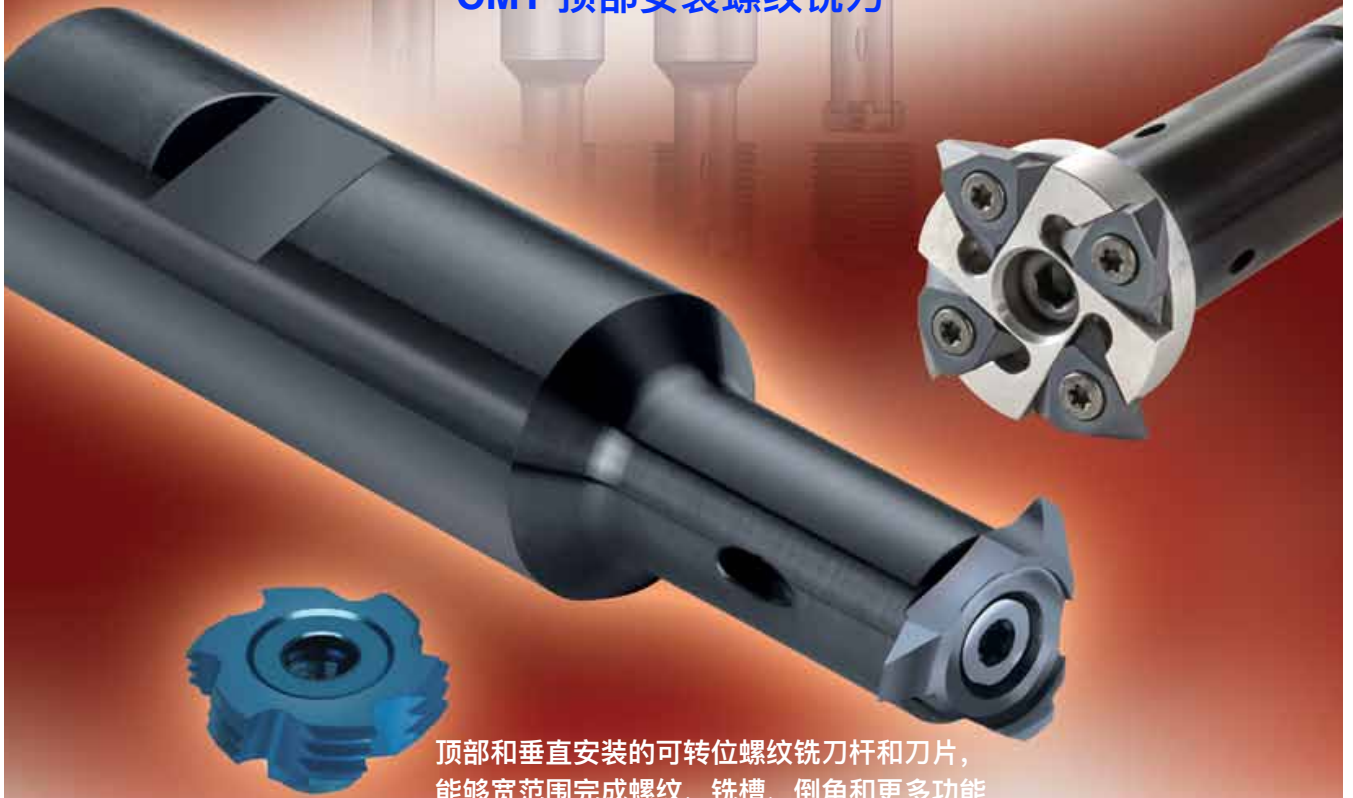




# CMT Vertical Mill-Thread

## CMT 顶部安装螺纹铣刀



顶部和垂直安装的可转位螺纹铣刀杆和刀片，  
能够宽范围完成螺纹、铣槽、倒角和更多功能

**Vertical milling indexable inserts and toolholders to perform a wide variety of threads, grooves, chamfers and more.**

### 优点 Advantages of CMT - Vertical Mill-Thread

- Ground profile inserts for high precision and excellent performance.  
磨制外形刀片，高精度和高效能
- Working at high machining parameters, with high surface quality.  
工作在高加工参数和高表面质量
- Solid and accurate clamping method enables full repeatability. 坚固和精确的夹持方法使得刀片安装可重复性
- Same insert for right-hand or left-hand threads.  
相同的刀片可以加工右手或左手螺纹
- Toolholders include weldon shank and coolant bore. 刀杆包括侧固柄和内冷孔
- Chamfer inserts are also available. 也可以安装倒角刀片

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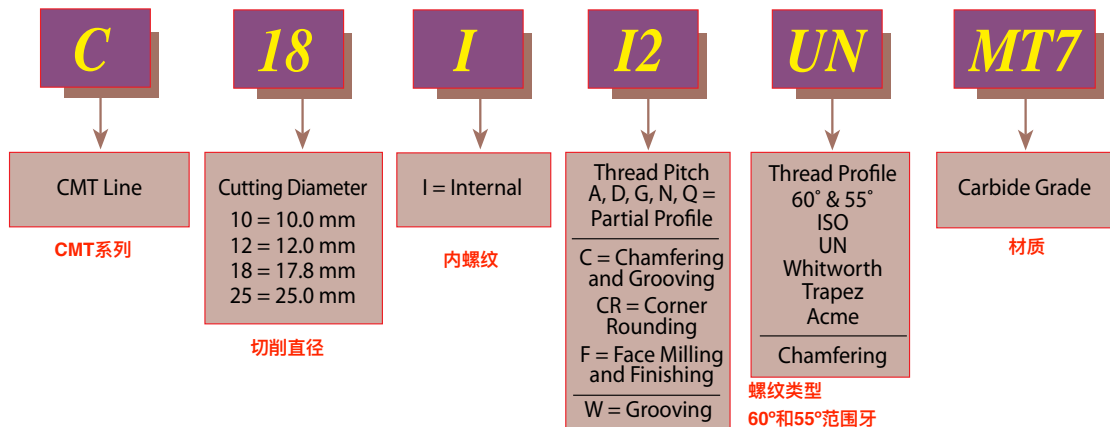
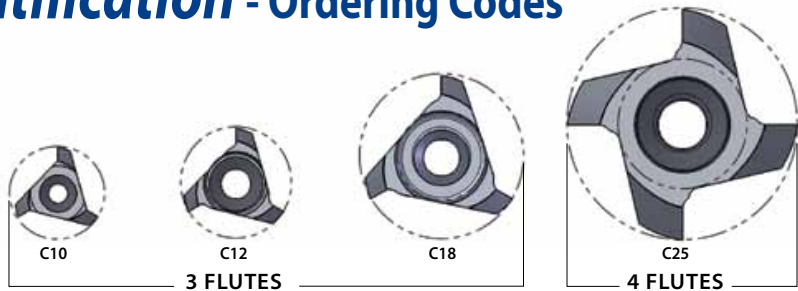


