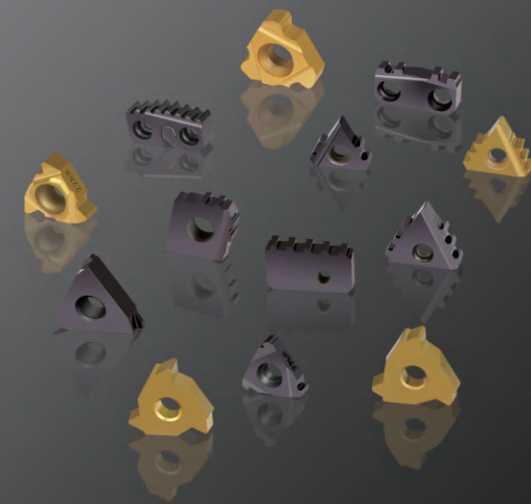




求实创新，追求卓越
PRAGMATIC INNOVATION
THE PURSUIT OF EXCELLENCE

品质源于
1956



硬质合金 石油管螺纹刀具

Carbide Threading Tools for oil pipe



地 址/Add: 四川省成都市新都工业大道东段601号
No.601, Eastern Sec Industrial Rd, Xindu Dist, Sichuan, China

公司电话/Tel:
028-83243828

销售电话: 028-83242134

华东片区 (江苏、上海、浙江、福建):
028-83258061 021-33703787

华北片区 (山东、河北、河南、):
028-83249579

华中片区 (安徽、湖北、湖南、江西、广东、广西):
028-83243290 028-83257552

西部片区 (重庆、四川、贵州、云南、甘肃、陕西、青海、宁夏、西藏、新疆):
028-83246516 028-83242077

北方片区 (黑龙江、吉林、辽宁、天津、北京、山西、内蒙古):
028-83246702

外贸及相关业务/Tel: 028-83271096 028-83246491

传真/Fax: 028-83242075

网址/Web: www.ctri.com.cn



成都工具研究所有限公司
CHENGDU TOOL RESEARCH INSTITUTE CO.,LTD



COMPANY PROFILE

公司简介

成都工具研究所有限公司于1999年成为中国机械工业集团有限公司全资子公司，集团2017年世界500强排名334位。我公司前身是成都工具研究所，创建于1956年，是原国家机械工业部直属的我国机械工业唯一的综合性工具科研开发机构，主要从事精密切削刀具，精密测量仪器和表面改性技术三大类机械产品共性技术研究及其高新技术产品的开发与生产，并担负着全国工具行业发展规划、产品标准、产品质量监督检测等行业技术工作，出版有中文核心技术物《工具技术》。

成都工具研究所有限公司是我国工具行业唯一的综合性科技型企业，是国家刀具、量具、量仪产品质量监督检测中心以及中国机械工业金属切削刀具技术协会、中国机床工具工业协会工具分会和中国仪器仪表学会机械测试仪器分会等十多个行来、社会组织的归口挂靠单位。

精益求精
促进机械加工技术进步

Chengdu Tool Research Institute Co.,Ltd(CTRI),was accepted into China National Machinery Industry Corporation (SINOMACH) in1999.SINOMACH ranked 334 th on World Top 500 List in 2017 .CTRI,founded in 1956 formerly under the direction of China's Machinery Ministry,is the sole comprehensive tool researching and scientific developing institution in China's machinery industry.CTRI is principally engaged in researching,developing,manufacturing and selling tools,measuring instruments and surface modified technique and equipment.Also,CTRI is the bellwether in China's tool industry development,products standards,and products quality control etc.And CTRI publishes Chinese Core Periodicals Tool Engineering.

These following organizations are subordinate to CTRI:National Center of Supervision and Inspection on Cutting Tool Products Quality China Metal Cutting Tool Engineering Association (CMCTEA)Tool Session of China Machine Tool&Tool Builder's Association State Tool Quality Supervision&Inspection Center Branch of China Instrument Society for Mechanical Measuring Instruments.

品质源于

1956

行业地位

Industry Status

成都工具研究所是我国工具行业科研、技术的领头羊、行业归口所，以下组织挂靠在我所：
Chengdu Tool Research Institute is a leading scientific research and technology center in China tool industry. It also works as a supporting institute for the following organizations:

- 中国机械工业金属切削刀具技术协会
China metal cutting tool Engineering Association
- 中国机床工具工业协会工具分会
China Machine Tool & Tool Builder's Association Tools Branch
- 中国仪器仪表学会机械量测试仪器学会
China Instrument and Control Society
- 国家刀具质量监督监测中心
National Tool Quality Supervision and Monitoring Center
- 机械工业量具量仪产品质量监督检测中心
Mechanical industrial measuring instrument products Quality Supervision Testing Center
- 国家进出口商品检验局刀具认可实验室
China Import and Export Commodity Inspection Bureau tool accredited laboratory
- 国家进出口商品检验局量具量仪认可实验室
China Import and Export Commodity Inspection Bureau measuring instrument for Laboratory Accreditation
- 科技成果检测鉴定国家级检验机构（刀具）
Scientific and technological achievements identification of national inspection agency (tool)
- 科技成果检测鉴定部级检验机构（量具量仪）
Science and technology achievements inspection level inspection

- agency (measuring)
全国刀具标准化技术委员会秘书处
The tool Standardization Technical Committee Secretariat
- 全国量具量仪标准化技术委员会秘书处
The measuring tool and instrument Standardization Technical Committee Secretariat
- ISO/TC 29（工具）P成员国内归口单位
ISO/TC 29 (tool) P members internally controlled unit
- ISO/TC213（产品的几何和几何技术规范及检验）P成员国内归口单位
ISO/TC213 (geometry and geometry specification and inspection of products) P members internally controlled unit
- CNACL 国家认可实验室
CNACL National Laboratory Accreditation
- 《工具技术》杂志社
Tool Engineering
- 国家精密工具生产力促进中心
National Precision Tool Productivity Promotion Center
- 中国机械工业金属切削刀具技术协会
China metal cutting tool Engineering Association
- 中国机械工程学会生产工程分会切削专业委员会
China Institute of mechanical engineering, production engineering branch, cutting Committee
- 四川省机械工程学学会机加工专业委员会
Sichuan Mechanical Engineering Society Machine processing professional committee

科研成果

Scientific Achievements

自成都工具研究所成立以来，主要取得以下科研成果：
Followings are main scientific achievements since the foundation of CIRT：

- 一、国家发明奖三项：
three National Invention Awards
- 齿轮整体误差测量新技术 发明二等奖
The second prize in new technology of integrated error measuring gear Invention
- 单晶金刚石钎焊工艺及焊料 发明二等奖
The second prize in mono-crystalline diamond brazing technology and solder Invention
- 无锡易磨高性能高速钢 发明三等奖
The third prize in Wuxi easy grinding high speed steel

- 二、国家科技进步奖八项
Eight "the national science and technology progress awards"
- 量具刀具产品标准的制定和贯彻 二等奖
The second prize in The formulation and implementation of measuring tool products standard
- 中模数硬质合金齿轮滚刀 三等奖
The third prize in the module of carbide gear hob
- 立方氮化硼聚晶机理及其应用 三等奖
The third prize in PCBN mechanism and application
- 涂层硬质合金刀片成套技术及装备研究 三等奖
The third prize in researching coated carbide inserts integrated technology and equipment
- QPQ盐浴复合处理技术及成套设备 二等奖

- The second prize in composite treatment technology for QPQ salt bath and complete sets of equipment
- 机电一体化发展预测与综合分析（合作项目） 三等奖
The third prize in Electromechanical integration development prediction and comprehensive analysis (cooperated projects)
- 材料动态断裂性能研究及其在典型机械零部件上的应用（合作项目） 三等奖
Research on dynamic fracture properties of materials and its application in the typical mechanical parts on the (cooperated project) the Third prize
- 机械工业共性数据库（合作项目） 二等奖
The second prize in Machinery industry common database (cooperated projects)

- 三、省部科技进步奖
The Provincial Department of science and Technology Progress Award
- 121项（略）
121 items (omission)



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1956

人力资源

Human Resources

全所共有职工400余人，其中科技人员320人，有突出贡献的国家级专家3人，享受国家政府津贴26人，省部级专家15人，研究员级高级工程师27人，高级工程师103人，高级会计师、高级经济师10人、中级技术人员140人，硕士研究生14人，大中专生146人，专业涉及机械、金属材料、电子、计算机、机电一体化等专业。

CTRI presently has almost 400 employees, 320 of whom are technical staff, 3 state-level experts with outstanding contribution, 26 recipients of government special allowance, 15 ministerial level experts, 27 professor level senior engineers, 103 senior engineers, 10 senior accountants and senior economists, 140 intermediate technical staff, 14 with master degree, 146 with college diploma and employees are widely involved in machinery, metal materials, electronic, computer, electromechanical integration specialty.

核心竞争力

Competitive Advantages

目前成都工具研究所已在刀具材料、精密复杂成形刀具与数控刀具设计及加工技术、刀具表面强化改性技术与装备、大型精密量仪设计制造、激光测量及光电传感器技术以及计算机软件等技术领域，形成了独特的整体、核心成套技术优势，初步构成了以硬质合金石油管螺纹梳刀、硬质合金精密异形刀具、超硬刀具、刀具表面强化技术及装备、齿轮测量仪、激光测量仪等六项主导产品，包含30多项核心、高新技术产品的产品技术结构，这些产品和技术大都处于国内领先或国际先进水平。

Chengdu Tool Research Institute has formed a completed and unique technical competitive advantages in tool material, precise and complex shaped cutter and NC tool design and processing technology, cutting tool surface modification and strengthening technology and equipment, large-scale design precision instrument manufacturing, laser and photoelectric sensor technology and computer software technology. It initially formed six leading products including carbide tredding tools for oil pipe, carbide precision special-shaped inserts, super hard cutting tools, tool surface strengthening technology and equipment, gear measuring instrument, laser measuring instrument. Those products are supported by more than 30 core, high-tech products technology structure and most of these products and technology are leading technologies in the domestic and international advanced level.



质量控制

Quality Control

质量认证:

ISO9001:2008

Quality Certification:

ISO9001:2008

质量方针:

以技术创新为先导，以质量管理为保证，以持续改进为核心，以顾客满意为目标。

Quality policy:

To make technical innovation as the guide, the quality of management as the guarantee, continuous improvement as the core and take customer satisfaction as the goal.

质量目标:

★贯彻ISO9001：2008标准，通过ISO9001：2008质量管理体系认证，并保持体系有效运行。

★技术不断创新，每年设计开发新产品或新项目2项以上。

★以质量管理为保证，加强过程控制，实施持续改进，产品质量精益求精，确保产品出厂合格率达100%。三年内使主导产品合格率提高到95%以上，成品交检批次合格率达到95%。

★以顾客为关注焦点，增进顾客满意，三年内使顾客满意率达98%以上，顾客投诉解决率达到100%。

★顾客重大投诉为零，重大质量事故为零，重大设备安全事故为零。

The quality objectives:

★in carrying out the standard of ISO9001:2008, through the ISO9001:2008 quality management system certification, and keep

the system running effectively.

★technology innovation, design and develop more than 2 new products or new projects each year

★to guarantee the quality management, strengthen the process control, carry out continuous improvement, refine on product quality, to ensure 100% products manufactured pass rate. Increase leading products pass rate to 95% in three years and the finished product inspection pass rate to 95%.

★customer focus, improve customer satisfaction, three years to make customer satisfaction rate reaches above 98%, to solve customer complaint rate reached 100%.

★customer major complaints to zero, a major quality accidents to zero, zero accident of major equipment.



服务管理

Service management

服务宗旨：

全心全意为用户服务

服务承诺：

尽可能满足用户的合理需求

服务标准：

快速、及时、有效，向用户提供一流产品和一流服务

Service Aim : put one's heart and soul into service for the user

Service Commitment: to meet the reasonable needs of users as far as possible

Service standards: rapid, timely, effective, provide first-class products and first-class service to users

企业合作

Business cooperation

- 与联合国合作建立中国量仪基地
- 与德国Klingelnberg公司合作，锥齿轮测量技术出口德国
- 广范与国外公司进行技术交流与合作
- 与国内大专院校、大型企业进行广范的技术交流与合作
- 与英国普法永道咨询公司合作，全面提升企业形象和管理能力

- cooperation with the United Nations to establish Chinese instrument base
- cooperation with Klingelnberg (Germany), bevel gear measurement technology exported to Germany
- technological exchanges and cooperation with foreign companies
- A wide range of cooperation and technological exchanges with colleges, universities and large domestic enterprises
- cooperation with British consulting company to improve corporate image and management ability

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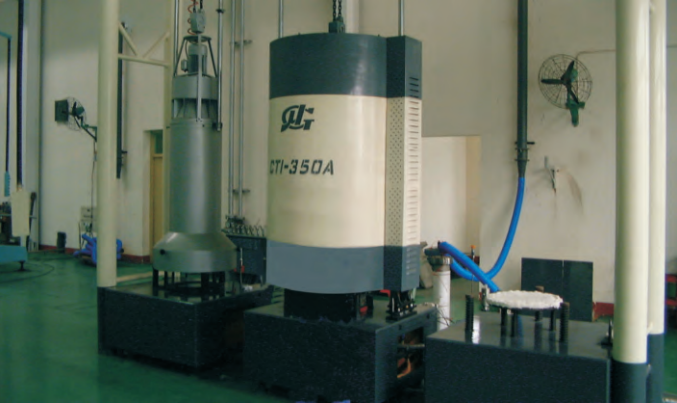
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硬质合金牌号性能及用途

Grade and application of carbide

牌号 Grade	金相 Metallographic	使用性能及用途介绍 Performance and application
GY0124		该牌号采用高强度基体、红硬性好，搭配PVD耐磨涂层，适用于高效车丝机加工低、中钢级和次高钢级（如J55, K55, N80, L80等）油管、套管螺纹及接箍螺纹。 Using good red-hardness and toughness body, working with PVD coating suite for tubing, casing and coupling threading cutting on low to middle and secondary high grade steel (like J55,K55,N80,L80 etc.) on the high-effective threading machine.
GY0326		该牌号采用高强度基体、红硬性好，有较好的抗冲击性能，同时搭配厚膜PVD涂层，增加刀具的耐磨性。适用于高效车丝机加工中、高钢级（如N80, P110等）油管、套管螺纹及接箍螺纹。 Using good red-hardness, toughness and excellent impact resistance body, enhance abrasive resistance after PVD coating. Suit for tubing, casing and coupling threading cutting on middle to high grade steel (like N80,P110 etc.) on the high-effective threading machine.
GY0127		该牌号采用强度高、红硬性好的基体，同时搭配抗粘性涂层。适用于中低速油管、套管螺纹加工，以及加工石油钻杆、石油钻铤、抽油杆等系列螺纹。 Using good red-hardness and toughness body, Working with anti-adhesive coating. Suit for middle-low speed cutting thread on tubing, casing, drill rod, drill collar and sucker rod.
GY0328		该牌号采用具有高强度的基体、红硬性好，抗冲击性能优异，同时搭配优异的抗高温耐磨性PVD涂层，增加了刀具的抗粘和耐磨。适用于加工特殊材料（如镍基，抗硫，抗挤毁，含Cr等）油管、套管螺纹及接箍螺纹，以及该系列螺纹的高速切削。 Using good red-hardness and toughnesbody, excellent impact resistance. Working with high temperature resistance and wearable coating, to improve tool's anti-adhesive and abrasive resistance. Suit for hard-working material(like: nickel base, sulfur resistance, collapse resistance and containing chromium) tubing, casing and coupling threading cutting, also suit for their high speed cutting condition.
GY17		该牌号具有较好的耐磨性和韧性，适用于螺纹梳刀的专用断屑器及其它刀片同时可根据不同的用途，进行表面涂层和非涂层处理。 For its good red-hardness and toughness, this grade is suitable for chipbreaker and other type insert, coating or un-coating.



硬质合金石油管螺纹刀片标注说明

The code introduction of carbide threading inserts for oil pipe

例：

Example:

B	5B	W	2	----	2	III
↑	↑	↑	↑		↑	↑
①	②	③	④		⑤	⑥

说明：

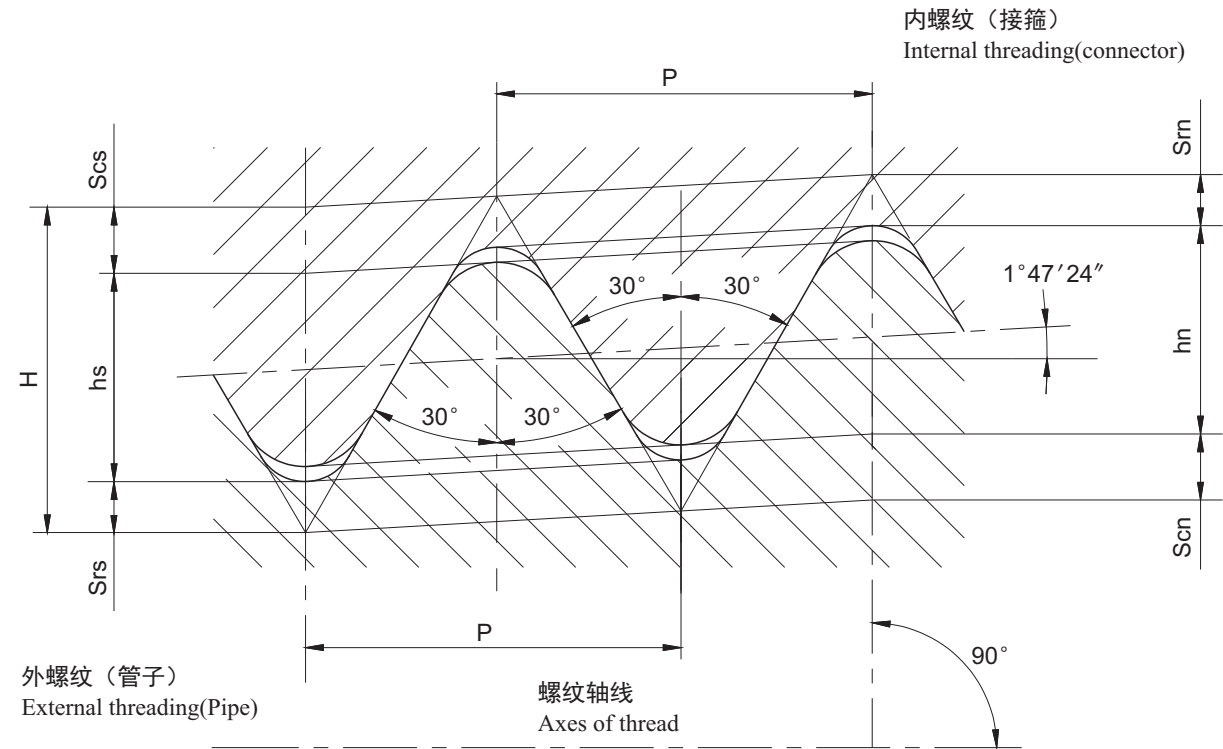
Introduction:

- ①—表示螺纹刀片使用车丝机床或使用厂商
Stands for the threading machine or company name.
"SK" 表示一般数控车丝机的刀片。"BP" "BC" 表示特定数控车丝机的刀片。非数控车丝机用的刀片可不标注。
"SK" stands for the insert used for the NC threading machine. "BP""BC" stands for the insert used for the specific NC threading machine. If not used for the NC threading machine, do not show any code.
- ②—表示螺纹的螺距或螺纹类型加工
Stands for the code of thread types or thread pitch
8—表示螺距P=1/8"(=3.175mm)锥度1:16的石油油管、套管V型圆螺纹。
8P=1/8 "(=3.175mm) V type round thread of tubing and casing(taper1:16).
10—表示螺距P=1/10"(=2.540mm)锥度1:16的石油油管V型圆螺纹。
10 P=1/10 "(=2.540mm) V type round thread of tubing (taper1:16).
5B—表示螺距P=1/5"(=5.080mm)锥度1:16的石油套管偏梯型螺纹。
5B P=1/5"(=5.080mm) buttress thread of casing(taper1:16).
5B+D—表示螺距P=1/5"(=5.080mm)锥度1:12的石油套管偏梯型螺纹。
5B+D P=1/5"(=5.080mm) buttress thread of casing(taper1:12).
4Y1—表示螺距P=1/4"(=6.350mm)的V-0.038R锥度1:6的石油钻杆接头螺纹。
4Y1 P=1/4"(=6.350mm) V-0.038R thread of oil drillrod connector(taper1:6)
4Y2—表示螺距P=1/4"(=6.350mm)的V-0.038R锥度1:4的石油钻杆接头螺纹。
4Y2 P=1/4"(=6.350mm) V-0.038R thread of oil drillrod connector(taper1:4).
5Y3—表示螺距P=1 / 5" (=5.080mm)的V-0.040锥度1:4的石油钻杆接头螺纹。
5Y3 P=1/5"(=5.080mm) V-0.040 thread of oil drillrod connector(taper1:4).
4Y4—表示螺距P=1 / 4" (=6.350mm)的V-0.050锥度1:4的石油钻杆接头螺纹。
4Y4 P=1/4"(=6.350mm) V-0.050 thread of oil drillrod connector(taper1:4).
4Y5—表示螺距P=1 / 4" (=6.350mm)的V-0.050锥度1:6的石油钻杆接头螺纹。
4Y5 P=1/4"(=6.350mm) V-0.050 thread of oil drillrod connector(taper1:6).
6Y6—表示螺距P=1 / 6" (=4.233mm)的V-O.055锥度1:8的石油钻杆接头螺纹。
6Y6 P=1/6"(=4.233mm) V-0.050 thread of oil drillrod connector(taper1:8).
4Y7—表示螺距P=1 / 4" (=6.350mm)的V--O.065锥度1:6的石油钻杆接头螺纹。
4Y7 P=1/4"(=6.350mm) V-0.065 thread of oil drillrod connector(taper1:6).
4PAC—表示螺距P=1 / 4" (=6.350mm)耐的V-0.076锥度1:8的石油钻杆接头螺纹。
4PAC P=1/4"(=6.350mm) V-0.076 thread of oil drillrod connector(taper1:8).
30H9—表示螺距P=1 / 3" (=8.467mm)的V-0.084锥度5:48的石油钻杆接头螺纹。
30H9 P=1/3"(=8.467mm) V-0.084 thread of oil drillrod connector(taper5:48).
- ③—用字母“W”表示加工外螺纹，字母“N”表示加工内螺纹。
W— external thread N—internal thread.
- ④—用数字1、2、3、4分别表示刀片切削刃面数。
The character 1.2.3.4 stands for the number of the edges.
- ⑤—用数字1、2、3、8表示每个切削刃上的同时切削齿数。
The character 1.2.3.8 stands for the number of the teeth per edge .
- ⑥—用Ⅰ、Ⅱ等罗马数字表示不同的刀片齿形结构，仅一种结构时不标出。
The character Ⅰ.Ⅱ stands for the different teeth types. If only one type, don't show any code.



API (美标) 石油油管、套管圆螺纹形式及参数

The type of API tubing and casing round thread



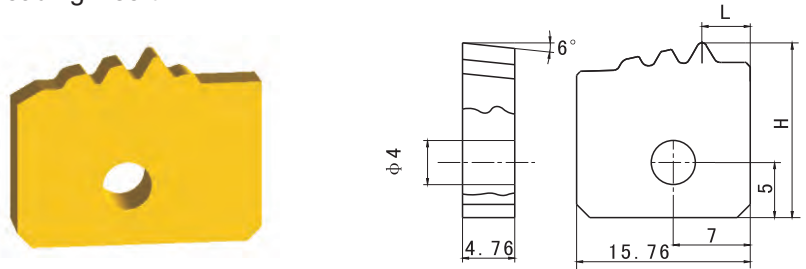
石油油管、套管圆螺纹参数
Date of tubing and casing round threading

螺纹要素 Parameter of thread	1/8" 牙型 8 tooth/inch	1/10" 牙型 10 tooth/inch
螺距P Pitch	3.175	2.54
原始三角形高度H Height of the primitive triangle degree	2.75	2.20
牙型高度hs=hn Height of the tooth	1.81	1.412
牙顶削平高度Scs=Scn Scraping height of crest	0.508	0.432
牙底削平高度Srs=Srn Scraping height of bottom	0.432	0.356

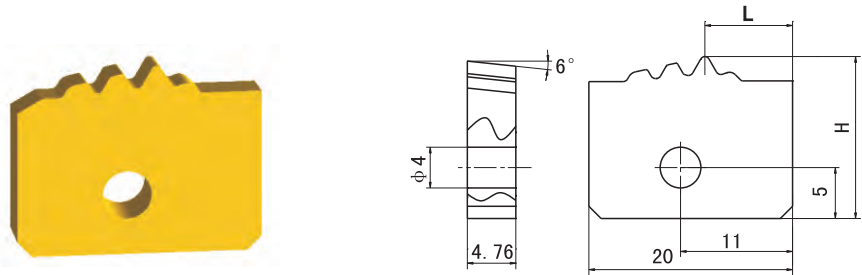
API 石油油管、套管圆螺纹 > Colinet系列圆螺纹刀片

API tubing and casing round threading > Colinet series round threading inserts

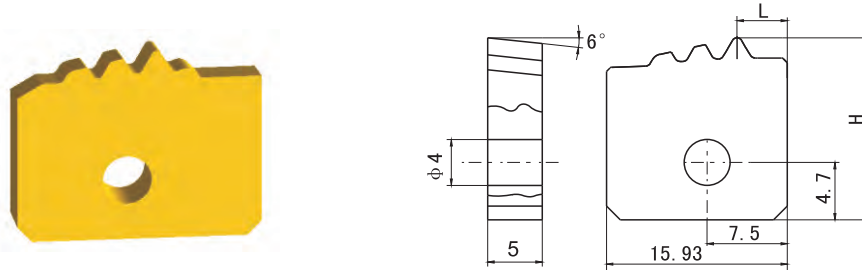
外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C8W1-31(15°)	8	1:16	API油管套管圆螺纹 API round tubing casing thread	15.54	5.98	BXCQW1B I	0124、0326
C8W1-32(15°)	8	1:16	API油管套管圆螺纹 API round tubing casing thread	15.86	4.393	BXCQW1B I	0124、0326
C10W1-31	10	1:16	API油管圆螺纹 API round tubing thread	15.16	5.67	BXCQW1B I	0124、0326
C10W1-32	10	1:16	API油管圆螺纹 API round tubing thread	15.45	4.4	BXCQW1B I	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C8W1-31(12°)	8	1:16	API油管套管圆螺纹 API round tubing casing thread	15.6	10.2	BXCQW1B II	0124、0326
C8W1-32(12°)	8	1:16	API油管套管圆螺纹 API round tubing casing thread	15.9	8.61	BXCQW1B II	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C8W1-3	8	1:16	API油管套管圆螺纹 API round tubing casing thread	15.75	4.4	BXCQW1B I	0124、0326
C10W1-4	10	1:16	API油管圆螺纹 API round tubing thread	15.75	2.5	BXCQW1B I	0124、0326



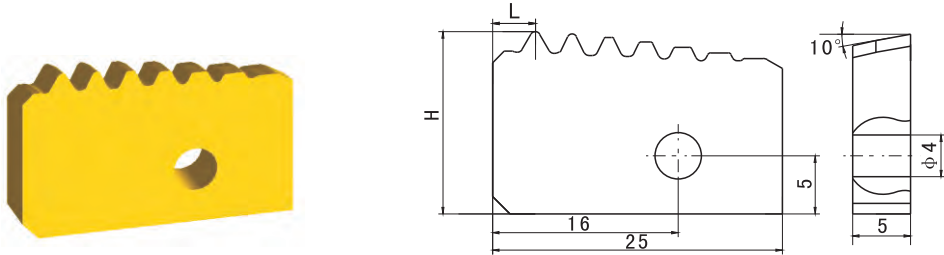
API 石油油管、套管圆螺纹 > Colinet系列圆螺纹刀片

API tubing and casing round threading > Colinet series round threading inserts

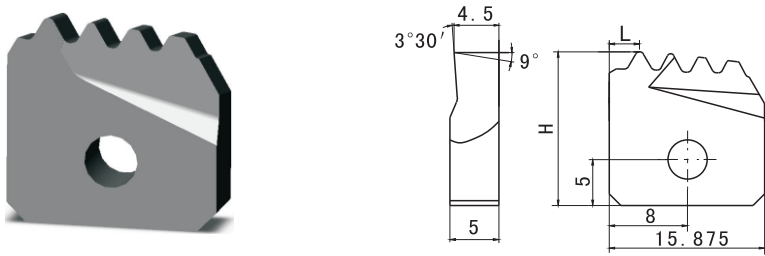
API 石油油管、套管圆螺纹 > PMC系列圆螺纹刀片

API tubing and casing round threading > PMC series round threading inserts

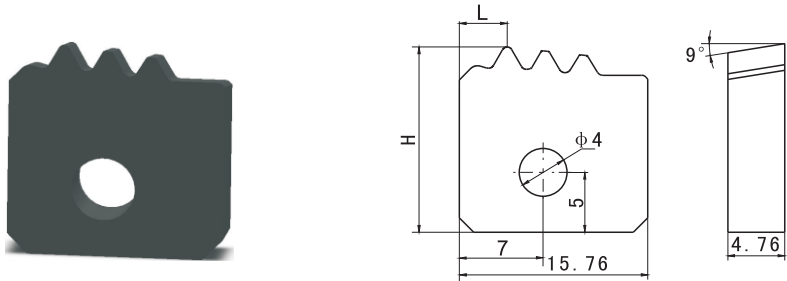
内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C8N1-7	8	1:16	API套管圆螺纹 API round tubing casing thread	15.715	3.7	XCQN1BIII	0124、0326
C10N1-8	10	1:16	API油管圆螺纹 API round tubing thread	15.49	2.5	XCQN1BIII	0124、0326



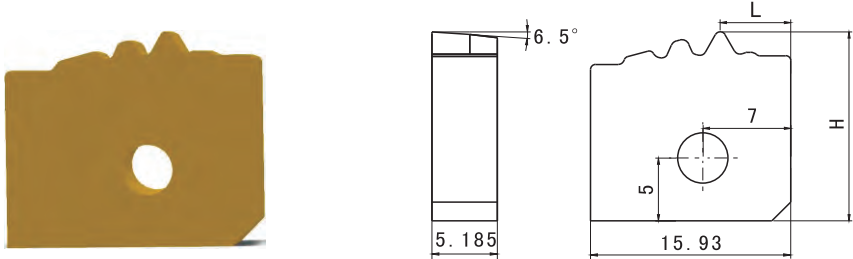
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C8N1-4	8	1:16	API套管圆螺纹 API round tubing casing thread	15.7	3.1	XCQN1B II	0124、0326
C10N1-5	10	1:16	API油管圆螺纹 API round tubing thread	15.75	2.5	XCQN1B II	0124、0326



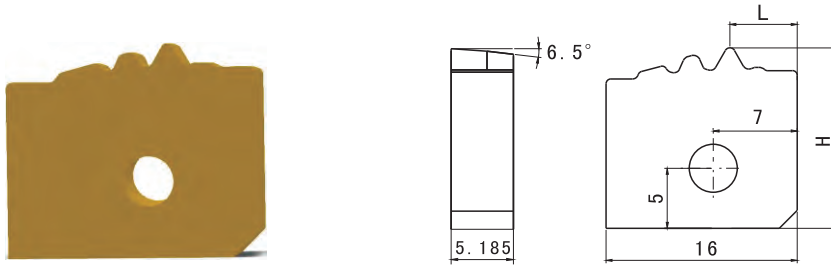
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C8N1-3	8	1:16	API套管圆螺纹 API round tubing casing thread	15.5	4.0	XCQN1B I	0124、0326
C8N1-3F	8	1:16	API套管圆螺纹 API round tubing casing thread	15.7	3.15	XCQN1B I	0124、0326

注：C8N1-3F为反向走刀螺纹刀片
Remark: C8N1-3F reverse feeding threading inserts

外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
P8W1-31(12°)	8	1:16	API套管圆螺纹 API round casing thread	14.7	7.72	XP8W1-31、XP8W1B	0124、0326
P8W1-32(12°)	8	1:16	API套管圆螺纹 API round casing thread	14.96	6.67	XP8W1-31、XP8W1B	0124、0326
P8W1-33(12°)	8	1:16	API套管圆螺纹 API round casing thread	15.04	5.61	XP8W1-31、XP8W1B	0124、0326
BP8W1-31(15°)	8	1:16	API油管圆螺纹 API round tubing thread	14.71	7.72	XP8W1-31、XP8W1B	0124、0326
BP8W1-32(15°)	8	1:16	API油管圆螺纹 API round tubing thread	14.96	6.67	XP8W1-31、XP8W1B	0124、0326
BP8W1-33(15°)	8	1:16	API油管圆螺纹 API round tubing thread	15.04	5.61	XP8W1-31、XP8W1B	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
P10W1-31	10	1:16	API油管圆螺纹 API round tubing thread	14.315	7.3	XP10W1-31、XP10W1B	0124、0326
P10W1-32	10	1:16	API油管圆螺纹 API round tubing thread	14.57	6.46	XP10W1-31、XP10W1B	0124、0326
P10W1-33	10	1:16	API油管圆螺纹 API round tubing thread	14.65	5.61	XP10W1-31、XP10W1B	0124、0326



API 石油油管、套管圆螺纹 > PMC系列圆螺纹刀片

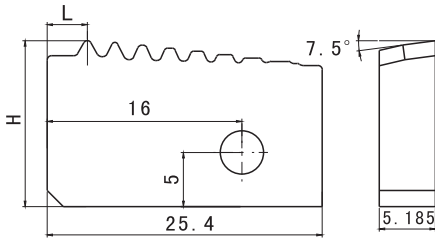
API tubing and casing round threading > PMC series round threading inserts

API 石油油管、套管圆螺纹 > 蝶形系列圆螺纹刀片

API tubing and casing round threading > Papilionaceous series round threading inserts

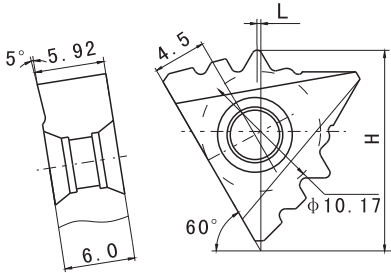
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内螺纹刀片 Internal threading insert



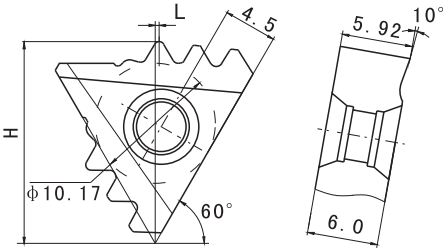
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
P10N1-8	10	1:16	API油管圆螺纹 API round tubing thread	15.34	3.7	XP10N1-8、BXPQN1C	0124、0326
P8N1-7	8	1:16	API油套管圆螺纹 API round tubing casing thread	15.715	3.7	XP8N1-7、XP8N1-7A XP8N1-7B、BXPQN1C	0124、0326

外螺纹刀片 External threading insert

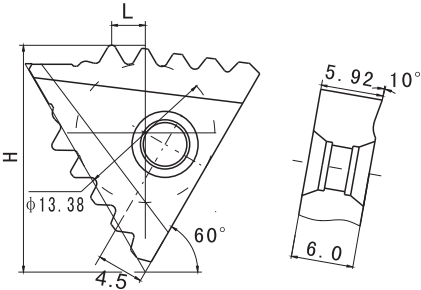


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
B8W2-3(15°)	8	1:16	API油管圆螺纹 API round tubing thread	17.09	0.32	0124、0326
B8W2-3(12°)	8	1:16	API套管圆螺纹 API round casing thread	17.09	0.32	0124、0326
B10W2-4	10	1:16	API油管圆螺纹 API round tubing thread	17.09	0.32	0124、0326

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
B8N2-3	8	1:16	API油套管圆螺纹 API round tubing casing thread	17.09	0.32	0124、0326
B10N2-4	10	1:16	API油管圆螺纹 API round tubing thread	17.09	0.01	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
B8N2-5	8	1:16	API油套管圆螺纹 API round tubing casing thread	21.84	3.24	0124、0326



API 石油油管、套管圆螺纹 > S系列圆螺纹刀片

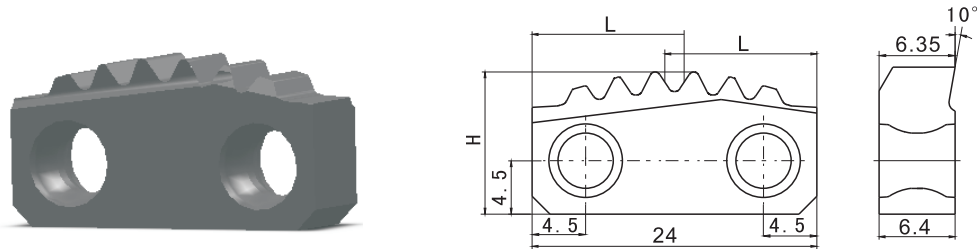
API tubing and casing round threading > S-series round threading inserts

API 石油油管、套管圆螺纹 > U系列圆螺纹刀片

API tubing and casing round threading > U-series round threading inserts

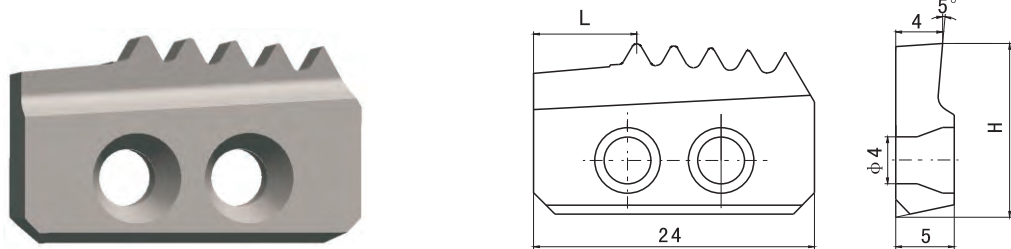
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外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
S8W2-3	8	1:16	API油套管圆螺纹 API round tubing casing thread	12	12.815	0124、0326
S10W2-3	10	1:16	API油套管圆螺纹 API round tubing casing thread	11.93	16.48	0124、0326

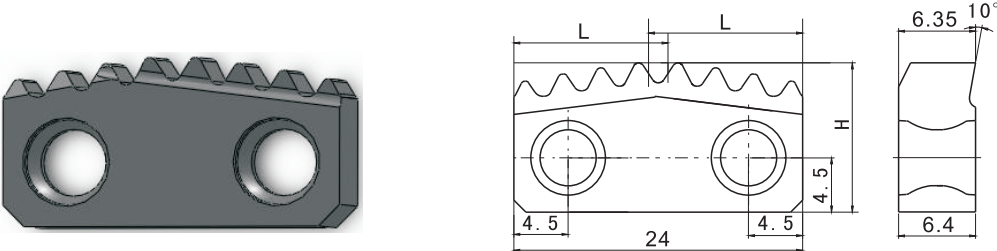
内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
U8N1-7	8	1:16	API油套管圆螺纹 API round tubing casing thread	14.85	3.4	0124、0326
U8N1-7F	8	1:16	API油套管圆螺纹 API round tubing casing thread	14.85	3.4	0124、0326
U10N1-7	10	1:16	API油套管圆螺纹 API round tubing casing thread	14.85	7.4	0124、0326

注：U8N1-7F为反向走刀螺纹刀片
Remark: U8N1-7F reverse feeding threading inserts

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
S8N2-4	8	1:16	API油管圆螺纹 API round tubing thread	12.4	12.815	0124、0326
S10N2-4	10	1:16	API油管圆螺纹 API round tubing thread	12.4	12.815	0124、0326



API 石油油管、套管圆螺纹 > 双面刃系列圆螺纹刀片

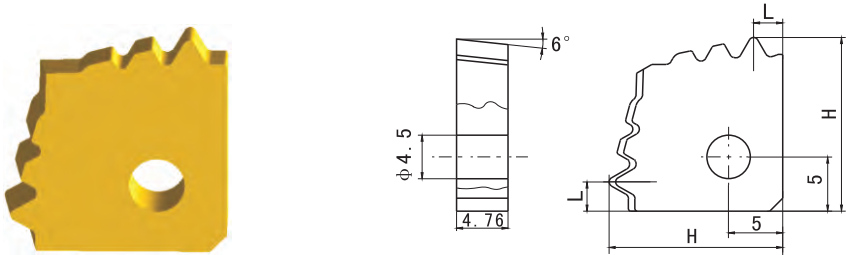
API tubing and casing round threading > Double-side series round threading inserts

API 石油油管、套管圆螺纹 > 双面刃系列圆螺纹刀片

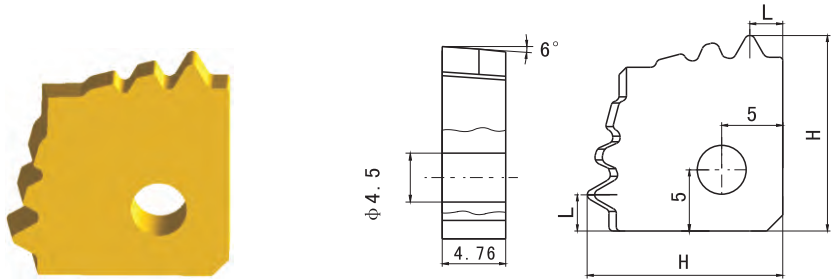
API tubing and casing round threading > Double-side series round threading inserts

A

外螺纹刀片 External threading insert

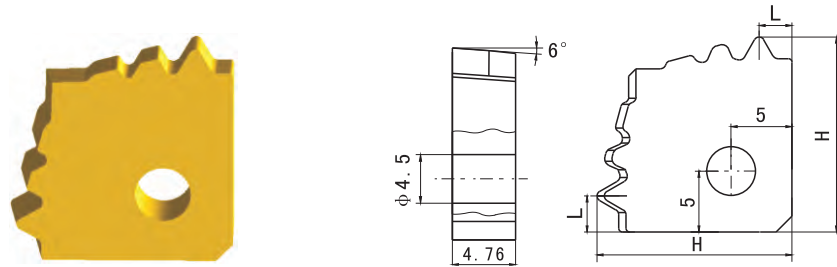


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
BC10W2-31	10	1:16	API油管圆螺纹 API round tubing thread	15.3	3.97	TA2118B	0124、0326
BC10W2-32	10	1:16	API油管圆螺纹 API round tubing thread	15.59	2.7	TA2118B	0124、0326
BC8W2-31(15°)	8	1:16	API油管圆螺纹 API round tubing thread	15.54	4.29	TA2118B	0124、0326
BC8W2-32(15°)	8	1:16	API油管圆螺纹 API round tubing thread	15.86	2.7	TA2118B	0124、0326
BC8W2-31(12°)	8	1:16	API套管圆螺纹 API round casing thread	15.54	4.29	TA2118B	0124、0326
BC8W2-32(12°)	8	1:16	API套管圆螺纹 API round casing thread	15.86	2.7	TA2118B	0124、0326

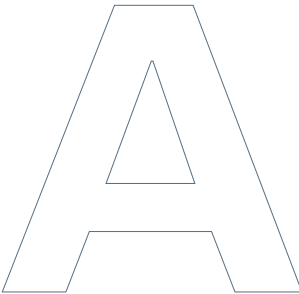


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
BP10W2-31	10	1:16	API油管圆螺纹 API round tubing thread	15.2	4.39	TA2118B	0124、0326
BP10W2-32	10	1:16	API油管圆螺纹 API round tubing thread	15.53	3.547	TA2118B	0124、0326
BP10W2-33	10	1:16	API油管圆螺纹 API round tubing thread	15.6	2.7	TA2118B	0124、0326
BP8W2-31(15°)	8	1:16	API油管圆螺纹 API round tubing thread	15.67	4.817	TA2118B	0124、0326
BP8W2-32(15°)	8	1:16	API油管圆螺纹 API round tubing thread	15.92	3.76	TA2118B	0124、0326
BP8W2-33(15°)	8	1:16	API油管圆螺纹 API round tubing thread	16	2.7	TA2118B	0124、0326

外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
BM10W2-4	10	1:16	API油管圆螺纹 API round tubing thread	15.6	2.7	TA2118B	0124、0326
BM8W2-3(15°)	8	1:16	API油管圆螺纹 API round tubing thread	16.0	2.7	TA2118B	0124、0326





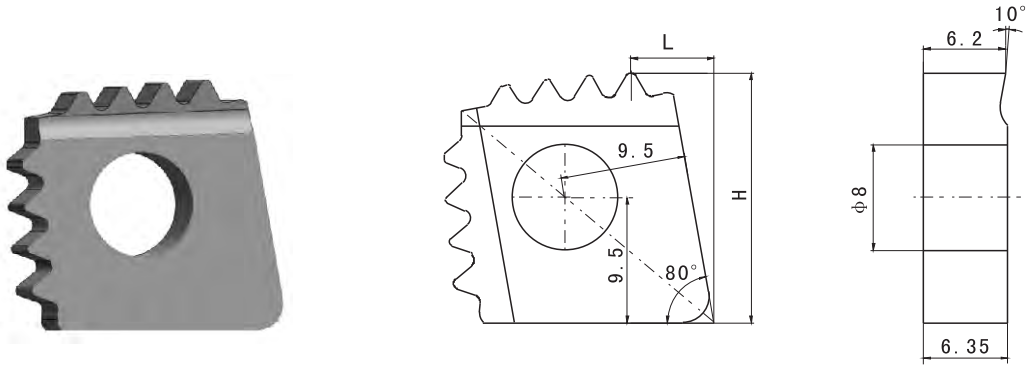
API 石油油管、套管圆螺纹 > K形系列圆螺纹刀片
API tubing and casing round threading > K-series round threading inserts

