



Mill-Thread Solid Carbide

整体硬质合金螺纹铣刀



优点 Advantages of Mill-Thread Solid Carbide

- Thread is generated in one pass. 螺纹一次生成
- Spiral flutes allow smooth cutting action. 螺旋槽设计达到平稳切削
- Shorter machining time due to multi, 3 to 6, flutes. 短的加工时间, 多至3-6槽
- 2.2 mm and up cutting diameter. 2.2mm以上的切削直径
- Threads up to shoulder in blind hole. 盲孔螺纹至根部
- Longer tool life due to special multi-layer coating. 特殊的三层涂层延长刀具寿命
- Same tool can be used for a variety of materials. 相同的刀具可用于所有材料
- Excellent surface finish. 杰出的表面光洁度
- Low cutting pressure allows thin wall machining. 低切削力可用于薄壁零件加工
- Same tool used for R.H and L.H. threads. 相同的刀具可用于右手或左手螺纹

MT - Thread Mills without internal coolant MT不带内冷

MTB - Thread Mills with internal coolant bore for blind holes MTB带内冷, 出水口在前部

MTZ - Thread Mills with internal coolant through the flutes MTZ带内冷, 出水口在切削槽

MTQ - Thread Mills that include relieved neck for deep work pieces MTQ带内冷, 出水口在前端, 缩颈, 大长径比

FMT - Fast Thread Mills with internal coolant bore FMT带内冷, 高速螺纹铣刀

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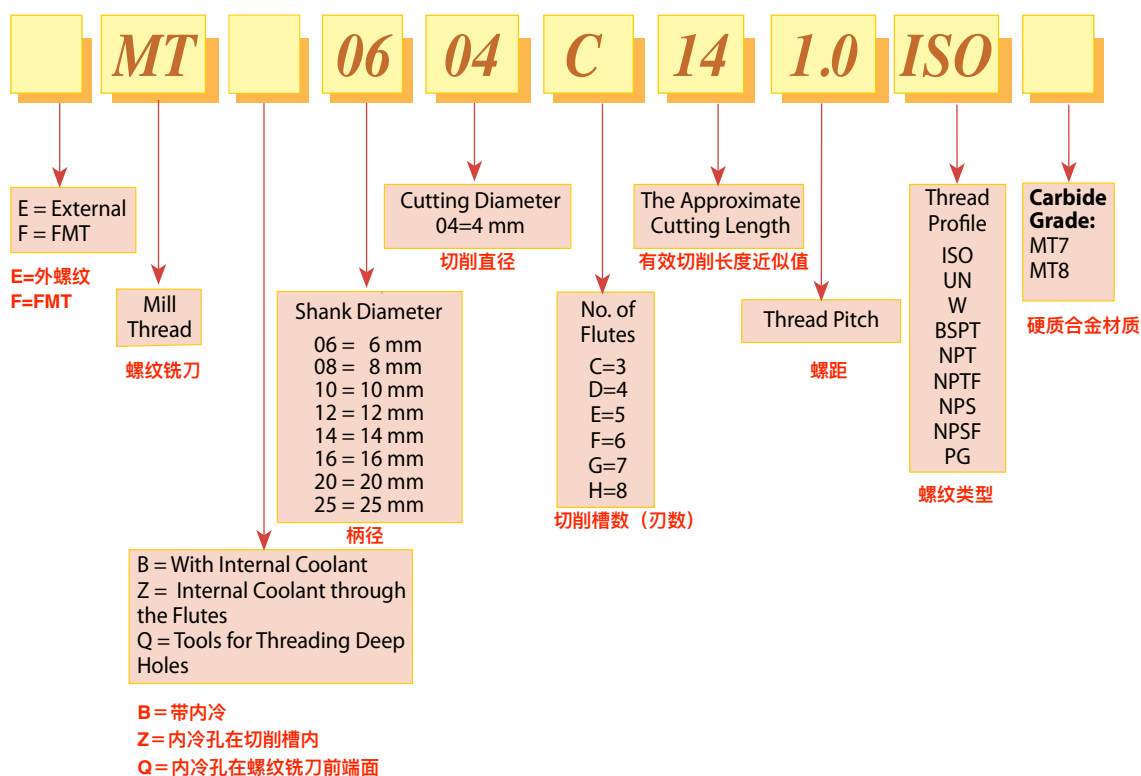


整体硬质合金螺纹铣刀

Product Identification 产品标识

Mill-Thread Solid Carbide Ordering Codes

整体硬质合金螺纹铣刀订货编号

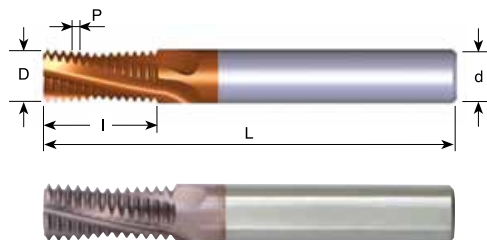
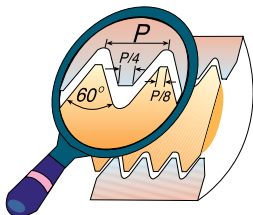




Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

ISO ISO-无内冷/只能用于内螺纹
Tools for Internal thread



螺距	公制粗牙	公制细牙	订货号	柄径	切削直径	切削槽数	有效长度	总长
Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	I	L
0.5	M3	$\varnothing \geq 4$	MT06022C5 0.5 ISO	6	2.2	3	5.3	58
0.5		$\varnothing \geq 5$	MT06038C10 0.5 ISO	6	3.8	3	10.3	58
0.7	M4	$\varnothing \geq 5$	MT06031C7 0.7 ISO	6	3.1	3	7.4	58
0.75		$\varnothing \geq 6$	MT06045C10 0.75 ISO	6	4.5	3	10.1	58
0.8	M5	$\varnothing \geq 6$	MT06036C9 0.8 ISO	6	3.6	3	9.2	58
1.0	M6	$\varnothing \geq 7$	MT0604C10 1.0 ISO	6	4.0	3	10.5	58
1.0	M6	$\varnothing \geq 7$	MT0604C14 1.0 ISO	6	4.0	3	14.5	58
1.0		$\varnothing \geq 9$	MT0606C12 1.0 ISO	6	6.0	3	12.5	58
1.0		$\varnothing \geq 10$	MT0808D16 1.0 ISO	8	8.0	4	16.5	64
1.25	M8	$\varnothing \geq 10$	MT0605C14 1.25 ISO	6	5.0	3	14.4	58
1.25	M8	$\varnothing \geq 10$	MT0605C19 1.25 ISO	6	5.0	3	19.4	58
1.5	M10	$\varnothing \geq 12$	MT0807C17 1.5 ISO	8	7.0	3	17.3	64
1.5	M10	$\varnothing \geq 12$	MT0807C24 1.5 ISO	8	7.0	3	24.8	76
1.5		$\varnothing \geq 14$	MT1010D21 1.5 ISO	10	10.0	4	21.8	73
1.5		$\varnothing \geq 20$	MT1616F33 1.5 ISO	16	16.0	6	33.8	105
1.75	M12	$\varnothing \geq 14$	MT0808C20 1.75 ISO	8	8.0	3	20.1	64
1.75	M12	$\varnothing \geq 14$	MT0808C28 1.75 ISO	8	8.0	3	28.9	76
2.0	M16	$\varnothing \geq 17$	MT1010C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M16	$\varnothing \geq 17$	MT1010C39 2.0 ISO	10	10.0	3	39.0	105
2.0		$\varnothing \geq 18$	MT1212D27 2.0 ISO	12	12.0	4	27.0	84
2.0		$\varnothing \geq 26$	MT2020F41 2.0 ISO	20	20.0	6	41.0	105
2.5	M20	$\varnothing \geq 22$	MT1414D33 2.5 ISO	14	14.0	4	33.8	84
2.5	M20	$\varnothing \geq 22$	MT1414D48 2.5 ISO	14	14.0	4	48.8	105
3.0	M24	$\varnothing \geq 25$	MT1616C40 3.0 ISO	16	16.0	3	40.5	105
3.0	M24	$\varnothing \geq 25$	MT1616C58 3.0 ISO	16	16.0	3	58.5	120
3.0	M27	$\varnothing \geq 28$	MT2020D43 3.0 ISO	20	20.0	4	43.5	105