# CMT Vertical Mill-Thread

## CMT立装螺纹铣刀

### Product Identification - Ordering Codes

产品标识-订货编号



CMT系列

切削直径

内螺纹

材质

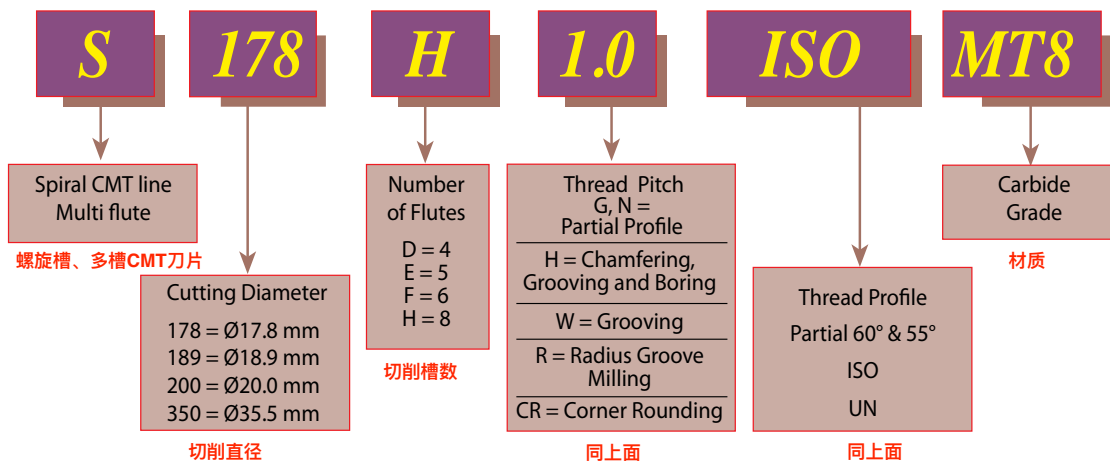
螺纹类型  
60°和55°范围牙  
完整牙 - ISO/UN

英制惠氏螺纹  
梯型螺纹 - DIN 013  
梯型螺纹 - 美国ACME



### CMT Spiral Multi Flute Inserts

CMT螺旋槽多槽刀片



螺旋槽、多槽CMT刀片

切削直径

切削槽数

同上面

同上面

材质

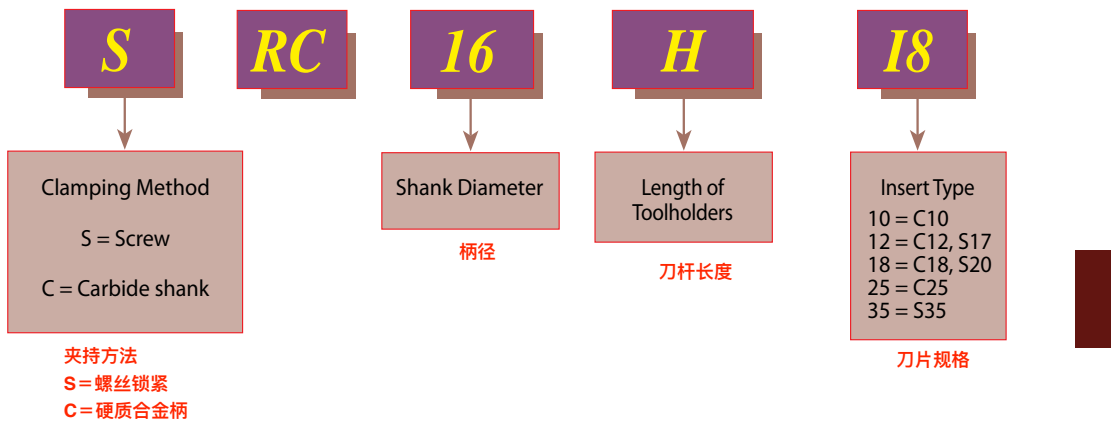


## CMT Vertical Mill-Thread

CMT顶部垂直安装螺纹铣刀

## Product Identification - Ordering Codes 产品标识-订货编号

CMT Toolholders CMT刀杆





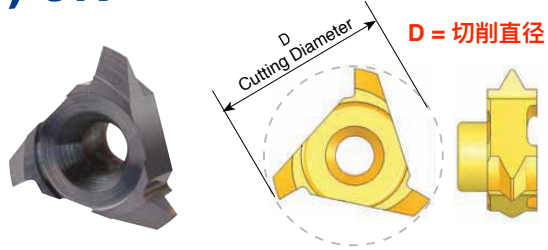
## CMT Vertical Mill-Thread

### CMT立装螺纹铣刀片

## Partial Profile 60° - ISO, UN 不完整牙-范围牙60° -ISO/UN通用

Same insert for internal and external thread

内外螺纹通用



Insert Type 刀片规格	Pitch Range 螺距范围 mm	Pitch Range 螺距范围 TPI	Ordering Code 订货编号	D	Thread Diameter (min)		Holder Code 刀杆编号		
					Pitch Low Range	Pitch High Range			
C10	Int. 0.5 - 0.8	56 - 28	C10 A60	10.0	最小直径范围 $\varnothing \geq 11$	最大直径范围 $\varnothing \geq 12$	H1, 2, 12, 13		
	Ex. 0.4 - 0.8	64 - 32			C10 G60	$\varnothing \geq 12$		$\varnothing \geq 14$	H1, 2, 12
	Int. 1.0 - 2.0	28 - 13	C12 A60			12.0	$\varnothing \geq 13$	$\varnothing \geq 14$	
	Ex. 0.8 - 1.75	32 - 15			C12 G60		$\varnothing \geq 14$	$\varnothing \geq 16$	
C18	Int. 0.5 - 0.8	56 - 28	C18 A60	17.8			$\varnothing \geq 19$		H6, 7, 8, 9, 16
	Ex. 0.4 - 0.8	64 - 32			C18 G60		$\varnothing \geq 20$	$\varnothing \geq 21$	
	Int. 1.0 - 1.75	28 - 14	C18 D60			$\varnothing \geq 21$	$\varnothing \geq 23$		
	Ex. 0.8 - 1.5	32 - 16			C25 G60	25.0	$\varnothing \geq 28$	$\varnothing \geq 30$	
	Int. 2.0 - 3.0	13 - 8	C25 N60				$\varnothing \geq 30$	$\varnothing \geq 34$	
Ex. 1.75 - 2.5	15 - 10	C25 Q60		$\varnothing \geq 34$	$\varnothing \geq 35$				
Int. 1.5 - 2.5	16 - 10		C25 G60	25.0	$\varnothing \geq 28$		$\varnothing \geq 30$	H10, 11, 17, 18	
Ex. 1.0 - 2.0	28 - 13	C25 N60			$\varnothing \geq 30$		$\varnothing \geq 34$		
Int. 3.0 - 5.0	8 - 5		C25 Q60		$\varnothing \geq 34$	$\varnothing \geq 35$			
Ex. 2.5 - 4.5	10 - 6	C25 Q60			$\varnothing \geq 34$	$\varnothing \geq 35$			
Int. 5.0 - 6.0	5 - 4		C25 Q60		$\varnothing \geq 34$	$\varnothing \geq 35$			
Ex. 4.5 - 5.0	6 - 5	C25 Q60		$\varnothing \geq 34$	$\varnothing \geq 35$				

\* For complete toolholder description see pages 193 and 194 \* 刀杆样式见193-194页



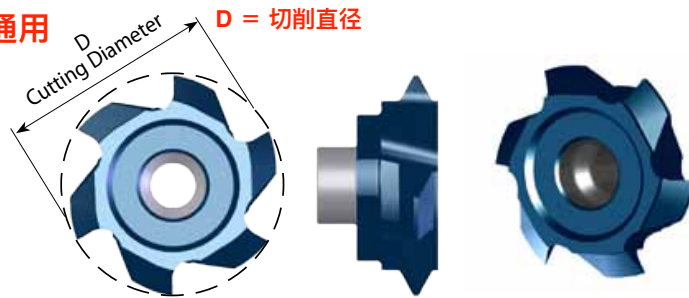
## CMT Vertical Mill-Thread

CMT立装螺纹铣刀

### Partial Profile 60° - ISO, UN 不完整牙-范围牙60° -ISO/UN通用

Same insert for internal and external thread

Multi Flute 多槽-内外螺纹通用



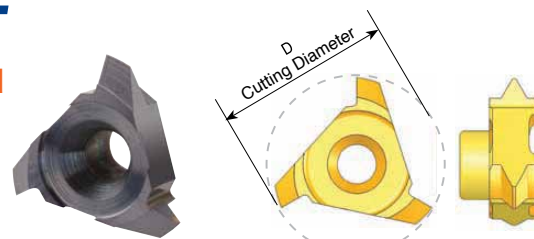
刀片型号	订货号	螺距范围	牙数范围	槽数	螺纹直径		适用刀杆	
Insert Type	Ordering Code	Pitch Range mm	Pitch Range TPI	D	Thread Dia (min)		Holder Code	
					Pitch Low range	Pitch High range		
S20	S200 F G60	Int. 1.5-2.5	16-10	20.0	6	$\varnothing \geq 23$	$\varnothing \geq 25$	H6, 7, 8, 9, 16
		Ex. 1.0-2.0	28-13	20.0	6	$\varnothing \geq 23$	$\varnothing \geq 25$	
	S200 D N60	Int. 3.0-5.0	8- 5	20.0	4	$\varnothing \geq 25$	$\varnothing \geq 29$	H16
		Ex. 2.5-4.5	10-6	20.0	4	$\varnothing \geq 25$	$\varnothing \geq 29$	

