



Mill - Thread Inserts and Kits

螺纹铣刀片和套盒



**Mill-Thread tools for threading on CNC milling machines
by using helical interpolation programs**

用螺纹插补程序在数控机床上铣螺纹

Advantages of Mill-Thread Tools

- Same toolholder and insert can produce both right-hand and left-hand threads.
同样的刀杆和刀片可以加工右手螺纹和左手螺纹
- A single insert & toolholder can produce a given thread on many diameters (External & Internal).
一个刀片和刀杆能够加工许多内螺纹和外螺纹
- Prismatic shape of insert's tail ensures exact and reliable clamping in the toolholder.
刀片的尾棱型保证刀片在刀杆上准确、可靠的夹持
- Most inserts are double sided, having two cutting edges.
大多数刀片都是双面的，两个面都有切削刃
- Thread is produced in one tool pass.
螺纹加工一次完成
- MT tools can produce tapered threads.
MT螺纹铣刀可以加工锥型螺纹
- Improved productivity thanks to increased cutting speeds and multitooth type carbide inserts.
生产效率的提高得益于提高的切削速度和多齿型硬质合金刀片
- Threading to one pitch of a shoulder in a blind hole.
相同螺距的螺纹铣刀可以加工内螺纹和外螺纹和盲孔根部
- Longer tool life thanks to a special multilayer coating process.
特殊的多层涂层延长刀具寿命
- Lower tooling costs, considerably less expensive than using taps and dies.
比使用丝锥和板牙加工螺纹，成本低，便宜。
- Since lower machine power is required, a smaller machine can produce larger threads in a single operation with less idle time and tool changes.
只需要较低的机床功率，小机床可以加工大的螺纹，一个更少的空闲时间和换刀时间。

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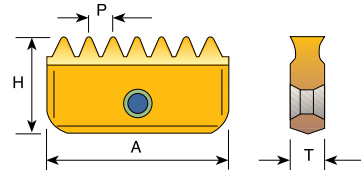
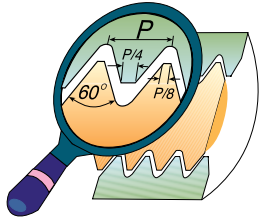


Mill - Thread Inserts

螺纹铣刀片



ISO 完整牙-ISO



刀片规格=A

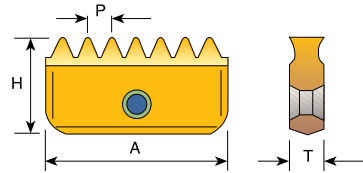
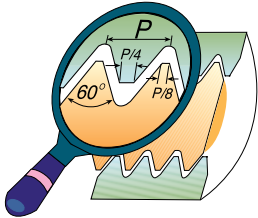
螺距 Pitch mm	内/外	Insert Size = A				
		12	14	21	30	40
0.5	Ext.					
0.5	Int.	* 12 I 0.5 ISO	14 I 0.5 ISO			
0.75	Ext.		14 E 0.75 ISO			
0.75	Int.	* 12 I 0.75 ISO	14 I 0.75 ISO			
1.0	Ext.		14 E 1.0 ISO	21 E 1.0 ISO		
1.0	Int.	* 12 I 1.0 ISO	14 I 1.0 ISO	21 I 1.0 ISO		
1.25	Ext.		14 E 1.25 ISO			
1.25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

Order example: 14 I 1.5 ISO MT7 订货样式: 14 I 1.5 ISO MT7

* One cutting edge * 一个切削刃



UN UNC, UNF, UNEF, UNS 完整牙-UN



刀片规格 = A

每吋牙数 Pitch TPI	内/外	Insert Size = A				
		12	14	21	30	40
32	Ext.		14 E 32 UN			
32	Int.	* 12 I 32 UN	14 I 32 UN			
28	Ext.		14 E 28 UN			
28	Int.	* 12 I 28 UN	14 I 28 UN			
27	Ext.					
27	Int.		14 I 27 UN			
24	Ext.		14 E 24 UN	21 E 24 UN		
24	Int.	* 12 I 24 UN	14 I 24 UN	21 I 24 UN		
20	Ext.		14 E 20 UN	21 E 20 UN	30 E 20 UN	
20	Int.	* 12 I 20 UN	14 I 20 UN	21 I 20 UN	30 I 20 UN	
18	Ext.		14 E 18 UN	21 E 18 UN	30 E 18 UN	
18	Int.	* 12 I 18 UN	14 I 18 UN	21 I 18 UN	30 I 18 UN	
16	Ext.		14 E 16 UN	21 E 16 UN	30 E 16 UN	40 E 16 UN
16	Int.	* 12 I 16 UN	14 I 16 UN	21 I 16 UN	30 I 16 UN	40 I 16 UN
14	Ext.		14 E 14 UN	21 E 14 UN	30 E 14 UN	40 E 14 UN
14	Int.		14 I 14 UN	21 I 14 UN	30 I 14 UN	40 I 14 UN
12	Ext.		14 E 12 UN	21 E 12 UN	30 E 12 UN	40 E 12 UN
12	Int.		14 I 12 UN	21 I 12 UN	30 I 12 UN	40 I 12 UN
11	Ext.		14 E 11 UN	21 E 11 UN		
11	Int.		14 I 11 UN			
10	Ext.		14 E 10 UN	21 E 10 UN	30 E 10 UN	40 E 10 UN
10	Int.		14 I 10 UN	21 I 10 UN	30 I 10 UN	40 I 10 UN
9	Ext.					
9	Int.		** 14 I 9 UN			
8	Ext.				30 E 8 UN	40 E 8 UN
8	Int.			21 I 8 UN	30 I 8 UN	40 I 8 UN
7	Ext.					
7	Int.			21 I 7 UN		
6	Ext.				30 E 6 UN	40 E 6 UN
6	Int.				30 I 6 UN	40 I 6 UN
5	Ext.					
5	Int.				30 I 5 UN	
4.5	Ext.					
4.5	Int.					40 I 4.5UN
4	Ext.					
4	Int.					40 I 4 UN
H		6.3	7.5	12	16	20
T		2.9	3.1	4.7	5.5	6.3

