.14	0.13	0.12	0.11	0.06							16NR9UN
8	1.83	0.31	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.11	0.06						16NR8UN
7	2.09	0.36	0.3	0.24	0.21	0.18	0.17	0.16	0.15	0.14	0.12	0.06						16NR7UN
6	2.44	0.4	0.33	0.25	0.23	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.11	0.06				16NR6UN
5	2.93	0.41	0.35	0.31	0.26	0.23	0.21	0.2	0.19	0.17	0.15	0.14	013	0.12	0.06			16NR5UN

NPT-60° 美制锥螺纹 - 内螺纹　　NPT-60° -Internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
27	0.753	0.15	0.13	0.1	0.1	0.09	0.06										11NR27NPT	16NR27NPT
18	1.129	0.25	0.19	0.16	0.13	0.12	0.11	0.1	0.06								11NR18NPT	16NR18NPT
14	1.451	0.28	0.22	0.18	0.16	0.13	0.12	0.11	0.1	0.09	0.06						11NT14NPT	16NR14NPT
11.5	1.767	0.29	0.22	0.19	0.17	0.15	0.13	0.13	0.12	0.11	0.1	0.09	0.06					16NR11.5NPT
8	2.54	0.38	0.31	0.25	0.21	0.19	0.16	0.15	0.14	0.13	0.12	0.12	0.11	.011	0.1	0.06		16NR8NPT

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

W-55° 惠氏螺纹 - 内螺纹　　whitworth-55° Full profile-internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
28	0.58	0.17	0.14	0.11	0.1	0.06											11NR28W	16NR28W
26	0.63	0.18	0.15	0.13	0.11	0.06											11NR24W	16NR24W
20	0.81	0.2	0.18	0.14	0.12	0.11	0.06										11NR20W	16NR20W
19	0.86	0.21	0.19	0.15	0.13	0.12	0.06										11NR19W	16NR19W
18	0.9	0.25	0.19	0.15	0.13	0.12	0.06										11NR18W	16NR18W
16	1.02	0.21	0.18	0.15	0.13	0.11	0.09	0.09	0.06								11NR16W	16NR16W
14	1.16	0.23	0.21	0.17	0.14	0.12	0.12	0.11	0.06								11NR14W	16NR14W
12	1.36	0.27	0.25	0.2	0.16	0.15	0.14	0.13	0.06									16NR12W
11	1.48	0.27	0.24	0.2	0.17	0.15	0.14	0.13	0.12	0.06								16NR11W
10	1.63	0.27	0.25	0.2	0.17	0.15	0.15	0.13	0.13	0.12	0.06							16NR10W
9	1.81	0.28	0.26	0.21	0.18	0.16	0.15	0.14	0.13	0.12	0.12	0.06						16NR9W
8	2.03	0.3	0.27	0.22	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.12	0.06					16NR8W
7	2.32	0.34	0.32	0.26	0.22	0.2	0.18	0.17	0.16	0.15	0.14	0.12	0.06					16NR7W
6	2.71	0.35	0.33	0.27	0.23	0.21	0.2	0.19	0.17	0.16	0.15	0.14	0.13	0.12	0.06			16NR6W
5	3.25	0.42	0.4	0.35	0.29	0.26	0.24	0.22	0.2	0.19	0.18	0.17	0.15	0.12	0.06			16NR5W

BSPT-55° 英制管螺纹 - 内螺纹　　BSPT-55° -Internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
19	0.86	0.22	0.19	0.15	0.12	0.12	0.06										11NR19BSPT	16NR19BSPT
14	1.16	0.24	0.2	0.17	0.14	0.12	0.12	0.11	0.06								11NR14BSPT	16NR14BSPT
11	1.48	0.25	0.23	0.21	0.18	0.16	0.14	0.13	0.12	0.06								16NR11BSPT

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

TR-30° 梯形螺纹 - 内螺纹　　TR-30° -Internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
1.5	0.9	0.23	0.21	0.16	0.13	0.11	0.06										16NR1.5TR	
2	1.25	0.29	0.26	0.21	0.17	0.14	0.12	0.06									16NR2.0TR	
3	1.75	0.32	0.31	0.24	0.19	0.18	0.17	0.15	0.13	0.06							16NR3.0TR	
4	2.25	0.33	0.32	0.24	0.22	0.21	0.17	0.16	0.15	0.14	0.13	0.12	0.06				22NR4.0TR	
5	2.75	0.35	0.32	0.26	0.24	0.22	0.21	0.19	0.19	0.17	0.15	0.14	0.13	0.12	0.06		22NR5.0TR	
6	3	0.38	0.35	0.32	0.28	0.25	0.22	0.2	0.18	0.16	0.14	0.12	0.1	0.08	0.06	...	22NR6.0TR	
7	3.5	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	0.1	0.08	...	27VNR7.0TR	
8	4	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	0.1	...	27VNR8.0TR	
9	4.5	0.48	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	...	27VNR9.0TR	
10	5	0.48	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	...	27VNR10.0TR	
12	6	0.48	0.45	0.41	0.38	0.36	0.33	0.3	0.27	0.24	0.21	0.19	0.17	0.15	0.12	...	27VNR12.0TR	

AMCE-29° 美制梯形螺纹 - 内螺纹　　ACME-29° -Internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
12	1.19	0.27	0.23	0.2	0.17	0.14	0.12	0.06	0.06								16NR12ACME	
10	1.52	0.29	0.25	0.21	0.18	0.16	0.14	0.12	0.11	0.06							16NR10ACME	
8	1.84	0.3	0.26	0.22	0.19	0.16	0.15	0.14	0.13	0.12	0.11	0.06					16NR8ACME	
6	2.37	0.34	0.3	0.27	0.24	0.21	0.19	0.16	0.14	0.12	0.12	0.11	0.11	0.06			22NR6ACME	
5	2.79	0.36	0.33	0.3	0.26	0.23	0.2	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.06		22NR5ACME	
4	3.43	0.4	0.36	0.33	0.3	0.26	0.23	0.2	0.18	0.17	0.16	0.15	0.14	0.13	0.12	...	22NR4ACME	

螺纹刀片进刀量推荐值

theading insert cutting times within definite depth for reference

STACME-29° 美制梯形螺纹 - 内螺纹　　Stub ACME-29° -Internal

螺距 (TPI) Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
16	0.6	0.18	0.14	0.12	0.1	0.06											16NR16STACME	
14	0.67	0.18	0.14	0.12	0.1	0.07	0.06										16NR14STACME	
12	0.76	0.18	0.16	0.14	0.12	0.1	0.08	0.06									16NR12STACME	
10	1.02	0.22	0.18	0.16	0.14	0.12	0.12	0.1	0.06								16NR10STACME	
8	1.21	0.24	0.2	0.18	0.14	0.12	0.11	0.08	0.08	0.06							16NR8STACME	
6	1.52	0.3	0.24	0.2	0.18	0.14	0.12	0.12	0.08	0.08	0.06						22NR6STACME	
5	1.78	0.34	0.28	0.22	0.2	0.16	0.14	0.12	0.1	0.08	0.08	0.06					22NR5STACME	
4	2.16	0.37	0.34	0.28	0.22	0.2	0.16	0.14	0.12	0.1	0.08	0.08	0.06				22NR4STACME	

RD-30° 德标 DIN405 圆螺纹 - 内螺纹　　Round DIN405-30° -Internal

螺距（mm） Pitch	总切削深度 Cutiing depth	加工步数 Cutting steps															适用刀片示例	
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	全牙型刀片	
10	1.27	0.23	0.21	0.2	0.19	0.16	0.12	0.1	0.06								16NR10RD	
8	1.59	0.23	0.21	0.2	0.19	0.18	0.16	0.14	0.12	0.1	0.06						16NR8RD	
6	2.12	0.26	0.25	0.24	0.22	0.21	0.19	0.17	0.16	0.14	0.12	0.1	0.06				16NR6RD	
4	3.18	0.34	0.33	0.32	0.3	0.28	0.26	0.24	0.22	0.2	0.19	0.17	0.15	0.12	0.06		22NR4RD	

螺纹识别表 thread identification table

特征代号	名称	牙型（牙型角或牙侧角、锥度）	标记示例	适用刀片示例	国家、地区及标准编号
Code	Description	Thread angle	Example of marking	insert	Example of marking
ACME	爱克母螺纹	牙型角 29° 锥度 0	1-3/4-4ACME-2G	22ER4ACME	澳大利亚 AS B202-1962
					英国 BS 1104:1957
					新西兰 NZS 1342:1958
					美国 ASME B1.5-1997
STUB ACME	矮牙爱克母螺纹	牙型角 29° 锥度 0	0.5"-16STUB ACME	16ER16STACME	美国 ASME B1.8-1997
API Sucker Rod	美国石油学会抽油杆螺纹	牙型角 60°	3/4" API Sucker Rod	16ER10APIRD	罗马尼亚 STAS 329-80
					美国 API Spec 11B-1986
B.S.F.	惠氏细牙螺纹	牙型角 55° 锥度 0	1/2"-16B.S.F.	16ER16W	澳大利亚 AS 3501-1987
					英国 BS 84-1956
					马来西亚 MS 218:1974
B.S.W.	惠氏粗牙螺纹	牙型角 55° 锥度 0	1/4"-20B.S.W.	16ER20W	澳大利亚 AS 3501-1987
					英国 BS84-1956
					马来西亚 MS 218:1974
Butt	锯齿螺纹 牙侧角 7° /45° 锥度 0		2.5"-8 Butt-2A	16ER8BBUT	美国 ANSI B1.9-1973
Buttress			2.0 BS Buttress thead 8tpi mediun class	16ER8ABUT	澳大利亚 AS B182-1961
					英国 BS 1657:1950
					新西兰 NZS 955:1951
G	55° 非密封管螺纹	牙型角 55° 锥度 0	G1-1/2 G1-1/2A G1-1/2B	16ER11W	国际 ISO 228-1:2000
					中国 GB/T7307-2001
					德国 DIN ISO228-1:2001
					法国 pr NF EN ISO 228-1:2002
					英国 BS 2779:1986
					俄罗斯 GOST 6357-81
					日本 JIS B0202-1999
					澳大利亚 AS1722:PART 2-1975
					巴西 NBR 6414/83
					意大利 UNI ISO 228-1
NPT	一般密封圆锥管螺纹	牙型角 60° 锥度 1:16	NPT3/8 3/8-18NPT	16ER18NPT	中国 GB/T 12716-2002
					厄瓜多尔 INEN117
					法国 NF E03-601, NF E29-684
					俄罗斯 GOST 6111
					美国 ASME B1.20.1-1983
NPTF	干密封圆锥管螺纹	牙型角 60° 锥度为 1:16	1/8-27NPTF-1	11ER27NPTF	瑞典 SMS1704, SMS1706, SMS1707
					美国 ANSI B1.20.3-1976
UN	美制统一螺纹	牙型角 60° 锥度 0	2-1/2-16UN-2B	16ER16UN	国际 ISO 68-2:1998, ISO263:1973, ISO 725:1978, ISO 5864:1993
					澳大利亚 AS B133:part1~2
					中国 GB/T 20667~20670-2006
					丹麦 DS/ISO 263.DS/ISO 725
					英国 BS ISO 68-2:1998, BS 1580-1~1580-3
					新西兰 NZS 1227
					瑞典 SMS 1713
					美国 ASME B1.1-1989

螺纹识别表 thread identification table

特征代号	名称	牙型（牙型角或牙侧角、锥度）	标记示例	适用刀片示例	国家、地区及标准编号
Code	Description	Thread angle	Example of marking	insert	Example of marking
TR	ISO 米制梯形螺纹	牙型角 30° 锥度 0	TR40*6	22ER6.0TR	国际 ISO2901, ISO2903-1993 ISO2902, ISO2904-1977
					中国 GB/T5796.1~5796.4-2005 BT/T12359-2008
					德国 DIN103 T1~T8 DIN263 T1~T2, DIN6341
					法国 NF ISO0901~2903:1997
					英国 NF BS5346:1976
					日本 JIS B0216~0218
					俄罗斯 GOST 9484, GOST 9562 GOST 24737, GOST 24738 GOST24739-1981
					意大利 UNI ISO 2901-2904
					荷兰 NEN2780~2784
					印度 IS:7008(part1~4)-1973
					芬兰 SFS4499~4502
W	惠氏螺纹	牙型角 55° 锥度 0	W3/16	16ER24W	阿根廷 IRAM 5030. IRAM 5036
					瑞士 SNV 24460. SNV 219504
					德国 DIN477 TI, DIN4668, DIN49301
					意大利 UNI2708~2709
					瑞典 SMS 3 B
Rc	55° 密封圆锥内螺纹	牙型角 55° 锥度 1:16	Rc1-1/4	16NR11BSPT	国际 ISO 7-1:1994
					中国 GB/T 7306.2-2000
					法国 NF E03-004
					英国 BS 21:1985
					印度 IS:554-1975
					意大利 UNI ISO7-1
					日本 JIS B 0203-1999
					俄罗斯 GOST 6211-81
					瑞典 SS ISO 7-1
API	石油钻杆接头螺纹	牙型角 60° 锥度 1:4, 1:6, 1:8	API NC26(2-3/8F) API IF THD 4-1/2REG API3-1/2FH	22ER4API***	中国 GB/T 9253.1-1999
					美国 API Spec7-1985
SAGE	锯齿螺纹	牙型角 3° /30° 锥度 0	B40X6-6C	27VNR6.0SAGE	中国 GB/T 13576
					德国 DIN513
RD	圆螺纹	牙型角 30° 锥度 0	RD40-1/6	16NR6RD	德国 DIN405
Pg	钢导管螺纹	牙型角 80° 锥度 0	Pg16	16NR16Pg	德国 DIN40430

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MP 系列铣槽刀具 MP milling grooving tools 117-118

TT 系列铣槽刀具 TT milling grooving tools 119-121

切槽切断刀具 GROOVING & PARTING TOOLS 123-175

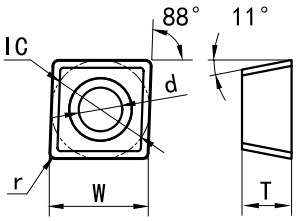
MP 系列铣槽刀片 Grooving Milling insert

型号 Model	IC (mm)	T (mm)	d (mm)
MPHT06*	6.35	3.18	2.8
MPHT08*	8.3	3.18	3.4
MPHT12*	12.7	4.76	5.56

☺ 优先推荐 Good recommendation

☹ 一般推荐 General recommendation

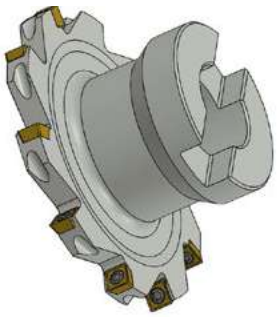
材质推荐 material recommended				
钢	P	☺	☺	
不锈钢	M	☺	☺	
铸铁	K	☹	☹	
有色金属	N			☺

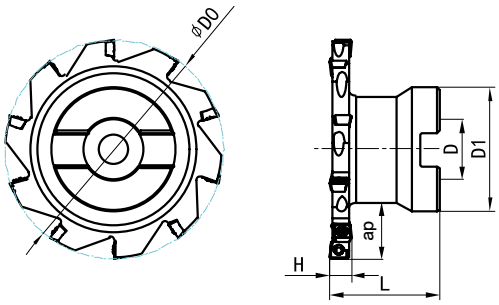


刀片 Insert	左手刀片 Left hand	刃宽 W	圆弧 r	DP220	DM215	DK110	配套刀具 Toolholders
	MPHT060304-M	6.35	0.4	●	●		如下
	MPHT080305-M	8.3	0.5	●	●		
	MPHT120408-M	12.7	0.8	●	●		

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

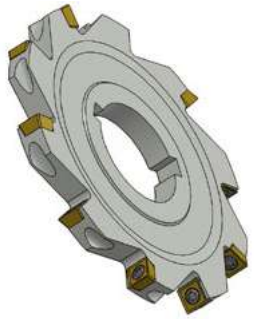
三面刃铣槽刀盘 Grooving Milling Holders

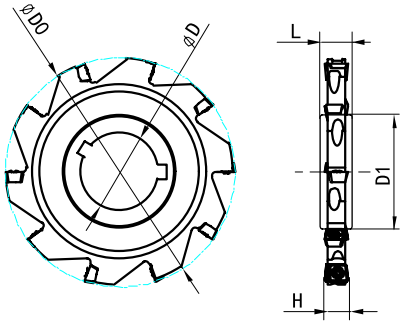




刀杆型号 Toolholder Type	刀片型号 Insert Type	刃数 NO. of insert	尺寸 Dimensions (mm) D0	H	ap	L	D	D1	接口形式 Adapter	螺钉 Insert Screw	扳手 Torx Key
SMT80-22BM06-10-H08	MPHT060304-M	10	80	8	21	40	22	45	A	L60M2.5*6.5	T08
SMT100-27BM06-14-H08		14	100	8	24	40	27	55	B	L60M2.5*6.5	T08
SMT100-27BM06-14-H10		14	100	10	24	40	27	55	B	L60M2.5*6.5	T08
SMT125-32CM06-16-H10		16	125	10	33	45	32	65	B	L60M5*11	T08
SMT125-32CM08-12-H12	MPHT080305-M	12	125	12	33	45	32	65	B	L60M3*7	T10
SMT160-40CM08-14-H12		14	160	12	45	45	40	80	B	L60M3*7	T10
SMT200-40CM08-18-H12		18	200	12	53	50	40	92	C	L60M3*7	T10
SMT125-32CM12-10-H16	MPHT120408-M	10	125	16	30	50	32	65	B	L60M5*11	T20
SMT160-40DM12-12-H16		12	160	16	45	60	40	80	B	L60M5*11	T20
SMT160-40DM12-12-H18		12	160	18	45	60	40	80	B	L60M5*11	T20
SMT200-40CM12-14-H16		14	200	16	53	50	40	92	C	L60M5*11	T20
SMT200-40CM12-14-H18		14	200	18	53	50	40	92	C	L60M5*11	T20
SMT200-40CM12-14-H20		14	200	20	53	50	40	92	C	L60M5*11	T20

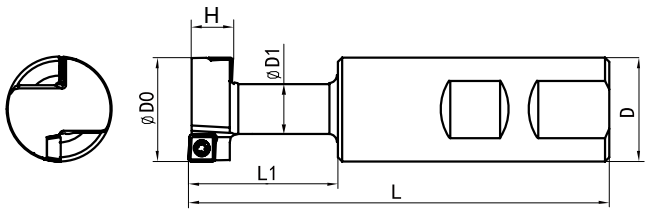
三面刃铣槽刀盘 Grooving Milling Holders





刀杆型号 Toolholder Type	刀片型号 Insert Type	刃数 NO. of insert	尺寸 Dimensions (mm) D0	H	L	D	D1	螺钉 Insert Screw	扳手 Torx Key
SMT80-XS27BM06-10-H08	MPHT060304-M	10	80	8	12	27	41	L60M2.5*6.5	T08
SMT100-XS32BM06-14-H08		14	100	8	12	32	47	L60M2.5*6.5	T08
SMT100-XS32BM06-14-H10		14	100	10	14	32	47	L60M2.5*6.5	T08
SMT125-XS40CM06-16-H10		16	125	10	14	40	55	L60M5*11	T08
SMT125-XS40CM08-12-H12	MPHT080305-M	12	125	12	16	40	55	L60M3*7	T10
SMT160-XS40CM08-14-H12		14	160	12	16	40	62	L60M3*7	T10
SMT160-XS40CM12-12-H16	MPHT120408-M	12	160	16	20	40	62	L60M5*11	T20
SMT160-XS40DM12-12-H18		12	160	18	24	40	62	L60M5*11	T20
SMT160-XS40DM12-12-H20		12	160	20	26	40	62	L60M5*11	T20
SMT200-XS50DM12-14-H16		14	200	16	20	50	72	L60M5*11	T20
SMT200-XS50DM12-14-H18		14	200	18	24	50	72	L60M5*11	T20
SMT200-XS50DM12-14-H20		14	200	20	26	50	72	L60M5*11	T20

三面刃铣槽刀杆 Grooving Milling Holders



刀杆型号 Toolholder Type	刀片型号 Insert Type	刃数 NO. of insert	尺寸 Dimensions (mm) D0	H	L1	L	D	D1	螺钉 Insert Screw	扳手 Torx Key
SMT21-32HM06-1-H09	MPHT060304-M	1	21	9	32	100	25	10	L60M2.5*6.5	T08
SMT25-35HM06-1-H11		1	25	11	35	100	25	12	L60M2.5*6.5	T08
SMT32-45JM08-2-H14	MPHT080305-M	2	32	14	45	110	32	15	L60M3*7	T10
SMT40-55KM12-2-H18	MPHT120408-M	2	40	18	55	125	32	19	L60M5*11	T20
SMT50-65MM12-2-H22		2	50	22	65	140	40	25	L60M5*11	T20

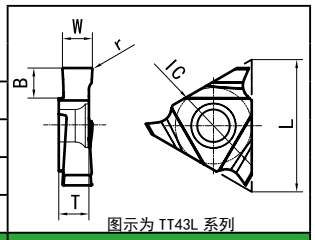
TT 系列铣槽刀片 Grooving Milling insert

型号 Model	L (mm)	IC (mm)	T (mm)	d (mm)
TGF32L	16	9.525	3.18	4.5
TT43L	22	12.7	5	5.45

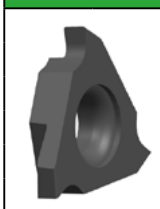
☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺	☺	
不锈钢	M	☺	☺	
铸铁	K	😐	😐	
有色金属	N			☺