不完整牙-范围牙60° -NPT锥管螺纹

### Partial Profile 60° - NPT

Same insert for internal and external thread

内外螺纹通用



刀片型号	每吋牙数	标准	订货号	切削直径	适用刀杆
Insert Type	Pitch TPI	Standard	Ordering Code	D	Holder Code
C10	18	1/4 - 3/8	C10 18 NPT	10.0	H1, 2, 12
C18	14	1/2 - 3/4	C18 14 NPT	15.8	H16
C25	11.5	1-2	C25 11.5NPT	25.0	H10, 11, 17, 18
	8	$\geq 2 \frac{1}{2}$	C25 8 NPT	25.0	

\* For complete toolholder description see pages 193 and 194 \* 刀杆式样见193-194页



## CMT Vertical Mill-Thread

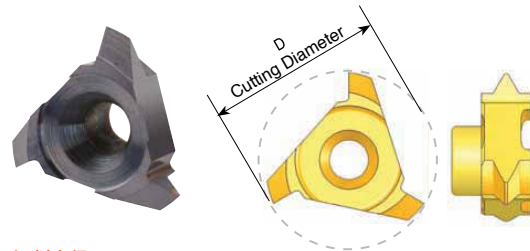
### CMT立装螺纹铣刀

不完整牙 - 范围牙55°BSP(G),BSF,BSW

## Partial Profile 55° - BSP(G), BSF, BSW

Same insert for internal and external thread

内外螺纹通用



刀片型号	每吋牙数	订货号	切削直径	螺纹直径	适用刀杆
Insert Type	Pitch Range TPI	Ordering Code	D	Thread Dia. (min)	Holder Code
C10	19-14	<b>C10 G55</b>	10.0	$\varnothing \geq 13$	H1, 2, 12
C12	28-19	<b>C12 G55</b>	12.0	$\varnothing \geq 14$	H3, 4, 5, 14, 15
	14- 11	<b>C12 N55</b>	12.2	$\varnothing \geq 16$	H3, 4, 5, 14
C18	14- 8	<b>C18 G55</b>	18.0	$\varnothing \geq 23$	H6, 7, 8, 9, 16
C25	7- 5	<b>C25 N55</b>	25.0	$\varnothing \geq 31$	H10, 11, 17, 18

范围牙55°-BSP(G),BSF,BSW

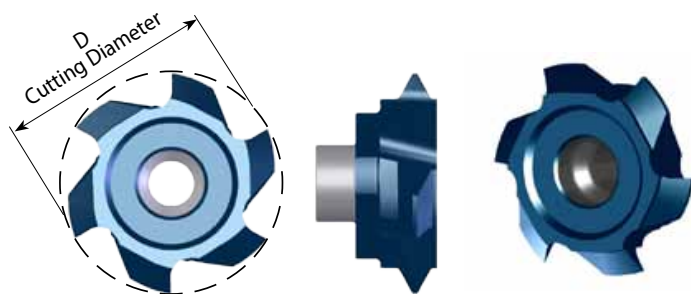
## Partial Profile 55° - BSP(G), BSF, BSW

Same insert for internal and external thread

### Multi Flute

多槽

内外螺纹通用



刀片型号	订货号	每吋牙数	切削直径	刃数	螺纹直径	适用刀杆
Insert Type	Ordering Code	Pitch Range TPI	D	No. of Flutes	Thread Dia (min)	Holder Code
S20	<b>S195 F G55</b>	14	19.5	6	$\varnothing \geq 23$	H6, 7, 8, 9, 16
	<b>S200 D N55</b>	8-6	20.0	4	$\varnothing \geq 25$	H16

\* For complete toolholder description see pages 193 and 194 \* 刀杆式样见193-194页



## CMT Vertical Mill-Thread

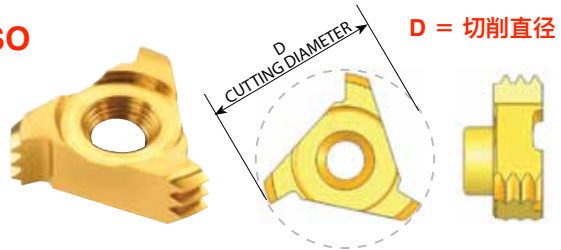


### CMT立装螺纹铣刀

## Full Profile - ISO 完整牙-ISO

Inserts for internal thread

只能用于内螺纹



刀片型号	螺距	公制粗牙	公制细牙	订货号	齿数	切削直径	适用刀杆
Insert Type	Pitch mm	M coarse	M fine	Ordering Code	Number of Teeth	D	Holder Code
C10	0.5		$\varnothing \geq 10$	<b>C10 I 0.5 ISO</b>	6	9.0	H1, 2, 12, 13
	1.0		$\varnothing \geq 12$	<b>C10 I 1.0 ISO</b>	3	10.0	
	1.5		$\varnothing \geq 13$	<b>C10 I 1.5 ISO</b>	2	10.0	
	1.75	M12	$\varnothing \geq 13$	<b>C10 I 1.75ISO</b>	1	9.6	H1, 2, 12
	2.0	M14	$\varnothing \geq 14$	<b>C10 I 2.0 ISO</b>	1	10.0	
C12	0.5		$\varnothing \geq 13$	<b>C12 I 0.5 ISO</b>	6	12.0	H3, 4, 5, 14, 15
	0.75		$\varnothing \geq 13$	<b>C12 I 0.75ISO</b>	4	12.0	
	1.0		$\varnothing \geq 14$	<b>C12 I 1.0 ISO</b>	3	12.0	
	1.5		$\varnothing \geq 15$	<b>C12 I 1.5 ISO</b>	2	12.0	
	2.0	M16	$\varnothing \geq 16$	<b>C12 I 2.0 ISO</b>	1	12.4	H3, 4, 5, 14
	2.5	M18, M20	$\varnothing \geq 17$	<b>C12 I 2.5 ISO</b>	1	12.0	
	3.0		$\varnothing \geq 17$	<b>C12 I 3.0 ISO</b>	1	12.4	
C18	0.5		$\varnothing \geq 19$	<b>C18 I 0.5 ISO</b>	9	17.8	H6, 7, 8, 9, 16
	0.75		$\varnothing \geq 19$	<b>C18 I 0.75ISO</b>	6	17.8	
	1.0		$\varnothing \geq 20$	<b>C18 I 1.0 ISO</b>	5	17.8	
	1.5		$\varnothing \geq 20$	<b>C18 I 1.5 ISO</b>	3	17.8	
	2.0		$\varnothing \geq 21$	<b>C18 I 2.0 ISO</b>	2	17.8	
	2.5	M22	$\varnothing \geq 22$	<b>C18 I 2.5 ISO</b>	2	17.8	
	3.0	M24, M27	$\varnothing \geq 23$	<b>C18 I 3.0 ISO</b>	1	17.8	
	3.5	M30, M33	$\varnothing \geq 24$	<b>C18 I 3.5 ISO</b>	1	17.8	
C25	3.0	M32, M33	$\varnothing \geq 30$	<b>C25 I 3.0 ISO</b>	2	25.0	H10, 11, 17, 18
	4.0	M36, M39	$\varnothing \geq 32$	<b>C25 I 4.0 ISO</b>	1	25.0	
	4.5	M45	$\varnothing \geq 33$	<b>C25 I 4.5 ISO</b>	1	25.0	
	5.0	M48, M52	$\varnothing \geq 34$	<b>C25 I 5.0 ISO</b>	1	25.0	
	5.5	M60	$\varnothing \geq 35$	<b>C25 I 5.5 ISO</b>	1	25.0	
	6.0	M64, M68	$\varnothing \geq 36$	<b>C25 I 6.0 ISO</b>	1	25.0	