Order example: 21 I 18 UN MT7 订货样式: 21 I 18 UN MT7

* One cutting edge * 只有单面切削刃

** Cannot be used with carbide shank Toolholders. ** 不能用硬质合金刀杆



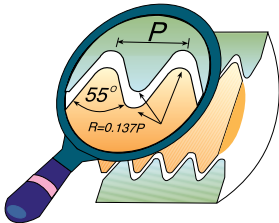
Mill - Thread Inserts

螺纹铣刀片



WHIT BSW, BSF, BSP

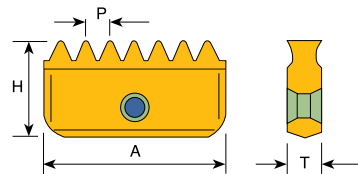
英国惠氏螺纹



相同刀片可以加工内、外螺纹

Same Insert for External and Internal thread.

刀片规格 = A

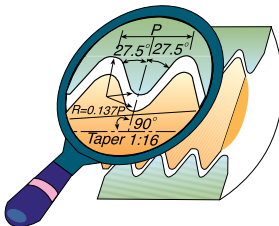


每吋牙数 Pitch TPI	Insert Size = A				
	12	14	21	30	40
24		14-24 W			
20		14-20 W	21-20 W		
19	* 12 - 19 W	14-19 W	21-19 W		
16		14-16 W	21-16 W	30-16 W	
14		14-14 W	21-14 W	30-14 W	
11		14-11 W	21-11 W	30-11 W	40-11 W
8					40- 8 W
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

* One cutting edge * 单面切削刃

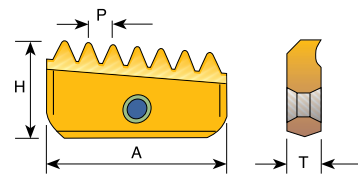
Order example: 21-11 W MT7 订货式样: 21-11 W MT7

BSPT BSPT 锥管螺纹刀片是单面的，可用于内、外螺纹



Conical pipe thread inserts are one-sided and may be used for both External and Internal threading.

刀片规格 = A



每吋牙数 Pitch TPI	Insert Size = A				
	12	14	21	30	40
19	12-19 BSPT	14-19 BSPT			
14		14-14 BSPT	21-14 BSPT		
11			21-11 BSPT	30-11 BSPT	40-11 BSPT
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

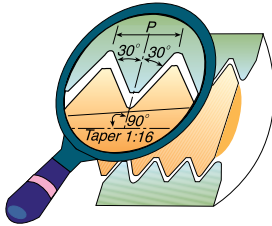
Order example: 14-19 BSPT MT7 订货式样: 14-9 BSPT MT7

For conical preparation end mills see page 221 锥形铣刀见221页



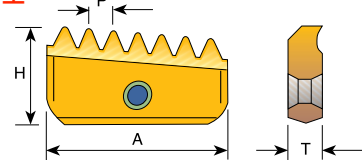
NPT

NPT锥管螺纹



锥管螺纹刀片是单面的，可用于内、外螺纹加工

Conical pipe thread inserts are one-sided and may be used for both External and Internal threading.



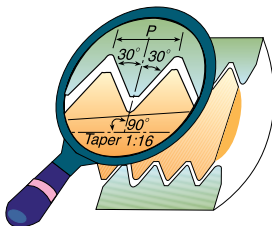
刀片规格 = A

每吋牙数 Pitch TPI	Insert Size = A				
	12	14	21	30	40
18	12-18 NPT	14-18 NPT			
14		14-14 NPT	21-14 NPT		
11.5			21-11.5 NPT	30-11.5 NPT	40-11.5 NPT
8				30- 8 NPT	40- 8 NPT
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

Order example: 30-11.5 NPT MT7 订货式样: 30-11.5 NPTMT

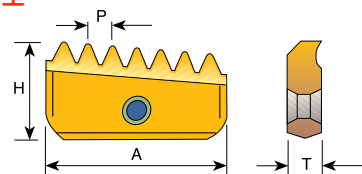
NPTF

NPTF干密封锥管螺纹



锥管螺纹刀片是单面的，可用于内、外螺纹加工

Conical pipe thread inserts are one-sided and may be used for both External and Internal threading.