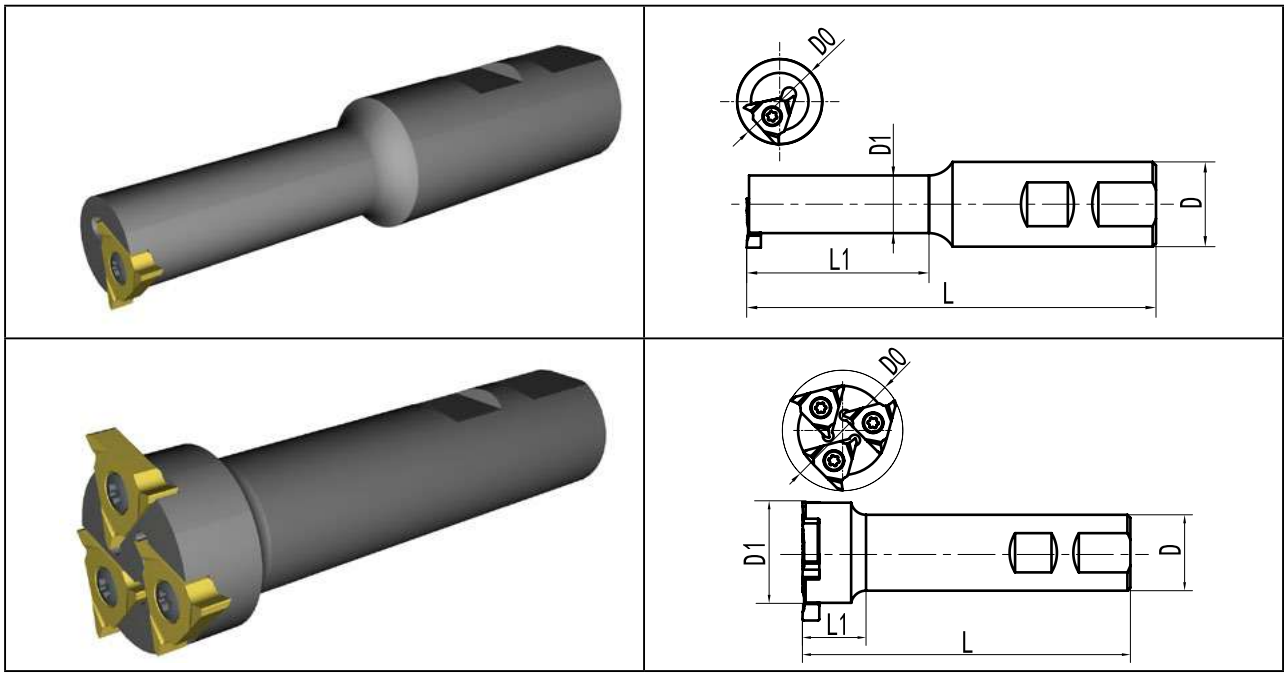


图示为 TT43L 系列

刀片 Insert	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	BR215	PM125	DK110	配套刀杆 Toolholders
	TGF32L150	1.5	2.0	0.1	●	●	○	SMT25-25KT32-1 SMT32-32MT32-1
	TGF32L200	2.0	2.8	0.15	●	●	○	
	TGF32L250	2.5	2.8		●	●	○	
	TGF32L300	3.0	2.8		●	●	○	
	TGF32L350	3.5	2.8		●	●	○	
	TGF32 系列其他型号见 121 页							
	TT43L200	2.0	4.8	0.2	●	●	○	SMT44-25JT43-3 SMT63-22CT43-6
	TT43L250	2.5	4.8		●	●	○	
	TT43L300	3.0	4.8		●	●	○	
	TT43L350	3.5	4.8		●	●	○	
	TT43L400	4.0	4.8		●	●	○	
	TT43L500	5.0	4.8		●	●	○	
	TT43L200-R1.0	2.0	4.8	1.0	●	●	○	
	TT43L250-R1.25	2.5	4.8	1.25	●	●	○	
	TT43L300-R1.5	3.0	4.8	1.5	●	●	○	
	TT43L350-R1.75	3.5	4.8	1.75	●	●	○	
	TT43L400-R2.0	4.0	4.8	2.0	●	●	○	

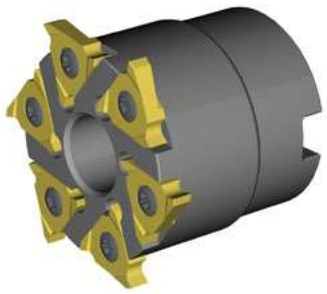
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

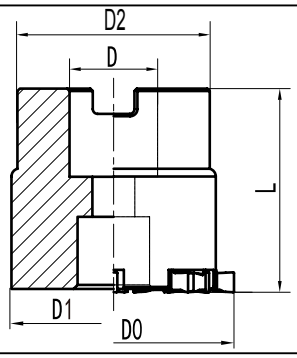
铣槽刀杆 Grooving Milling Holders



刀杆型号 Toolholder Type	刀片型号 Insert Type	刃数 NO. of insert	尺寸 Dimensions (mm)					螺钉 Insert Screw	扳手 Torx Key
			D0	L1	L	D	D1		
SMT25-25KT32-1	TGF32L**	1	25	56	120	25	19	L60M4*10	T15
SMT32-32MT32-1		1	32	77	150	32	25	L60M4*10	T15
SMT44-25JT43-3	TT43L**	3	44	-	110	25	33	L60M5*11	T20

铣槽刀盘 Grooving Milling Toolholders





刀板型号 Toolholder Type	刀片型号 Insert Type	刃数	尺寸 Dimensions (mm)					螺钉 Insert Screw	扳手 Torx Key
		NO. of insert	D0	L	D	D1	D2		
SMT63-22CT43-6	TT43L**	6	63	50	22	51	48	L60M5*11	T20
SMT80-27CT43-8	TT43L**	8	80	50	27	68	60	L60M5*11	T20

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GK 系列内孔大切深槽刀片 GK Internal grooving insert	143-144
GE 内孔切槽刀具 GE Grooving tools	145-148
GE 端面切槽刀具 GE Circlip Grooving tools	149-152
VC 系列端面切槽刀片 VC Internal circlip grooving insert	153-154
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TKF、TKFB 切槽、切断刀具 TKF TKFB Grooving & parting tools	158-163
THC42 切槽、切断刀具 THC42 Grooving & parting tools	164-165
MGMN 切槽、切断刀具 MGMN Grooving & parting tools	166-169
GX 切槽、切断刀具 QCD Grooving & parting tools	170
TD 切槽、切断刀具 TD Grooving & parting tools	171-175

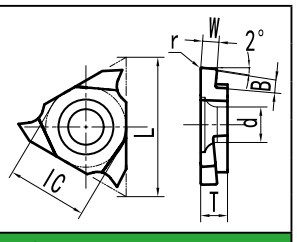
TGF32 标准型刀片 TGF32 Grooving Insert

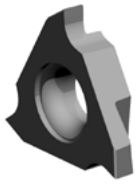
型号 Model	L (mm)	IC (mm)
TGF32**	16	9.525

☺ 优先推荐 Good recommendation

☺ 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	☺	
有色金属	N		☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) T	尺寸 Dimensions (mm) d
	TGF32R030	TGF32L030	0.30	0.8	0.03	●	●	●	○	3.18	4.5
	TGF32R033	TGF32L033	0.33	0.8	0.03	●	●	●	○		
	TGF32R045	TGF32L045	0.45	0.8	0.03	●	●	●	○		
	TGF32R050	TGF32L050	0.50	1.0	0.05	●	●	●	○		
	TGF32R060	TGF32L060	0.60	1.0	0.05	●	●	●	○		
	TGF32R065	TGF32L065	0.65	1.4	0.05	●	●	●	○		
	TGF32R070	TGF32L070	0.70	1.4	0.05	●	●	●	○		
	TGF32R075	TGF32L075	0.75	2.2	0.10	●	●	●	○		
	TGF32R080	TGF32L080	0.80	2.2	0.10	●	●	●	○		
	TGF32R085	TGF32L085	0.85	2.2	0.10	●	●	●	○		
	TGF32R090	TGF32L090	0.90	2.2	0.10	●	●	●	○		
	TGF32R095	TGF32L095	0.95	2.2	0.10	●	●	●	○		
	TGF32R100	TGF32L100	1.00	2.2	0.10	●	●	●	○		
	TGF32R110	TGF32L110	1.10	2.2	0.10	●	●	●	○		
	TGF32R115	TGF32L115	1.15	2.2	0.10	●	●	●	○		
	TGF32R120	TGF32L120	1.20	2.2	0.10	●	●	●	○		
	TGF32R125	TGF32L125	1.25	2.2	0.10	●	●	●	○		
	TGF32R130	TGF32L130	1.30	2.2	0.10	●	●	●	○		
	TGF32R135	TGF32L135	1.35	2.2	0.10	●	●	●	○		
	TGF32R140	TGF32L140	1.40	2.2	0.10	●	●	●	○		
	TGF32R145	TGF32L145	1.45	2.2	0.10	●	●	●	○		
	TGF32R150	TGF32L150	1.50	2.4	0.10	●	●	●	○		
	TGF32R155	TGF32L155	1.55	2.4	0.10	●	●	●	○		
	TGF32R160	TGF32L160	1.60	2.4	0.10	●	●	●	○		
	TGF32R165	TGF32L165	1.65	2.4	0.10	●	●	●	○		
	TGF32R170	TGF32L170	1.70	2.4	0.10	●	●	●	○		
	TGF32R175	TGF32L175	1.75	2.4	0.10	●	●	●	○		
	TGF32R180	TGF32L180	1.80	2.4	0.10	●	●	●	○		
	TGF32R185	TGF32L185	1.85	2.4	0.10	●	●	●	○		
	TGF32R190	TGF32L190	1.90	2.4	0.10	●	●	●	○		
	TGF32R200	TGF32L200	2.00	3.0	0.15	●	●	●	○		
	TGF32R210	TGF32L210	2.10	3.0	0.15	●	●	●	○		
	TGF32R215	TGF32L215	2.15	3.0	0.15	●	●	●	○		
	TGF32R220	TGF32L220	2.20	3.0	0.15	●	●	●	○		
	TGF32R225	TGF32L225	2.25	3.0	0.15	●	●	●	○		
	TGF32R230	TGF32L230	2.30	3.0	0.15	●	●	●	○		
	TGF32R240	TGF32L240	2.40	3.0	0.15	●	●	●	○		
	TGF32R250	TGF32L250	2.50	3.0	0.15	●	●	●	○		
	TGF32R260	TGF32L260	2.60	3.0	0.15	●	●	●	○		

* 可定制特殊宽度，以及特殊圆弧角

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

其他型号见下页
See next page for other models

接上页 Connect to the previous page

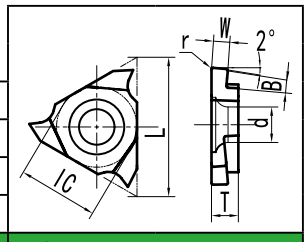
TGF32 标准型刀片 TGF32 Grooving Insert

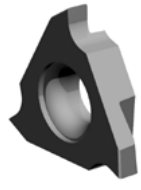
型号 Model	L (mm)	IC (mm)
TGF32**	16	9.525

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) T	尺寸 Dimensions (mm) d
	TGF32R265	TGF32L265	2.65	3.0	0.15	●	●	●	○	3.18	4.5
	TGF32R270	TGF32L270	2.70	3.0	0.15	●	●	●	○		
	TGF32R275	TGF32L275	2.75	3.0	0.15	●	●	●	○		
	TGF32R280	TGF32L280	2.80	3.0	0.15	●	●	●	○		
	TGF32R300	TGF32L300	3.00	3.0	0.20	●	●	●	○		
	TGF32R320	TGF32L320	3.20	3.0	0.20	●	●	●	○		

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

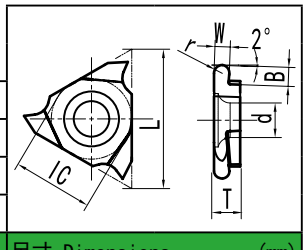
TGF32 球头型刀片 TGF32 Ball Type Insert

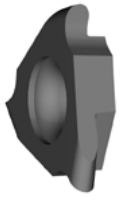
型号 Model	L (mm)	IC (mm)
TGF32**	16	9.525

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) T	尺寸 Dimensions (mm) d
	TGF32R050-R0.25	TGF32L050-R0.25	0.5	1.0	0.25	●	●	●	○	3.18	4.5
	TGF32R060-R0.30	TGF32L060-R0.30	0.6	2.3	0.30	●	●	●	○		
	TGF32R070-R0.35	TGF32L070-R0.35	0.7	2.3	0.35	●	●	●	○		
	TGF32R080-R0.40	TGF32L080-R0.40	0.8	2.3	0.40	●	●	●	○		
	TGF32R090-R0.45	TGF32L090-R0.45	0.9	2.3	0.45	●	●	●	○		
	TGF32R100-R0.50	TGF32L100-R0.50	1.0	3.6	0.50	●	●	●	○		
	TGF32R110-R0.55	TGF32L110-R0.55	1.1	3.6	0.55	●	●	●	○		
	TGF32R120-R0.60	TGF32L120-R0.60	1.2	3.6	0.60	●	●	●	○		
	TGF32R130-R0.65	TGF32L130-R0.65	1.3	3.6	0.65	●	●	●	○		
	TGF32R140-R0.70	TGF32L140-R0.70	1.4	3.6	0.70	●	●	●	○		
	TGF32R150-R0.75	TGF32L150-R0.75	1.5	3.6	0.75	●	●	●	○		
	TGF32R160-R0.80	TGF32L160-R0.80	1.6	3.6	0.80	●	●	●	○		
	TGF32R170-R0.85	TGF32L170-R0.85	1.7	3.6	0.85	●	●	●	○		
	TGF32R180-R0.90	TGF32L180-R0.90	1.8	3.6	0.90	●	●	●	○		
	TGF32R190-R0.95	TGF32L190-R0.95	1.9	3.6	0.95	●	●	●	○		
	TGF32R200-R1.00	TGF32L200-R1.00	2.0	3.6	1.00	●	●	●	○		
	TGF32R210-R1.05	TGF32L210-R1.05	2.1	3.6	1.05	●	●	●	○		
	TGF32R220-R1.10	TGF32L220-R1.10	2.2	3.6	1.10	●	●	●	○		
	TGF32R230-R1.15	TGF32L230-R1.15	2.3	3.6	1.15	●	●	●	○		

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

其他型号见下页
See next page for other models

接上页 Connect to the previous page

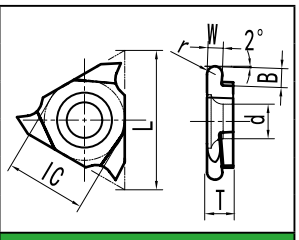
TGF32 球头型刀片 TGF32 Ball Type Insert

型号 Model	L (mm)	IC (mm)
TGF32**	16	9.525

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) T	尺寸 Dimensions (mm) d
	TGF32R240-R1.20	TGF32L240-R1.20	2.4	3.6	1.2	●	●	●	○	3.18	4.5
	TGF32R250-R1.25	TGF32L250-R1.25	2.5	3.6	1.25	●	●	●	○		
	TGF32R260-R1.30	TGF32L260-R1.30	2.6	3.6	1.3	●	●	●	○		
	TGF32R270-R1.35	TGF32L270-R1.35	2.7	3.6	1.35	●	●	●	○		
	TGF32R280-R1.40	TGF32L280-R1.40	2.8	3.6	1.4	●	●	●	○		
	TGF32R290-R1.45	TGF32L280-R1.45	2.9	3.6	1.45	●	●	●	○		
	TGF32R300-R1.50	TGF32L300-R1.50	3.0	3.6	1.5	●	●	●	○		
	TGF32R310-R1.55	TGF32L310-R1.55	3.1	3.6	1.55	●	●	●	○		
	TGF32R320-R1.60	TGF32L320-R1.60	3.2	3.6	1.6	●	●	●	○		

* 可定制特殊宽度，以及特殊圆弧角

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

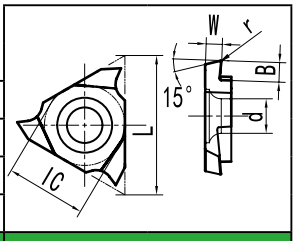
TGF32 斜刃型刀片　TGF32 Parting-off Insert

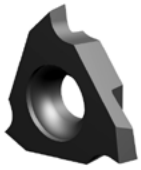
型号 Model	L (mm)	IC (mm)
TGF32**	16	9.525

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N		☺	



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	角度 α	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) d	T
	TGF32R050-S15R	TGF32L050-S15R	0.50	15	1.2	0.05	●	●	●	○	4.5	3.18
	TGF32R075-S15R	TGF32L075-S15R	0.75	15	2.3	0.1	●	●	●	○		
	TGF32R080-S15R	TGF32L080-S15R	0.80	15	2.3	0.1	●	●	●	○		
	TGF32R100-S15R	TGF32L100-S15R	1.00	15	3.7	0.1	●	●	●	○		
	TGF32R110-S15R	TGF32L110-S15R	1.10	15	3.7	0.1	●	●	●	○		
	TGF32R125-S15R	TGF32L125-S15R	1.25	15	3.7	0.1	●	●	●	○		
	TGF32R135-S15R	TGF32L135-S15R	1.35	15	3.7	0.1	●	●	●	○		
	TGF32R150-S15R	TGF32L150-S15R	1.50	15	3.7	0.1	●	●	●	○		
	TGF32R160-S15R	TGF32L160-S15R	1.60	15	3.7	0.1	●	●	●	○		
	TGF32R180-S15R	TGF32L180-S15R	1.80	15	3.7	0.1	●	●	●	○		
	TGF32R200-S15R	TGF32L200-S15R	2.00	15	3.7	0.1	●	●	●	○		
	TGF32R220-S15R	TGF32L220-S15R	2.20	15	3.7	0.1	●	●	●	○		
	TGF32R230-S15R	TGF32L230-S15R	2.30	15	3.7	0.1	●	●	●	○		
	TGF32R240-S15R	TGF32L240-S15R	2.40	15	3.7	0.1	●	●	●	○		
	TGF32R250-S15R	TGF32L250-S15R	2.50	15	3.7	0.1	●	●	●	○		
	TGF32R260-S15R	TGF32L260-S15R	2.60	15	3.7	0.1	●	●	●	○		
	TGF32R270-S15R	TGF32L270-S15R	2.70	15	3.7	0.1	●	●	●	○		
	TGF32R280-S15R	TGF32L280-S15R	2.80	15	3.7	0.1	●	●	●	○		
	TGF32R290-S15R	TGF32L290-S15R	2.90	15	3.7	0.1	●	●	●	○		
	TGF32R300-S15R	TGF32L300-S15R	3.00	15	3.7	0.1	●	●	●	○		

● 常备库存（主推） Standing stock　○ 非常备库存 Extraordinary stock

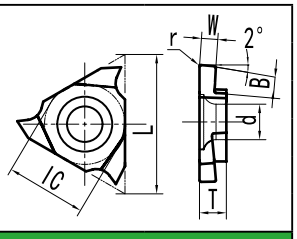
TGF32 大切深型刀片 Large Cutting Depth Insert

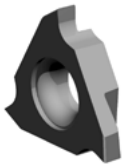
型号 Model	L (mm)	IC (mm)
TGF32**	16	9.525

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



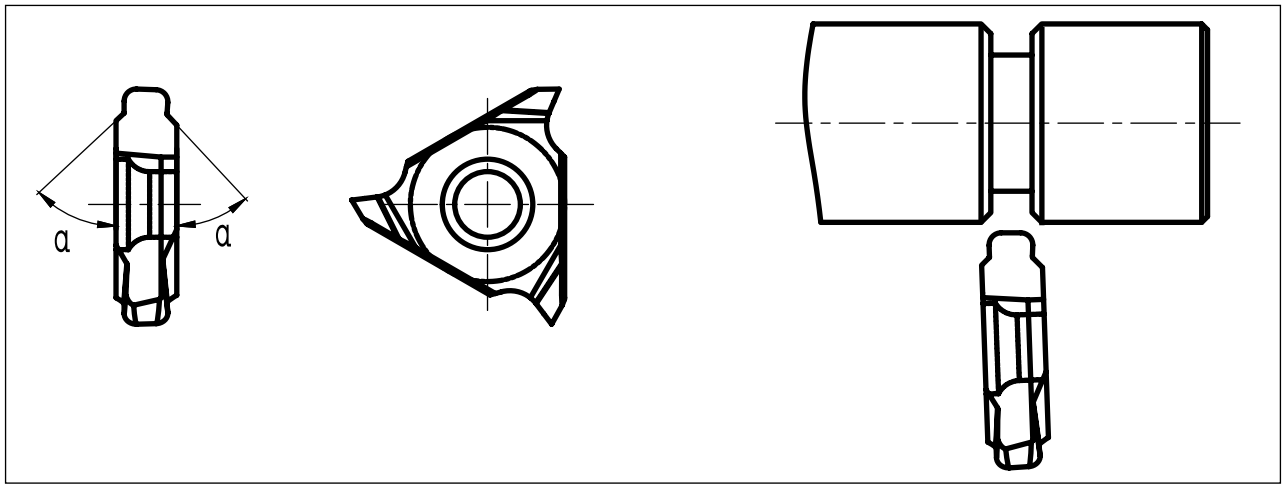
刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) T	尺寸 Dimensions (mm) d
	TGF32R050-L1.20	TGF32L050-L1.20	0.5	1.2	0.05	●	●	●	○	3.18	4.5
	TGF32R060-L1.60	TGF32L060-L1.60	0.6	1.6	0.05	●	●	●	○		
	TGF32R070-L2.20	TGF32L070-L2.20	0.7	2.2	0.05	●	●	●	○		
	TGF32R080-L2.20	TGF32L080-L2.20	0.8	2.2	0.05	●	●	●	○		
	TGF32R090-L2.20	TGF32L090-L2.20	0.9	2.2	0.05	●	●	●	○		
	TGF32R100-L3.70	TGF32L100-L3.70	1.0	3.7	0.1	●	●	●	○		
	TGF32R110-L3.70	TGF32L110-L3.70	1.1	3.7	0.1	●	●	●	○		
	TGF32R120-L3.70	TGF32L120-L3.70	1.2	3.7	0.1	●	●	●	○		
	TGF32R130-L3.70	TGF32L130-L3.70	1.3	3.7	0.1	●	●	●	○		
	TGF32R140-L3.70	TGF32L140-L3.70	1.4	3.7	0.1	●	●	●	○		
	TGF32R150-L3.70	TGF32L150-L3.70	1.5	3.7	0.1	●	●	●	○		
	TGF32R160-L3.70	TGF32L160-L3.70	1.6	3.7	0.1	●	●	●	○		
	TGF32R170-L3.70	TGF32L170-L3.70	1.7	3.7	0.1	●	●	●	○		
	TGF32R180-L3.70	TGF32L180-L3.70	1.8	3.7	0.1	●	●	●	○		
	TGF32R190-L3.70	TGF32L190-L3.70	1.9	3.7	0.1	●	●	●	○		
	TGF32R200-L3.70	TGF32L200-L3.70	2.0	3.7	0.1	●	●	●	○		
	TGF32R210-L3.70	TGF32L210-L3.70	2.1	3.7	0.1	●	●	●	○		
	TGF32R220-L3.70	TGF32L220-L3.70	2.2	3.7	0.1	●	●	●	○		
	TGF32R230-L3.70	TGF32L230-L3.70	2.3	3.7	0.1	●	●	●	○		
	TGF32R240-L3.70	TGF32L240-L3.70	2.4	3.7	0.1	●	●	●	○		
	TGF32R250-L3.70	TGF32L250-L3.70	2.5	3.7	0.1	●	●	●	○		