\* For complete toolholder description see pages 193 and 194 \* 刀杆完整描述见193-194页



## CMT立装螺纹铣刀

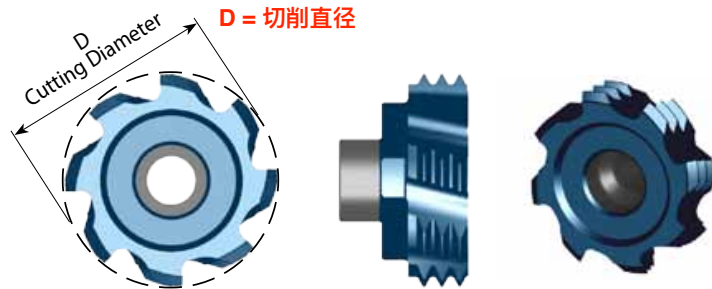
### Full Profile - ISO 完整牙-ISO

Inserts for internal thread

### Multi Flute

多槽

只能用于内螺纹



刀片型号	订货号	螺距	公制粗牙	公制细牙	齿数	切削直径	刃数	适用刀杆
Insert Type	Ordering Code	Pitch mm	M coarse	M fine	Number of Teeth	D	No. of Flutes	Holder Code
S20	<b>S163 H 1.0 ISO</b>	1.0		$\varnothing \geq 18$	5	16.3	8	H6, 7, 8, 9, 16
	<b>S175 H 1.5 ISO</b>	1.5		$\varnothing \geq 20$	3	17.5	8	
	<b>S186 F 2.0 ISO</b>	2.0		$\varnothing \geq 22$	2	18.6	6	
S17	<b>S160 F 2.5 ISO</b>	2.5	M20	$\varnothing \geq 20$	1	16.0	6	H3, 4, 5, 14, 15
S20	<b>S178 F 2.5 ISO</b>	2.5	M22	$\varnothing \geq 22$	2	17.8	6	H6, 7, 8, 9, 16
	<b>S189 F 3.0 ISO</b>	3.0	M24, M27	$\varnothing \geq 24$	1	18.9	6	
	<b>S200 F 3.5 ISO</b>	3.5	M30, M33	$\varnothing \geq 26$	1	20.0	6	
	<b>S200 F 4.0 ISO</b>	4.0	M36, M39	$\varnothing \geq 27$	1	20.0	6	
	<b>S200 E 4.5 ISO</b>	4.5	M42, M45	$\varnothing \geq 28$	1	20.0	5	
	<b>S200 D 5.0 ISO</b>	5.0	M48, M52	$\varnothing \geq 29$	1	20.0	4	H16
S35	<b>S350 F 6.0 ISO</b>	6.0	M64, M68	$\varnothing \geq 46$	1	35.0	6	H19, 20, 21
	<b>S350 F 8.0 ISO</b>	8.0		$\varnothing \geq 50$	1	35.0	6	

\* For complete toolholder description see pages 193 and 194 \* 刀杆完整描述见193-194页



# CMT Vertical Mill-Thread

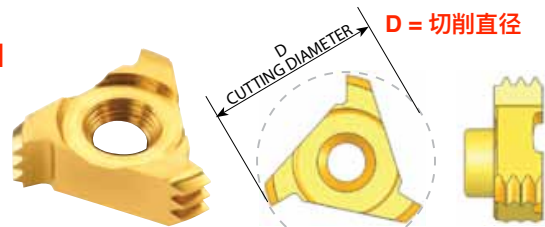


**CMT立装螺纹铣刀**

**Full Profile - UN 完整牙-UN**

Inserts for internal thread

只能用于内螺纹



刀片型号	每吋牙数	通用规格	美制-UNC/UNF/UNEF			订货号	齿数	切削直径	适用刀杆
Insert Type	Pitch TPI	Nominal Size	UNC	UNF	UNEF	Ordering Code	Number of Teeth	D	Holder Code
C10	20			1/2		<b>C10 I 20 UN</b>	2	10.0	H1, 2, 12, 13
	18			9/16		<b>C10 I 18 UN</b>	2	10.0	
	13		1/2			<b>C10 I 13 UN</b>	1	10.0	H1, 2, 12
	12	5/8, 11/16, 3/4	9/16			<b>C10 I 12 UN</b>	1	10.0	
C12	32	9/16, 5/8				<b>C12 I 32 UN</b>	3	12.0	H3, 4, 5, 14, 15
	28	9/16, 5/8, 11/16				<b>C12 I 28 UN</b>	3	12.0	
	24				9/16, 5/8, 11/16	<b>C12 I 24 UN</b>	2	12.0	
	20	9/16, 5/8, 11/16			3/4	<b>C12 I 20 UN</b>	2	12.0	
	18			5/8		<b>C12 I 18 UN</b>	2	12.0	
	16	5/8, 11/16		3/4		<b>C12 I 16 UN</b>	1	12.0	
	11		5/8			<b>C12 I 11 UN</b>	1	12.0	H3, 4, 5, 14
	10		3/4			<b>C12 I 10 UN</b>	1	12.0	
C18	32	3/4, 13/16, 7/8				<b>C18 I 32 UN</b>	6	17.8	H6, 7, 8, 9, 16
	28	3/4, 13/16, 7/8				<b>C18 I 28 UN</b>	5	17.8	
	24					<b>C18 I 24 UN</b>	4	17.8	
	20	11/16, 11/8			13/16, 7/8, 15/16	<b>C18 I 20 UN</b>	3	17.8	
	18					<b>C18 I 18 UN</b>	3	17.8	
	16	7/8, 1				<b>C18 I 16 UN</b>	3	17.8	
	14			7/8		<b>C18 I 14 UN</b>	2	17.8	
	12	7/8		1, 11/8		<b>C18 I 12 UN</b>	2	17.8	
	11					<b>C18 I 11 UN</b>	2	17.8	
	9		7/8			<b>C18 I 9 UN</b>	1	17.8	
C25	8	13/16, 11/4, 15/16				<b>C25 I 8 UN</b>	2	25.0	H10, 11, 17, 18
	7		11/4			<b>C25 I 7 UN</b>	1	25.0	
	6	17/16, 19/16	13/8, 11/2			<b>C25 I 6 UN</b>	1	25.0	
	5		1 3/4			<b>C25 I 5 UN</b>	1	25.0	
	4		2 1/2, 2 3/4			<b>C25 I 4 UN</b>	1	25.0	