刀片规格 = A

每吋牙数 Pitch TPI	Insert Size = A				
	12	14	21	30	40
18	12-18 NPTF	14-18 NPTF			
14		14-14 NPTF	21-14 NPTF		
11.5			21-11.5 NPTF	30-11.5 NPTF	40-11.5 NPTF
8				30- 8 NPTF	40- 8 NPTF
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

Order example: 21-14 NPTF MT7 订货样式: 21-14 NPTF MT7

For conical preparation end mills see page 221 锥形铣刀见221页



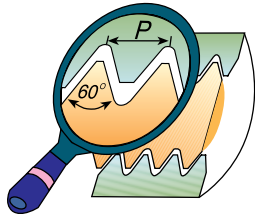
Mill - Thread Inserts

螺纹铣刀片



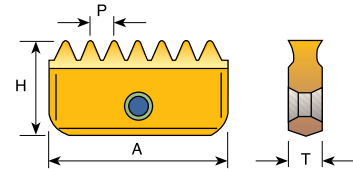
NPS

NPS



相同的刀片可以加工内、外螺纹

Same Insert for External and Internal thread



刀片规格 = A

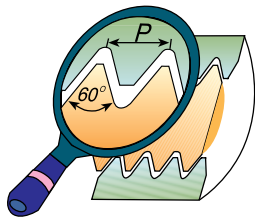
每吋牙数 Pitch TPI	Insert Size = A				
	12	14	21	30	40
18	* 12-18 NPS	14-18 NPS			
14		14-14 NPS	21-14 NPS		
11.5			21-11.5 NPS	30-11.5 NPS	40-11.5 NPS
8				30- 8 NPS	40- 8 NPS
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

Order example: 30-11.5 NPS MT7 订货样式: 30-11.5 NPS MT7

* One cutting edge * 一个切削刃

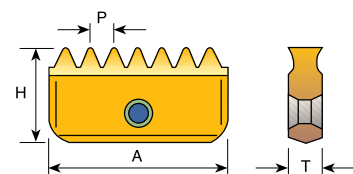
NPSF

NPSF-干密封圆柱螺纹



相同的刀片可以加工内、外螺纹

Same Insert for External and Internal thread



刀片规格 = A

每吋牙数 Pitch TPI	Insert Size = A				
	12	14	21	30	40
18	* 12-18 NPSF	14-18 NPSF			
14		14-14 NPSF	21-14 NPSF		
11.5			21-11.5 NPSF	30-11.5 NPSF	40-11.5 NPSF
8				30- 8 NPSF	40- 8 NPSF
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

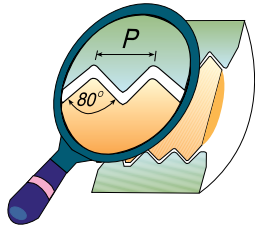
Order example: 21-14 NPSF MT7 订货样式: 21-14 NPSF MT7

* One cutting edge * 一个切削刃



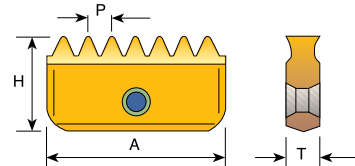
PG - DIN 40430

电力管线螺纹 - PG-DIN 40430



相同的刀片可以加工内、外螺纹

Same Insert for External and Internal thread



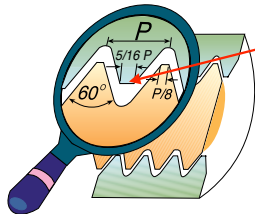
刀片规格 = A

牙数 Pitch TPI	Insert Size = A		
	14	21	30
18	14-18 PG (PG 9, 11, 13.5, 16)	21-18 PG (PG 16)	
16		21-16 PG (PG 21, 29, 36, 42, 48)	30-16 PG (PG 36, 42, 48)
H	7.5	12	16
T	3.1	4.7	5.6

Order example: 21-18 PG MT7 订货式样: 21-18 PG MT7

UNJ

UNJ-美国国家航空航天螺纹

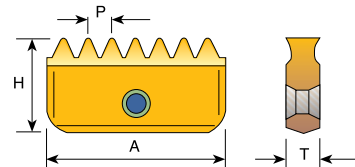


内螺纹牙尖5/16

Internal-?

Inserts for External thread

刀片只能用于外螺纹 (?)