API 石油油管、套管圆螺纹 > 标准三角形系列圆螺纹刀片
API tubing and casing round threading > Standard triangle series round threading inserts

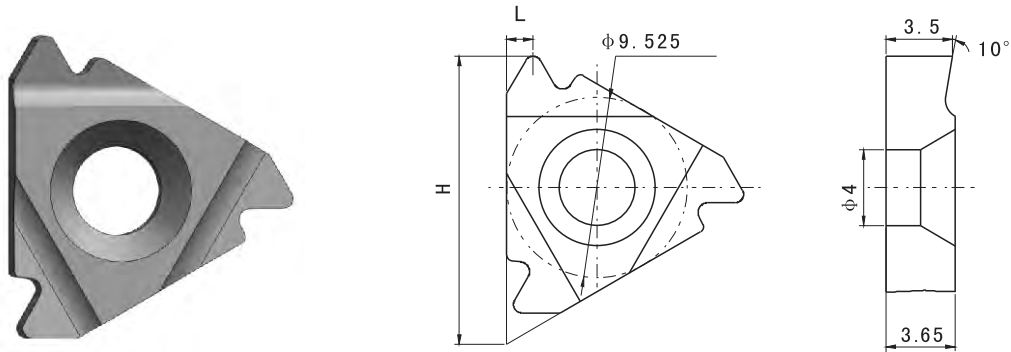
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外螺纹刀片 External threading insert

外螺纹刀片 External threading insert



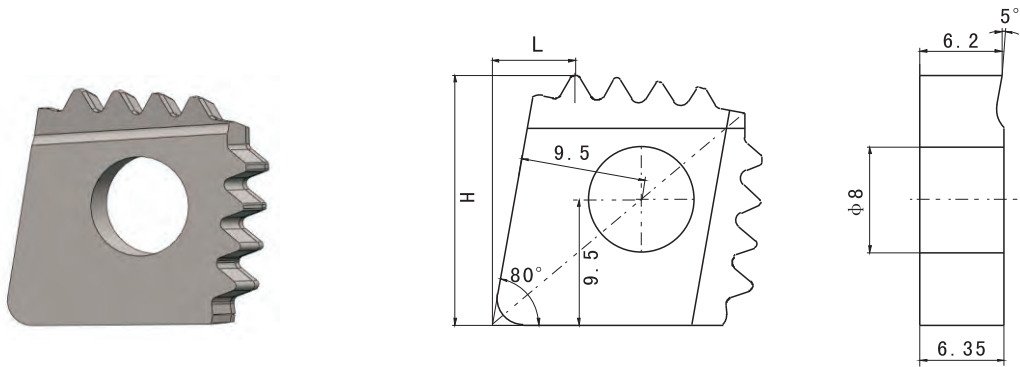
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
K8W2-4	8	1:16	API油套管圆螺纹 API round tubing casing thread	18.93	6.29	0124、0326



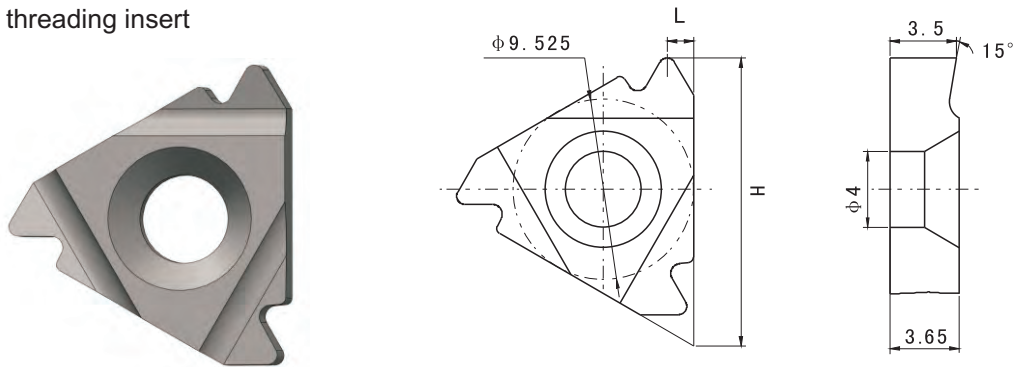
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
16ER8AP I	8	1:16	API油套管圆螺纹 API round tubing casing thread	15.2	1.4	0124、0326
16ER10AP I	10	1:16	API油套管圆螺纹 API round tubing casing thread	15.2	1.2	0124、0326

内螺纹刀片 Internal threading insert

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
K8N2-4	8	1:16	API油套管圆螺纹 API round tubing casing thread	18.93	6.29	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
16NR8AP I	8	1:16	API油套管圆螺纹 API round tubing casing thread	15.2	1.4	0124、0326
16NR10AP I	10	1:16	API油套管圆螺纹 API round tubing casing thread	15.2	1.2	0124、0326



API 石油油管、套管圆螺纹 > 大三角系列圆螺纹刀片

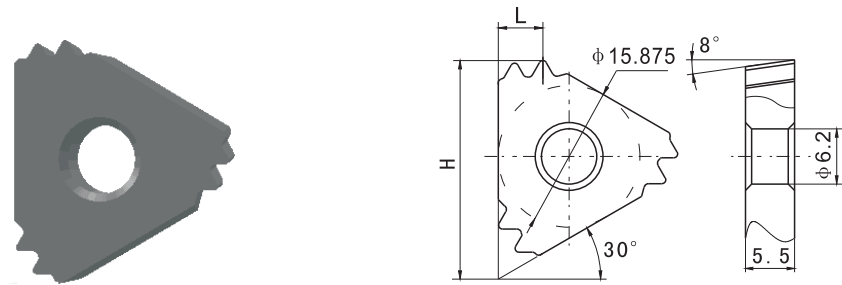
API tubing and casing round threading > Big triangle series round threading inserts

API 石油油管、套管圆螺纹 > 普通车丝机系列刀片

API tubing and casing round threading > Common threading machine inserts

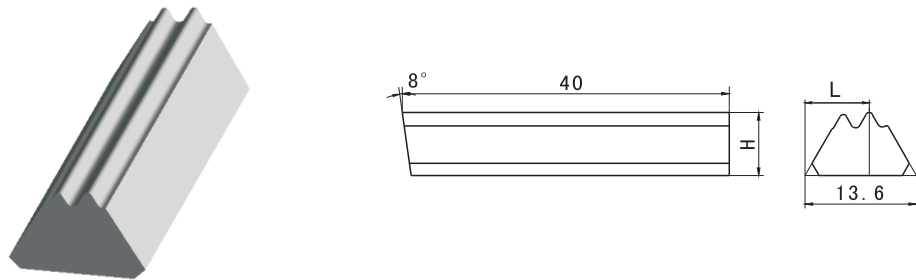
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外螺纹刀片 External threading insert



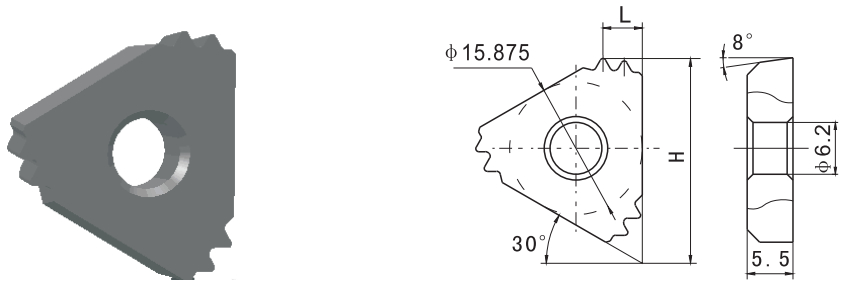
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
8W3-2	8	1:16	API油套管圆螺纹 API round tubing casing thread	24.3	5.0	J10(8)W3-DXQ	0124、0326
10W3-2	10	1:16	API油管圆螺纹 API round tubing thread	24.5	4.7	J10(8)W3-DXQ	0124、0326

长条形外螺纹刀片 Strip external threading insert



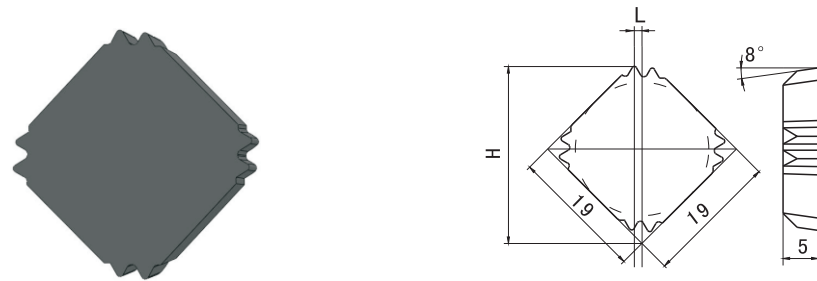
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
8W1-2	8	1:16	API油套管圆螺纹 API round tubing casing thread	7.7	7.85		0124、0326
10W1-2	10	1:16	API油管圆螺纹 API round tubing thread	7.7	7.2		0124、0326

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
8N3-2	8	1:16	API油套管圆螺纹 API round tubing casing thread	24.3	5.0	J10(8)N3-DXQ	0124、0326
10N3-2	10	1:16	API油管圆螺纹 API round tubing thread	24.5	4.7	J10(8)N3-DXQ	0124、0326

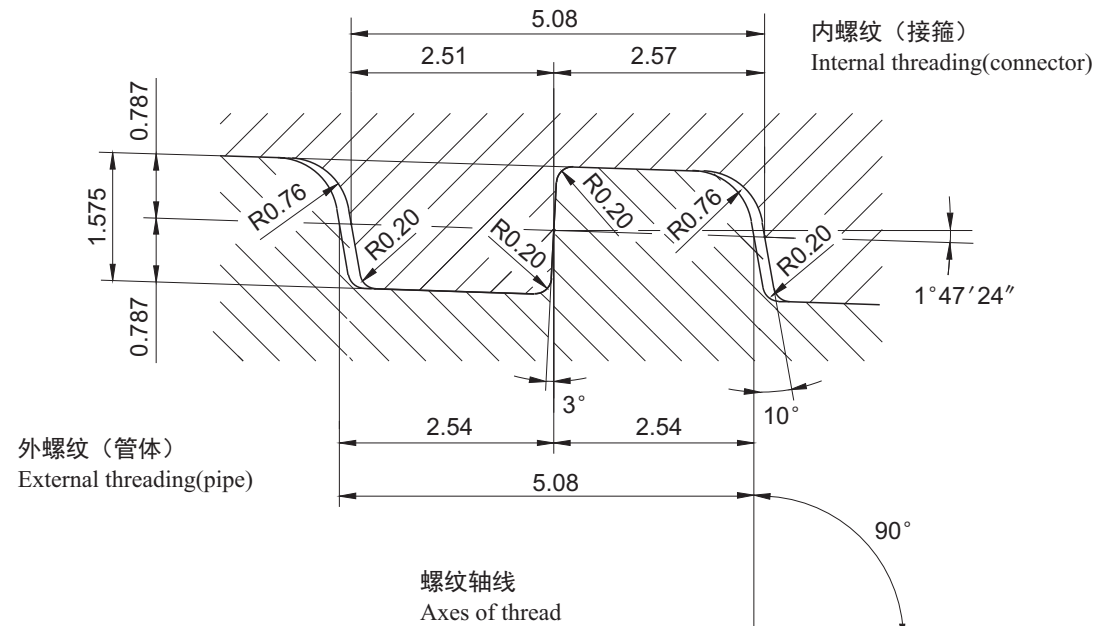
方形内螺纹刀片 Square internal threading insert



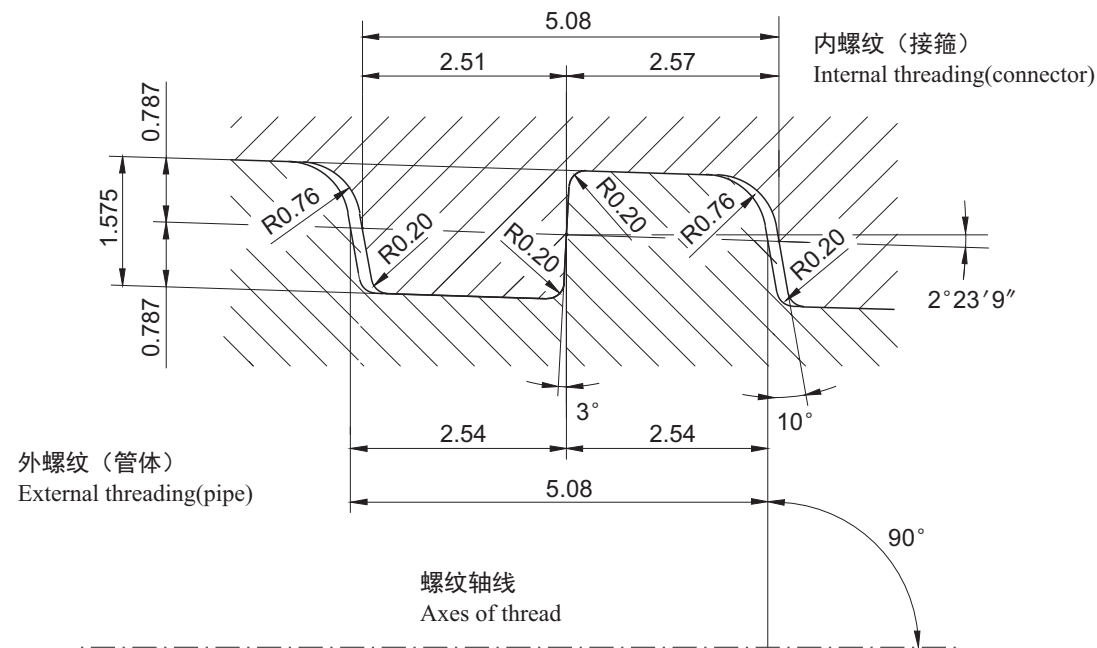
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
8N4-2	8	1:16	API油套管圆螺纹 API round tubing casing thread	25	1.35	J10(8)N4-DXQ	0124、0326
10N4-2	10	1:16	API油管圆螺纹 API round tubing thread	25.2	1.1	J10(8)N4-DXQ	0124、0326



API (美标) 石油套管偏梯形螺纹形式及参数
Type and date of API casing buttress threading

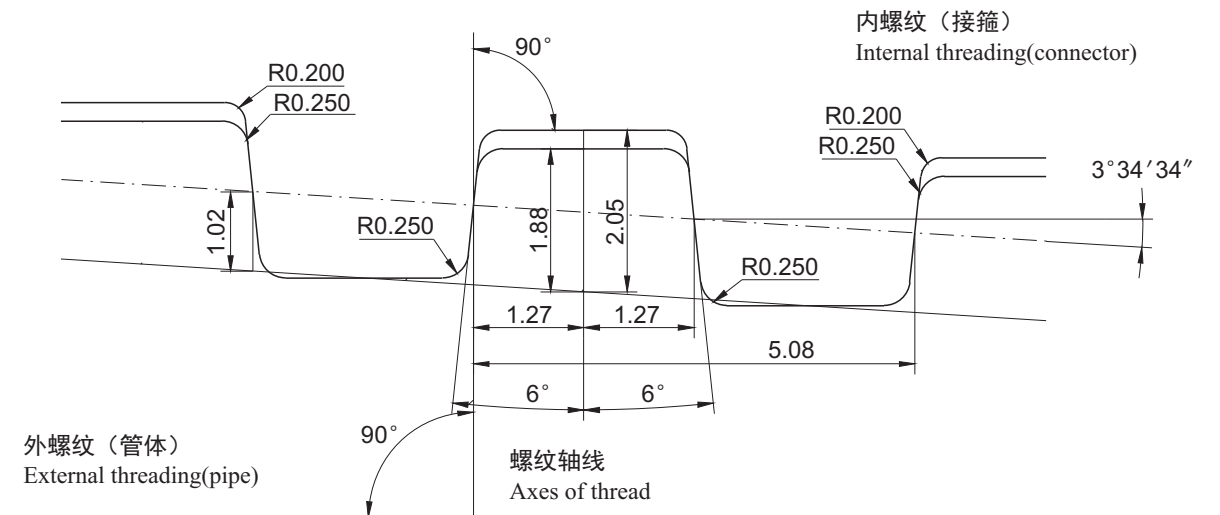


偏梯型套管螺纹牙型和尺寸 (规格4 1/2"-13 3/8", 5牙/25.4mm, 锥度1:16)
Form and dimension of buttress threading (diameter=4 1/2"-13 3/8", 5 tooth/25.4mm, taper 1:16)

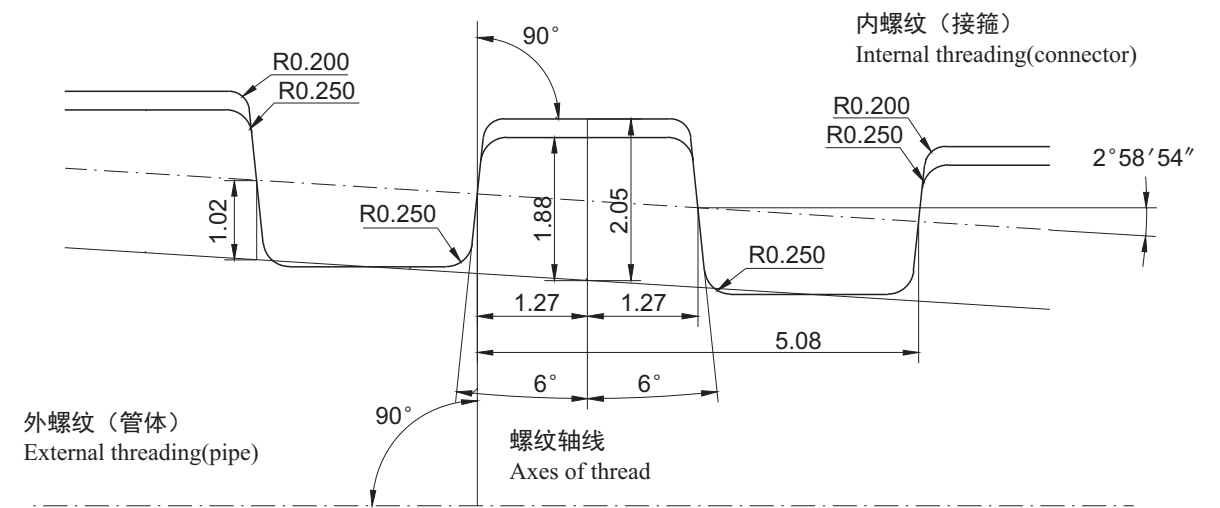


偏梯型套管螺纹牙型和尺寸 (规格不小于16", 5牙/25.4mm, 锥度1:12)
Form and dimension of buttress casing threading (diameter≥16", 5 tooth/25.4mm, taper 1:12)

API (美标) 石油套管偏梯形螺纹形式及参数
Type and date of API casing buttress threading



直连型套管螺纹牙型 (规格5"-7 5/8", 6牙/25.4mm, 锥度1:8)
Form of extreme-line casing threading (diameter=5"-7 5/8", 6 tooth/25.4mm, taper 1:8)



直连型套管螺纹牙型 (规格8 5/8"-10 3/4", 5牙/25.4mm, 锥度1:9.6)
Form of extreme-line casing threading (diameter=8 5/8"-10 3/4", 5 tooth/25.4mm, taper 1:9.6)





API 石油套管偏梯形螺纹 > Colinet系列偏梯扣刀片

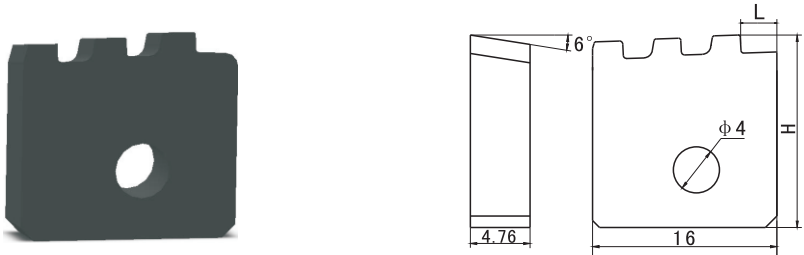
API buttress threading inserts for oil pipe > Colinet series buttress threading inserts

API 石油套管偏梯形螺纹 > Colinet系列偏梯扣刀片

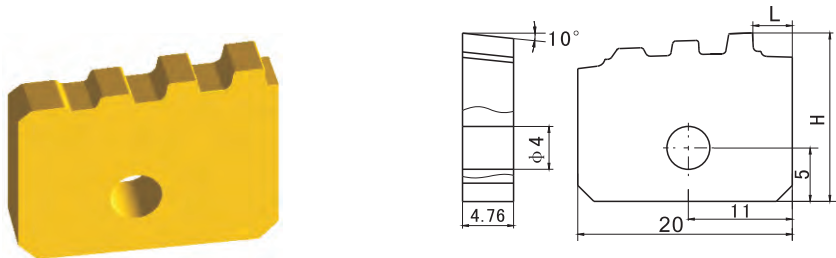
API buttress threading inserts for oil pipe > Colinet series buttress threading inserts

A

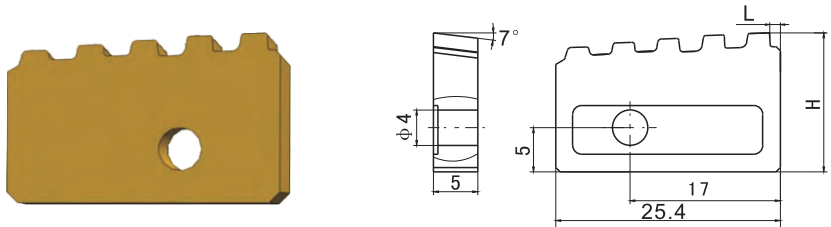
外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
5BW1-3	5	1:16	API偏梯形螺纹 API buttress thread	15.1	3.2	BXCQW1-B I	0124、0326
5BW1-3D	5	1:12	API偏梯形螺纹 API buttress thread	15.1	3.2	BXCQW1-B I	0124、0326

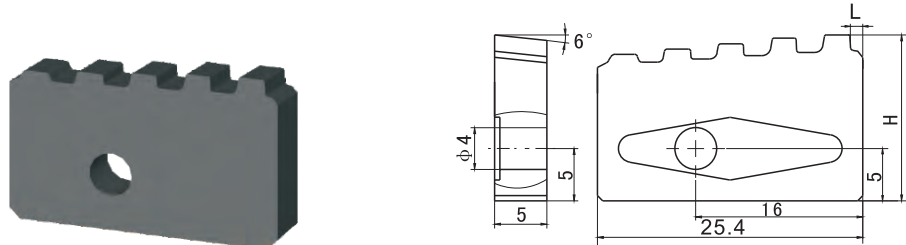


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C5BW1-31	5	1:16	API偏梯形螺纹 API buttress thread	15.70	3.65	BXCQW1-B II	0124、0326
C5BW1-32	5	1:16	API偏梯形螺纹 API buttress thread	15.88	1.0	BXCQW1-B II	0124、0326
C5BW1-31B	5	1:16	API偏梯形螺纹 API buttress thread	15.50	3.13	BXCQW1-B II	0124、0326
C5BW1-32B	5	1:16	API偏梯形螺纹 API buttress thread	15.88	3.0	BXCQW1-B II	0124、0326



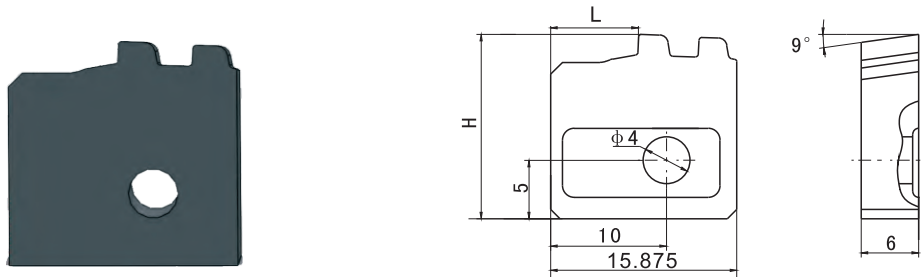
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C5BW1-5	5	1:16	API偏梯形螺纹 API buttress thread	15.736	1.185	BXCQW1-B III	0124、0326

外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
BC5BW1-5D	5	1:12	API偏梯形螺纹 API buttress thread	15.875	1.2	BXCQW1-B III	0124、0326

内螺纹刀片 Internal threading insert

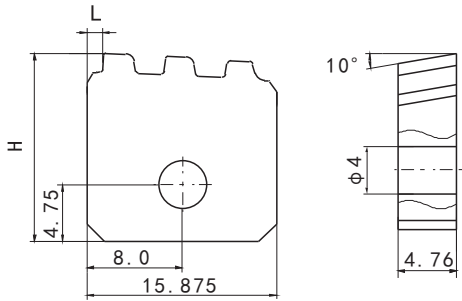
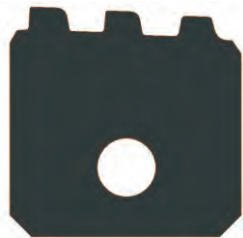


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C5BN1-2	5	1:16	API偏梯形螺纹 API buttress thread	15.75	7.65	BXCQN1B XC5BN1-2	0124、0326
C5BN1-2D	5	1:12	API偏梯形螺纹 API buttress thread	15.75	7.65	BXCQN1B XC5BN1-2	0124、0326

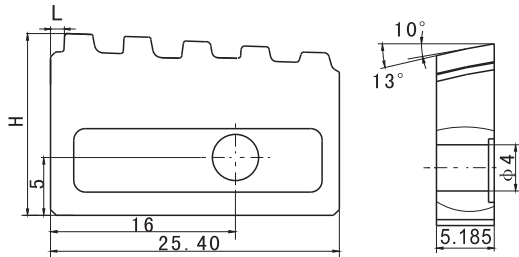


API 石油套管偏梯形螺纹 > Colinet系列偏梯扣刀片

API buttress threading inserts for oil pipe > Colinet series buttress threading inserts



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C5BN1-3	5	1:16	API偏梯形螺纹 API buttress thread	15.75	1.34	TG2-8T	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
C5BN1-5	5	1:16	API偏梯形螺纹 API buttress thread	15.74	1.185	XCQN1-BIII	0124、0326
C5BN1-5F	5	1:16	API偏梯形螺纹 API buttress thread	15.3	1.3	XCQN1-BIII	0124、0326

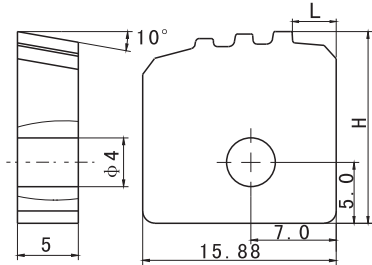
注：C5BN1-5F为反向走刀螺纹刀片
Remark: C5BN1-5F reverse feeding threading inserts

API 石油套管偏梯形螺纹 > PMC系列偏梯扣刀片

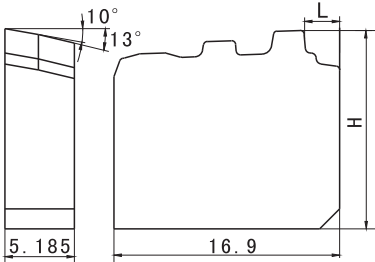
API buttress threading inserts for oil pipe > PMC series buttress threading inserts

A

外螺纹刀片 External threading insert

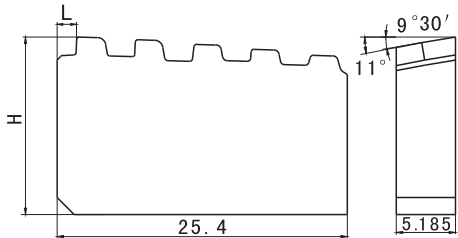
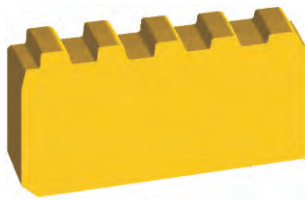


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
P5BW1-3	5	1:16	API偏梯形螺纹 API buttress thread	15.73	1.85	BXCQW1-B I	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
P5BW1-31	5	1:16	API偏梯形螺纹 API buttress thread	14.57	4.46	XP5BW1-31、XP5BW1-B	0124、0326
P5BW1-32	5	1:16	API偏梯形螺纹 API buttress thread	14.84	2.74	XP5BW1-32、XP5BW1-B	0124、0326
P5BW1-33	5	1:16	API偏梯形螺纹 API buttress thread	14.97	0.97	XP5BW1-33、XP5BW1-B	0124、0326

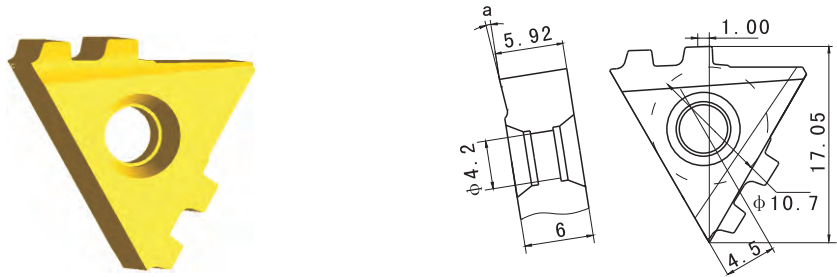
内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
P5BN1-5	5	1:16	API偏梯形螺纹 API buttress thread	15.608	1.7	XP5BN1-5、BXPQN1C	0124、0326
P5BN1-5S	5	1:16	API偏梯形螺纹 API buttress thread	15.608	1.8	XP5BN1-5A	0124、0326

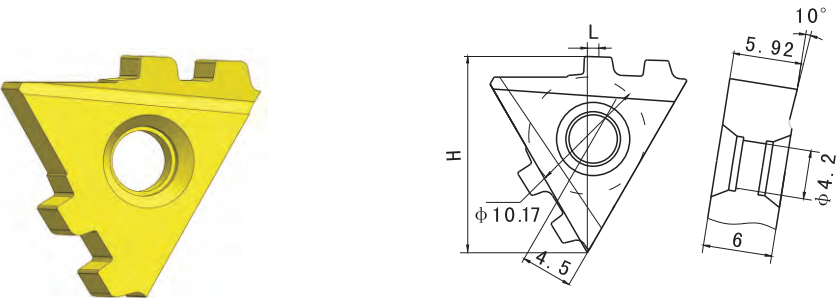


外螺纹刀片 External threading insert

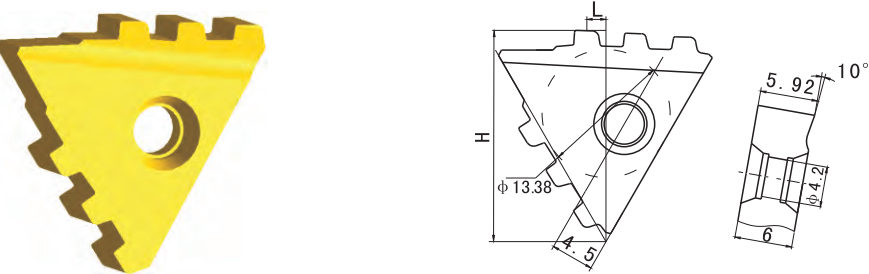


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	α	牌号 Grade
B5BW2-2	5	1:16	API偏梯形螺纹 API buttress thread	10°	0124、0326
B5BW2-2III	5	1:16	API偏梯形螺纹 API buttress thread	5°	0124、0326

内螺纹刀片 Internal threading insert

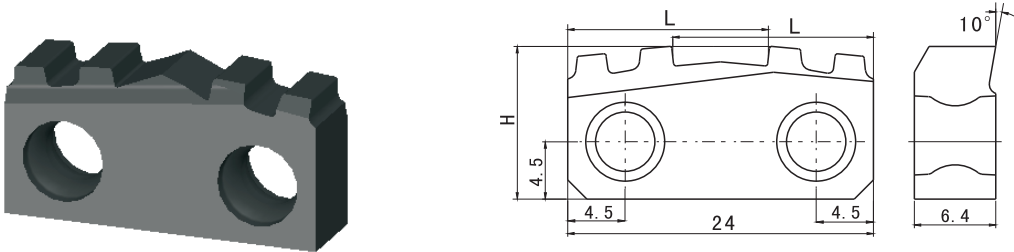


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
B5BN2-2	5	1:16	API偏梯形螺纹 API buttress thread	17.05	1.0	0124、0326



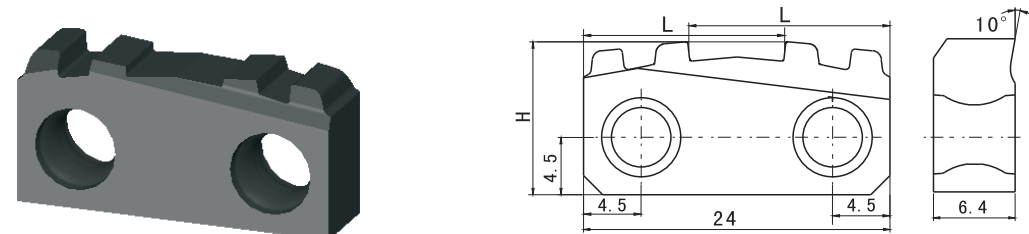
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
B5BN2-3	5	1:16	API偏梯形螺纹 API buttress thread	22.075	2.0	0124、0326

外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
S5BW2-2	5	1:16	API偏梯形螺纹 API buttress thread	12.0	15.76	0124、0326

内螺纹刀片 Internal threading insert

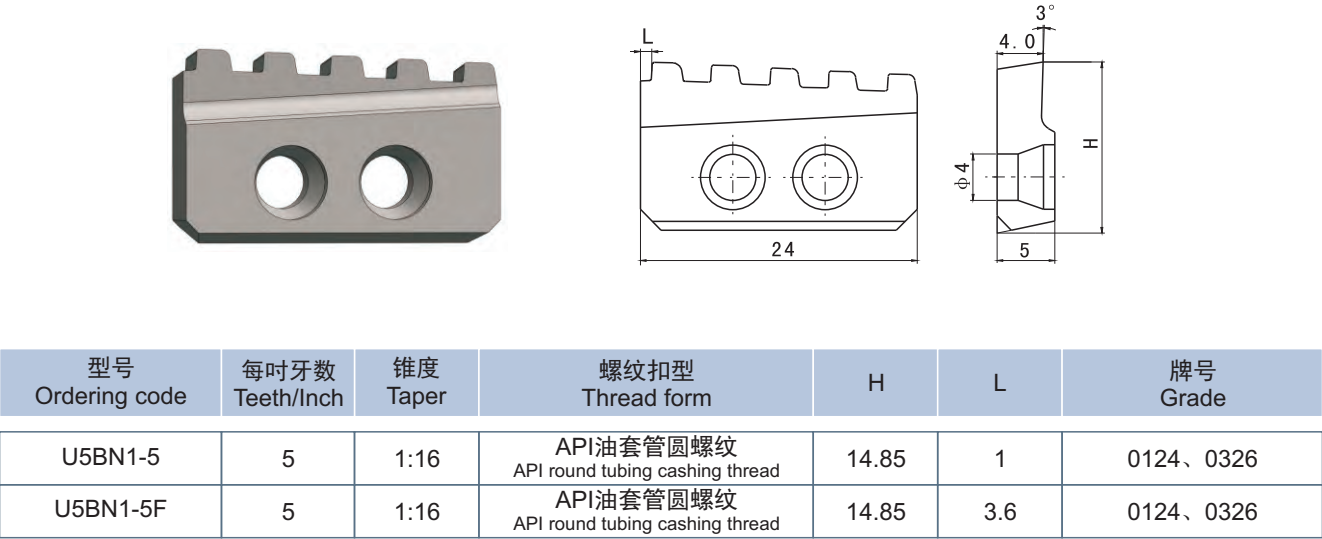


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
S5BN2-2	5	1:16	API偏梯形螺纹 API buttress thread	12.0	15.76	0124、0326

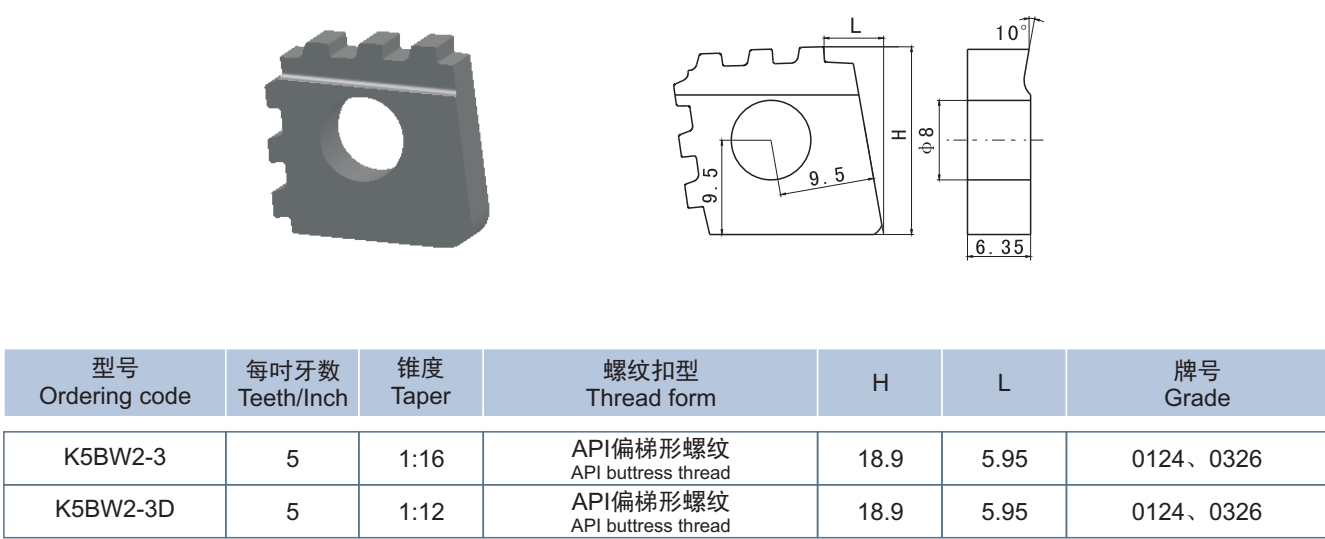


内螺纹刀片 Internal threading insert

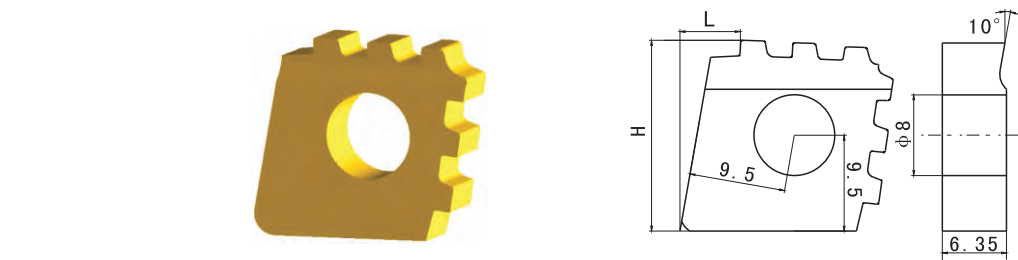
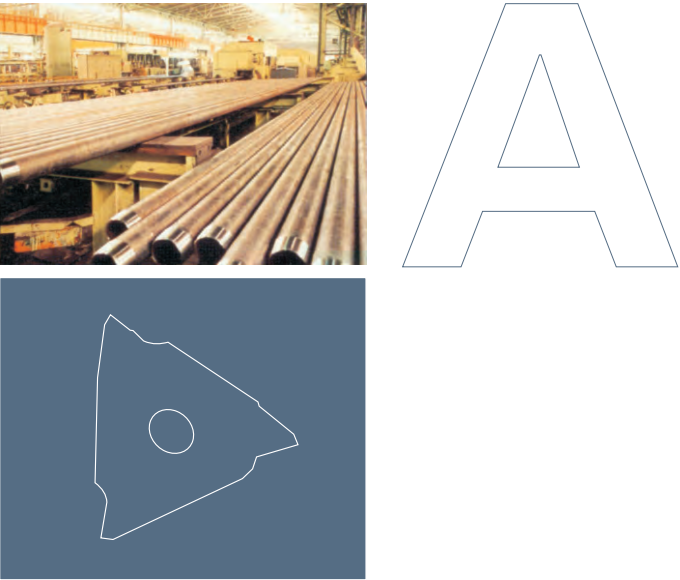
外螺纹刀片 External threading insert



注：U5BN1-5F为反向走刀螺纹刀片
Remark: U5BN1-5F reverse feeding threading inserts



内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
K5BN2-3	5	1:16	API偏梯形螺纹 API buttress thread	18.9	5.95	0124、0326
K5BN2-3D	5	1:12	API偏梯形螺纹 API buttress thread	18.9	5.95	0124、0326



API 石油套管偏梯形螺纹 > 立装系列偏梯扣刀片

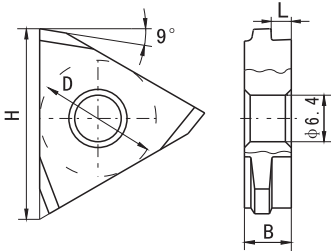
API buttress threading inserts for oil pipe > Vertical series buttress threading inserts

API 石油套管偏梯形螺纹 > 标准三角形系列偏梯扣刀片

API buttress threading inserts for oil pipe > Standard triangle series buttress threading inserts

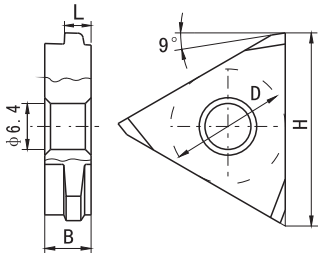
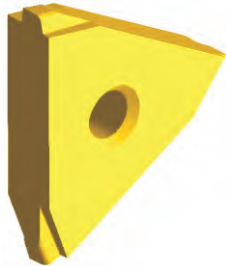
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外螺纹刀片 External threading insert

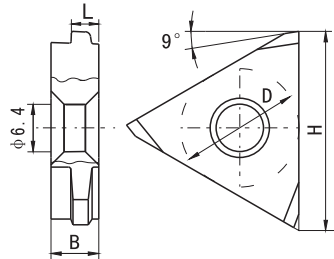
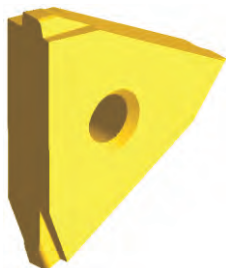


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	D	B	牌号 Grade
5BWL3	5	1:16	API偏梯形螺纹 API buttress thread	26.2	2.76	15.875	6.45	0124、0326

内螺纹刀片 Internal threading insert

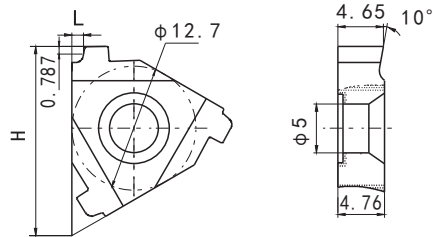
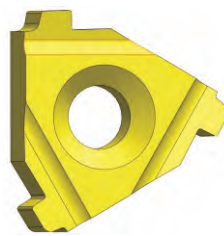


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	D	B	牌号 Grade
5BNL3	5	1:16	API偏梯形螺纹 API buttress thread	26.7	3.69	15.875	6.45	0124、0326



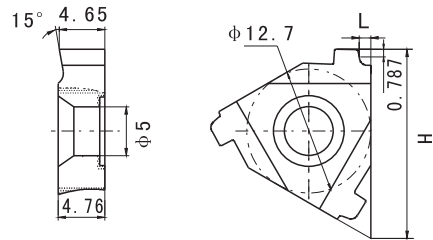
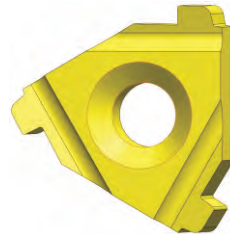
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	D	B	牌号 Grade
T5BNL3-1KT	5	1:16	API偏梯形螺纹 API buttress thread	26.75	3.40	15.875	6.45	0124、0326

外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
22ER5B3-1	5	1:16	API偏梯形螺纹 API buttress thread	19.4	1.2	0124、0326

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
22NR5B3-1	5	1:16	API偏梯形螺纹 API buttress thread	19.4	0.8	0124、0326