Order example: MT 1212D27 2.0 ISO MT7 订货样式: Mt 1212D27 2.0 ISO MT7

For thread mills with coolant bore see following pages 带内冷螺纹铣刀见下页

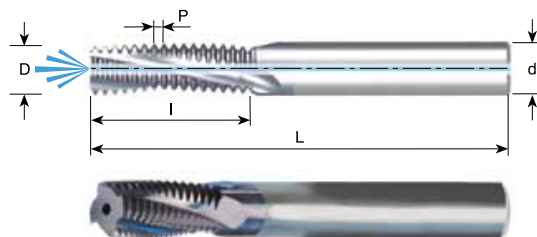
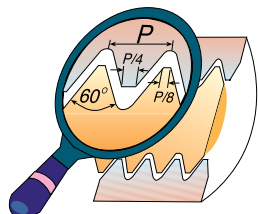
For small thread mills see pages 227-228, 235 & 245  小径螺纹铣刀见227-228, 235, 245页



Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

ISO With internal coolant bore ISO-带内冷/只能用于内螺纹
Tools for Internal thread



螺距	公制粗牙	公制细牙	订货号	柄径	切削直径	切削槽数	有效长度	总长
Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	I	L
0.5		$\phi \geq 5$	MTB06038C10 0.5 ISO	6	3.8	3	10.3	58
0.7	M4	$\phi \geq 5$	MTB06031C7 0.7 ISO	6	3.1	3	7.4	58
0.75		$\phi \geq 6$	MTB06045C10 0.75 ISO	6	4.5	3	10.1	58
0.75		$\phi \geq 12$	MTB1010D24 0.75 ISO	10	10.0	4	24.4	73
0.8	M5	$\phi \geq 6$	MTB06038C9 0.8 ISO	6	3.8	3	9.2	58
1.0	M6	$\phi \geq 7$	MTB06046C10 1.0 ISO	6	4.6	3	10.5	58
1.0	M6	$\phi \geq 7$	MTB06046C14 1.0 ISO	6	4.6	3	14.5	58
1.0		$\phi \geq 9$	MTB0606C12 1.0 ISO	6	6.0	3	12.5	58
1.0		$\phi \geq 10$	MTB0808D16 1.0 ISO	8	8.0	4	16.5	64
1.0		$\phi \geq 12$	MTB1010D24 1.0 ISO	10	10.0	4	24.5	73
1.25	M8	$\phi \geq 10$	MTB0606C14 1.25 ISO	6	6.0	3	14.4	58
1.25	M8	$\phi \geq 10$	MTB0606C19 1.25 ISO	6	6.0	3	19.4	58
1.5	M10	$\phi \geq 12$	MTB08078C17 1.5 ISO	8	7.8	3	17.0	64
1.5	M10	$\phi \geq 12$	MTB08078C24 1.5 ISO	8	7.8	3	24.8	76
1.5		$\phi \geq 14$	MTB1010D21 1.5 ISO	10	10.0	4	21.8	73
1.5		$\phi \geq 16$	MTB1212D26 1.5 ISO	12	12.0	4	26.3	84
1.5		$\phi \geq 20$	MTB1616F33 1.5 ISO	16	16.0	6	33.8	105
1.75	M12	$\phi \geq 12$	MTB1009C20 1.75 ISO	10	9.0	3	20.1	73
1.75	M12	$\phi \geq 12$	MTB1009C28 1.75 ISO	10	9.0	3	28.9	73
2.0	M14	$\phi \geq 15$	MTB1010C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M16	$\phi \geq 17$	MTB12118D27 2.0 ISO	12	11.8	4	27.0	84
2.0	M16	$\phi \geq 17$	MTB12118D39 2.0 ISO	12	11.8	4	39.0	105
2.0		$\phi \geq 26$	MTB2020F41 2.0 ISO	20	20.0	6	41.0	105
2.5	M20	$\phi \geq 22$	MTB1615E33 2.5 ISO	16	15.0	5	33.8	105
2.5	M20	$\phi \geq 22$	MTB1615E48 2.5 ISO	16	15.0	5	48.8	105
3.0	M24	$\phi \geq 25$	MTB2018D40 3.0 ISO	20	18.0	4	40.5	105
3.0	M24	$\phi \geq 25$	MTB2018D58 3.0 ISO	20	18.0	4	58.5	120
3.0	M27	$\phi \geq 27$	MTB2020D43 3.0 ISO	20	20.0	4	43.5	105

Order example: MTB 08078C17 1.5 ISO MT7 订货样式: MTB 08078C17 1.5 ISO MT7

For thread mills with coolant through the flutes see next page 切削槽出水内冷螺纹铣刀见下页

For small thread mills see pages 227-228, 235 & 245 小径螺纹铣刀见227-228, 235, 245页

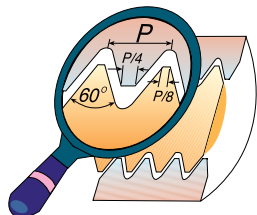


Mill - Thread Solid Carbide



整体硬质合金螺纹铣刀

ISO With internal coolant through the flutes ISO-带内冷切削槽出水/只能用于内螺纹
Tools for Internal Thread



螺距	公制粗牙	公制细牙	订货号	柄径	切削直径	切削槽数	有效刃长	总长
Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	I	L
1.0	M6	$\varnothing \geq 7$	MTZ06048C10 1.0 ISO	6	4.8	3	10.5	58
1.0		$\varnothing \geq 9$	MTZ0606C12 1.0 ISO	6	6.0	3	12.5	58
1.0		$\varnothing \geq 10$	MTZ0808D16 1.0 ISO	8	8.0	4	16.5	64
1.25	M8	$\varnothing \geq 10$	MTZ0606C14 1.25 ISO	6	6.0	3	14.4	58
1.25	M8	$\varnothing \geq 10$	MTZ0606C19 1.25 ISO	6	6.0	3	19.4	58
1.5	M10	$\varnothing \geq 12$	MTZ08078C17 1.5 ISO	8	7.8	3	17.0	64
1.5		$\varnothing \geq 14$	MTZ1010D21 1.5 ISO	10	10.0	4	21.8	73
1.5		$\varnothing \geq 16$	MTZ1212D26 1.5 ISO	12	12.0	4	26.3	84
1.5		$\varnothing \geq 20$	MTZ1616E33 1.5 ISO	16	16.0	5	33.8	101
1.75	M12	$\varnothing \geq 12$	MTZ1009C20 1.75 ISO	10	9.0	3	20.1	73
1.75	M12	$\varnothing \geq 12$	MTZ1009C28 1.75 ISO	10	9.0	3	28.9	73
2.0	M14	$\varnothing \geq 15$	MTZ1010C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M16	$\varnothing \geq 17$	MTZ12118D27 2.0 ISO	12	11.8	4	27.0	84
2.5	M20	$\varnothing \geq 22$	MTZ1615E33 2.5 ISO	16	15.0	5	33.8	101

Order example: MTZ 08078C17 1.5 ISO MT7 订货式样: MTZ 08078C17 1.5 ISO MT7

For small thread mills see pages 227-228, 235 & 245



小径螺纹铣刀见227-228, 235, 245页



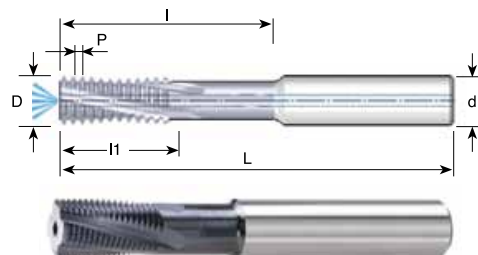
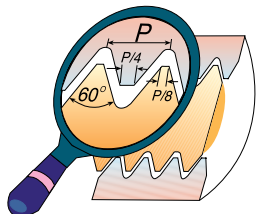
Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