每吋牙数 Pitch TPI		Insert Size = A	
		14	21
		刀片规格 = A	
24	Ext.	14 E 24 UNJ	21 E 24 UNJ
20	Ext.	14 E 20 UNJ	21 E 20 UNJ
18	Ext.	14 E 18 UNJ	21 E 18 UNJ
16	Ext.	14 E 16 UNJ	21 E 16 UNJ
14	Ext.	14 E 14 UNJ	21 E 14 UNJ
12	Ext.	14 E 12 UNJ	21 E 12 UNJ
H		7.5	12
T		3.1	4.7

Order example: 21E 16 UNJ MT7 订货式样: 21E 16 UNJ MT7

For internal UNJ threads it is common to use UN inserts as partial profile. UNJ内螺纹通常用UN不完整牙刀片 (?)

译者认为上述说明可能卡麦斯有误, 因为UNJ对内螺纹要求极严。UNJ内螺纹牙尖要求为5/16×P, 而标准UN内螺纹牙尖为1/4×P, 因此; 理论上标准UN内螺纹不能与UNJ外螺纹相配。上面可能是卡麦斯误将内螺纹写错为外螺纹。



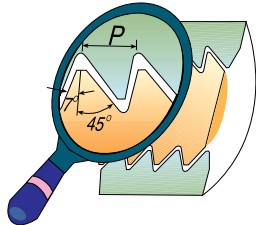
Mill - Thread Inserts

螺纹铣刀片



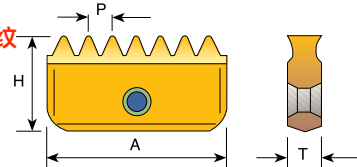
American Buttress

美国锯齿螺纹



ABUT螺纹铣刀片是一个面可以用于内、外螺纹

ABUT thread inserts are one-sided and may be used for both External and Internal threading



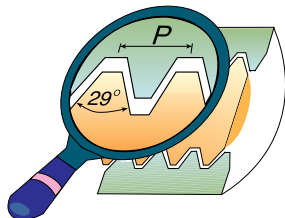
刀片规格 = A

每吋牙数 Pitch TPI	Insert Size = A		
	21	30	40
16	21 - 16 ABUT	30 - 16 ABUT	
12	21 - 12 ABUT	30 - 12 ABUT	
10	21 - 10 ABUT	30 - 10 ABUT	
8	21 - 8 ABUT	30 - 8 ABUT	
6		30 - 6 ABUT	
4		* 30 - 4 ABUT	40 - 4 ABUT
H	12	16	20
T	4.7	5.6	6.3

Order example: 30 - 6 ABUT MT7 订货式样: 30-6 ABUT MT7

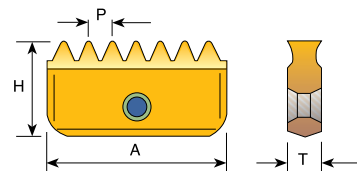
* Inserts to be used only on Multi-Insert toolholders see page 155 * 刀片只能用于多齿刀盘见155页

ACME ACME美制梯型螺纹



只能用于内螺纹

Inserts for Internal threads



每吋牙数 Pitch TPI		Insert Size = A 刀片规格 = A		
		21	30	40
12	Int.	21 12 ACME	30 12 ACME	
10	Int.	21 10 ACME	30 10 ACME	
8	Int.	21 8 ACME	30 8 ACME	
6	Int.		30 6 ACME	
5	Int.		30 5 ACME	
4	Int.		* 30 4 ACME	40 4 ACME
3.5	Int.			40 3.5 ACME
3	Int.			** 40 3 ACME
H		12	16	20
T		4.7	5.6	6.3

Order example: 21 | 8 ACME MT7 订货式样: 21 | 8 ACME MT7

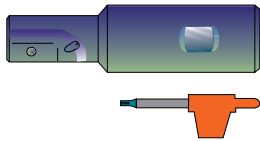
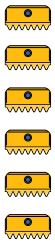
* Inserts to be used only on Multi-Insert toolholders see page 155 * 刀片只能用于多齿刀盘间155页

** One cutting edge ** 一个切削刃



ISO内螺纹铣刀片套盒

Internal ISO Kits



MTK 12 ISO	MTK 14 ISO
<u>INSERTS</u>	<u>INSERTS</u>
12 0.75 ISO	14 1.0 ISO 2 Pcs
12 1.0 ISO 2 Pcs	14 1.5 ISO 2 Pcs
12 1.25 ISO	14 2.0 ISO 2 Pcs
12 1.5 ISO 2 Pcs	
<u>TOOLHOLDER</u>	<u>TOOLHOLDER</u>
SR 0009 H12	SR 0017 H14
<u>KEY</u>	<u>KEY</u>
K12	K14
<u>SCREW</u>	<u>SCREW</u>
S12	S14

