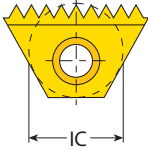


VarDEX产品订货码

■ 螺纹铣削刀片

3	B	I	1.5	ISO	TM2	F	VBX	028/...
1	2	3	4	5	6	7	8	9

1- 刀片尺寸 6.0 - 6.0 mm 2 - 1/4" 3 - 3/8" 3B - 3/8"B 4 - 1/2" 5 - 5/8" 6B - 3/4"B 	2- 切削刃长 B - TMB	3- 加工类型 E - 外螺纹 I - 内螺纹 EI - 外螺纹 + 内螺纹	4- 螺距 0.35 - 6.0
5- 标准型 ISO- ISO 公制螺纹 UN- 美制UN UNJ- UNJ W- Whitworth for BSW, BSP NPT - NPT NPTF - NPTF NPS- NPS	BSPT- British Standard Pipe Thread PG- Pg DIN 40430 ACME- ACME TR- Trapez DIN 103	6- 产品系列 TM2 TM	8- 刀片材质 VBX VTX VK2
		7- 螺距类型 F = 细牙螺纹	9- 粗牙刀片 028/...

■ 螺纹铣削刀杆

B	TM	N	C	20	-	3	B		LH	-	
1	2	3	4	5		6	7	8	9		10

1- 刀杆形式 B - 防震系统	2- 加工类型 TM - Thread Milling	3- 镗杆型式 2 - 双槽 M - 小型 L - 长型 N - 锥形刀杆 V - 立装刀杆 S - 单齿刀杆 O - 偏置刀杆 W - 加粗型刀杆	4- 冷却类型 C - 中心孔冷却
5- 刀杆柄径 10, 12, 16, 20, 25, 32, 40	6- 刀片尺寸 6.0 - 6.0mm 2 - 1/4" 3 - 3/8" 3B - 3/8"B 4 - 1/2" 5 - 5/8" 6B - 3/4"B	7- 刃口长 B - TMB	9- 左/右手刀杆 None - 右手 LH - 左手
		8- 系列号 (针对TMO刀杆) 1 - 16	10- 系列号 (针对粗牙刀杆) 124/...

■ 螺纹盘铣刀

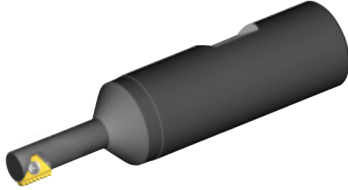
TMSH	-	D63	-	22	-	3	B
1		2		3		4	5

1- 产品系列 Thread Mill Shell Mill	2- 切削直径 38, 50, 63, 80, 100, 125	3- 连接孔直径 16, 22, 27, 32, 40	4- 刀片尺寸 2 - 1/4" 3 - 3/8" 3B - 3/8"B 5 - 5/8" 6B - 3/4"B
5- 刃口长 B - TMB			

螺纹铣削标准系列

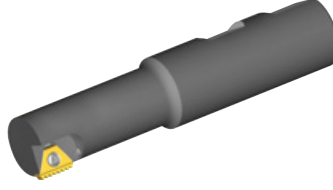


TMMC 小直径加工



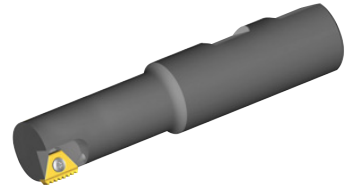
排屑槽数 (Z) 1
切削直径 (D2) 9.0
刀杆悬伸长度 (L1) 12.0-17.0

TMC 通用加工



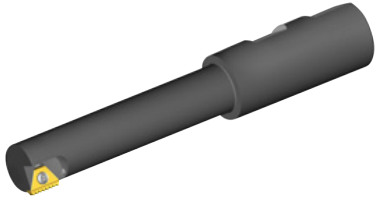
排屑槽数 (Z) 1
切削直径 (D2) 9.0-46.0
刀杆悬伸长度 (L1) 12.0-63.0

TMC 124/... 粗牙螺纹

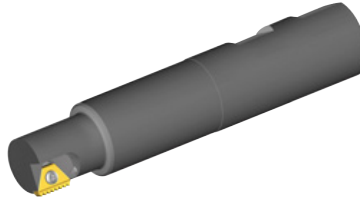


排屑槽数 (Z) 1
切削直径 (D2) 9.0-22.0
刀杆悬伸长度 (L1) 15.0-40.0

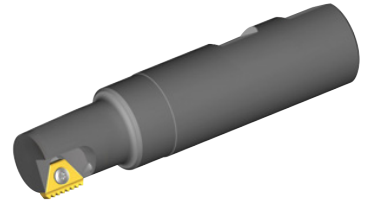
TMLC 长螺纹加工



排屑槽数 (Z) 1
切削直径 (D2) 11.5-46.0
刀杆悬伸长度 (L1) 17.0-93.0

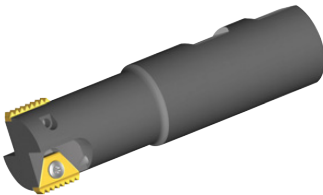


TMNC 锥螺纹加工



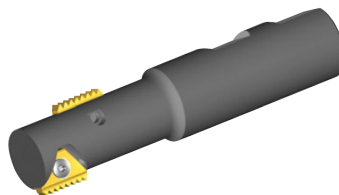
排屑槽数 (Z) 1
切削直径 (D2) 15.5-37.0
刀杆悬伸长度 (L1) 22.0-58.0

TM2C 高进给



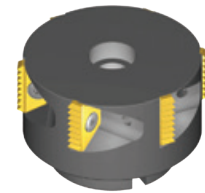
排屑槽数 (Z) 2
切削直径 (D2) 17.0-52.0
刀杆悬伸长度 (L1) 20.0-65.0

TMOC 低加工循环



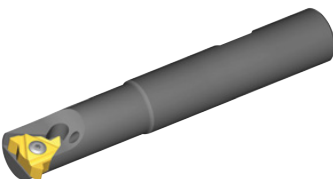
排屑槽数 (Z) 1
切削直径 (D2) 14.5-30.0
刀杆悬伸长度 (L1) 25.0-52.0