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

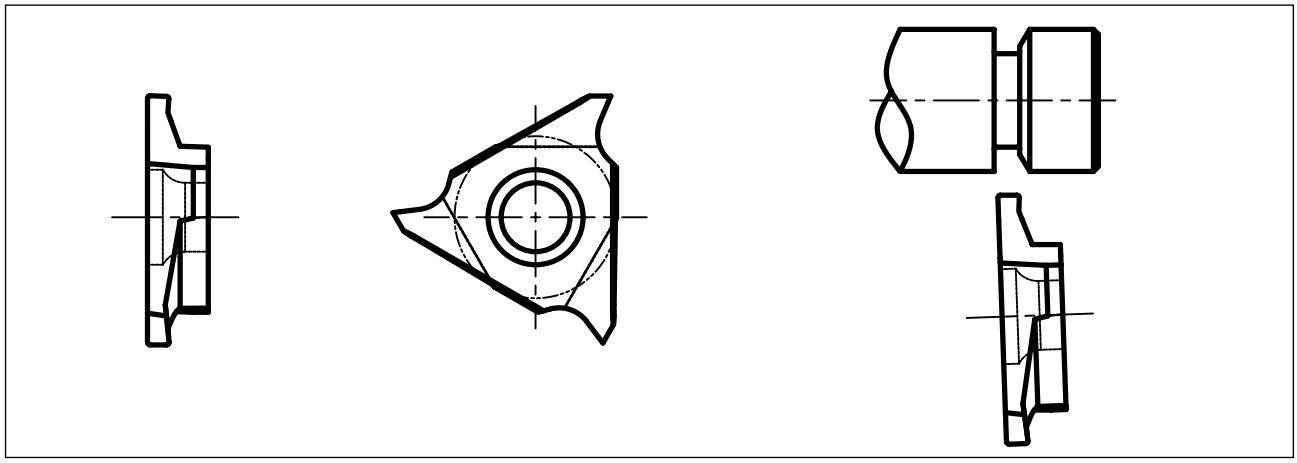
TGF32、DBA43、TT43L 系列非标槽刀片定制说明：

Other type grooving inserts can be customized:

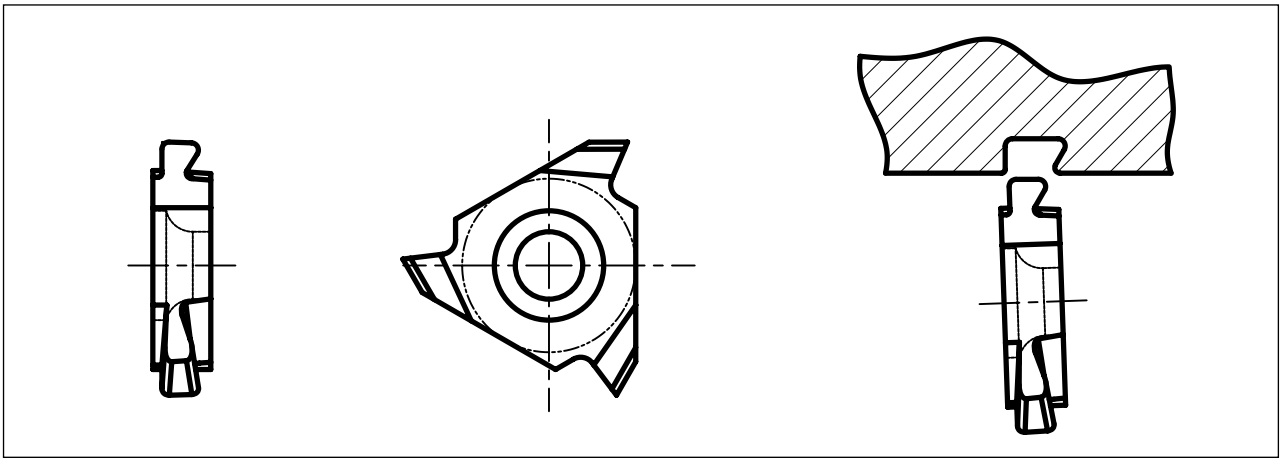
案例一：定制槽口倒角



案例二：单侧指定角度

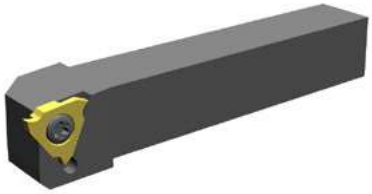


案例三：定制异形槽

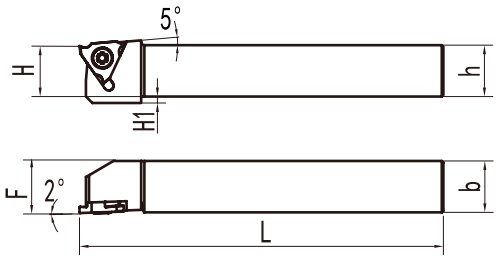


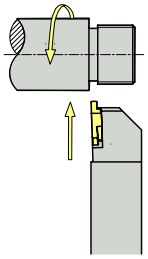
TGF32 外切槽刀杆 External Grooving Tools

形式一：直头型
适用于走芯机

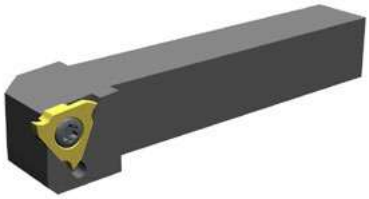


图示为右手刀具 Right hand shown

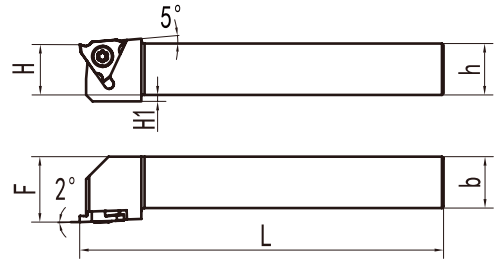


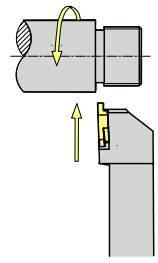


形式二：偏头型



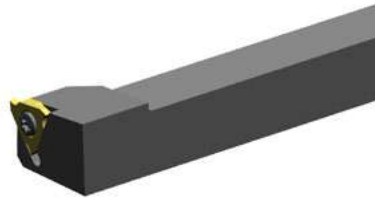
图示为右手刀具 Right hand shown



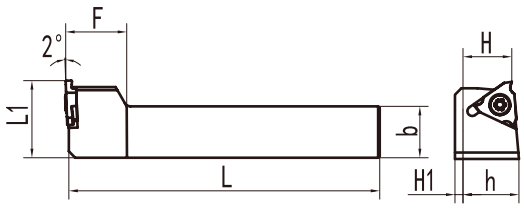


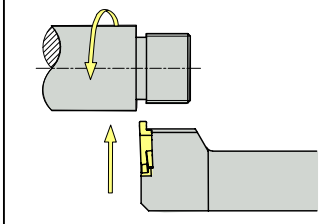
刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)						形式 Type	刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L	H1			
TKGFR	1010K-16F	TGF32R**	10	10	10	10	125	2	一	L60M4*10	T-15
	1212K-16F		12	12	12	12	125	-			
	1212M-16F		12	12	12	12	150	-			
	1616M-16F		16	16	16	16	150	-			
	1212H-16		12	12	12	16	100	-	二		
	1616H-16		16	16	16	20	100	-			
	2020K-16		20	20	20	25	125	-			
	2525M-16		25	25	25	30	150	-			
TKGFL	1010K-16F	TGF32L**	10	10	10	10	125	2	一	L60M4*10	T-15
	1212K-16F		12	12	12	12	125	-			
	1212M-16F		12	12	12	12	150	-			
	1616M-16F		16	16	16	16	150	-			
	1212H-16		12	12	12	16	100	-	二		
	1616H-16		16	16	16	20	100	-			
	2020K-16		20	20	20	25	125	-			
	2525M-16		25	25	25	30	150	-			

TGF32 切槽刀杆 – 排刀机用 Gang-type Grooving Tools



图示为左手刀具 Left hand shown

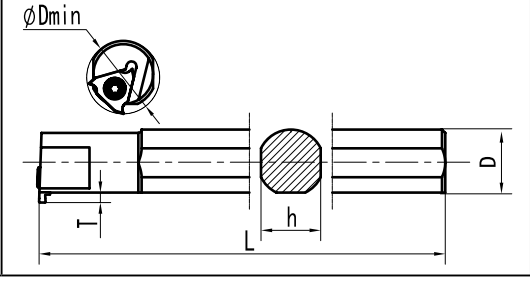


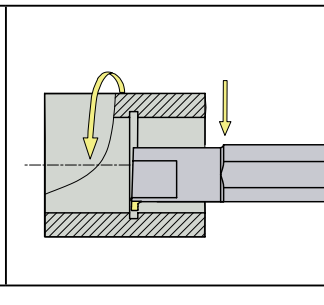


刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
		h	b	H	F	L	H1	L1		
TKGFL1010F-16-A90	TGF32R**	10	10	10	12	85	2	16	L60M4*10	T-15
TKGFL1212H-16-A90		12	12	12	16	100	–	20		
TKGFL1616H-16-A90		16	16	16	20	100	–	24		
TKGFL2020K-16-A90		20	20	20	25	125	–	30		
TKGFL2525M-16-A90		25	25	25	32	150	–	35		

TGF32 内孔切槽刀杆 TGF32/DBA43 Internal Grooving Tools

图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
		Dmin	T	D	H	L		
S16K-SRTGF3219	TGF32L**	19	2.5	16	15	125	L60M4*10	T-15
S20M-SRTGF3223		23		20	19	150		
S25Q-SRTGF3227		27		25	23	180		

说明：当切槽宽度在 2mm 以下时，切槽深度 T 值详见 TGF32L 系列的深度 B

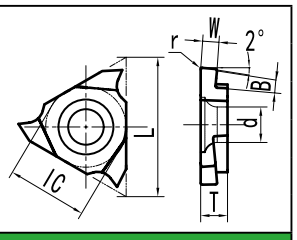
DBA43 标准型刀片 DBA43 Grooving Insert

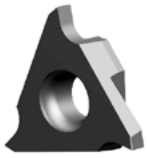
型号 Model	L (mm)	IC (mm)
DBA43**	22	12.7

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) T	d
	DBA43R075	DBA43L075	0.75	2.5	0.1	●	●	●	○	4.76	5.4
	DBA43R100	DBA43L100	1.0	2.5	0.1	●	●	●	○		
	DBA43R120	DBA43L120	1.2	2.5	0.1	●	●	●	○		
	DBA43R130	DBA43L130	1.3	2.7	0.1	●	●	●	○		
	DBA43R140	DBA43L140	1.4	2.7	0.1	●	●	●	○		
	DBA43R145	DBA43L145	1.45	3.0	0.1	●	●	●	○		
	DBA43R150	DBA43L150	1.5	3.0	0.1	●	●	●	○		
	DBA43R160	DBA43L160	1.6	3.0	0.1	●	●	●	○		
	DBA43R170	DBA43L170	1.7	3.3	0.2	●	●	●	○		
	DBA43R175	DBA43L175	1.75	3.3	0.2	●	●	●	○		
	DBA43R180	DBA43L180	1.8	3.3	0.2	●	●	●	○		
	DBA43R185	DBA43L185	1.85	3.3	0.2	●	●	●	○		
	DBA43R195	DBA43L195	1.95	3.3	0.2	●	●	●	○		
	DBA43R200	DBA43L200	2.0	3.5	0.2	●	●	●	○		
	DBA43R210	DBA43L210	2.1	3.5	0.2	●	●	●	○		
	DBA43R220	DBA43L220	2.2	3.5	0.2	●	●	●	○		
	DBA43R225	DBA43L225	2.25	3.5	0.2	●	●	●	○		
	DBA43R230	DBA43L230	2.3	3.5	0.2	●	●	●	○		
	DBA43R240	DBA43L240	2.4	3.5	0.2	●	●	●	○		
	DBA43R250	DBA43L250	2.5	4.2	0.2	●	●	●	○		
	DBA43R265	DBA43L265	2.65	4.2	0.2	●	●	●	○		
	DBA43R270	DBA43L270	2.7	4.2	0.2	●	●	●	○		
	DBA43R280	DBA43L280	2.8	4.6	0.3	●	●	●	○		
	DBA43R300	DBA43L300	3.0	4.6	0.3	●	●	●	○		
	DBA43R320	DBA43L320	3.2	4.6	0.3	●	●	●	○		
	DBA43R325	DBA43L325	3.25	4.6	0.3	●	●	●	○		
	DBA43R330	DBA43L330	3.3	4.8	0.3	●	●	●	○		
	DBA43R350	DBA43L350	3.5	4.8	0.3	●	●	●	○		
	DBA43R360	DBA43L360	3.6	4.8	0.3	●	●	●	○		
	DBA43R380	DBA43L380	3.8	4.8	0.3	●	●	●	○		
	DBA43R400	DBA43L400	4.0	4.8	0.3	●	●	●	○		
	DBA43R420	DBA43L420	4.2	5.0	0.3	●	●	●	○		
	DBA43R450	DBA43L450	4.5	5.0	0.3	●	●	●	○		
	DBA43R460	DBA43L460	4.6	5.0	0.3	●	●	●	○		
	DBA43R470	DBA43L470	4.7	5.0	0.3	●	●	●	○		
	DBA43R480	DBA43L480	4.8	5.0	0.3	●	●	●	○	5.2	
	DBA43R500	DBA43L500	5.0	5.0	0.3	●	●	●	○		
	DBA43R510	DBA43L510	5.1	5.0	0.3	●	●	●	○		
	DBA43R520	DBA43L520	5.2	5.0	0.3	●	●	●	○		
	DBA43R200-R0.5	DBA43L200-R0.5	2.0	5.0	0.5	●	●	●	○	4.76	
	DBA43R250-R0.5	DBA43L250-R0.5	2.5	5.0	0.5	●	●	●	○		
	DBA43R300-R0.5	DBA43L300-R0.5	3.0	5.0	0.5	●	●	●	○		
	DBA43R350-R0.5	DBA43L350-R0.5	3.5	5.0	0.5	●	●	●	○		
	DBA43R400-R0.5	DBA43L400-R0.5	4.0	5.0	0.5	●	●	●	○		

可以定制特殊宽度、以及特殊圆弧角

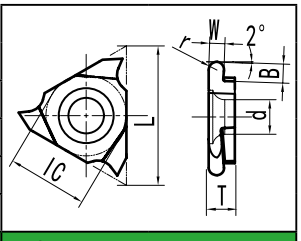
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

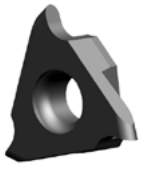
DBA43 球头型刀片　DBA43 Ball Type Insert

型号 Model	L (mm)	IC (mm)
DBA43**	22	12.7

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

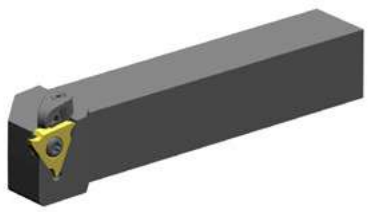
材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



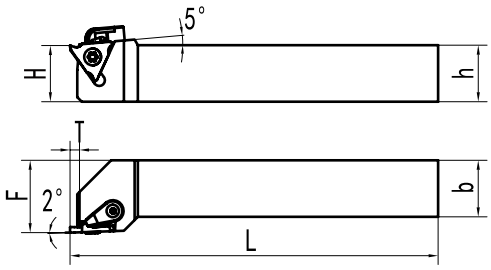
刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	圆弧 r	切深 B	PM125 R	PM125 L	DK110 R	DK110 L	尺寸 Dimensions (mm) T	尺寸 Dimensions (mm) d
	DBA43R100-R0.50	DBA43L100-R0.50	1.0	0.50	3.5	●	●	●	○	4.76	5.4
	DBA43R110-R0.55	DBA43L110-R0.56	1.1	0.55	3.5	●	●	●	○		
	DBA43R120-R0.60	DBA43L120-R0.60	1.2	0.60	3.5	●	●	●	○		
	DBA43R140-R0.70	DBA43L140-R0.70	1.4	0.70	3.5	●	●	●	○		
	DBA43R150-R0.75	DBA43L150-R0.75	1.5	0.75	3.0	●	●	●	○		
	DBA43R160-R0.80	DBA43L160-R0.80	1.6	0.80	3.0	●	●	●	○		
	DBA43R170-R0.85	DBA43L170-R0.85	1.7	0.85	3.0	●	●	●	○		
	DBA43R180-R0.90	DBA43L180-R0.90	1.8	0.90	3.0	●	●	●	○		
	DBA43R200-R1.00	DBA43L200-R1.00	2.0	1.00	5.0	●	●	●	○		
	DBA43R220-R1.10	DBA43L220-R1.10	2.2	1.10	5.0	●	●	●	○		
	DBA43R230-R1.15	DBA43L230-R1.15	2.3	1.15	5.0	●	●	●	○		
	DBA43R240-R1.20	DBA43L240-R1.20	2.4	1.20	5.0	●	●	●	○		
	DBA43R250-R1.25	DBA43L250-R1.25	2.5	1.25	5.0	●	●	●	○		
	DBA43R260-R1.30	DBA43L260-R1.30	2.6	1.30	5.0	●	●	●	○		
	DBA43R270-R1.35	DBA43L270-R1.35	2.7	1.35	5.0	●	●	●	○		
	DBA43R280-R1.40	DBA43L280-R1.40	2.8	1.40	5.0	●	●	●	○		
	DBA43R300-R1.50	DBA43L300-R1.50	3.0	1.50	5.0	●	●	●	○		
	DBA43R320-R1.60	DBA43L320-R1.60	3.2	1.60	5.0	●	●	●	○		
	DBA43R340-R1.70	DBA43L340-R1.70	3.4	1.70	5.0	●	●	●	○		
	DBA43R350-R1.75	DBA43L350-R1.75	3.5	1.75	5.0	●	●	●	○		
	DBA43R360-R1.80	DBA43L360-R1.80	3.6	1.80	5.0	●	●	●	○		
	DBA43R400-R2.00	DBA43L400-R2.00	4.0	2.00	5.0	●	●	●	○		
	DBA43R420-R2.10	DBA43L420-R2.10	4.2	2.10	5.0	●	●	●	○		
	DBA43R450-R2.25	DBA43L450-R2.25	4.5	2.25	5.0	●	●	●	○		
	DBA43R500-R2.50	DBA43L500-R2.50	5.0	2.50	5.0	●	●	●	○		

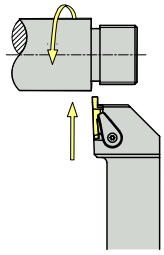
● 常备库存（主推） Standing stock　○ 非常备库存 Extraordinary stock

DBA43 外切槽刀杆 External Grooving Tools



图示为右手刀具 Right hand shown

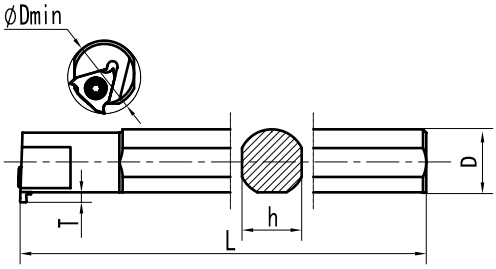


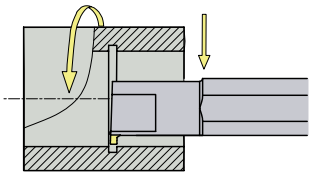


刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key	压板 Clamp	双头螺栓 Clamp screw	扳手 Hew wrench
			h	b	H	F	L	H1	T					
TKGBAR	2020K22-35	DBA43R075~320	20	20	20	25	125	4	4.2	L60M5x11	T-20	HL1814	ML0625	S2.5
	2525M22-35		25	25	25	32	150							
	2020K22-52	DBA43R325~520	20	20	20	25	125		5.2					
	2525M22-52		25	25	25	32	150							
	3232P22-52		32	32	32	40	170							
TKGBAL	2020K22-35	DBA43L075~320	20	20	20	25	125	4	4.2	L60M5x11	T-20	HL1814	ML0625	S2.5
	2525M22-35		25	25	25	32	150							
	2020K22-52	DBA43L325~520	20	20	20	25	125		5.2					
	2525M22-52		25	25	25	32	150							
	3232P22-52		32	32	32	40	170							

DBA43 内孔切槽刀杆 DBA43 Internal Grooving Tools

图示为右手刀具





刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
		Dmin	T	D	H	L		
S25R-SRDBA4329	DBA43L**	29	4.5	25	23	200	L60M5*11	T-20
S32S-SRDBA4335		35		32	30	250		