\* For complete toolholder description see pages 193 and 194 \* 刀杆完整描述见193-194页



## CMT Vertical Mill-Thread

### 完整牙-UN Full Profile - UN

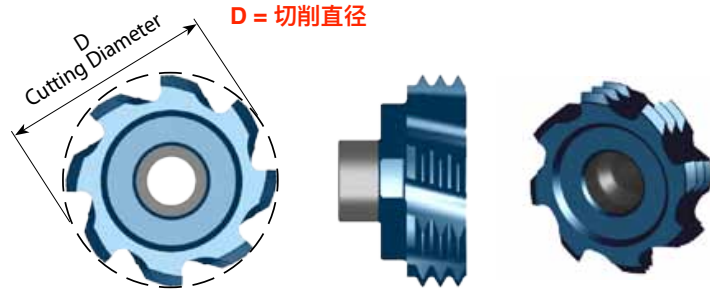
Inserts for internal thread

Multi Flute

多槽

只能用于内螺纹

### CMT立装螺纹铣刀



刀片型号	订货号	每吋牙数	通用规格	美制-UNC/UNF/UNEF			齿数	切削直径	刃数	适用刀杆
Insert Type	Ordering Code	Pitch TPI	Nominal size	UNC	UNF	UNEF	Number of Teeth	D	No. of Flutes	Holder Code
S20	S160 H 24 UN	24				11/16	4	16.0	8	H6, 7, 8, 9, 16
	S169 H 20 UN	20				3/4, 13/16, 7/8, 15/16, 1	4	16.9	8	
	S164 F 16 UN	16	7/8, 15/16, 1		3/4		3	16.4	6	
	S191 F 14 UN	14			7/8		2	19.1	6	
	S186 F 12 UN	12	7/8, 15/16		1		2	18.6	6	
	S178 F 9 UN	9		7/8			1	17.8	6	
	S200 F 8 UN	8	1 1/8	1			1	20.0	6	
	S200 F 7 UN	7		1 1/8, 1 1/4			1	20.0	6	
	S200 E 6 UN	6	1 7/16	1 3/8, 1 1/2			1	20.0	5	
S200 D 5 UN	5		1 3/4			1	20.0	4	H16	
S35	S350 F 4 UN	4		2 1/2, 2 3/4, 3			1	35.0	6	H19, 20, 21

\* For complete toolholder description see pages 193 and 194 \* 刀杆完整描述见193-194页

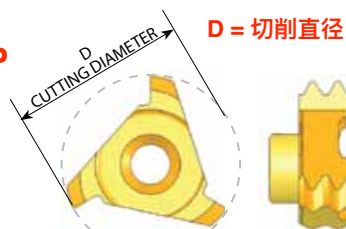


## CMT Vertical Mill-Thread

CMT立装螺纹铣刀

**G 55°** BSW, BSF, BSP **G 55°-BSW/BSF/BSP**

Same Insert for internal and external thread  
内外螺纹通用

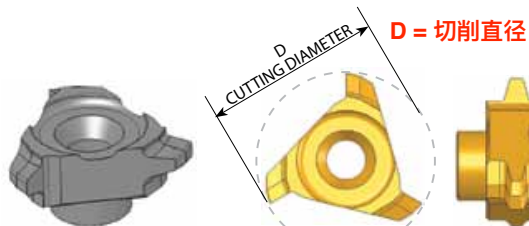


刀片型号	每吋牙数	标准	订货号	齿数	切削直径	适用刀杆
Insert Type	Pitch TPI	Standard	Ordering Code	Number of Teeth	D	Holder Code
C10	19	G 1/4	<b>C10 19 W</b>	2	10.0	H1, 2, 12, 13
C12	19	G 3/8	<b>C12 19 W</b>	2	12.0	H3, 4, 5, 14, 15
C18	14	G 7/8	<b>C18 14 W</b>	2	17.8	H6, 7, 8, 9, 16
	11	G ≥ 1	<b>C18 11 W</b>	2	17.8	

**30° 梯型螺纹-din103**

**Trapez - DIN 103**

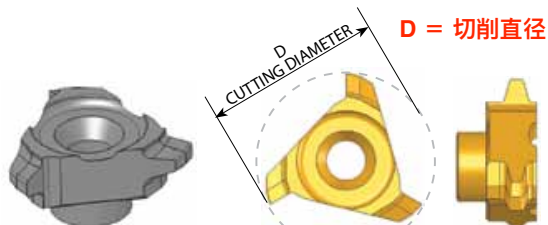
Inserts for internal thread  
只能用于内螺纹



刀片型号	螺距	标准	订货号	切削直径	适用刀杆
Insert Type	Pitch mm	Standard	Ordering Code	D	Holder Code
C10	2.0	Ø ≥ 16	<b>C10 I 2 TR</b>	10.0	H1, 2, 12,
C18	3.0	Ø ≥ 24	<b>C18 I 3 TR</b>	17.8	H6, 7, 8, 9, 16
	4.0	Ø ≥ 26	<b>C18 I 4 TR</b>	17.8	H16
	5.0	Ø ≥ 28	<b>C18 I 5 TR</b>	17.8	
C25	6.0	Ø ≥ 36	<b>C25 I 6 TR</b>	25.0	H10, 11, 17, 18

**Acme 29° 美制ACME梯型螺纹**

Inserts for internal thread  
只能用于内螺纹



刀片型号	每吋牙数	标准	订货号	切削直径	适用刀杆
Insert Type	Pitch TPI	Standard	Ordering Code	D	Holder Code
C18	5	1 1/8, 1 1/4	<b>C18 I 5 ACME</b>	18.0	H16
C25	4	1 1/2, 1 3/4, 2	<b>C25 I 4 ACME</b>	25.0	H10, 11, 17, 18

\* For complete toolholder description see pages 193 and 194 \* 刀杆完整描述见193-194页

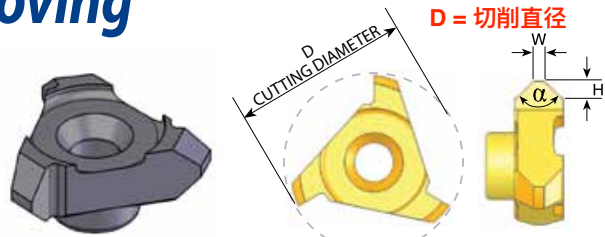


## CMT Vertical Mill-Thread

### CMT立装螺纹铣刀

## Chamfering and Grooving

### 倒角和铣槽

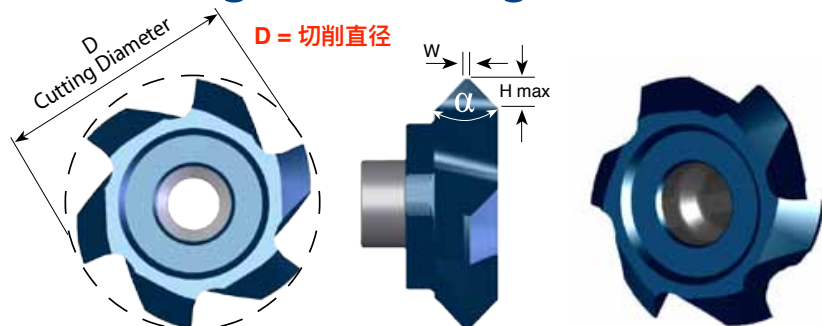


刀片型号	订货号	切削直径	切削刃高度	刀尖宽度	切削刃角度	适用刀杆
Insert Type	Ordering Code	D	H	W	$\alpha$	Holder Code*
C10	<b>C10 C90</b>	10.0	1.30	0.4	90°	H1, 2, 12
C12	<b>C12 C90</b>	12.0	1.35	0.3	90°	H3, 4, 5, 14
C18	<b>C18 C90</b>	17.8	1.95	1.1	90°	H6, 7, 8, 9, 16
C25	<b>C25 C90</b>	25.0	2.50	1.0	90°	H10, 11, 17, 18