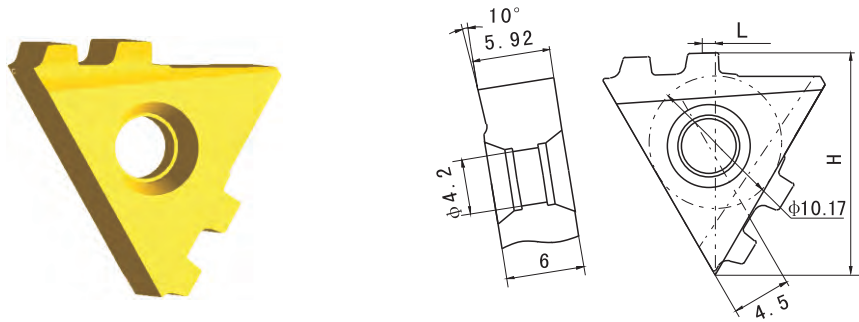
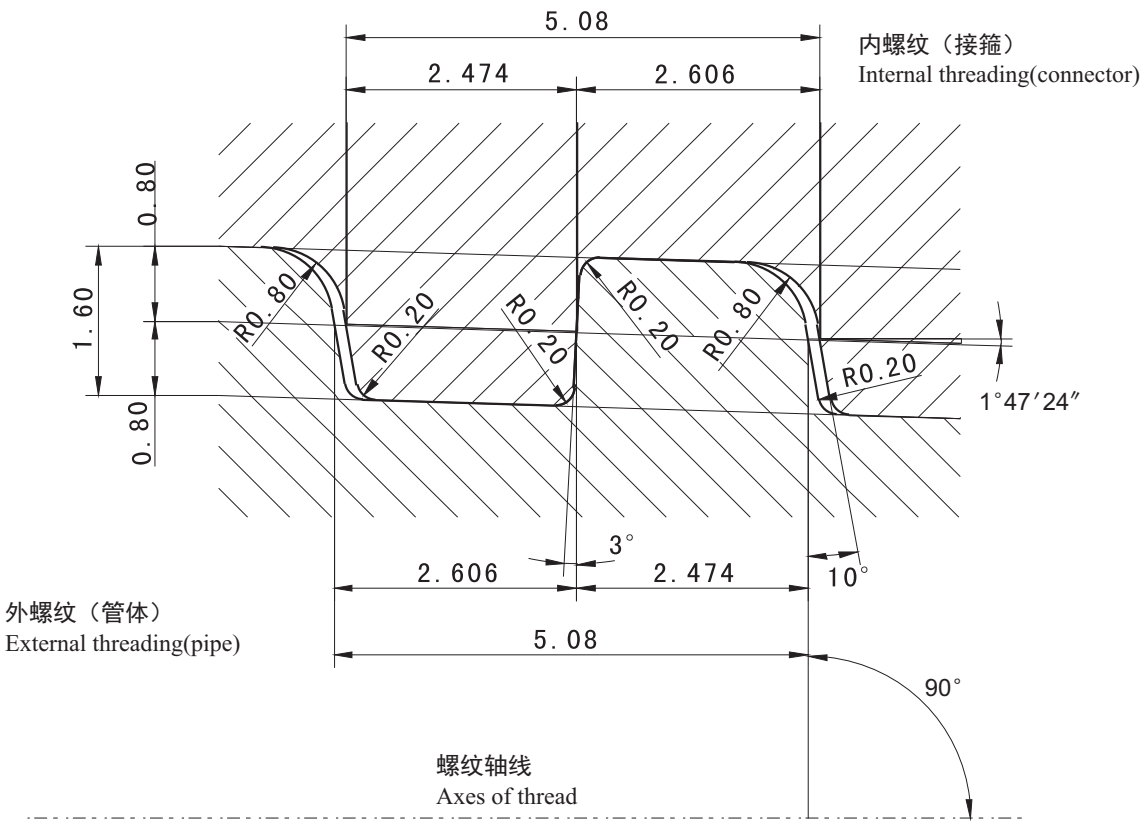


GOST (俄标) 石油套管偏梯形螺纹形式及参数
Type and date of GOST buttress threading inserts for oil pipe

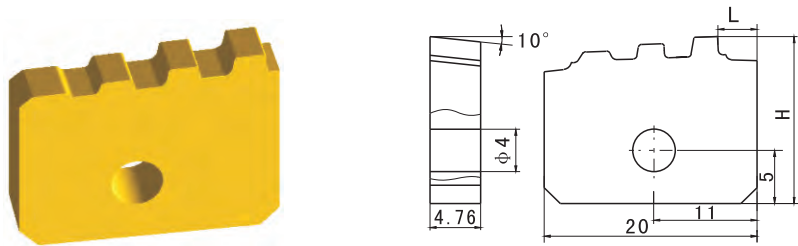
GOST (俄标) 石油套管偏梯形螺纹刀片
GOST buttress threading inserts for oil pipe

A

外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
E5BW2-2	5	1:16	OTTM、OTTG	17.03	0.83	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
E5BW1-31	5	1:16	OTTM、OTTG	15.70	3.64	BXCQW1-B II	0124、0326
E5BW1-32	5	1:16	OTTM、OTTG	15.88	1.0	BXCQW1-B II	0124、0326

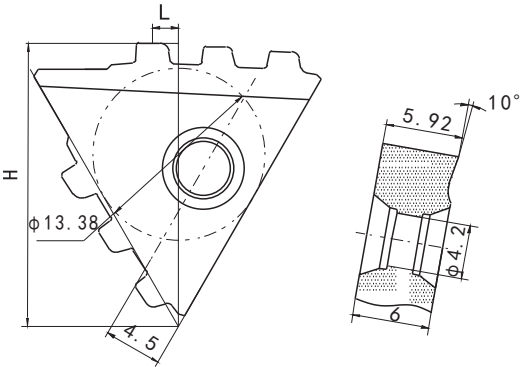


GOST (俄标) 石油套管偏梯形螺纹刀片
GOST buttress threading inserts for oil pipe

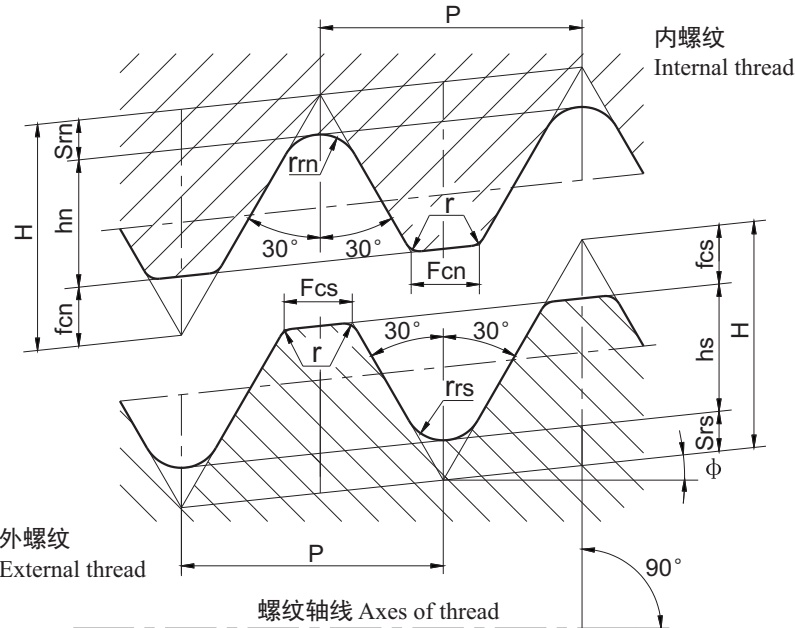
石油钻杆接头螺纹形式及参数
Thread type and date of oil drillrod connectors

内螺纹刀片 Internal threading insert

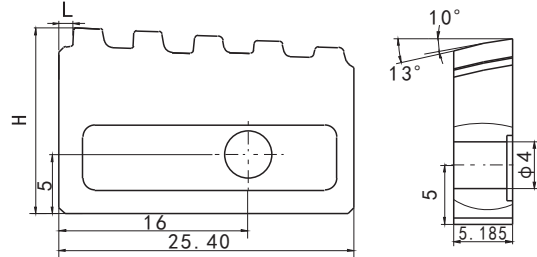
石油钻杆接头螺纹形式 Thread type of oil drillrod connectors



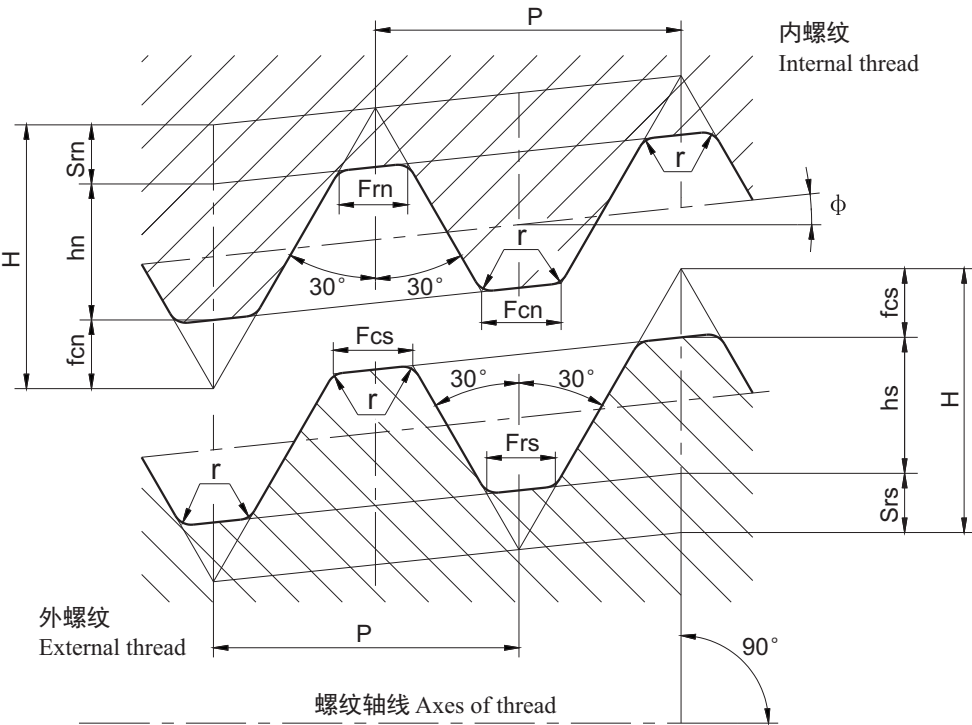
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	牌号 Grade
E5BN2-3	5	1:16	OTTM、OTTG	22.075	2.0	0124、0326



V-0.038R V-0.040和V-0.050螺纹牙型
Thread form of V-0.03R, V-0.040 & V-0.050



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	螺纹扣型 Thread form	H	L	断屑器 Chipbreaker	牌号 Grade
E5BN1-5	5	1:16	OTTM、OTTG	15.736	1.2	TG3-1	0124、0326



V-0.055 V-0.065和V-0.076螺纹牙型
Thread form of V-0.055, V-0.065 & V-0.076



石油钻杆接头螺纹形式及参数

Thread type and date of oil drill rod connectors

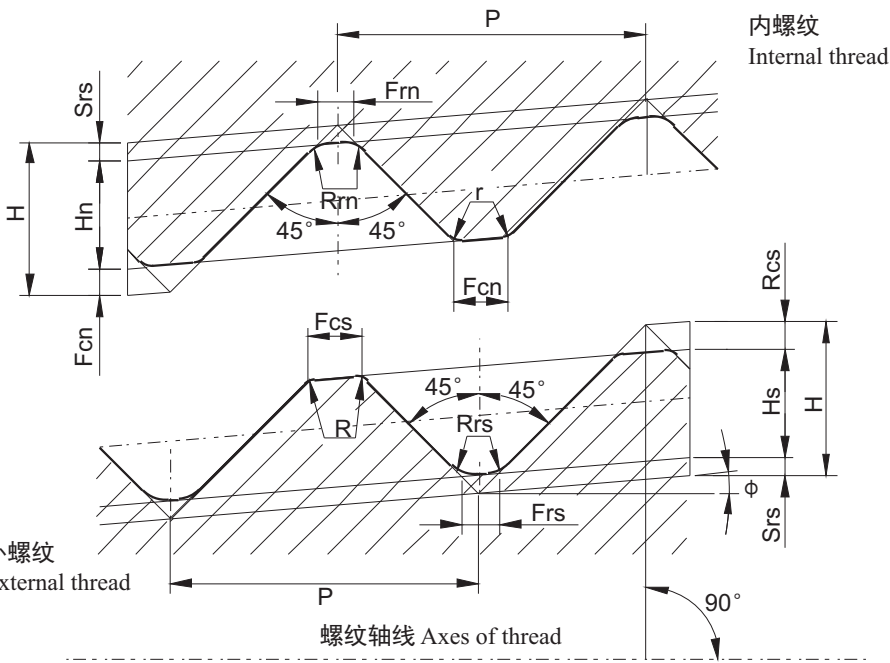
石油钻杆接头螺纹形式及参数

Thread type and date of oil drill rod connectors

石油钻杆接头螺纹参数及应用范围
Date and application range of oil drill rod connector threading

螺纹牙型代号 Code of thread		Y1	Y2	Y3	Y4	Y5	Y6	Y7	PAC
螺 距 Pitch	每吋牙数 Teeth/inch	4	4	5	4	4	6	4	4
	P	6.350	6.350	5.080	6.350	6.350	4.233	6.35	6.35
原始三角形高度 H Height of primitive triangle degree H		5.487	5.471	4.376	5.471	5.487	3.660	5.487	5.492
牙型高度hn=hs Height of tooth type hn=hs		3.095	3.083	2.993	3.742	3.755	1.420	2.831	2.350
牙顶削平高度 Srn=Srs frn=frs Scraping height of crest Srn=Srs frn=frs		1.426	1.423	0.875	1.094	1.097	1.209	1.426	1.671
牙顶宽度 Fcn=Fcs Width of tooth crest Fcn=Fcs		1.65	1.65	1.02	1.27	1.27	1.40	1.65	1.93
牙底宽度 Frn=Frs Wedth of tooth crest Frn=Frs		0.965	0.965	0.508	0.635	0.635	1.031	1.229	1.472
牙底削平高度 Srn=Srs Wedth of tooth bottom Srn=Srs		-----	-----	-----	-----	-----	1.19	1.42	1.70
牙底圆弧半径 rrn=rrs Circle-arc radius of tooth bottom rrn=rrs		0.97	0.97	0.51	0.64	0.64	-----	0.38	0.38
牙顶削平倒圆半径 r Rounded radius of crest scraping r		0.38	0.38	0.38	0.38	0.38	0.38	0.38	0.38
螺纹锥角 2tgQ Taper angle of thread 2tgQ		1: 6	1: 4	1: 4	1: 4	1: 6	1: 8	1: 6	1: 8
应用范围 Application range		NC23-NC50	NC56-NC77	2 3/8"-4 1/2" REG 3 1/2" FH 4 1/2" FH	5 1/2" REG 7 5/8" REG 8 5/8" REG	6 5/8" REG 5 1/2" FH 6 5/8" FH	NC10-NC16	4" FH 2 3/8"-5 1/2" IF	2 3/8"-4 1/2" OHSW, 2 3/8"-4 1/2" OHLW, 2 3/8"-3 1/2" PAC

单位: mm
Unit : mm

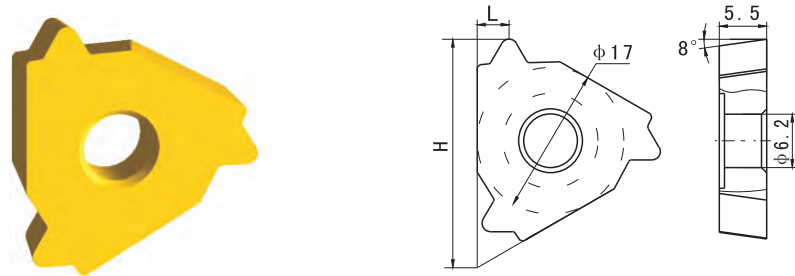


V-0.050和V-0.084螺纹牙型 Thread form of V-0.050 & V-0.084

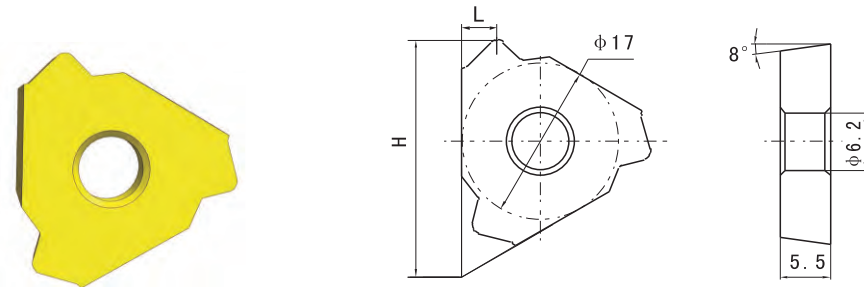
螺纹牙型代号 Code of thread		35H6	35H4	30H9
		V-0.050	V-0.050	V-0.084
螺 距 Pitch	每吋牙数 Teeth/inch	3.5	3.5	3
	P	7.257	7.257	8.467
原始三角形高度H Height of primitive triangle degree H		3.603	3.572	4.222
牙型高度hn=hs Height of tooth type hn=hs		2.54	2.522	2.286
牙顶削平高度 Srn=Srs frn=frs Scraping height of crest Srn=Srs frn=frs		0.433	0.425	0.866
牙顶宽度 Fcn=Fcs Width of tooth crest Fcn=Fcs		1.27	1.27	2.13
牙底宽度 Frn=Frs Wedth of tooth crest Frn=Frs		0.86	0.86	1.73
牙底圆弧半径 rrn=rrs Circle-arc radius of tooth bottom rrn=rrs		0.76	0.76	0.76
牙顶削平倒圆半径 r Rounded radius of crest scraping r		0.38	0.38	0.38
螺纹锥角 2tgQ Taper angle of thread 2tgQ		1: 6	1: 4	5: 48
加工范围 Application range		3 1/2" -6 5/8" H90	7-8 5/8" H90	2 3/8" -3 1/2" SLH90



外螺纹刀片 External threading insert

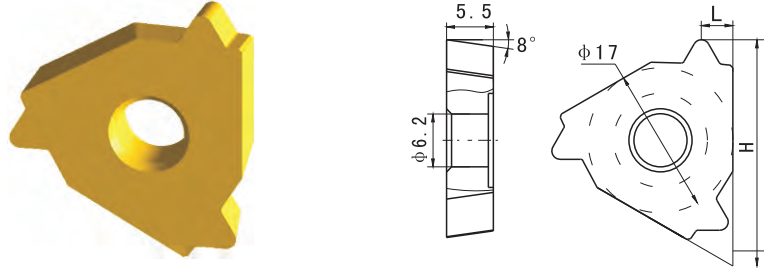


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
4Y1W3	4	1:6	V-0.038R	26.51	3.7	0124、0326
4Y2W3	4	1:4	V-0.038R	26.51	3.7	0124、0326
5Y3W3	5	1:4	V-0.040	26.96	3.7	0124、0326
4Y4W3	4	1:4	V-0.050	26.83	3.7	0124、0326
4Y5W3	4	1:6	V-0.050	26.83	3.7	0124、0326
4Y5W3-1T	4	1:12	V-0.050	26.83	3.7	0124、0326
4Y7W3	4	1:6	V-0.065	26.24	3.7	0124、0326
MZ4Y1W3	4	1:16	V-0.038R	26.51	3.7	0124、0326



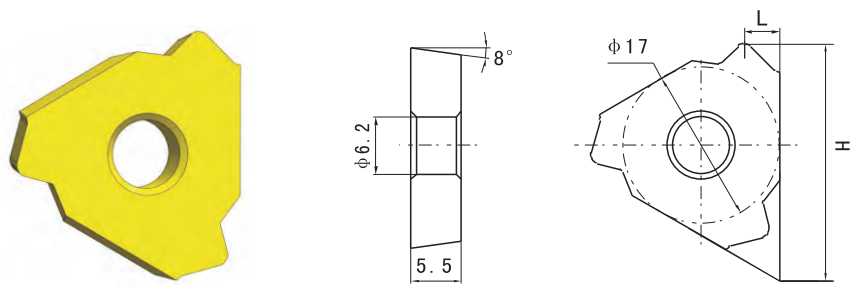
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
35H4W3	3.5	1:4	V-0.050	25.76	3.85	0124、0326

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
4Y1N3	4	1:6	V-0.038R	26.51	3.7	0124、0326
4Y1N3-1T	4	1:6	V-0.038R	26.9	3.7	0124、0326
4Y2N3	4	1:4	V-0.038R	26.51	3.7	0124、0326
5Y3N3	5	1:4	V-0.040	26.96	3.7	0124、0326
4Y4N3	4	1:4	V-0.050	26.83	3.7	0124、0326
4Y5N3	4	1:6	V-0.050	26.83	3.7	0124、0326
4Y5N3-1T	4	1:12	V-0.050	26.83	3.7	0124、0326
4Y7N3	4	1:6	V-0.065	26.24	3.7	0124、0326
MZ4Y1N3	4	1:16	V-0.038R	26.51	3.7	0124、0326

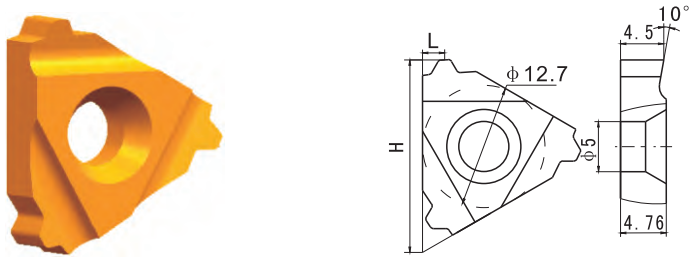
注：4Y1N3-1T为左旋螺纹刀片
Remark: 4Y1N3-1T is the left hand insert.



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
35H4N3	3.5	1:4	V-0.050	25.76	3.85	0124、0326

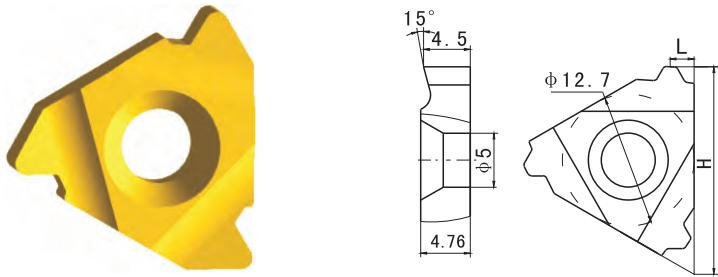


外螺纹刀片 External threading insert



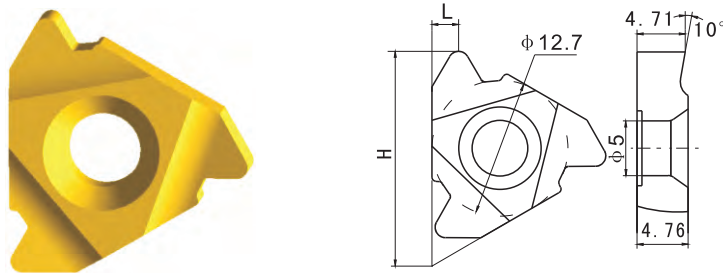
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
22ER6APIT	6	1:8	V-0.055	20	2.3	0124、0326
6Y6W3-1	6	1:8	V-0.055	20	2.3	0124、0326

内螺纹刀片 Internal threading insert

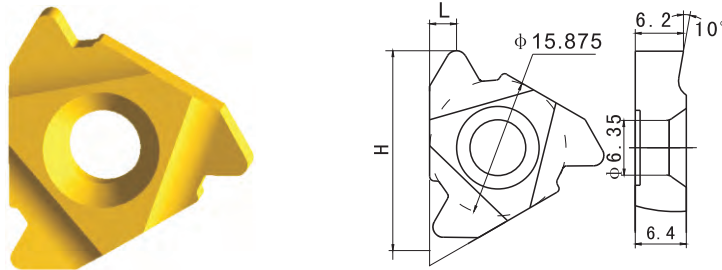


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
22NR6APIT	6	1:8	V-0.055	20	2.3	0124、0326
6Y6N3-1	6	1:8	V-0.055	20	2.3	0124、0326

外螺纹刀片 External threading insert



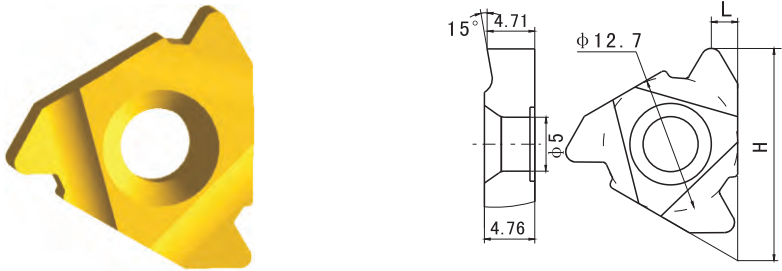
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
22ER4Y1	4	1:6	V-0.038R	20	2.5	0124、0326



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
27ER4Y1	4	1:6	V-0.038R	25.40	2.8	0124、0326
27ER4Y5	4	1:6	V-0.050	25.30	3.2	0124、0326

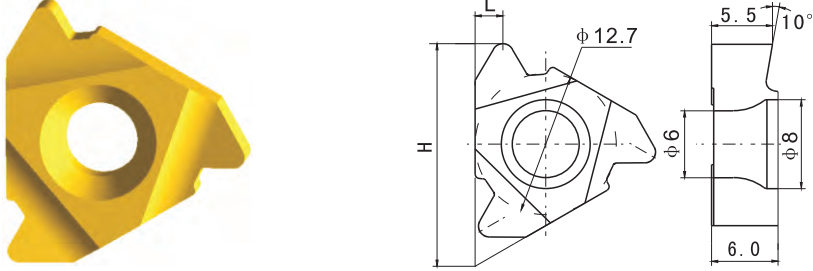


内螺纹刀片 Internal threading insert



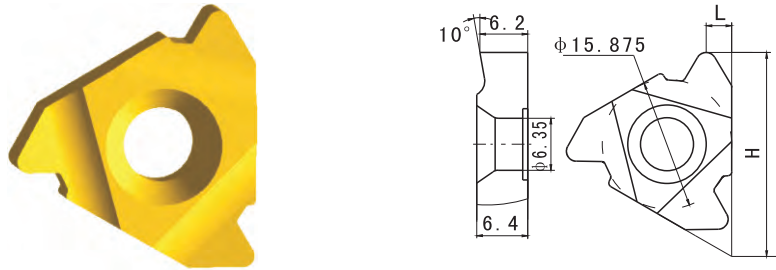
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22NR4Y1	4	1:6	V-0.038R	20.00	2.5	0124、0326

外螺纹刀片 External threading insert

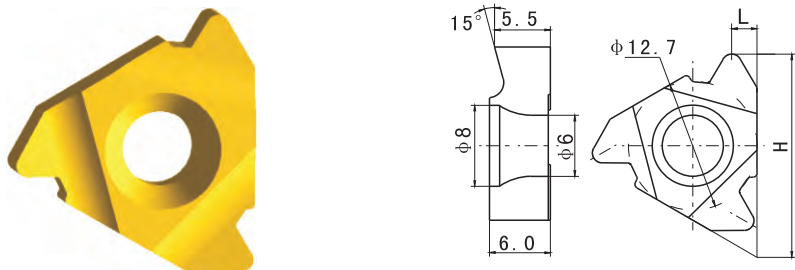


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
22ER4Y1SV	4	1:6	V-0.038R	20.30	2.5	0124、0326
22ER4Y5SV	4	1:6	V-0.050	20.15	2.8	0124、0326

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
27NR4Y1	4	1:6	V-0.038R	25.40	2.8	0124、0326
27NR4Y5	4	1:6	V-0.050	25.30	3.2	0124、0326

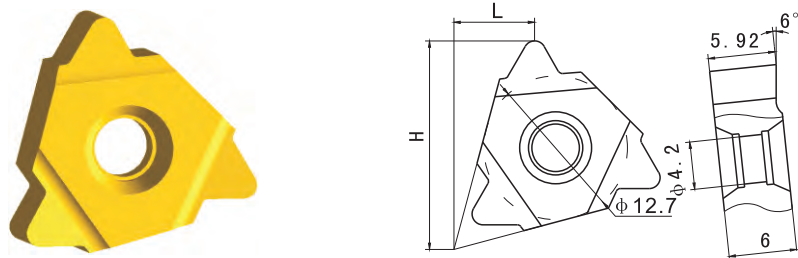


型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
22NR4Y1SV	4	1:6	V-0.038R	20.3	2.5	0124、0326
22NR4Y5SV	4	1:6	V-0.050	20.15	2.8	0124、0326



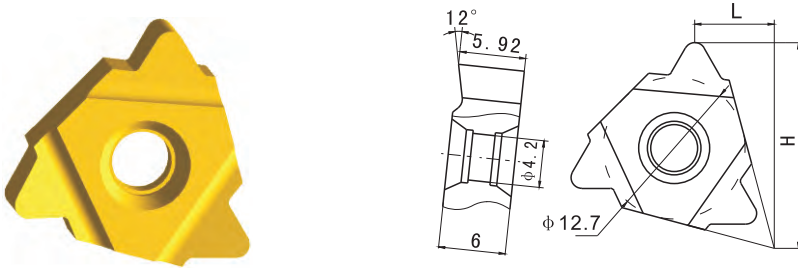
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外螺纹刀片 External threading insert



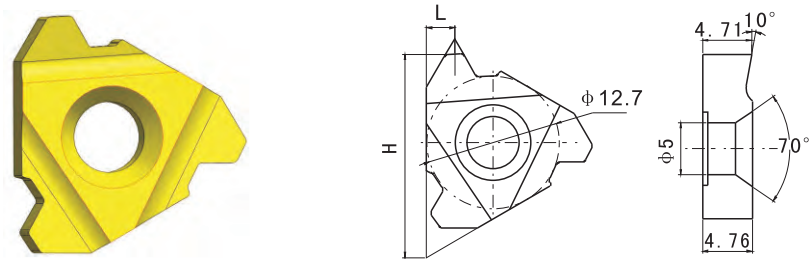
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
B4Y1W3	4	1:6	V-0.038R	18.43	7.13	0124、0326
B4Y1W3-1T	4	1:16	V-0.038R	18.43	7.13	0124、0326
B4Y2W3	4	1:4	V-0.038R	18.43	7.13	0124、0326
B5Y3W3	5	1:4	V-0.040	18.58	7.13	0124、0326
B4Y4W3	4	1:4	V-0.050	18.43	7.13	0124、0326
B4Y5W3	4	1:6	V-0.050	18.43	7.13	0124、0326
B4Y5W3-1T	4	1:16	V-0.050	18.50	7.3	0124、0326

内螺纹刀片 Internal threading insert



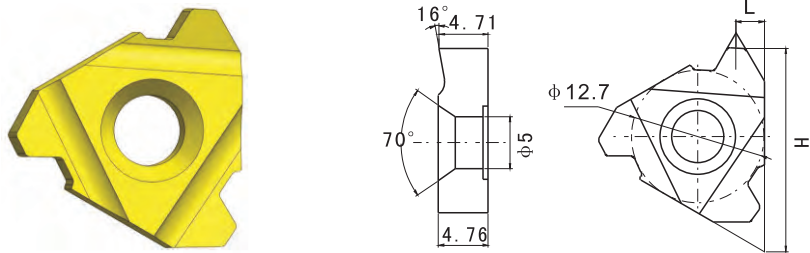
型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
B4Y1N3	4	1:6	V-0.038R	18.43	7.13	0124、0326
B4Y1N3-1T	4	1:16	V-0.038R	18.43	7.13	0124、0326
B4Y2N3	4	1:4	V-0.038R	18.43	7.13	0124、0326
B5Y3N3	5	1:4	V-0.040	18.58	7.13	0124、0326
B4Y4N3	4	1:4	V-0.050	18.43	7.13	0124、0326
B4Y5N3	4	1:6	V-0.050	18.43	7.13	0124、0326
B4Y5N3-1T	4	1:16	V-0.050	18.50	7.3	0124、0326

外螺纹刀片 External threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
22ER4PAC	4	1:8	V-0.076	19.5	2.7	0124、0326

内螺纹刀片 Internal threading insert



型号 Ordering code	每吋牙数 Teeth/Inch	锥度 Taper	扣型 Thread form	H	L	牌号 Grade
22NR4PAC	4	1:8	V-0.076	19.5	2.7	0124、0326



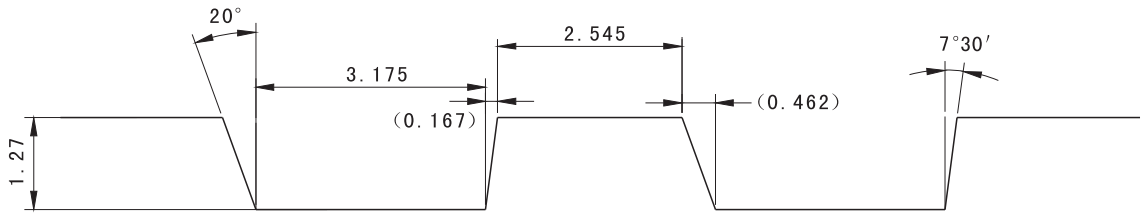
套铣管螺纹形式及参数
Type and date of milling pipe threading

套铣管螺纹刀片
Milling pipe threading inserts

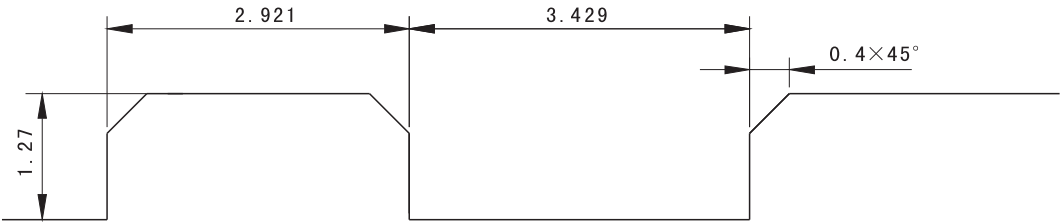
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套铣管螺纹形式 Type of milling pipe threading

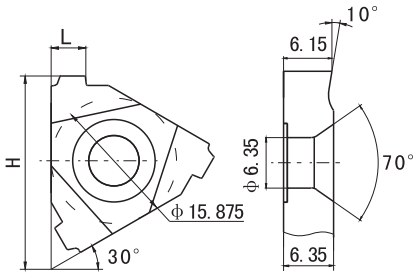
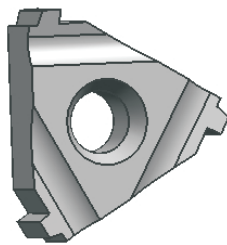
外螺纹刀片 External threading insert



双级偏梯形短齿同步螺纹(FJWP)牙型尺寸
Dimensions of two grade butress short tooth syn-thread(FJWP)

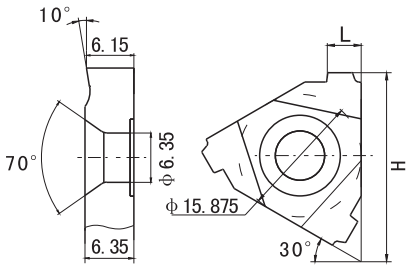
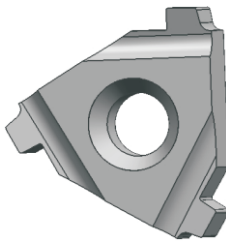


双级偏梯形短齿同步螺纹(TJWP)牙型尺寸
Dimensions of two grade regularity rectangle short tooth syn-thread (TSWP)



型号 Ordering code	每吋牙数 Teeth/Inch	扣型 Thread form	H	L	牌号 Grade
27E4FJWP3	4	FJWP	24. 55	4. 4	0124、0326

内螺纹刀片 Internal threading insert

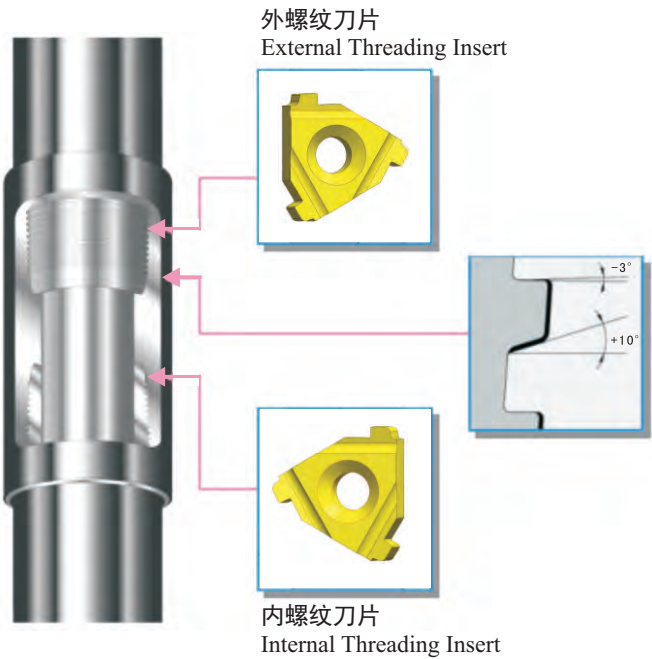


型号 Ordering code	每吋牙数 Teeth/Inch	扣型 Thread form	H	L	牌号 Grade
27N4FJWP3	4	FJWP	24. 55	4. 4	0124、0326
27N4TSWP3	4	TSWP	24. 55	4. 4	0124、0326



石油油管、套管特殊扣型螺纹

Special threading form of tube and casing for oil pipe



1、近几年来，根据石油管生产厂家开发生产特殊扣螺纹油井管的需要，先后成功研究开发了加工特殊扣型螺纹的内、外螺纹刀片。目前已生产供应的特殊扣型内、外螺纹刀片有数种(考虑到参与实验的用户的保密要求，暂未列入本样本)。

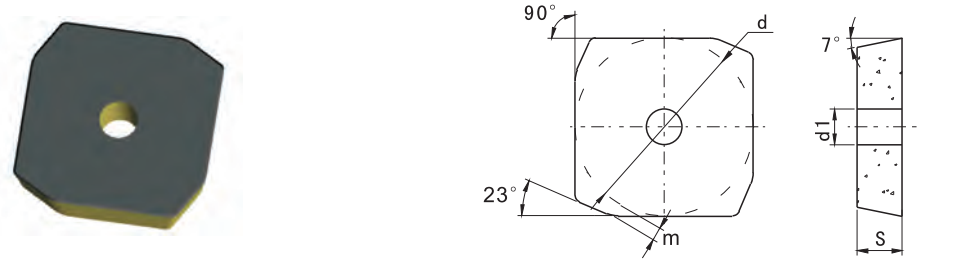
CTRI has successfully developed internal and external threading inserts to process special thread form according to oil pipe manufacturer's requirement for special form oil pipe recent years (Inserts are not listed in this brochure as confidential request from customers involved in the experiments).

2、成都工具研究所有限可可根据用户提供的特殊扣型样品实物或技术要求设计制造各种特殊扣型螺纹刀片，也可以根据协议明确双方责、权，共享技术成果。

CTRI is capable of design and manufacturing special thread form inserts according to samples or specific technical requirement. At the same time, we will definite rights and duty based on the negotiated agreement to share the technology achievements with customer.

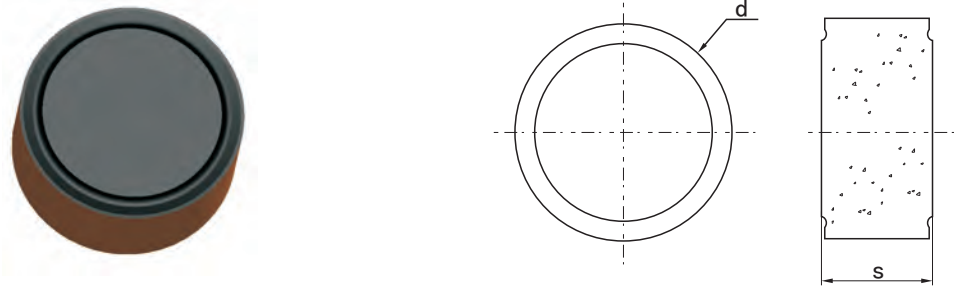
外圆，镗孔刀片

External turning insert, boring insert



型号 Ordering code	d	s	d1	m	牌号 Grade
C/26417	25	6.35	5	1.73	0350、5350

注：新版API型号为C/26417(30)，即C/26417中23° 为30° 。
P.S: The New API code is C/26417(30), means the 23° change to 30° .