ISO With relieved neck and internal coolant bore

Tools for Internal Thread

ISO-缩颈/大长径比/端面出水内冷/只能用于内螺纹



螺距	公制细牙	订货号	柄径	切削直径	切削槽数	切削刃长度	有效长度	总长
Pitch TPI	M fine	Ordering Code	d	D	No. of Flutes	I1	I	L
1.0	$\emptyset \geq 12$	MTQ1010D32 1.0 ISO	10	10.0	4	18.0	32.0	73
1.0	$\emptyset \geq 14$	MTQ1212D38 1.0 ISO	12	12.0	4	21.0	38.0	84
1.0	$\emptyset \geq 18$	MTQ1616F45 1.0 ISO	16	16.0	6	26.0	45.0	105
1.5	$\emptyset \geq 13$	MTQ1010D30 1.5 ISO	10	10.0	4	18.0	30.0	73
1.5	$\emptyset \geq 15$	MTQ1212D34 1.5 ISO	12	12.0	4	19.5	34.5	84
1.5	$\emptyset \geq 19$	MTQ1616F43 1.5 ISO	16	16.0	6	25.5	43.5	105
1.5	$\emptyset \geq 23$	MTQ2020F60 1.5 ISO	20	20.0	6	36.0	60.0	105
2.0	$\emptyset \geq 16$	MTQ1212D42 2.0 ISO	12	12.0	4	24.0	42.0	84
2.0	$\emptyset \geq 20$	MTQ1616E45 2.0 ISO	16	16.0	5	26.0	45.0	105
2.0	$\emptyset \geq 24$	MTQ2020F56 2.0 ISO	20	20.0	6	34.0	56.0	105
3.0	$\emptyset \geq 22$	MTQ1616D45 3.0 ISO	16	16.0	4	30.0	45.0	105
3.0	$\emptyset \geq 26$	MTQ2020E54 3.0 ISO	20	20.0	5	33.0	54.0	105
3.5	$\emptyset \geq 26$	MTQ2020D45 3.5 ISO	20	20.0	4	28.0	45.5	105
4.0	$\emptyset \geq 31$	MTQ2525D64 4.0 ISO	25	25.0	4	40.0	64.0	160

Order example: MTQ 1010D30 1.5 ISO MT7 订货样式: MTQ 1010D30 1.5 ISO MT7

For small thread mills see pages 227-228, 235 & 245



小径螺纹铣刀见227-228页, 235, 245页

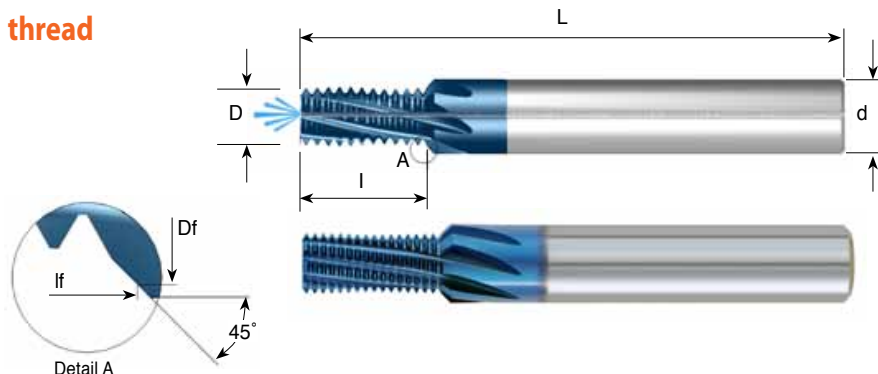


Mill - Thread Solid Carbide



整体硬质合金螺纹铣刀

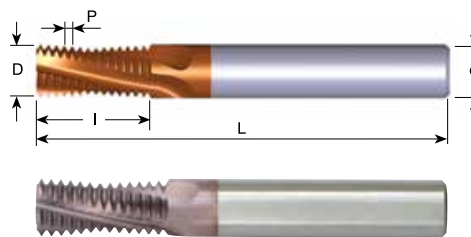
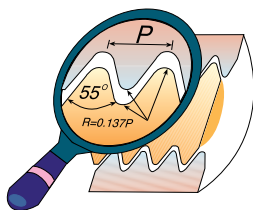
ISO Fast MT With internal coolant bore ISO-高速螺纹铣刀/前端面出水/只能用于内螺纹
Tools for Internal thread



螺距	公制粗牙	公制细牙	订货号	柄径	切削直径	切削槽数	有效长度	总长		
Pitch mm	M coarse	M fine	Ordering Code	d	D	Df	Flutes	l	lf	L
1.0	M6	Ø ≥ 7	FMT 08048 F10 1.0 ISO	8	4.8	6.8	6	10.5	11.5	64
1.25	M8	Ø ≥ 10	FMT 10064 G14 1.25 ISO	10	6.4	9.6	7	14.4	16.0	73
1.5	M10	Ø ≥ 12	FMT 1008 G17 1.5 ISO	10	8.0	9.8	7	17.3	18.2	73
1.75	M12	Ø ≥ 12	FMT 12095 G20 1.75 ISO	12	9.5	11.7	7	20.1	21.2	84

Order example: FMT 1008 G17 1.5 ISO MT8 订货样式: FMT 1008 G17 1.5 ISO MT8

G (55°) BSF, BSP G (55°) BSF,BSP/内外螺纹通用
Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	切削直径	有效刀长	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/16-G1/8	MT0606C9 28 W	6	6.0	3	9.5	58
19	G1/4-3/8	MT0808C14 19 W	8	8.0	3	14.0	64
14	G1/2-7/8	MT1212D19 14 W	12	12.0	4	19.0	84
14	G1/2-7/8	MT1212D26 14 W	12	12.0	4	26.3	84
11	G ≥ 1	MT1212C24 11 W	12	12.0	3	24.2	84
11	G ≥ 1	MT1616D38 11 W	16	16.0	4	38.1	105
11	G ≥ 1	MT2020E47 11 W	20	20.0	5	47.3	105

Order example: MT 1212D19 14 W MT7 订货样式: MT 1212D19 14 W MT7

For small thread mills see pages 231, 234 & 247 小径螺纹铣刀见231, 234, 247页

For thread mills with coolant see next page 带内冷螺纹铣刀见下页

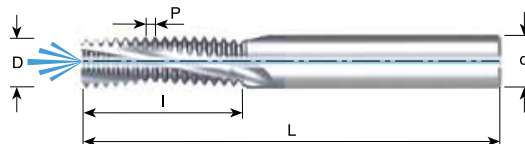


Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

G (55°) BSF, BSP With internal coolant bore

Same Tool for Internal and External Thread **G (55°) BSF,BSP/内冷端面出水/内外螺纹通用**



每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效刃长	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	MTB08078C14 28W	8	7.8	3	14.1	64
19	G1/4-3/8	MTB1010D16 19W	10	10.0	4	16.7	73
14	G1/2-7/8	MTB1616E26 14W	16	16.0	5	26.3	105
11	G≥1	MTB1616D38 11W	16	16.0	4	38.1	105
11	G≥1	MTB2020E47 11W	20	20.0	5	47.3	105

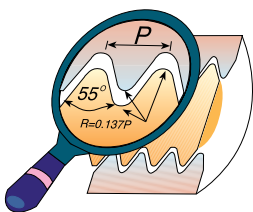
Order example: MTB 1010D16 19 W MT7 订货式样: MTB 1010D16 19 W MT7

For small thread mills see pages 231, 234 & 247 小径螺纹铣刀见231, 234, 247页

G 55° BSF,BSP 切削槽内出水内冷/内外螺纹通用

G 55° BSF, BSP With internal coolant through the flutes

Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	刃数	有效刃长	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	MTZ08078C14 28W	8	7.8	3	14.1	64
19	G1/4-3/8	MTZ1010D16 19W	10	10.0	4	16.7	73
14	G1/2-7/8	MTZ1616E26 14W	16	16.0	5	26.3	101
11	G≥1	MTZ1616D38 11W	16	16.0	4	38.1	101

Order example: MTZ 08078C14 28 W MT7 订货式样: MTZ 08078C14 28 W MT7

For small thread mills see pages 231, 234 & 247  小径螺纹铣刀见231, 234, 247页



整体硬质合金螺纹铣刀

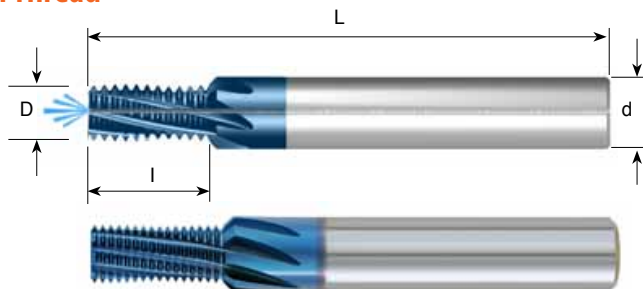
Mill - Thread Solid Carbide



G (55°) 高速螺纹铣刀/内冷前端面出水/内外螺纹通用

G 55° Fast MT With internal coolant bore

Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	刃数	有效刃长	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	FMT08078H14 28W	8	7.8	8	14.1	64
19	G1/4-3/8	FMT1010G16 19W	10	10.0	7	16.7	73
14	G1/2-7/8	FMT1616H26 14W	14	14.0	8	26.3	84
11	G≥1	FMT1616H38 11W	16	16.0	8	38.1	105