TMSH 大直径、深孔高速加工



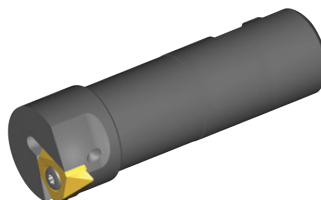
排屑槽数 (Z) 6-9
切削直径 (D2) 38.0-125.0
刀杆悬伸长度 (L1) 最大 200

TMSC 短螺纹经济型加工



排屑槽数 (Z) 1
切削直径 (D2) 12.5
刀杆悬伸长度 (L1) 25.0

TMVC 大螺距加工

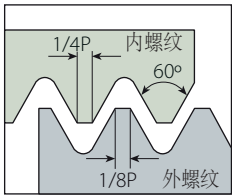


排屑槽数 (Z) 1
切削直径 (D2) 46.0
刀杆悬伸长度 (L1) 60.0

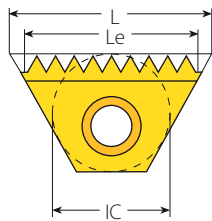
TM Standard

ISO 公制螺纹

内螺纹/外螺纹



标准参照: R262 (DIN 13)
公差等级: 6g/6H



标准型 TM

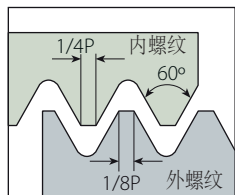
标准型 TM

刀片尺寸		螺距	订货代码		Le	刀齿
IC	L mm	mm	外螺纹	内螺纹	mm	刀杆
6.0mm	10.4	0.5		6.0I0.5ISOTM...	10.0	20
		0.75		6.0I0.75ISOTM...	9.75	13
		1.0		6.0I1.0ISOTM...	9.0	9
		1.25		6.0I1.25ISOTM...	8.75	7
		1.5		6.0I1.5ISOTM...	9.0	6
1/4"	11	0.5		2I0.5ISOTM2...	10.0	20
		0.75	2E0.75ISOTM2...	2I0.75ISOTM2...	10.5	14
		1.0	2E1.0ISOTM2...	2I1.0ISOTM2...	10.0	10
		1.25	2E1.25ISOTM2...		10.0	8
		1.25		2I1.25ISOTM2...	8.75	7
		1.5	2E1.5ISOTM2...		9.0	6
		1.5		2I1.5ISOTM2...	10.5	7
3/8"	16	0.5		3I0.5ISOTM2...	15.0	30
		0.75	3E0.75ISOTM2...	3I0.75ISOTM2...	15.0	20
		0.8		3I0.8ISOTM2...	14.4	18
		1.0	3E1.0ISOTM2...		14.0	14
		1.0		3I1.0ISOTM2...	15.0	15
		1.25	3E1.25ISOTM2...	3I1.25ISOTM2...	15.0	12
		1.5	3E1.5ISOTM2...	3I1.5ISOTM2...	15.0	10
		1.75	3E1.75ISOTM2...	3I1.75ISOTM2...	14.0	8
3/8"B	22	2.0	3E2.0ISOTM2...	3I2.0ISOTM2...	14.0	7
		1.0	3BE1.0ISOTM2...	3BI1.0ISOTM2...	22.0	22
		1.25	3BE1.25ISOTM2...	3BI1.25ISOTM2...	21.25	17
		1.5	3BE1.5ISOTM2...	3BI1.5ISOTM2...	21.0	14
		1.75	3BE1.75ISOTM2...	3BI1.75ISOTM2...	21.0	12
5/8"	27	2.0	3BE2.0ISOTM2...	3BI2.0ISOTM2...	22.0	11
		1.0	5E1.0ISOTM2...	5I1.0ISOTM2...	26.0	26
		1.25	5E1.25ISOTM2...	5I1.25ISOTM2...	25.0	20
		1.5	5E1.5ISOTM2...	5I1.5ISOTM2...	25.5	17
		1.75	5E1.75ISOTM2...	5I1.75ISOTM2...	24.5	14
		2.0	5E2.0ISOTM2...	5I2.0ISOTM2...	24.0	12
		2.5	5E2.5ISOTM2...	5I2.5ISOTM2...	25.0	10
		3.0	5E3.0ISOTM2...	5I3.0ISOTM2...	24.0	8
		3.5	5E3.5ISOTM2...	5I3.5ISOTM2...	24.5	7
		4.0	5E4.0ISOTM2...	5I4.0ISOTM2...	24.0	6
		4.5	5E4.5ISOTM2...	5I4.5ISOTM2...	22.5	5

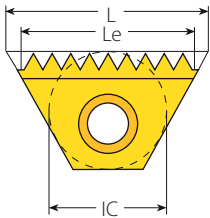
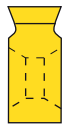
所有刀片有两个切削刃, 除了MiniTM (IC 6.0 mm) 只含有一个刀刃

ISO 公制螺纹 (续)

内螺纹/外螺纹



标准参照: R262 (DIN 13)
公差等级: 6g/6H



标准型 TM

标准型 TM

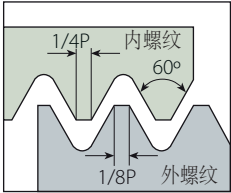
刀片尺寸		螺距	订货代码		Le	刀齿
IC	L mm	mm	外螺纹	内螺纹	mm	刀杆
3/4"B	38.5	1.5	6BE1.5ISOTM2...	6BI1.5ISOTM2...	36.0	24
		2.0	6BE2.0ISOTM2...	6BI2.0ISOTM2...	36.0	18
		2.5	6BE2.5ISOTM2...	6BI2.5ISOTM2...	35.0	14
		3.0	6BE3.0ISOTM2...	6BI3.0ISOTM2...	36.0	12
		4.0	6BE4.0ISOTM2...	6BI4.0ISOTM2...	32.0	8
		4.5	6BE4.5ISOTM2...	6BI4.5ISOTM2...	31.5	7
		5.0	6BE5.0ISOTM2...	6BI5.0ISOTM2...	30.0	6
		5.5	6BE5.5ISOTM2...	6BI5.5ISOTM2...	33.0	6
		6.0	6BE6.0ISOTM2...	6BI6.0ISOTM2...	30.0	5