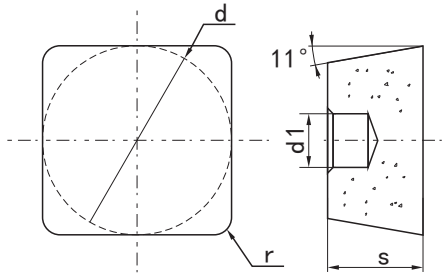


型号 Ordering code	d	s	牌号 Grade
TA3933A	15.875	7.94	0350、5350

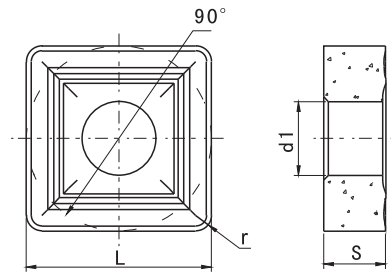


外圆，镗孔刀片

External turning insert, boring insert



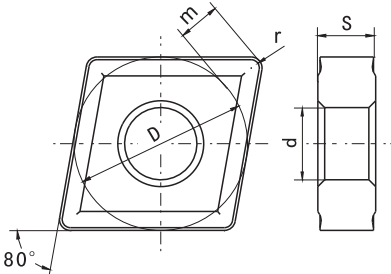
型号 Ordering code	d	s	d1	r	牌号 Grade
C/23931	15.95	8.01	4.23	1.6	0350、5350



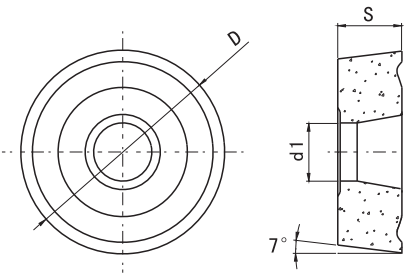
型号 Ordering code	L	d	s	d1	r	牌号 Grade
SNMM090308	9.525	9.525	3.8	3.18	0.8	0359
SNMG120412	12.7	12.7	4.76	5.16	1.2	0359
SNMM250724	25.4	25.4	7.64	9.12	2.4	0359
SNMG250924	25.4	25.4	9.525	9	2.4	0359

外圆，镗孔刀片

External turning insert, boring insert



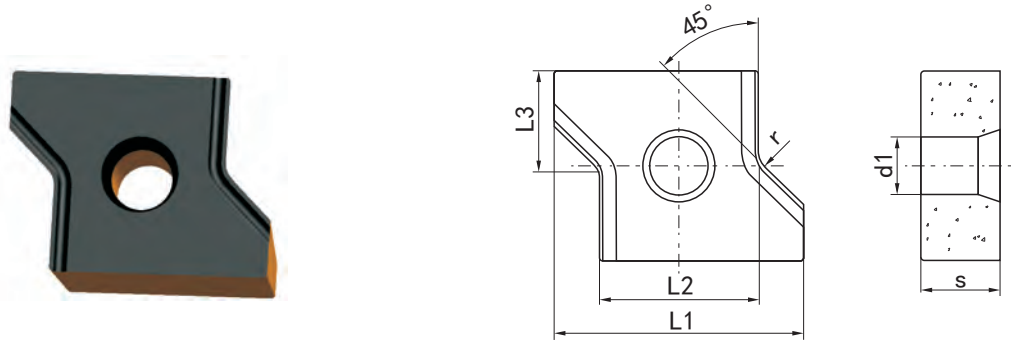
型号 Ordering code	L	d	s	d1	r	牌号 Grade
CNMG120404	12.9	12.7	4.76	5.16	0.4	0359
CNMG120408	12.9	12.7	4.76	5.16	0.8	0359



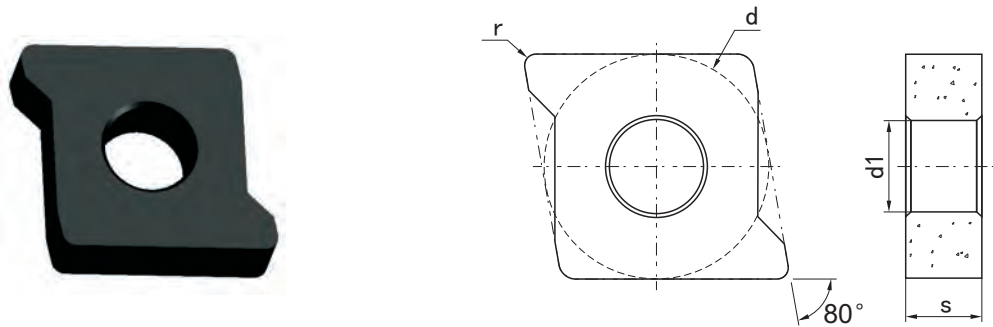
型号 Ordering code	D	s	d1	牌号 Grade
RCMX1606M0	16	6.35	5.2	0359



端面、倒角
Chamfer insert、Face turning insert

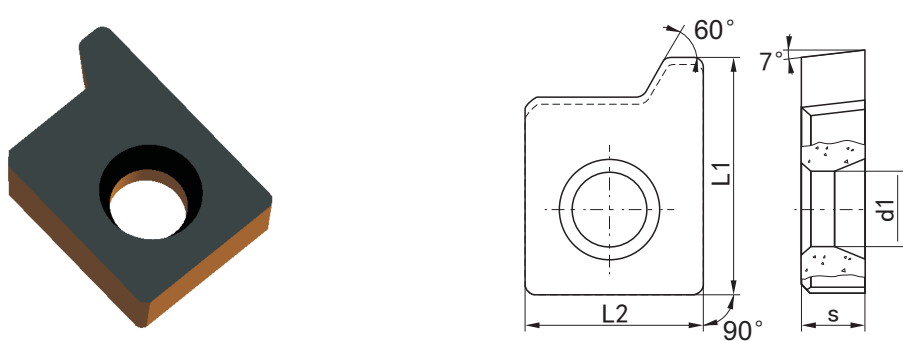


型号 Ordering code	L1	L2	L3	s	d1	r	牌号 Grade
C/32246B	25	16	9	7.94	5.74	2	0350、5350
C/32246/T	25	16.25	7.7	7.94	5.5	1.5	0350、5350

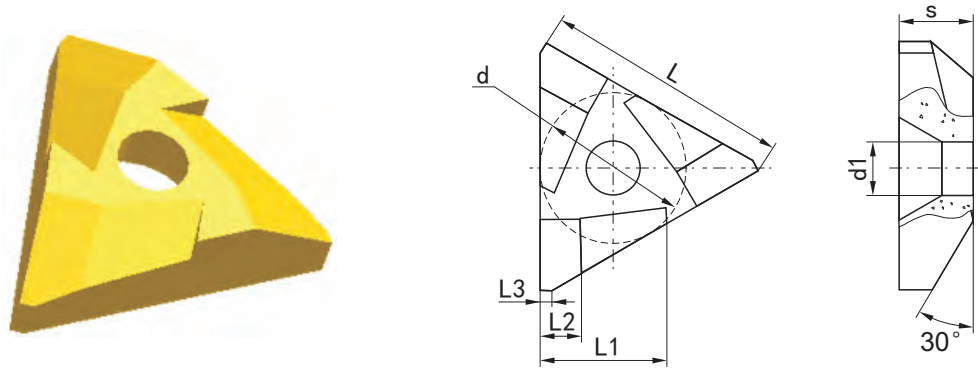


型号 Ordering code	d	s	d1	r	牌号 Grade
5.104060046E	19.05	6.35	7.9	1.2	0350、5350

端面、倒角
Chamfer insert、Face turning insert



型号 Ordering code	L1	L2	s	d1	牌号 Grade
C/20943	17.78	12.76	4.76	5.6	0350、5350

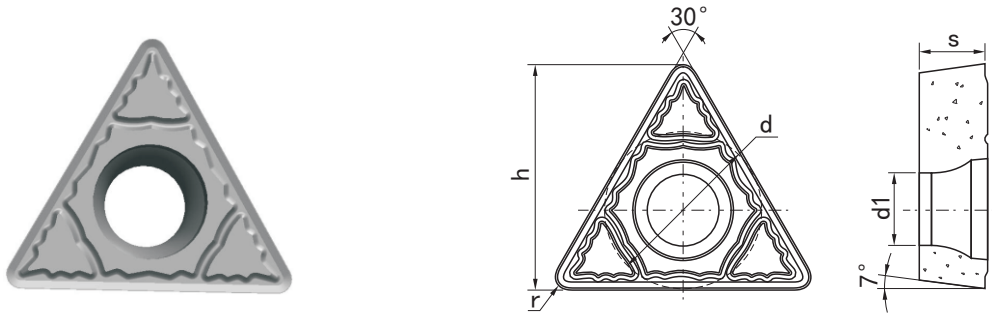


型号 Ordering code	L	L1	L2	L3	d	s	d1	牌号 Grade
TB4233N	33	16.2	5.3	1.4	19.05	9.6	6.8	0331、0359

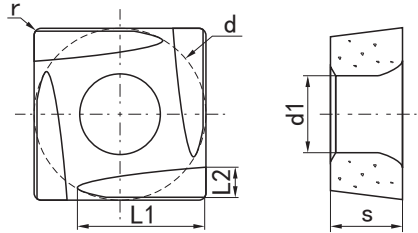


毛刺刀/铲齿刀

De-burring insert



型号 Ordering code	d	h	s	d1	r	牌号 Grade
TCMX16T308-FR	9.525	13.49	3.97	4.5	0.8	5364
TCMX16T304-FR	9.525	13.89	3.97	4.5	0.4	5364



型号 Ordering code	L1	L2	d	s	d1	r	牌号 Grade
SCEX09T304EL	7.17	1.88	9.525	3.97	4.4	0.4	0331、5331

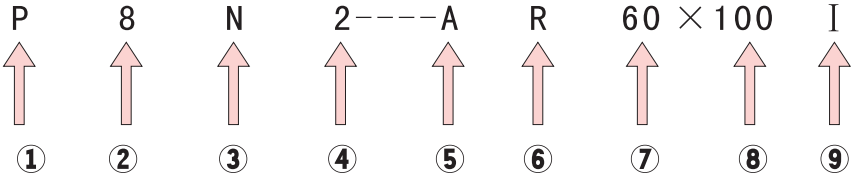
石油管螺纹加工刀杆型号标注说明

Oil pipe thread processing tool shank designation specification



例:

Example:

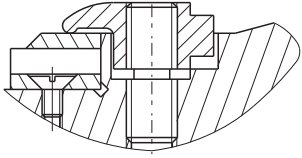
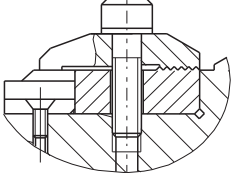
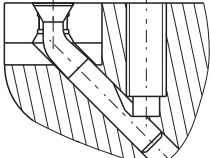
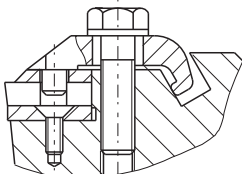
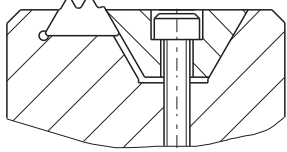
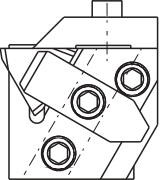


说明:

Specification:

①用M、C、P、J、F、G等字母分别表示不同类型的刀片夹紧方式，具体含义如下表：

Letters M、C、P、J、F、G means different inserts clamping, specific meanings are as follows:

夹紧形式 Clamping Type	钩形螺母压紧 Hook Shaped Screw Clamping	夹紧形式 Clamping Type	上压板压紧 Upper Clamping
夹紧代号 Clamping Code	M	夹紧代号 Clamping Code	C
 M：表示钩形螺母上压式 M means Hook Shaped Screw Upper Clamping Design		 C：表示锯齿形压板上压式 Saw Tooth Shaped Upper Clamping Design	
夹紧形式 Clamping Type	斜拉杆锥面压紧 oblique Rod Tapered Clamping	夹紧形式 Clamping Type	斜面双向压紧 Bevel Both Side Clamping
夹紧代号 Clamping Code	P	夹紧代号 Clamping Code	J
 P：表示斜拉杆内拉式锥面压紧 Oblique Rod Internal-Pulling Type Tapered Clamping Design		 J：表示带芯杆压板斜面双向压紧 Clamp with Core Rod Bevel Both Sides Clamping Design	
夹紧形式 Clamping Type	楔块斜面压紧 Wedge Bevel Clamping	夹紧形式 Clamping Type	侧面压板压紧 Lateral Clamping
夹紧代号 Clamping Code	F	夹紧代号 Clamping Code	G
 F：表示楔块斜面侧向压紧 Wedge Bevel Lateral Clamping Design		 G：表示立装刀片侧面压紧 Vertical Inserts Lateral Clamping Design	

②、③、④、⑨项数字或字母表示含义分别与刀片②、③、④、⑥相同。

2 3 4 9 numbers or letters mean the same inserts 2 3 4 6.



石油管螺纹加工刀杆型号标注说明

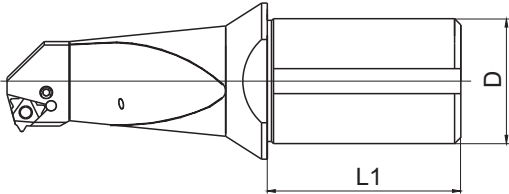
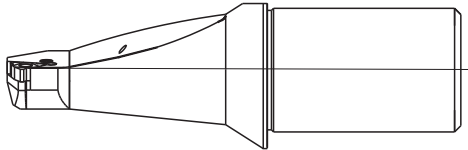
Oil pipe thread processing tool shank designation specification

⑤用字母A、B、C、D分别表示被加工的石油油管、套管、钻杆直径范围如下表：
5 Letters A B C D mean oil pipe, casing, and drill rod diameter ranges respectively:

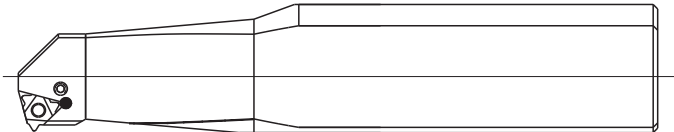
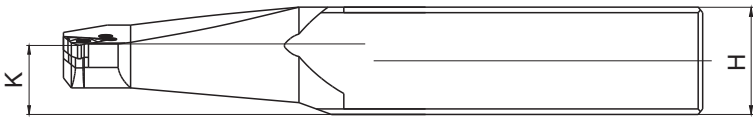
石油管材名称 Oil Pipe Materials Name	管材直径 Pipe Diameter			
	A类 (A Type)	B类 (B Type)	C类 (C Type)	D类 (D Type)
石油油管、套管 (加工V形圆螺纹) Oil Pipe Tube, Casing (to process V shaped round thread)	$2\frac{3}{8}"\sim 3\frac{1}{2}"$	$4"\sim 5\frac{1}{2}"$	$6\frac{5}{8}"\sim 8\frac{5}{8}"$	$9\frac{5}{8}"\sim 13\frac{3}{8}"$
石油钻杆 Oil Pipe Drill Rod	$2\frac{3}{8}"\sim 3\frac{1}{2}"$	$4"\sim 5\frac{1}{2}"$	$6\frac{5}{8}"\sim 8\frac{5}{8}"$	
石油套管 (加工偏梯形螺纹) Oil Pipe Casing (to process Buttress Thread)		$4\frac{1}{2}"\sim 6\frac{5}{8}"$	$7"\sim 11\frac{3}{4}"$	$9\frac{5}{8}"\sim 20"$

⑥用字母R或S分别表示内螺纹刀杆柄部截面形状。“R”表示圆柄，“S”表示方柄。外螺纹刀杆均为方柄，该项省略。
6 R and S mean cross section profile of internal threading tool shank. "R" means round bar, and "S" means square shank. External tool holders are all square shank.

⑦、⑧对于内螺纹刀杆，分别表示刀杆柄部直径D和长度L1(圆柄)，或者刀杆柄部高度H和刀尖至刀杆柄部底面的高度K(方柄)。若外螺纹刀杆即表示刀杆柄部高度H和刀尖至刀杆柄部底面的高度K。(见图)
For internal thread tool shank, 7 and 8 mean diameter of tool shank D and length L (round bar), or tool holder Height H and height K from insert tip to bottom of tool shank (square shank). If it is for external threading tool holder, it means tool shank height H and height K from insert tip to bottom of tool shank. (See below pictures)



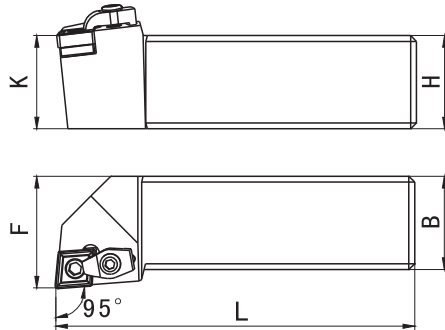
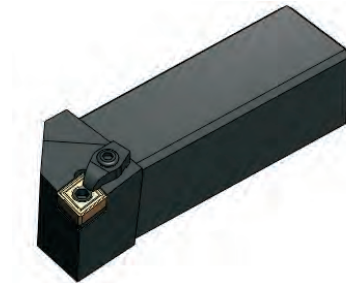
圆形内螺纹刀杆 Round Internal Thread Holder



方形内螺纹刀杆 Square Internal Thread Holder

外圆刀杆

Tool shank for external turning inserts



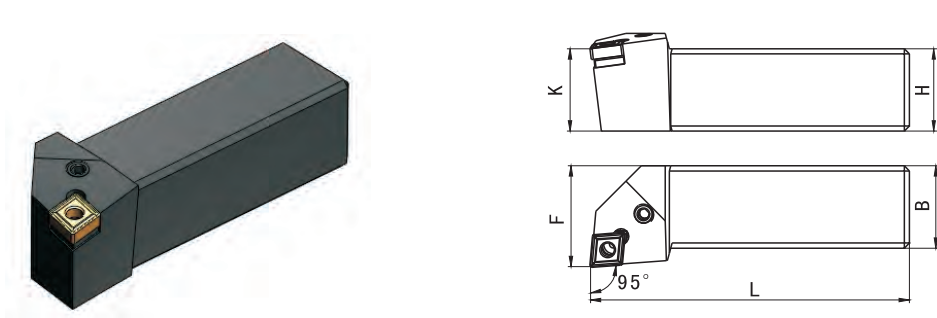
刀杆型号 Ordering code	尺寸 Dimension				
	K	B	F	H	L
MCLNR/L 2525 M16	25	25	32	25	150
MCLNR/L 3225 P16	32	25	32	32	170
MCLNR/L 3232 P16	32	32	40	32	170
MCLNR/L 4040 S16	40	40	48	40	250

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	CNMG160608	C16B-7.8	YMA-15	SLX-6	S3/S4



外圆刀杆

Tool shank for external circle turning inserts

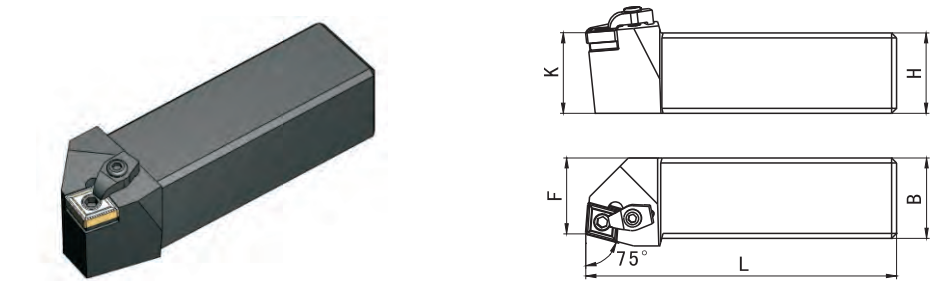


刀杆型号 Ordering code	尺寸 Dimension				
	K	B	F	H	L
PCLNR/L 2525 M16	25	25	32	25	150
PCLNR/L 3225 P16	32	32	32	32	170
PCLNR/L 3232 P16	32	32	40	32	170
PCLNR/L 4040 S16	40	40	48	40	250

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	压紧螺钉 Clamp bolt	扳手 Wrench
图例 Pic.						
型号 Ordering code	CNMG160608	C16A-8.1	G0516	HT0606	YLB8-20	S3

外圆刀杆

Tool shank for external circle turning inserts



刀杆型号 Ordering code	尺寸 Dimension				
	K	B	F	H	L
MCBNR/L 2525 M16	25	25	22	25	150
MCBNR/L 3225 P16	32	25	22	32	170
MCBNR/L 3232 P16	32	32	28	32	170
MCBNR/L 4040 S16	40	40	35	40	250

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	CNMG160608	C16B-7.8	YMA-15	SLX-6	S3/S4

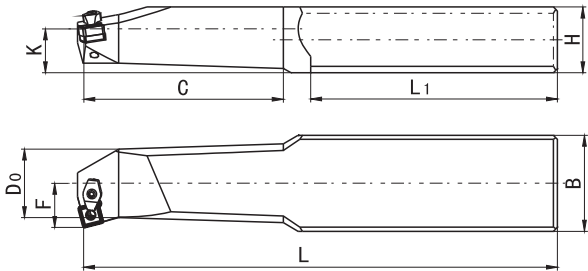
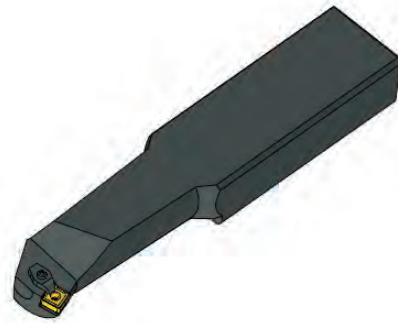
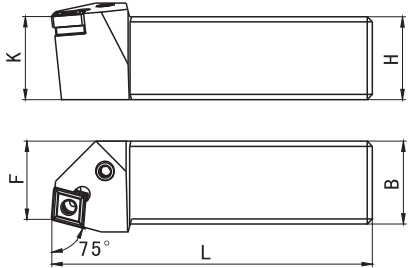
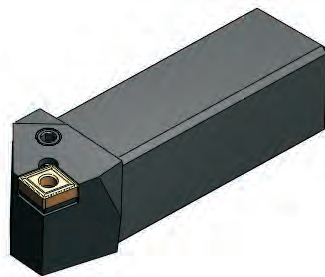


外圆刀杆

Tool shank for external circle turning inserts

镗孔刀杆

Tool shank for boring inserts



刀杆型号 Ordering code	尺寸 Dimension				
	K	B	F	H	L
PCBNR/L 2525 M16	25	25	22	25	150
PCBNR/L 3225 P16	32	25	22	32	170
PCBNR/L 3232 P16	32	32	28	32	170
PCBNR/L 4040 S16	40	40	35	40	250

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	压紧螺钉 Clamp bolt	扳手 Wrench
图例 Pic.						
型号 Ordering code	CNMG160608	C16A-8.1	G0516	HT0606	YLB8-20	S3

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension								适用机床 Machine tool
			L	L ₁	H	C	K	D ₀	F	B	
A	MSKNR15-AS40×25	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	275	150	40	100	25	42	26	65.8	C620改
	MSKNR15-AS48×32		305	180	48	100	32	42	26	74.3	QK1312 Q1319
B	MSKNR15-BS48×32	4"~5 $\frac{1}{2}$ "	335	180	48	130	32	50	32	74.3	
	MSKNR15-BS55×36		355	200	55	130	36	50	32	75	S1-262 QK1312
C	MSKNR15-CS48×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	358	180	48	158	32	56	36	74.3	
	MSKNR15-AS55×36		378	200	55	158	36	56	36	77.2	S1-262 S1-245
D	MSKNR15-DS55×36	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	395	200	55	175	36	60	43	81.5	

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	SNMG150616	S15B-7.8	YMA-15	SLX-6	S3/S4



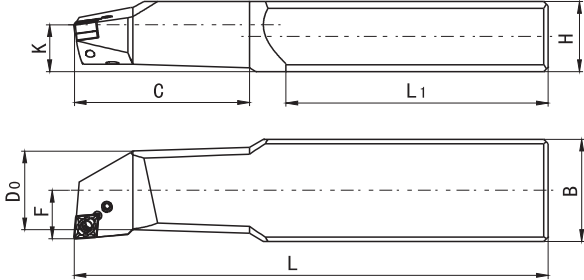
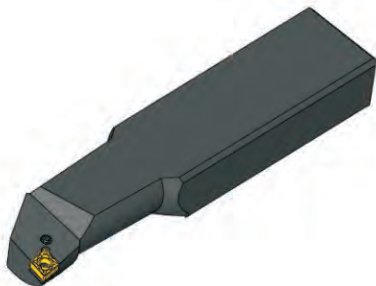
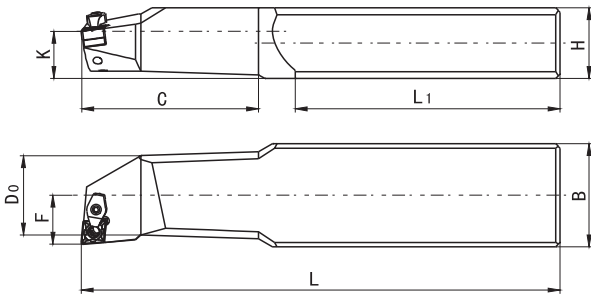
镗孔刀杆

Tool shank for boring inserts

镗孔刀杆

Tool shank for boring inserts

C



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension								适用机床 Machine tool
			L	L ₁	H	C	K	D ₀	F	B	
A	MCLNR16-AS40×25	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	275	150	40	100	25	42	26	65.8	C620改
	MCLNR16-AS48×32		305	180	48	100	32	42	26	74.3	QK1312 Q1319
B	MCLNR16-BS48×32	4"~5 $\frac{1}{2}$ "	335	180	48	130	32	50	32	74.3	
	MCLNR16-BS55×36		355	200	55	130	36	50	32	75	S1-262 QK1312
C	MCLNR16-CS48×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	358	180	48	158	32	56	36	74.3	
	MCLNR16-AS55×36		378	200	55	158	36	56	36	77.2	S1-262 S1-245
D	MCLNR16-DS55×36	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	395	200	55	175	36	60	43	81.5	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension								适用机床 Machine tool
			L	L ₁	H	C	K	D ₀	F	B	
A	PCLNR16-AS40×25	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	275	150	40	100	25	42	26	65.8	C620改
	PCLNR16-AS48×32		305	180	48	100	32	42	26	74.3	QK1312 Q1319
B	PCLNR16-BS48×32	4"~5 $\frac{1}{2}$ "	335	180	48	130	32	50	32	74.3	
	PCLNR16-BS55×36		355	200	55	130	36	50	32	75	S1-262 QK1312
C	PCLNR16-CS48×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	358	180	48	158	32	56	36	74.3	
	PCLNR16-AS55×36		378	200	55	158	36	56	36	77.2	S1-262 S1-245
D	PCLNR16-DS55×36	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	395	200	55	175	36	60	43	81.5	

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	CNMG160608	C16B-7.8	YMA-15	SLX-6	S3/S4

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	压紧螺钉 Clamp bolt	扳手 Wrench
图例 Pic.						
型号 Ordering code	CNMG160608	C16A-8.1	G0516	HT0606	YLB8-20	S3

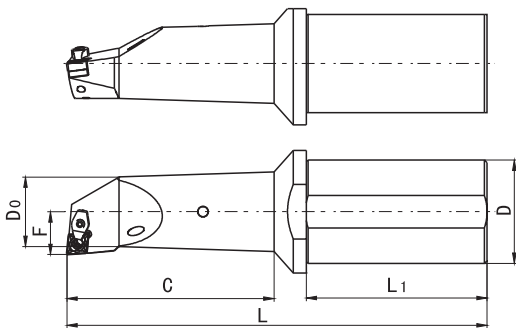
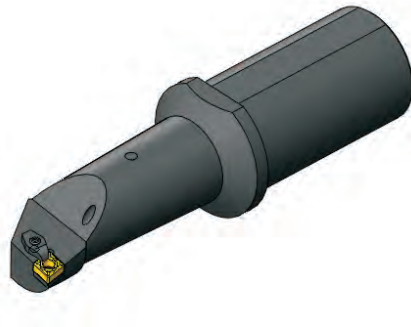
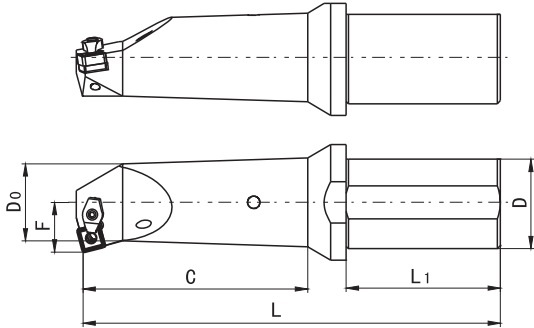
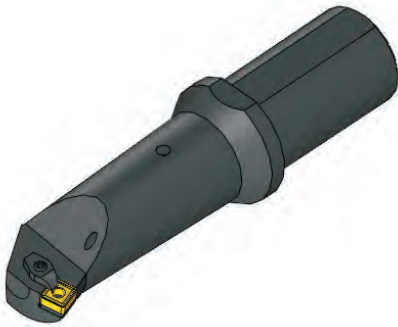


镗孔刀杆

Tool shank for boring inserts

镗孔刀杆

Tool shank for boring inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						适用机床 Machine tool
			L	L ₁	D	D ₀	C	F	
A	MSKNR15-AR40×80	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	205	80	40	26	100	26	CK7815 CK7620
	MSKNR15-AR50×90		215	90	50	26	100	26	CK7832 CK3263A
	MSKNR15-AR60×100		225	100	60	26	100	26	CK7840
	MSKNR15-AR80×140		265	140	80	26	100	26	CK3263B
B	MSKNR15-BR40×80	4"~5 $\frac{1}{2}$ "	235	80	40	31	130	32	CK7815 CK7620
	MSKNR15-BR50×90		245	90	50	31	130	32	CK7832 CK3263A
	MSKNR15-BR60×100		255	100	60	31	130	32	CK7840
	MSKNR15-BR80×140		295	140	80	31	130	32	CK3263B
C	MSKNR15-CR60×100	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	278	100	60	36	158	36	CK7840
	MSKNR15-CR80×140		318	140	80	36	158	36	CK3263B
D	MSKNR15-DR60×100	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	295	100	60	43	175	43	CK7840
	MSKNR15-DR80×140		335	140	80	43	175	43	CK3263B

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						适用机床 Machine tool
			L	L ₁	D	D ₀	C	F	
A	MCLNR16-AR40×80	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	205	80	40	26	100	26	CK7815 CK7620
	MCLNR16-AR50×90		215	90	50	26	100	26	CK7832 CK3263A
	MCLNR16-AR60×100		225	100	60	26	100	26	CK7840
	MCLNR16-AR80×140		265	140	80	26	100	26	CK3263B
B	MCLNR16-BR40×80	4"~5 $\frac{1}{2}$ "	235	80	40	31	130	32	CK7815 CK7620
	MCLNR16-BR50×90		245	90	50	31	130	32	CK7832 CK3263A
	MCLNR16-BR60×100		255	100	60	31	130	32	CK7840
	MCLNR16-BR80×140		295	140	80	31	130	32	CK3263B
C	MCLNR16-CR60×100	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	278	100	60	36	158	36	CK7840
	MCLNR16-CR80×140		318	140	80	36	158	36	CK3263B
D	MCLNR16-DR60×100	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	295	100	60	43	175	43	CK7840
	MCLNR16-DR80×140		335	140	80	43	175	43	CK3263B

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	SNMG150608	S15B-7.8	YMA-15	SLX-6	S3/S4

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	CNMG160608	C16B-7.8	YMA-15	SLX-6	S3/S4



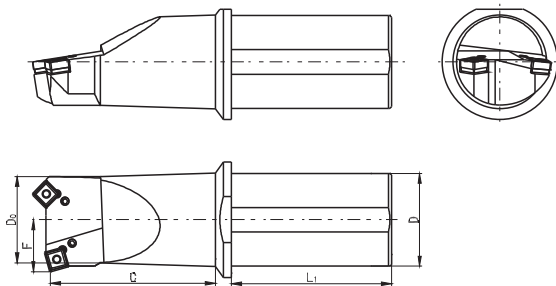
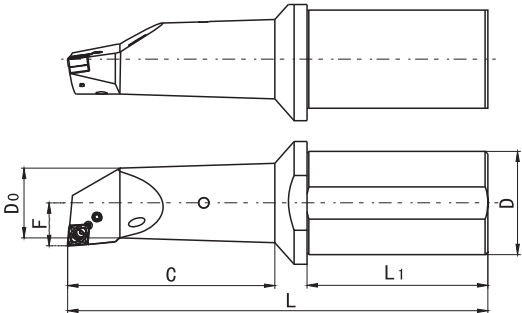
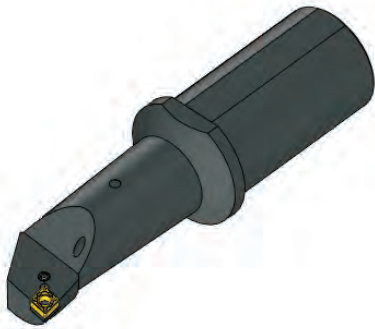
镗孔刀杆

Tool shank for boring inserts

镗孔端面圆柄复合刀杆

Complex round shank holder for boring hole and end facing

C



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						适用机床 Machine tool
			L	L ₁	D	D ₀	C	F	
A	PCLNR16-AR40×80	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	205	80	40	26	100	26	CK7815 CK7620
	PCLNR16-AR50×90		215	90	50	26	100	26	CK7832 CK3263A
	PCLNR16-AR60×100		225	100	60	26	100	26	CK7840
	PCLNR16-AR80×140		265	140	80	26	100	26	CK3263B
B	PCLNR16-BR40×80	4"~5 $\frac{1}{2}$ "	235	80	40	31	130	32	CK7815 CK7620
	PCLNR16-BR50×90		245	90	50	31	130	32	CK7832 CK3263A
	PCLNR16-BR60×100		255	100	60	31	130	32	CK7840
	PCLNR16-BR80×140		295	140	80	31	130	32	CK3263B
C	PCLNR16-CR60×100	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	278	100	60	36	158	36	CK7840
	PCLNR16-CR80×140		318	140	80	36	158	36	CK3263B
D	PCLNR16-DR60×100	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	295	100	60	43	175	43	CK7840
	PCLNR16-DR80×140		335	140	80	43	175	43	CK3263B

刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension					
		L	L ₁	D ₀	D	C	F
PSKNR12/12-AR80X140 (A1)	2 $\frac{3}{8}$ "	274.5	140	42	80	100	26.3
PSKNR12/12-AR80X140 (A2)	2 $\frac{7}{8}$ "~3 $\frac{1}{2}$ "	284.5	140	54	80	110	32.3

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	杠杆螺钉 Lever screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	SNMG120408	S12BP	LC4	MCS821	S3

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	压紧螺钉 Clamp bolt	扳手 Wrench
图例 Pic.						
型号 Ordering code	CNMG160608	C16A-8.1	G0516	HT0606	YLB8-20	S3



蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts

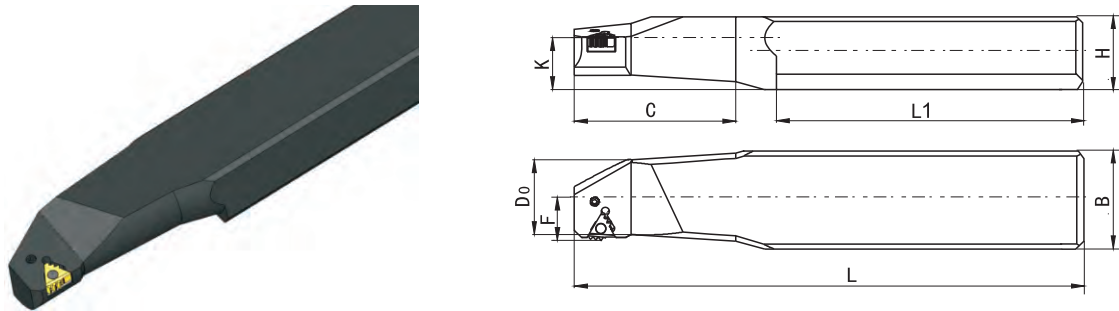
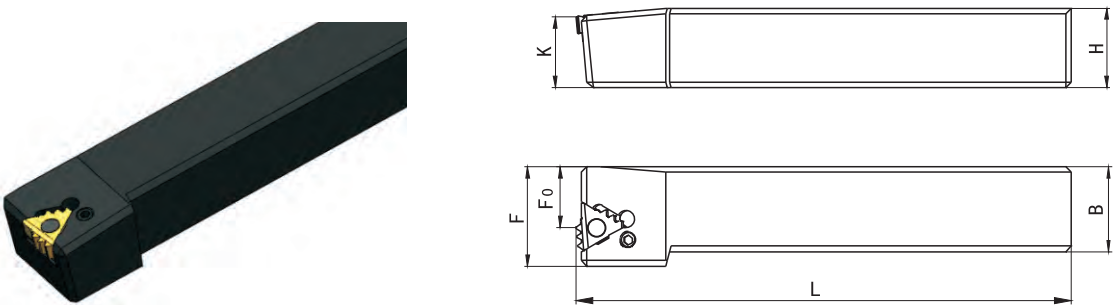
蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts



蝶形圆扣外螺纹刀片用刀杆 Tool shank for papilionaceous round external threading inserts

蝶形圆扣内螺纹刀片用方柄刀杆 Square tool shank for papilionaceous round internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
A	P10(8)W2-A28×25	2 ³ / ₈ "~3 ¹ / ₂ "	175	28	25	30	35	22	70'	C620改
	P10(8)W2-A35×32		175	35	32	35	40	27	70'	Qk1312
	P10(8)W2-A40×40		175	40	40	40	45	30	70'	
B	P10(8)W2-B35×32	4"~5 ¹ / ₂ "	175	35	32	35	40	27	50'	
	P10(8)W2-B40×40		175	40	40	40	45	30	50'	Q1319
C	P10(8)W2-C35×32	6 ⁵ / ₈ "~8 ⁵ / ₈ "	175	35	32	35	40	27	30'	S1-344
	P10(8)W2-C40×40		175	40	40	40	45	30	30'	S1-189
D	P10(8)W2-D35×32	9 ⁵ / ₈ "~13 ³ / ₈ "	175	35	32	35	40	27	15'	
	P10(8)W2-D40×40		175	40	40	40	45	30	15'	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
A	P10(8)N2-AS40×25	2 ³ / ₈ "~3 ¹ / ₂ "	275	150	40	100	25	26	42	65	70′	C620改
	P10(8)N2-AS48×32		305	180	48	100	32	26	42	74	70′	Qk1312 Q1319
	P10(8)N2-AS48×32(A1)	2 ³ / ₈ "	265	140	48	85	32	26.5	45	74	70′	
	P10(8)N2-AS48×32(A2)	2 ⁷ / ₈ "~3 ¹ / ₂ "	275	140	48	95	32	30.5	50	74	70′	
B	P10(8)N2-BS48×32	4"~5 ¹ / ₂ "	335	180	48	130	32	31	50	74	50′	Qk1312 Q1319
	P10(8)N2-BS55×36		335	200	55	130	36	31	50	77	50′	S1-262 S1-245 QK1312 Q1319
C	P10(8)N2-CS48×32	6 ⁵ / ₈ "~8 ⁵ / ₈ "	358	180	48	158	32	36	56	74	30′	
	P10(8)N2-CS55×36		378	200	55	158	36	36	56	77	30′	
D	P10(8)N2-DS55×36	9 ⁵ / ₈ "~13 ³ / ₈ "	395	200	55	175	36	43	60	81	15′	

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B8W2-3H B10W2-4H	169.798	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B8N2-3H B10N2-4H	169.523	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3



蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts

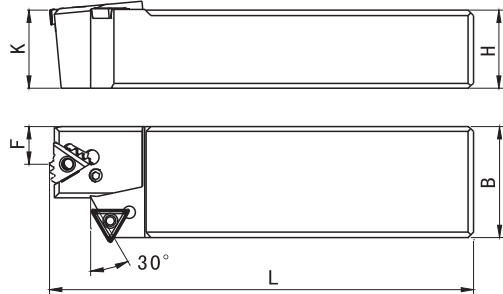
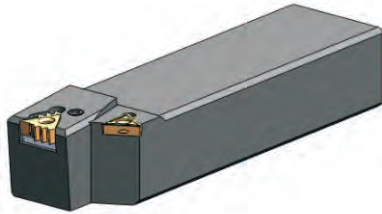
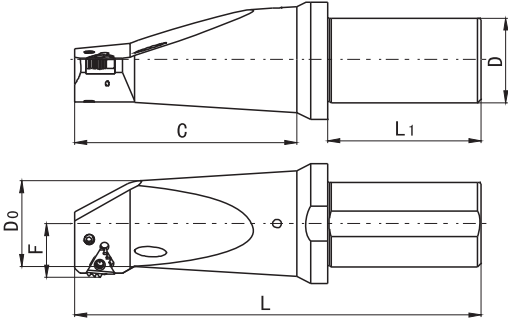
蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts



蝶形圆扣内螺纹刀片用圆柄刀杆 Round tool shank for papilionaceous round internal threading inserts

蝶形圆扣外螺纹刀片用复合刀杆 Multi-duty tool shank for papilionaceous round external threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
A	P10 (8) N2-AR40×80	2 ³ / ₈ "~3 ¹ / ₂ "	205	80	40	100	42	26	70'	CK7815 CK7620
	P10 (8) N2-AR50×90		215	90	50	100	42	26	70'	CK7832 CK3263A
	P10 (8) N2-AR60×100		225	100	60	100	42	26	70'	CK7840
	P10 (8) N2-AR80×140		265	140	80	100	42	26	70'	CK3263B
	P10 (8) N2-AR60×140 (A1)	2 ³ / ₈ "	265	140	60	85	45	26.5	70'	
	P10 (8) N2-AR60×140 (A2)	2 ⁷ / ₈ "~3 ¹ / ₂ "	275	140	60	95	50	30.5	70'	
B	P10 (8) N2-BR40×80	4"~5 ¹ / ₂ "	235	80	40	130	50	31	50'	CK7815 CK7620
	P10 (8) N2-BR50×90		245	90	50	130	50	31	50'	CK7832 CK3263A
	P10 (8) N2-BR60×100		255	100	60	130	50	31	50'	CK7840
	P10 (8) N2-BR80×140		295	140	80	130	50	31	50'	CK3263B
C	P10 (8) N2-CR50×90	6 ⁵ / ₈ "~8 ⁵ / ₈ "	268	90	50	158	56	36	30'	CK7840
	P10 (8) N2-CR60×100		278	100	60	158	56	36	30'	CK3263B
	P10 (8) N2-CR80×140		318	140	80	158	56	36	30'	CK7832 CK3263A
D	P10 (8) N2-DR60×100	9 ⁵ / ₈ "~13 ³ / ₈ "	295	100	60	175	60	43	15'	CK7840
	P10 (8) N2-DR80×140		335	140	80	175	60	43	15'	CK3263B

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension					
			L	H	K	F	B	λ
A	P10 (8) W2-A32X-TCMX	2 ³ / ₈ "~3 ¹ / ₂ "	170	31.5	32	15	45	70'
B	P10 (8) W2-B32X-TCMX	4"~5 ¹ / ₂ "	170	31.5	32	15	45	50'
C	P10 (8) W2-C32X-TCMX	6 ⁵ / ₈ "~8 ⁵ / ₈ "	170	31.5	32	15	45	30'
D	P10 (8) W2-D32X-TCMX	9 ⁵ / ₈ "~13 ³ / ₈ "	170	31.5	32	15	45	15'

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B8N2-3H B10N2-4H	169.523	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod
图例 Pic.			
型号 Ordering code	B8W2-3H/B10W2-4H	TCMT16T308 169.798	Φ4 斜拉杆 Φ4 Oblique rod

配件 Accessory	顶丝 Lock screw	梅花头螺钉 Screw	扳手 Wrench	扳手 Wrench
图例 Pic.				
型号 Ordering code	M6	M4×12	T15	S3



蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts

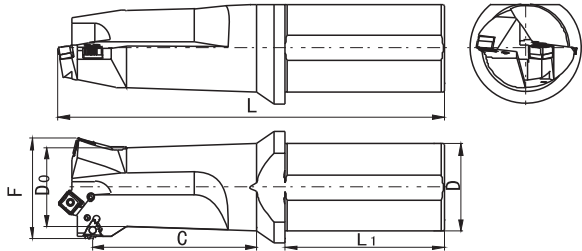
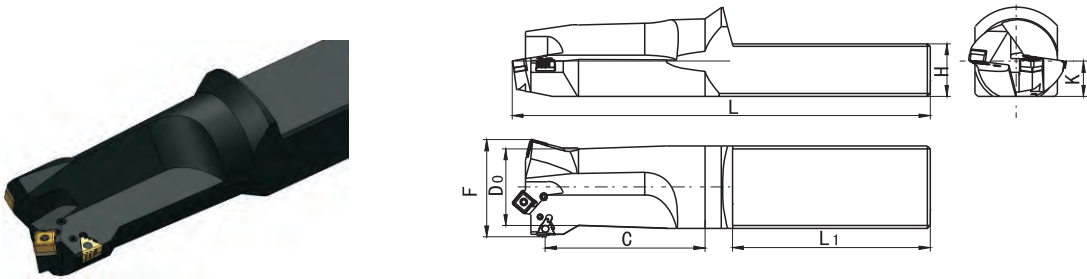
蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts



蝶形圆扣螺纹刀片用方柄复合刀杆
Square multiduty tool shank for papilionaceous round internal threading inserts

蝶形圆扣螺纹刀片用圆柄复合刀杆
Round multiduty tool shank for papilionaceous round internal threading inserts



刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							
		L	L ₁	D ₀	H	K	C	F	λ
P10(8)-PSN12/12-BS48X32	3 $\frac{1}{2}$ "~4 $\frac{1}{2}$ "	274	140	50	48	32	82.5	63	60°
P10(8)-PSN15/15-CS48X32	4 $\frac{1}{2}$ "~7"	400	200	70	48	32	145	98.5	50°
P10(8)-PSN15/15-DS48X32	7"以上	415	200	84	48	32	159	102.6	30°

刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
		L	L ₁	D ₀	D	C	F	λ
P10(8)-PSN12/12-BR80X140	3 $\frac{1}{2}$ "~4 $\frac{1}{2}$ "	274	140	50	80	82.5	63	60°
P10(8)-PSN15/15-CR80X200	4 $\frac{1}{2}$ "~7"	400	200	70	80	145	98.5	50°
P10(8)-PSN15/15-DR80X200	7" 以上	415	200	84	80	159	102.6	30°

配件 Accessory	刀片 Insert		刀垫 Shim	杠杆 Lever	杠杆螺钉 Lever screw	斜拉杆 Oblique rod	顶丝 Lock screw
图例 Pic.							
型号 Ordering code	B8N2-3H	SNMG120408 SNMG150608	169.523	S12BP S15BP	LC4 LC5	MCS821 MCS825	Φ4 斜拉杆 Φ4 Oblique rod

配件 Accessory	刀片 Insert		刀垫 Shim	杠杆 Lever	杠杆螺钉 Lever screw	斜拉杆 Oblique rod	顶丝 Lock screw
图例 Pic.							
型号 Ordering code	B8N2-3H	SNMG120408 SNMG150608	169.523	S12BP S15BP	LC4 LC5	MCS821 MCS825	Φ4 斜拉杆 Φ4 Oblique rod

※所使用扳手为S3
※Wrench applied is S3

※所使用扳手为S3
※Wrench applied is S3



蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts

蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts

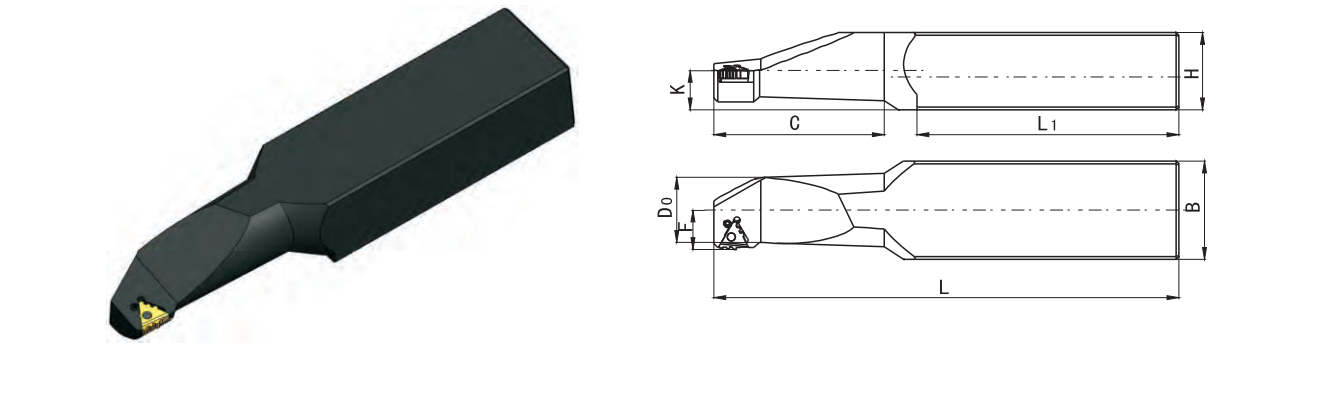
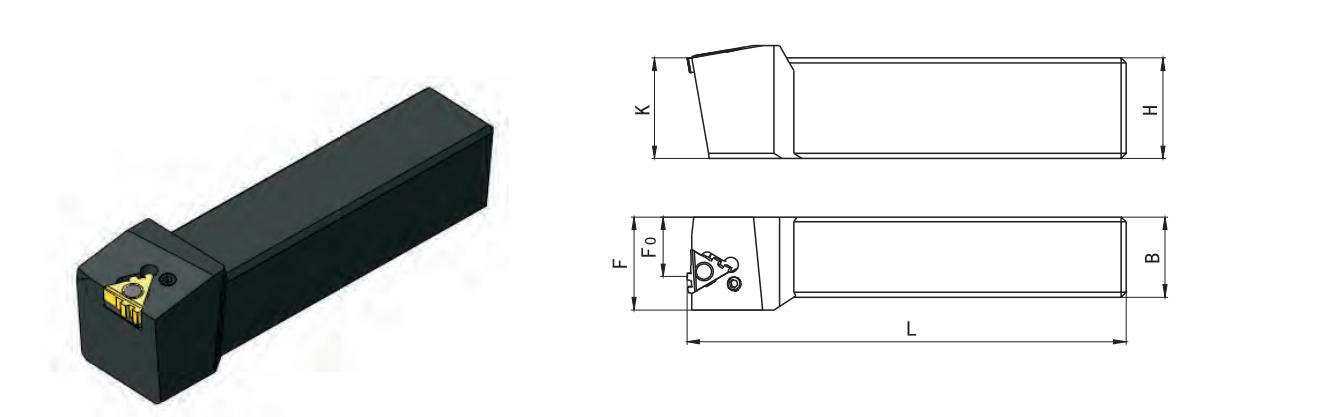


蝶形偏梯外螺纹刀片用刀杆

Tool shank for papilionaceous buttress external threading inserts

蝶形偏梯内螺纹刀片用刀杆

Square tool shank for papilionaceous buttress internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
B	P5BW2-B35×32	4"~5 $\frac{1}{2}$ "	175	35	32	35	40	25	60'	QK1312 S1-245 S1-127
C	P5BW2-C35×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	175	35	32	35	40	25	40'	
D	P5BW2-D35×32	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	175	35	32	35	40	25	20'	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
B	P5BN2-BS48×32	4"~5 $\frac{1}{2}$ "	335	180	48	130	32	31	50	74	60′	S1-127 S1-344
	P5BN2-BS55×36		355	200	55	130	36	31	50	77	60′	S1-262 S1-245
C	P5BN2-CS48×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	358	180	48	158	32	36	56	74	40′	S1-127 S1-344
	P5BN2-CS55×36		378	200	55	158	36	36	56	77	40′	S1-245 S1-262
D	P5BN2-DS55×36	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	395	200	55	175	36	43	60	81	20′	