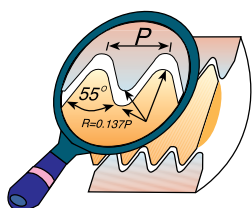
Order example: FMT 1616 H38 11W MT8 订货样式: FMT 1616 H38 11 W MT*

* Without cutting chamfer * 不带倒角切削刃

英制惠氏螺纹/BSW/内冷切削槽内出水/内外螺纹通用

Whitworth BSW With internal coolant through the flutes

Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	刃数	有效刃长	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
* 20	1/4	MTZ06046C12 20W	6	4.6	3	12.1	58
18	5/16	MTZ06053C14 18W	6	5.3	3	14.8	58
16	3/8	MTZ08064C16 16W	8	6.8	3	16.7	64
16	1/2	MTZ10092D24 16W	10	9.2	4	24.6	73
14	7/16	MTZ08078D20 14W	8	7.8	4	20.9	64
12	1/2	MTZ10086D24 12W	10	8.6	4	24.4	73
11	5/8	MTZ12109D28 11W	12	10.9	4	28.9	84

Order example: MTZ 08064C16 16 W MT7 订货样式: MTZ 08064C16 16 W MT7

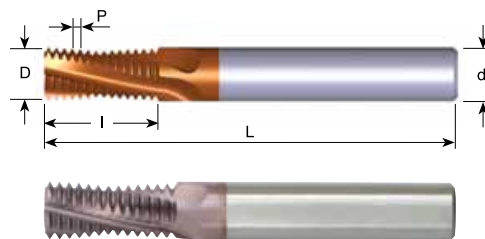
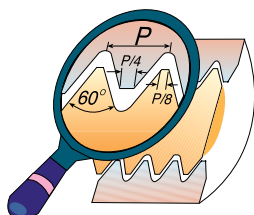
* Cutter without coolant * 无内冷



Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

UN UN/只能用于内螺纹 Tools for Internal Thread



每吋牙数	美制-UN/UNF/UNEF			订货号	柄径	切削直径	刃数	有效刃长	总长
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
40	5			MT06025C6 40UN	6	2.5	3	6.0	58
32	8	10	12	MT06032C6 32UN	6	3.2	3	6.8	58
28		1/4		MT0604C11 28UN	6	4.0	3	11.3	58
28			7/16-1/2	MT0606C14 28UN	6	6.0	3	14.1	58
24		5/16		MT0605C14 24UN	6	5.0	3	14.3	58
24		3/8	9/16-5/8	MT0807C21 24UN	8	7.0	3	20.6	64
20	1/4			MT06045C12 20UN	6	4.5	3	12.1	58
20		7/16-1/2		MT0807C21 20UN	8	7.0	3	21.0	64
20			3/4-1	MT1212E27 20UN	12	12.0	5	27.3	84
18	5/16			MT0605C14 18UN	6	5.0	3	14.8	58
18		9/16-5/8	1 1/8-1 5/8	MT1010D26 18UN	10	10.0	4	26.1	73
16	3/8			MT0606C16 16UN	6	6.0	3	16.7	58
16		3/4		MT1212D31 16UN	12	12.0	4	31.0	84
14	7/16			MT0807C20 14UN	8	7.0	3	20.9	64
14		7/8		MT1615E37 14UN	16	15.0	5	37.2	105
13	1/2			MT0808C22 13UN	8	8.0	3	22.5	64
12	9/16			MT1010C26 12UN	10	10.0	3	26.5	73
12		1-1 1/2		MT1616E41 12UN	16	16.0	5	41.3	105
11	5/8			MT1010C28 11UN	10	10.0	3	28.9	73
10	3/4			MT1212C34 10UN	12	12.0	3	34.3	84
9	7/8			MT1615C38 9UN	16	15.0	3	38.1	105
8	1			MT1616C42 8UN	16	16.0	3	42.9	105
7	1 1/8-1 1/4			MT2020D45 7UN	20	20.0	4	45.3	105

Order example: MT 1615 E37 14 UN MT7 订货样式: MT 1615 E37 14 UN MT7

For thread mills with coolant bore see following pages 带内冷螺纹铣刀见下页

For small thread mills see pages 229-230, 235 & 246



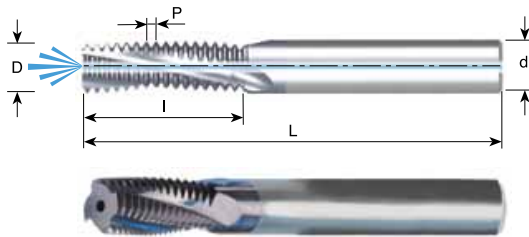
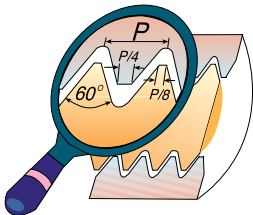
小径螺纹铣刀见229-230, 235, 246页



Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

UN With internal coolant bore UN/内冷前端面出水/只能用于内螺纹
Tools for Internal Thread



每吋牙数	美制-UN/UNF/UNEF			订货号	柄径	切削直径	刃数	有效刃长	总长
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
32	8	10	12	MTB06032C6 32 UN	6	3.2	3	6.8	58
32			5/16	MTB0606C14 32 UN	6	6.0	3	14.7	58
32			3/8	MTB0808D18 32 UN	8	8.0	4	18.7	64
28		1/4		MTB0605C11 28 UN	6	5.0	3	11.3	58
28			7/16-1/2	MTB0606C14 28 UN	6	6.0	3	14.1	58
24		5/16		MTB08066C14 24 UN	8	6.6	3	14.3	64
24		3/8	9/16-5/8	MTB0808D21 24 UN	8	8.0	4	20.6	64
20	1/4			MTB06047C12 20 UN	6	4.7	3	12.1	58
20		7/16		MTB0808C21 20 UN	8	8.0	3	21.0	64
20		1/2		MTB1010D22 20 UN	10	10.0	4	22.3	73
20			3/4-1	MTB1212E27 20 UN	12	12.0	5	27.3	84
18	5/16			MTB06056C14 18 UN	6	5.6	3	14.8	58
18		9/16-5/8	1 1/8-1 5/8	MTB12113D26 18 UN	12	11.3	4	26.1	84
16	3/8			MTB08067C16 16 UN	8	6.7	3	16.7	64
16		3/4		MTB1212D31 16 UN	12	12.0	4	31.0	84
14	7/16			MTB08077C20 14 UN	8	7.7	3	20.9	64
14		7/8		MTB1616E37 14 UN	16	16.0	5	37.2	105
13	1/2			MTB10092C22 13 UN	10	9.2	3	22.5	73
12	9/16			MTB12105C26 12 UN	12	10.5	3	26.5	84
12		1-1 1/2		MTB1616E41 12 UN	16	16.0	5	41.3	105
11	5/8			MTB12114C28 11 UN	12	11.4	3	28.9	84
10	3/4			MTB16144D34 10 UN	16	14.4	4	34.3	105
9	7/8			MTB1616C38 9 UN	16	16.0	3	38.1	105
8	1			MTB20195D42 8 UN	20	19.5	4	42.9	105
7	1 1/8-1 1/4			MTB2020D45 7 UN	20	20.0	4	45.3	105

Order example: MTB 1212D31 16 UN MT7 订货样式: MTB 1212D31 16 UN MT7

For thread mills with coolant through the flutes see next page 带内冷切削槽出水螺纹铣刀见下页

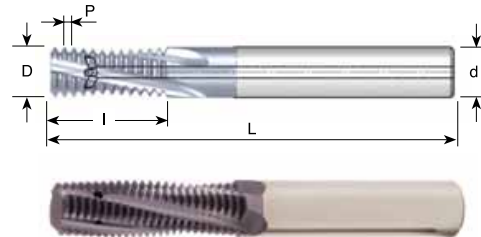
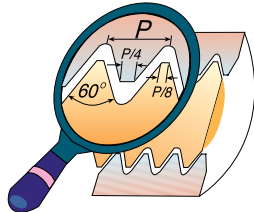
For small thread mills see pages 229-230, 235 & 246 小径螺纹铣刀见229-230, 235, 246页



Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

UN With internal coolant through the flutes **UN/内冷切削槽出水/只能用于内螺纹**
Tools for Internal Thread