TMC...-6B
TMSH...-6B

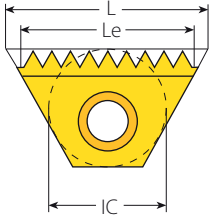
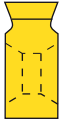
TM Standard

ISO 公制螺纹 (续)

内螺纹



标准参照: R262 (DIN 13)
公差等级: 6g/6H



粗牙 螺距 **TM**

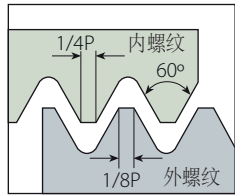
粗牙 TM

螺纹		刀片尺寸		订货代码	刃口数	Le	刀齿	镗孔直径范围
		IC	L mm	内螺纹		mm	刀杆	mm
M10 X 0.75	6.0 mm	10.4		6.0I0.75ISOTM...028/001	1	9.75	TMMC12-6.0	9.1-10
M10 X 0.75				6.0I0.75ISOTM...028/001	1	9.75	TMMC20-6.0	9.1-10
M12 X 1.25				6.0I1.25ISOTM...028/002	1	8.75	TMMC12-6.0	10.6-11.4
M12 X 1.25				6.0I1.25ISOTM...028/002	1	8.75	TMMC20-6.0	10.6-11.4
M12 X 1.75				6.0I1.75ISOTM...028/003	1	8.75	TMMC20-6.0-124/003	10.1-19
M14 X 2.0	1/4"	11		2I2.0ISOTM...028/004	2	10.0	TMC12-2	11.8-19.5
M14 X 2.0				2I2.0ISOTM...028/004	2	10.0	TMC20-2	11.8-19.5
M16 X 2.0				2I2.0ISOTM...028/004	2	10.0	TMC12-2	11.8-19.5
M16 X 2.0				2I2.0ISOTM...028/004	2	10.0	TMC20-2	11.8-19.5
M20 X 2.5	3/8"	16		3I2.5ISOTM...028/005	1	12.5	TMC16-3-124/001	17.2-19.2
M22 X 2.5	1/2"	22		4I2.5ISOTM...028/006	1	17.5	TMC25-4-124/002	19.2-31.6
M24 X 3.0				4I3.0ISOTM...028/007	1	18.0	TMC25-4-124/002	20.7-32.7
M27 X 3.0				4I3.0ISOTM...028/007	1	18.0	TMC25-4-124/002	20.7-32.7
M30 X 3.5	5/8"	27		5I3.5ISOTM...028/008	2	24.5	TMC25-5-124/004	26.2-35.9
M33 X 3.5				5I3.5ISOTM...028/008	2	24.5	TMC25-5-124/004	26.2-35.9
M36 X 3.0				5I3.0ISOTM...028/009	2	24.0	TMC25-5	32.7-39
M36 X 4.0				5I4.0ISOTM...028/010	2	24.0	TMC25-5	31.6-38.5
M39 X 3.0				5I3.0ISOTM...028/009	2	24.0	TMC25-5	32.7-39
M39 X 4.0				5I4.0ISOTM...028/010	2	24.0	TMC25-5	31.6-38.5
M42 X 4.5				5I4.5ISOTM...028/011	2	22.5	TMC25-5	37.1-48
M45 X 4.5				5I4.5ISOTM...028/011	2	22.5	TMC25-5	37.1-48
M48 X 5.0				5I5.0ISOTM...028/075	2	20.0	TMC25-5	38.9-∞
M52 X 5.0				5I5.0ISOTM...028/075	2	20.0	TMC25-5	38.9-∞

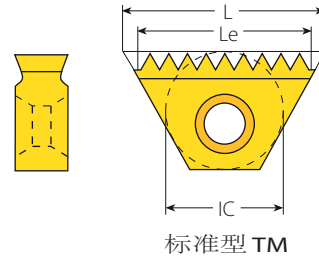
详细刀杆信息, 请参考284页

ISO 公制螺纹 (续)

内螺纹/外螺纹

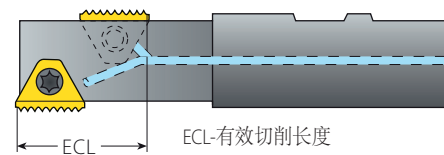


标准参照: R262 (DIN 13)
公差等级: 6g/6H



TMO刀杆的标准TM刀片

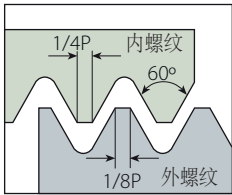
刀片尺寸		螺距	订货代码		有效切削长度	
IC	L mm	mm	外螺纹	内螺纹	刀杆	mm
1/4"	11	0.5		2I0.5ISOTM2...	TMOC20-2-8	19.0
		0.75	2E0.75ISOTM2...	2I0.75ISOTM2...	TMOC20-2-9	19.5
		1.0	2E1.0ISOTM2...	2I1.0ISOTM2...	TMOC20-2-8	19.0
		1.25	2E1.25ISOTM2...		TMOC20-2-10	18.7
		1.25		2I1.25ISOTM2...	TMOC20-2-10	16.2
		1.5	2E1.5ISOTM2...		TMOC20-2-8	18.0
		1.5		2I1.5ISOTM2...	TMOC20-2-8	19.5
3/8"	16	0.5		3I0.5ISOTM2...	TMOC20-3-1	28.5
		0.5		3I0.5ISOTM2...	TMOC20-3-10	29.0
		0.75	3E0.75ISOTM2...	3I0.75ISOTM2...	TMOC20-3-11	28.5
		1.0	3E1.0ISOTM2...		TMOC20-3-10	28.0
		1.0		3I1.0ISOTM2...	TMOC20-3-10	29.0
		1.25	3E1.25ISOTM2...	3I1.25ISOTM2...	TMOC20-3-7	28.7
		1.5	3E1.5ISOTM2...	3I1.5ISOTM2...	TMOC20-3-1	28.5
		1.75	3E1.75ISOTM2...	3I1.75ISOTM2...	TMOC20-3-12	26.2
5/8"	27	2.0	3E2.0ISOTM2...	3I2.0ISOTM2...	TMOC20-3-10	28.0
		1.0	5E1.0ISOTM2...	5I1.0ISOTM2...	TMOC25-5-12	46.0
		1.0	5E1.0ISOTM2...	5I1.0ISOTM2...	TMOC25-5-16	47.0
		1.25	5E1.25ISOTM2...	5I1.25ISOTM2...	TMOC25-5-13	48.7
		1.5	5E1.5ISOTM2...	5I1.5ISOTM2...	TMOC25-5-14	48.0
		1.5	5E1.5ISOTM2...	5I1.5ISOTM2...	TMOC25-5-16	46.5
		1.75	5E1.75ISOTM2...	5I1.75ISOTM2...	TMOC25-5-15	47.2
		2.0	5E2.0ISOTM2...	5I2.0ISOTM2...	TMOC25-5-12	44.0
		2.5	5E2.5ISOTM2...	5I2.5ISOTM2...	TMOC25-5-12	45.0
		2.5	5E2.5ISOTM2...	5I2.5ISOTM2...	TMOC25-5-14	47.5
		3.0	5E3.0ISOTM2...	5I3.0ISOTM2...	TMOC25-5-16	45.0
		3.5	5E3.5ISOTM2...	5I3.5ISOTM2...	TMOC25-5-16	45.5
		4.0	5E4.0ISOTM2...	5I4.0ISOTM2...	TMOC25-5-12	44.0
		4.5	5E4.5ISOTM2...	5I4.5ISOTM2...	TMOC25-5-14	45.0
		5.0		5I5.0ISOTM...028/075	TMOC25-5-12	40.0