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B5BW2-2	169. 798	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B5BN2-3	169. 973	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3



蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts

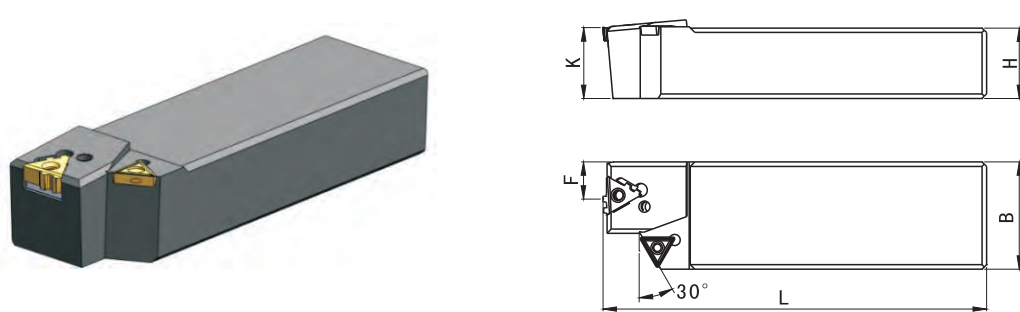
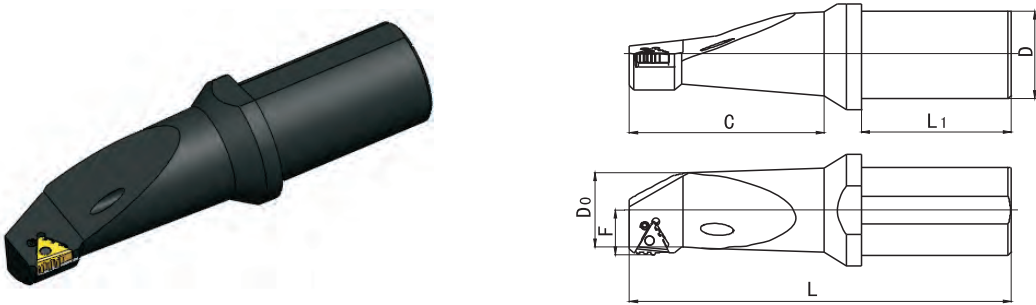
蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts



蝶形偏梯内螺纹刀片用圆柄刀杆
Round tool shank for papilionaceous buttress internal threading inserts

蝶形偏梯外螺纹刀片用复合刀杆
Multiduty tool shank for papilionaceous buttress external threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
B	P5BN2-BR50×90	4 $\frac{1}{2}$ "~6 $\frac{5}{8}$ "	245	90	50	130	50	31	60'	CK7820 CK7832
	P5BN2-BR60×100		255	100	60	130	50	31	60'	CK7840 S1-181
	P5BN2-BR80×140		295	140	80	130	50	31	60'	CK3263
C	P5BN2-CR60×100	7"~11 $\frac{3}{4}$ "	283	100	60	158	56	36	40'	CK7820 CK7832
	P5BN2- CR80×140		323	140	80	158	56	36	40'	CK3263
D	P5BN2- DR60×100	13 $\frac{3}{8}$ "~20"	300	100	60	175	60	43	20'	CK7840 S1-181
	P5BN2- Dr80×140		340	140	80	175	60	43	20'	Ck3263

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension					
			L	H	K	F	B	λ
B	P5BW2-B32X-TCMX	4 $\frac{1}{2}$ "~6 $\frac{5}{8}$ "	170	31.5	32	15	45	60'
C	P5BW2-C32X-TCMX	7"~11 $\frac{3}{4}$ "	170	31.5	32	15	45	40'
D	P5BW2-D32X-TCMX	13 $\frac{3}{8}$ "~20"	170	31.5	32	15	45	20'

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B5BN2-3	169. 973	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3

配件 Accessory	刀片 Insert		刀垫 Shim	斜拉杆 Oblique rod
图例 Pic.				
型号 Ordering code	B5BW2-2		169. 798	Φ4 斜拉杆 Φ4 Oblique rod

配件 Accessory	顶丝 Lock screw	梅花头螺钉 Screw	扳手 Wrench	扳手 Wrench
图例 Pic.				
型号 Ordering code	M6	M4×12	T15	S3



蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts

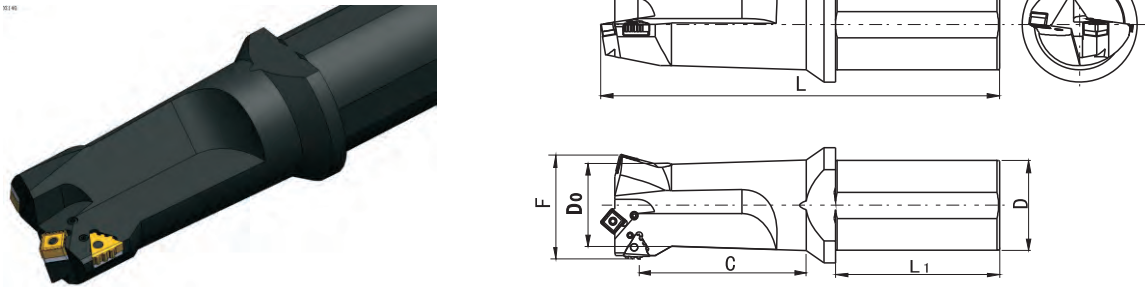
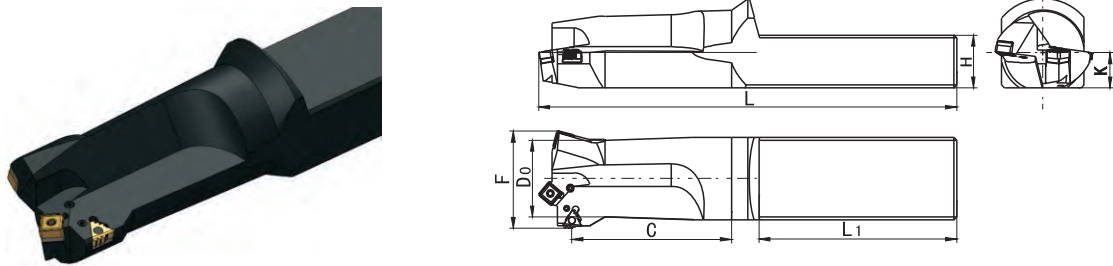
蝶形螺纹刀片用刀杆

Tool shank for papilionaceous threading inserts



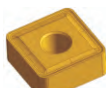
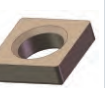
蝶形梯扣螺纹刀片用方柄复合刀杆
Square multiduty tool shank for papilionaceous buttress internal threading inserts

蝶形偏梯内螺纹刀片用圆柄复合刀杆
Round multiduty tool shank for papilionaceous buttress internal threading inserts



刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							
		L	L ₁	D ₀	H	K	C	F	λ
P5B-PSN15/15-CS48X32	4 $\frac{1}{2}$ "~7"	400	200	70	48	32	145	98.5	50'
P5B-PSN15/15-DS48X32	7" 以上	415	200	84	48	32	159	102.6	30'

刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
		L	L ₁	D ₀	D	C	F	λ
P5B-PSN15/15-CR80X200	4 $\frac{1}{2}$ "~7"	400	200	70	80	145	98.5	50'
P5B-PSN15/15-DR80X200	7" 以上	415	200	84	80	159	102.6	30'

配件 Accessory	刀片 Insert		刀垫 Shim		杠杆 Lever	杠杆螺钉 Lever screw	斜拉杆 Oblique rod	顶丝 Lock screw
图例 Pic.								
型号 Ordering code	B5BN2-3H	SNMG120408 SNMG150608	169.973	S12BP S15BP	LC4 LC5	MCS821 MCS825	Φ4 斜拉杆 Φ4 Oblique rod	M6 斜拉杆顶丝

配件 Accessory	刀片 Insert		刀垫 Shim	杠杆 Lever	杠杆螺钉 Lever screw	斜拉杆 Oblique rod	顶丝 Lock screw
图例 Pic.							
型号 Ordering code	B5BN2-3H	SNMG120408 SNMG150608	169.973	S12BP S15BP	LC4 LC5	MCS821 MCS825	Φ4 斜拉杆 Φ4 Oblique rod

※所使用扳手为S3
※Wrench applied is S3

※所使用扳手为S3
※Wrench applied is S3



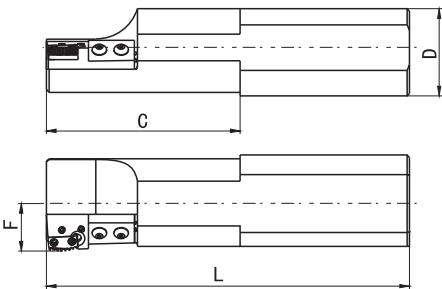
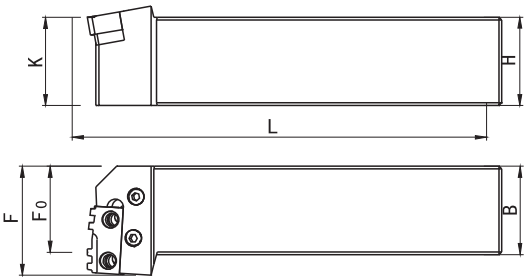
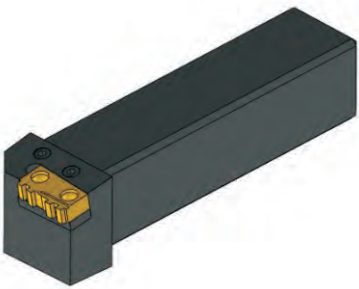
双孔系列螺纹刀片用刀杆
Tool shank for double-hole series threading inserts

双孔系列螺纹刀片用刀杆
Tool shank for double-hole series threading inserts



双孔刀片系列外螺纹刀杆
Tool shank for double-hole series external threading inserts

双孔刀片系列内螺纹刀杆
Tool shank for double-hole series internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	B	K	F	F ₀	λ	
A	DP8 (5B) W2-A32×32	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	175	32	32	32	39	31	70'	QK1312 S1-344B S1-245 S1-262 S1-127
	DP8 (5B) W2-A40×40		175	40	40	40	47	39	70'	
B	DP8 (5B) W2-B32×32	4"~5 $\frac{1}{2}$ "	175	32	32	32	39	31	50'	
	DP8 (5B) W2-B40×40		175	40	40	40	47	39	50'	
C	DP8 (5B) W2-C32×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	175	32	32	32	39	31	30'	
	DP8 (5B) W2-C40×40		175	40	40	40	47	39	30'	
D	DP8 (5B) W2-D32×32	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	175	32	32	32	39	31	15'	
	DP8 (5B) W2-D40×40		175	40	40	40	47	39	15'	

刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension				
		L	C	D	F	λ
DP8 (5B) N2-BR80×300	4"~5 $\frac{1}{2}$ "	300	160	80	40	50'

配件 Accessory	刀块 Insert block	调节螺钉 Adjustment screw	蘑菇头螺钉 Screw
图例 Pic.			
型号 Ordering code	DP8 (5B) N2-CA17	M6	Sm8

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	压紧螺钉 Clamp bolt	扳手 Wrench
图例 Pic.						
型号 Ordering code	S5BW2-2 S8BW2-3	DP8 (5B) W2-DD	G0620	Ht0808	YLB8-20	S3

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	压紧螺钉 Clamp bolt	扳手 Wrench
图例 Pic.						
型号 Ordering code	S8N2-4 S5BN2-2	DP8 (5B) N2-DD	G0620	Ht0808	YLB8-20	S3/S5



菱形系列螺纹刀片用刀杆

Tool shank for diamond series threading inserts

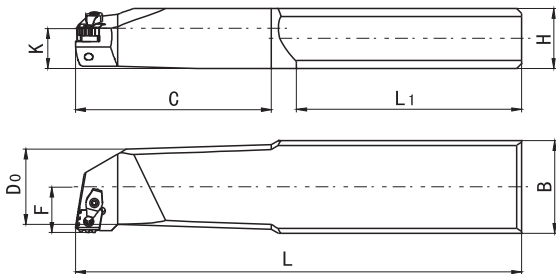
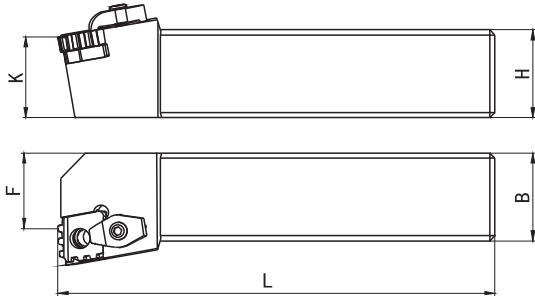
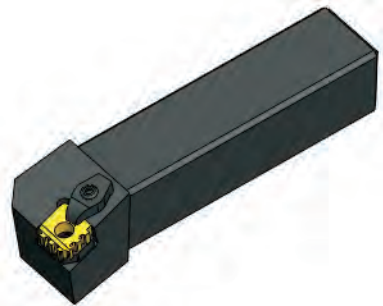
菱形系列螺纹刀片用刀杆

Tool shank for diamond series threading inserts



菱形刀片系列外螺纹用刀杆
Tool shank for diamond series external threading inserts

菱形刀片系列内螺纹用方柄刀杆
Square tool shank for diamond series internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						适用机床 Machine tool
			L	H	K	B	F	λ	
B	M5BW2-B35×32	4 ¹ / ₂ "~6 ⁵ / ₈ "	175	35	32	35	31	60'	QK1312
C	M5BW2-C35×32	7"~11 ³ / ₄ "	175	35	32	35	31	40'	S1-245
D	M5BW2-D35×32	11 ³ / ₈ "~20"	175	35	32	35	31	20'	S1-127

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L1	H	C	K	D ₀	B	F	λ	
B	M5BN2-BS48×32	4 ¹ / ₂ "~6 ⁵ / ₈ "	335	180	48	130	32	50	74	31	60'	S1-127
	M5BN2-BS55×36		355	200	55	130	36	50	77	31	60'	S1-245
C	M5BN2-CS48×32	7"~11 ³ / ₄ "	358	180	48	158	32	56	74	36	40'	S1-127
	M5BN2-CS55×36		378	200	55	158	36	56	77	36	40'	S1-245
D	M5BN2-DS55×36	11 ³ / ₈ "~20"	395	200	55	175	36	60	81	43	20'	S1-262

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	K5BW2-3	K5BW2-DD	YMA-15	SLX-7	S4

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	K5BN2-3	K5BN2-DD	YMA-15	SLX-7	S4



菱形系列螺纹刀片用刀杆

Tool shank for diamond series threading inserts

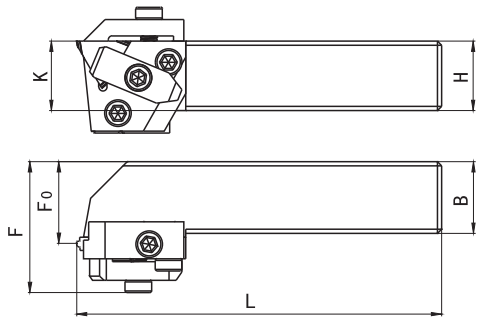
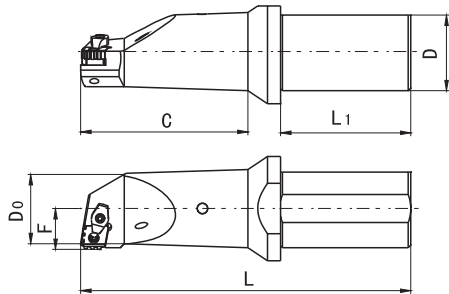
立装系列螺纹刀片用刀杆

Tool shank for vertical series threading inserts



菱形刀片系列内螺纹用圆柄刀杆
Round tool shank for diamond series internal threading inserts

立装偏梯形外螺纹刀片用刀杆
Tool shank for vertical buttress external threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
B	M5BN2-BR50×90	4 $\frac{1}{2}$ "~6 $\frac{5}{8}$ "	245	90	50	130	50	31	60°	CK7820 CK7832
	M5BN2-BR60×100		255	100	60	130	50	31	60°	CK7840 S1-181
	M5BN2-BR80×140		295	140	80	130	50	31	60°	CK3263
C	M5BN2-CR60×100	7"~11 $\frac{3}{4}$ "	283	100	60	158	56	36	40°	CK7840 S1-181
	M5BN2-CR80×140		323	140	80	158	56	36	40°	CK3263
D	M5BN2-DR60×100	13 $\frac{3}{8}$ "~20"	300	100	60	175	60	43	20°	CK7840 S1-181
	M5BN2-DR80×140		340	140	80	175	60	43	20°	CK3263

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
B	G5BWL3-B35×32	4 $\frac{1}{2}$ "~6 $\frac{5}{8}$ "	175	35	32	35	56	40	60°	QK1312 S1-344B
	G5BWL3-B43×40		175	43	40	43	64	48	60°	
C	G5BWL3-C35×32	7"~11 $\frac{3}{4}$ "	175	35	32	35	56	40	40°	S1-245 S1-262
	G5BWL3-C43×40		175	43	40	43	64	48	40°	
D	G5BWL3-D35×32	13 $\frac{3}{8}$ "~20"	175	35	32	35	56	40	20°	S1-127
	G5BWL3-D43×40		175	43	40	43	64	48	20°	

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	K5BN2-3	K5BN2-DD	YMA-15	SLX-7	S4

配件 Accessory	刀片 Insert	镶块 Glutting	压板 Clamp	断屑器 Chip breaker	螺钉 Screw	扳手 Wrench
图例 Pic.						
型号 Ordering code	5BWL3	G5BWL3-XK	GB5WL3-YB	G5BWL3-DXQ	M8×25 M8×35	S5



立装系列螺纹刀片用刀杆

Tool shank for vertical series threading inserts

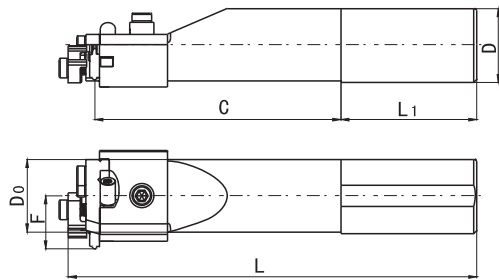
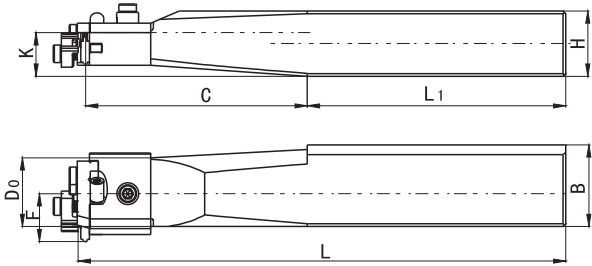
立装系列螺纹刀片用刀杆

Tool shank for vertical series threading inserts



立装偏梯形内螺纹刀片用方柄刀杆
Square tool shank for vertical buttress internal threading inserts

立装偏梯形内螺纹刀片用圆柄刀杆
Round tool shank for vertical buttress internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
B	G5BNL3-BS48×32	4 $\frac{1}{2}$ "~6 $\frac{5}{8}$ "	340	180	48	135	32	31	50	74	60'	S1-127 S1-344
	G5BNL3-BS55×36		360	200	55	135	36	31	50	77	60'	S1-245 S1-262
C	G5BNL3-CS48×32	7"~11 $\frac{3}{4}$ "	363	180	48	163	32	36	56	74	40'	S1-127 S1-344
	G5BNL3-CS55×36		383	200	55	163	36	36	56	77	40'	S1-245 S1-262
D	G5BNL3-DS55×36	13 $\frac{3}{8}$ "~20"	400	200	55	180	36	43	60	81	20'	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
B	G5BNL3-BR50×90	4 $\frac{1}{2}$ "~6 $\frac{5}{8}$ "	250	90	50	135	50	31	60'	CK7820 CK7832
	G5BNL3-BR60×100		260	100	60	135	50	31	60'	CK7840 S1-181
	G5BNL3-BR80×140		300	140	80	135	50	31	60'	CK3263
C	G5BNL3-CR50×90	7"~11 $\frac{3}{4}$ "	273	90	50	163	56	36	40'	CK7820 CK7832
	G5BNL3-CR60×100		283	100	60	163	56	36	40'	CK7840 S1-181
	G5BNL3-CR80×140		323	140	80	163	56	36	40'	CK3263
D	G5BNL3-DR50×90	13 $\frac{3}{8}$ "~20"	290	90	50	180	60	43	20'	CK7820 CK7832
	G5BNL3-DR60×100		300	100	60	180	60	43	20'	CK7840 S1-181
	G5BNL3-DR80×140		340	140	80	180	60	43	20'	CK3263

配件 Accessory	刀片 Insert	镶块 Glutting	T型螺纹 T screw	螺母 Nut
图例 Pic.				
型号 Ordering code	5BNL3	G5BNL3-XK	G5BNL3-TXLD	G5BNL3-LM

配件 Accessory	刀片 Insert	镶块 Glutting	T型螺纹 T screw	螺母 Nut
图例 Pic.				
型号 Ordering code	5BNL3	G5BNL3-XK	G5BNL3-TXLD	G5BNL3-LM

小套 Casing	压板 Clamp	螺钉 Screw	扳手 Wrench
G5BNL3-XT	G5BNL3-YB	M8×25 M8×35	S5

小套 Casing	压板 Clamp	螺钉 Screw	扳手 Wrench
G5BNL3-XT	G5BNL3-YB	M8×25 M8×35	S5



三角形系列螺纹刀片用刀杆

Tool shank for triangle threading inserts

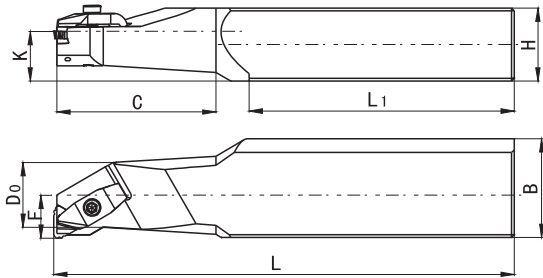
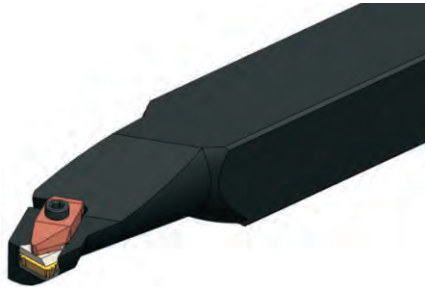
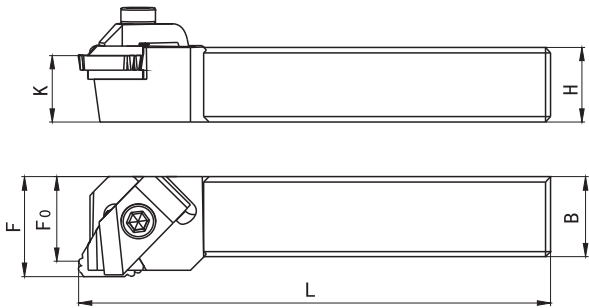
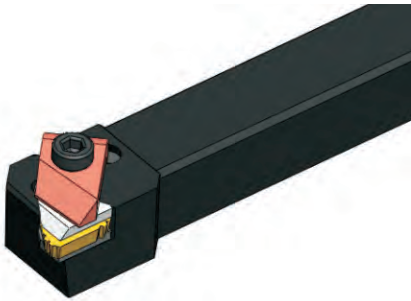
三角形系列螺纹刀片用刀杆

Tool shank for triangle threading inserts



三角形刀片系列外螺纹用刀杆
Tool shank for triangle external threading inserts

三角形刀片系列内螺纹用方柄刀杆
Square tool shank for triangle internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
A	J10 (8) W3-A28×25	2 ³ / ₈ "~3 ¹ / ₂ "	175	28	25	30	35	30	70'	QK1312 S1-344B S1-245 S1-262 S1-127
	J10 (8) W3-A35×32		175	35	32	35	40	35	70'	
	J10 (8) W3-A40×40		175	40	40	40	45	40	70'	
B	J10 (8) W3-B35×32	4"~5 ¹ / ₂ "	175	35	32	35	40	35	50'	
	J10 (8) W3-B40×40		175	40	40	40	45	40	50'	
C	J10 (8) W3-C35×32	6 ⁵ / ₈ "~8 ⁵ / ₈ "	175	35	32	35	40	35	30'	
	J10 (8) W3-C40×40		175	40	40	40	45	40	30'	
D	J10 (8) W3-D35×32	9 ⁵ / ₈ "~13 ³ / ₈ "	175	35	32	35	40	35	15'	
	J10 (8) W3-D40×40		175	40	40	40	45	40	15'	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
A	J10 (8) N3-AS40×25	2 ³ / ₈ "~3 ¹ / ₂ "	265	150	40	90	25	26	42	65	70'	C620改 QK1312
	J10 (8) N3-AS48×32		295	180	48	90	32	26	42	74	70'	
B	J10 (8) N3-BS48×32	4"~5 ¹ / ₂ "	325	180	48	120	32	31	50	74	50'	S1-262
	J10 (8) N3-BS55×36		345	200	55	120	36	31	50	77	50'	
C	J10 (8) N3-CS48×32	6 ⁵ / ₈ "~8 ⁵ / ₈ "	348	180	48	148	32	36	56	74	30'	QK1312 S1-262
	J10 (8) N3-CS55×36		368	200	55	148	36	36	56	77	30'	
D	J10 (8) N3-DS55×36	9 ⁵ / ₈ "~13 ³ / ₈ "	385	200	55	165	36	43	60	81	15'	

配件 Accessory	刀片 Insert	刀垫 Shim	十字螺钉 Screw	断屑器 Chip breaker	钻内压板 Drilling within the platen	压板螺钉 Screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	8 W 3-2 10 W 3-2	J10 (8) W3-DD	M4×8	J10 (8) W3-DXQ	J4 (5) W3-YB	M8×25	S5 S5

配件 Accessory	刀片 Insert	刀垫 Shim	十字螺钉 Screw	断屑器 Chip breaker	钻内压板 Drilling within the platen	压板螺钉 Screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	8 N 3-2 10 N 3-2	J10 (8) N3-DD	M4×8	J10 (8) N3-DXQ	J4 (5) N3-YB	M8×25	S5 S5



三角形系列螺纹刀片用刀杆

Tool shank for triangle threading inserts

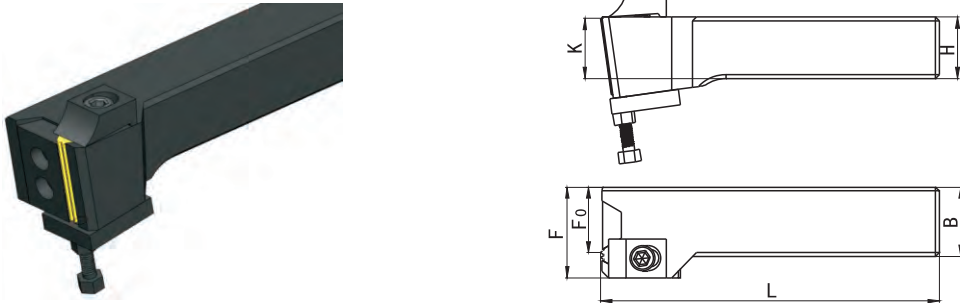
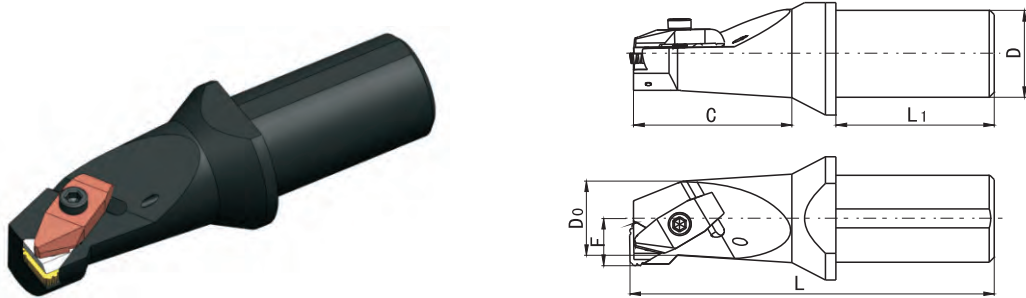
长条形系列螺纹刀片用刀杆

Tool shank for strip threading inserts



三角形刀片系列内螺纹用圆柄刀杆
Round tool shank for triangle internal threading inserts

长条形二齿螺纹刀片用外刀杆
Tool shank for strip double-tooth external threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
A	J10 (8) N3-AR40×80	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	195	80	40	90	42	26	70'	CK7815
	J10 (8) N3-AR50×90		205	90	50	90	42	26	70'	CK7832
	J10 (8) N3-AR60×100		215	100	60	90	42	26	70'	CK7840
	J10 (8) N3-AR80×140		250	140	80	90	42	26	70'	CK3236
B	J10 (8) N3-BR50×90	4"~5 $\frac{1}{2}$ "	235	90	50	120	50	31	50'	CK7820
	J10 (8) N3-BR60×100		245	100	60	120	50	31	50'	CK7840
	J10 (8) N3-BR80×140		285	140	80	120	50	31	50'	CK3263
C	J10 (8) N3-CR60×100	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	268	100	60	148	56	36	30'	CK7840
	J10 (8) N3-CR80×140		308	140	80	148	56	36	30'	CK3263
D	J10 (8) N3-DR60×100	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	285	100	60	165	60	43	15'	CK7840
	J10 (8) N3-DR80×140		325	140	80	165	60	43	15'	CK3263

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
A	F10 (8) W1-2A32×32	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	175	32	32	36	43	30	70'	QK1312 Q1319 S1-127 S1-344B
B	F10 (8) W1-2BC32×32	4"~8 $\frac{5}{8}$ "	175	32	32	36	43	30	30'	
D	F10 (8) W1-2D32×32	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	175	32	32	36	43	30	15'	

配件 Accessory	刀片 Insert	刀垫 Shim	十字螺钉 Screw	断屑器 Chip breaker	钻内压板 Drilling within the platen	压板螺钉 Screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	8N3-2 10N3-2	J10 (8) N3-DD	M4×8	J10 (8) N3-DXQ	J4 (5) N3-YB	M8×25	S5S5

配件 Accessory	刀片 Insert	压板 Clamp	调节螺钉 Adjustment Screw	支撑板 Retaining Plate	楔块 Wedge	螺钉 Screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	10W1-2 8W1-2	F10 (8) W1-DXB	M6×35	F10 (8) W1-ZCB	F10 (8) W1-XK	M8×25	S5S5



四边形系列螺纹刀片用刀杆

Tool shank for quadrilateral threading inserts

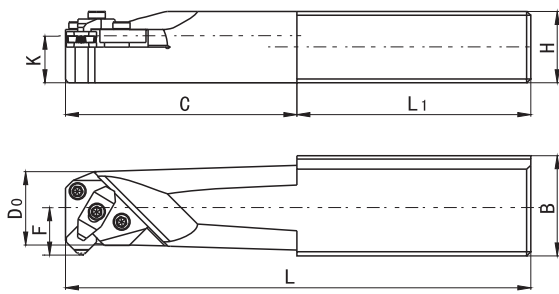
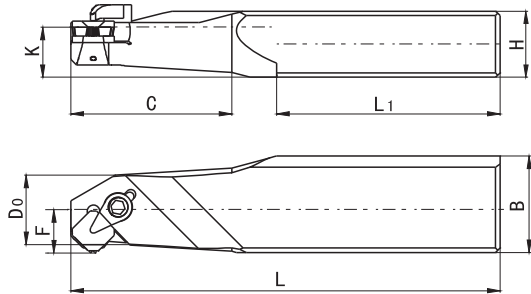
四边形系列螺纹刀片用刀杆

Tool shank for quadrilateral threading inserts



四边形内螺纹刀片用方柄刀杆
Square tool shank for quadrilateral internal threading inserts

四边形内螺纹刀片用方柄刀杆
Square tool shank for quadrilateral internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
A	M10 (8) N4-AS40×25	2 ³ / ₈ "~3 ¹ / ₂ "	275	150	40	100	25	28	42	66	70'	C620改
	M10 (8) N4-AS48×32		305	180	48	100	32	28	42	74	70'	QK1312 Q1319

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
B	C10 (8) N4-BS48×32	4"~5 ¹ / ₂ "	335	180	48	130	32	31	50	74	50'	QK1312 Q1319
	C10 (8) N4-BS55×36		335	180	55	130	36	31	50	77	50'	
C	C10 (8) N4-CS48×32	6 ⁵ / ₈ "~8 ⁵ / ₈ "	358	180	48	158	32	35	56	74	30'	S1-262 S1-246
	C10 (8) N4-CS55×36		358	180	55	158	36	35	56	77	30'	
D	C10 (8) N4-DS55×36	9 ⁵ / ₈ "~13 ³ / ₈ "	375	180	55	175	36	37	60	81	15'	

配件 Accessory	刀片 Insert	刀垫 Shim	十字螺钉 Screw	断屑器 Chip breaker	压板 Clamp	螺钉 Screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	10N4-2	M10 (8) N4-DD	M4×8	M10 (8) N4-DXQ	YMB13-20	ZYLD-M10	S5 S5

配件 Accessory	刀片 Insert	断屑器 Chip breaker	刀垫 Shim	十字螺钉 Screw
图例 Pic.				
型号 Ordering code	8N4-2 / 10N4-2	M10 (8) N4-DXQ	M10 (8) N4-DD	M4×8

压板 Clamp	镶块 Glutting	螺钉 Screw	垫圈 Washer	扳手 Wrench
C10 (8) N4-YB	C10 (8) N4-XK	M8×25 / M8×35	GB848-85-8-140HV	S5



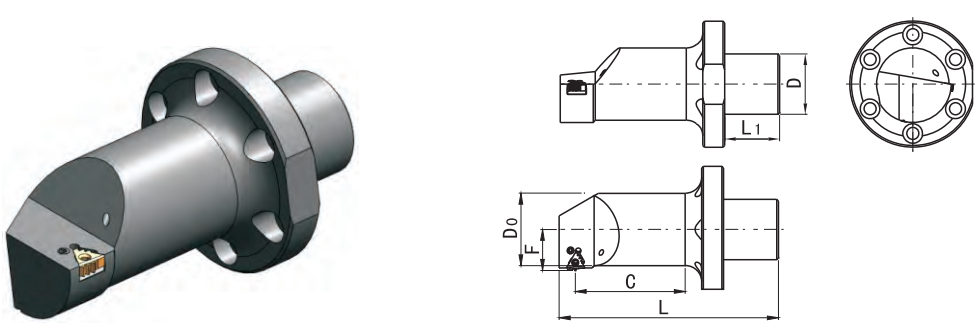
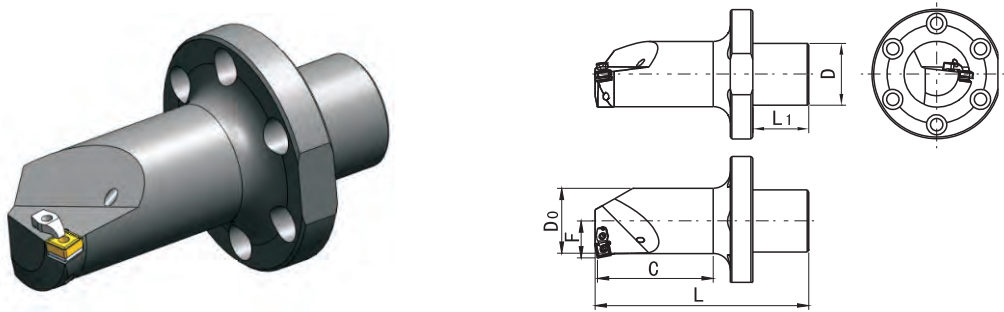
406机床用刀杆
Tool shank for 406 machine tool

406机床用刀杆
Tool shank for 406 machine tool



406镗刀杆 Tool shank for 406 boring tool

406圆扣梳刀杆 Tool shank for 406 round chasing tool



刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension					
		L	L ₁	D ₀	D	C	F
406-A1101L	2 $\frac{3}{8}$ "	159	50	44	55	71	26
406-A1111L	2 $\frac{7}{8}$ "	170	50	52	55	82	30
406-A1121L	3 $\frac{1}{2}$ "	176	50	50	55	88	29
406-A1121L-15		176	50	50	55	88	32
406-A4105L	4"	205	50	66	55	117	34
406-A1141L	4 $\frac{1}{2}$ "	176	50	50	55	88	29
406-A8111L		180	50	70	55	92	38
406-A8121L	5"	190	50	58	55	102	32
406-A1131L	5 $\frac{1}{2}$ "	205	50	60	55	117	33
406-A1131L-15		205	50	70	55	117	40

刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
		L	L ₁	D ₀	D	C	F	λ
406-A1108L	2 $\frac{3}{8}$ "	183	50	48	55	83	28.5	70'
406-A1112L	2 $\frac{7}{8}$ "	195	50	55	55	95	32	70'
406-A1122L	3 $\frac{1}{2}$ "	200	50	58	55	100	32.2	50'
406-A4106L	4"	220	50	70	55	120	40.5	50'
406-A1142L	4 $\frac{1}{2}$ "	200	50	58	55	100	32.2	50'
406-A8112L		190	50	66	55	90	36	50'
406-A8122L	5"	200	50	66	55	100	37.9	50'
406-A1132L	5 $\frac{1}{2}$ "	215	50	70	55	115	40.5	50'

配件 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	螺销 Screw pin	扳手 Wrench
图例 Pic.					
型号 Ordering code	SNMG120408 SNMG150608	S12B-6.8 S15B-7.8	YMA-10/YMA-15	SLX-5/SLX-6	S3/S4

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B8N2-3H/B10N2-4H	169.523	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3



406机床用刀杆

Tool shank for 406 machine tool

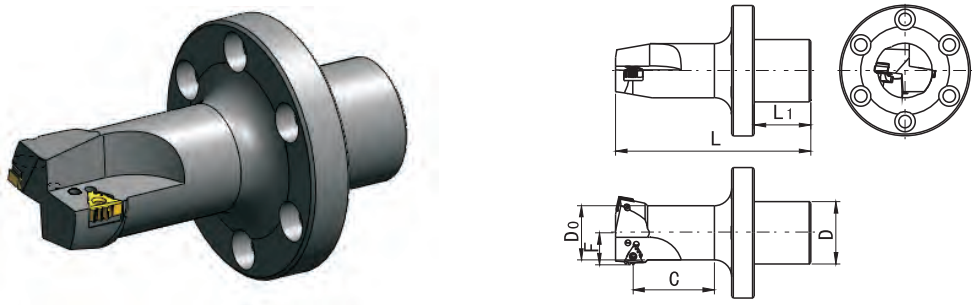
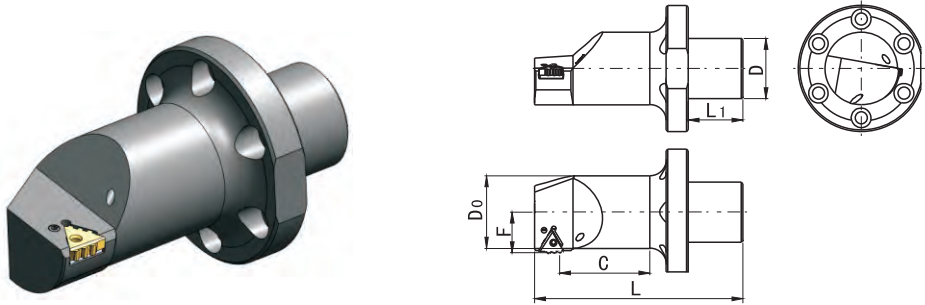
406机床用刀杆

Tool shank for 406 machine tool



406平装偏梯扣梳刀杆 Tool shank for 406 horizontal buttress chasing tool

406复合刀杆 406 multiduty tool shank



刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
		L	L ₁	D ₀	D	C	F	λ
406-A1142L-P5BN2	4 $\frac{1}{2}$ "	200	50	58	55	100	32.2	50°
406-A8122L-P5BN2	5"	200	50	66	55	100	37.9	50°
406-A1132L-P5BN2	5 $\frac{1}{2}$ "	215	50	70	55	115	40.5	50°

刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
		L	L ₁	D ₀	D	C	F	λ
406-A1112L-MSKNR15	2 $\frac{7}{8}$ "	195	50	48	55	95	30	70°
406-A1132L-MSKNR19	5 $\frac{1}{2}$ "	215	50	64	55	115	37	50°

配件 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B5BN2-3	169.973	Φ4 斜拉杆 Φ4 Oblique rod	M6	S3

配件 Accessory	刀片 Insert			刀垫 Shim		
图例 Pic.						
型号 Ordering code	B8N2-3H B10N2-4H	SNMG190620	SNMG150616	169.523	S15B-7.8	S19B-8.8

配件 Accessory	斜拉杆 Oblique rod	顶丝 Lock screw	螺销 Screw pin	压板 Clamp	扳手 Wrench
图例 Pic.					
型号 Ordering code	Φ4 斜拉杆 Φ4 Oblique rod	M6	SLX-6/SLX-7	YMA-15/YMA-19	S3/S4/S5



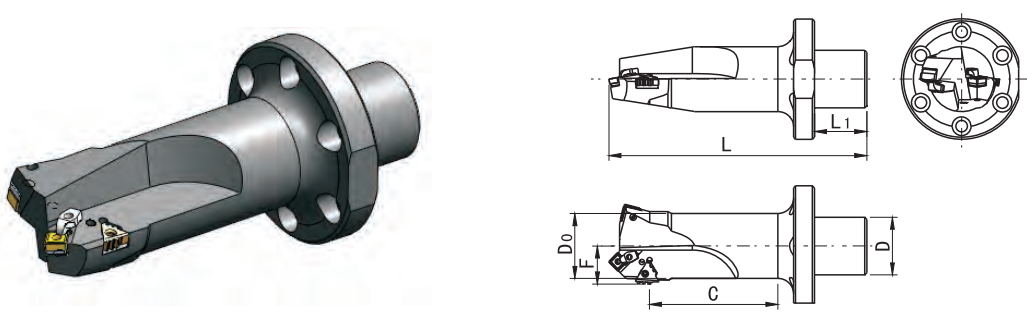
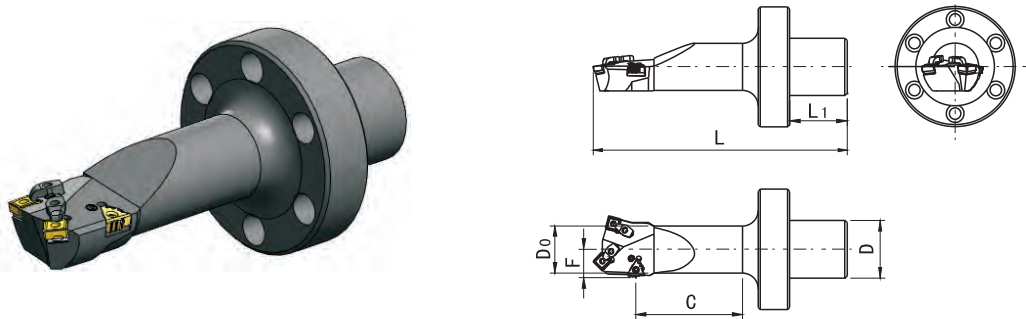
406机床用刀杆
Tool shank for 406 machine tool

406机床用刀杆
Tool shank for 406 machine tool

C

406复合刀杆 406 multiduty tool shank

406复合刀杆 406 multiduty tool shank



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
			L	L ₁	D ₀	D	C	F	λ
A	406-A1112L-MSKNR12/12	2 $\frac{7}{8}$ "	243	55	48	55	102	30	70°

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
			L	L ₁	D ₀	D	C	F	λ
B	406-A1132L-MSKNR15/12	5 $\frac{1}{2}$ "	247	55	64	55	160	37	50°

配件 Accessory	刀片 Insert		刀垫 Shim	
图例 Pic.				
型号 Ordering code	B8W2-3H/B10W2-4H		SNMG120408	
			169.523	
			S12B-6.8	

配件 Accessory	刀片 Insert			刀垫 Shim		
图例 Pic.						
型号 Ordering code	B8N2-3H B10N2-4H			SNMG120408		
				SNMG150616		
				169.523		
				S12B-6.8		
				S15B-7.8		

配件 Accessory	斜拉杆 Oblique rod	顶丝 Lock screw	压板 Clamp	扳手 Wrench
图例 Pic.				
型号 Ordering code	Φ4 斜拉杆 Φ4 Oblique rod	M6	YMA-10	S3

配件 Accessory	斜拉杆 Oblique rod	顶丝 Lock screw	螺销 Screw pin	压板 Clamp	扳手 Wrench
图例 Pic.					
型号 Ordering code	Φ4 斜拉杆 Φ4 Oblique rod	M6	SLX-5/SLX-6	YMA-10/YMA-15	S3/S4