每吋牙数	美制-UN/UNF/UNEF			订货号	柄径	切削直径	刃数	有效刃长	总长
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
28		1/4		MTZ0605C11 28 UN	6	5.0	3	11.3	58
28			7/16-1/2	MTZ0606C14 28 UN	6	6.0	3	14.1	58
24		5/16		MTZ08066C14 24 UN	8	6.6	3	14.3	64
24		3/8	9/16-5/8	MTZ0808D21 24 UN	8	8.0	4	20.6	64
20		7/16		MTZ0808C21 20 UN	8	8.0	3	21.0	64
20		1/2		MTZ1010D22 20 UN	10	10.0	4	22.3	73
20			3/4-1	MTZ1212E27 20 UN	12	12.0	5	27.3	84
18	5/16			MTZ06056C14 18 UN	6	5.6	3	14.8	58
18		9/16-5/8	1 1/8-1 5/8	MTZ12113D26 18 UN	12	11.3	4	26.1	84
16	3/8			MTZ08067C16 16 UN	8	6.7	3	16.7	64
16		3/4		MTZ1212D31 16 UN	12	12.0	4	31.0	84
14	7/16			MTZ08077C20 14 UN	8	7.7	3	20.9	64
14		7/8		MTZ1616E37 14 UN	16	16.0	5	37.2	101
13	1/2			MTZ10092C22 13 UN	10	9.2	3	22.5	73
12	9/16			MTZ12105C26 12 UN	12	10.5	3	26.5	84
11	5/8			MTZ12114C28 11 UN	12	11.4	3	28.9	84
10	3/4			MTZ16144D34 10 UN	16	14.4	4	34.3	101

Order example: MTZ 0808D21 24 UN MT7 订货样式: MTZ 0808D21 24 UN MT7

For small thread mills see pages 229-230, 235 & 246



小径螺纹铣刀见229-230, 235, 246页



整体硬质合金螺纹铣刀

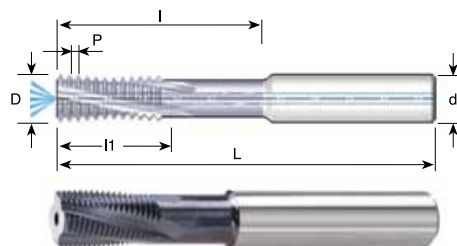
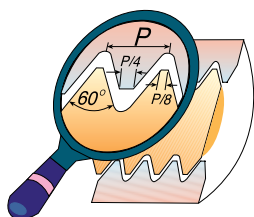
Mill - Thread Solid Carbide



UN/缩颈/大长径比/内冷前端出水/只能用于内螺纹

UN With relieved neck and internal coolant bore

Tools for Internal Thread



每吋牙数	螺纹规格	订货号	柄径	切削直径	切削刀数	刃长	有效长度	总长
Pitch TPI	Thread size	Ordering Code	d	D	No. of Flutes	I1	I	L
20	$\varnothing \geq 12$	MTQ1010D30 20 UN	10	10.0	4	17.8	30.5	73
20	$\varnothing \geq 14$	MTQ1212E35 20 UN	12	12.0	5	20.3	35.6	84
20	$\varnothing \geq 18$	MTQ1616F43 20 UN	16	16.0	6	25.4	43.2	105
18	$\varnothing \geq 15$	MTQ1212D35 18 UN	12	12.0	4	19.7	35.3	84
16	$\varnothing \geq 15$	MTQ1212D35 16 UN	12	12.0	4	20.7	35.0	84
16	$\varnothing \geq 19$	MTQ1616E42 16 UN	16	16.0	5	25.4	42.9	105
16	$\varnothing \geq 23$	MTQ2020F58 16 UN	20	20.0	6	36.5	58.8	105
14	$\varnothing \geq 20$	MTQ1616E45 14 UN	16	16.0	5	25.4	45.3	105
12	$\varnothing \geq 16$	MTQ1212D42 12 UN	12	12.0	4	25.4	42.3	84
12	$\varnothing \geq 24$	MTQ2020E55 12 UN	20	20.0	5	33.9	55.1	105

Order example: MTQ 1212D35 16 UN MT7 订货样式: MTQ 1212D35 16 UN MT7

For small thread mills see pages 229-230, 235 & 246



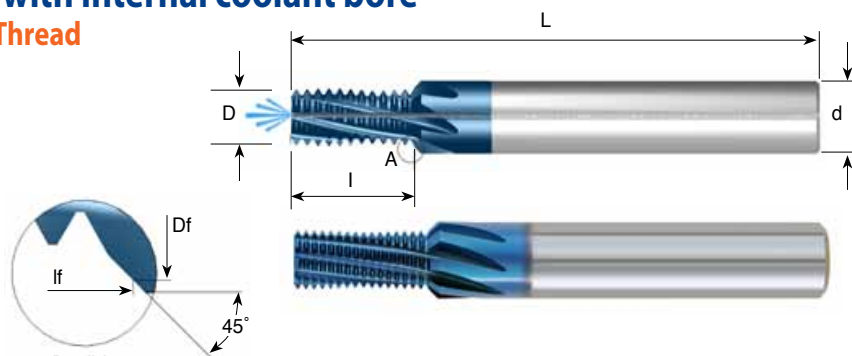
小径螺纹铣刀见229-230, 235, 246页



UN/高速螺纹铣刀/内冷前端出水/只能用于内螺纹

UN Fast MT with internal coolant bore

Tools for Internal Thread



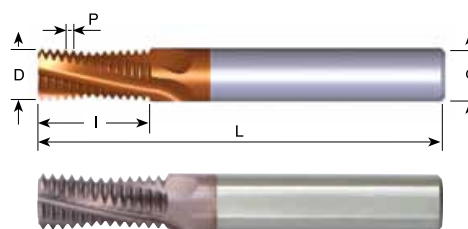
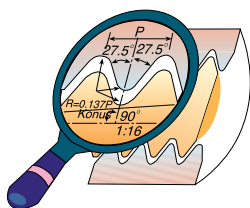
每吋牙数	美制-UN/UNF/UNEF			Detail A	订货号			柄径	切削直径	切削刃数有效长度		总长
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	Df	Flutes	I	If	L	
24		5/16, 3/8	9/16, 5/8, 11/16	FMT 10066 G14 24 UN	10	6.6	9.6	7	14.3	15.8	73	
20	1/4			* FMT 08048 E12 20 UN	8	4.8	6.8	5	12.1	13.1	64	
20		7/16, 1/2	3/4, 1	FMT 12092 H21 20 UN	12	9.2	11.4	8	21.0	22.1	84	
18	5/16	9/16, 5/8	11/16	FMT 1006 F14 18 UN	10	6.0	8.4	6	14.8	16.0	73	
16	3/8	3/4		FMT 10074 F16 16 UN	10	7.4	9.6	6	16.7	17.8	73	
14	7/16	7/8		FMT 12085 F20 14 UN	12	8.5	10.7	6	20.9	22.0	84	

Order example: FMT 08048 E12 20 UN MT8 订货样式: FMT 08048 E12 20UN MT8

* without internal coolant * 不带内冷

BSPT BSPT-英制锥管螺纹/内外螺纹通用

Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效刀长	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	RC1/16-1/8	MT0606C9 28 BSPT	6	6.0	3	9.5	58
19	RC1/4-3/8	MT0808C14 19 BSPT	8	8.0	3	14.0	64
14	RC1/2-7/8	MT1212D19 14 BSPT	12	12.0	4	19.1	84
11	RC1-2	MT1616D28 11 BSPT	16	16.0	4	28.9	105

Order example: MT 1616D28 11 BSPT MT7 订货样式: MT 1616D28 11 BSPT MT7

For thread mills with coolant through the flutes see next page 螺纹铣刀切削槽出水见下页

For conical preparation end mills see page 221 BSPT/NPT/NPTF锥管螺纹用-锥度立铣刀见221页



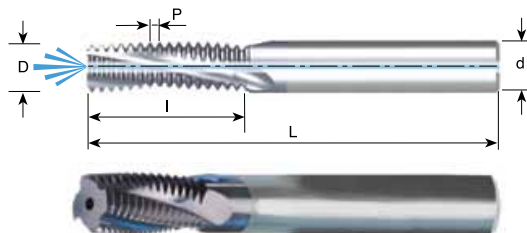
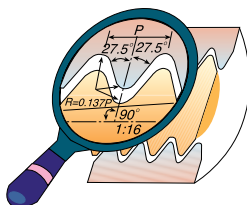
整体硬质合金螺纹铣刀