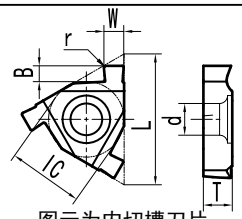
T16/T11 系列切槽刀片 T16/T11 Grooving Insert

型号 Model	L (mm)	IC (mm)	T (mm)	d (mm)
T11**	11	6.35	3.18	3
T16**	16	9.525	3.65	4

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



图示为内切槽刀片

刀片 Insert	内切槽刀片 Internal	外切槽刀片 External	槽宽 W	切深 B	圆弧 r	PM125 N	PM125 E	DK110 N	DK110 E	刀杆 Toolholder
	T11N040	T11E040	0.4	1.0	0.05	●	○	○	○	内切刀片配内螺纹刀杆 外切刀片配外螺纹刀杆
	T11N050	T11E050	0.5	1.0	0.05	●	●	○	○	
	T11N060	T11E060	0.6	1.0	0.05	○	○	○	○	
	T11N070	T11E070	0.7	1.2	0.05	●	○	○	○	
	T11N080	T11E080	0.8	1.2	0.05	●	●	○	○	
	T11N090	T11E090	0.9	1.2	0.05	●	●	○	○	
	T11N100	T11E100	1.0	1.5	0.05	●	●	○	○	
	T11N110	T11E110	1.1	1.5	0.1	●	○	○	○	
	T11N120	T11E120	1.2	1.5	0.1	●	●	○	○	
	T11N130	T11E130	1.3	1.5	0.1	●	○	○	○	
	T11N140	T11E140	1.4	1.5	0.1	●	●	○	○	
	T11N150	T11E150	1.5	1.5	0.1	●	●	○	○	
	T11N160	T11E160	1.6	1.4	0.1	●	●	○	○	
	T11N170	T11E170	1.7	1.4	0.1	●	●	○	○	
	T11N180	T11E180	1.8	1.3	0.1	●	●	○	○	
	T11N200	T11E200	2.0	1.2	0.1	●	●	○	○	
	T16N033	T16E033	0.33	1.6	0.05	●	○	○	○	内切刀片配内螺纹刀杆 外切刀片配外螺纹刀杆
	T16N040	T16E040	0.4	1.6	0.05	●	○	○	○	
	T16N050	T16E050	0.5	1.6	0.05	○	○	○	○	
	T16N060	T16E060	0.6	1.6	0.05	●	○	○	○	
	T16N070	T16E070	0.7	1.6	0.05	●	●	○	○	
	T16N075	T16E075	0.75	1.6	0.05	●	●	○	○	
	T16N080	T16E080	0.8	1.6	0.05	●	○	○	○	
	T16N095	T16E095	0.95	1.6	0.05	●	○	○	○	
	T16N100	T16E100	1.0	1.8	0.1	●	●	○	○	
	T16N110	T16E110	1.1	1.8	0.1	●	○	○	○	
	T16N115	T16E115	1.15	1.8	0.1	●	●	○	○	
	T16N120	T16E120	1.2	1.8	0.1	●	●	○	○	
	T16N130	T16E130	1.3	1.8	0.1	●	○	○	○	
	T16N140	T16E140	1.4	1.8	0.1	●	●	○	○	
	T16N145	T16E145	1.45	1.8	0.1	●	●	○	○	
	T16N150	T16E150	1.5	1.8	0.1	●	●	○	○	
	T16N160	T16E160	1.6	1.8	0.1	●	○	○	○	
	T16N175	T16E175	1.75	1.8	0.1	●	●	○	○	
	T16N180	T16E180	1.8	1.8	0.1	●	●	○	○	
	T16N200	T16E200	2.0	1.8	0.1	●	○	○	○	
	T16N215	T16E215	2.15	2.0	0.2	●	●	○	○	
	T16N225	T16E225	2.25	2.0	0.2	●	●	○	○	
	T16N230	T16E230	2.3	2.0	0.2	●	○	○	○	
	T16N250	T16E250	2.5	2.0	0.2	●	●	○	○	
	T16N265	T16E265	2.65	2.2	0.2	●	○	○	○	
	T16N300	T16E300	3.0	2.0	0.2	●	●	○	○	

* 可定制特殊宽度，以及特殊圆弧角

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

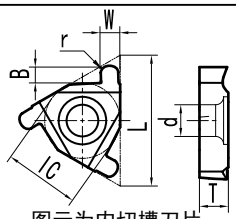
T16/T11 球头型刀片 Ball Type Insert

型号 Model	L (mm)	IC (mm)	T (mm)	d (mm)
T11**	11	6.35	3.18	3
T16**	16	9.525	3.65	4

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



图示为内切槽刀片

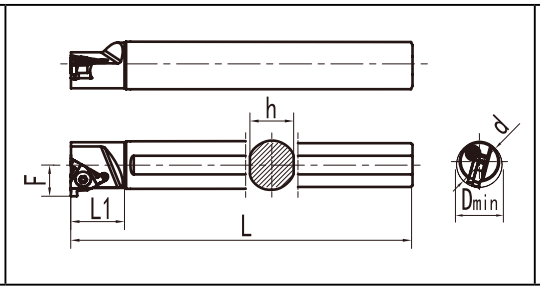
刀片 Insert	内切槽刀片 Internal	外切槽刀片 External	槽宽 W	切深 B	圆弧 r	PM125 N	PM125 E	DK110 N	DK110 E	刀杆 Toolholder
	T11N050-R0.25	T11E050-R0.25	0.5	1.0	0.25	●	○	○	○	T11N** → SNR**11 T11E** → SER**11
	T11N060-R0.30	T11E060-R0.30	0.6	1.0	0.30	●	○	○	○	
	T11N080-R0.40	T11E080-R0.40	0.8	1.2	0.40	●	○	○	○	
	T11N100-R0.50	T11E100-R0.50	1.0	1.5	0.50	●	○	○	○	
	T11N120-R0.60	T11E120-R0.60	1.2	1.5	0.60	●	○	○	○	
	T11N140-R0.70	T11E140-R0.70	1.4	1.5	0.70	●	○	○	○	
	T11N150-R0.75	T11E150-R0.75	1.5	1.5	0.75	●	○	○	○	
	T11N160-R0.80	T11E160-R0.80	1.6	1.4	0.80	●	○	○	○	
	T11N180-R0.90	T11E180-R0.90	1.8	1.3	0.90	●	○	○	○	
	T11N200-R1.00	T11E200-R1.00	2.0	1.2	1.00	●	○	○	○	
	T16N050-R0.25	T16E050-R0.25	0.5	1.6	0.25	●	○	○	○	T16N** → SNR**16 T16E** → SER**16
	T16N060-R0.30	T16E060-R0.30	0.6	1.6	0.30	●	○	○	○	
	T16N080-R0.40	T16E080-R0.40	0.8	1.6	0.40	●	○	○	○	
	T16N100-R0.50	T16E100-R0.50	1.0	2.0	0.50	●	○	○	○	
	T16N120-R0.60	T16E120-R0.60	1.2	2.0	0.60	●	○	○	○	
	T16N140-R0.70	T16E140-R0.70	1.4	2.0	0.70	●	○	○	○	
	T16N150-R0.75	T16E150-R0.75	1.5	2.0	0.75	●	○	○	○	
	T16N160-R0.80	T16E160-R0.80	1.6	2.0	0.80	●	○	○	○	
	T16N180-R0.90	T16E180-R0.90	1.8	2.0	0.90	●	○	○	○	
	T16N200-R1.00	T16E200-R1.00	2.0	2.0	1.00	●	○	○	○	
	T16N250-R1.25	T16E250-R1.25	2.5	2.0	1.25	●	○	○	○	
	T16N300-R1.50	T16E300-R1.50	3.0	2.0	1.50	●	○	○	○	

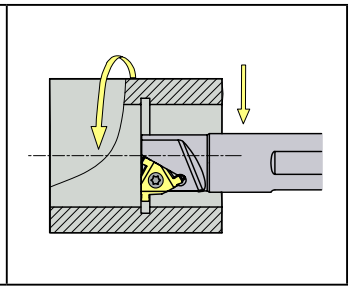
* 可定制特殊宽度，以及特殊圆弧角

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

T11N/T16N 内切槽刀杆 Internal Grooving Tools

图示为右手刀具 Right hand shown

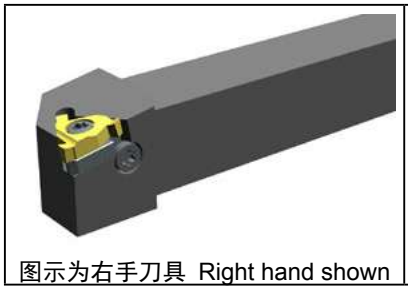


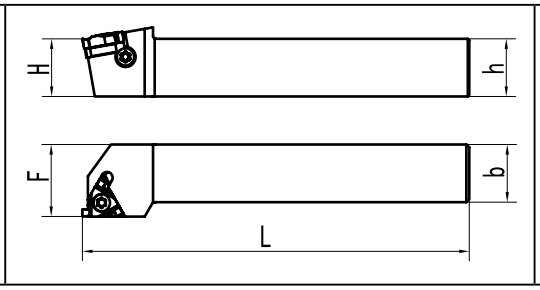


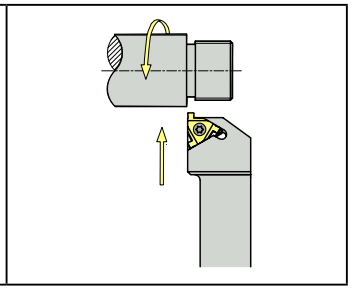
刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key	刀垫 Anvil	侧面螺钉 Anvil Screw	扳手 Hex Wrench
			Dmin	L1	d1	d	F	L	h					
SNR	0010H11	T11N**	12	12	10	10	7.4	100	9	L60M2.5*6	T-08	-	-	-
	0012K11		15	15	12	12	8.4	125	11	L60M2.5*6	T-08	-	-	-
	0013M11		15	25	13	13	8.9	150	12	L60M2.5*6	T-08	-	-	-
	0013M16	T16N**	16	25	13	16	10.2	150	15	L60M3.5*12	T-15	-	-	-
	0016M16		19	25	15	16	11.7	150	15	L60M3.5*12	T-15	-	-	-
	0020Q16		24	24	19	20	13.7	180	18	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0025R16		29	29	24	25	16.2	200	23	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0032S16		36	36	31	32	19.7	250	30	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0040T16		44	44	38	40	23.7	300	37	L60M3.5*12	T-15	NGM-16	MQ030080	T10
	0050U16		54	54	47	50	28.7	350	46	L60M3.5*12	T-15	NGM-16	MQ030080	T10

*T11N/T16N 系列切槽刀片配内螺纹刀杆使用，通用性好
* 安装某些宽度的切槽刀片时，刀垫可能会与被加工槽发生干涉，需要把干涉部分磨掉才能正常使用

T16E 外切槽刀杆 External Grooving Tools


图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key	刀垫 Anvil	侧面螺钉 Anvil Screw	扳手 Hex Wrench
			h	b	H	F	L					
SER	1212F16	T16E**	12	12	12	16	80	L60M3.5x12	T-15	-	-	-
	1616H16		16	16	16	20	100	L60M3.5*12	T-15	-	-	-
	2020K16		20	20	20	25	125	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	2525M16		25	25	25	32	150	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	3225P16		32	32	32	32	170	L60M3.5*12	T-15	EGM-16	MQ030080	T10
	3232P16		32	32	32	40	170	L60M3.5*12	T-15	EGM-16	MQ030080	T10

*T16E 系列切槽刀片配外螺纹刀杆使用，通用性好
* 安装某些宽度的切槽刀片时，刀垫可能会与被加工槽发生干涉，需要把干涉部分磨掉才能正常使用

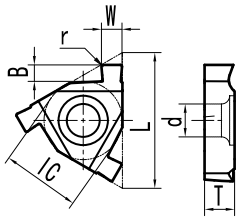
T16/T22 端面切槽刀片 Circlip Grooving Insert

型号 Model	L (mm)	IC (mm)	T (mm)	d (mm)
T16**DM**	16	9.525	3.65	4
T22**DM**	22	12.7	4.76	5

☺ 优先推荐 Good recommendation

☺ 一般推荐 General recommendation

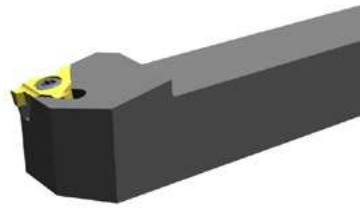
材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	☺	
有色金属	N		☺

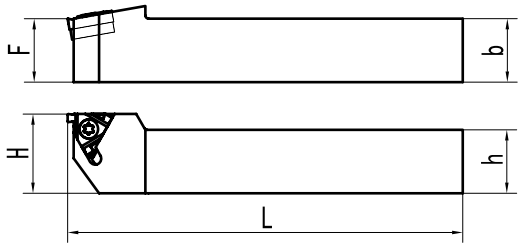


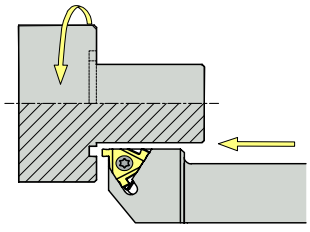
刀片 Insert	右手刀片 Right hand	端面圆直径范围	槽宽 w	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	配套刀杆 Toolholders
	T16N150DM10	大于 >10	1.5	1.8	0.1	○		○		SEL**-16
	T16N200DM10	大于 >10	2.0	2.2	0.1	○		○		
	T16N250DM10	大于 >10	2.5	2.2	0.1	○		○		
	T22N200DM15	大于 >15	2.0	3.0	0.1	○		○		SEL**-22
	T22N250DM15	大于 >15	2.5	3.0	0.1	○		○		
	T22N300DM15	大于 >15	3.0	3.0	0.1	○		○		
	T16N150DM10R075	大于 >10	1.5	2.0	0.75	○		○		SEL**-16
	T16N200DM10R100	大于 >10	2.0	2.2	1.0	○		○		
	T22N200DM15R100	大于 >15	2.0	3.0	1.0	○		○		SEL**-22
	T22N250DM15R125	大于 >15	2.5	3.0	1.25	○		○		

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

T16N/T22N 端面切槽刀杆 Circlip Grooving Tools


图示为左手刀具 Left hand shown





刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key	刀垫 Anvil	侧面螺钉 Anvil Screw	扳手 Hex Wrench
		h	b	H	F	L					
SEL1212F16	T16N**	12	12	12	16	80	L60M3.5*12	T-15	-	-	-
1616H16		16	16	16	20	100	L60M3.5*12	T-15	-	-	-
2020K16		20	20	20	25	125	L60M3.5*12	T-15	EGM-16	MQ030080	T-10
2525M16		25	25	25	32	150	L60M3.5*12	T-15	EGM-16	MQ030080	T-10
2525M22	T22N**	25	25	25	32	150	L60M4.5*14	T-20	EGM-22	MQ040080	S2.5
3225P22		32	32	32	32	170					
3232P32		32	32	32	40	170					

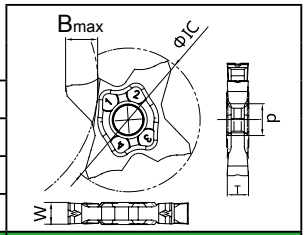
TDG 系列四角切槽刀片 Four-prongs Grooving Insert

型号 Model	IC (mm)	T (mm)	d (mm)
TDG27*	27	4	5.6

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
钢件	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N			☺

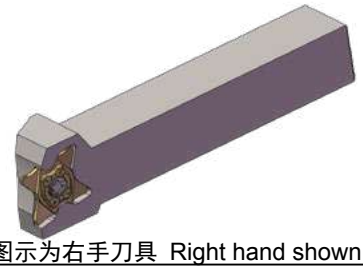


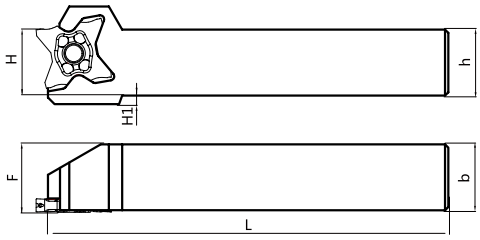
刀片 Insert	槽型	刀片型号 insert type	槽宽 w	切深 Bmax	圆弧 r	DM215	DK110	配套刀杆 Toolholders
		TDG27-150-0.2	1.5	5.7	0.2	●	○	TDHR/L**
		TDG27-175-0.2	1.75	5.7	0.2	●	○	
		TDG27-200-0.2	2.0	6.4	0.2	●	○	
		TDG27-250-0.3	2.5	6.4	0.3	●	○	
		TDG27-300-0.2	3.0	6.4	0.2	●	○	
		TDG27-300-0.4	3.0	6.4	0.4	●	○	
		TDG27-350-0.2	3.5	6.4	0.2	●	○	
		TDG27-400-0.2	4.0	6.4	0.2	●	○	

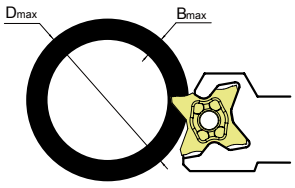
* 可定制特殊宽度

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

TDG 系列切槽刀杆 Grooving Tools


图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)						极限加工尺寸	刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L	H1			
TDHR	1010H27	TDG27**	10	10	10	10	100	9	Dmax 与 Bmax 见下表	L60M5*13	T-20
	1212H27		12	12	12	12	100	8			
	1616H27		16	16	16	16	110	6			
	2020K27		20	20	20	20	125	2			
	2525M27		25	25	25	25	150	–			
TDHL	1010H27		10	10	10	10	100	9		L60M5*13	T-20
	1212H27		12	12	12	12	100	8			
	1616H27		16	16	16	16	110	6			
	2020K27		20	20	20	20	125	2			
	2525M27		25	25	25	25	150	–			

刀具实际极限切深 Bmax 与被加工直径 Dmax 的参考值

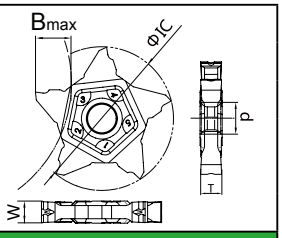
刀片型号 Inserts Type	极限切深 Bmax	被加工外圆直径 Dmax									
		B ≤ 3.0	B ≤ 3.5	B ≤ 4.0	B ≤ 4.5	B ≤ 5.0	B ≤ 5.5	B ≤ 5.7	B ≤ 6.0	B ≤ 6.2	B ≤ 6.4
TDG27-150	5.8	YES	600	280	180	130	50	35	–	–	–
TDG27-200	6.5	YES	600	280	180	130	105	85	60	50	30
TDG27-250	6.5	YES	600	280	180	130	50	35	–	–	–
TDG27-300	6.5	YES	600	280	180	135	105	95	85	78	55
TDG27-350	6.5	YES	600	280	180	120	105	95	85	78	68
TDG27-400	6.5	YES	600	280	180	120	105	95	85	78	68

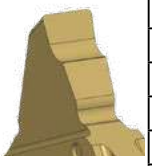
PEN 系列五角切槽刀片　PEN Five-prongs Grooving Insert

型号 Model	IC (mm)	T (mm)	d (mm)
PEN24*	24	4	5.6

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

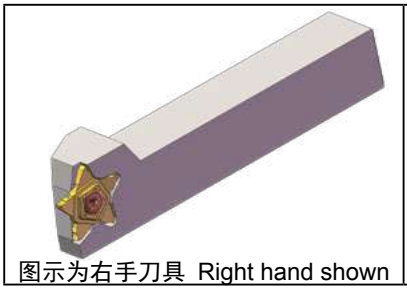
材质推荐 material recommended				
钢件	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N			☺

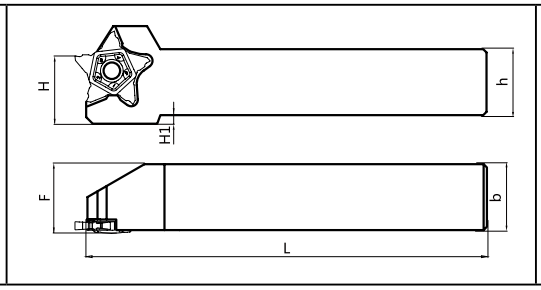


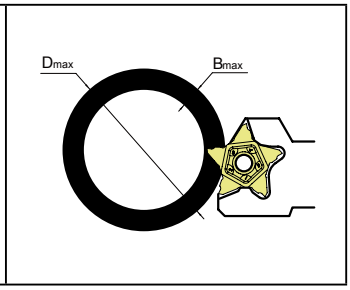
刀片 Insert	槽型	刀片型号 insert type	槽宽 w	切深 Bmax	圆弧 r	DM215	DK110	配套刀杆 Toolholders
		PEN24-050S	0.5	2.9	0.1	●	○	PCHR/L**
		PEN24-080S	0.8	2.9	0.1	●	○	
		PEN24-100S	1.0	4.9	0.1	●	○	
		PEN24-120S	1.2	4.9	0.1	●	○	
		PEN24-125S	1.25	4.9	0.1	●	○	
		PEN24-150S	1.5	4.9	0.1	●	○	
		PEN24-175S	1.75	4.9	0.1	●	○	
		PEN24-200S	2.0	4.9	0.2	●	○	
		PEN24-250S	2.5	4.9	0.2	●	○	
		PEN24-300S	3.0	4.9	0.2	●	○	
		PEN24-320S	3.2	6.4	0.2	●	○	
		PEN24-350S	3.5	6.4	0.2	●	○	
		PEN24-400S	4.0	6.4	0.2	●	○	

● 常备库存（主推） Standing stock　○ 非常备库存 Extraordinary stock

PEN 系列切槽刀杆　PEN Grooving Tools


图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)						极限加工尺寸	刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L	H1			
PCHR	1010H24	PEN24**	10	10	10	10	100	6	Dmax 与 Bmax 见下表	L60M5*12.5	T-20
	1212H24		12	12	12	12	100	4			
	1616H24		16	16	16	16	110	–			
	2020K24		20	20	20	20	125	–			
	2525M24		25	25	25	25	150	–			
PCHL	1010H24		10	10	10	10	100	6		L60M5*12.5	T-20
	1212H24		12	12	12	12	100	4			
	1616H24		16	16	16	16	110	–			
	2020K24		20	20	20	20	125	–			
	2525M24		25	25	25	25	150	–			

刀具实际极限切深 Bmax 与被加工直径 Dmax 的参考值

刀片型号 Inserts Type	极限切深 Bmax	被加工外圆直径 Dmax									
		B ≤ 3.0	B ≤ 3.5	B ≤ 4.0	B ≤ 4.5	B ≤ 5.0	B ≤ 5.5	B ≤ 5.7	B ≤ 6.0	B ≤ 6.2	TB ≤ 6.4
PEN24-050S	2.9	20	–	–	–	–	–	–	–	–	–
PEN24-080S	2.9	20	–	–	–	–	–	–	–	–	–
PEN24-100S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-120S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-125S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-150S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-175S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-200S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-250S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-300S	4.9	YES	800	280	50	20	–	–	–	–	–
PEN24-320S	6.4	YES	800	280	180	120	80	70	60	–	–
PEN24-350S	6.4	YES	800	280	180	120	80	70	60	–	–
PEN24-400S	6.4	YES	800	280	180	120	80	70	60	–	–

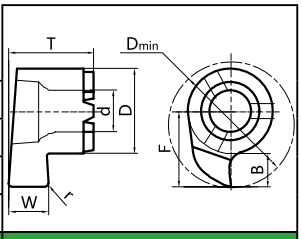
GK 系列内孔大切深槽刀片 GK Internal Grooving Insert