Order example : MTK 14 | ISO 订货样式: MTK 12 | ISO



Mill-Thread Toolholders

螺纹铣刀杆



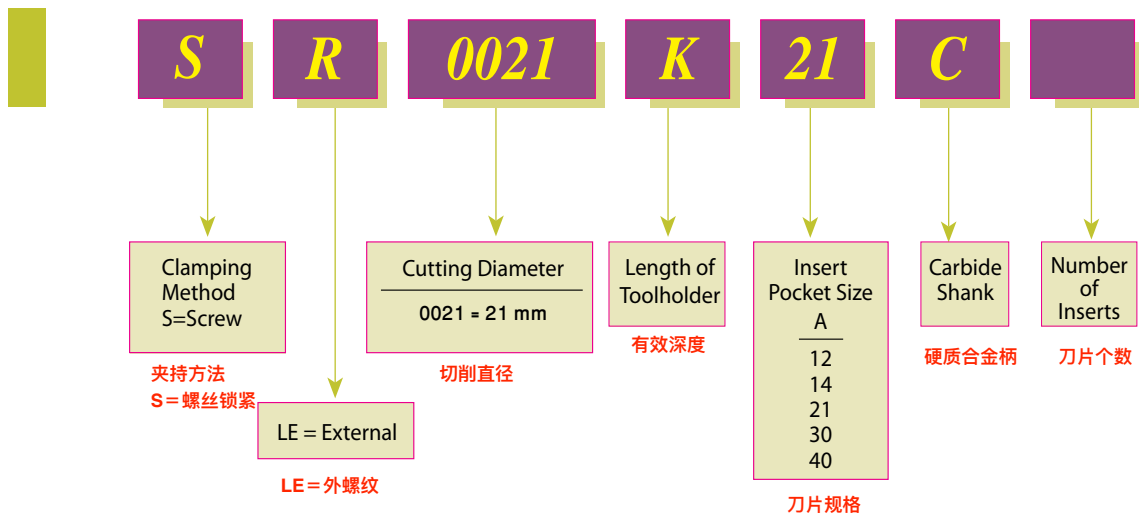
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Product Identification	产品标识	152
Single Insert Toolholders	单刀片刀杆	153
Long Shank Toolholders	长的刀杆	153
Twin Insert Toolholders	双刀片刀杆	154
Multi Insert Toolholders	多刀片刀盘	155
External Multi Insert Toolholders	多刀片外螺纹刀盘	155
Long Carbide Shank Toolholders	硬质合金长刀杆	156
Carbide Shank Toolholders for Single Point Threading	硬质合金刀杆单刃螺纹刀片	156



螺纹铣刀杆

Product Identification 产品标识

Mill-Thread Toolholders Ordering Codes 螺纹铣刀杆订货编码



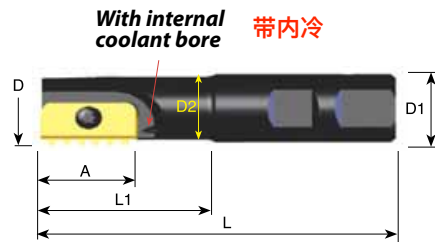


Mill - Thread Toolholders

螺纹铣刀杆

Single Insert Toolholders

单刀片螺纹铣刀杆



订货号 Ordering Code	A	D	D1	D2	L	L1	刀片螺丝 Insert Screw	扳手 Torx Key
* SR0009H12	12	9.5	20	7.5	85	14	S12	K12
SR0010H12	12	9.9	20	7.6	85	16	S12	K12
SR0012F14	14	12.0	20	8.9	75	20	S14	K14
SR0014H14	14	14.5	20	11.2	85	25	S14	K14
SR0017H14	14	17.0	20	13.4	85	30	S14	K14
** SR0018H21	21	18.0	20	14.4	85	30	S21	K21
SR0021H21	21	21.0	20	16.5	94	40	S21	K21
SR0029J30	30	29.0	25	22.4	110	50	S30	K30
SR0048M40	40	48.0	40	35.0	153	78	S40	K40

Order example: SR0029J30 订货样式: SR0029J30

* Not for conical inserts: 12-18 NPT, 12-18 NPTF, 12-19 BSPT * 不能用于锥管螺纹如: 12-18 NPT, 12-18 NPTF, 12-19 BSPT

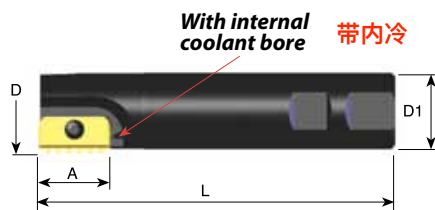
** Cannot be used with the following inserts:

21 I 3.5 ISO, 21 I 8 UN, 21 I 7 UN, 21-11 BSPT, 21-11.5 NPT, 21-11.5 NPTF

** 不能用于以下刀片: 21 I 3.5 ISO, 21 I 8 UN, 21 I 7 UN, 21-11 BSPT, 21-11.5 NPT, 21-11.5 NPTF

长的刀杆

Long Shank Toolholders



订货号 Ordering Code	A	D	D1	L	刀片螺丝 Insert Screw	扳手 Torx Key
SR0025K21	21	25	20	125	S21	K21
SR0031M30	30	31	25	150	S30	K30
SR0038M30	30	38	32	150	S30	K30
SR0048R40	40	48	40	210	S40	K40