## Chamfering, Grooving and Boring

### Multi Flute

### 多刃



刀片型号	订货号	切削直径	切削刃高度	刀尖宽度	切削刃角度	刃数	适用刀杆
Insert Type	Ordering Code	D	H max	W	$\alpha$	No. of Flutes	Holder Code
S17	<b>SC160 E H14</b>	16.0	1.35	0.2	90°	5	H3, 4, 5, 14, 15
S20	<b>SC170 E H14</b>	17.0	1.35	0.2	90°	5	H6, 7, 8, 9, 16
	<b>SC200 F H14</b>	20.0	1.35	0.2	90°	6	H6, 7, 8, 9, 16
S35	<b>SC200 F H24</b>	20.0	2.35	0.2	90°	6	
	<b>SC350 F H42</b>	35.0	4.20	0.2	90°	6	H19, 20, 21
S20	<b>SC200 F H20</b>	20.0	1.95	1.0	90°	6	H6, 7, 8, 9, 16
	<b>SC200 F H17</b>	20.0	1.70	1.5	90°	6	
	<b>SC200 F H15</b>	20.0	1.50	2.0	90°	6	
	<b>SC200 F H12</b>	20.0	1.20	2.5	90°	6	

\* For complete toolholder description see pages 193 and 194 \* 适配刀杆见193-194页

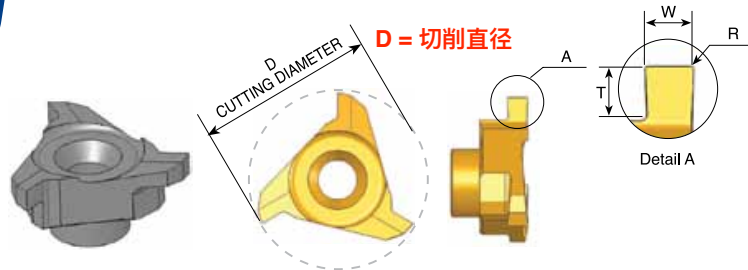


# CMT Vertical Mill-Thread

CMT立装螺纹铣刀

## Groove Milling

槽铣



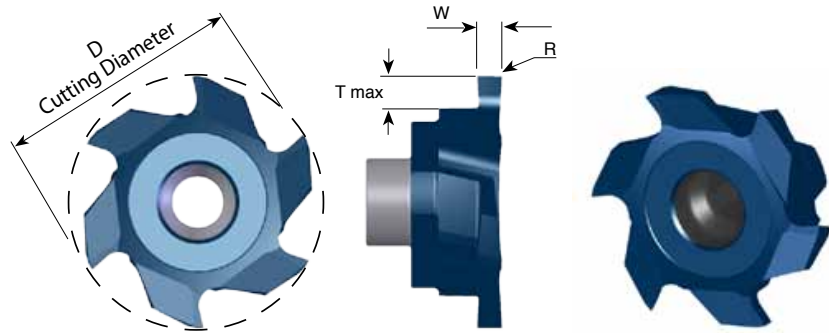
刀片型号	订货号	切削直径	切削刃宽度	切削刃深度	刀尖 R	最小槽径	适用刀杆
Insert Type	Ordering Code	D	W ±0.02	T max.	R	Groove Dia. (min.)	Holder Code
C10	<b>C10 W08</b>	10.0	0.80	0.80	0.1	Ø > 10.0	H1, 2, 12, 13
	<b>C10 W09</b>		0.90	0.90			
	<b>C10 W10</b>		1.00	0.90			
C12	<b>C12 W08</b>	12.0	0.80	0.80	0.1	Ø > 12.0	H3, 4, 5, 14, 15
	<b>C12 W10</b>		1.00	0.90			
C18	<b>C18 W10</b>	17.8	1.00	1.50	0.1	Ø > 17.8	H6, 7, 8, 9, 16
	<b>C18 W12</b>		1.20	1.50			
	<b>C18 W15</b>		1.50	1.95			
	<b>C18 W20</b>		2.00	2.80			H16
C25	<b>C25 W20</b>	25.0	2.00	3.00	0.2	Ø > 25	H10, 11, 17, 18
	<b>C25 W25</b>		2.50	3.00			
	<b>C25 W30</b>		3.00	3.00			
	<b>C25 W35</b>		3.50	3.50			
	<b>C25 W40</b>		4.00	3.50			
	<b>C25 W50</b>		5.00	3.50			

\* For complete toolholder description see pages 193 and 194 \* 适配刀杆见193-194页



## CMT立装螺纹铣刀

### Groove Milling 铣槽/多刃 Multi Flute



刀片型号	订货号	切削直径	切削刃宽度	切削刃深度	刀尖R	最小槽径	刃数	适用刀杆
Insert Type	Ordering Code	D	W ±0.02	T Max.	R	Groove Dia. (min)	No. of Flutes	Holder Code
S17	SG170 F W15	17.0	1.5	2.8	0.2	Ø > 17	6	H3, 4, 5, 14, 15
	SG170 F W20	17.0	2.0					
	SG170 F W25	17.0	2.5					
S20	SG200 F W15	20.0	1.5	2.9	0.2	Ø > 20	6	H6, 7, 8, 9, 16
	SG200 F W20	20.0	2.0					
	SG200 F W25	20.0	2.5					
	SG200 F W30	20.0	3.0					
	SG200 F W40	20.0	4.0					
	SG200 F W49	20.0	4.9					
S20	SG200 E W20T	20.0	2.0	3.7	0.2	Ø > 20	5	H16
	SG200 E W25T	20.0	2.5					
	SG200 E W30T	20.0	3.0					
S35	SG350 F W30T	35.0	3.0	6.3	0.2	Ø > 35	6	H19, 20, 21
	SG350 F W40T	35.0	4.0					
	SG350 F W50T	35.0	5.0					
	SG350 F W60T	35.0	6.0					
	SG350 F W80T	35.0	8.0					

\* For complete toolholder description see pages 193 and 194 \* 配套刀杆见193-194页



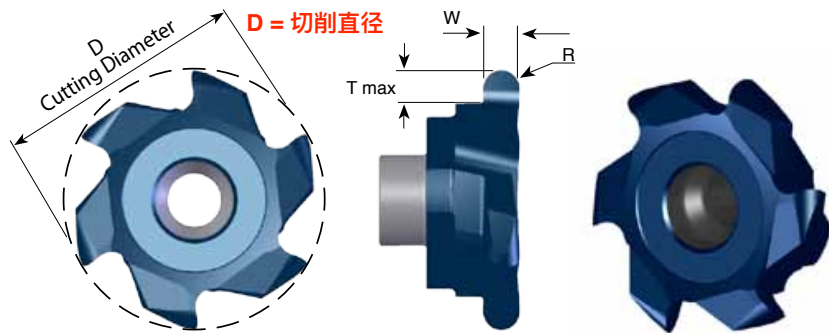
## CMT Vertical Mill-Thread

CMT立装螺纹铣刀

### Full Radius Groove Milling R槽铣刀

Multi Flute

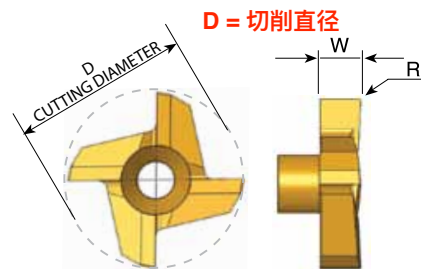
多槽



刀片型号	订货号	切削直径	R值	切削刃宽度	最大切深	最小槽径	刃数	适用刀杆
Insert Type	Ordering Code	D	R	W ±0.02	T Max.	Groove Dia. (min)	No. of Flutes	Holder Code
S20	SG200 F R10	20.0	1.0	2.0	2.9	Ø > 20	6	H6, 7, 8, 9, 16
	SG200 F R12	20.0	1.2	2.4				
	SG200 F R15	20.0	1.5	3.0				
	SG200 F R20	20.0	2.0	4.0				

面铣和精铣

### Face Milling and Finishing



刀片型号	订货号	切削直径	切削刃厚度	刀尖R	适用刀杆
Insert Type	Ordering Code	D	W	R	Holder Code
C18	C18 F R0.1	17.8	5.0	0.1	H6, 7, 8, 9, 16
C25	C25 F R0.2	25.0	6.0	0.2	H10, 11, 17, 18