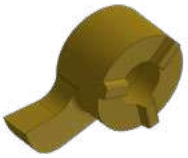
型号 Model	D (mm)	T (mm)	d (mm)
GK7R**	5.2	5.2	2.7
GK12R**	7.3	5.9	3.6
GK18R**	11.2	7.9	5.1

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	☺	
有色金属	N		☺

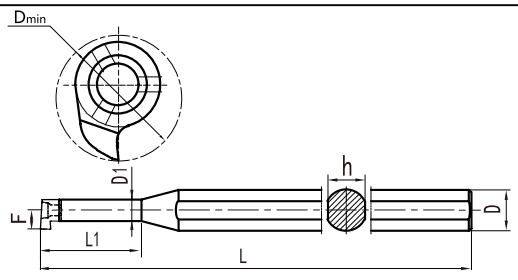


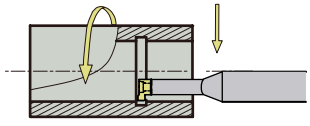
刀片 Insert	右手刀片 Right hand	最小加工直径 Dmin	槽宽 W	切深 B	圆弧 r	F	PM125	DK110	配套刀杆 Toolholders
	GK7R100-L1.5	7	1.0	1.5	0.1	4.1	●	○	KGK7R0012H075 KGK7R0016K075 KGK7R0020M075
	GK7R120-L1.5		1.2		0.1		●	○	
	GK7R125-L1.5		1.25		0.1		●	○	
	GK7R150-L1.5		1.5		0.1		●	○	
	GK7R175-L1.5		1.75		0.1		●	○	
	GK7R200-L1.5		2.0		0.1		●	○	
	GK7R100	7.5	1.0	2	0.1	4.6	●	○	KGK7R0012H075 KGK7R0016K075 KGK7R0020M075
	GK7R120		1.2		0.1		●	○	
	GK7R125		1.25		0.1		●	○	
	GK7R150		1.5		0.1		●	○	
	GK7R175		1.75		0.1		●	○	
	GK7R200		2.0		0.1		●	○	
	GK7R225		2.25		0.1		●	○	
	GK7R250		2.5		0.1		●	○	
	GK7R300		3.0		0.1		●	○	
	GK12R150	12	1.5	4.3	0.1	8.05	●	○	KGK12R0012H12 KGK12R0016K12 KGK12R0020M12
	GK12R160		1.6		0.1		●	○	
	GK12R200		2.0		0.1		●	○	
	GK12R225		2.25		0.2		●	○	
	GK12R240		2.4		0.2		●	○	
	GK12R250		2.5		0.2		●	○	
	GK12R280		2.8		0.2		●	○	
	GK12R300		3.0		0.2		●	○	
	GK12R350		3.5		0.2		●	○	
	GK12R400		4.0		0.2		○	○	
	GK12R480		4.8		0.2		○	○	
	GK18R200	18.5	2.0	7	0.2	12.7	●	○	KGK18R0016L18.5 KGK18R0020M18.5 KGK18R0025N18.5
	GK18R225		2.25		0.2		●	○	
	GK18R240		2.4		0.2		●	○	
	GK18R250		2.5		0.2		●	○	
	GK18R280		2.8		0.2		●	○	
	GK18R300		3.0		0.2		●	○	
	GK18R350		3.5		0.2		●	○	
	GK18R400		4.0		0.2		●	○	
	GK18R480		4.8		0.2		○	○	
	GK18R500		5.0		0.2		○	○	

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

KGK 系列内孔切槽刀杆 KGK Internal Grooving Tools

图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type	刀片型号	最小加工直径	尺寸 Dimensions (mm)						刀片螺钉 Insert Screw	扳手 Torx Key
		Dmin	L1	L	D1	D	h	F		
KGK7R0012H075	GK7R	见上页刀片 Dmin 值	18	100	5.2	12	11	见上页刀片 F 值	L60M2.2*7.5	T-7
KGK7R0016K075			18	125	5.2	16	15		L60M2.2*7.5	T-7
KGK7R0020M075			18	150	5.2	20	19		L60M2.2*7.5	T-7
KGK12R0012H12	GK12R		25	100	7.3	12	11		L60M3*12	T-10
KGK12R0016K12			25	125	7.3	16	15		L60M3*12	T-10
KGK12R0020M12			25	150	7.3	20	19		L60M3*12	T-10
KGK18R0016L18.5	GK18R		38	135	11.2	16	15		L60M4.5*16	T-20
KGK18R0020M18.5			38	150	11.2	20	19		L60M4.5*16	T-20
KGK18R0025N18.5			38	160	11.2	25	24		L60M4.5*16	T-20

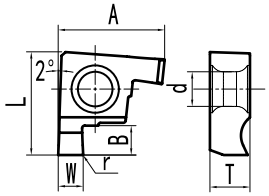
GER 系列内孔切槽刀片 GER Internal Grooving Insert

型号 Model	A (mm)	L (mm)	T (mm)	d (mm)
GER**-A	6.69	6.5	2.58	2.5
GER**-B	8.46	8.2	3.18	2.7
GER**-C	5.8	11.48	4.05	2.8
GER**-D	6.8	16.44	5.05	3.4
GER**-E	9.54	21.66	5.55	4.4

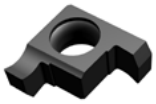
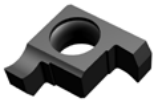
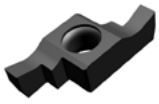
☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



A、B 系列刀片式样

刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	配套刀杆 Toolholders
	GER050-A	GEL050-A	0.5	1.2	0.05	●	○	○	○	右手刀片配右刀杆 SIGER0808A
	GER060-A	GEL060-A	0.6	1.2	0.05	●	○	○	○	
	GER070-A	GEL070-A	0.7	1.2	0.05	●	○	○	○	
	GER080-A	GEL080-A	0.8	1.2	0.05	●	○	○	○	
	GER100-A	GEL100-A	1.0	1.7	0.05	●	○	○	○	
	GER120-A	GEL120-A	1.2	1.7	0.05	●	○	○	○	
	GER125-A	GEL125-A	1.25	1.7	0.05	●	○	○	○	
	GER140-A	GEL140-A	1.4	1.7	0.1	●	○	○	○	
	GER150-A	GEL150-A	1.5	1.7	0.1	●	○	○	○	
	GER180-A	GEL180-A	1.8	1.7	0.1	●	○	○	○	
	GER200-A	GEL200-A	2.0	1.7	0.1	●	○	○	○	
	GER080-B	GEL080-B	0.8	1.8	0.05	●	○	○	○	右手刀片配右刀杆 SIGER1010B SIGER1210B
	GER100-B	GEL100-B	1.0	2.4	0.05	●	○	○	○	
	GER120-B	GEL120-B	1.2	2.4	0.05	●	○	○	○	
	GER125-B	GEL125-B	1.25	2.4	0.05	●	○	○	○	
	GER130-B	GEL130-B	1.3	2.4	0.1	●	○	○	○	
	GER145-B	GEL145-B	1.45	2.4	0.1	●	○	○	○	
	GER150-B	GEL150-B	1.5	2.4	0.1	●	○	○	○	
	GER180-B	GEL180-B	1.8	2.4	0.1	●	○	○	○	
	GER200-B	GEL200-B	2.0	2.4	0.2	●	○	○	○	
	GER225-B	GEL225-B	2.25	2.4	0.2	●	○	○	○	
	GER250-B	GEL250-B	2.5	2.4	0.2	●	○	○	○	
	GER280-B	GEL280-B	2.8	2.4	0.2	●	○	○	○	
	GER300-B	GEL300-B	3.0	2.4	0.2	●	○	○	○	
	GER100-C	GEL100-C	1.0	2.5	0.05	●	○	○	○	右手刀片配右刀杆 SIGER1412C SIGER1612C SIGER1616C
	GER120-C	GEL120-C	1.2	2.5	0.05	●	○	○	○	
	GER125-C	GEL125-C	1.25	2.5	0.05	●	○	○	○	
	GER140-C	GEL140-C	1.4	2.5	0.1	●	○	○	○	
	GER145-C	GEL145-C	1.45	2.5	0.1	●	○	○	○	
	GER150-C	GEL150-C	1.5	2.5	0.1	●	○	○	○	
	GER160-C	GEL160-C	1.6	2.5	0.1	●	○	○	○	
	GER170-C	GEL170-C	1.7	2.5	0.1	●	○	○	○	
	GER185-C	GEL185-C	1.85	2.5	0.1	●	○	○	○	
	GER195-C	GEL195-C	1.95	2.5	0.1	●	○	○	○	
	GER200-C	GEL200-C	2.0	2.5	0.1	●	○	○	○	
	GER225-C	GEL225-C	2.25	2.5	0.1	●	○	○	○	
	GER250-C	GEL250-C	2.5	2.5	0.2	●	○	○	○	
	GER275-C	GEL275-C	2.75	2.5	0.2	●	○	○	○	
	GER280-C	GEL280-C	2.8	2.5	0.2	●	○	○	○	
	GER300-C	GEL300-C	3.0	2.5	0.2	●	○	○	○	
	GER320-C	GEL320-C	3.2	2.5	0.2	●	○	○	○	
	GER350-C	GEL350-C	3.5	2.5	0.2	●	○	○	○	

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

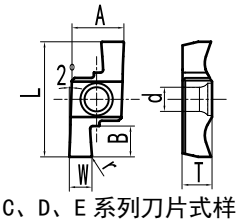
GER 系列内孔切槽刀片 GER Internal Grooving Insert

型号 Model	A (mm)	L (mm)	T (mm)	d (mm)
GER**-A	6.69	6.5	2.58	2.5
GER**-B	8.46	8.2	3.18	2.7
GER**-C	5.8	11.48	4.05	2.8
GER**-D	6.8	16.44	5.05	3.4
GER**-E	9.54	21.66	5.55	4.4

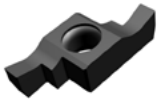
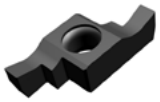
☺ 优先推荐 Good recommendation

☹ 一般推荐 General recommendation

材质推荐 material recommended				
钢件	P	☺		
不锈钢	M	☺		
铸铁	K	☹		
有色金属	N			☺



C、D、E 系列刀片式样

刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	配套刀杆 Toolholders
	GER100-D	GEL100-D	1.0	2.5	0.05	●	○	○	○	右手刀片配右刀杆 SIGER2020D SIGER2525D
	GER120-D	GEL120-D	1.2	2.5	0.05	●	○	○	○	
	GER125-D	GEL125-D	1.25	2.5	0.05	●	○	○	○	
	GER140-D	GEL140-D	1.4	2.5	0.05	●	○	○	○	
	GER145-D	GEL145-D	1.45	2.5	0.1	●	○	○	○	
	GER150-D	GEL150-D	1.5	4.5	0.1	●	○	○	○	
	GER170-D	GEL170-D	1.7	4.5	0.1	●	○	○	○	
	GER185-D	GEL185-D	1.85	4.5	0.1	●	○	○	○	
	GER195-D	GEL195-D	1.95	4.5	0.1	●	○	○	○	
	GER200-D	GEL200-D	2.0	4.5	0.1	●	○	○	○	
	GER225-D	GEL225-D	2.25	4.5	0.1	●	○	○	○	
	GER230-D	GEL230-D	2.3	4.5	0.2	●	○	○	○	
	GER250-D	GEL250-D	2.5	4.5	0.2	●	○	○	○	
	GER275-D	GEL275-D	2.75	4.5	0.2	●	○	○	○	
	GER280-D	GEL280-D	2.8	4.5	0.2	●	○	○	○	
	GER300-D	GEL300-D	3.0	4.5	0.2	●	○	○	○	
	GER320-D	GEL320-D	3.2	4.5	0.2	●	○	○	○	
	GER350-D	GEL350-D	3.5	4.5	0.2	●	○	○	○	
	GER400-D	GEL400-D	4.0	4.5	0.2	●	○	○	○	
	GER100-E	GEL100-E	1.0	3.5	0.05	●	○	○	○	右手刀片配右刀杆 SIGER2525E SIGER3232E SIGER4032E
	GER150-E	GEL150-E	1.5	3.5	0.1	●	○	○	○	
	GER170-E	GEL170-E	1.7	3.5	0.1	●	○	○	○	
	GER185-E	GEL185-E	1.85	3.5	0.1	●	○	○	○	
	GER195-E	GEL195-E	1.95	3.5	0.1	●	○	○	○	
	GER200-E	GEL200-E	2.0	6.5	0.1	●	○	○	○	
	GER225-E	GEL225-E	2.25	6.5	0.1	●	○	○	○	
	GER230-E	GEL230-E	2.3	6.5	0.2	●	○	○	○	
	GER250-E	GEL250-E	2.5	6.5	0.2	●	○	○	○	
	GER275-E	GEL275-E	2.75	6.5	0.2	●	○	○	○	
	GER280-E	GEL280-E	2.8	6.5	0.2	●	○	○	○	
	GER300-E	GEL300-E	3.0	6.5	0.2	●	○	○	○	
	GER330-E	GEL330-E	3.3	6.5	0.2	●	○	○	○	
	GER350-E	GEL350-E	3.5	6.5	0.2	●	○	○	○	
	GER400-E	GEL400-E	4.0	6.5	0.2	●	○	○	○	
	GER430-E	GEL430-E	4.3	6.5	0.2	●	○	○	○	
	GER450-E	GEL450-E	4.5	6.5	0.2	●	○	○	○	
	GER460-E	GEL460-E	4.6	6.5	0.2	●	○	○	○	
	GER500-E	GEL500-E	5.0	6.5	0.2	●	○	○	○	

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

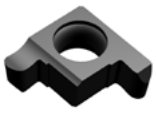
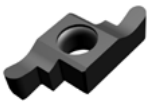
GER 圆弧系列内孔切槽刀片 GER Internal Grooving Insert

型号 Model	A (mm)	L (mm)	T (mm)	d (mm)
GER**-A	6.69	6.5	2.58	2.5
GER**-B	8.46	8.2	3.18	2.7
GER**-C	5.8	11.48	4.05	2.8
GER**-D	6.8	16.44	5.05	3.4
GER**-E	9.54	21.66	5.55	4.4

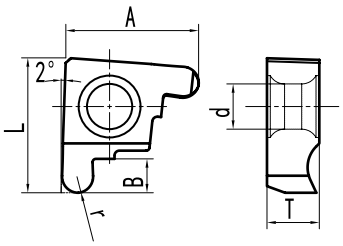
☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺

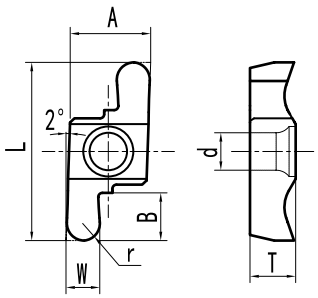
图片式样见下图
See the following two pictures

刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	配套刀杆 Toolholders
	GER100-050AR	GEL100-050AR	1.0	1.7	0.5	●	○	○	○	右手刀片配右刀杆 SIGER0808A
	GER150-075AR	GEL150-075AR	1.5	1.7	0.75	●	○	○	○	
	GER200-100AR	GEL200-100AR	2.0	1.7	1	●	○	○	○	
	GER100-050BR	GEL100-050BR	1.0	2.4	0.5	●	○	○	○	右手刀片配右刀杆 SIGER1010B SIGER1210B
	GER150-075BR	GEL150-075BR	1.5	2.4	0.75	●	○	○	○	
	GER200-100BR	GEL200-100BR	2.0	2.4	1	●	○	○	○	
	GER250-125BR	GEL250-125BR	2.5	2.4	1.25	●	○	○	○	
	GER300-150BR	GEL300-150BR	3.0	2.4	1.5	●	○	○	○	
	GER100-050CR	GEL100-050CR	1.0	2.5	0.5	●	○	○	○	右手刀片配右刀杆 SIGER1412C SIGER1612C SIGER1616C
	GER150-075CR	GEL150-075CR	1.5	2.5	0.75	●	○	○	○	
	GER200-100CR	GEL200-100CR	2.0	2.5	1	●	○	○	○	
	GER250-125CR	GEL250-125CR	2.5	2.5	1.25	●	○	○	○	
	GER300-150CR	GEL300-150CR	3.0	2.5	1.5	●	○	○	○	
	GER150-075DR	GEL150-075DR	1.5	4.5	0.75	●	○	○	○	右手刀片配右刀杆 SIGER2020D SIGER2525D
	GER200-100DR	GEL200-100DR	2.0	4.5	1	●	○	○	○	
	GER250-125DR	GEL250-125DR	2.5	4.5	1.25	●	○	○	○	
	GER300-150DR	GEL300-150DR	3.0	4.5	1.5	●	○	○	○	
	GER250-125ER	GEL250-125ER	2.5	6.5	1.25	●	○	○	○	右手刀片配右刀杆 SIGER2525E SIGER3232E SIGER4032E
	GER300-150ER	GEL300-150ER	3.0	6.5	1.5	●	○	○	○	
	GER350-175ER	GEL350-175ER	3.5	6.5	1.75	●	○	○	○	
	GER400-200ER	GEL400-200ER	4.0	6.5	2	●	○	○	○	
	GER450-225ER	GEL450-225ER	4.5	6.5	2.25	●	○	○	○	
	GER500-250ER	GEL500-250ER	5.0	6.5	2.5	●	○	○	○	

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock



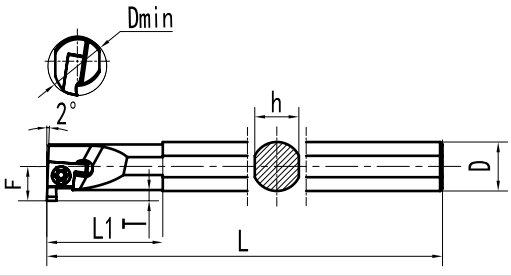
A、B 系列刀片式样
A/B Series Insert Type

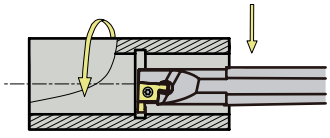


C、D、E 系列刀片式样
C/D/E Series Insert Type

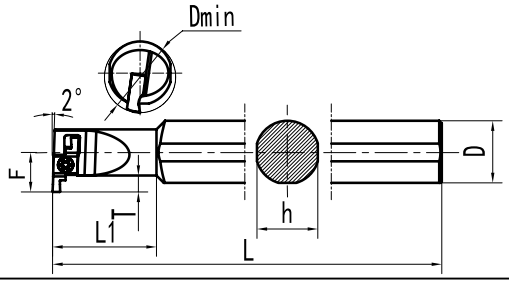
SIGE 型内孔切槽刀杆 Internal Grooving Tools

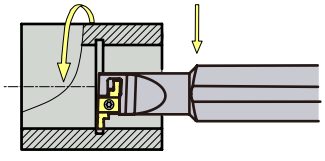
图示为右手刀具 Right hand shown





图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type		刀片型号 Insert Type	最小加工直径 Dmin	尺寸 Dimensions (mm) T	L1	D	F	h	L	刀片螺钉 Insert Screw	扳手 Torx Key
SIGER	0808A	GER**-A GER**AR	8	1.5	20	8	4.8	7.2	100	L60M2.2*5	T-6
*	0808A-WH		8		28	8	4.8	7.2	125		
	1010B	GER**-B GER**-BR	10	2.2	25	10	6.2	9	125	L60M2.5*6	T-8
*	1010B-WH		10		35	10	6.2	9	125		
	1210B		12		30	10	7	9	125		
	1412C	GER**-C GER**-CR	14	2.5	33	12	8	11.4	150	L60M2.5*6	T-8
	1612C		16		20	12	8.5	11.4	150		
	1616C		16		36	16	9	15	160		
	2020D	GER**-D GER**-DR	20	4.5	40	20	12.1	19	180	L60M3*8	T-10
	2525D		25	4.2	45	25	12.3	24	200		
	2525E	GER**-E GER**-ER	25	6.5	45	25	15.6	24	200	L60M4*8.5	T-15
	3232E		32		55	32	19	30.4	220		
	4032E		40		-	32	23	30.4	250		
SIGEL	0808A	GEL**-A GEL**AR	8	1.5	20	8	4.8	7.2	100	L60M2.2*5	T-6
	0808A-WH		8		20	8	4.8	7.2	100		
	1010B	GEL**-B GEL**-BR	10	2.2	25	10	6.2	9	125	L60M2.5*6	T-8
	1010B-WH		10		25	10	6.2	9	125		
	1210B		12		30	10	7	9	125		
	1412C	GEL**-C GEL**-CR	14	2.5	33	12	8	11.4	150	L60M2.5*6	T-8
	1612C		16		20	12	8.5	11.4	150		
	1616C		16		36	16	9	15	160		
	2020D	GEL**-D GEL**-DR	20	4.5	40	20	12.1	19	180	L60M3*8	T-10
	2525D		25	4.2	45	25	12.3	24	200		
	2525E	GEL**-E GEL**-ER	25	6.5	45	25	15.6	24	200	L60M4*8.5	T-15
	3232E		32		55	32	19	30.4	220		
	4032E		40		-	32	23	30.4	250		

* SIGER0808A-WH 与 SIGER1010B-WH 为硬质合金抗震型刀杆

* SIGER4032E 与 SIGEL4032E 刀杆有效长度 L1 为省略值，该刀杆是直柄，无台阶，可按需求调整有效长度

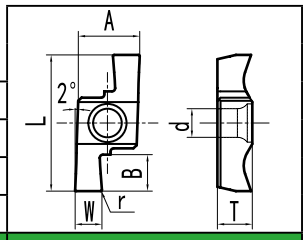
GER 端面切槽刀片 Circlip Grooving Insert

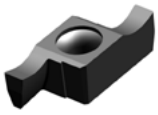
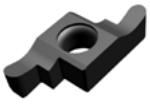
型号 Model	A (mm)	L (mm)	T (mm)	d (mm)
GER**-D	6.8	16.44	5.05	3.4
GER**-E	9.54	21.66	5.55	4.4