Order example: SR0031M30 订货样式: SR0031M30

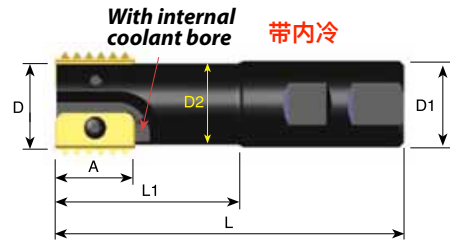
For holders with long overhang reduce the cutting speed and feed rate between 20% to 40% (depends on workpiece material, pitch and overhang)

使用长刀杆减少切削速度和进给20% - 40%之间 (取决于工件材料, 螺距和刀杆悬伸长度)



Twin Insert Toolholders

双刀片刀杆



订货号 Ordering Code	A	D	D1	D2	L	L1	刀片数 No. of Inserts	刀片螺丝 Insert Screw	扳手 Torx Key
SR0020H14-2	14	20	20	16	93	41	2	S14	K14
SR0030J21-2	21	30	25	24	108	52	2	S21	K21
SR0040L30-2	30	40	32	30	130	70	2	S30	K30
SR0050M40-2	40	50	40	38	153	78	2	S40	K40

Order example: SR0040L30-2 订货式样: SR0040L30-2

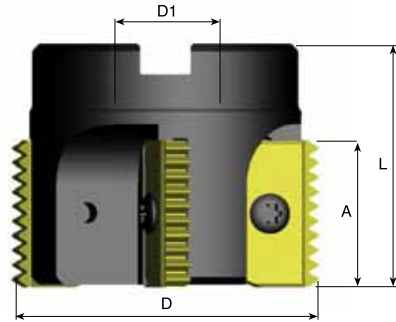


Mill - Thread Toolholders

螺纹铣刀盘

Multi Insert Toolholders

多刀片螺纹铣刀盘

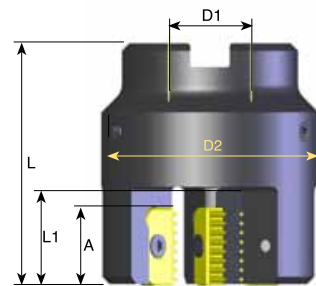
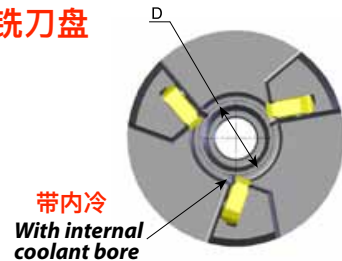
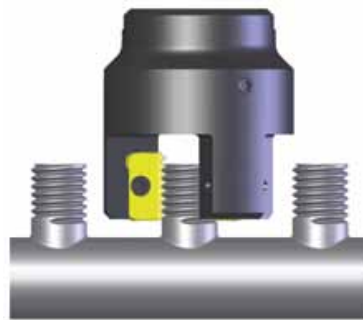


订货号 Ordering Code	A	D	D1	L	刀片数 No. of Inserts	刀片螺丝 Insert Screw	扳手 Torx Key
SR0063C21-5	21	63	22	50	5	S21	K21
SR0063C30-4	30	63	22	50	4	S30	K30
SR0080D30-4	30	80	27	55	4	S30	K30
SR0100D30-4	30	100	32	60	4	S30	K30
SR0100D30-8	30	100	32	60	8	S30	K30
SR0080D40-4	40	80	27	65	4	S40	K40
SR0100E40-4	40	100	32	70	4	S40	K40
SR0100E40-6	40	100	32	70	6	S40	K40

Order example: SR0080D30-4 订货式样: SR0080D30-4

External Multi Insert Toolholder 多刀片外螺纹铣刀盘

- Reduced machining time 减少加工时间
- Optimal coolant supply 最佳的冷却供给



订货号 Ordering Code	A	D	D1	D2	L	L1	刀片数 No. of Inserts	刀片螺丝 Insert Screw	扳手 Torx Key
SLE0020D21-3	21	20	22	58	65	25	3	S21	K21
SLE0030D21-3	21	30	22	68	65	25	3	S21	K21
SLE0045E21-4	21	45	27	83	70	25	4	S21	K21

Order example: SLE0030D21-3 订货式样: SLE0030D21-3

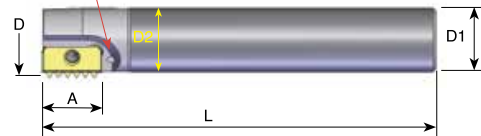


Long Carbide Shank Toolholders

硬质合金长刀杆



With internal coolant bore 带内冷



订货号 Ordering Code	A	D	D1	D2	L	刀片螺丝 Insert Screw	扳手 Torx Key
SR0010K12C	12	9.9	8	8	125	S12	K12
SR0013H14C	14	13.2	10	10	110	S14	K14
SR0013J14C	14	13.2	10	10	155	S14	K14
SR0015K14C	14	15.2	12	12	175	S14	K14
SR0021K21C	21	21.0	16	16	130	S21	K21
SR0021M21C	21	21.0	16	16	200	S21	K21
SR0027S30C	30	27.0	20	20	270	S30	K30