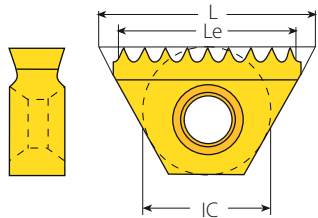
上述刀片的Le和齿数请参照256-257页上的标准刀片表格
更多刀杆信息, 请参阅289页

ISO 公制螺纹 (续)

内螺纹/外螺纹



标准参照: R262 (DIN 13)
公差等级: 6g/6H

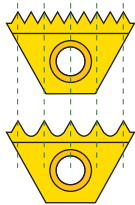


细牙 TM

细牙螺纹铣刀

刀片尺寸		螺距	订货代码		Le	刀齿
IC	L mm	mm	外螺纹	内螺纹	mm	刀杆
6.0mm	10.4	0.35	6.0E0.35ISOTMF...	6.0I0.35ISOTMF...	9.45	14
		0.4	6.0E0.4ISOTMF...	6.0I0.4ISOTMF...	9.2	12
		0.45	6.0E0.45ISOTMF...	6.0I0.45ISOTMF...	9.45	11
		0.5	6.0E0.5ISOTMF...		9.5	10
		0.6	6.0E0.6ISOTMF...		9.0	8
		0.7	6.0E0.7ISOTMF...		9.1	7
		0.75	6.0E0.75ISOTMF...		8.25	6
		0.8	6.0E0.8ISOTMF...		8.8	6
		0.9	6.0E0.9ISOTMF...		8.1	5
1/4"	11	0.35	2E0.35ISOTM2F...	2I0.35ISOTM2F...	10.15	15
		0.4	2E0.4ISOTM2F...	2I0.4ISOTM2F...	10.0	13
		0.45	2E0.45ISOTM2F...	2I0.45ISOTM2F...	9.45	11
		0.5	2E0.5ISOTM2F...		9.5	10
		0.6	2E0.6ISOTM2F...		10.2	9
		0.7	2E0.7ISOTM2F...		9.1	7
		0.8	2E0.8ISOTM2F...		8.8	6
		0.9	2E0.9ISOTM2F...		9.9	6
3/8"	16	0.35	3E0.35ISOTM2F...	3I0.35ISOTM2F...	14.35	21
		0.4	3E0.4ISOTM2F...	3I0.4ISOTM2F...	14.8	19
		0.45	3E0.45ISOTM2F...	3I0.45ISOTM2F...	14.85	17
		0.5	3E0.5ISOTM2F...		13.5	14
		0.6	3E0.6ISOTM2F...		13.8	12
		0.7	3E0.7ISOTM2F...		14.7	11
		0.8	3E0.8ISOTM2F...		13.6	9
		0.9	3E0.9ISOTM2F...		13.5	8

注意: 完成螺纹加工需走两个螺旋插补轨迹, 细牙TM刀片产生范围牙型
订货示例: 6.0E0.35ISOTMF VBX
所有刀片均有两个切削刃, 除了MiniTM (IC6.0mm)仅含一个切削刃
更多刀杆信息参阅280页



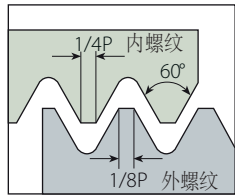
细牙螺纹

细牙螺纹螺距较小, 由于相邻齿的刀尖圆弧过小, 因此细牙多齿螺纹刀片的制造非常困难。瓦格斯公司设计出的细牙多齿螺纹刀片其齿间距为两倍细牙螺距

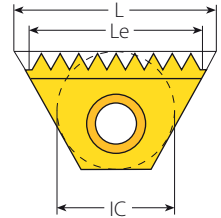
重要提示!
所有细牙螺纹刀片为范围牙型 (因加大刀尖圆弧所致)

美制UN(不变螺距)