406机床用刀杆

Tool shank for 406 machine tool

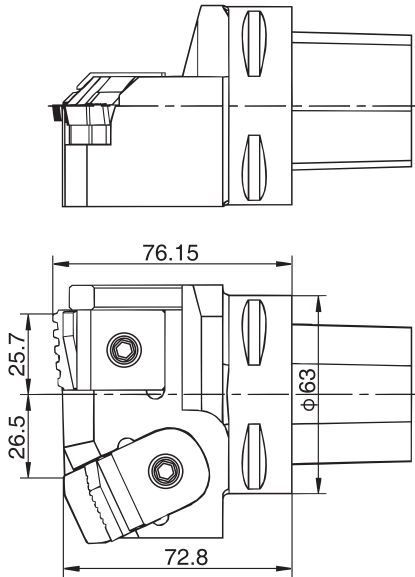
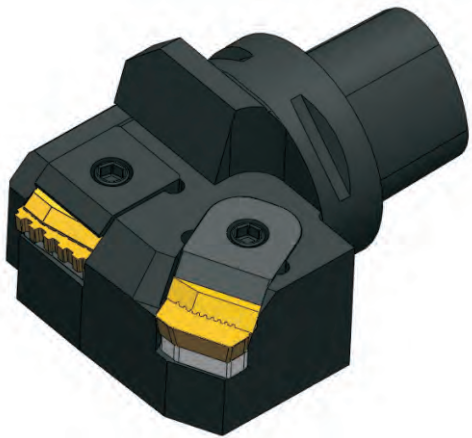
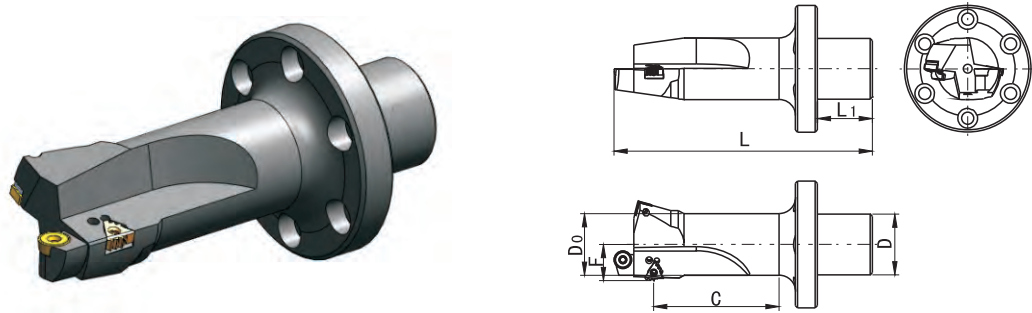
适用于Capto工具系统刀杆

Tool shank suitable for Capto Tooling System



406复合刀杆 406 multiduty tool shank

适用于Capto工具系统刀杆 Tool shank suitable for Capto tooling system



刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension						
		L	L ₁	D ₀	D	C	F	λ
406-P10(8)N2-MSKNR12/R16	4 $\frac{1}{2}$ "	235	50	62	55	114	32.7	50°

配件 Accessory	刀片 Insert			刀垫 Shim		压板 Clamp
图例 Pic.						
型号 Ordering code	B8N2-3H B10N2-4H	SNMG120408	RCMX1606M0	169.523	S12B-6.8	YMA-10

配件 Accessory	斜拉杆 Oblique rod	顶丝 Lock screw	螺销 Screw pin	梅花头螺钉 Screw	扳手 Wrench	扳手 Wrench
图例 Pic.						
型号 Ordering code	Φ4 斜拉杆 Φ4 Oblique rod	M6	SLX-5	M6	T20	S3

配件 Accessory	刀片 Insert		刀垫 Shim		断屑器 Chip breaker		压板 Clamp	
图例 Pic.								
型号 Ordering code	C5BW1-5	C/26417	TG2-5-7	C/26418	TG3-5-7	C/26419	GY-0017	GY-0018

配件 Accessory	靠垫 Supporting cushion	挡板 Plate	螺钉 Screw	螺钉 Screw
图例 Pic.				
型号 Ordering code	GY-0019	GY-0036	M6内六角螺钉	M6x0.5

※该图例所示柄为ISO-26623标准Capto C6柄
※Shank shown is ISO-26623 Standard Capto C6 Shan



适用于Capto工具系统刀杆

Tool shank suitable for Capto Tooling System

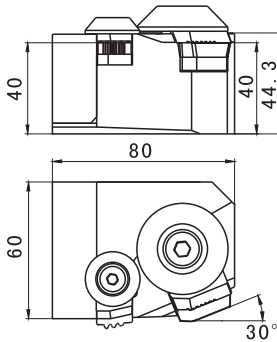
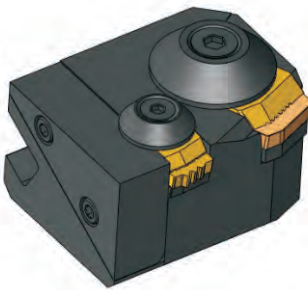
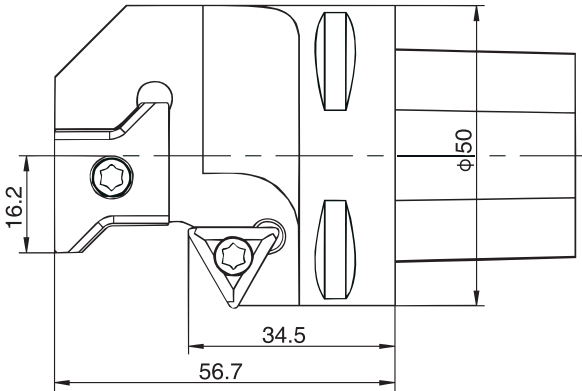
专用复合系列刀座

Specific multiduty Cartridge



适用于Capto工具系统刀杆 Tool shank suitable for Capto tooling system

专用复合刀座 Specific multiduty cartridge



配件 Accessory	刀片 Insert		螺钉 Screw	螺钉 Screw
图例 Pic.				
型号 Ordering code	C/32246-B	TCMX16T308	M6 梅花头螺钉 M6 Screw	M5 梅花头螺钉 M5 Screw

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
04040X						
	C8W1-31 (15°) C8W1-32 (15°)	TG2-6	BXCQW1B I	C/26417	C/26418	C/26419

※该图例所示柄为ISO-26623标准Capto C5柄
※Shank shown is ISO-26623 Standard Capto C5 Shan

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Screw	挡板螺钉 Plate screw	扳手 Wrench
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04040定位板 04040 Locating Plate	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5



专用复合系列刀座

Specific multiduty Cartridge

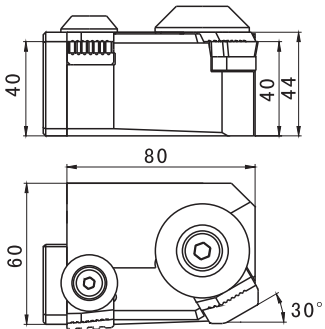
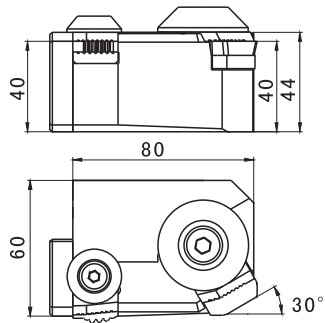
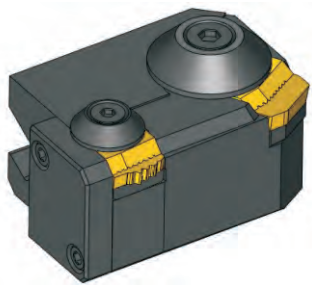
专用复合系列刀座

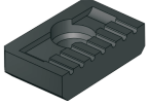
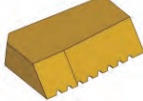
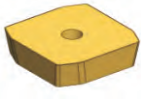
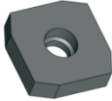
Specific multiduty Cartridge

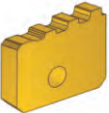
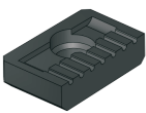
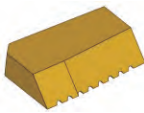
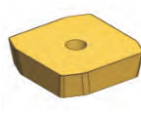
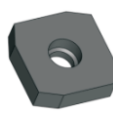


专用复合刀座 Specific multiduty Cartridge

专用复合刀座 Specific multiduty Cartridge



刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
04057						
	C8W1-31 (12°) C8W1-32 (12°)	C/28681	BXCQW1B II	C/26417	C/26418	C/26419

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
04057 (PTK-B) 04057 (PTK-C) 04057 (PTK-D)						
	C5BW1-31 C5BW1-32	C/28681	BXCQW1B II	C/26417	C/26418	C/26419

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
					
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04022DWB-1	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
					
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04022DWB-1	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

刀座型号 Ordering code	加工范围 Working range	λ
04057 (PTK-B)	4 1/2" ~ 6 5/8"	60'
04057 (PTK-C)	7" ~ 11 3/4"	40'
04057 (PTK-D)	13 3/8" ~ 20"	20'



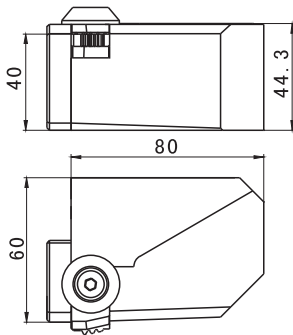
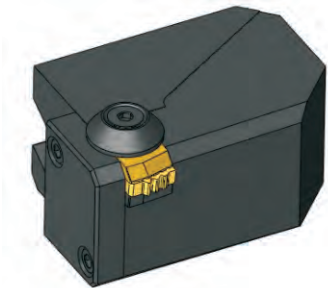
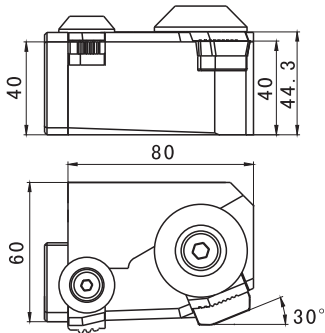
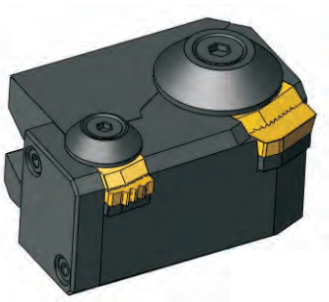
专用复合系列刀座
Specific multiduty Cartridge

专用复合系列刀座
Specific multiduty Cartridge



专用复合刀座 Specific multiduty Cartridge

专用复合刀座 Specific multiduty Cartridge



刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
04022-1-1						
	P8W1-31 (12°)	TG2-6T	BXCQW1BI	C/26417	C/26418	C/26419

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	压板 Clamp
04022-1-2				
	P8W1-33 (12°)	TG2-6T	BXCQW1BI	Φ 24环形压板 Φ 24 Circline Clamp

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
Φ 40/Φ 24环形压板 Φ 40/Φ 24 Circline Clamp	04022DWB-1	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
04022DWB-1	M5×0.5	M6	M5×12	S3/S4/S5



专用复合系列刀座

Specific multiduty Cartridge

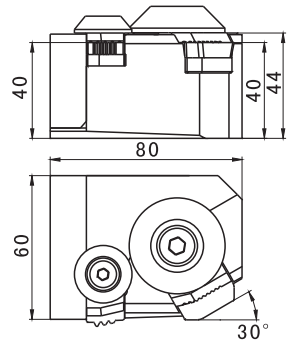
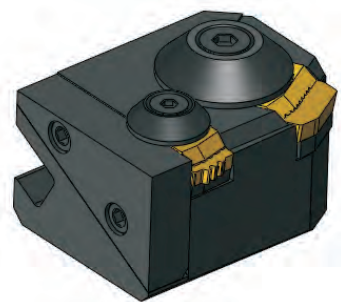
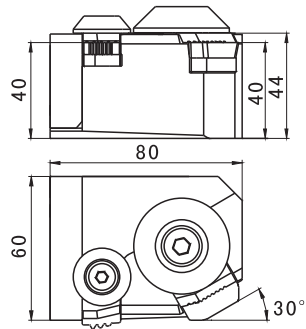
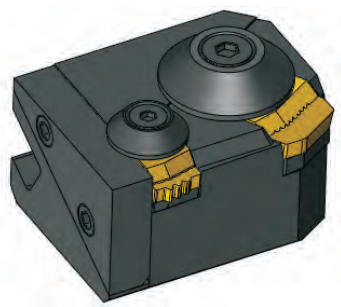
专用复合系列刀座

Specific multiduty Cartridge



专用复合刀座 Specific multiduty Cartridge

专用复合刀座 Specific multiduty Cartridge



刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
040W-26417 /C8-1						
	C8W1-32 (15°)	TG2-6	BXCQW1BI	C/26417	C/26418	C/26419

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
040W-26417/ C8-2						
	C8W1-32 (15°)	TG2-6	BXCQW1BI	C/26417	C/26418	C/26419

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04040 定位板 04040 Locating Plate	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04040 定位板 04040 Locating Plate	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

※ 040W-26417/C8-1用于8牙/时圆扣，梳刀粗车，外圆精车。
040W-26417/C8-1 used for 8 tooth/inch round threading, thread finishing cut, external circle roughing cut.

※ 040W-26417/C8-2用于8牙/时圆扣，梳刀精车，外圆粗车。
040W-26417/C8-2 used for 8 tooth/inch round threading, thread roughing cut, external circle finishing cut.



专用复合系列刀座

Specific multiduty Cartridge

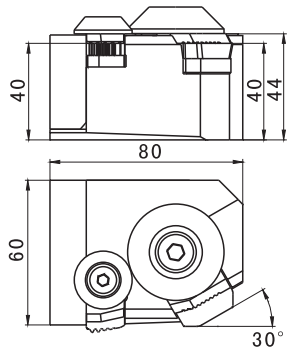
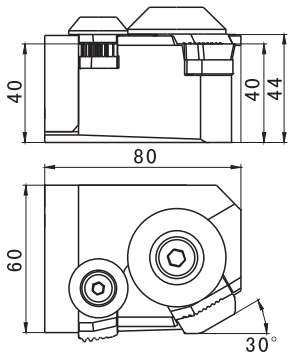
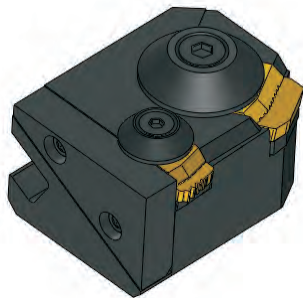
专用复合系列刀座

Specific multiduty Cartridge



专用复合刀座 Specific multiduty Cartridge

专用复合刀座 Specific multiduty Cartridge



刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
040W-26417/ C10-1						
	C10W1-32	TG2-6	BXCQW1BI	C/26417	C/26418	C/26419

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
040W-26417/ C10-2						
	C10W1-32	TG2-6	BXCQW1BI	C/26417	C/26418	C/26419

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04040 定位板 04040 Locating Plate	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04040 定位板 04040 Locating Plate	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

※ 040W-26417/C10-1用于10牙/吋圆扣，梳刀粗车，外圆精车。
040W-26417/C10-1 used for 10 tooth/inch round threading, thread finishing cut, external circle roughing cut.

※ 040W-26417/C10-2用于10牙/吋圆扣，梳刀精车，外圆粗车。
040W-26417/C10-2 used for 10 tooth/inch round threading, thread roughing cut, external circle finishing cut.



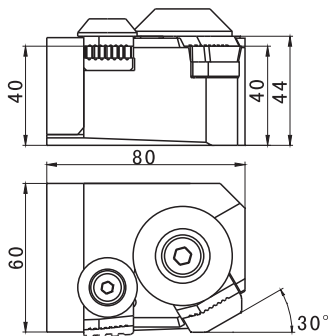
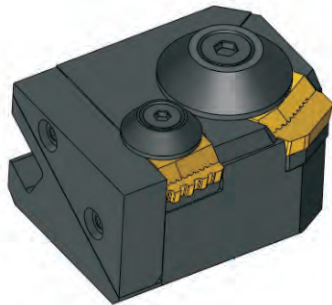
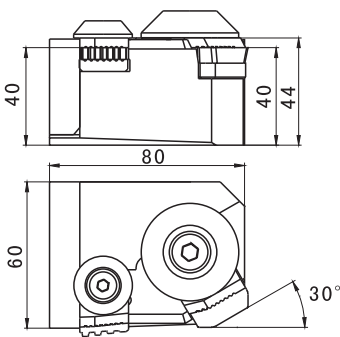
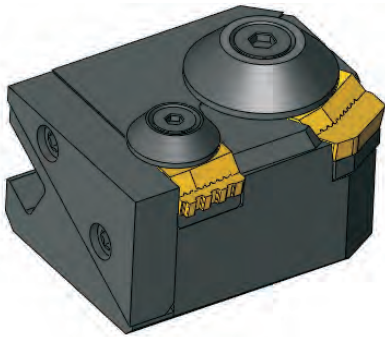
专用复合系列刀座
Specific multiduty Cartridge

专用复合系列刀座
Specific multiduty Cartridge



专用复合刀座 Specific multiduty Cartridge

专用复合刀座 Specific multiduty Cartridge



刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
040W-26417/ C5-1						
	C5BW1-32	C/28681	BXCQW1B II	C/26417	C/26418	C/26419

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	外圆刀片 External face Turning	刀垫 Shim	断屑器 Chip breaker
040W-26417/ C5-2						
	C5BW1-32	C/28681	BXCQW1B II	C/26417	C/26418	C/26419

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压紧螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04040 定位板 04040 Locating Plate	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

压板 Clamp	挡板 Plate	刀垫螺钉 Shim screw	压紧螺钉 Clamp screw	挡板螺钉 Plate screw	扳手 Wrench
Φ40/Φ24环形压板 Φ40/Φ24 Circline Clamp	04040 定位板 04040 Locating Plate	M5×0.5/M6×0.75	M8/M6	M5×12	S3/S4/S5

※ 040W-26417/C5-1用于5牙/时梯扣，梳刀粗车，外圆精车。
040W-26417/C5-1 used for 5 tooth/inch round threading, thread finishing cut, external circle roughing cut.

※ 040W-26417/C5-2用于5牙/时梯扣，梳刀精车，外圆粗车。
040W-26417/C5-2 used for 5 tooth/inch round threading, thread roughing cut, external circle finishing cut.



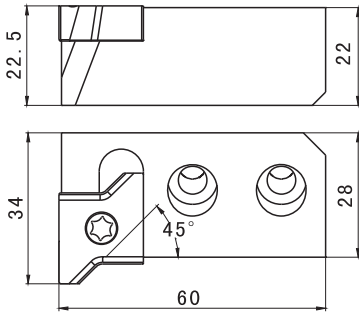
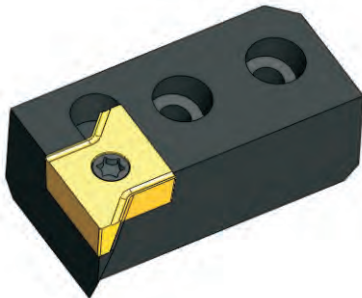
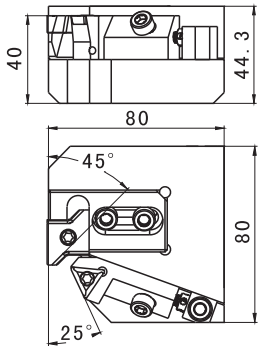
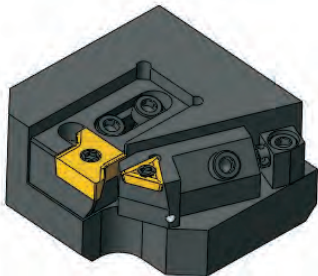
专用复合系列刀座
Specific multiduty Cartridge

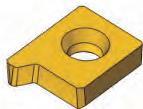
专用复合系列刀座
Specific multiduty Cartridge

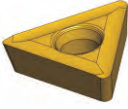
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专用复合刀座 Specific multiduty Cartridge

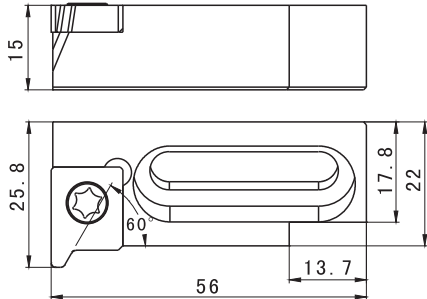
小刀夹 Cartridges

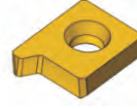


刀座型号 Ordering code	刀夹 Cartridges	刀片 Insert	刀夹 Cartridges	刀片 Insert	刀夹 Cartridges
04026					
	04029-1	C/20943	04029-2	C/32246-B	STSCR12CA-16T

刀片 Insert	调节螺钉 Adjustment screw	螺钉 Screw	螺钉 Screw	扳手 Wrench	扳手 Wrench
					
TCMX16T308	M5	M4/M5	M6	T20/T15	S5

刀杆型号 Ordering code	刀片 Insert	梅花头螺钉 Screw	扳手 Wrench
C/33297			
	C/32246-B	M5×12	T20



刀杆型号 Ordering code	刀片 Insert	梅花头螺钉 Screw	扳手 Wrench
NCT7			
	C/20943	M5×12	T20

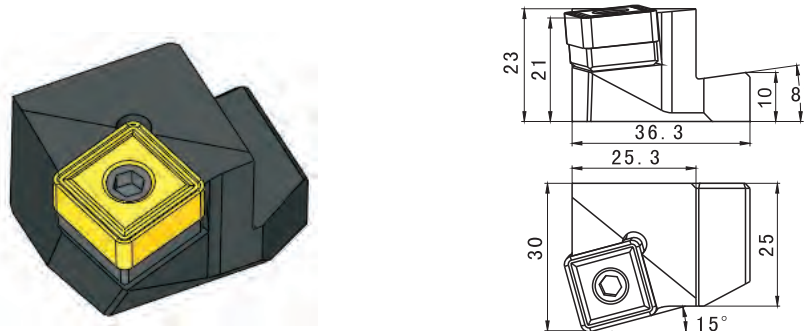


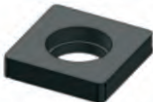
专用复合系列刀座
Specific multiduty Cartridge

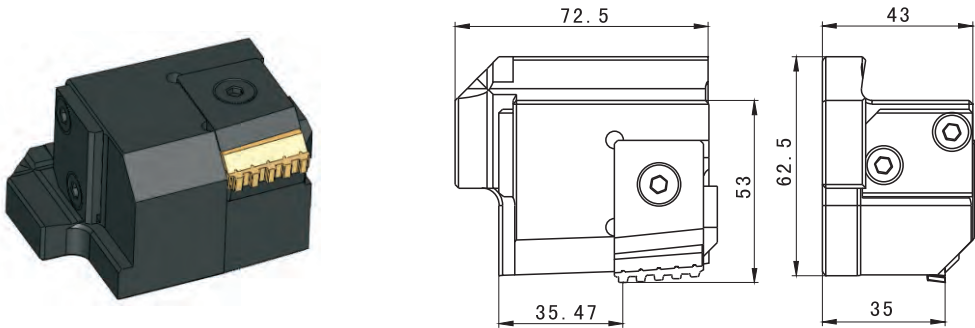
BM系列刀座
BM series cutter block

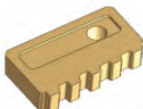
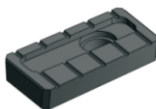
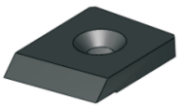
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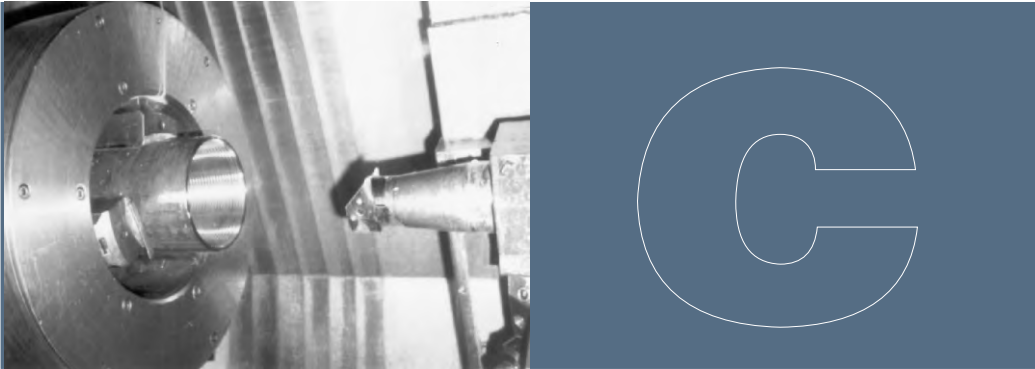
小刀夹 Cartridges

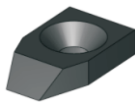


刀杆型号 Ordering code	刀片 Insert	刀垫 Shim	螺销 Screw pin	扳手 Wrench
C/34952				
	SNMG150616	S15B-7.8	SLX-6	S3



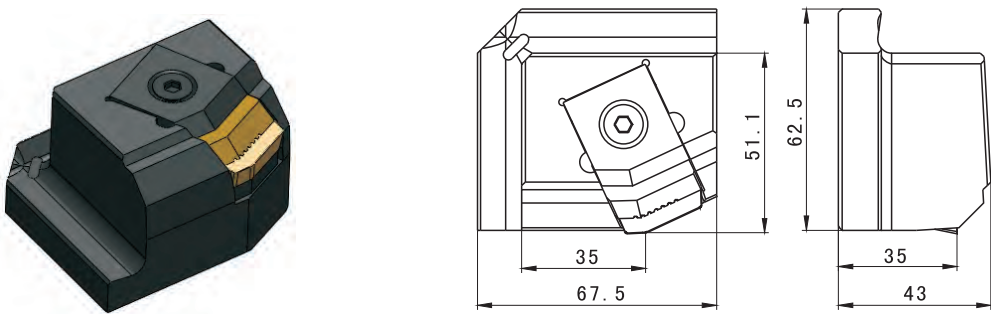
刀杆型号 Ordering code	刀片 Insert	刀垫 Shim	断屑器 Chip breaker	压板 Clamp
BM-0007				
	C5BW1-5	TG2-4	BXCQW1BIII	BM-0007-YB



侧压板 Side gulde	侧定位板 Side locating plate	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	扳手 Wrench
				
BM-0007-CYB	BM-0007-CDWB	M5×0.5	M4/M6	S2/S4

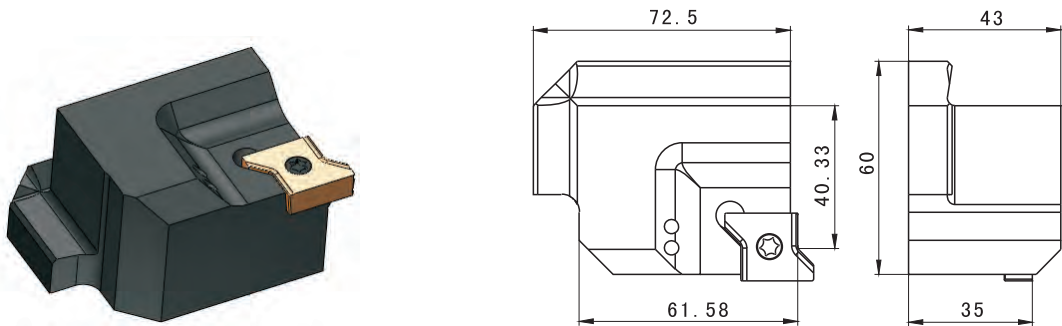


BM系列刀座
BM series cutter block



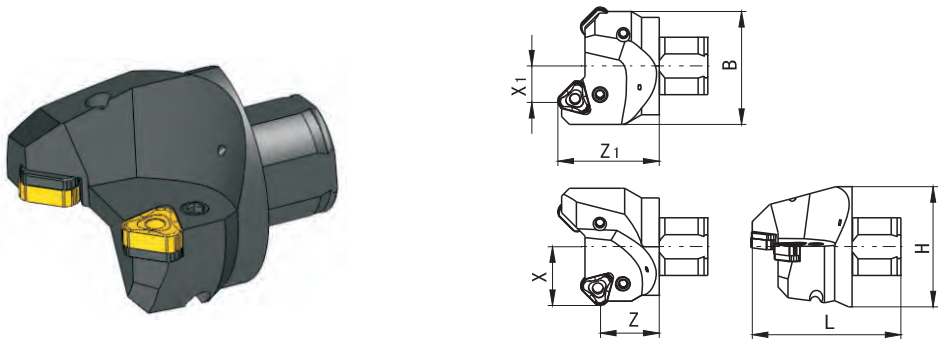
刀杆型号 Ordering code	刀片 Insert	刀垫 Shim	断屑器 Chip breaker	压板 Clamp	刀垫螺钉 Shim screw	压板螺钉 Clamp screw	扳手 Wrench
BM-0004							
	C/26417	C/26418	C/26419	BM-0004-YB	M6×0.75	M6	S4

小刀夹 Cartridges



刀杆型号 Ordering code	刀片 Insert	梅花头螺钉 Screw	扳手 Wrench
BM-0012			
	C/32246-B	M5	T20

BP系列刀座
BP series cutter block



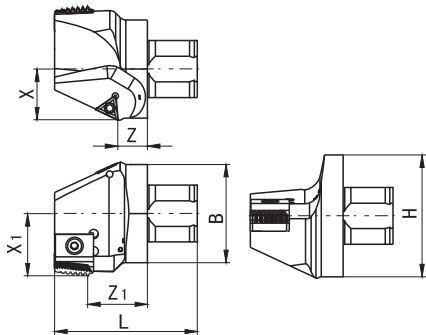
型号 Ordering code	主要尺寸 Dimension						
	L	B	H	X	Z	X ₁	Z ₁
BP-0006	61	40	49	23	25.16	10.29	42
BP-0007	75	50	61	30	31.7	16.51	52
BP-0008	94	63	78	40	40.4	20.58	64

刀座型号 Ordering code	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	杠杆螺钉 Lever screw	扳手 Wrench
BP-0006 BP-0007 BP-0008						
	TNMG1604X TNMG2204X TNMG2706X	BP-0006-DD BP-0007-DD BP-0008-DD	G0620	Ht0808	YLB8-20	S3

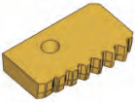
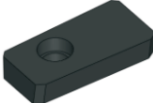
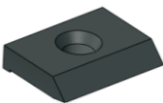


BP系列刀座

BP series cutter block



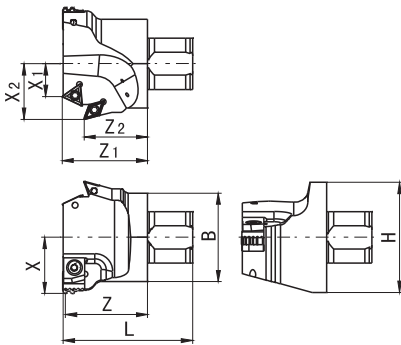
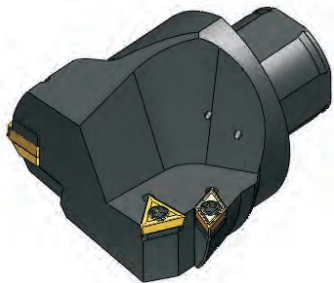
型号 Ordering code	主要尺寸 Dimension						
	L	B	H	X	Z	X ₁	Z ₁
BP-0012	91.5	63	78	33.33	18.29	40	37.6

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	压板 Clamp	刀垫螺钉 Shim screw
BP-0012					
	C8N1-7	TG2-3	C/41107	BP-0012-YB	M5×0.5

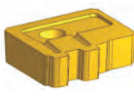
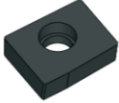
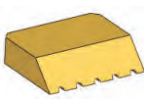
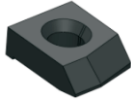
压板螺钉 Clamp screw	毛刺刀片 De-burring insert	刀垫 Shim	梅花头螺钉 Screw	扳手 Wrench	扳手 Wrench
					
M6	TCMT16T304	TG2-2	M5	T20	S3/S4

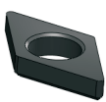
BP系列刀座

BP series cutter block



型号 Ordering code	主要尺寸 Dimension								
	L	B	H	X	Z	X ₁	Z ₁	X ₂	Z ₂
BP-0017	92	63	78	40	58.05	30.25	45.89	40	45

刀座型号 Ordering code	螺纹刀片 Threading Inserts	刀垫 Shim	断屑器 Chip breaker	压板 Clamp	刀垫螺钉 Shim screw	压板螺钉 Clamp screw
BP-0017						
	C5BN1-2	TG2-6	TG3-2	BP-0017-YB	M5×0.5	M6

毛刺刀片 De-burring insert	刀垫 Shim	毛刺刀片 De-burring insert	刀垫 Shim	梅花头螺钉 Screw	扳手 Wrench	扳手 Wrench
						
TCMT16T304	TG2-2	DCMT11T304	D11B(2.8)	M5	T20	S3/S4



倒角、端面、毛刺等配套刀杆

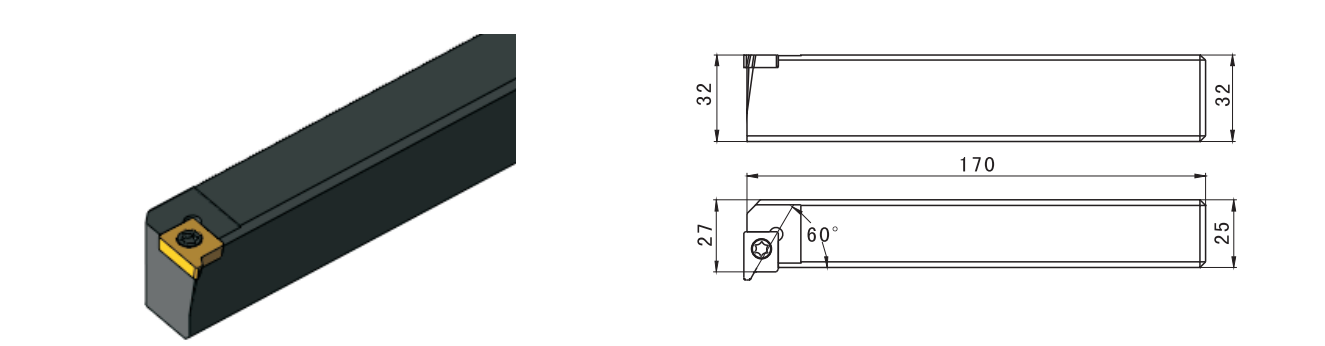
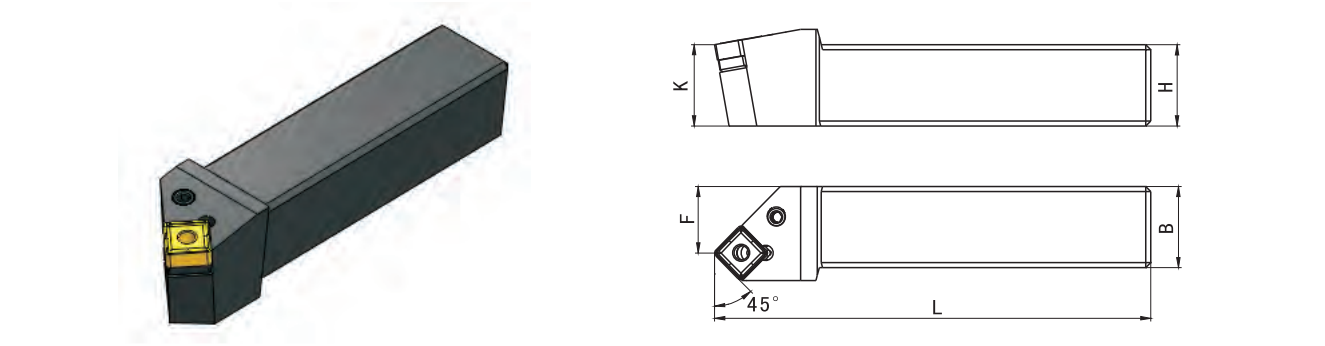
Complete tool shank for chamfer, de-burring and face turning inserts.

倒角、端面、毛刺等配套刀杆

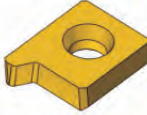
Complete tool shank for chamfer, de-burring and face turning inserts.

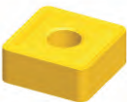
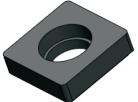
45° 倒角刀杆 Tool shank of 45° angle chamfer insert

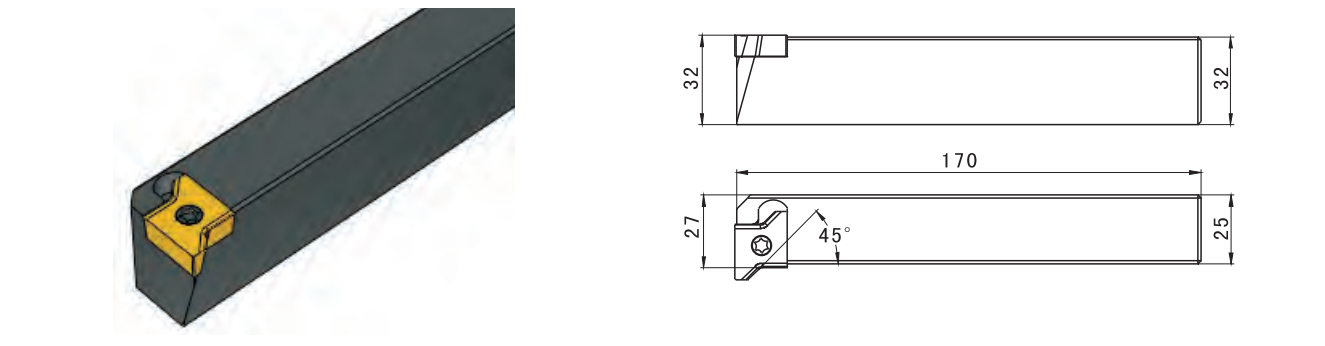
倒角端面刀杆 Tool shank of chamfer and face turning insert

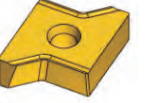


刀杆型号 Ordering code	主要尺寸 Dimension				
	K	B	F	H	L
PSSNR/L 3225 P15	32	25	18	32	170
PSSNR/L 3232 P15	32	32	26	32	170
PSSNR/L 4040 S15	40	40	35	40	250

刀杆型号 Ordering code	刀片 Insert	梅花头螺钉 Screw	扳手 Wrench
C/20943- 32×25×170			
	C/20943	M5×12	T20

配件 Accessory	刀片 Insert	刀垫 Shim	杠杆 Lever	弹销 Spring pin	压紧螺钉 Clamp bolt	扳手 Wrench
图例 Pic.						
型号 Ordering code	SNMG150616	S15A-8.1	G0516	HT0505	YLB8-20	S3



刀杆型号 Ordering code	刀片 Insert	梅花头螺钉 Screw	扳手 Wrench
C/32246- 32×25×170			
	C/32246-B	M5×12	T20



倒角、端面、毛刺等配套刀杆

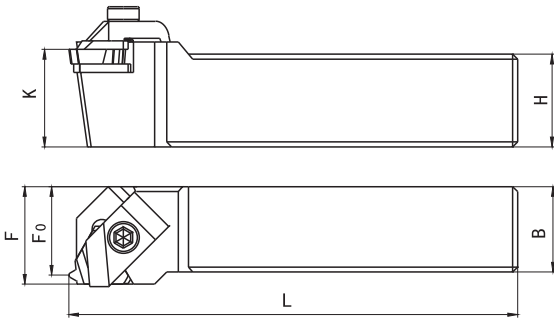
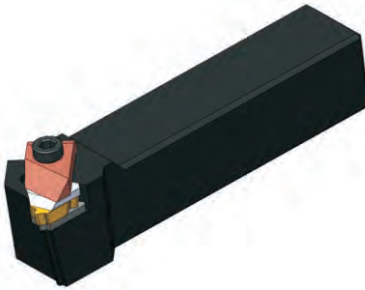
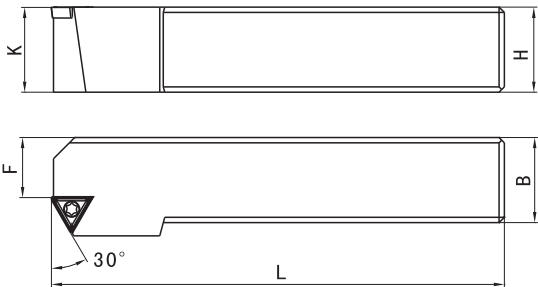
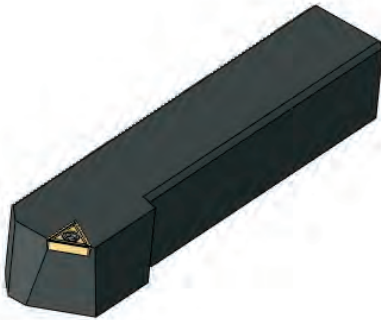
Complete tool shank for chamfer, de-burring and face turning inserts.

钻杆螺纹加工用刀杆

Tool shank for drill rod threading



去毛刺刀杆 Tool shank of de-burring insert



刀杆型号 Ordering code	主要尺寸 Dimension				
	K	B	F	H	L
STWCR3232P16	32	32	22	32	170
STWCR4040S16	40	40	30	40	250

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
A	J4 (5) W3-A35×32 I	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	175	35	32	35	40	36	110'	CK3263 CK7840 S1-245 S1-262
B	J4 (5) W3-B35×32 I	4"~5 $\frac{1}{5}$ "	175	35	32	35	40	36	80'	
C	J4 (5) W3-C35×32 I	5 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	175	35	32	35	40	36	45'	

配件 Accessory	刀片 Insert	梅花头螺钉 Screw	扳手 Wrench
图例 Pic.			
型号 Ordering code	TCMT16T308	M4×12	T15

名称 Accessory	刀片 Insert	断屑器 Chip breaker	刀垫 Shim	十字螺钉 Screw	钻内压板 Drilling within the platen	压板螺钉 Clamp screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	4Y1W3-1	J4 (5) W3-DXQ	J4 (5) W3-DD	M4×8	J4 (5) W3-YB	M8×25	S5 S5

※ 此杆也可配刀片4Y2W3-1、4Y4W3-1、4Y5W3-1、4Y7W3-1、5Y3W3-1使用。
This tool shank also can be used by matching with the inserts of 4Y2W3-1、4Y4W3-1、4Y5W3-1、4Y7W3-1、5Y3W3-1.



钻杆螺纹加工用刀杆

Tool shank for drill rod threading

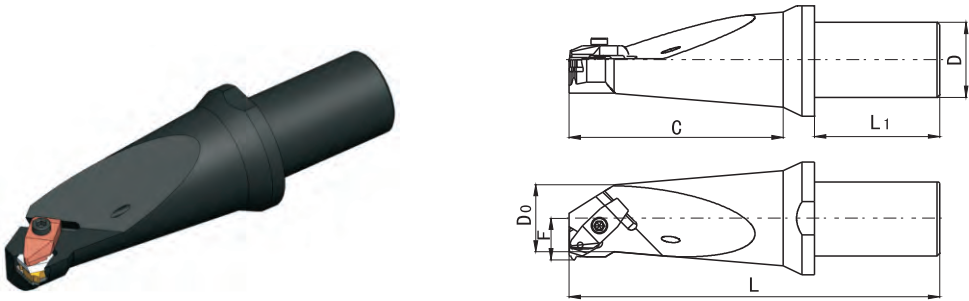
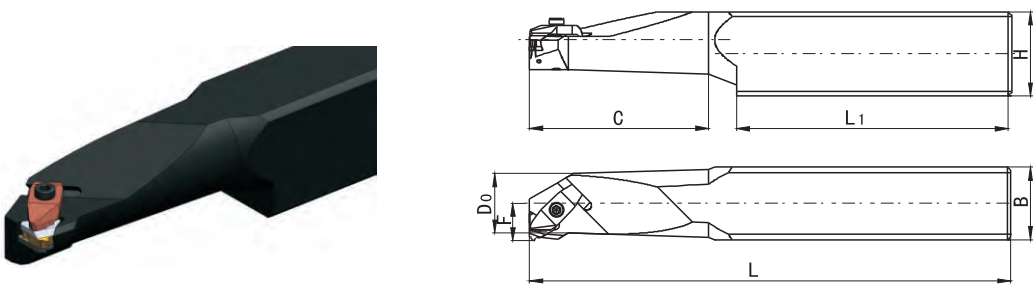
钻杆螺纹加工用刀杆

Tool shank for drill rod threading



钻杆 I 型内螺纹刀片用方柄刀杆 Square tool shank for I type internal threading inserts

钻杆 I 型内螺纹刀片用圆柄刀杆 Round tool shank for I type internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
B	J4 (5) N3-BS48×32 I	4"~5 $\frac{1}{2}$ "	330	180	48	150	32	30.8	48	74	80'	S1-127 S1-344
	J4 (5) N3-BS55×36 I		350	200	55	150	36	30.8	48	77	80'	S1-262 S1-245
C	J4 (5) N3-CS55×36 I	5 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	382	200	55	182	36	33.5	53	81	45'	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
B	J4 (5) N3-BR60×100 I	4"~5 $\frac{1}{5}$ "	265	100	60	140	48	30.8	80'	S1-190 CK7840 CK3263
	J4 (5) N3-BR80×140 I		310	140	80	140	48	30.8	80'	
C	J4 (5) N3-CR60×100 I	5 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	295	100	60	170	53	33.5	45'	CK7840 S1-190 CK3263
	J4 (5) N3-CR80×140 I		340	100	80	170	53	33.5	45'	

名称 Accessory	刀片 Insert	断屑器 Chip breaker	刀垫 Shim	十字螺钉 Screw	钻内压板 Drilling within the platen	压板螺钉 Clamp screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	4Y1N3-1	J4 (5) N3-DXQ	J4 (5) N3-DD	M4×8	J4 (5) N3-YB	M8×25	S5

名称 Accessory	刀片 Insert	断屑器 Chip breaker	刀垫 Shim	十字螺钉 Screw	钻内压板 Drilling within the platen	压板螺钉 Clamp screw	扳手 Wrench
图例 Pic.							
型号 Ordering code	4Y1N3-1	J4 (5) N3-DXQ	J4 (5) N3-DD	M4×8	J4 (5) N3-YB	M8×25	S5 S5

※ 此杆也可配刀片4Y2N3-1、4Y4N3-1、4Y5N3-1、4Y7N3-1、5Y3N3-1使用。
This tool shank also can be used by matching with the inserts of 4Y2N3-1、4Y4N3-1、4Y5N3-1、4Y7N3-1、5Y3N3-1.