Order example: SR0015K14C 订货式样: SR0015K14C

For holders with long overhang reduce the cutting speed and feed rate between 20% to 40% (depends on workpiece material, pitch and overhang)

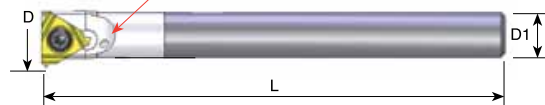
刀杆长悬伸减少切削速度和进给20% - 40% (取决于工件材料、螺距和悬伸长度)

Carbide Shank Toolholders for Single Point Threading

单尖硬质合金刀杆



带内冷
With internal coolant bore



螺距牙数范围

订货号 Ordering Code		Pitch Range		D	D1	L	刀片螺丝 Insert Screw	扳手 Torx Key
		mm	TPI					
SR0005D06C	6	0.5-1.25	48-20	6.8	5.0	63	S06	K06
SR0006H08C	8	0.5-1.75	48-14	8.8	6.0	100	S08	K08
* SR0010M11C	11	0.5-2.00	48-11	13.2	10.0	150	S11	K11

For Inserts see the Thread Turning Tools section of this catalog 刀片选择见样本螺纹车刀片部分

For an internal application use an internal R.H. insert. 适用于内螺纹R.H.刀片

* For an external application use an external L.H. insert. * 外螺纹适用于外螺纹L.H.刀片



Mill-Thread Inserts Speed and Feed Selection 螺纹铣刀片-速度与进给选择

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: 亚微颗粒级钛铝化氮 (TiAlN) 复合涂层 (ISO K10-K20) 通用所有材料, 中到高的切削速度**

ISO ISO标准	Materials 材料	Cutting Speed m/min 切削速度	
		MT7	MT7
P	Low and Medium Carbon Steels 低到中碳钢	115 - 280	
	High Carbon Steels 高碳钢	130 - 200	
	Alloy Steels, Treated Steels 合金钢、热处理钢	105 - 180	
M	Stainless Steels 不锈钢	130 - 190	
	Cast Steels 铸造不锈钢	150 - 190	
K	Cast Iron 铸铁	80 - 70	
N	Non-Ferrous & Aluminum 非铁金属和铝	180 - 340	
	Synthetics, Duroplastics, Thermoplastics 合成材料/硬塑料/热塑料	115 - 460	
S	Nickel Alloys, Titanium Alloys 镍合金、钛合金	25 - 90	

Recommended FEED RATE: 0.05 - 0.15 mm 推荐进给: 0.05-0.15mm

Spiral Mill-Thread Inserts Speed and Feed Selection 螺旋螺纹铣刀片速度与进给选择

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:亚微颗粒级钛铝化氮 (TiAlN) 复合涂层 (ISO K10-K20) 通用所有材料, 中到高的切削速度**

ISO ISO标准	Materials 材料	Cutting Speed m/min 切削速度	
		MT7	MT7
P	Low and Medium Carbon Steels 低和中碳钢	145 - 360	
	High Carbon Steels 高碳钢	165 - 255	
	Alloy Steels, Treated Steels 合金钢、热处理钢	135 - 230	
M	Stainless Steels 不锈钢	165 - 245	
	Cast Steels 铸造不锈钢	190 - 245	
K	Cast Iron 铸铁	100 - 220	
N	Non-Ferrous & Aluminum 非铁金属和铝	230 - 440	
	Synthetics, Duroplastics, Thermoplastics 合成材料/硬塑料/热塑料	145 - 590	
S	Nickel Alloys, Titanium Alloys 镍合金、钛合金	30 - 115	

Recommended FEED RATE: 0.05 - 0.15 mm 推荐进给: 0.05 - 0.15mm

As you may note, cutting speed is shown in range terms. In most standard cases choosing a speed in the middle of the range would be a good choice for a start.

For hard metals reduce cutting speed. 加工硬材料时降低切削速度。

正如你可能注意到切削速度显示于一个范围内。在大多数标准的情况下，速度选择在中间值将是一个很好的选择开始。对于硬金属要降低切削速度。



Tool Selection 螺纹铣刀选择

For indexable and solid carbide Mill Threads 用于可转位螺纹铣刀和整体硬质合金螺纹铣刀

The following chart provides a fairly accurate visual selection tool for Internal Threading.