内螺纹/外螺纹



标准参照: ANSI B1.1.74
公差等级: Class 2A/2B



标准型 TM

标准型 TM

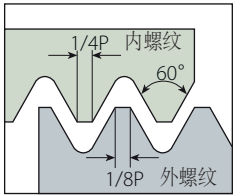
刀片尺寸		螺距	订货代码		Le	刀齿
IC	L mm	tpi	外螺纹	内螺纹	mm	刀杆
6.0mm	10.4	32		6.0I32UNTM...	9.53	12
		28		6.0I28UNTM...	9.07	10
		24		6.0I24UNTM...	9.53	9
		20		6.0I20UNTM...	8.89	7
		18		6.0I18UNTM...	8.47	6
		16		6.0I16UNTM...	7.94	5
1/4"	11	48		2I48UNTM2...	10.05	19
		40		2I40UNTM2...	10.16	16
		32		2I32UNTM2...	10.32	13
		28	2E28UNTM2...	2I28UNTM2...	9.98	11
		27	2E27UNTM2...	2I27UNTM2...	10.35	11
		24	2E24UNTM2...	2I24UNTM2...	9.53	9
		20	2E20UNTM2...	2I20UNTM2...	10.16	8
		18	2E18UNTM2...	2I18UNTM2...	9.88	7
		16	2E16UNTM2...	2I16UNTM2...	9.53	6
		14	2E14UNTM2...	2I14UNTM2...	9.07	5
3/8"	16	40		3I40UNTM2...	14.61	23
		32		3I32UNTM2...	15.08	19
		28	3E28UNTM2...	3I28UNTM2...	14.51	16
		27	3E27UNTM2...	3I27UNTM2...	14.11	15
		26	3E26UNTM2...	3I26UNTM2...	14.65	15
		24	3E24UNTM2...	3I24UNTM2...	14.82	14
		20	3E20UNTM2...	3I20UNTM2...	13.97	11
		18	3E18UNTM2...	3I18UNTM2...	14.11	10
		16	3E16UNTM2...	3I16UNTM2...	14.29	9
		14	3E14UNTM2...	3I14UNTM2...	14.51	8
		13	3E13UNTM2...	3I13UNTM2...	13.68	6
		12	3E12UNTM2...	3I12UNTM2...	14.82	7
		11.5	3E11.5UNTM2...	3I11.5UNTM2...	13.25	6
		11	3E11UNTM2...	3I11UNTM2...	13.25	6
3/8"B	22	24	3BE24UNTM2...	3BI24UNTM2...	21.16	20
		20	3BE20UNTM2...	3BI20UNTM2...	21.59	17
		18	3BE18UNTM2...	3BI18UNTM2...	21.17	15
		16	3BE16UNTM2...	3BI16UNTM2...	20.64	13
		14	3BE14UNTM2...	3BI14UNTM2...	21.77	12
		13	3BE13UNTM2...	3BI13UNTM2...	21.49	11
		12	3BE12UNTM2...	3BI12UNTM2...	21.17	10

所有刀片有两个切削刃, 除了MiniTM (IC 6.0 mm) 只含有一个刀刃
更多刀杆信息参阅280页

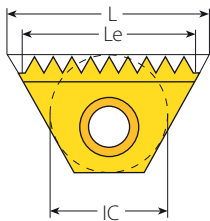
TM Standard

美制UN(不变螺距) (续)

内螺纹/外螺纹



标准参照: ANSI B1.1.74
公差等级: Class 2A/2B



标准型 TM

标准型 TM

刀片尺寸		螺距	订货代码		Le	刀齿
IC	L mm	tpi	外螺纹	内螺纹	mm	刀杆
5/8"	27	24	5E24UNTM2...	5I24UNTM2...	25.40	24
		20	5E20UNTM2...	5I20UNTM2...	25.40	20
		18	5E18UNTM2...	5I18UNTM2...	25.40	18
		16	5E16UNTM2...	5I16UNTM2...	25.40	16
		14	5E14UNTM2...	5I14UNTM2...	25.40	14
		13	5E13UNTM2...	5I13UNTM2...	25.40	13
		12	5E12UNTM2...	5I12UNTM2...	25.40	12
		11.5	5E11.5UNTM2...	5I11.5UNTM2...	24.30	11
		11	5E11UNTM2...	5I11UNTM2...	25.40	11
		10	5E10UNTM2...		22.86	9
		10		5I10UNTM2...	25.40	10
		9	5E9UNTM2...	5I9UNTM2...	22.58	8
		8	5E8UNTM2...	5I8UNTM2...	22.23	7
		7	5E7UNTM2...		21.77	6
		7		5I7UNTM2...	25.40	7
		6	5E6UNTM2...		21.17	5
		6		5I6UNTM2...	25.40	6
3/4"B	38.5	6	6BE6UNTM2...	6BI6UNTM2...	38.87	8
		5	6BE5UNTM2...	6BI5UNTM2...	30.48	6
		4.5	6BE4.5UNTM2...	6BI4.5UNTM2...	33.87	6
		4	6BE4UNTM2...	6BI4UNTM2...	31.75	5

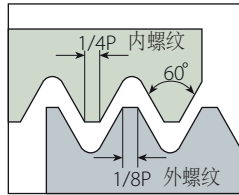
TMC...-5
TMSH...-5

TMC...-6B
TMSH...-6B

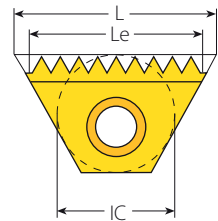
所有刀片有两个切削刃, 除了MiniTM (IC 6.0 mm) 只含有一个刀刃
详细刀杆信息, 请参考280页

美制UN(不变螺距) (续)