Mill - Thread Solid Carbide



BSPT-英制BSPT-锥管螺纹/内冷前端出水/内外螺纹通用

BSPT With internal coolant bore
Same Tool for Internal and External Thread

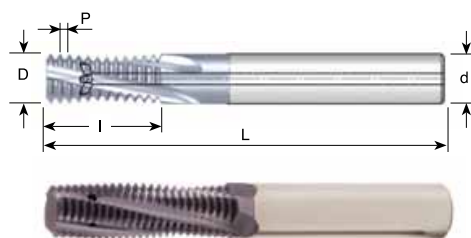
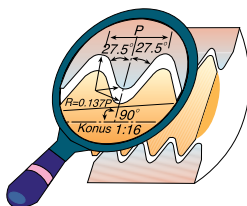


每吋牙数	标准	订货号	柄径	直径	切削刃数	有效刃长	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	RC1/8	MTB08078C14 28 BSPT	8	7.8	3	14.1	64
19	RC1/4-3/8	MTB1010D16 19 BSPT	10	10.0	4	16.7	73
14	RC1/2-7/8	MTB1616E26 14 BSPT	16	16.0	5	26.3	105
11	RC1-2	MTB1616D28 11 BSPT	16	16.0	4	28.9	105

Order example: MTB 08078C14 28 BSPT MT7 订货式样: MTB 08078C14 28 BSPT MT7

BSPT-英制锥管螺纹/内冷切削槽出水/内外螺纹通用

BSPT With internal coolant through the flutes
Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	RC1/8	MTZ08078C14 28 BSPT	8	7.8	3	14.1	64
19	RC1/4-3/8	MTZ1010D16 19 BSPT	10	10.0	4	16.7	73
14	RC1/2-7/8	MTZ1616E26 14 BSPT	16	16.0	5	26.3	101
11	RC1-2	MTZ1616D28 11 BSPT	16	16.0	4	28.9	101

Order example: MTZ 1010D16 19 BSPT MT7 订货式样: MTZ 1010D16 19 BSPT MT7

For conical preparation end mills see page 221 BSPT/NPT/NPTF锥管螺纹用锥度立铣刀见221页

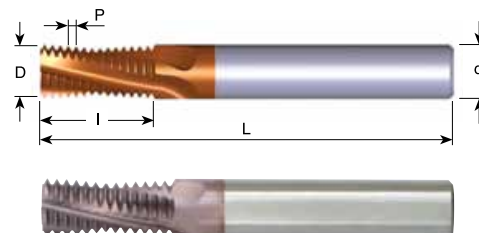
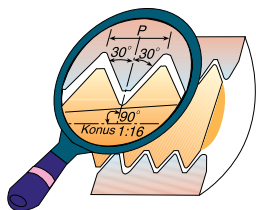


Mill - Thread Solid Carbide

整体硬质合金螺纹铣刀

NPT NPT-锥管螺纹/内外螺纹通用/无内冷

Same Tool for Internal and External Thread

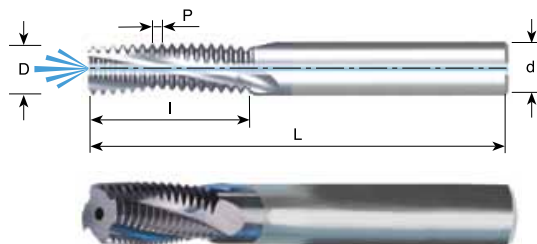


每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/16-1/8	MT0606C9 27 NPT	6	6.0	3	9.9	58
18	1/4-3/8	MT0808C14 18 NPT	8	8.0	3	14.8	64
14	1/2-3/4	MT1212D20 14 NPT	12	12.0	4	20.9	84
11.5	1-2	MT1616D27 11.5 NPT	16	16.0	4	27.6	105
8	≥2 1/2	MT2020D39 8 NPT	20	20.0	4	39.7	105

Order example: MT 0808C14 18 NPT MT7 订货样式: MT 0808C14 18 NPT MT7

NPT With internal coolant NPT-锥管螺纹内冷前端出水/内外螺纹通用

Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTB08076C10 27 NPT	8	7.6	3	10.8	64
18	1/4-3/8	MTB1010D16 18 NPT	10	10.0	4	16.2	73
14	1/2-3/4	MTB16155D22 14 NPT	16	15.5	4	22.7	105
11.5	1-2	MTB2020D29 11.5 NPT	20	20.0	4	29.8	105
8	≥2 1/2	MTB2020D39 8 NPT	20	20.0	4	39.7	105

Order example: MTB 1010D16 18 NPT MT7 订货样式: MTB 1010D16 18 NPT MT7

For thread mills with coolant through the flutes see next page 切削槽内出水内冷螺纹铣刀见下页

For conical preparation end mills see page 221 BSPT/NPT/NPTF用锥度立铣刀见221页



整体硬质合金螺纹铣刀

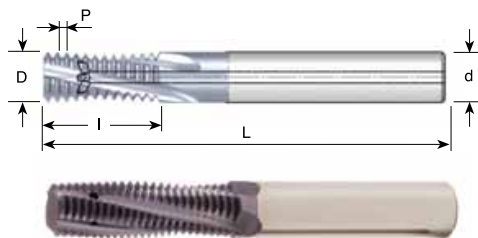
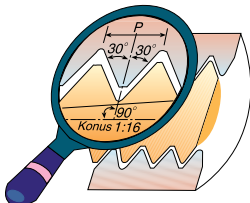
Mill - Thread Solid Carbide



NPT-锥管螺纹/切削槽内出水内冷/内外螺纹通用

NPT With internal coolant through the flutes

Same Tool for Internal and External Thread

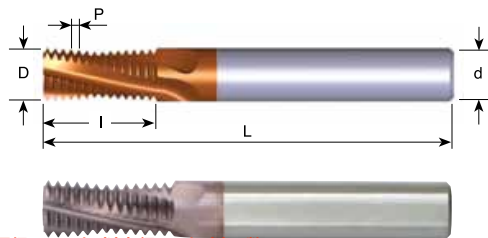
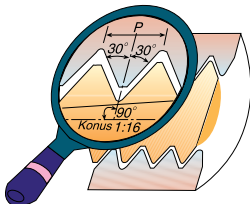


每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTZ08076C10 27NPT	8	7.6	3	10.8	64
18	1/4-3/8	MTZ1010D16 18NPT	10	10.0	4	16.2	73
14	1/2-3/4	MTZ16155D22 14NPT	16	15.5	4	22.7	101

Order example: MTZ 08076C10 27 NPT MT7 订货样式: MTZ 08076C10 27 NPT MT7

NPTF NPTF-干密封锥管螺纹/内外螺纹通用

Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/16-1/8	MT0606C9 27 NPTF	6	6.0	3	9.9	58
18	1/4-3/8	MT0808C14 18 NPTF	8	8.0	3	14.8	64
14	1/2-3/4	MT1212D20 14 NPTF	12	12.0	4	20.9	84
11.5	1-2	MT1616D27 11.5 NPTF	16	16.0	4	27.6	105
8	≥ 1/2	MT2020D39 8 NPTF	20	20.0	4	39.7	105

Order example: MT 1212D20 14 NPTF MT7 订货样式: MT 1212D20 14 NPTF MT7

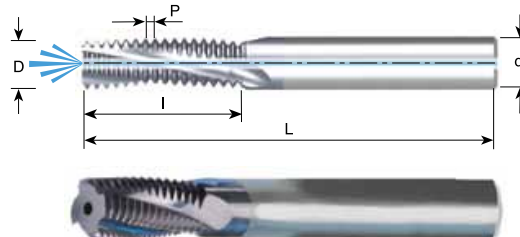
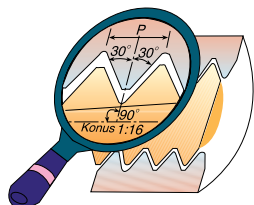
For thread mills with coolant bore see next page 前端出水螺纹铣刀见下页

For conical preparation end mills see page 221 BSPT/NPT/NPTF锥管螺纹用锥度立铣刀见221页



NPTF-干密封锥管螺纹/内冷前端出水/内外螺纹通用

NPTF With internal coolant bore
Same Tool for Internal and External Thread

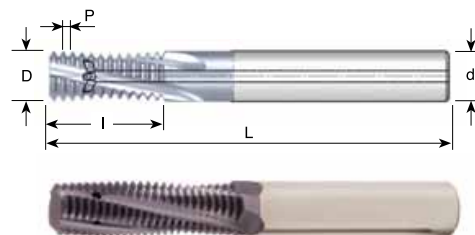
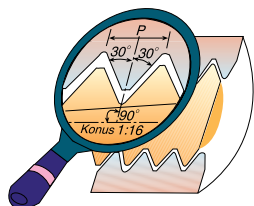