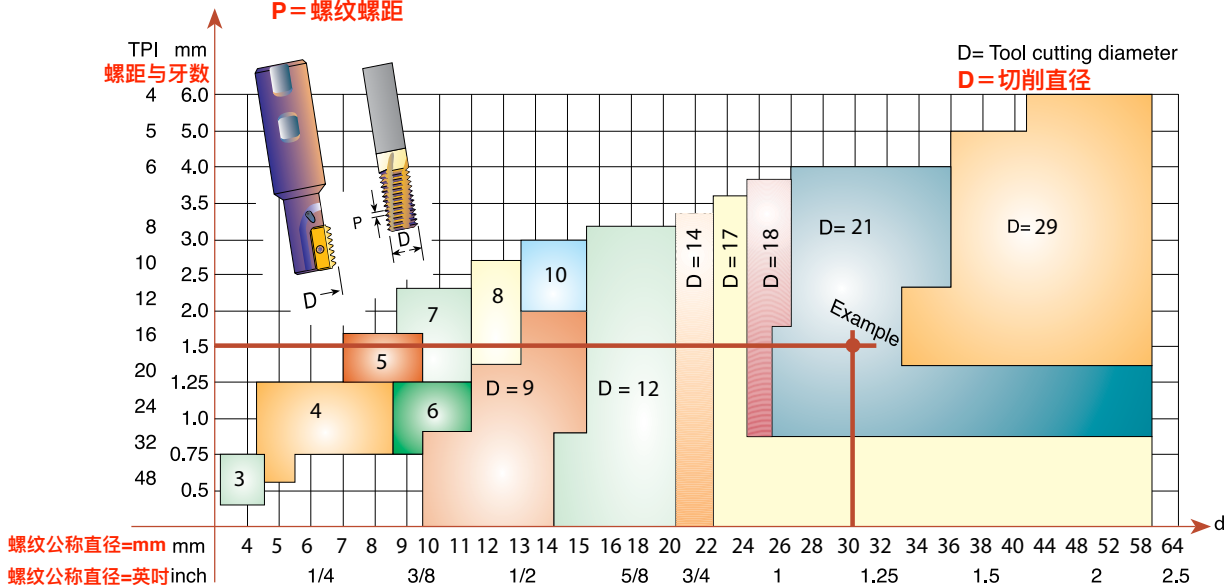
The chart is suitable for the following thread forms: ISO, UN, WHIT, NPT, NPTF, BSPT and PG.

下面的图表为内螺纹提供了一个相当精确的可视化选择工具。图表适用于以下螺纹形式：ISO, UN,

英制惠氏螺纹, NPT NPTF锥管螺纹、BSPT锥管螺纹和PG-DIN - 40430电力管线螺纹。

P= Thread Pitch

P = 螺纹螺距



Any tool with a small cutting diameter can produce larger diameter threads. 任何一个小的切削直径可以加工大直径螺纹

Example: Internal thread M30 x 1.5: 样式: 内螺纹M30x1.5:

Find a Milling Tool to produce d=30 Internal right hand ISO thread with a thread pitch P=1.5 mm. As can be seen from the chart above, the two red lines intersect at a selected tool with a cutting diameter of D=21 mm

Chosen toolholder: SR0021 H21

Insert: 21 I 1.5 ISO MT7

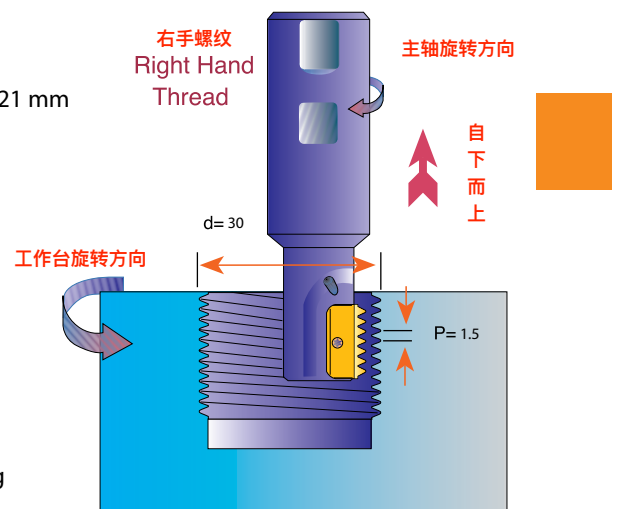
查寻一个 D = 30内螺纹的铣削公称直径
根据螺距查出 P = 1.5毫米的ISO右手螺纹。
从上面的图表可以找出两条棕色线相交在一个灰色选择区域, 切削直径 D = 21毫米处。

选定螺纹铣刀杆: SR0021 H21

选定螺纹铣刀片: 21 I 1.5 ISO MT7

If you need assistance, please call your local distributor and ask for help in selecting the appropriate tool as well as for a CNC program to suit your CNC milling machine.

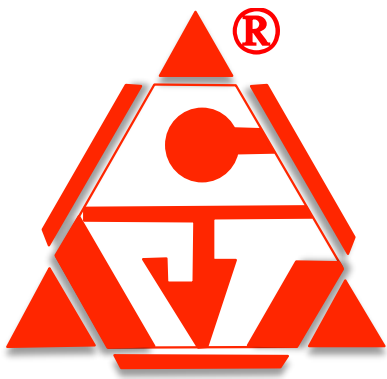
如果你需要帮助, 请打电话给您当地的经销商, 并要求他们帮助选择一个适当的工具, 以及根据你的机床操作系统选择一个螺纹铣削的CNC程序。



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