内螺纹



标准参照: ANSI B1.1.74
公差等级: Class 2A/2B



粗牙 螺距 TM

粗牙 TM

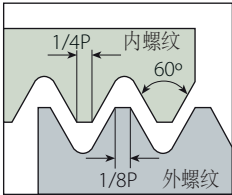
螺纹	刀片尺寸		订货代码	刃口数	Le	刀齿	镗孔直径范围
	IC	L mm	内螺纹		mm	刀杆	mm
7/16"-20UNF	6.0mm	10.4	6.0I20UNTM...028/012	1	8.89	7 TMMC12-6.0	9.7-11.4
7/16"-20UNF			6.0I20UNTM...028/012	1	8.89	7 TMMC20-6.0	9.7-11.4
7/16"-16UN			6.0I16UNTM...028/014	1	7.94	5 TMMC12-6.0	9.3-14.1
7/16"-16UN			6.0I16UNTM...028/014	1	7.94	5 TMMC20-6.0	9.3-14.1
7/16"-14UNC			6.0I14UNTM...028/013	1	9.07	5 TMMC20-6.0-124/003	9.1-9.9
1/2"-13UNC	1/4"	11	2I13UNTM...028/015	1	9.77	5 TMC20-2-124/005	10.5-19.5
1/2"-16UN	6.0mm	10.4	6.0I16UNTM...028/014	1	7.94	5 TMMC12-6.0	9.3-14.1
1/2"-16UN			6.0I16UNTM...028/014	1	7.94	5 TMMC20-6.0	9.3-14.1
9/16"-12UNC	1/4"	11	2I12UNTM...028/016	1	8.47	4 TMC20-2-124/005	11.9-15.6
9/16"-18UNF			2I18UNTM...028/017	2	9.88	7 TMC12-2	12.7-14.5
9/16"-18UNF			2I18UNTM...028/017	2	9.88	7 TMC20-2	12.7-14.5
9/16"-16UN	6.0mm	10.4	6.0I16UNTM...028/014	1	7.94	5 TMMC12-6.0	9.3-14.1
9/16"-16UN			6.0I16UNTM...028/014	1	7.94	5 TMMC20-6.0	9.3-14.1
5/8"-11UNC	1/4"	11	2I11UNTM...028/018	1	9.24	4 TMC20-2-124/006	13.3-18.5
5/8"-12UN			2I12UNTM...028/016	1	8.47	4 TMC20-2-124/005	11.9-15.6
5/8"-16UN	6.0mm	10.4	6.0I16UNTM...028/014	1	7.94	5 TMMC12-6.0	9.3-14.1
5/8"-16UN			6.0I16UNTM...028/014	1	7.94	5 TMMC20-6.0	9.3-14.1
11/16"-12UN	1/4"	11	2I12UNTM...028/016	1	8.47	4 TMC20-2-124/005	11.9-15.6
3/4"-10UNC	3/8"	16	3I10UNTM...028/019	1	12.70	5 TMC16-3-124/001	16.3-31.6
3/4"-12UN			3I12UNTM...028/020	2	14.82	7 TMNC16-3	16.7-18.3
13/16"-12UN			3I12UNTM...028/020	2	14.82	7 TMC16-3	18.3-19.5
7/8"-9UNC	1/2"	22	4I9UNTM...028/021	1	16.93	6 TMC25-4-124/002	19.1-32.5

TM Standard

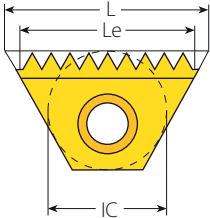
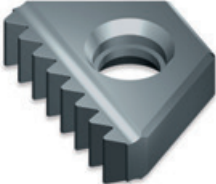
详细刀杆信息, 请参考280页

美制UN(不变螺距) (续)

内螺纹



标准参照: ANSI B1.1.74
公差等级: Class 2A/2B



粗牙 螺距 TM

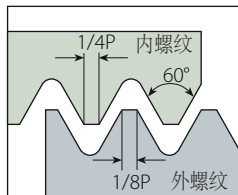
粗牙 TM

螺 纹		刀片尺寸		订货代码	刃口数	Le	刀齿	镗孔直径范围
		IC	L mm	内螺纹		mm	刀杆	mm
1"-8UNC	1/2"	22		418UNTM...028/022	1	19.05	TMC25-4-124/007	21.9-28.3
1 1/16"-8UN				418UNTM...028/022	1	19.05	TMC25-4-124/007	21.9-28.3
1 1/8"-7UNC				417UNTM...028/023	1	18.14	TMC25-4-124/002	24.6-35.9
1 1/8"-8UN				418UNTM...028/022	1	19.05	TMC25-4-124/007	21.9-28.3
1 3/16"-8UN				418UNTM...028/022	1	19.05	TMC25-4-124/007	21.9-28.3
1 1/4"-7UNC				417UNTM...028/023	1	18.14	TMC25-4-124/002	24.6-35.9
1 1/4"-8UN	5/8"	27		518UNTM...028/024	2	22.23	TMC25-5-124/004	28.3-33.0
1 5/16"-8UN				518UNTM...028/024	2	22.23	TMC25-5-124/004	28.3-33.0
1 3/8"-6UNC				516UNTM...028/025	2	25.40	TMC25-5-124/004	30.3-36.7
1 3/8"-8UN				518UNTM...028/024	2	22.23	TMC25-5-124/004	28.3-33.0
1 7/16"-6UN				516UNTM...028/025	2	25.40	TMC25-5-124/004	30.3-36.7
1 7/16"-8UN				518UNTM...028/024	2	22.23	TMC25-5	33.0-39.0
1 1/2"-6UNC				516UNTM...028/025	2	25.40	TMC25-5-124/004	30.3-36.7
1 1/2"-8UN				518UNTM...028/024	2	22.23	TMC25-5	33.0-39.0
1 9/16"-6UN				516UNTM...028/025	2	25.40	TMC25-5-124/004	30.3-36.7
1 9/16"-8UN				518UNTM...028/024	2	22.23	TMC25-5	33.0-39.0
1 5/8"-6UN				516UNTM...028/025	2	25.40	TMC25-5	36.7-45.0
1 5/8"-8UN				518UNTM...028/024	2	22.23	TMC25-5	33.0-39.0
1 11/16"-6UN				516UNTM...028/025	2	25.40	TMC25-5	36.7-45.0
1 3/4"-5UNC				515UNTM...028/077	2	20.32	TMC25-5	38.9-∞
1 3/4"-6UN				516UNTM...028/025	2	25.40	TMC25-5	36.7-45.0
1 13/16"-6UN				516UNTM...028/025	2	25.40	TMC25-5	36.7-45.0
1 7/8"-6UN				516UNTM...028/025	2	25.40	TMC25-5	36.7-45.0
1 15/16"-6UN				516UNTM...028/025	2	25.40	TMC25-5	36.7-45.0

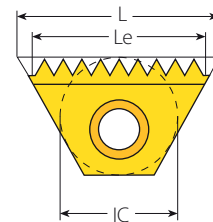
详细刀杆信息, 请参考280页

美制UN(不变螺距) (续)