每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTB08076C10 27 NPTF	8	7.6	3	10.8	64
18	1/4-3/8	MTB1010D16 18 NPTF	10	10.0	4	16.2	73
14	1/2-3/4	MTB16155D22 14 NPTF	16	15.5	4	22.7	105
11.5	1-2	MTB2022D29 11.5 NPTF	20	20.0	4	29.8	105
8	≥ 2 1/2	MTB2020D39 8 NPTF	20	20.0	4	39.7	105

Order example: MTB 16155D22 14 NPTF MT7 订货样式: MTB 16155D22 14 NPTF MT7

NPTF-干密封锥管螺纹/内冷切削槽出水/内外螺纹通用

NPTF With internal coolant through the flutes
Same Tool for Internal and External Thread



每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTZ08076C10 27 NPTF	8	7.6	3	10.8	64
18	1/4-3/8	MTZ1010D16 18 NPTF	10	10.0	4	16.2	73
14	1/2-3/4	MTZ16155D22 14 NPTF	16	15.5	4	22.7	101

Order example: MTZ 1010D16 18 NPTF MT7 订货样式: MTZ 1010D16 18 NPTF MT7

For conical preparation end mills see page 221 **BSPT/NPT/NPTF**锥管螺纹用立铣刀见221页



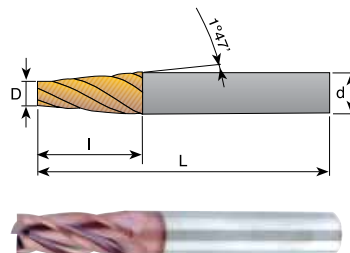
Solid Carbide Tapered End Mills 整体硬质合金锥度立铣刀

Solid carbide tapered end mills are used for milling preparation of conical threads before the thread milling operation. 硬质合金锥度立铣刀用于锥管螺纹铣削前的锥度孔的加工

优点:

Advantages:

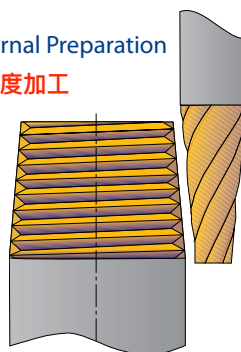
- * 增加螺纹铣刀和可转位螺纹铣刀片的寿命
- * Increases the tool life of mill thread cutters and indexable inserts.
- * Equal and uniform load along the cutting edge of the mill thread cutter. * 与锥管螺纹锥度一致的切削刃
- * Shorter machining time during the mill thread operation, due to the tapered preparation. * 为锥管螺纹预先铣削锥度，短的加工时间
- * Same tool for internal and external preparation.
- * 相同的立铣刀可用于内、外锥度加工



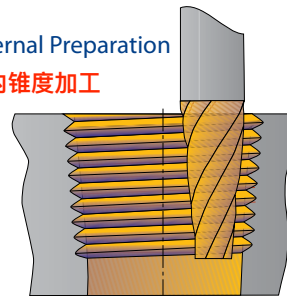
订货号 Ordering Code	柄径 d	切削直径 D	有效长度 l	总长 L	切削刃数 No. of Flutes	相配螺纹规格 Size
SC0652D12	6	5.2	12	58	4	NPT 1/16" - 1/8" NPTF 1/16" - 1/8" BSPT 1/16" - 1/8"
SC1085D24	10	8.5	24	73	4	NPT 1/8" - 1" NPTF 1/8" - 1" BSPT 1/8" - 1"
SC1210D32	12	10	32	84	4	NPT 1/4" - 3" NPTF 1/4" - 3" BSPT 1/4" - 3"

Order example: SC 1085D24 MT7 订货式样: SC 1085D24 MT7
Carbide grade: MT7 硬质合金材质: MT7

External Preparation
外锥度加工

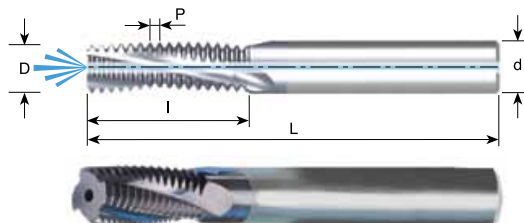
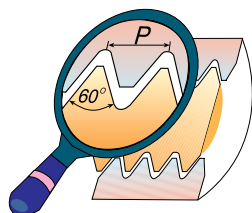


Internal Preparation
内锥度加工





NPS With internal coolant bore NPS-内冷前端出水/内外螺纹通用
Same Tool for Internal and External Thread - Inch Shank



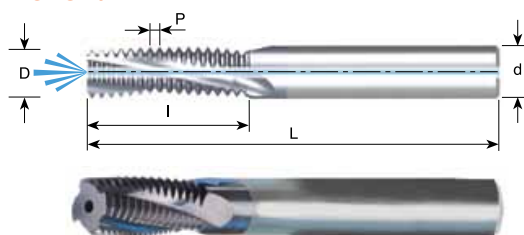
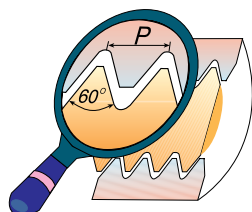
每吋牙数	标准	订货号	柄径	切削直径	切削刃数	有效刃长	总长
Pitch TPI	Standard	Ordering Code	d inch	D	No. of Flutes	I	L
27	1/8	MTB0312C04 27 NPS	5/16	7.6	3	10.8	63
18	1/4-3/8	MTB0375D06 18 NPS	3/8	9.5	4	16.2	76
14	1/2-3/4	MTB0625D08 14 NPS	5/8	15.5	4	22.7	101
11.5	1-2	MTB0750D11 11.5 NPS	3/4	19.0	4	29.8	101

Order example: MTB 0375D06 18 NPS MT7 订货样式: MTB 0375D06 18 NPS MT7

NPSF-美国干密封圆柱螺纹/内冷前端出水/内外螺纹通用

NPSF With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank



每吋牙数	标准	订货号	英吋柄径	切削直径	切削刃数	有效长度	总长
Pitch TPI	Standard	Ordering Code	d inch	D	No. of Flutes	I	L
27	1/8	MTB0312C04 27 NPSF	5/16	7.6	3	10.8	63
18	1/4-3/8	MTB0375D06 18 NPSF	3/8	9.5	4	16.2	76
14	1/2-3/4	MTB0625D08 14 NPSF	5/8	15.5	4	22.7	101
11.5	1-2	MTB0750D11 11.5 NPSF	3/4	19.0	4	29.8	101

Order example: MTB 0312C04 27 NPSF MT7 订货样式: MTB 0312C04 27 NPSF MT7



整体硬质合金螺纹铣刀

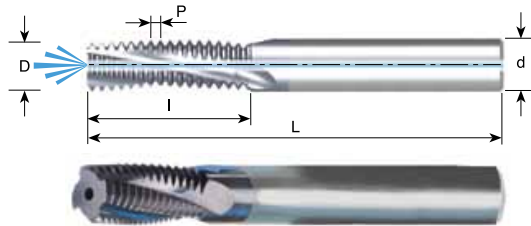
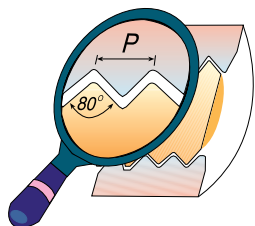
Mill - Thread Solid Carbide



PG-电力管线螺纹/DIN 40430/内冷前端出水/内外螺纹通用

PG DIN 40430 - With internal coolant bore

Same Tool for Internal and External Thread



牙数 Pitch TPI	标准 Standard	订货号 Ordering Code	柄径 d	切削直径 D	切削刃数 No. of Flutes	有效刃长 I	总长 L
20	Pg 7	MTB1010D19 20 PG	10	10.0	4	19.7	73
18	Pg 9, 11, 13.5, 16	MTB1212D20 18 PG	12	12.0	4	20.5	84
16	Pg 21, 29, 36, 42, 48	MTB1212D23 16 PG	12	12.0	4	23.0	84