※ 此杆也可配刀片4Y2N3-1、4Y4N3-1、4Y5N3-1、4Y7N3-1、5Y3N3-1使用。
This tool shank also can be used by matching with the inserts of 4Y2N3-1、4Y4N3-1、4Y5N3-1、4Y7N3-1、5Y3N3-1.



钻杆螺纹加工用刀杆

Tool shank for drill rod threading

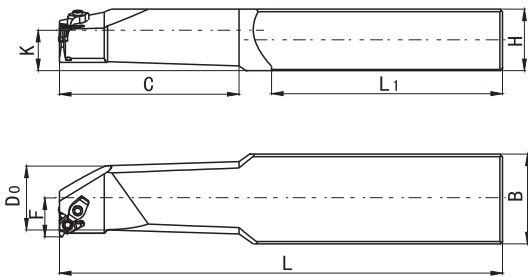
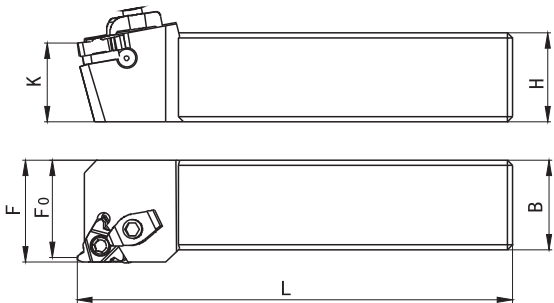
钻杆螺纹加工用刀杆

Tool shank for drill rod threading



钻杆Ⅱ型外螺纹刀片用刀杆 Tool shank for Ⅱ type external threading inserts

钻杆Ⅱ型内螺纹刀片用方柄刀杆 Square tool shank for Ⅱ type internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
A	M4 (5) W3-A35×32	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	175	35	32	35	40	37	110'	CK3263 CK7840 S1-181 S1-190 S1-245 S1-262
B	M4 (5) W3-B35×32	4"~5 $\frac{1}{2}$ "	175	35	32	35	40	37	80'	
C	M4 (5) W3-C35×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	175	35	32	35	40	37	45'	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
B	M4 (5) N3-BS48×32	4"~5 $\frac{1}{2}$ "	330	180	48	150	32	30.8	48	74	80'	S1-127 S1-344 S1-262 S1-245
	M4 (5) N3-BS55×36		350	200	55	150	36	30.8	48	77	80'	
C	M4 (5) N3-CS55×36	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	382	200	55	182	36	33.5	53	81	45'	

名称 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	梅花头螺钉 Screw	蘑菇头螺钉 Screw	扳手 Wrench	扳手 Wrench
图例 Pic.							
型号 Ordering code	22ER4Y1SV	M4 (5) W3-DD	YMA-15	M5×15	SM4×12	T20	S4/S2.5

名称 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	梅花头螺钉 Screw	蘑菇头螺钉 Screw	扳手 Wrench	扳手 Wrench
图例 Pic.							
型号 Ordering code	22NR4Y1SV	M4 (5) N3-DD	YMA-15	M5×15	SM4×12	T20	S4/S2.5



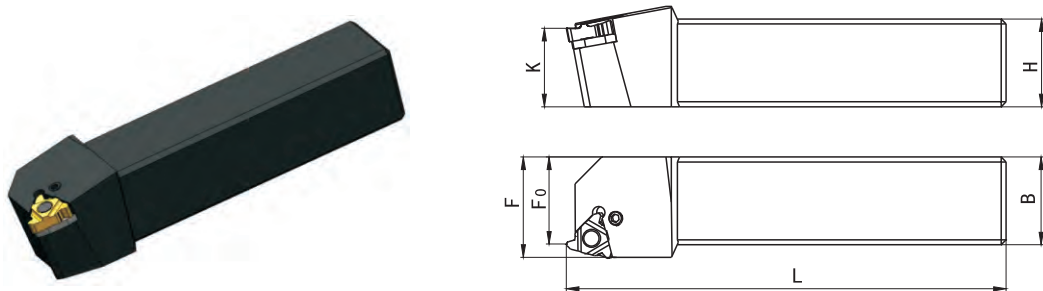
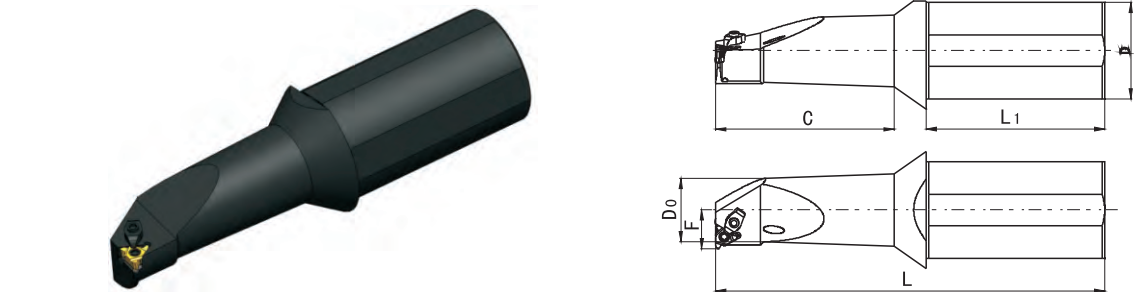
钻杆螺纹加工用刀杆
Tool shank for drill rod threading

钻杆螺纹加工用刀杆
Tool shank for drill rod threading



钻杆Ⅱ型内螺纹刀片用圆柄刀杆 Round tool shank for Ⅱ type internal threading inserts

钻杆Ⅲ型内螺纹刀片用刀杆 Tool shank for Ⅲ type external threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
B	M4 (5) N3-BR60×100	4"~5 $\frac{1}{2}$ "	275	100	60	150	48	30	80'	S1-490 CK7840 CK3263
	M4 (5) N3-BR80×140		315	140	80	150	48	30	80'	
C	M4 (5) N3-CR60×100	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	312	100	60	182	53	33	45'	CK7840 S1-190 CK3263
	M4 (5) N3-CR80×140		352	140	80	182	53	33	45'	

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	H	K	B	F	F ₀	λ	
A	P4 (5) W3-A35×32Ⅲ	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	175	35	32	35	40	32	110'	CK3263 CK7840 S1-181 S1-190 S1-245 S1-262
B	P4 (5) W3-B35×32Ⅲ	4"~5 $\frac{1}{5}$ "	175	35	32	35	40	32	80'	
C	P4 (5) W3-C35×32Ⅲ	5 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	175	35	32	35	40	32	45'	

名称 Accessory	刀片 Insert	刀垫 Shim	压板 Clamp	梅花头螺钉 Screw	蘑菇头螺钉 Screw	扳手 Wrench	扳手 Wrench
图例 Pic.							
型号 Ordering code	22NR4Y1SV	M4 (5) N3-DD	YMA-15	M5×15	SM4×12	T20	S4/S2.5

名称 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B4Y1W3-1	169.537	φ4	M6	S3

※ 此杆也可配刀片B4Y2W3-1、B4Y4W3-1、B4Y5W3-1、B4Y7W3-1、B5Y3W3-1使用。
This tool shank also can be used by matching with the inserts of B4Y2W3-1、B4Y4W3-1、B4Y5W3-1、B4Y7W3-1、B5Y3W3-1.



钻杆螺纹加工用刀杆

Tool shank for drill rod threading

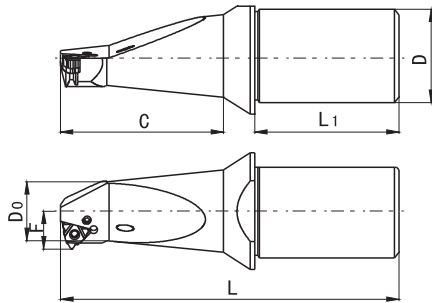
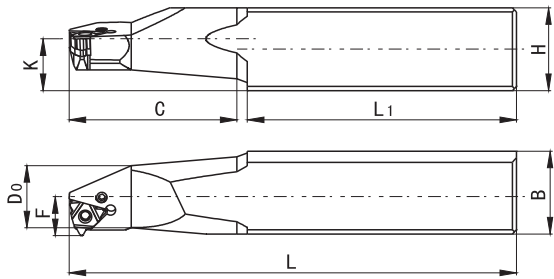
钻杆螺纹加工用刀杆

Tool shank for drill rod threading



钻杆Ⅲ型内螺纹刀片用方柄刀杆 Square tool shank for Ⅲ type internal threading inserts

钻杆Ⅲ型内螺纹刀片用圆柄刀杆 Round tool shank for Ⅲ type internal threading inserts



类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension									适用机床 Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
A	P4 (5) N3-AS48×32Ⅲ	2 ³ / ₈ "~3 ¹ / ₂ "	330	180	48	125	32	26	40	74	110'	S1-127 S1-344
	P4 (5) N3-AS55×36Ⅲ		350	200	55	125	36	26	40	77	110'	S1-262 S1-245
B	P4 (5) N3-BS48×32Ⅲ	4"~5 ¹ / ₅ "	345	180	48	140	32	30.8	48	74	80'	S1-127 S1-344
	P4 (5) N3-BS55×36Ⅲ		365	200	55	140	36	30.8	48	77	80'	S1-262 S1-245
C	P4 (5) N3-CS55×36Ⅲ	5 ⁵ / ₈ "~8 ⁵ / ₈ "	420	220	55	170	36	34	55	81	45'	S1-262 S1-245

类型 Type	刀杆型号 Ordering code	加工范围 Working range	主要尺寸 Dimension							适用机床 Machine tool
			L	L ₁	D	C	D ₀	F	λ	
A	P4 (5) N3-AR60×100III	2 ³ / ₈ "~3 ¹ / ₂ "	250	100	60	125	40	26	110'	CK7840 CK3263A
	P4 (5) N3-AR80×140III		290	140	80	125	40	26	110'	CK3263B
B	P4 (5) N3-BR60×100III	4"~5 ¹ / ₅ "	265	100	60	140	48	30	80'	CK7840 CK3263A
	P4 (5) N3-BR80×140III		310	140	80	140	48	30	80'	CK3263B
C	P4 (5) N3-CR60×100III	5 ⁵ / ₈ "~8 ⁵ / ₈ "	295	100	60	170	53	33	45'	CK7840 CK3263A
	P4 (5) N3-CR80×140III		340	140	80	170	53	33	45'	CK3263B

名称 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B4Y1N3-1	169.737	φ4	M6	S3

名称 Accessory	刀片 Insert	刀垫 Shim	斜拉杆 Oblique rod	顶丝 Lock screw	扳手 Wrench
图例 Pic.					
型号 Ordering code	B4Y1N3-1	169.737	φ4	M6	S3

※ 此杆也可配刀片B4Y2W3-1、B4Y4W3-1、B4Y5W3-1、B4Y7W3-1、B5Y3W3-1使用。
This tool shank also can be used by matching with the inserts of B4Y2W3-1、B4Y4W3-1、B4Y5W3-1、B4Y7W3-1、B5Y3W3-1.

※ 此杆也可配刀片B4Y2W3-1、B4Y4W3-1、B4Y5W3-1、B4Y7W3-1、B5Y3W3-1使用。
This tool shank also can be used by matching with the inserts of B4Y2W3-1、B4Y4W3-1、B4Y5W3-1、B4Y7W3-1、B5Y3W3-1.



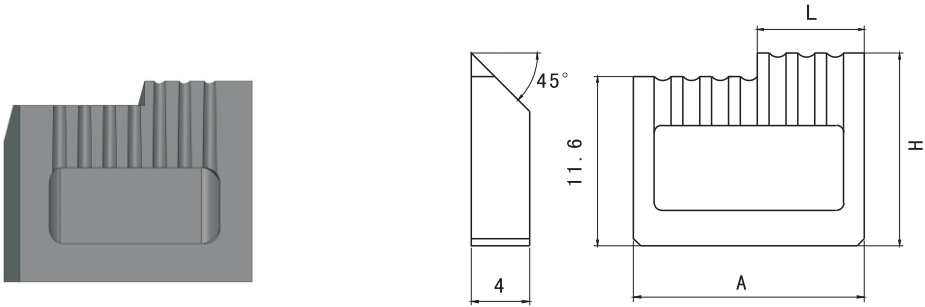
硬质合金断屑器 > Colinet系列刀片配套断屑器

Chip breaker > Chip breaker for Colinet series threading inserts

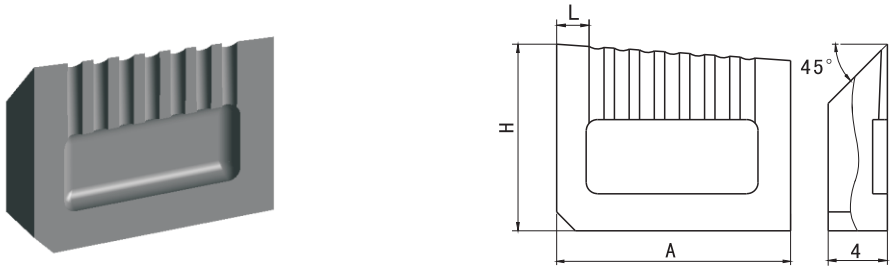
硬质合金断屑器 > Colinet系列刀片配套断屑器

Chip breaker > Chip breaker for Colinet series threading inserts

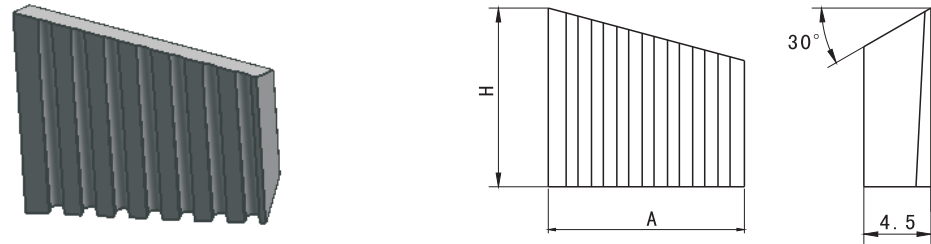
外螺纹刀片断屑器 Chip breaker for external threading inserts



型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XCQW1-1	15.8	13.2	7.318	C8BW1-1、C5BW1-1

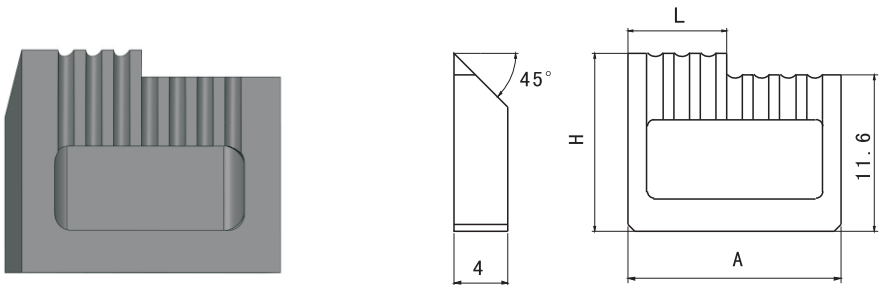


型号 Ordering code	A	H	L	适用刀片型号 Match inserts
BXCQW1BI	15.76	12.6	2.2	C8W1-31 (15°)、C8W1-32 (15°)、C10W1-31、C10W1-32
BXCQW1BII	20	12	1.9	C8W1-31 (12°)、C8W1-32 (12°)、C5BW1-31、C5BW1-32
BXCQW1BIII	25.10	13.0	2.0	C5BW1-5、BC5BW1-5D

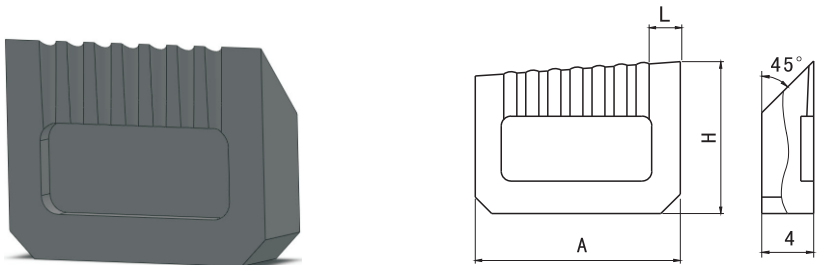


型号 Ordering code	A	H	适用刀片型号 Match inserts
TA2118B	12.5	12.5	双面刃系列圆螺纹刀片 Double-side series round threading inserts

内螺纹刀片断屑器 Chip breaker for internal threading inserts



型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XCQN1-1	15.8	13.2	7.318	C5BN1-1、C8BN1-1



型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XCQN1BI	15.75	12.6	2.4	C8N1-3、C8N1-3F
XCQN1BII	15.80	12.7	1.3	C8N1-4、C10N1-5
XCQN1BIII	25.20	12.7	2.4	C8N1-7、C10N1-8、C5BN1-5



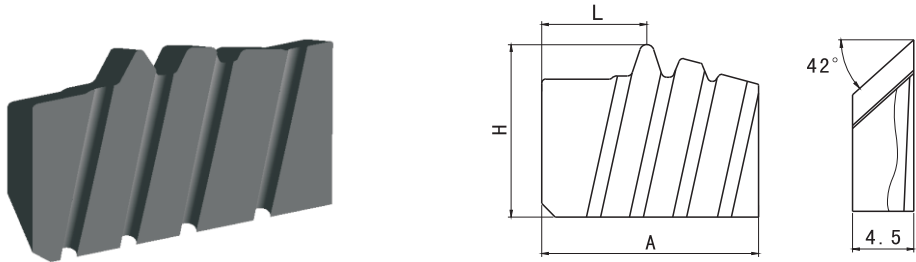
硬质合金断屑器 > PMC系列刀片配套断屑器

Chip breaker > Chip breaker for PMC series threading inserts

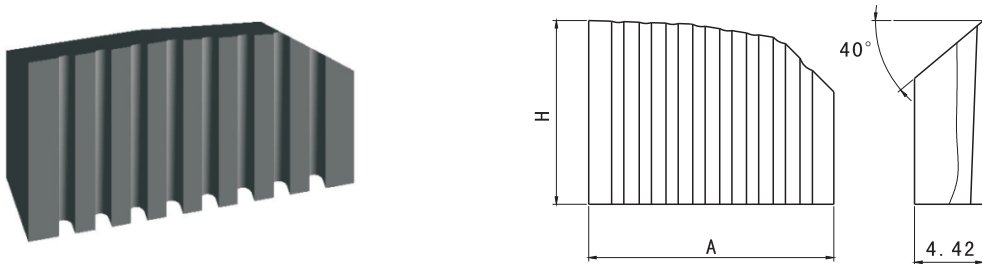
硬质合金断屑器 > PMC系列刀片配套断屑器

Chip breaker > Chip breaker for PMC series threading inserts

外螺纹刀片断屑器 Chip breaker for external threading inserts

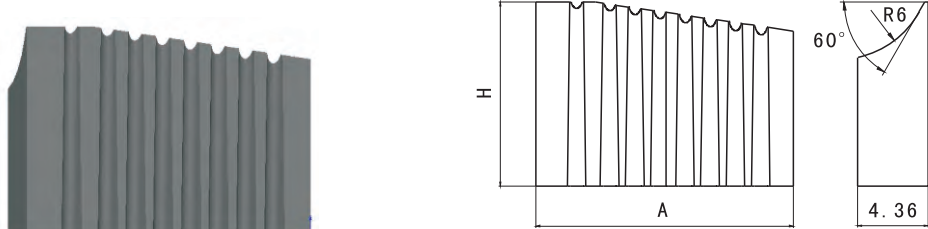


型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XP8W1-31	15.93	12.66	7.72	P8W1-31 (12°) 、P8W1-31 (15°)
XP8W1-32	15.93	13	6.67	P8W1-32 (12°) 、P8W1-32 (15°)
XP8W1-33	15.93	13.4	5.61	P8W1-33 (12°) 、P8W1-33 (15°)
XP10W1-31	16	12.82	7.3	P10W1-31
XP10W1-32	16	12.82	6.46	P10W1-32
XP10W1-33	16	13.32	5.61	P10W1-33

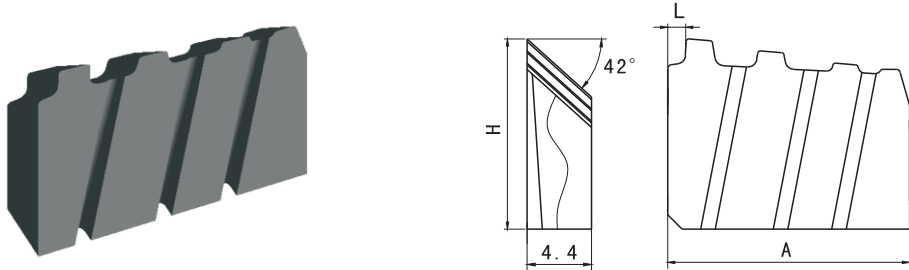


型号 Ordering code	A	H	适用刀片型号 Match inserts
XP8W1B	16	12.45	P8W1-31、P8W1-32、P8W1-33
XP10W1B	16	12.45	P10W1-31、P10W1-32、P10W1-33

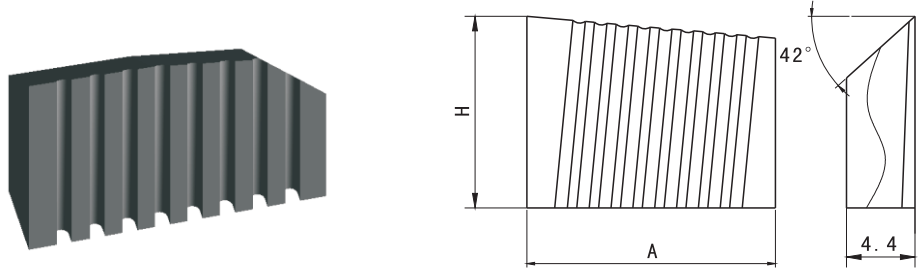
外螺纹刀片断屑器 Chip breaker for external threading inserts



型号 Ordering code	A	H	适用刀片型号 Match inserts
XP8WR6	16	11.42	P8W1-31、P8W1-32、P8W1-33



型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XP5BW1-31	16.9	13.6	4.8	P5BW1-31
XP5BW1-32	16.9	13.45	3.1	P5BW1-32
XP5BW1-33	16.9	14.2	1.25	P5BW1-33



型号 Ordering code	A	H	适用刀片型号 Match inserts
XP5BW1-B	16.9	12.32	P5BW1-31、P5BW1-32、P5BW1-33



硬质合金断屑器 > PMC系列刀片配套断屑器

Chip breaker > Chip breaker for PMC series threading inserts

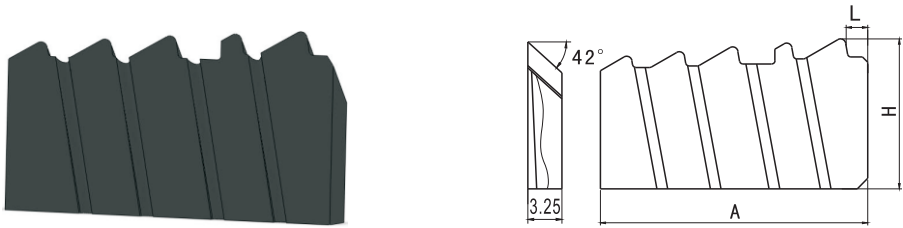
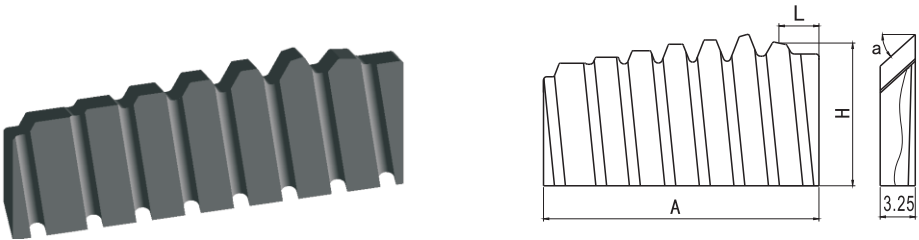
硬质合金断屑器 > PMC系列刀片配套断屑器

Chip breaker > Chip breaker for PMC series threading inserts

D

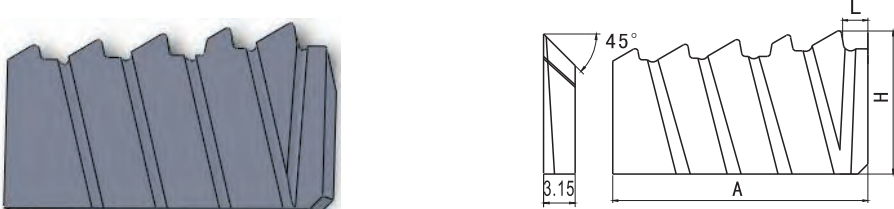
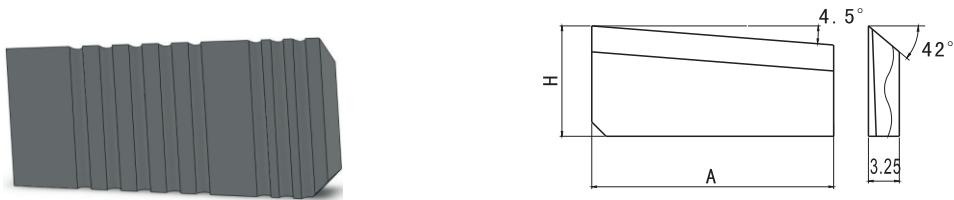
内螺纹刀片断屑器 Chip breaker for internal threading inserts

内螺纹刀片断屑器 Chip breaker for internal threading inserts



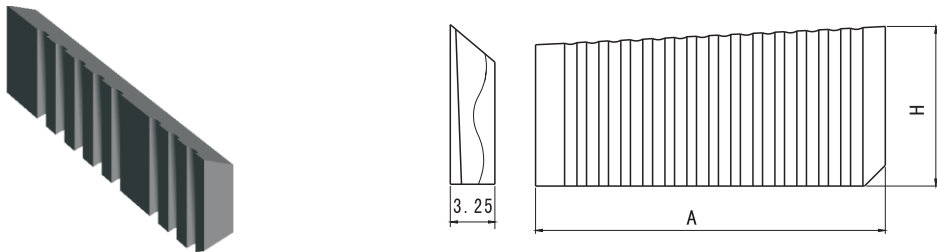
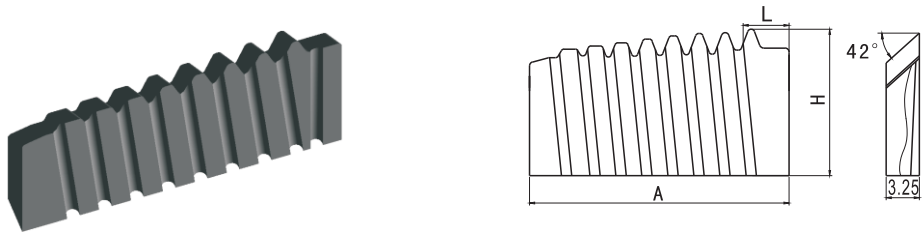
型号 Ordering code	A	H	L	α	适用刀片型号 Match inserts
XP8N1-7	25.4	14.3	3.7	42°	P8N1-7
XP8N1-7A	25.4	14.25	3.7	45°	P8N1-7

型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XP5BN1-5	25.4	14.55	2.17	P5BN1-5



型号 Ordering code	A	H	适用刀片型号 Match inserts
XP8N1-7B	25.4	12.93	P8N1-7

型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XP5BN1-5A	25.4	14.3	2.5	P5BN1-5

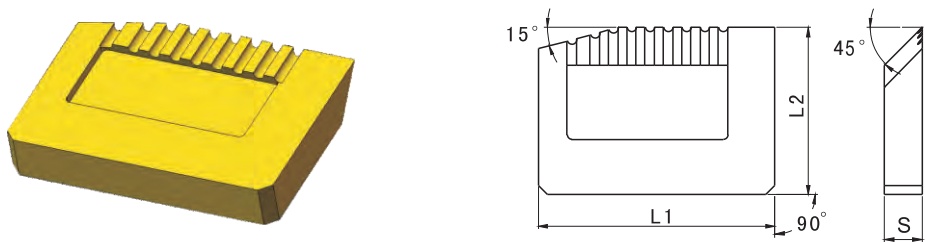


型号 Ordering code	A	H	L	适用刀片型号 Match inserts
XP10N1-8	25.4	14.34	4.49	P10N1-8

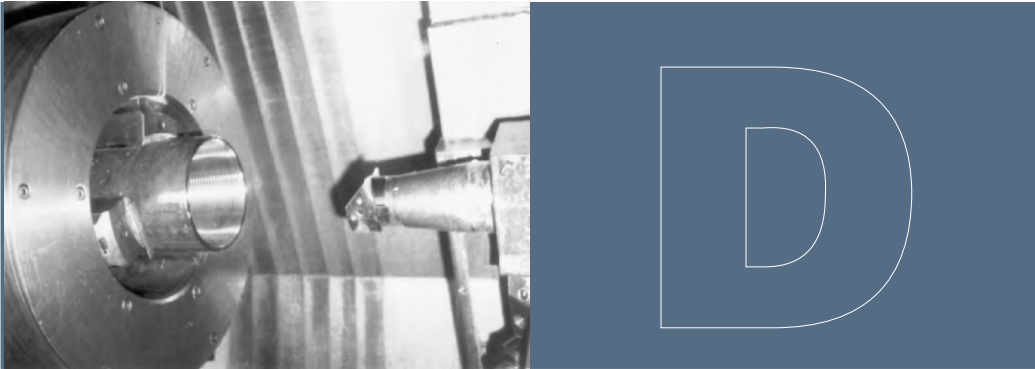
型号 Ordering code	A	H	适用刀片型号 Match inserts
BXPQN1C	25.4	11.6	BP5BN1-5、BP10N1-8、BP8N-17

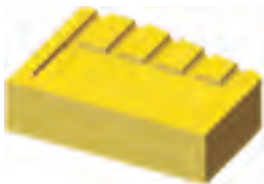
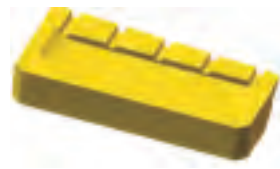
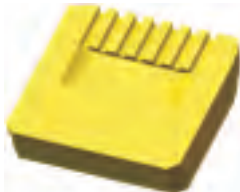
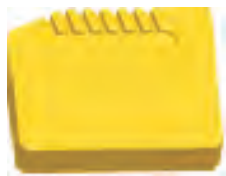


D



型号 Ordering code	L1	L2	s	配套刀片 Match inserts
C/26419	25.5	18	4.05	C/26417

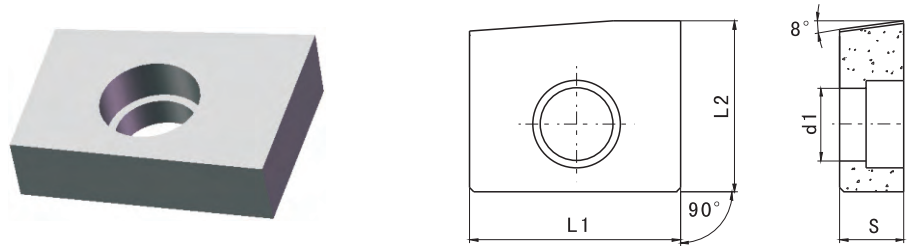


			
TG3-1	TG3-2	TG3-3	
			
TG3-4	TG3-5	TG3-7	
			
TG3-8	TG3-9	C/41107	
			
C/26244A	C/27525	C/32155	
			
C/23932/2	C/26419/T	TA2586	TA3848

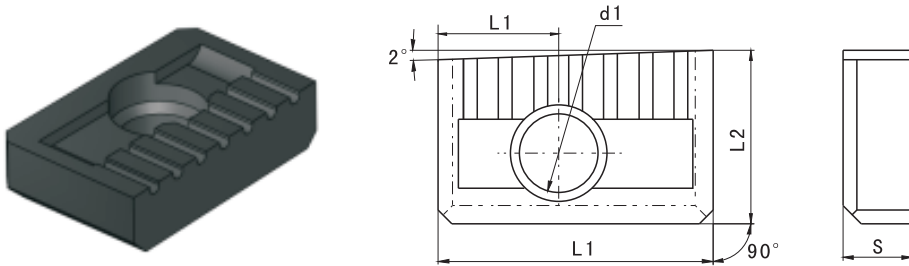


硬质合金刀垫
Shim

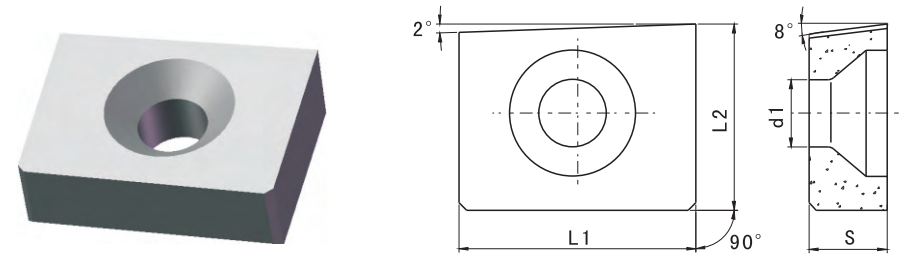
Colinet系列螺纹刀片配套刀垫 Shim for Colinet series threading inserts



型号 Ordering code	L ₁	L ₂	d ₁	S	适用刀片型号 Match inserts
TG2-6	15.65	12.7	5.4	5	C8W1-31 (15°)、C8W1-32 (15°) C10W1-31、C10W1-32



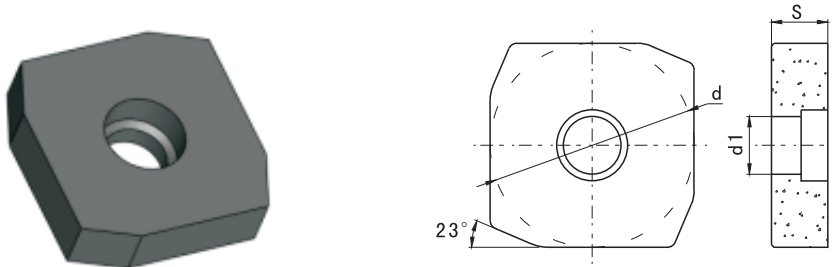
型号 Ordering code	L ₁	L ₂	L ₃	d ₁	S	适用刀片型号 Match inserts
C/28681	19.9	12.6	8.7	5.7	5	C5BW1-31、C5BW1-32 C8W1-31 (12°)、C8W1-32 (12°)



型号 Ordering code	L ₁	L ₂	d1	d2	S	适用刀片型号 Match inserts
TG2-3	25.5	12.91	5.29	6.46	4.76	C8N1-7、C10N1-8

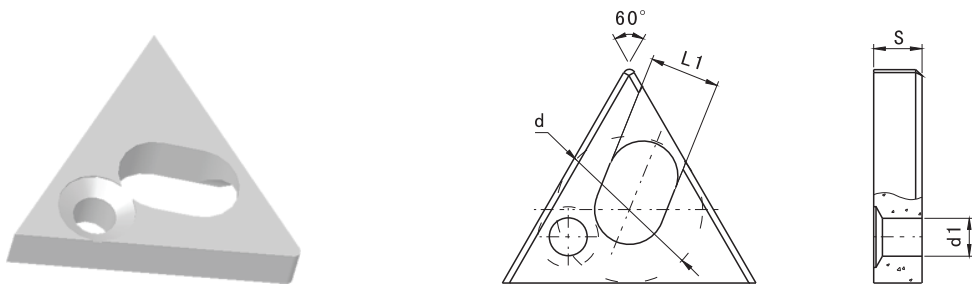
硬质合金刀垫
Shim

Colinet系列螺纹刀片配套刀垫 Shim for Colinet series threading inserts

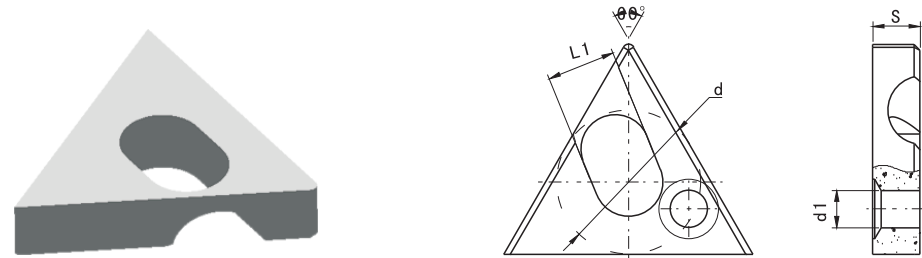


型号 Ordering code	d	d ₁	S	适用刀片型号 Match inserts
C/26418	22.5	6.6	6.35	C/26417

蝶形系列螺纹刀片配套刀垫 Shim for Papilionaceous series threading inserts



型号 Ordering code	L ₁	d	S	d ₁	适用刀片型号 Match inserts
169.523	4.8	9.6	3.18	2.5	B8N2-3H、B10N2-4H



型号 Ordering code	L ₁	d	S	d ₁	适用刀片型号 Match inserts
169.798	4.8	9.67	3.18	2.5	B8W2-3H、B10W2-4H B5BW2-2



硬质合金刀垫

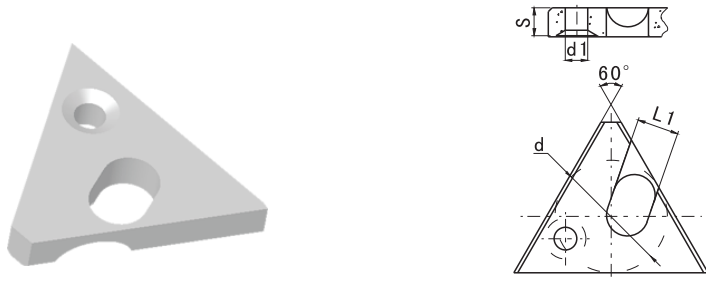
Shim

硬质合金刀垫

Shim

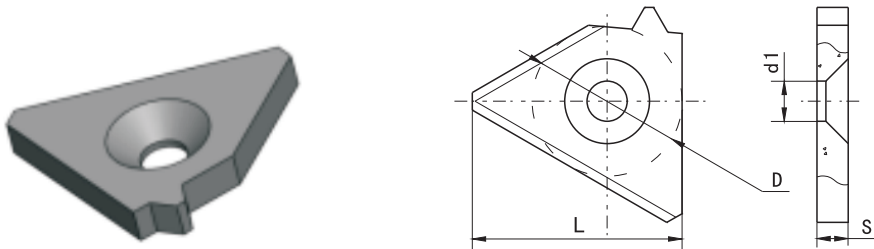
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蝶形系列螺纹刀片配套刀垫 Shim for Papilionaceous series threading inserts

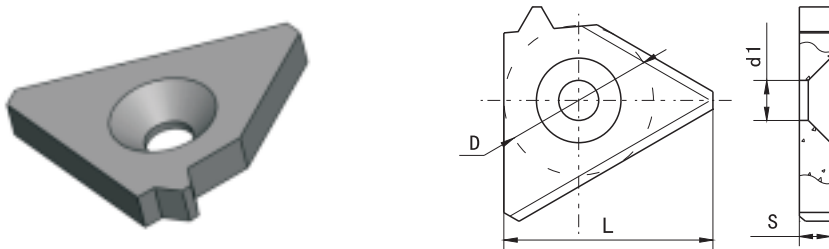


型号 Ordering code	L ₁	d	S	d ₁	适用刀片型号 Match inserts
169. 973	20. 7	12. 38	3. 18	2. 5	B5BN2-3

钻杆系列螺纹刀片配套刀垫 Shim for drill rod series threading inserts

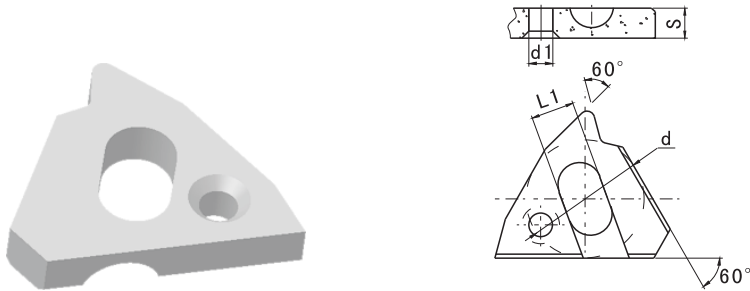


型号 Ordering code	L	D	d ₁	S	适用刀片型号 Match inserts
J4 (5) N3-DD	23. 5	16. 8	4. 5	3. 5	4Y1N3、4Y2N3、 4Y4N3、4Y5N3、 4Y7N3、5Y3N3

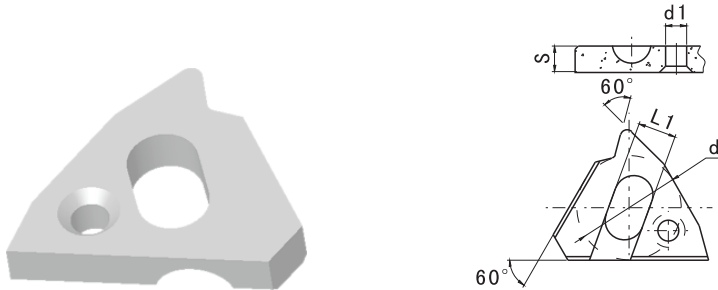


型号 Ordering code	L	D	d ₁	S	适用刀片型号 Match inserts
J4 (5) W3-DD	23. 5	16. 8	4. 5	3. 5	4Y1W3、4Y2W3、 4Y4W3、4Y5W3、 4Y7W3、5Y3W3

钻杆系列螺纹刀片配套刀垫 Shim for drill rod series threading inserts



型号 Ordering code	L ₁	d	S	d ₁	适用刀片型号 Match inserts
169. 737	4. 6	12. 5	3. 18	2. 5	B4Y1N3、B4Y2N3、 B4Y4N3、B4Y5N3、 B4Y7N3、B5Y3N3



型号 Ordering code	L ₁	d	S	d ₁	适用刀片型号 Match inserts
169. 537	4. 6	12. 5	3. 18	2. 5	B4Y1W3、B4Y2W3、 B4Y4W3、B4Y5W3、 B4Y7W3、B5Y3W3



硬质合金刀垫
Shim

石油管螺纹刀具的使用

The use of carbide threading tools for oil pipes

E

(1) 影响石油管螺纹加工质量和刀具切削性能三要素

Three factors of affecting the machining quality of carbide threading tools for oil pipes and tool machinability.

(a) 刀具本身的外部要素。包含：

External factors of the tools ,including:

- ①、刀具结构设计的合理性；
Rationality of the design of the tool structure;
- ②、刀片刃面及齿形精度、光洁度及表层组织状况；
Blade face, the profile accuracy, degree of finish and the condition of surface structure;
- ③、刀片刃口强化质量；
Enforcing quality of cutting edge
- ④、刀杆制造精度及附件如断屑器等的质量。
Manufacturing accuracy of the rod and the quality of the accessories ,such as break chips.

(b) 刀片本身的内在要素。主要包含：

Internal factors of the inserts ,including:

- ①、刀片基体材料质量与性能；
Quality and performance of the base material of inserts
- ②、刀片表面涂层质量与性能；
Quality and performance of the top coating of inserts
- ③、刀杆材质及热处理性能。
Materials , performance of the heat treatment of tool rods

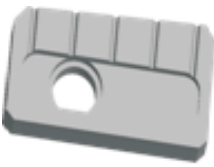
(c) 刀片的使用要素。主要包含：

Use factors of tools, including:

- ①、刀具的正确选择和使用；
Correct choice and use of tools
- ②、螺纹加工设备状况；
The statue of thread processing equipment
- ③、切削冷却方式及效果；
Mode and effect of cutting cooling
- ④、被加工材料的可加工性及材质均匀性；
Workability and homogeneity of the machined materials
- ⑤、螺纹加工切削规范的正确选择。
Correct choice for cutting specification of thread processing

要素(a)、(b)取决于刀具生产者单位，要素(c)取决于刀具使用者单位。刀具合理使用的重要性可见一斑。

(a) (b) depended on tools manufacturer, (c) depended on tools user. Reasonably using tools is very important.



TG2-4



TG2-5



TG2-8



TG2-9



TG2-10



TG2-12



TA2997A



TA4142



TA4121A



TA5243



TA5587



UCN120612



C/26246D



C/26247



C/27526E



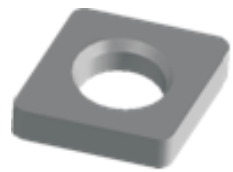
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512.083



512.123



570.013



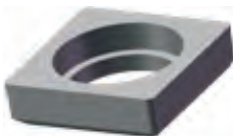
169.333



SM45



7815000



7883003



NX22-1



(2) 石油管螺纹加工的两种方式

Two processing mode of carbide threading tools for oil pipes

第一种：螺纹车削方式：(油、套管及钻杆螺纹加工均采用)

Mode of threading(used to process thread oil pipes, casing pipes and boring rod)

其切削运动的特点为：

The features of the cutting movement.

- 工件(管体或接箍、接头)作旋转运动。产生切削主运动。

Rotational movement of the work pieces (pipes or connectors).The principle cutting movement is occurred.

- 刀具(螺纹刀具及拔荒刀)作沿锥螺纹母线方向的走刀运动及间断的吃刀。

Movements and intermittent bites while the tools(threading and roughing tools)move along the generatrix of taper thread.