内螺纹/外螺纹



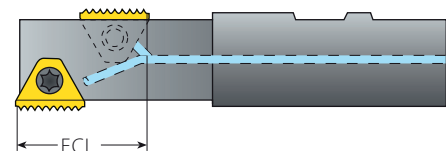
标准参照: ANSI B1.1.74
公差等级: Class 2A/2B



标准型 TM

TM0刀杆的标准TM刀片

刀片尺寸		螺距	订货代码		有效切削长度	
IC	L mm	tpi	外螺纹	内螺纹	刀杆	mm
1/4"	11	48		2I48UNTM2...	TMOC20-2-1	19.58
		48		2I48UNTM2...	TMOC20-2-2	18.52
		48		2I48UNTM2...	TMOC20-2-9	19.05
		32		2I32UNTM2...	TMOC20-2-1	19.85
		28	2E28UNTM2...	2I28UNTM2...	TMOC20-2-3	17.24
		24	2E24UNTM2...	2I24UNTM2...	TMOC20-2-2	17.99
		20	2E20UNTM2...	2I20UNTM2...	TMOC20-2-4	19.05
		18	2E18UNTM2...	2I18UNTM2...	TMOC20-2-2	18.34
		16	2E16UNTM2...	2I16UNTM2...	TMOC20-2-1	19.05
		14	2E14UNTM2...	2I14UNTM2...	TMOC20-2-3	16.33
3/8"	16	32		3I32UNTM2...	TMOC20-3-3	27.78
		32		3I32UNTM2...	TMOC20-3-11	28.58
		28	3E28UNTM2...	3I28UNTM2...	TMOC20-3-3	27.21
		27	3E27UNTM2...	3I27UNTM2...	TMOC20-3-4	27.28
		24	3E24UNTM2...	3I24UNTM2...	TMOC20-3-6	27.52
		20	3E20UNTM2...	3I20UNTM2...	TMOC20-3-6	26.67
		18	3E18UNTM2...	3I18UNTM2...	TMOC20-3-6	26.82
		16	3E16UNTM2...	3I16UNTM2...	TMOC20-3-6	26.99
		14	3E14UNTM2...	3I14UNTM2...	TMOC20-3-6	27.21
		13	3E13UNTM2...	3I13UNTM2...	TMOC20-3-2	25.4
		12	3E12UNTM2...	3I12UNTM2...	TMOC20-3-6	27.52
		11.5	3E11.5UNTM2...	3I11.5UNTM2...	TMOC20-3-5	24.3

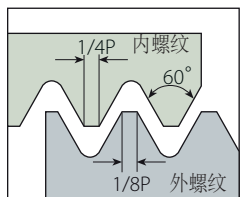


ECL - 有效切削长度

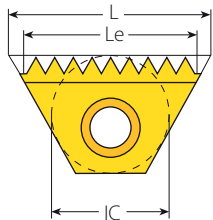
上述刀片的Le和齿数, 请参照261-262页。
详细刀杆信息, 请参考289页

美制UN(不变螺距) (续)

内螺纹/外螺纹



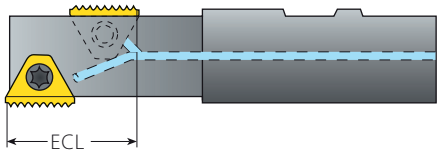
标准参照: ANSI B1.1.74
公差等级: Class 2A/2B



标准型 TM

TMO刀杆的标准TM刀片

刀片尺寸		螺距	订货代码		有效切削长度	
IC	L mm	tpi	外螺纹	内螺纹	刀杆	mm
5/8"	27	24	5E24UNTM2..	5I24UNTM2..	TMOC25-5-1	50.80
		24	5E24UNTM2...	5I24UNTM2...	TMOC25-5-2	46.57
		20	5E20UNTM2...	5I20UNTM2...	TMOC25-5-1	50.80
		18	5E18UNTM2...	5I18UNTM2...	TMOC25-5-1	50.80
		18	5E18UNTM2...	5I18UNTM2...	TMOC25-5-2	46.57
		16	5E16UNTM2...	5I16UNTM2...	TMOC25-5-3	47.63
		14	5E14UNTM2...	5I14UNTM2...	TMOC25-5-1	50.80
		14	5E14UNTM2...	5I14UNTM2...	TMOC25-5-4	47.17
		13	5E13UNTM2...	5I13UNTM2...	TMOC25-5-1	50.80
		12	5E12UNTM2...	5I12UNTM2...	TMOC25-5-2	46.57
		12	5E12UNTM2...		TMOC25-5-1	50.80
		11.5	5E11.5UNTM2...	5I11.5UNTM2...	TMOC25-5-5	46.38
		11	5E11UNTM2...	5I11UNTM2...	TMOC25-5-6	48.49
		11		5I11UNTM2...	TMOC25-5-1	46.18
		10	5E10UNTM2...		TMOC25-5-7	43.18
		10		5I10UNTM2...	TMOC25-5-7	45.72
		9	5E9UNTM2...	5I9UNTM2...	TMOC25-5-8	45.16
		8	5E8UNTM2...	5I8UNTM2...	TMOC25-5-9	44.45
		7	5E7UNTM2...		TMOC25-5-10	43.54
		7		5I7UNTM2...	TMOC25-5-10	47.17
		6	5E6UNTM2...		TMOC25-5-2	42.33
		6		5I6UNTM2...	TMOC25-5-2	46.57
		5		5I5UNTM...028/077	TMOC25-5-7	40.64

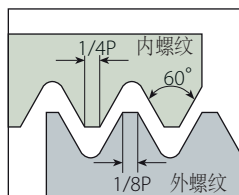


ECL - 有效切削长度

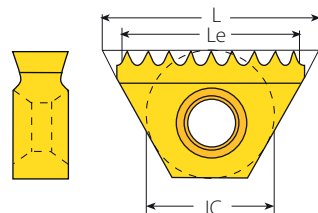
上述刀片的Le和齿数, 请参照261-262页。
详细刀杆信息, 请参考289页

美制UN(不变螺距) (续)