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺

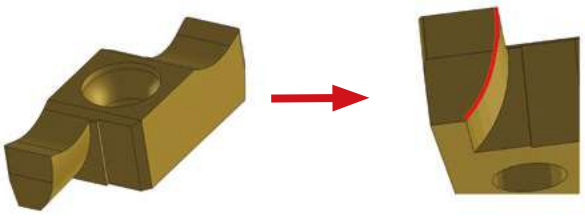


刀片 Insert	右手刀片 Right hand	端面圆直径范围	槽宽 W	切深 B	圆弧 r	PM125	DK110	配套刀杆 Toolholders
平切形刃 	GER100DM06-D	>6mm	1.0	2.5	0.05	●	○	右手刀片配左手刀杆 SEGEL1010H-D SEGEL1212H-D SEGEL1616H-D SEGEL2020K-D SEGEL2525M-D
	GER150DM10-D	>10mm	1.5	4.5	0.2	●	○	
	GER200DM10-D	>10mm	2.0	4.5	0.2	●	○	
	GER250DM15-D	>15mm	2.5	4.5	0.2	●	○	
	GER300DM15-D	>15mm	3.0	4.5	0.2	●	○	
	GER400DM15-D	>15mm	4.0	4.5	0.2	●	○	
	GER150DM10-E	>10mm	1.5	3.6	0.1	●	○	右手刀片配左手刀杆 SEGEL1616K-E SEGEL2020K-E SEGEL2525M-E SEGEL3232M-E
	GER200DM10-E	>10mm	2.0	6.5	0.2	●	○	
	GER250DM15-E	>15mm	2.5	6.5	0.2	●	○	
	GER300DM15-E	>15mm	3.0	6.5	0.2	●	○	
	GER350DM15-E	>15mm	3.5	6.5	0.2	●	○	
	GER400DM15-E	>15mm	4.0	6.5	0.2	●	○	
	GER450DM15-E	>15mm	4.5	6.5	0.2	●	○	
	GER500DM15-E	>15mm	5.0	6.5	0.2	●	○	
圆弧形刃 	GER150DM10R075-D	>10mm	1.5	2.5	0.75	○	○	右手刀片配左手刀杆 SEGEL1010K-D SEGEL1212K-D SEGEL1616H-D SEGEL2020K-D SEGEL2525M-D
	GER200DM10R100-D	>10mm	2.0	3.5	1.0	○	○	
	GER250DM15R125-D	>15mm	2.5	4.5	1.25	○	○	
	GER300DM15R150-D	>15mm	3.0	4.5	1.5	○	○	
	GER400DM15R200-D	>15mm	4.0	4.5	2.0	○	○	
	GER150DM10R075-E	>10mm	1.5	3.6	0.75	○	○	右手刀片配左手刀杆 SEGEL1616H-E SEGEL2020K-E SEGEL2525M-E SEGEL3232M-E
	GER200DM10R100-E	>10mm	2.0	4.8	1.0	○	○	
	GER250DM15R125-E	>15mm	2.5	6.0	1.25	○	○	
	GER300DM15R150-E	>15mm	3.0	6.5	1.5	○	○	
	GER400DM15R200-E	>15mm	4.0	6.5	2.0	○	○	
	GER500DM15R250-E	>15mm	5.0	6.5	2.5	○	○	

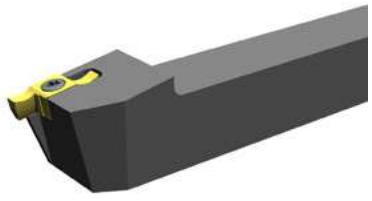
* 端面槽刀具宽度、r 角、切深、最小加工直径均可定制

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

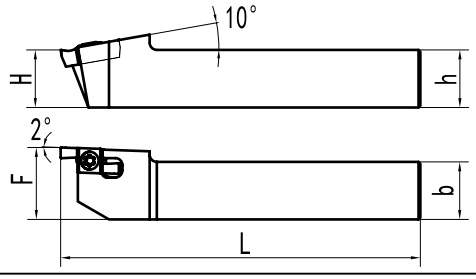
副后刀面 -- 圆弧形避空位
数控程序精细修磨，圆润过渡
相较于简单直线过渡，加强刀片刚性
提升刀片耐用度，稳定性

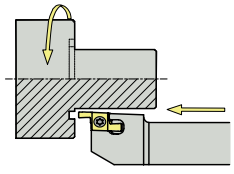


SEGEL 型端面切槽刀杆 Circlip Grooving Tools



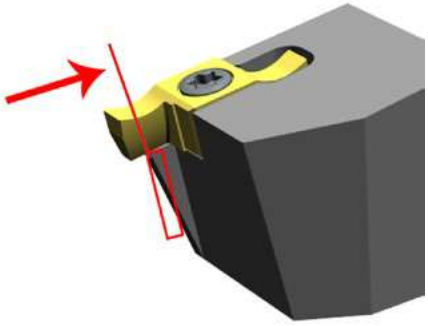
图示为左手刀具 Left hand shown





刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
		h	b	L	F	H		
SEGEL1010H-D	GER**-D	10	10	100	10	10	L60M3*10	T-10
SEGEL1212H-D		12	12	100	12	12		
SEGEL1616H-D		16	16	100	20	16		
SEGEL2020K-D		20	20	125	25	20		
SEGEL2525M-D		25	25	150	32	25		
SEGEL1616K-E	GER**-E	16	16	125	20	16	L60M4*8.5	T-15
SEGEL2020K-E		20	20	125	25	20		
SEGEL2525M-E		25	25	150	32	25		
SEGEL3232M-E		32	32	150	37	32		

特别说明：
当切较深端面槽时，刀杆支持部位处（见右图红色标注处）会与工件发生干涉，必须要把干涉部位磨掉才能保证刀具正常使用。



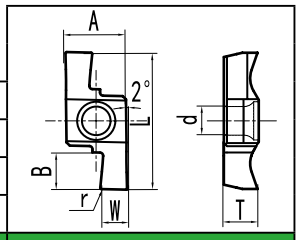
GEL 内孔端面切槽刀片 Internal Circlip Grooving Insert

型号 Model	A (mm)	L (mm)	T (mm)	d (mm)
GEL**-E	9.54	21.66	5.55	4.4

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺

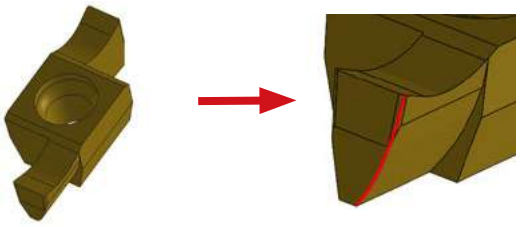


刀片 Insert	右手刀片 Right hand	端面圆直径范围	槽宽 W	切深 B	圆弧 r	PM125	DK110	配套刀杆 Toolholders
平切形刃	GEL150DM10-E	>10mm	1.5	3.6	0.1	●	○	左手刀片配右手刀杆 SIGER0025M-E
	GEL200DM10-E	>10mm	2.0	4.8	0.1	●	○	
	GEL250DM15-E	>15mm	2.5	6.0	0.2	●	○	
	GEL300DM15-E	>15mm	3.0	6.5	0.2	●	○	
	GEL350DM15-E	>15mm	3.5	6.5	0.2	●	○	
	GEL400DM15-E	>15mm	4.0	6.5	0.2	●	○	
	GEL450DM15-E	>15mm	4.5	6.5	0.2	●	○	
	GEL500DM15-E	>15mm	5.0	6.5	0.2	●	○	
圆弧形刃	GEL150DM10R075-E	>10mm	1.5	3.6	0.75	●	○	左手刀片配右手刀杆 SIGER0025M-E
	GEL200DM10R100-E	>10mm	2.0	4.8	1.0	●	○	
	GEL250DM15R125-E	>15mm	2.5	6.0	1.25	●	○	
	GEL300DM15R150-E	>15mm	3.0	6.5	1.5	●	○	
	GEL400DM15R200-E	>15mm	4.0	6.5	2.0	●	○	
	GEL500DM15R250-E	>15mm	5.0	6.5	2.5	●	○	

* 端面槽刀具宽度、r 角、切深、最小加工直径均可定制

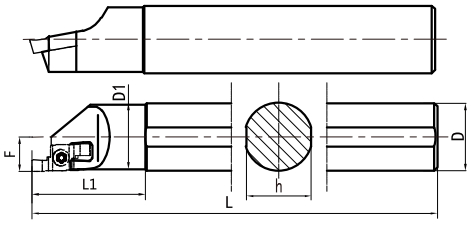
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

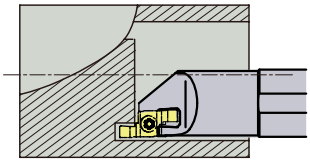
副后刀面 -- 圆弧形避空位
数控程序精细修磨，圆润过渡
相较于简单直线过渡，加强刀片刚性
提升刀片耐用度，稳定性



SIGER 型内端面切槽刀杆 Internal Circlip Grooving Tools

图示为右手刀具 Right hand shown





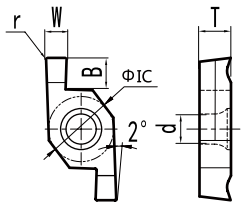
刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)						刀片螺钉 Insert Screw	扳手 Torx Key
		D1	L1	D	L	F	h		
SIGER0020Q-E	GEL**-DM**-E	19	40	20	180	10.8	19	L60M4*8.5	T-15
SIGER0025R-E		24	42	25	200	13.3	24	L60M4*8.5	T-15

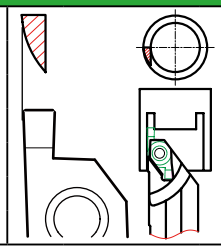
VC 系列端面切槽刀片 Internal Circlip Grooving Insert

型号 Model	IC (mm)	T (mm)	d (mm)
VC16**-DM20*	9.525	4.6	4.4

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended				
钢件	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N			☺

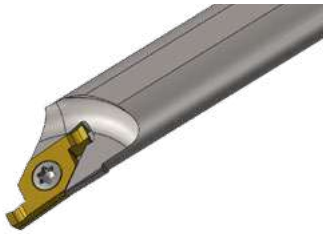


刀片 Insert		刀片型号 Right hand	端面圆直径范围	槽宽 W	切深 B	圆弧 r	PM125	DK110	配套刀杆 Toolholders
		VC16R100-DM20L	>20mm	1.0	2.5	0.1	●	○	S16M-SVFPR16-18 S20Q-SVFPR16-22 S25R-SVFPR16-27
		VC16R125-DM20L	>20mm	1.25	2.5	0.1	●	○	
		VC16R150-DM20L	>20mm	1.5	4.8	0.2	●	○	
		VC16R180-DM20L	>20mm	1.8	4.8	0.2	●	○	
		VC16R200-DM20L	>20mm	2.0	4.8	0.2	●	○	
		VC16R250-DM20L	>20mm	2.5	4.8	0.2	●	○	
		VC16R300-DM20L	>20mm	3.0	4.8	0.2	●	○	

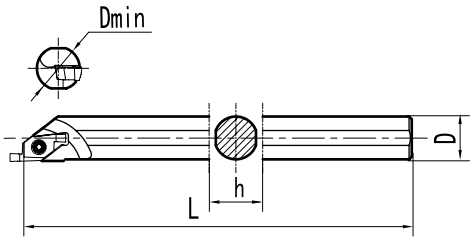
* 端面槽刀具宽度、r 角、切深、最小加工直径均可定制

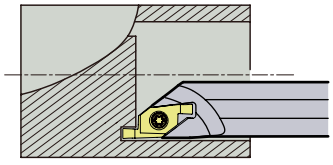
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

SVFPR 端面切槽刀杆 Internal Circlip Grooving Tools



图示为右手刀具 Right hand shown





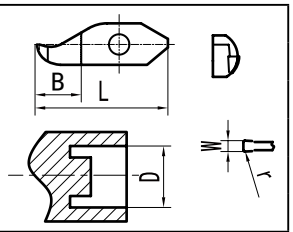
刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)				刀片螺钉 Insert Screw	扳手 Torx Key
		Dmin	D	L	h		
S16M-SVFPR16-18	VC16R**-DM20L	18	16	150	15	L60M4*8.5	T-15
S20Q-SVFPR16-22		22	20	180	19	L60M4*8.5	T-15
S25R-SVFPR16-27		27	25	200	24	L60M4*8.5	T-15

SPDR 端面切槽刀片　SPDR Internal Circlip Grooving Insert

型号 Model	L (mm)
SPDR**DM06A	13.6
SPDR**DM10	25.1

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



刀片 Insert	右手刀片 Right hand	端面圆直径范围 D min	端面圆直径范围 D max	槽宽 W	切深 B	圆弧 r	PM125	DK110	配套刀杆 Toolholders
	SPDR080DM06A	6	∞	0.8	4.5	0.1	○	○	
	SPDR100DM06A	6	∞	1.0	6	0.15	○	○	KSPDR0010F06A KSPDR0012F06A
	SPDR120DM06A	6	∞	1.2	6	0.15	○	○	
	SPDR150DM06A	6	∞	1.5	6	0.15	○	○	
	SPDR175DM06A	6	∞	1.75	6	0.15	○	○	
	SPDR200DM06A	6	∞	2.0	6	0.15	○	○	
	SPDR100DM10	10	32	1.0	5.4	0.2	●	○	KSPDR0012F10 KSPDR0016F10 KSPDR0020F10
	SPDR150DM10	10	32	1.5	6.4	0.2	●	○	
	SPDR200DM10	10	∞	2.0	7.8	0.2	●	○	
	SPDR250DM10	10	∞	2.5	9.9	0.2	●	○	
	SPDR300DM10	10	∞	3.0	9.9	0.2	●	○	

注：其他宽度的切削刃可以接受定制． Note: cutting edges of other widths can be customized.

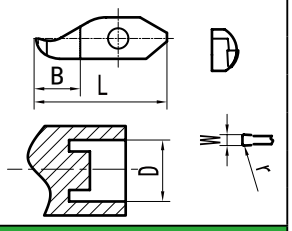
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

SPDR 球头型切槽刀片　SPDR Ball type Insert

型号 Model	L (mm)
SPDR**DM06	13.6
SPDR**DM10	25.1

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢件	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



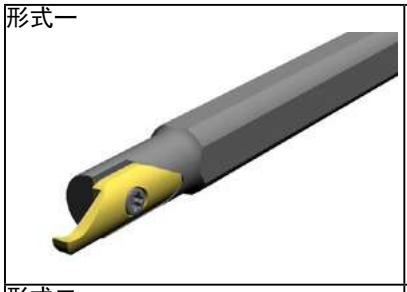
刀片 Insert	右手刀片 Right hand	端面圆直径范围 D min	端面圆直径范围 D max	槽宽 W	切深 B	圆弧 r	PM125	DK110	配套刀杆 Toolholders
	SPDR080DM06A-R0.40	6	∞	0.80	4.5	0.40	○	○	KSPDR0010F06A KSPDR0012F06A
	SPDR100DM06A-R0.50	6	∞	1.00	6.0	0.50	○	○	
	SPDR120DM06A-R0.60	6	∞	1.20	6.0	0.60	○	○	
	SPDR150DM06A-R0.75	6	∞	1.50	6.0	0.75	○	○	
	SPDR180DM06A-R0.90	6	∞	1.80	6.0	0.90	○	○	
	SPDR200DM06A-R1.00	6	∞	2.00	6.0	1.00	○	○	
	SPDR100DM10-R0.50	10	32	1.00	5.4	0.50	●	○	KSPDR0012F10 KSPDR0016F10 KSPDR0020F10
	SPDR150DM10-R0.75	10	32	1.50	6.4	0.75	●	○	
	SPDR200DM10-R1.00	10	∞	2.00	7.8	1.00	●	○	
	SPDR250DM10-R1.25	10	∞	2.50	9.9	1.25	●	○	
	SPDR300DM10-R1.50	10	∞	3.00	9.9	1.50	●	○	

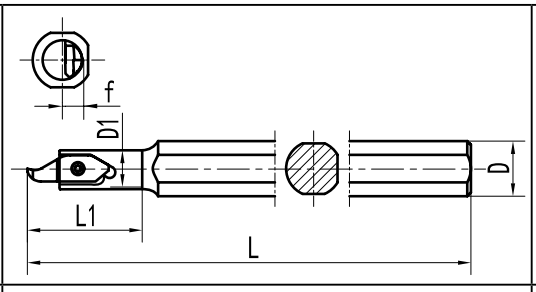
注：其他宽度的切削刃可以接受定制． Note: cutting edges of other widths can be customized.

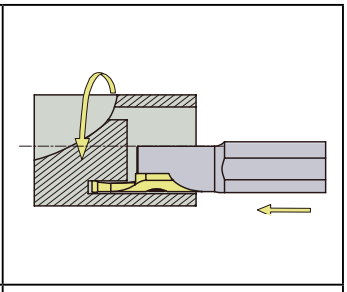
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

小径内孔端面切槽刀杆 Internal Circlip Grooving Tools

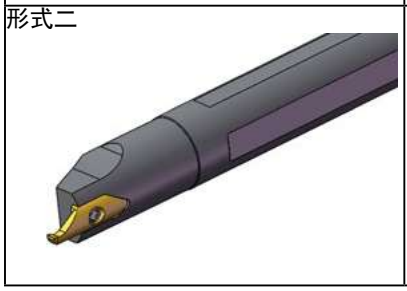
形式一

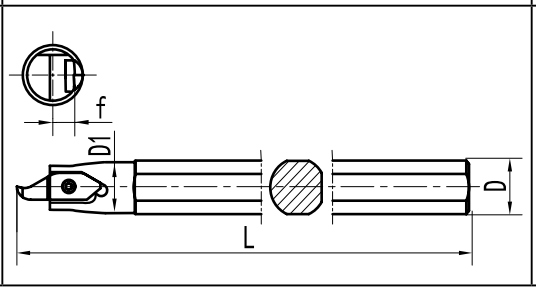


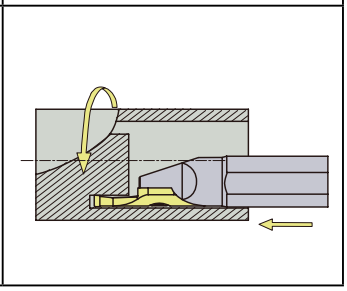




形式二







刀杆型号 Toolholder Type	刀片型号 Insert Type	形式 Type	尺寸 Dimensions (mm)					刀片螺钉 Insert Screw	扳手 Torx Key
			D	D1	L	L1	f		
KSPDR0010F06A	SPDR**DM06A	形式一	10	6	90	18	3	L60M2*6	T-6
KSPDR0012H06A			12	6	100	18	3	L60M2*6	T-6
KSPDR0016K06A			16	6	125	18	3	L60M2*6	T-6
KSPDR0012H10	SPDR**DM10		12	10	100	32	5.2	L60M3*8	T-10
KSPDR0016K10			16	10	125	36	5.2	L60M3*8	T-10
KSPDR0020M10			20	10	150	42	5.2	L60M3*8	T-10
KSPDR0012K10F		形式二	12	11.5	125	-	6.8	L60M3*8	T-10
KSPDR0016M10F			16	15.5	150	-	8.8	L60M3*8	T-10
KSPDR0020P10F			20	19.5	170	-	10.8	L60M3*8	T-10

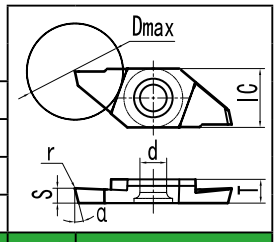
TKF12 系列切断切槽刀片 TKF Parting-off Insert

型号 Model	IC (mm)	T (mm)	d (mm)
TKF12**	8.7	3	5
TKF16**	9.5	4	5

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N			☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	角度 α	切断深度 Dmax/2	PM125 R	PM125 L	DK110 R	DK110 L	圆弧 r	刀杆 Toolholder
	TKF12R050-S	TKF12L050-S	0.5	0	2.5	●	○	○	○	0.05	右手刀片配右刀杆 – KTKFR1010K-12 KTKFR1212K-12 KTKFR1616M-12 KTKFR2020M-12
	TKF12R070-S	TKF12L070-S	0.7	0	4	●	○	○	○	0.05	
	TKF12R100-S	TKF12L100-S	1.0	0	6	●	○	○	○	0.08	
	TKF12R150-S	TKF12L150-S	1.5	0	6	●	○	○	○	0.08	
	TKF12R200-S	TKF12L200-S	2.0	0	6	●	○	○	○	0.08	
	TKF12R050-S16R	TKF12L050-S16R	0.5	16	2.5	●	○	○	○	0.05	
	TKF12R070-S16R	TKF12L070-S16R	0.7	16	4	●	○	○	○	0.05	
	TKF12R100-S16R	TKF12L100-S16R	1.0	16	6	●	○	○	○	0.08	
	TKF12R150-S16R	TKF12L150-S16R	1.5	16	6	●	○	○	○	0.08	
	TKF12R200-S16R	TKF12L200-S16R	2.0	16	6	●	○	○	○	0.08	
	TKF12R050-NB	TKF12L050-NB	0.5	0	2.5	●	○	○	○	0.05	左手刀片配左刀杆 – KTKFL1010K-12 KTKFL1212K-12 KTKFL1212M-12 KTKFL1616M-12 KTKFL2020M-12
	TKF12R070-NB	TKF12L070-NB	0.7	0	4	●	○	○	○	0.05	
	TKF12R100-NB	TKF12L100-NB	1.0	0	6	●	○	○	○	0.08	
	TKF12R150-NB	TKF12L150-NB	1.5	0	6	●	○	○	○	0.08	
	TKF12R200-NB	TKF12L200-NB	2.0	0	6	●	○	○	○	0.08	
	TKF12R050-NB-20DR	TKF12L050-NB-20DR	0.5	20	2.5	●	○	○	○	0.05	
	TKF12R070-NB-20DR	TKF12L070-NB-20DR	0.7	20	4	●	○	○	○	0.05	
	TKF12R100-NB-20DR	TFK12L100-NB-20DR	1.0	20	6	●	○	○	○	0.08	
	TKF12R150-NB-20DR	TKF12L150-NB-20DR	1.5	20	6	●	○	○	○	0.08	
	TKF12R200-NB-20DR	TKF12L200-NB-20DR	2.0	20	6	●	○	○	○	0.08	

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

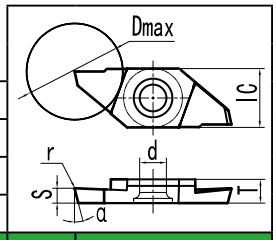
TKF16 系列切断切槽刀片 TKF Parting-off Insert

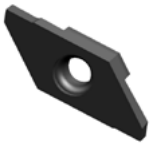
型号 Model	IC (mm)	T (mm)	d (mm)
TKF12**	8.7	3	5
TKF16**	9.5	4	5