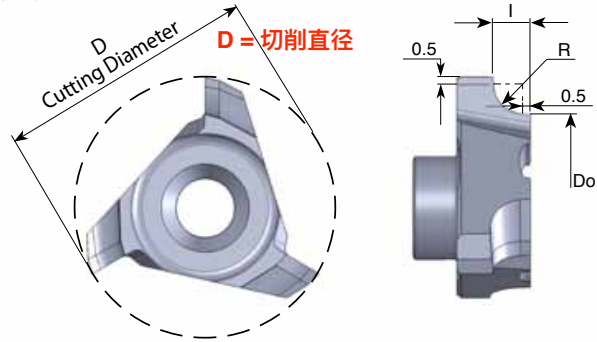
\* For complete toolholder description see pages 193 and 194 \* 配套刀杆见193-194页



## CMT螺纹铣刀

### Corner Rounding

圆角铣刀

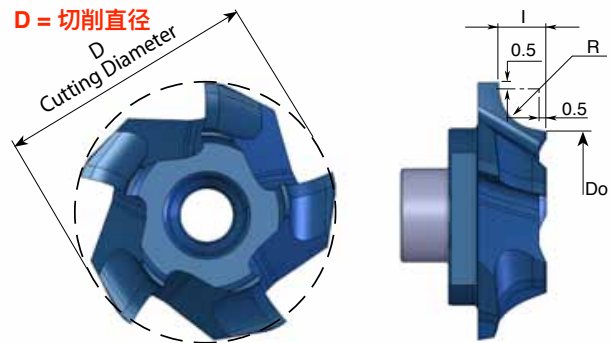


刀片型号	订货号	切削直径		R值	圆弧宽度	适用刀杆
Insert Type	Ordering Code	D	Do	R	I	Holder Code
C10	<b>C10 CR05</b>	10.0	7.9	0.5	1.05	H1, 2, 12, 13
	<b>C10 CR10</b>	10.0	6.9	1.0	1.55	
C18	<b>C18 CR13</b>	17.8	14.2	1.25	1.80	H6, 7, 8, 9, 16
	<b>C18 CR15</b>	17.8	13.7	1.5	2.05	
	<b>C18 CR20</b>	17.8	12.7	2.0	2.55	

圆角铣刀

### Corner Rounding

Multi Flute 多齿



刀片型号	订货号	切削直径		R值	圆弧宽度	刃数	适用刀杆
Insert Type	Ordering Code	D	Do	R	I	No. of Flutes	Holder Code
S17	<b>S170 E CR10</b>	17.0	13.9	1.0	1.55	5	H3, 4, 5, 14, 15
	<b>S170 E CR13</b>	17.0	13.4	1.25	1.80	5	
	<b>S170 E CR15</b>	17.0	12.9	1.5	2.05	5	

\* For complete toolholder description see pages 193 and 194 多齿 配套刀杆见193-194页

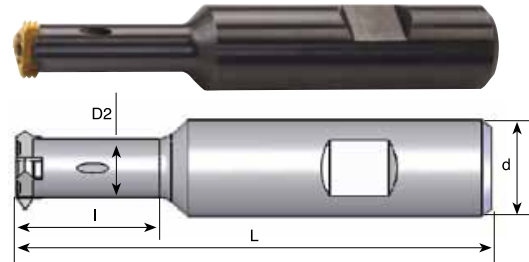


## CMT Vertical Mill-Thread

### CMT立装螺纹铣刀

## Steel Toolholders 钢制刀杆

With internal coolant 带内冷



刀杆型号	订货号	刀片型号	柄径	安装部直径	有效长度	总长	刀片螺丝	扳手
Tool No.	Ordering Code	Insert Type	d	D2	l	L	Insert Screw	Torx Key
H1	<b>SRC 1210 E</b>	C10	12	7.3	19	70	S5	K5
H2	<b>SRC 1610 G</b>		16		19	90		
H3	<b>SRC 1212 E</b>	C12, S17	12	9.0	25	70	S10	K10
H4	<b>SRC 1612 G</b>		16		25	90		
H5	<b>SRC 1612 H</b>		16		35	100		
H6	<b>SRC 1618 H</b>	C18, S20	16	13.8	48	100	S16	K16
H7	<b>SRC 2018 H</b>		20		32	100		
H8	<b>SRC 2018 J</b>		20		48	110		
H9	<b>SRC 2018 L</b>		20		74	140		
H10	<b>SRC 2525 J</b>	C25	25	17.5	45	115	S27	K27
H11	<b>SRC 2525 M</b>		25		80	150		
H19	<b>SRC 2535 H</b>	S35	25	22	40	100	S33	K33
H20	<b>SRC 2535 K</b>		25		60	130		

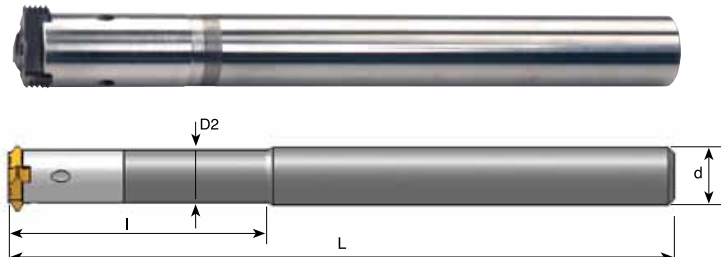


## CMT Vertical Mill-Thread

### CMT立装螺纹铣刀

## Carbide Shank Toolholders 硬质合金刀杆

With internal coolant  
带内冷



刀杆型号	订货号	刀片型号	柄径	安装部直径	有效长度	总长	刀片螺丝	扳手
Tool No.	Ordering Code	Insert Type	d	D2	l	L	Insert Screw	Torx Key
H12	<b>CRC 0810 L35 K</b>	C10	8	7.3	35	125	S5	K5
H13	<b>CRC 0810 K</b>		8	8.0	—	125	S5	K5
H14	<b>CRC 1012 L40 M</b>	C12, S17	10	9.0	40	150	S10	K10
H15	<b>CRC 1012 M</b>		10	10.0	—	150	S10	K10
H16	<b>CRC 1218 P</b>	C18, S20	12	12.0	—	170	S16	K16
H17	<b>CRC 1625 R</b>	C25	16	16.0	—	205	S27	K27
H18	<b>CRC 2025 L85 S</b>		20	17.5	85	250	S27	K27
H21	<b>CRC 2035 S</b>		20	22.0	—	260	S33	K33

Toolholders without Weldon 非侧固式刀杆



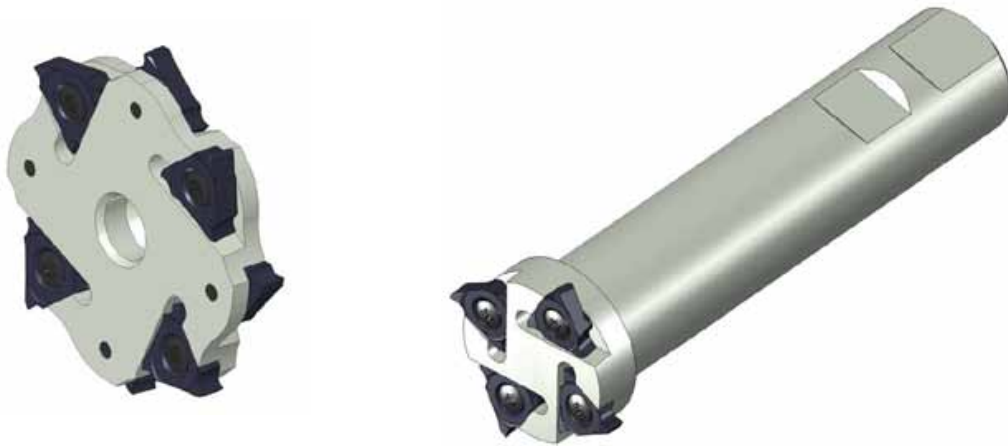
## CMT Vertical Mill-Thread

CMT立装螺纹铣刀

## CMT Multi Insert Milling Cutters CMT多刀片铣刀

**Carmex presents a new generation of CMT indexable milling inserts and cutters for Grooving, Chamfering and Threading**

Carmex推出了一个新的可转位铣刀片和刀杆用于铣槽、倒角和螺纹



### Inserts 刀片

- **Insert profiles are fully ground**  
刀片外形全部磨制
  - **Spiral inserts for smooth cutting operation**  
螺旋刀片切削平稳
  - **Three cutting edges on each insert**  
每个刀片三个切削刃
  - **For a wide range of materials and applications**  
适用于宽范围的所有材料
- Carbide grade: MT7  
硬质合金材质: MT7