- 螺纹车削方式为最广泛应用的石油管螺纹加工方式。其中有单个刀片切削及成组刀片(一般为二片刀)配合组合刀具切削二种，视具体生产条件及车丝机而定。钻杆接头螺纹加工全部采用单刀螺纹车削方式。

Threading is used an the most widely way of processing the thread of oil pipes. According to the production conditions and threading machine, there are two ways: single insert threading and packaged inserts (two blades in general) threading with tools units. All the drill rod connectors are threaded by single insert threading.

第二种：螺纹切头加工方式：(仅油、套管螺纹加工采用)

Mode of processing threading head (only used to process thread oil pipes, casing pipes)

其切削运动的特点为：

The features of the cutting movement:

- 工件(管体或接箍)在切削加工时被定位装夹牢固及静止。

Work pieces(pipes or connectors) are positioned and clamped firmly.

- 刀具(螺纹刀具及拔荒刀)作绕工件轴线旋转的切削主运动及同时作沿锥螺纹母线方向的走刀运动及间断的吃刀。

And still movements and intermittent bites while the tools(threading and roughing tools) rotate around the work pieces axis and move along the generatrix of taper thread.

- 螺纹切头加工方式分为外切头及内切头两种。适用于大量生产油管、套管及其接箍的加工，生产效率高。外切头一般含三片刀片的成组螺纹刀片及成组的拔荒刀，内切头含一片螺纹刀片及多片拔荒刀片等。

The ways for processing are internal cropping and external cropping. They are fit for producing oil pipes, tubing and processing connectors efficiently in large number. External cropping contains packaged threading inserts(three blades in general) and roughing tools units; internal cropping contains single insert threading insert and packaged blades in roughing tools units.

石油管螺纹刀具的使用

The use of carbide threading tools for oil pipes

(3) 石油管加工推荐配刀方案

Recommended Proposal for oil pipe processing

2 3/8" 加工方案如下：Machining Proposal

内螺纹：

Internal Threading:

P10(8)N2-AR80×140(A1)

加工圆螺纹

Round Thread Processing

PSKNR12/12-AR80×140(A1)

镗内孔、平端面

Inner Hole Boring, face turning

外螺纹：External Threading:

P10(8)W2-A32-TCMX

加工圆螺纹、去外毛刺

Round Thread Processing , external scarfing

MRGCL3225P16

车外圆、平端面

External Turning, face turning

2 7/8"~3 1/2" 加工方案如下：Machining Proposal:

内螺纹：

Internal Threading:

P10(8)N2-AR80×140(A2)

加工圆螺纹

Round Thread Processing

PSKNR12/12-AR80×140(A2)

镗内孔、平端面

Inner Hole Boring, face turning

外螺纹：

External Threading:

P10(8)W2-A32-TCMX

加工圆螺纹、去外毛刺

Round Thread Processing , external scarfing

MRGCL3225P16

车外圆、平端面

External Turning, face turning

3 1/2"~4 1/2" 加工方案如下：Machining Proposal:

内螺纹：

Internal Threading:

P10(8)-PSN12/12-BR80×200

加工圆螺纹、平端面、镗内孔

Round Thread Processing, face turning, inner hole boring

外螺纹：

External Threading:

P10(8)W2-B32-TCMX

加工圆螺纹、去外毛刺

Round Thread Processing , external scarfing

MRGCL3225P16

车外圆、平端面

External Turning, face turning



4¹/₂"~7" 加工方案如下: Machining Proposal:

内螺纹:		
Internal Threading:		
P10(8)-PSN15/15-CR80×200	加工圆螺纹、平端面、镗内孔	
	Round Thread Processing , face turning, inner hole boring	
P5B-PSN15/15-CR80×200	加工梯形螺纹、平端面、镗内孔	
	Buttress Thread Processing , face turning, inner hole boring	
外螺纹:		
External Threading:		
P10(8)W2-B32-TCMX	加工圆螺纹、去外毛刺	
	Round Thread Processing , external scarfing	
P5BW2-B32-TCMX	加工梯形螺纹、去外毛刺	
	Buttress Thread Processing , external scarfing	
MRGCL3225P16	车外圆、平端面	
	External Turning, face turning	

7" 以上加工方案如下: Machining Proposal:

内螺纹:		
Internal Threading:		
P10(8)-PSN15/15-DR80×200	加工圆螺纹、平端面、镗内孔	
	Round Thread Processing , face turning, inner hole boring	
P5B-PSN15/15-DR80×200	加工梯形螺纹、平端面、镗内孔	
	Buttress Thread Processing , face turning, inner hole boring	
外螺纹:		
External Threading:		
P10(8)W2-C32-TCMX	加工圆螺纹、去外毛刺	
	Round Thread Processing , external scarfing	
P5BW2-C32-TCMX	加工梯形螺纹、去外毛刺	
	Buttress Thread Processing , external scarfing	
MRGCL3225P16	车外圆、平端面	
	External Turning, face turning	



※ 以上方案仅供用户参考
The above plan is only for customer reference

(4) 硬质合金石油管螺纹刀片的选用建议

Suggestions for selecting carbide threading inserts for oil pipes

(1) 油管套管螺纹刀片:
Threading inserts for tubing and casing:

- (A) 大批量生产条件:
Condition for mass production:
- (a) 采用螺纹切头加工方式的车丝机选用的刀片:
Insert for threading machine of threaded head:
加工外螺纹(成组刀片)有: External threading inserts(completed inserts):
P8W1-31/P8W1-32/ P8W1-33; P10W1-31/2/3; P5BW1-31/2/3等。
加工内螺纹有: Internal threading inserts:
P8N1-7; P10N1-8; P5BN1-5;
- (b) 采用螺纹车削方式的车丝机选用的刀片:
Insert for threading machine of threaded turning:
加工外螺纹: External threading inserts:
成组刀片有: Completed inserts:
C8W1-31/C8W1-32; C10W1-31/C10W1-32; C5BW1-31/C5BW1-32
BC8W2-31/BC8W2-32; BC10W2-31/BC10W2-32
C8W1-3; C10W1-4;
单片刀片有: Single inserts:
B8W2-3; B10W2-4; B5BW2-2
S8W2-3; S5BW2-2
BM8W2-3; BM10W2-4;
K8W2-4; K5BW2-3; K5BW2-3D
5BW1-3; C5BW1-5
加工内螺纹: Internal threading inserts:
08N1-7; C10N1-8; C5BN1-5; C5BN1-2; C5BN1-3
B8N2-3; B8N2-5; B10N2-4; B5BN2-3; B5BN2-2
S8N2-4; S5BN2-2
K8N2-4; K5BN2-3; K5BN2-3D
U5BN1-5; U5BN1-5F
U8N1-7; U8N1-7F; U10N1-7
SK8N1-3; SK8N1-5

(B) 小批量生产条件(均采用螺纹车削方式加工)选用的刀片:
Insert for pilot production(processing in threaded turning):
加工外螺纹: External threading inserts:
10WI-2; 8W1-2;



8W3-2; 10W3-2;
16ER8API; 16ER1OAPI
5BWL3;
加工内螺纹: Internal threading inserts:
10N4-2; 8N4-2;
10N3-2; 8N3-2;
16NR8API; 16NR1OAPI
5BNL3;

(2) 钻杆螺纹刀片(均采用螺纹车削方式加工):
Threading inserts of drill rod(processing in threaded turning):

- I 型刀片: 通用
Type I : ordinary
II 型刀片: 通用
Type II : ordinary
III 型刀片: 主要适用于3 1/2" 以下小规模格钻杆接头内外螺纹加工。
Type III : mainly used on external and internal thread for tool joint below 3 1/2" .

(5) 石油管螺纹刀片切削图形
Cutting figures of carbide threading inserts for oil pipe

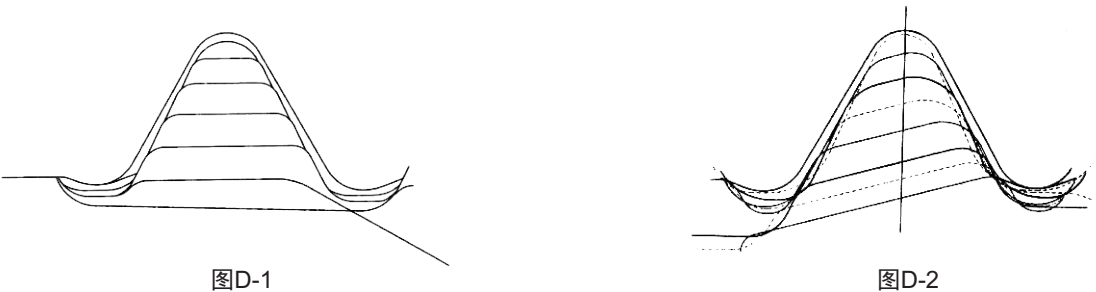
石油管螺纹刀片存在如何合理设计各齿结构的切削图形及各齿切削负荷的分配问题, 它对于改善及提高螺纹加工质量、效率及刀具寿命十分孟要。单齿刀片(如钻杆接头刀片)存在设计不同进给及吃刀方式决定每次切削行程的切削图形问题, 而不由刀齿齿形结构决定。
The right design of teeth structure and load will progress the quality and efficiency of carbide threading inserts, also will increase the service life of inserts. The different feed ways will decide the cutting figures of single teeth insert (e.g. drill rod connector insert),but not decided by the teeth structure.

(1) 一次走刀行程完成全螺纹切削的情况:
Thread cutting condition of one time feeding:

在机床功率及刚性足够大时, 以一次行程完成全螺纹切削的方案为最佳方案, 即可以显著提高效率, 又可最为合理设计切削图形, 提高螺纹刀片寿命。必须注意, 无论是一次走刀行程还是多次行程完成全螺纹切削的螺纹刀片, 其最后一个精车齿即为保证螺纹精度的齿形, 必须覆盖全螺纹牙形并在各部位均含有合理切削余量。(两齿侧为0.07-0.12mm.齿底齿顶为0.10-0.20mm)
If the power and stiffness of threading machine is enough large, finish the thread cutting by the one time feeding will be the most favorable alternatives. Which will increase the efficiency and design the cutting figures more reasonable, increasing the service life of inserts. Notes: no matter the threading insert finish thread cutting by one time feed or repeatedly feed, the last fine teeth must wholly cover the threading teeth and ensure the chipping allowance is reasonable(the side tooth is 0.07-0.12mm,tooth top and tooth bottom is0.10-0.20mm).

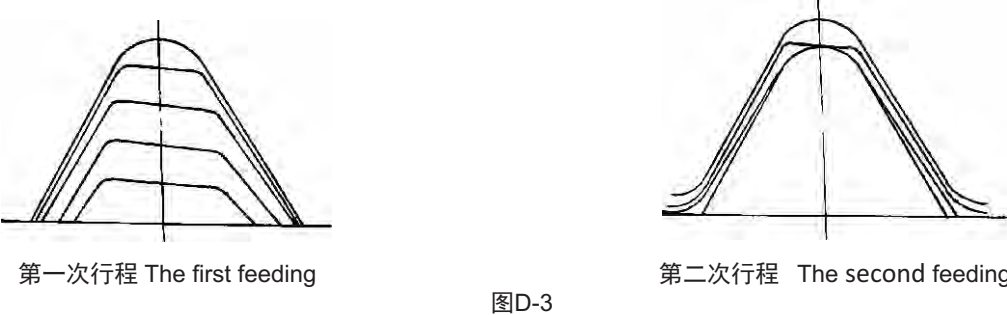
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例1: P8N1-7的套管接箍圆螺纹的内螺纹切削图形(图D-1)
e.g. 1: The cutting figures of internal round threading of P8N1-7 casing connector. (D-1)
例2: P8W1-31/P8W1-32/P8W1-33的三大片成组套管管体回螺纹的外螺纹切削图形(图D-2)
e.g. 2: The cutting figures of external round threading of casing pipe body formed by P8W1-31/P8W1-32/P8W1-33. (D-2)

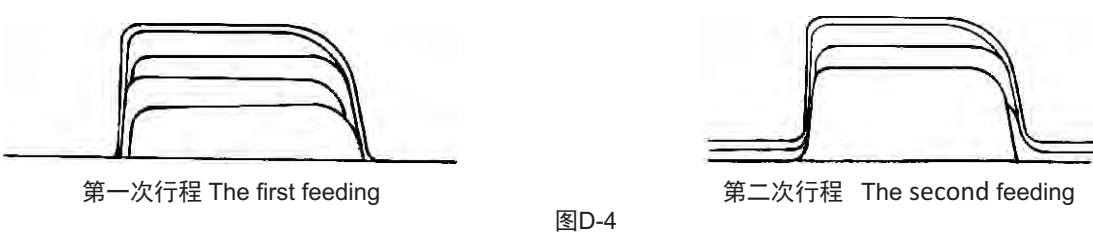


(2) 多次走刀行程完成全螺纹切削的情况:
Thread cutting condition of repeatedly feeding:
在车丝机功率及刚性不能满足一次走刀行程完成全螺纹切削的情况下只能采取多次走刀行程来完成。此时, 第一次行程应切除主要的余最, (特别是对3个齿以上的刀片), 故螺纹刀片切削图形设计以第一次行程的分配作为依据。随后的行程对各粗车齿而言, 切削t都是较小的。
If the power and stiffness of threading machine is not enough large to complete the one time feed, have to use the repeatedly feeding. In this case, the first process should cut down the most chipping allowance,(specially for the 3 tooth or more), so the allocation of the first process will decide the design of inserts cutting figures. The next process for roughing tooth , the chipping allowance will be small.

例1: B8N2-5套管接箍圈螺纹的内螺纹切削图形(图D-3)
e.g. 1: The cutting figures of internal round threading of B8N2-3 casing connector. (D-3)



例2: P5BN1-5套管接箍偏梯形螺纹的内螺纹切削图形(图D-4)
e.g. 2: The cutting figures of internal buttress threading of P5BN1-5 casing connector. (D-4)

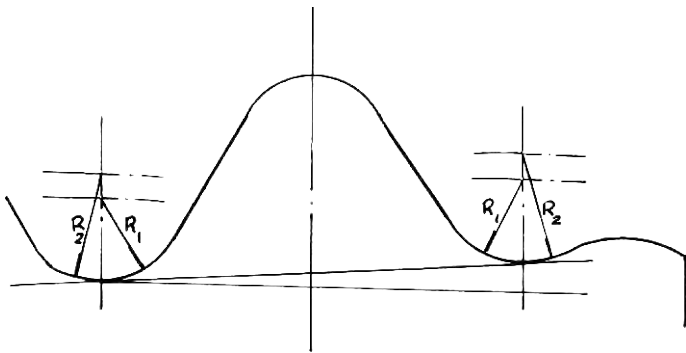




(6) 石油油管套管圆螺纹刀片精车齿底的“双圆弧”结构
"Double circular-arc" structure of refined bottom tooth of carbide threading inserts for oil pipe

如图D-5所示，石油油管及套管和其接箍加工的圆螺纹刀片，在精车齿两侧齿底处采用“双圆弧”结构，即：R1与R2二个圆弧段，且 $R2 \approx R1 + (0.2 \sim 0.3)$ ，(R1为0.508mm或0.432mm)，实践证明，可避免工件螺纹齿顶出现“小平顶扣”及齿顶“对接”划道等缺陷。

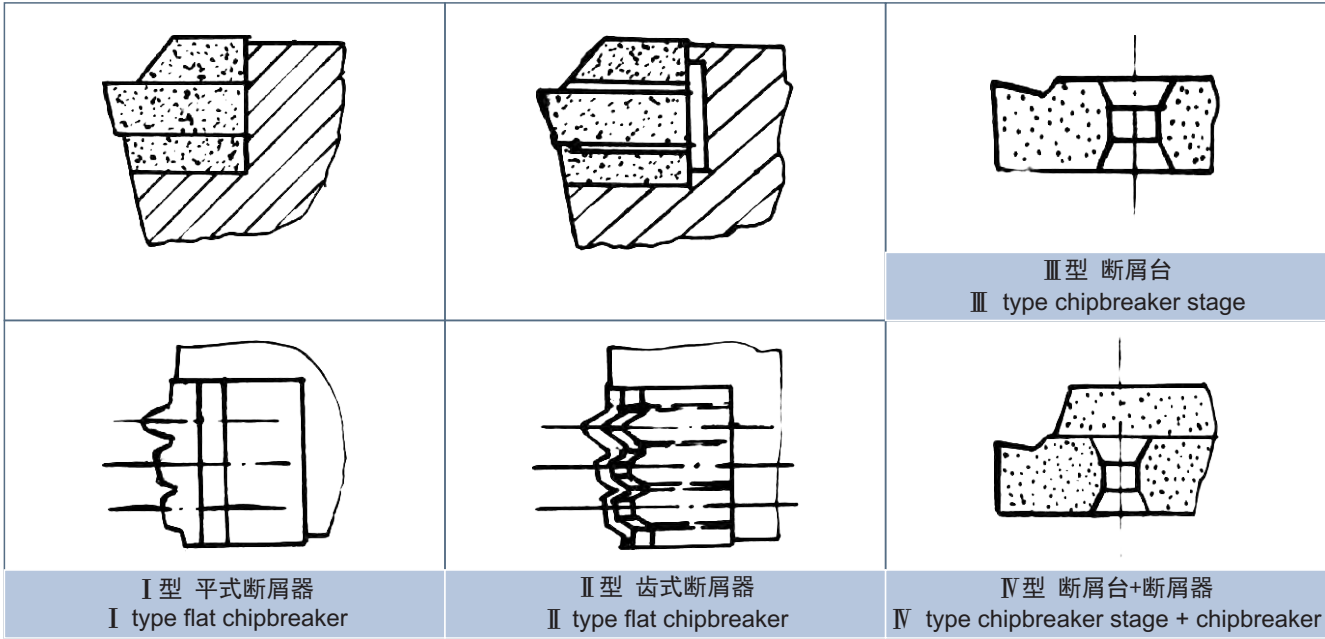
As the table D-5, the round threading inserts of tubing, casing and the connector, with the "double circular-arc" structure on the refined bottom tooth, i.e. R1, R2, $R2 \approx R1 + (0.2 \sim 0.3)$, (R1=0.508mm or 0.432mm) will help to avoid the flaws of "flat teeth" and "crash" on the tooth of the thread.



图D-5 刀片精车齿
Table D-5 finishing tooth of insert

(7) 石油管螺纹刀片槽形及断屑器的几种类型：
Several types of flute and chip breaker of carbide threading inserts for oil pipe:

采用如图D-6的四种型式的螺纹刀片槽形或断屑器结构。
D-6 four type groove and chipbreaker structure for threading inserts.



图D-6

必须指出，石油管螺纹加工中的断屑问题是当今的技术难题之一，且在多齿的刀片上优甚，特别是精车齿的断屑最为困难。上述刀片槽形及断屑器结构可对排屑及卷屑状况以明显改善，也能部分断屑。

The chip breaking is one of the difficult in oil pipe threading cutting, specially for the finishing tooth. Above structure will improve chip issuing and breaking partly.

(8) 石油管螺纹刀片装夹结构及刀杆结构的几种形式
The several forms of oil pipe thread blade clamping structure and cutter arbor structure

刀杆是介于刀片和刀架(或刀座)之间的连接部分。应具有足够的强度、硬度和精度。

The cutter arbor is a connecting part between the blade and the cutter holder(or tool apron),which must have sufficient strength , rigidity and a precision.

刀杆头部是装夹刀片的部分，柄部是装入刀架(或刀座)的部分。

The head of cutter arbor is part that is clamping the blade; the stem is part that is installed into the cutter holder (or tool apron).

刀杆头部即装夹刀片部分的结构主要是依据刀片形状而确定的。除要求本身具有足够强度和刚性外，还要保证装夹刀片的刚性、定位可靠性准确性、使用方便以及排屑断屑等要求。

The structure of the head of arbor , namely , part of clamping the blade, is mainly determined according to the blade shape. It requests not only sufficient strength and rigidity, but also requests that the rigidity of clamping blade, the position' s accuracy and reliability, the ease of use and the chip removal the chip-breaking are ensured.

不同结构形状的刀片有相应的装夹结构。可参见硬质合金石油管螺纹刀杆型号标注说明。

The different structures and shapes of the blades have corresponding clamping structures, it can be found in the type-labeling instructions for the oil pipe thread cutter shank of cemented carbide.

上压式(M及C结构)为不带孔的四方形刀片(或扇形刀片)的装夹结构。大多用于加工油、套管接箍内螺纹。勾形螺母的螺钉两端各带左、右螺纹并起压板作用将刀片及导屑板夹紧。

The up-packing type (the structure of M and C) is the clamping structure of no hole square-shaped blade (or fan-shaped blade), which is used mostly for processing the joint internal threads of oil pipes and casings. The screw of hook-shaped nut with the left thread and right thread at the both ends play the role of pressuring plate that is clamping the blade and the guide chip plate tightly.

斜拉杆内拉式(P结构)为带双锥孔刀片的内拉式夹紧结构。具有双向夹紧作用。刀片双锥孔应保证需要的精度。结构紧凑、定位可靠、刀片材料利用率高是其主要特点。油、套管及钻杆等刀片(双锥孔刀片)均适用。

The draw-in type of inclined pulling rod (the P structure) is a draw-in type clamping structure with a double-tapered-hole blade, which has a two-way clamping effect. The precision needed of the tapered hole of blade should be guaranteed. It is characterized by compact structure, reliable positioning and higher blade material utilization rate. The blades (double tapered-hole blades) of oil pipes, casings and drilling stems and others are all suitable for use.

带芯杆压板斜面双向夹紧结构(J结构)主要用在钻杆接头螺纹刀片及抽油杆部件油管螺纹的三角形直孔刀片的夹紧。

The two-way clamping structure with core rod pressuring plate slope(the J structure) is mainly used for the clamping between the drilling stem joint thread blade and the triangle straight hole cutter of oil pipe thread of sucker rod assembly.

楔块斜面侧面夹紧(F结构)用于棱体长条形非涂层可重磨式刀片的装夹结构。使用在油、套管管体外螺纹加工，夹紧牢固，刀刃磨损后可沿前刀面进行重磨以多次使用。使用时刀刃中心高可根据需要进行调整。

The wedge slope lateral clamping (the F structure) is used for the clamping structure of long prismoid strip, non-coated, regrinding-type blades, which is used in processing the external threads of oil pipe, casing body, with features of clamping firm and multiple usage by re-grinding along the cutter edge surface after the cutter edge abrasion, the blade center height can be adjusted as required when using.

立装刀片侧面压紧(G结构)主要用于立装三角形可转位偏梯形套管螺纹单齿刀片的装夹结构。刀片强度及刚性较好，夹紧牢固是其特点。此结构在上压及侧压两个方向分别加以夹固。

The lateral clamping of standing mounted blade (the G structure) is mainly used for the clamping structure of the standing mounted triangular indexable buttress casing thread single-tooth blade. It is good at its blade strength and rigidity, with features of clamping firm. This structure has clamping in the two directions of upward pressure and lateral pressure respectively.

刀杆的柄部装入刀架(或刀座)内，一般的刀杆柄部截面为方形或长方形。在某些加工内螺纹的数控车丝机上，柄部截面为圆形。柄部尺寸应保证刀杆具有足够的强度和刚性的要求，并使刀杆头部伸出长度应尽可能小，以防止产生切削振动及螺纹表面波纹。

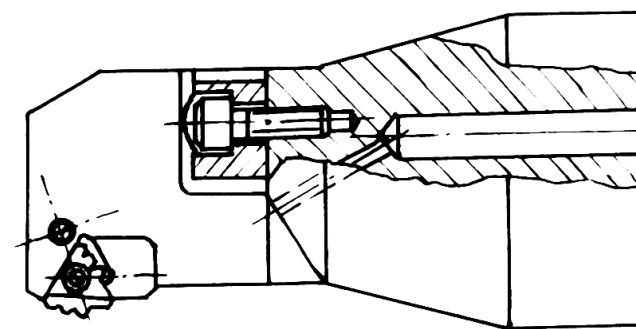
The arbor's shank is mounted into the cutter holder (tool apron), the average arbor shank section is square or rectangular. In some CNC threading lathe for processing the internal thread, the shank section is round shape. The arbor shank size should ensure the arbor shank of sufficient strength and rigidity requirements, and ensure that the ending length of arbor head should be short as much as possible to prevent the generation of cutting vibration and thread surface ripple.

大多数情况下，刀杆柄部和头部为整体结构，但也有将头部及柄部分离的模块式拼装结构，主要在内螺纹刀杆上使用，如图D-7所示。头部损坏时，只需要更换头部，不要更换整个刀杆。

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用，如图D-7所示。头部损坏时，只需要更换头部，不要更换整个刀杆。

In most cases, the arbor shank and head is an integral structure, but there is also a modular assembly structure that the head and shank is separated from each other, which is mainly used the internal thread arbor, as shown in diagram D-7. When the head is damaged, we just have to replace for the head, without need to replace for the entire arbor.



图D-7

为了保持加工螺纹时刀片两侧刃有大致相同的侧刃法向后角，刀片安装在刀杆上需要倾斜一个角度，其值应等于或接近于螺纹的螺旋升角。故与螺距及螺纹直径有关。这一倾斜角在刀杆上已加工出来，大约 $0^{\circ} \sim 1^{\circ} 20'$ 之间，分四种档次。故使用者在刀杆选用时应在管螺纹规格(直径及螺距)确定之后，来选取相应的刀杆规格。本样本C-050页中刀杆标注说明④的A、B、C、D即表示适用不同直径管材的刀杆规格。

In order to maintain that the two blade edges on both sides have roughly the same normal relief angle of side cutting edge when processing the thread, the blade installed in the arbor is on the need to tilt at an angle; its value should be equal to or near to the thread helix angle. Therefore, it is associated with the thread pitch and the thread diameter. The tilt angle has been processed out of the arbor, between about $0^{\circ} \sim 1^{\circ} 20'$, which are divided into the for sub-grades. Therefore, when the arbors are chose and used, users should choose the appropriate arbor sized after the pipe thread sizes(the diameter and the thread pitch) have been determined. The pipe thread arbor size(diameter and pitch) is determined, to select the appropriate arbor size. The A, B, C, D in the cutter arbor labeling instruction ④ on page C-050 of this sample book indicate the arbor sizes applicable to different diameter pipes.

刀杆及刀杆部件需用优质钢材制造，并进行热处理以保持及达到要求的硬度及强度，断屑器应由性能良好的硬质合金制造。刀杆基面及定位面等均应磨削以达到要求的精度。

The cutter arbor and the arbor parts are required to be manufactured from the high-quality steel. And they should be heat-treated to maintain and achieve the required hardness and strength; the chip breaker should be made of the cemented carbide. The arbor basal face and positioning surface etc. Shall be grinded so as to achieve the required accuracy.



(9) 石油管螺纹刀片切削用量的选择建议

Suggestions for selecting cutting parameters of carbide threading inserts for oil pipe

(2)走刀次数及各次吃刀深度推荐表(见表D-2)

Recommended feeding frequency and depth(table D-2)

(1) 切削速度推荐表：(见表D-1)

Recommended cutting speed(Table D-1)

刀片类型 Type	工件钢级 Steel grade					
	普通级钢 Plain	次高钢级 Seconddaryhigh	高钢级 High	抗S Resistant to corrosion	抗挤毁 Anti-collapse	高Cr、高镍 Nickelic high chromium
	以J55为代表 其他如H40、 K55、M65等 J55 H40 K55 M65	以N80为代表 其他如C75、 L80等 N80 C75 L80	以P110为代表 其他如C90、 T95、Q125等 P110 C90 T98 Q125	N80+S、SS P110+S、SS	N80+T P110+T	13Cr
	切削速度（米/分） Cutting speed(m/min)					
	90~120	80~100	----	----	----	----
非涂层刀片 Non coated insert						
涂层刀片 Coated insert	170~220	150~200	120~180	120~180	100~160	50~100

注：表列数据为带冷却液充分冷却时的选择；如为干切削则速度应低20%。

Remark: The data in table is for coolant cooling enough, when dry cutting please lower 20% speed.

表D-2
Table D-2

刀片种类规格 Type		走刀行程次序 Feed sequence											
		1	2	3	4	5	6	7	8	9	10	11	12
		吃刀深度(mm) Penetration of a tool(mm)											
Round threading(8 tooth/inch)	Internal threading 内螺纹	2齿刀片 2 tooth insert	0.60	0.40	0.35	0.30	0.20	0.20					
		3齿刀片 3 tooth insert	0.80	0.60	0.40	0.20							
		5齿刀片 5 tooth insert	1.75	0.25									
		7齿刀片(二次) 7 tooth insert	1.80	0.20									
		7齿刀片(一次) 7 tooth insert	2.00										
	External threading 外螺纹	2齿刀片 2 tooth insert	0.70	0.45	0.40	0.30	0.20						
		3齿刀片 3 tooth insert	0.85	0.60	0.35	0.20							
		3齿刀片(2片成组) 3 tooth insert	2.00										
		3齿刀片(3片成组) 3 tooth insert	2.00										
Round threading(10 tooth/inch)	Internal threading 内螺纹	2齿刀片 2 tooth insert	0.55	0.40	0.35	0.20	0.15						
		3齿刀片 3 tooth insert	0.80	0.55	0.20								
		4齿刀片 4 tooth insert	1.00	0.50	0.15								
		8齿刀片 8 tooth insert	1.60										
	External threading 外螺纹	2齿刀片 2 tooth insert	0.55	0.50	0.35	0.20							
		3齿刀片 3 tooth insert	0.90	0.55	0.15								
		4齿刀片 4 tooth insert	1.05	0.50	0.15								
		3齿刀片(2片、3片成组) 3 tooth insert	1.60										



(2)走刀次数及各次吃刀深度推荐表(见表D-3)
Recommended feeding frequency and depth(Table D-3)

表D-3
Table D-3

刀片种类规格 Type			走刀行程次序 Feed sequence											
			1	2	3	4	5	6	7	8	9	10	11	12
			吃刀深度(mm) Penetration of a tool(mm)											
Round buttress threading(5 tooth/inch)	Internal threading 内螺纹	单齿立装刀片 1 tooth insert	0.35	0.30	0.25	0.25	0.20	0.20	0.20					
		3齿刀片 3 tooth insert	0.50	0.40	0.35	0.30	0.20							
		5齿刀片 5 tooth insert	1.30	0.45										
	External threading 外螺纹	单齿立装刀片 1 tooth insert	0.45	0.35	0.30	0.25	0.25	0.20						
		2齿刀片 2 tooth insert	0.45	0.40	0.35	0.35	0.20							
		3齿刀片 3 tooth insert	0.55	0.50	0.40	0.30								
Drill rod connector threading	Internal threading 内螺纹	3齿刀片(3片成组) 3 tooth insert	1.75											
		4y1、4y2、5y3单齿刀片 single teeth insert	0.50	0.45	0.40	0.40	0.35	0.30	0.25	0.20	0.15	0.15	0.10	
		4y4、4y5单齿刀片 single teeth insert	0.50	0.45	0.45	0.40	0.35	0.35	0.35	0.30	0.30	0.25	0.15	0.10
	External threading 外螺纹	4y6单齿刀片 single teeth insert	0.45	0.45	0.40	0.40	0.30	0.30	0.25	0.20	0.20	0.10		
		4y1、4y2、5y3单齿刀片 single teeth insert	0.50	0.45	0.45	0.40	0.35	0.30	0.30	0.25	0.20	0.10		
		4y4、4y5单齿刀片 single teeth insert	0.55	0.50	0.45	0.40	0.40	0.35	0.35	0.35	0.30	0.20	0.10	
		4y6单齿刀片 single teeth insert	0.50	0.45	0.40	0.40	0.35	0.35	0.25	0.20	0.10			

※ 加工钻杆接头螺纹如用普通刀粗车，再用成形刀片精车时，则此表中成形刀片的吃刀次数应相应减少。
PS: The feeding frequency in the table should be decreased if the thread for drill rod connectors be roughing turned by plain tool then refined by form tool.

(10) 石油管螺纹刀具使用中应注意的若干问题
A number of issues that should be noticed in using oil pie thread cutting tool

(1) 使用前，使用者应了解刀具结构，加工要求及使用要求。
Before using it, the user should be aware of the tool structure, processing requests and operating requirements.

(2) 刀杆必须正确牢固装夹在刀架(或刀座)上。安装前，刀架及刀杆基面应擦拭干净。普通车丝机的刀杆柄部基面应采用百分表进行找正，使之平行或垂直于螺纹轴线方向。找正误差应在0.015mm/100mm之内。否则将引起螺纹牙形误差，甚至超差。
The arbor must be correctly and securely clamped onto the cutter holder(or tool apron). Before installation . the tool holder and arbor base surface should be wiped clean. The arbor shank base surface of general threading machine should be aligned by using a dial indicator to make it parallel or perpendicular to the screw axis. The alignment error should be within the 0.015mm/100mm. Other wise the error of thread form will be caused and even beyond the tolerance.

(3) 螺纹刀片应正确安装到刀杆的刀片槽内。用手将刀片侧边定位面靠牢，然后拧紧夹紧螺钉。刀片定位应正确可靠，夹紧牢固。夹紧螺钉或其他夹紧另件以及断屑器等如有损坏应及时更换，以免在切削时损坏螺纹刀片。每次换刀片时，刀杆上的刀片槽及刀片各基面均应擦拭干净，不得有碎屑夹入，否则会影响定位精度或把刀片夹碎。
The thread blade should be installed correctly onto the blade slot of arbor. The side positioning faces of the blade are pushed by hand firmly, and then tightening the clamp screw. The positioning of blade should be accurate and reliable, clamping firm. The clamping screw or other clamping components and chip breaker etc should be replaced in time if any damage to avoid damage in the thread blades when cutting. Each time when the blade being changed , the blade slot of arbor and all the basal surfaces of the blade should be wiped clean, not allowing any chips being.

(4) 机床锥度板一定要调整准确，尽量减少加工螺纹锥度误差。
The lathe tapered plate must be accurately adjusted to minimize the processing thread taper error.

(5) 根据不同螺纹直径和螺距大小，螺纹刀杆上的刀片槽底面具有不同的刃倾角，以适应螺旋升角的变化需要，改善刀片侧后角状况，使用者在选用刀杆时应加以注意。
According to the different thread diameters and the thread pitch sizes, the bottom surfaces of the blade slot on the thread arbor have different blade edge tilt angles to accommodate the change requirements of helix angle, improving the situation in the lateral rear angle of the blade , the user should pay attention to it in the selection of cutter arbors.

(6) 在加工过程中，应随时注意螺纹表面状态、刀片刃口状态及车丝机运转状态，以便及时调整操作，保持加工正常进行。螺纹表面缺陷最常见的是波纹和划道，影响其出现的因素较多，有螺纹刀片方面的，有机床方面的等。划道的出现可能由于:或因刀刃的光洁度，或因刀刃有微小崩刃及缺口，或因刀刃上粘有积屑瘤或因切屑缠绕刮伤所致。精车齿齿底圆弧在一侧为全圆弧者最易出现“对接”划道(指油、套管圆螺纹)。加工螺纹时，吃刀深度不够以致未能加工完拔荒的余量则在螺纹牙顶会出现明显划道。机床系统刚性差时易在管端处几扣出现牙顶划道(刀片切削时)。螺纹表面的波纹系因系统的振动引起，可能由于：系统刚度较差、机床功率不够，或由于刀刃过于锋利(如非涂层刀片的刀刃未强化的情况)，或



因刀刃磨损过大，或因系统自振频率与切削时强迫振动频率交接近时均可能引起波纹。如出现上述划道和波纹缺陷均应根据具体情况及原因加以处理。

In the process, we should always pay attention to the thread surface condition , the blade edge status and the threading machine operating state, in order to adjust operations at any time to maintain the normal process. The most common thread surface defects are corrugated and scuffing, the factors that result in their occurrences are many, some in the thread blades aspect, and another in the lathe aspect and so on. The scuffing occurrence may be due to the causes that: either the finish degree of blade, or tiny edge chippings and notches in the blade, or the chip built up sticking with the blade or the scratch wound caused by the chip. It is the most vulnerable to a ‘ docking” scuffing occurrence(refer to oil pipe, busing round thread) that the circular arc of finish turning teeth bottom at one side is a whole circular arc. In processing the thread, the depth of cut is not enough so that it fails to process the complete allowance of rough machining, therefore the clear scuffing would occur on the top of thread. If the rigidity of machine tool system is poor, it is easy that the scuffing occurs on the top of several teeth at the ending of pipe(when the blade is cutting). The ripple on the thread surface was due to the vibration of the system. And it is likely to cause ripples that: either the poorer stiffness of system, the machine power is not enough , or because the blade is too sharp(such as the situation that the edge of non-coated blades is not intensified), or the excessive wear and tear of blade, or because the system self-oscillation frequency is closer to the frequency of forced vibration in cutting .If the above scuffing and ripple defects occur, we should treat them according to the concrete circumstances and causes.

(7) 加工石油管螺纹时，对螺纹精度必须进行单项仪检查及螺纹量规检查。如果螺纹参数检查中的齿高及齿形角出现超差者，通常与刀片的齿形精度有关。必须检查刀片齿形精度或更换新的刀片。精车齿刀尖若产生，塌尖护现象易引起齿高增大超差。刀尖磨损易引起齿高减小而超差。相应地也会影响齿形角的变化。其他螺纹参数如螺距、锥度、紧密距等产生误差则往往与机床调整不当有关，需重新调整机床。

When processing the oil pipe thread, the thread must be inspected for its precision using a single parameter measurement instrument and the thread gauge. If it is found that the tooth height and the tooth profile angle is out of tolerance during the thread parameters examination, it is associated commonly with a tooth profile precision of the blade . The blade must be checked for the tooth profile accuracy or replaced with a new blade. If the finish tooth tip has a "collapse point" phenomenon , which can easily lead to that the tooth height is increased and out of tolerance. Accordingly, it will affect the change of tooth profile angle. The errors caused by other parameters such as thread pitch, taper degree, thread stand off and others are often related to the poor adjustment of machine tool, as a result, it is required to re-adjust the machine.

(8) 正确的刀片刃口强化对螺纹加工过程至关重要。涂层螺纹刀片的成品本身在生产厂家已进行合理的刃口强化工序。其刃口倒圆半径应选为R=0.04~0.06mm为合适。刀片齿顶及齿底的倒圆半径应均匀，差值不能过大。非涂层的可重磨刀片往往在生产厂家未进行过刃口强化。加工过程中若出现不正常情况(如波纹等)，操作者可用小三角油石(碳化硅或金刚石油石)顺着刃口方向对刀刃进行仔细研磨以实现刃口强化要求。重磨后的刀片刃口也应如此处理。

The right blade cutting edge is essential to strengthen the process of thread processing. The coated thread blades themselves as finished products have been conducted with a reasonable cutting edge strengthening process in the manufacturer. It is more appropriate that the cutting edge rounding radius should be chosen as R=0.04~0.06mm. The rounding radius on the top and bottom of blade teeth should be uniform; their difference is not allowed to be too large. The non-coated regrinding blades tend to be not strengthened on their cutting edges in the manufacturer. If the



abnormal conditions (such as corrugated, etc.) occur in processing, the operator can use a small triangle whetstone (silicon carbide or diamond whetstone) to make a careful grinding on the blade edge along the direction of the edge to achieve the strengthening requirements of cutting edges . The re-grinded insert edge should be treated as such.

(9) 在当前情况下，石油管螺纹加工时必须进行充分的冷却，仍以供给冷却液的方式为主。这是提高螺纹加工质量及刀具耐用度的重要因素。冷却液应正好喷射到刀齿切削部分。有条件时可用高压冷却液喷射。并在通过刀片前刃面或底面及断屑器或垫片的小槽将冷却液直接高压喷射到刀刃切削区域，效果十分明显。且有利于增加排屑作用。

Under the current situation, oil pipe thread must be fully cooled in processing, still with the coolant supply as the main way. This is the important factor to improve the quality of the thread processing and the tool life. The coolant should be just sprayed to the cutting part of the cutter exactly. If possible, high-pressure coolant injection can be used . And through the front edge surface or bottom of the blade and the chip breaker or the small slots of pads , the coolant will be jetted directly to the blade cutting area, the effect is very obvious. Also it helps increase the chip removal effect.

(10) 刀片的重磨：涂层刀片一般不宜进行重磨。非涂层刀片一般应进行重磨。重磨时只刃磨刀片的前刃面，按照原刀片前刃面的方向重磨。不应当在砂轮机上用手握持刀片或刀杆重磨，而应当在工具磨床上采用专用夹具重磨。砂轮规格推荐：

JR1，120#-180#粒度，75%浓度：SBW100X20X35

The regrinding of blades: generally the coated blade is not suitable for regrinding. And generally the non-coated blades should be re-grinded. The regrinding is only conducted on the front edge surface of the blade in the direction of the front edge surface of the original blade. The regrinding should not be implemented on the grinding wheel machine by holding the blade or the arbor in the hands, but should be carried out in the tool grinding machine by adopting a special fixture. The grinding wheel size recommended is as below:

JR1, particle size 120#-180#, density 75%: SBW100×20×35

使用中常见问题产生原因及推荐解决措施：(如表D-4)

The common problems, the causes and the recommended solutions:(as shown in table D-4)



表D-4 常见问题产生原因及推荐解决措施
Table D-4 Frequently Asked Questions and the causes and the recommend solutions

常见问题 Frequently Asked Questions	产生原因及推荐措施 The causes and the recommend solutions
(1)切削时产生振动及波纹 The vibration and the ripple caused in cutting	(1)检查系统刚度是否足够，工件及刀杆伸出量是否太长，主轴轴承是否适当调整、刀片是否夹紧牢固等。 Checking that if the rigidity of system is enough, if the exerted length of work-piece or cutting arbor is too long, if the main shaft bearing is adjusted properly, if the blade is clamped firm and so on. (2)调低或调高主轴一~二档转速试加工，选择避免波纹产生的转数。 The spindle speed is reduced or increased by one or two gears for trial processing to choose the revolution can avoid ripples. (3)对非涂层刀片，若刀刃原来未进行刃口强化，可在现场用细油石轻轻研磨刃口(顺着刃口方向)。或者在新刃口加工几个工件后，波纹即能减轻或消除。 For the non-coated blade, if the cutting edge of blade has never been strengthened originally, now we can use a fine whetstone to lap gently the cutting edge in the field(along the edge direction). Or we process several work-pieces on the new cutting edge, then the ripples can be alleviated or eliminated.
(2)刀片磨损很快，耐用度很低 The blades wear quickly, the durability is short	(1)检查一下切削用量是否选择太高，特别是切削速度及吃刀深度是否太大。并进行调整。 Checking that if the cutting data selected is too high, especially, if the cutting speed and cutting depth is too large. If so , the adjustment must be implemented. (2)是否未供给足够冷却液。 The cutting chips wind and break the blade. (3)切削挤住刀刃，引起细微崩刃而增大刀具磨损。 The chips jam the blades that lead to tiny crack tipping which increases the cutting-tool wear. (4)刀片夹固不牢，或者在切削过程中产生松动。 The blade champing is strong or loosing during cutting. (5)刀片本身质量问题。 The blade itself has quality problems.
(3)刀片大块崩刃或碎裂 The large chippings come off from the blade or the blade is cracked	(1)刀片槽内是否有碎屑或硬质颗粒夹入，在夹紧时已产生裂纹或应力。 If some scraps or rigid grains have been clamped inside, that leads to cracks or stress during clamping. (2)切屑在切削过程中缠绕及打坏刀片。 The cutting chips wind and break the blade. (3)走刀过程中刀片受到偶然碰撞。 The cutting blade comes under accidental collision during blade moving. (4)拔荒刀等的前序刀具打刀引起螺纹刀片的随后崩裂。 The cutter fight of the preorder cutters such as roughing cutters etc, leads to subsequent crack of thread blades. (5)用手操作退刀的机床，多次退时，因后面次数的退刀动作缓慢而引起刀刃负荷陡然增大打刀。 For the machine tool that retracts its cutters by hand, when retracting for many times, the cutter fights would be caused by the suddenly increasing load in the cutting edge due to the slow motion of last retracts. (6)工件材质不均匀或可加工性很差。 The material quality of work-pieces is not uniform or their machinability is very poor. (7)刀片本身质量问题。 The blade itself has quality problems.

表D-4 常见问题产生原因及推荐解决措施
Table D-4 Frequently Asked Questions and the causes and the recommend solutions

常见问题 Frequently Asked Questions	产生原因及推荐措施 The causes and the recommend solutions
(4)管螺纹齿形误差超差 The errors of pipe thread teeth profile are out of tolerance	(1)刀片精车齿刀刃已磨损，需更换新的刀片。 The finish turning teeth cutting edge of blade has been worn, and it is needed to be replaced by new one. (2)刀片精车齿产生“塌尖”现象，应当降低切削速度及吃刀深度。 The finish turning teeth of blade have a “collapse tip” phenomenon; we should appropriately reduce the cutting speed and the cutting depth. (3)刀片或刀杆安装不正确。如刀杆安装时未找正基面，刀片基面未靠牢等。 The blade or the arbor is installed improperly such as the basal surface fails to be aligned during installing; the basal surface of blade fails to be leaned against firmly. (4)刀刃上产生微小崩刃，应及时换刀。 The cutting edge has tiny crack tipping , the cutter must be replaces in time. (5)刀刃上产生积屑瘤，应当提高切削速度，或用细油石轻轻研磨去除积屑瘤，或更换刀片。 The blade has some chip build up, to avoid it, we should increase appropriately the cutting speed , or use fine whetstone to gently lap and remove the buildup, or replace for the blade.

※ 以上方案仅供用户参考
The above plan is only for customer reference