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



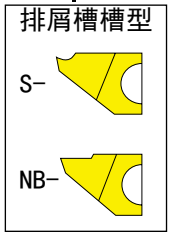
刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	角度 α	切断深度 Dmax/2	PM125 R	PM125 L	DK110 R	DK110 L	圆弧 r	刀杆 Toolholder
	TKF16R100-S	TKF16L100-S	1.0	0	8	●	○	○	○	0.08	右手刀片配右刀杆 – KTKFR1010K-16 KTKFR1212K-16 KTKFR1616M-16 KTKFR2020M-16
	TKF16R150-S	TKF16L150-S	1.5	0	8	●	○	○	○	0.1	
	TKF16R200-S	TKF16L200-S	2.0	0	8	●	○	○	○	0.1	
	TKF16R250-S	TKF16L250-S	2.5	0	8	●	○	○	○	0.1	
	TKF16R300-S	TKF16L300-S	3.0	0	8	●	○	○	○	0.15	
	TKF16R100-S16R	TKF16L100-S16R	1.0	16	8	●	○	○	○	0.08	
	TKF16R150-S16R	TKF16L150-S16R	1.5	16	8	●	○	○	○	0.1	
	TKF16R200-S16R	TKF16L200-S16R	2.0	16	8	●	○	○	○	0.1	
	TKF16R250-S16R	TKF16L250-S16R	2.5	16	8	●	○	○	○	0.1	
	TKF16R300-S16R	TKF16L300-S16R	3.0	16	8	●	○	○	○	0.15	
	TKF16R100-NB	TKF16L100-NB	1.0	0	8	●	○	○	○	0.08	左手刀片配左刀杆 – KTKFL1010K-16 KTKFL1212K-16 KTKFL1212M-16 KTKFL1616M-16 KTKFL2020M-16
	TKF16R150-NB	TKF16L150-NB	1.5	0	8	●	○	○	○	0.1	
	TKF16R200-NB	TKF16L200-NB	2.0	0	8	●	○	○	○	0.1	
	TKF16R250-NB	TKF16L250-NB	2.5	0	8	●	○	○	○	0.1	
	TKF16R300-NB	TKF16L300-NB	3.0	0	8	●	○	○	○	0.15	
	TKF16R100-NB-20DR	TKF16L100-NB-20DR	1.0	20	8	●	○	○	○	0.08	
	TKF16R150-NB-20DR	TKF16L150-NB-20DR	1.5	20	8	●	○	○	○	0.1	
	TKF16R200-NB-20DR	TKF16L200-NB-20DR	2.0	20	8	●	○	○	○	0.1	
	TKF16R250-NB-20DR	TKF16L250-NB-20DR	2.5	20	8	●	○	○	○	0.1	
	TKF16R300-NB-20DR	TKF16L300-NB-20SR	3.0	20	8	●	○	○	○	0.15	

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

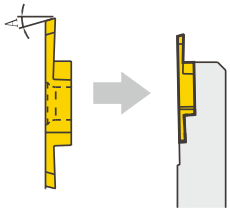
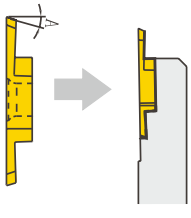
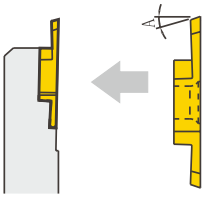
刀片型号表示方法 Representation method for blade type

TKF 12 R 100 -S- 16 R

- TKF：刀片名称
- 12：刀片大小
- R：刀片左右手 R：右手刀 L：左手刀
- 100：刀片的刃宽 100=1.0mm
- -S-：排屑槽槽型 S- / NB-
- 16：导程角的角度 16=16°
- R：导程角的方向 R：右朝向 L：左朝向



TKF 系列刀片导程角命名示例

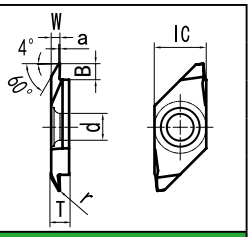
右手刀杆配右手刀片		右手刀杆配右手刀片		左手刀杆配左手刀片	
刀片导程角方向	R	刀片导程角方向	L	刀片导程角方向	R
刀片型号示例	TKF12R150-S16R	刀片型号示例	TKF12R150-S16L	刀片型号示例	TKF12L150-S16R
					

TKFB 后扫刀片 TKFB Back Turning Insert

型号 Model	IC (mm)	T (mm)	d (mm)
TKFB12**	8.7	3	5
TKFB16**	9.5	4	5

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

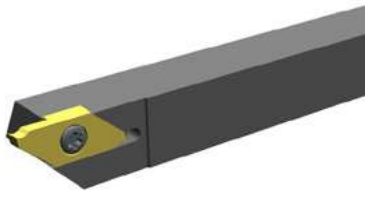
材质推荐 material recommended				
钢	P	☺		
不锈钢	M	☺		
铸铁	K	😐		
有色金属	N			☺



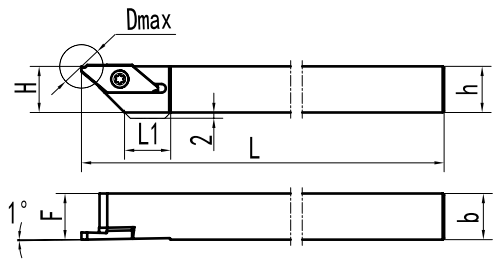
刀片 Insert	右手刀片 Right hand	槽宽 W	刃宽 a	切深 B	圆弧 r	PM125 R	PM125 L	DK110 R	DK110 L	刀杆 Toolholder
	TKFB12R15005M	1.5	0.25	2.6	<0.05	●	○	○	○	KTKFR1010K-12 KTKFR1212K-12 KTKFR1616M-12...
	TKFB12R28005M	2.8	0.3	4.6	<0.05	●	○	○	○	
	TKFB12R28010M	2.8	0.3	4.6	<0.1	●	○	○	○	
	TKFB16R38005M	3.8	0.3	6.3	<0.05	●	○	○	○	KTKFR1616M-16 KTKFR2020M-16...
	TKFB16R38010M	3.8	0.3	6.3	<0.1	●	○	○	○	

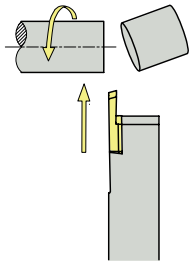
● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

TKF 系列切槽切断刀杆　Grooving & Parting-off Tools



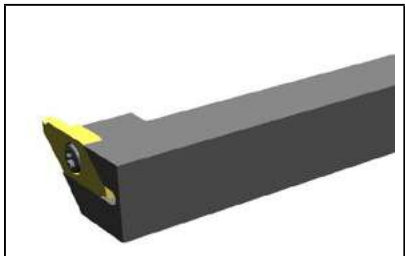
图示为右手刀具 Right hand shown



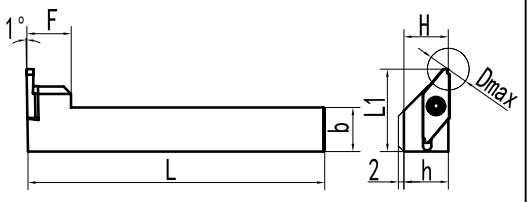


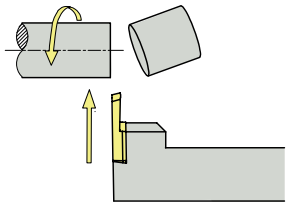
刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L	Dmax	L1		
KTKFR	1010K-12	TKF12R**（切槽／断） TKFB12R**（后扫） TKFT12R**（螺纹）	10	10	10	10	125	12	15	L60M4*10	T-15
	1212K-12		12	12	12	12			–		
	1212M-12		12	12	12	12	150				
	1616M-12		16	16	16	16					
	2020M-12		20	20	20	20					
	2525M-12		25	25	25	25					
KTKFR	1010K-16	TKF16R**（切槽／断） TKFB16R**（后扫） TKFT16R**（螺纹）	10	10	10	10	125	16	20	L60M4*10	T-15
	1212K-16		12	12	12	12			–		
	1212M-16		12	12	12	12	150				
	1616M-16		16	16	16	16					
	2020M-16		20	20	20	20					
	2525M-16		25	25	25	25					
KTKFL	1010K-12	TKF12L**（切槽／断） TKFB12L**（后扫） TKFT12L**（螺纹）	10	10	10	10	125	12	15	L60M4*10	T-15
	1212K-12		12	12	12	12			–		
	1212M-12		12	12	12	12	150				
	1616M-12		16	16	16	16					
	2020M-12		20	20	20	20					
	2525M-12		25	25	25	25					
KTKFL	1010K-16	TKF16L**（切槽／断） TKFB16L**（后扫） TKFT16L**（螺纹）	10	10	10	10	125	16	20	L60M4*10	T-15
	1212K-16		12	12	12	12			–		
	1212M-16		12	12	12	12	150				
	1616M-16		16	16	16	16					
	2020M-16		20	20	20	20					
	2525M-16		25	25	25	25					

TKF 系列切槽刀杆 – 排刀机用 Gang-type Grooving Tools



图示为左手刀具





刀杆型号 Toolholder Type	刀片型号 Insert Type	尺寸 Dimensions (mm)							刀片螺钉 Insert Screw	扳手 Torx Key
		h	b	H	F	L	Dmax	L1		
KTKFL1010F-12-A90	TKF12R**（切槽 / 断）	10	10	10	10	80	12	16	L60M4*10	T-15
KTKFL1212F-12-A90	TKFB12R**（后扫）	12	12	12	12	80		20		
KTKFL1616H-12-A90		16	16	16	16	100		24		
KTKFL2020K-12-A90	TKFT12R**（螺纹）	20	20	20	20	125		30		
KTKFL1010F-16-A90	TKF16R**（切槽 / 断）	10	10	10	10	80	16	20	L60M4*10	T-15
KTKFL1212F-16-A90	TKFB16R**（后扫）	12	12	12	12	80		20		
KTKFL1616H-16-A90		16	16	16	16	100		24		
KTKFL2020K-16-A90	TKFT16R**（螺纹）	20	20	20	20	125		30		

走芯机刀杆专用螺钉

Screw for CNC Precision Automatic Lathe tool holders

订货型号SP-M4X10

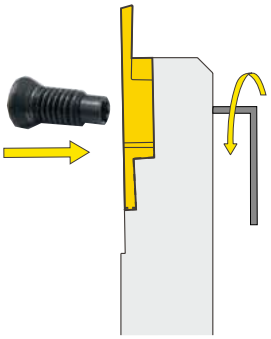
Ordering code: SP-M4X10

★ 走芯机刀杆专用螺钉(M4X10)
Screw for CNC Precision Automatic Lathe tool holders (M4*10)

★ 从正面锁紧使用扳手T15，从背面锁紧使用扳手T8
Front Side： Locking with T15 Wrench
Reverse Side：Locking with T8 Wrench

★ 需单独订购
Ordered Separately

★ 适配于TGF32、TKF12/16、TKFB、THC42系列刀具
Apply to ： Tool Holders for inserts TGF32, TKF12/16, TKFB, THC42



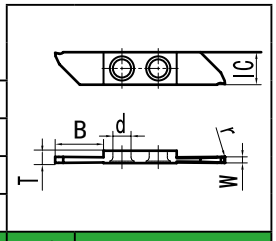
螺钉可在刀杆另一侧拧松，方便拆换刀片

THC42 双孔切槽、切断刀片 THC42 Parting-off Insert

型号 Model	IC (mm)	d (mm)
THC42**	7.94	4.35

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended			
钢	P	☺	
不锈钢	M	☺	
铸铁	K	😐	
有色金属	N		☺



刀片 Insert	右手刀片 Right hand	左手刀片 Left hand	槽宽 W	切深 B	圆弧 r	角度 α	PM125 R	PM125 L	DK110 R	DK110 L	厚度 T	刀杆 Toolholder
	THC42R100-CE	THC42L100-CE	1.0	5	0.06	0	●		○		3.07	右手刀片配右刀杆 - THCR1010J42 THCR1212J42 THCR1616J42 THCR2020K42 THCR2525M42 左手刀片配左刀杆 - THCL1010J42 THCL1212J42 THCL1616J42 THCL2020K42 THCL2525M42
	THC42R150-CE	THC42L150-CE	1.5	8.5	0.06	0	●		○		3.07	
	THC42R200-CE	THC42L200-CE	2.0	11.5	0.1	0	●		○		3.07	
	THC42R250-CE	THC42L250-CE	2.5	11.5	0.1	0	●		○		3.07	
	THC42R300-CE	THC42L300-CE	3.0	11.5	0.2	0	●		○		3.07	
	THC42R340-CE	THC42L340-CE	3.4	11.5	0.2	0	●		○		3.47	
	THC42R100-CE15R	THC42L100-CE15R	1.0	5	0.06	15	●		○		3.07	
	THC42R150-CE15R	THC42L150-CE15R	1.5	8.5	0.06	15	●		○		3.07	
	THC42R200-CE15R	THC42L200-CE15R	2.0	11.5	0.1	15	●		○		3.07	
	THC42R250-CE15R	THC42L250-CE15R	2.5	11.5	0.1	15	●		○		3.07	
	THC42R300-CE15R	THC42L300-CE15R	3.0	11.5	0.2	15	●		○		3.07	
	THC42R340-CE15R	THC42L340-CE15R	3.4	11.5	0.2	15	●		○		3.47	
	THC42R200-CN	THC42L200-CN	2.0	11.5	0.1	0	●		○		3.07	
	THC42R250-CN	THC42L250-CN	2.5	11.5	0.1	0	●		○		3.07	
	THC42R300-CN	THC42L300-CN	3.0	11.5	0.2	0	●		○		3.07	
	THC42R200-CU15R	THC42L200-CU15R	2.0	11.5	0.1	15	●		○		3.07	
	THC42R250-CU15R	THC42L250-CU15R	2.5	11.5	0.1	15	●		○		3.07	
	THC42R300-CU15R	THC42L300-CU15R	3.0	11.5	0.2	15	●		○		3.07	

* 可定制特殊宽度，以及特殊圆弧角

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

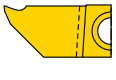
刀片型号表示方法 Representation method for blade type

THC 42 R 200 -CE 15 R

- THC：刀片名称
- 42：刀片大小
- R：刀片左右手 R：右手刀 L：左手刀
- 200：刀片的刃宽 050=0.5mm
- -CE：排屑槽槽型
- 15：导程角的角度 15=15°
- R：导程角的方向 R：右朝向 L：左朝向

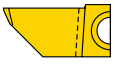
排屑槽槽型

CE-



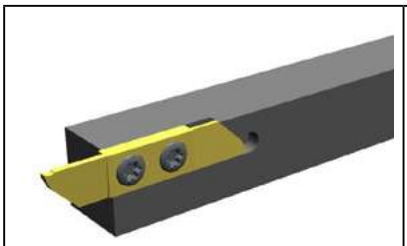
CU-

CN-

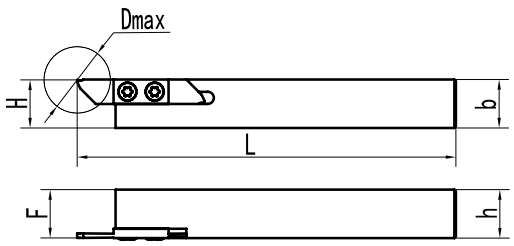


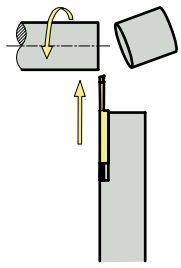
CU15R-

THC42 切槽刀杆 THC42 Parting-off Tools



图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type		刀片型号 Insert Type	尺寸 Dimensions (mm)						刀片螺钉 Insert Screw	扳手 Torx Key
			h	b	H	F	L	Dmax		
THCR	1010J42	THC42R**	10	10	10	10	110	23	L60M4*10	T-15
	1212J42		12	12	12	12				
	1616J42		16	16	16	16				
	2020K42		20	20	20	20	125			
	2525M42		25	25	25	25	150			
THCL	1010J42	THC42L**	10	10	10	10	110	23	L60M4*10	T-15
	1212J42		12	12	12	12				
	1616J42		16	16	16	16				
	2020K42		20	20	20	20	125			
	2525M42		25	25	25	25	150			

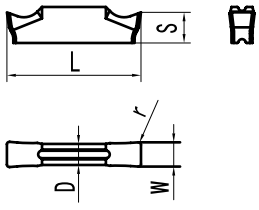
MGMN 系列切槽切断刀片 MGMN Parting-off Insert

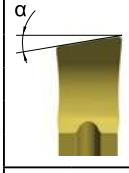
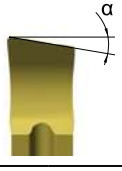
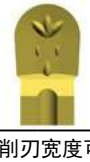
型号 Model	L (mm)	S (mm)	D (mm)
MGMN150**	16	3.5	1.2
MGMN200**	16	3.5	1.6
MGMN250**	18.5	3.85	2
MGMN300**	21	4.8	2.35
MGMN400**	21	4.8	3.3
MGMN500**	26	5.8	4.12

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

材质推荐 material recommended				
钢	P	☺	☺	
不锈钢	M	☺	☺	
铸铁	K	😐	😐	
有色金属	N			☺



刀片 Insert	槽型	刀片型号 Type	槽宽 W	圆弧 r	角度 α	PM310	DP510	DK110	刀杆 Toolholder
		MGGN150-LH	1.5	0.15	0	●	●	●	刀片既可以配右刀杆也可以配左刀杆 刀杆的末尾数字代表配套的刀片刃宽，示例： 外切槽 MGEHR/L2020-3.0 配 MGMN300** 内切槽 MGIVR2520-3.0 配 MGMN300**
		MGGN200-LH	2.0	0.2		●	●	●	
		MGGN250-LH	2.5	0.2		●	●	●	
		MGGN300-LH	3.0	0.4		●	●	●	
		MGGN400-LH	4.0	0.4		●	●	●	
		MGGN500-LH	5.0	0.8		●	●	●	
		MGGN150-S06R	1.5	0.15	6	●	●	●	
		MGGN200-S06R	2.0	0.2		●	●	●	
		MGGN250-S06R	2.5	0.2		●	●	●	
		MGGN300-S06R	3.0	0.4		●	●	●	
		MGGN400-S06R	4.0	0.4		●	●	●	
		MGGN500-S06R	5.0	0.8		●	●	●	
		MGGN150-S06L	1.5	0.15		●	●	●	
		MGGN200-S06L	2.0	0.2		●	●	●	
		MGGN250-S06L	2.5	0.2		●	●	●	
		MGGN300-S06L	3.0	0.4		●	●	●	
		MGGN400-S06L	4.0	0.4		●	●	●	
		MGGN500-S06L	5.0	0.8		●	●	●	
		MGMN150-G	1.5	0.15	0	●	●		
		MGMN200-G	2.0	0.2		●	●		
		MGMN250-G	2.5	0.2		●	●		
		MGMN300-G	4.0	0.4		●	●		
		MGMN400-G	4.0	0.4		●	●		
		MGMN200-M	2.0	0.2		●	●		
		MGMN250-M	2.5	0.2		●	●		
		MGMN300-M	3.0	0.4		●	●		
		MGMN400-M	4.0	0.4		●	●		
		MGMN500-M	5.0	0.8		●	●		
		MGMN600-M	6.0	0.8		●	●		
		MGMN200-T	2.0	0.2		●	●		
		MGMN300-T	3.0	0.4		●	●		
		MGMN400-T	4.0	0.4		●	●		
		MGMN500-T	5.0	0.8		○	○		
		MGMN200-C	2.0	0.2		●	●		
		MGMN250-C	2.5	0.2		●	●		
		MGMN300-C	3.0	0.4		●	●		
		MGMN400-C	4.0	0.4		●	●		
		MGMN500-C	5.0	0.8		●	●		
		MRMN200-M	2.0	1.0		●	●		
		MRMN300-M	3.0	1.5		●	●		
		MRMN400-M	4.0	2.0		●	●		
		MRMN500-M	5.0	2.5		●	●		

MGGN 系列切削刃角度、切削刃宽度可定制

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

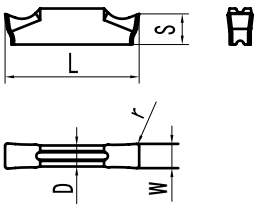
MGMN 系列切槽切断刀片 MGMN Parting-off Insert PCD & CBN

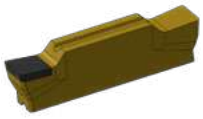
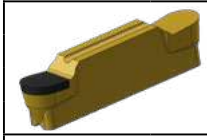
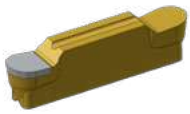
型号 Model	L (mm)	S (mm)	D (mm)
MGMN150**	16	3.5	1.2
MGMN200**	16	3.5	1.6
MGMN250**	18.5	3.85	2
MGMN300**	21	4.8	2.35
MGMN400**	21	4.8	3.3
MGMN500**	26	5.8	4.12

☺ 优先推荐 Good recommendation

😐 一般推荐 General recommendation

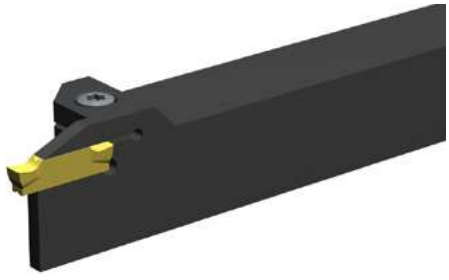
材质推荐 material recommended				
铸铁	K	☺		
有色金属	N	☺		
高硬材料	H		😐	



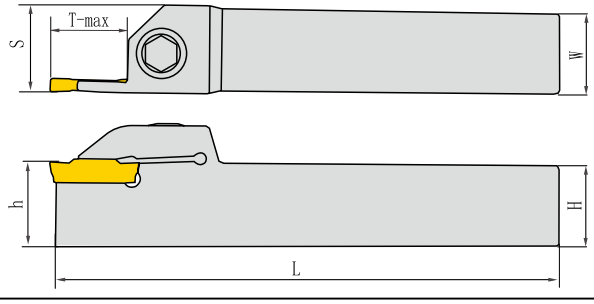
刀片 Insert	槽型	刀片型号 Type	槽宽 W	圆弧 r	角度 α	PCD	CBN		刀杆 Toolholder
		MGMN150-PCD	1.5	0.15	0	●			刀片既可以配右刀杆 也可以配左刀杆 刀杆的末尾数字代表配套的刀片刃宽，示例： 外切槽 MGEHR/L2020-3.0 配 MGMN300** 内切槽 MGIVR2520-3.0 配 MGMN300**
		MGMN200-PCD	2.0	0.2		●			
		MGMN250-PCD	2.5	0.2		●			
		MGMN300-PCD	4.0	0.4		●			
		MGMN400-PCD	4.0	0.4		●			
		MGMN500-PCD	5.0	0.4		●			
		MGMN150-CBN	1.5	0.15			●		
		MGMN200-CBN	2.0	0.2			●		
		MGMN250-CBN	2.5	0.2			●		
		MGMN300-CBN	3.0	0.4			●		
		MGMN400-CBN	4.0	0.4			●		
		MGMN500-CBN	5.0	0.4			●		
		MRMN200-PCD	2.0	1.0		●			
		MRMN300-PCD	3.0	1.5		●			
		MRMN400-PCD	4.0	2.0		●			
		MRMN500-PCD	5.0	2.5		●			
		MRMN200-CBN	2.0	1.0			●		
		MRMN300-CBN	3.0	1.5			●		
		MRMN400-CBN	4.0	2.0			●		
		MRMN500-CBN	5.0	2.5			●		