### Milling cutters / Disc milling cutter 铣切削/铣刀盘

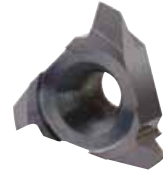
- **4 - 8 inserts per holder, for high productivity** 刀杆安装4-8个刀片高效率
- **To use with Carmex standard CMT - S35 toolholders** 使用Carmex标准CMT-S35刀杆
- **The milling cutters are coated with a special layer (silver color) for high Anti-corrosive resistance and extra protection against cutting burrs**  
铣刀的表面涂有特殊的涂层（银色），高耐腐蚀性和特别的保护，此外防止切削毛刺



铣螺纹技术参数  
Mill - Thread Technical Section

Cutting Data CMT-螺纹铣刀切削数据

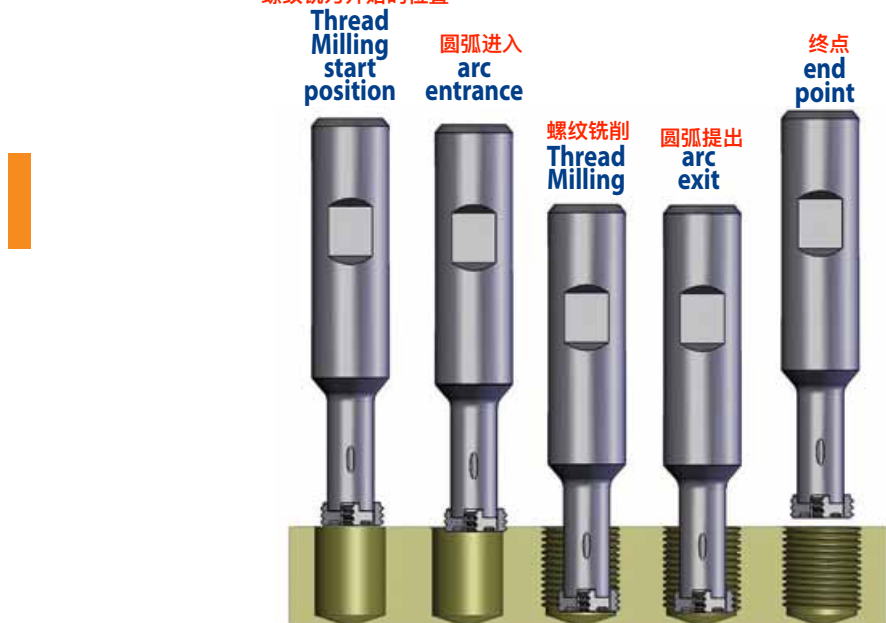
CMT type



**MT7** Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds. **MT7: 亚微颗粒级钛氯化氮 (TiAlN) 复合涂层 (ISO K10-K20) 适用于所有材料; 中到高的切削速度。**

ISO ISO标准	Materials 材料	Cutting Speed m/min 切削速度	Feed mm/tooth 进给/每齿 Cutting Diameter=D 切削直径			
			Ø10	Ø12	Ø18	Ø25
P	Low and Medium Carbon Steels <0.55%C 低和中碳钢	60 - 120	0.16	0.17	0.20	0.22
	High Carbon Steels ≥0.55%C 高碳钢	60 - 90	0.14	0.16	0.20	0.22
	Alloy Steels, Treated Steels 合金钢、热处理钢	50 - 80	0.10	0.12	0.16	0.18
M	Stainless Steels - Free Cutting 易切不锈钢	70 - 100	0.10	0.11	0.15	0.17
	Stainless Steels - Austenitic 奥氏体不锈钢	60 - 90	0.10	0.11	0.15	0.17
	Cast Steels 铸造不锈钢	70 - 90	0.10	0.12	0.16	0.18
K	Cast Iron 铸铁	40 - 80	0.16	0.17	0.20	0.22
N	Aluminum ≤12%Si, Copper 硅含量小于等于12%铝合金/铜	100 - 200	0.16	0.17	0.20	0.22
	Aluminum >12% Si 硅含量大于12%铝合金	60 - 140	0.10	0.11	0.16	0.18
	Synthetics, Duroplastics, Thermoplastics 合成材料/硬塑料/热塑料	50 - 200	0.19	0.19	0.22	0.24
S	Nickel Alloys, Titanium Alloys 镍合金、钛合金	20 - 40	0.07	0.07	0.10	0.12
H	Hardened Steel 45 - 50HRC 硬钢HRC45-50	60 - 70	0.09	0.09	0.13	0.15
	Hardened Steel 50 - 55HRC 硬钢HRC50-55	50 - 60	0.08	0.08	0.12	0.14

螺纹铣刀开始的位置





铣螺纹技术部分

Mill - Thread Technical Section



Cutting Data CMT – 多槽螺旋刀片切削数据



CMT Spiral Multi Flute Inserts

**Carbide grade - MT8:** 亚微颗粒级铝钛氮 (AlTiN) 复合涂层 (ISO K10-K20)  
特别的耐热和平稳的切削, 用于高效率和通用加工, 适用于所有材料  
Sub-Micron Grade with Aluminum Titanium Nitride (AlTiN) multi-layer coating (ISO K10-K20).  
Extremely high heat resistant and smooth cutting operation, for high performance, and normal machining conditions. General purpose for all materials.

ISO Standard ISO标准	Material 材料	Cutting Speed m/min 切削速度	Feed mm/tooth 进给 Cutting Diameter = D
			Ø16-Ø35 切削直径
P	Low and Medium Carbon Steels <0.55%C 低和中碳钢	60-120	0.14-0.24
	High Carbon Steels ≥0.55%C 高碳钢	60- 90	0.12-0.24
	Alloy Steels, Treated Steels 合金钢/热处理钢	50- 80	0.08-0.20
M	Stainless Steel-Free Cutting 易切不锈钢	70-100	0.08-0.19
	Stainless Steel-Austenitic 奥氏体不锈钢	60- 90	0.08-0.19
	Cast Steels 铸造不锈钢	70- 90	0.08-0.20
K	Cast Iron 铸铁	40- 80	0.14-0.24
N	Aluminum ≤12%Si, Copper 硅含量小于等于12%铝合金/铜	100-200	0.14-0.26
	Aluminum >12%Si 硅含量大于12%的铝合金	60-140	0.08-0.22
	Synthetics, Duroplastics, Thermoplastics 合成材料/硬塑料/热塑料	50-200	0.17-0.28
S	Nickel Alloys, Titanium Alloys. 镍合金/钛合金	20- 40	0.05-0.14
H	Hardened Steel, 45-50HRc 淬硬钢HRC45-50	60- 70	0.07-0.17
	Hardened Steel, 51-55HRc 淬硬钢HRC50-55	50- 60	0.06-0.16

三 禄 切 削 刀 具  
**SUNROXM**



上海三禄贸易有限公司



*Carmex*  
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