Order example: MTB 1212 D20 18 PG MT7 订货样式: MTB 1212 D20 18 PG MT7

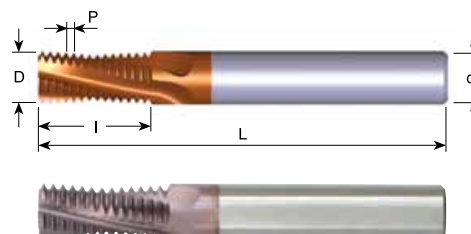
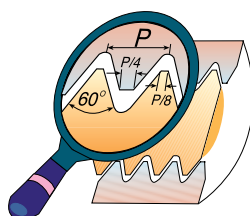


Mill - Thread Solid Carbide 整体硬质合金外螺纹铣刀 for External Threads

Advantages:

- * Excellent surface finish thanks to the spiral flutes * 由于螺旋切削槽特别好的表面光洁度
- * Short machining time due to multi 3 to 5 flutes * 多到3-5槽，短的加工时间

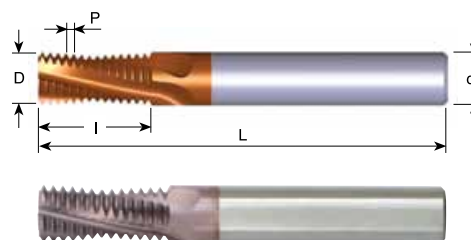
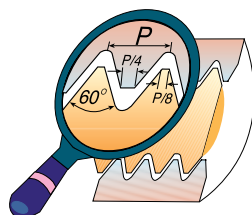
ISO ISO 只能用于外螺纹-无内冷



螺距	订货号	柄径	切削直径	切削刀数	有效长度	总长
Pitch mm	Ordering Code	d	D	No. of Flutes	I	L
1.0	EMT1010D16 1.0 ISO	10	10.0	4	16.5	73
1.0	EMT1212E20 1.0 ISO	12	12.0	5	20.5	84
1.25	EMT1010D16 1.25 ISO	10	10.0	4	16.9	73
1.5	EMT1010D15 1.5 ISO	10	10.0	4	15.8	73
1.5	EMT1212D20 1.5 ISO	12	12.0	4	20.3	84
1.75	EMT1212D20 1.75 ISO	12	12.0	4	20.1	84
2.0	EMT1010C17 2.0 ISO	10	10.0	3	17.0	73
2.0	EMT1212D21 2.0 ISO	12	12.0	4	21.0	84

Order example: EMT 1010D15 1.5 ISO MT7 订货样式: EMT 1010D15 1.5 ISO MT7

UN UN外螺纹-无内冷



每吋牙数	订货号	柄径	切削直径	切削刀数	有效长度	总长
Pitch TPI	Ordering Code	d	D	No. of Flutes	I	L
24	EMT1010D16 24 UN	10	10.0	4	16.4	73
20	EMT1212E21 20 UN	12	12.0	5	21.0	84
18	EMT1212D20 18 UN	12	12.0	4	20.5	84
16	EMT1212D21 16 UN	12	12.0	4	21.4	84
14	EMT1212D20 14 UN	12	12.0	4	20.9	84
12	EMT1212D20 12 UN	12	12.0	4	20.1	84

Order example: EMT 1212D20 18 UN MT7 订货样式: EMT 1212D20 18 UN MT7



Mill-Thread Solid Carbide Grades, Speed and Feed Selection 整体硬质合金螺纹铣刀切削速度和进给选择

MT, MTB, MTZ, EMT Types MT/MTB/MTZ/EMT型

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: 亚微颗粒级钛氮化氮 (TiAlN) 复合涂层 (ISO K10-K20) 通用于所有材料; 中到高的切削速度。**

ISO 标准	Materials 材料	Cutting Speed m/min 切削速度	Feed mm/tooth 每齿进给 Cutting Diameter=D 切削直径										
			Ø2	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
P	Low and Medium Carbon 低和中碳钢 Steels <0.55%C 钢	100-250	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
	High Carbon Steels ≥0.55%C 高碳钢	110-180	0.02	0.03	0.03	0.05	0.06	0.07	0.08	0.09	0.10	0.12	0.15
	Alloy Steels, Treated Steels 合金钢/热处理钢	90- 60	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
M	Stainless Steels - Free Cutting 易切不锈钢	60-160	0.02	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.11
	Stainless Steels - Austenitic 奥氏体不锈钢	60-120	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
	Cast Steels 铸造不锈钢	130-170	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
K	Cast Iron	70-150	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
N	Aluminum ≤12%Si, Copper 硅含量12%以下铝合金/铜	150-350	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
	Aluminum >12% Si 硅含量大于12%铝合金	100-250	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
	Synthetics, Duroplastics, Thermoplastics	100-400	0.05	0.06	0.07	0.08	0.10	0.11	0.12	0.13	0.15	0.18	0.22
S	合成材料/硬塑料/热塑料 Nickel Alloys, Titanium Alloys 镍合金/钛合金	20- 80	0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04	0.04	0.04	0.05

For cutters with long cutting length reduce feed rate by 40% 切削深度大时减少进给率40%



MTQ type MTQ型

Thread mills with relieved neck and internal coolant for milling medium and large threads on relatively deep work pieces. 缩颈螺纹铣刀；内冷，在相对比较深的工件上铣削中到大螺纹。

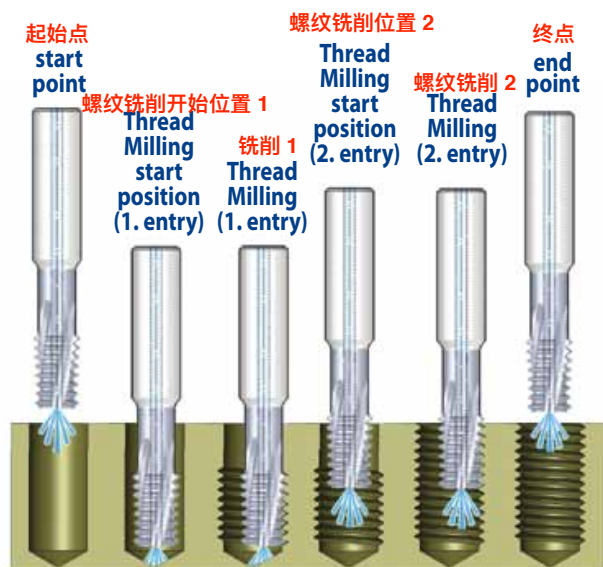
Carbide grade: MT7 硬质合金材质：MT7

Advantages 优点

- To produce medium and large threads on relatively deep work pieces. 在相对比较深的工件上铣削中到大的螺纹
- To use overhang according to the application. 悬伸根据用途
- To perform deep threads at the bottom of the application. 加工深孔螺纹自底部开始
- Provides high rigidity and stability (anti-vibration). 高刚性和稳定性 (抗振)
- Accomplishes deep threads in one pass. 一次完成深孔螺纹加工
- Relatively low cutting forces due to short cutting length. 切削刀短，比较低的切削力
- Threads length up to 3D. 3倍径螺纹深度

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 每齿进给 Cutting Diameter=D 切削直径					
			Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
P	Low and Medium Carbon Steels < 0.55%C 低和中碳钢	100 - 250	0.06	0.07	0.07	0.08	0.10	0.12
	High Carbon Steels ≥ 0.55%C 高碳钢	110 - 180	0.05	0.05	0.06	0.07	0.09	0.10
	Alloy Steels, Treated Steels 合金钢/热处理钢	90 - 160	0.03	0.04	0.04	0.05	0.06	0.07
M	Stainless Steels - Free Cutting 易切不锈钢	60 - 160	0.04	0.04	0.05	0.06	0.06	0.08
	Stainless Steels - Austenitic 奥氏体不锈钢	60 - 120	0.04	0.04	0.04	0.05	0.06	0.07
	Cast Steels 铸造不锈钢	130 - 170	0.03	0.04	0.04	0.05	0.06	0.07
K	Cast Iron 铸铁	70 - 150	0.06	0.07	0.07	0.08	0.10	0.12
N	Aluminum ≤ 12%Si, Copper 硅含量小于等于12%铝合金/铜	150 - 350	0.06	0.07	0.07	0.08	0.10	0.12
	Aluminum > 12% Si 硅含量大于12%铝合金	100 - 250	0.03	0.04	0.04	0.05	0.06	0.07
	Synthetics, Duroplastics, Thermoplastics 合成材料/硬塑料/热塑料	100 - 400	0.08	0.09	0.10	0.11	0.13	0.15
S	Nickel Alloys, Titanium Alloys 镍合金/钛合金	20 - 80	0.02	0.02	0.02	0.03	0.03	0.03



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