● 常备库存（主推） Standing stock ◯ 非常备库存 Extraordinary stock

MGMN 系列外切刀杆 External Parting-off Tools



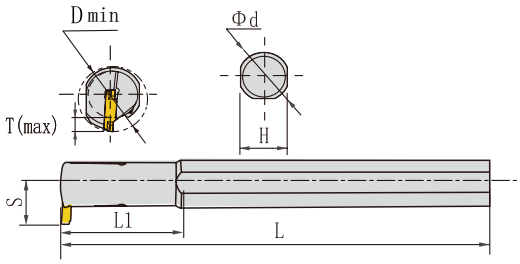
图示为右手刀具 Right hand shown

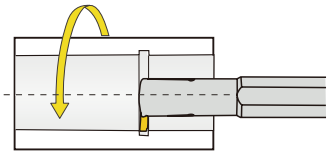


刀杆型号 Toolholder Type		刀片型号 Insert Type	最大切深	尺寸 Dimensions (mm)				刀片螺钉 Insert Screw	扳手 Torx Key
			Tmax	H=(h)	W	L	S		
MGEHR 右手刀杆 Right hand	1616-1.5	MGMN150-G MGGN150-LH	14	16	16	100	16.2	LTX0512	L2.0
	2020-1.5			20	20	125	20.2		
	1212-2	MGMN200-G MGGN200-LH MRMN200-M	14	12	12	100	14.25	BHA0616	L5.0
MGEHL 左手刀杆 Left hand	1616-2			16	16	100	16.25		
	2020-2			20	20	125	20.25		
	2525-2			25	25	150	25.25		
	2020-2.5	MGMN250-G MGMN250-M MGGN250-LH	16	20	20	125	20.3		
	2525-2.5			25	25	150	25.3		
	1616-3	MGMN300-M MGGN300-LH MRMN300-M	18	16	16	100	16.35	BHA0616	L5.0
	2020-3		18	20	20	125	20.4		
	2525-3		18	25	25	150	25.4		
	3232-3		18	32	32	170	32.4		
	2020-4	MGMN400-M MGGN400-LH MRMN400-M	18	20	20	125	20.5		
	2525-4		18	25	25	150	25.4		
	3232-4		18	32	32	170	32.4		
	2020-5	MGMN500-M MGGN500-LH MRMN500-M	23	20	20	150	20.5		
	2525-5		23	25	25	150	25.5		
	3232-5		23	32	32	170	32.5		

MGMN 系列内切刀杆 Internal Parting-off Tools

图示为右手刀具 Right hand shown





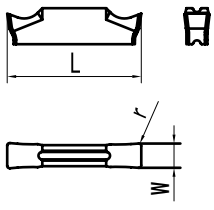
刀杆型号 Toolholder Type		刀片型号 Insert Type	最大切深 Tmax	尺寸 Dimensions (mm) Dmin	d	L	L1	H	S	刀片螺钉 Insert Screw	扳手 Torx Key
MGIVR 右手刀杆 Right hand	2016-1.5	MGMN150-G MGGN150-LH	4	20	16	125	35	15	11.3	MHB0310	L2.5
	2520-1.5			25	20	150	45	18	13.1	MHA0512	L4.0
	2925-1.5			29	25	200	45	23	16.2		
MGIVL 左手刀杆 Left hand	2016-2	MGMN200-G MGGN200-LH MRMN200-M	5	20	16	125	35	15	12.4	MHB0310	L2.5
	2520-2			25	20	150	45	18	14	MHA0512	L4.0
	2925-2			29	25	200	45	23	17.2		
	2520-2.5	MGMN250-G MGMN250-M MGGN250-LH	5	25	20	150	45	18	15.1	MHA0512	L4.0
	2925-2.5			29	25	200	45	23	18.2		
	2520-3	MGMN300-M MGGN300-LH MRMN300-M	6	25	20	150	45	18	15.6	MHA0512	L4.0
	3125-3			31	25	200	45	23	18.9		
	3732-3			37	32	250	65	30	21.5		
	2520-4	MGMN400-M MGGN400-LH MRMN400-M	6	25	20	150	45	18	15.6		
	3125-4			31	25	200	45	23	18.9		
	3732-4			37	32	250	65	30	21.5		
	3125-5	MGMN500-M MGGN500-LH MRMN500-M	8	31	25	200	45	23	19.5		
	3732-5			37	32	250	65	30	21.5		

GX 系列切槽切断刀片　GX Parting-off Insert

型号 Model	L (mm)
GX22E200*	22
GX22E250*	22
GX22E300*	22
GX25E400*	25
GX25E500*	25
GX25E600*	25

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

材质推荐 material recommended					
钢	P	☺	☺	☺
不锈钢	M	☺	☺	☺
铸铁	K	😐	😐	😐
有色金属	N			



刀片 Insert	槽型	刀片型号 Type	槽宽 W	圆弧 r	DM215	DP510	BR215	刀杆 Toolholder
		GX22E200N02-IS	2.0	0.2	●	○	○	GXAR***-22 GXAL***-22
		GX22E250N02-IS	2.5	0.2				
		GX22E300N03-IS	3.0	0.3	●	○	○	
		GX25E400N04-IS	4.0	0.35	●	○	○	
		GX25E500N04-IS	5.0	0.4				
		GX25E600N04-IS	6.0	0.4				

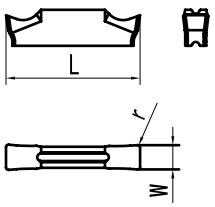
● 常备库存（主推） Standing stock　○ 非常备库存 Extraordinary stock

TD 系列切槽切断刀片 TD Parting-off Insert

型号 Model	L (mm)	S (mm)	D (mm)
TD*2	20	3.9	1.7
TD*3	20	4	2.4
TD*4	20	4.05	3
TD*5	25	4.89	4

☺ 优先推荐 Good recommendation
😐 一般推荐 General recommendation

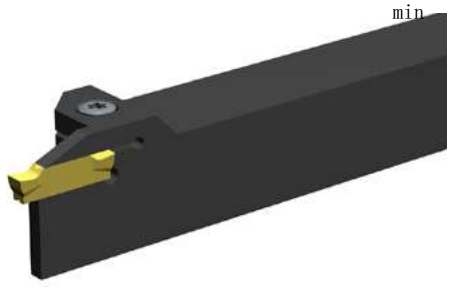
材质推荐 material recommended					
钢	P				
不锈钢	M				
铸铁	K				
有色金属	N				



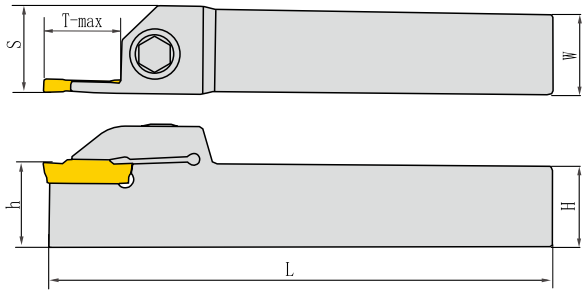
刀片 Insert	槽型	刀片型号 Type	槽宽 W	圆弧 r	PM310	BR215	DK110	刀杆 Toolholder
		TDC2-LH	2	0.2	●		○	刀片既可以配右刀杆也可以配左刀杆 刀杆的末尾数字代表配套的刀片刃宽，示例： 外切槽 TTER/L2020-3.0 配 TDC3 内切槽 TTIR2520-3.0 配 TDC3
		TDC3-LH	3	0.2	●		○	
		TDC4-LH	4	0.3	●		○	
		TDC5-LH	5	0.3	●		○	
		TDJ2	2	0.2	●	●		
		TDJ3	3	0.2	●	●		
		TDJ4	4	0.3	●	●		
		TDJ5	5	0.3	●	●		
		TDC2	2	0.2	●	●		
		TDC3	3	0.2	●	●		
		TDC4	4	0.3	●	●		
		TDC5	5	0.3	●	●		
		TDT3	3	0.2	●	●		
		TDT4	4	0.3	●	●		
		TDT5	5	0.3	●	●		

● 常备库存（主推） Standing stock ○ 非常备库存 Extraordinary stock

TD 系列外切刀杆 External Parting-off Tools



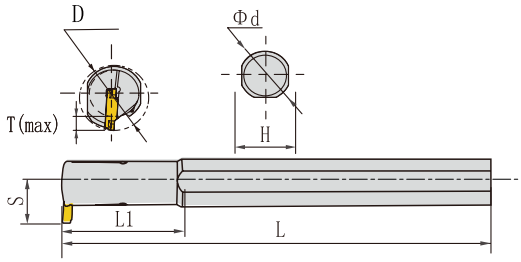
图示为右手刀具 Right hand shown

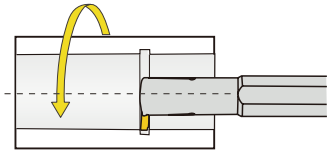


刀杆型号 Toolholder Type		刀片型号 Insert Type	最大切深 Tmax	尺寸 Dimensions (mm) H=(h)	W	L	S	刀片螺钉 Insert Screw	扳手 Torx Key
TTER 右手刀杆 Right hand	1616-2.0	TD*2	14	16	16	110	15.1	M5*16	L4.0
	2020-2.0			20	20	125	19.1		
	2525-2.0			25	25	150	24.1		
TTEL 左手刀杆 Left hand	1616-3.0	TD*3	18	16	16	110	14.8	M5*16	L4.0
	2020-3.0			20	20	125	18.8		
	2525-3.0			25	25	150	23.8		
	2020-4.0	TD*4	18	20	20	125	18.5	M6*16	L5.0
	2525-4.0			25	25	150	23.5		
	2525-5.0	TD*5	23	25	25	150	23.1	M8*20	L6.0
	3232-5.0			32	32	170	29.1		

TD 系列内切刀杆 Internal Parting-off Tools

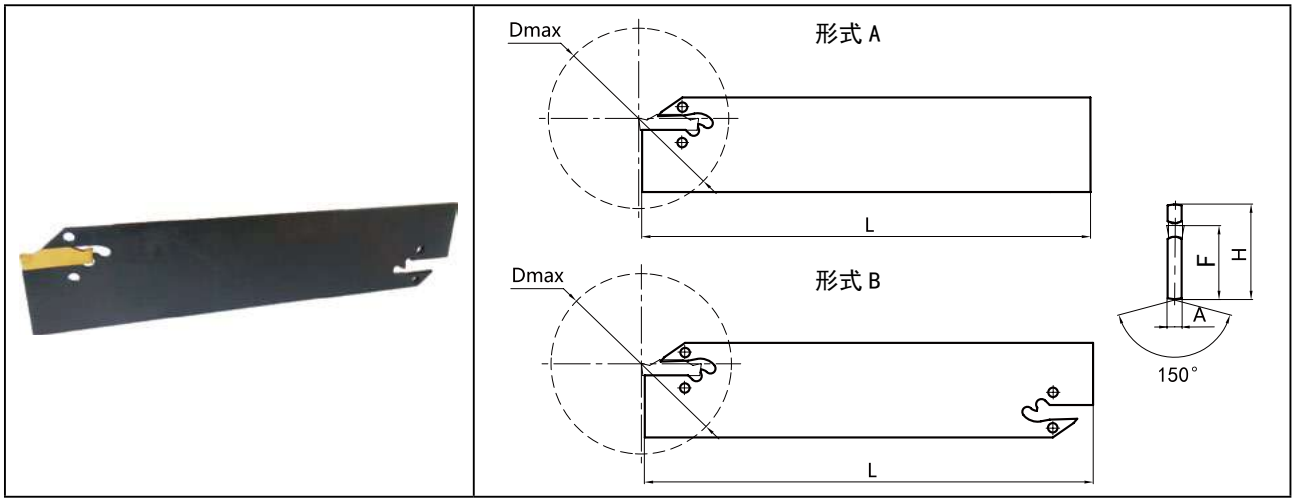
图示为右手刀具 Right hand shown





刀杆型号 Toolholder Type		刀片型号 Insert Type	最大切深 Tmax	最小过孔 Dmin	尺寸 Dimensions (mm) L1	L	F	A	d	刀片螺钉 Insert Screw	扳手 Torx Key
TTIR 右手刀杆 Right hand	16-2C	TD*2	8.5	25	-	125	16.5	1.8	16	M5*0.8*10	L-W4
	20-2C		6.0	25	40	160	15.8	1.6	20	M5*0.8*12	L-W4
	25-2C		5.0	25	40	200	17.5	1.6	25	M5*0.8*16	L-W4
TTIL 左手刀杆 Left hand	20-3C	TD*3	6.0	25	40	160	15.8	2.1	20	M5*0.8*12	L-W4
	25-3C		5.1	25	40	200	17.5	2.1	25	M5*0.8*16	L-W4
	32-3C		4.7	31	60	250	19.8	2.1	32		L-W4
	20-4C	TD*4	6.0	25	40	160	15.8	2.9	20	M5*0.8*12	L-W4
	25-4C		5.2	25	40	200	17.5	2.9	25	M5*0.8*16	L-W4
	32-4C		4.7	31	60	250	20.8	2.9	32		L-W4
	25-5C	TD*5	5.2	31	40	200	17.3	3.9	25	M6*1*16	L-W5
	32-5C		4.7	31	60	250	20.8	3.9	32	M6*1*20	L-W5

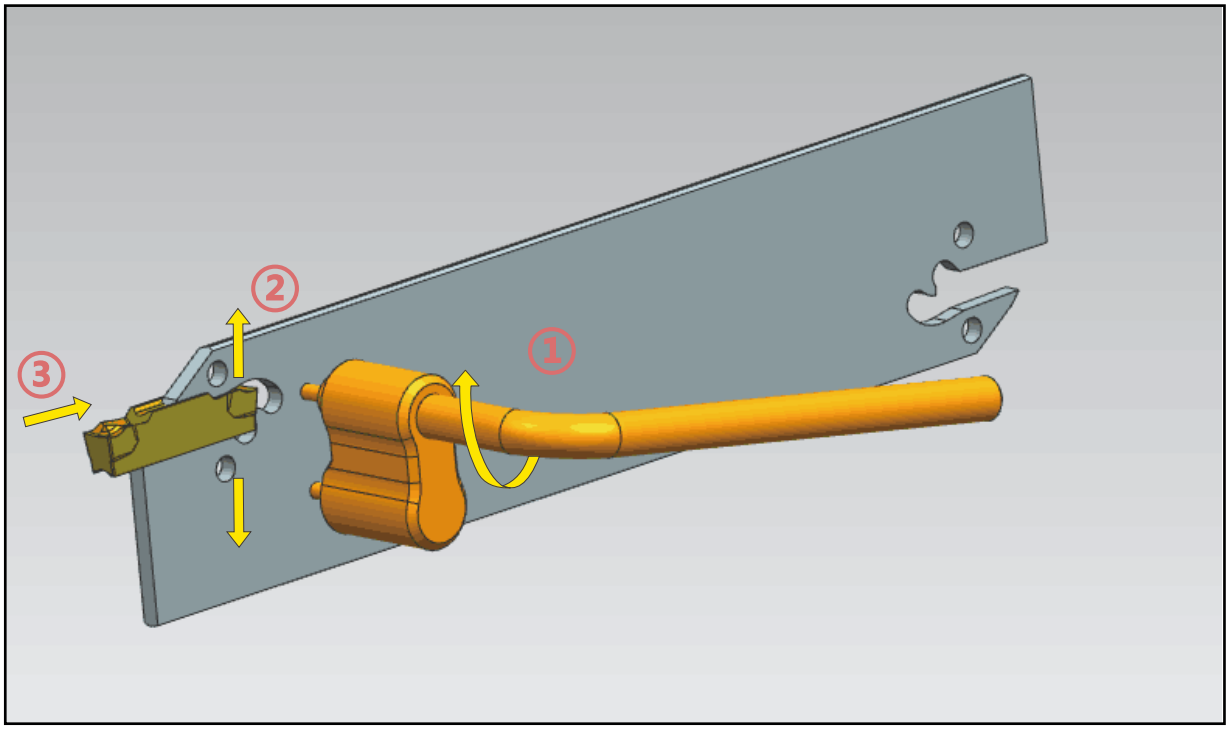
TD 系列切槽、切断刀板 Parting & Grooving Blade



刀板型号 Toolholder Type	形式 Type	刀片型号 Insert Type	最大切深 Dmax	尺寸 Dimensions (mm) H	L	F	A	扳手 Extractor	刀座 Blook for parting & grooving balde
TGB26-2	A	TD*2	40	26	150	21.4	1.8	EDG-33B	TTBN**-26
TGB32-2	B		50	32		24.9	1.8		TTBN**-32
TGB26-3	A	TD*3	50	26		21.4	2.4		TTBN**-26
TGB32-3	B		100	32		24.9	2.4		TTBN**-32
TGB26-4	A	TD*4	80	26		21.4	3.2		TTBN**-26
TGB32-4	B		100	32		24.6	3.2		TTBN**-32
TGB32-5	B	TD*5	120	32		24.6	4.0		TTBN**-32
TGB32-6	B	TD*6					5.2		

EDG-33B 扳手需单独订购 . EDG-33B wrench must be ordered separately.

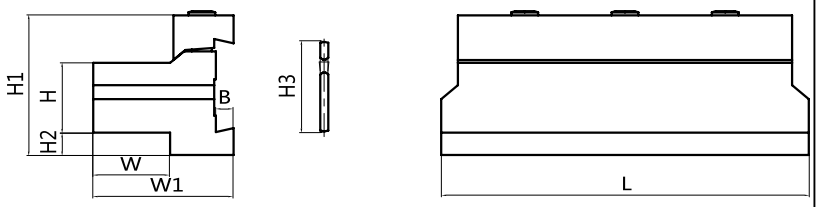
刀板使用说明：



①将扳手对准刀板上面的两个孔，然后握住手柄旋转
②使刀板上下压板撑开适当距离，使得刀片得以放入
③按箭头方向推入刀片，放置至抵紧刀板支撑位
④回转扳手至初始位置，并取出扳手

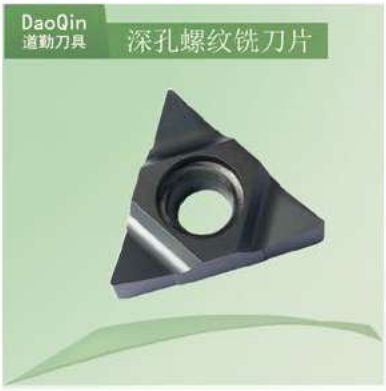
① Aim the wrench at the two holes of blade, hold the handle and rotate
② to make upper and lower plate opened at appropriate distance and put insert into blade
③ Push the insert in the direction of the arrow
④ Turn wrench into initial position,take out the wrench

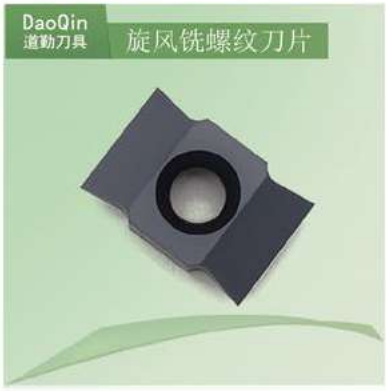
切槽、切断刀座 Parting & Grooving Tools

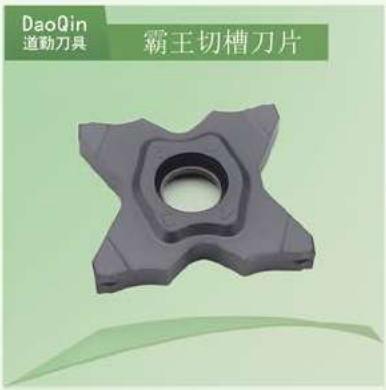


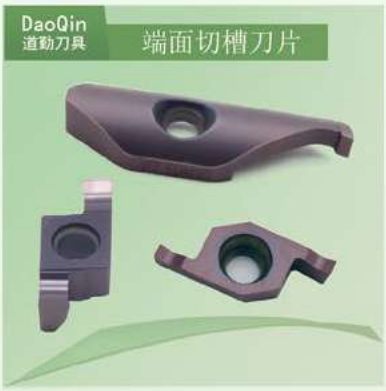
刀座型号 Toolholder Type	尺寸 Dimensions (mm)									扳手 Extractor	刀板 parting & grooving balde
	H	W	H3	L	H1	H2	W1	B	M		
TTBU20-26	20	21.5	26	87	44	9	38	5	3-M6	L-W5	TGB 26-**
TTBU25-26	25	23	26	100	45	5	42	5	3-M6		
TTBU20-32	20	19	32	100	50	13	38	5.3	4-M6		TGB 32-**
TTBU25-32	25	23	32	110	50	8	42	5.3	4-M6		
TTBU32-32	32	29	32	110	54	5	48	5.3	4-M6		

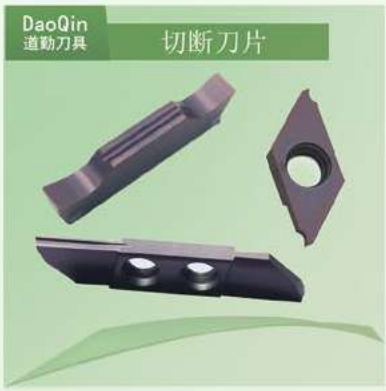
【1】参考：《公制、美制和英制螺纹标准手册》（第三版）全国螺纹标准化技术委员会・中国标准出版社
【2】参考：《螺纹标准汇编》（上）（中）（下） 全国螺纹标准化技术委员会・中国标准出版社











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