内螺纹/外螺纹



标准参照: ANSI B1.1.74
公差等级: Class 2A/2B



细牙 TM

细牙 TM

刀片尺寸		螺距	订货代码		Le	刀齿
IC	L mm	tpi	外螺纹	内螺纹	mm	刀杆
6.0mm	10.4	80	6.0E80UNTMF...	6.0I80UNTMF...	9.84	16
		72	6.0E72UNTMF...	6.0I72UNTMF...	9.53	14
		64	6.0E64UNTMF...	6.0I64UNTMF...	9.13	12
		56	6.0E56UNTMF...	6.0I56UNTMF...	9.53	11
		48	6.0E48UNTMF...		9.00	9
		44	6.0E44UNTMF...		8.66	8
		40	6.0E40UNTMF...		8.26	7
		36	6.0E36UNTMF...		9.17	7
		32	6.0E32UNTMF...		8.73	6
1/4"	11	80	2E80UNTM2F...	2I80UNTM2F...	9.84	16
		72	2E72UNTM2F...	2I72UNTM2F...	10.23	15
		64	2E64UNTM2F...	2I64UNTM2F...	9.92	13
		56	2E56UNTM2F...	2I56UNTM2F...	9.53	11
		48	2E48UNTM2F...		10.05	10
		44	2E44UNTM2F...		9.81	9
		40	2E40UNTM2F...		9.53	8
		36	2E36UNTM2F...		9.17	7
		32	2E32UNTM2F...		8.73	6
3/8"	16	80	3E80UNTM2F...	3I80UNTM2F...	14.29	23
		72	3E72UNTM2F...	3I72UNTM2F...	14.46	21
		64	3E64UNTM2F...	3I64UNTM2F...	14.68	19
		56	3E56UNTM2F...	3I56UNTM2F...	14.06	16
		48	3E48UNTM2F...		14.29	14
		44	3E44UNTM2F...		14.43	13
		40	3E40UNTM2F...		14.61	12
		36	3E36UNTM2F...		14.82	11
		32	3E32UNTM2F...		13.49	9

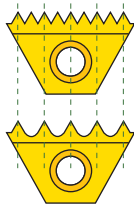
TM Standard

注意: 完成螺纹加工需走两个螺旋插补轨迹, 细牙TM刀片产生范围牙型
订货示例: 6.0E80UNTMF VBX
所有刀片均有两个切削刃, 除了MiniTM (IC6.0mm)仅含一个切削刃
详细刀杆信息, 请参考280页

细牙螺纹

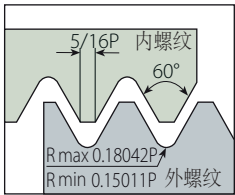
细牙螺纹螺距较小, 由于相邻齿的刀尖圆弧过小, 因此细牙多齿螺纹刀片的制造非常困难。瓦格斯公司设计出的细牙多齿螺纹刀片其齿间距为两倍细牙螺距

重要提示!
所有细牙螺纹刀片为范围牙型 (因加大刀尖圆弧所致)

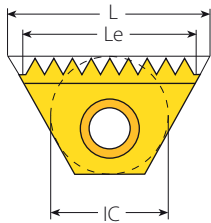
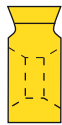
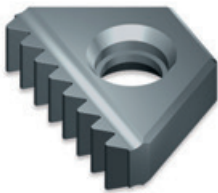


美制航空螺纹

内螺纹/外螺纹



标准参照: MIL-S-8879C
公差等级: 3A/3B



标准型 TM

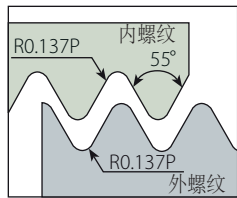
标准型 TM

刀片尺寸		螺距		订货代码		Le	刀齿	刀杆
IC	L mm	tpi	外螺纹	内螺纹		mm		
6.0mm	10.4	24		6.0I24UNJTM...		9.53	9	TMMC...-6.0
		20		6.0I20UNJTM...		8.89	7	
		18		6.0I18UNJTM...		8.47	6	
		16		6.0I16UNJTM...		9.53	6	
1/4"	11	24	2E24UNJTM2...	2I24UNJTM2...		9.53	9	TMC...-2 TMSH...-2
		20	2E20UNJTM2...	2I20UNJTM2...		10.16	8	
		18		2I18UNJTM2...		9.88	7	
		16	2E16UNJTM2...	2I16UNJTM2...		9.53	6	
		14	2E14UNJTM2...	2I14UNJTM2...		9.07	5	
3/8"	16	24	3E24UNJTM2...	3I24UNJTM2...		14.82	14	TMC...-3 TMSH...-3
		20	3E20UNJTM2...	3I20UNJTM2...		13.97	11	
		18	3E18UNJTM2...	3I18UNJTM2...		14.11	10	
		16	3E16UNJTM2...	3I16UNJTM2...		14.29	9	
		14	3E14UNJTM2...	3I14UNJTM2...		14.51	8	
		13	3E13UNJTM2...			13.68	7	
		12	3E12UNJTM2...	3I12UNJTM2...		14.82	7	
5/8"	27	16	5E16UNJTM2...	5I16UNJTM2...		25.40	16	TMC...-5 TMSH...-5
		12	5E12UNJTM2...	5I12UNJTM2...		25.40	12	
		11	5E11UNJTM2...	5I11UNJTM2...		25.40	11	

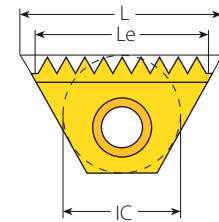
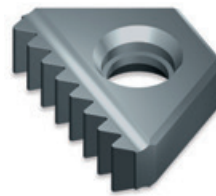
所有刀片有两个切削刃, 除了MiniTM (IC 6.0 mm)只含有两个刀刃
详细刀杆信息, 请参考280页

惠氏螺纹 BSW, BSP

内螺纹/外螺纹



BSW 标准参照: B.S.84:1956, DIN 259, ISO228/1:1982
BSP 标准参照: B.S.2779:1956
公差等级: BSW-Medium class A, BSP-Medium class



标准型 TM

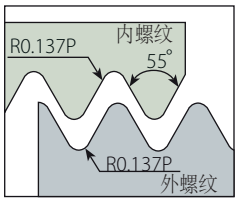
标准型 TM

刀片尺寸		螺距	订货代码	Le	刀齿	
IC	L mm	tpi	外螺纹 + 内螺纹	mm		刀杆
6.0mm	10.4	28	6.0EI28WTM...	9.07	10	TMMC...-6.0
		26	6.0EI26WTM...	8.79	9	
		24	6.0EI24WTM...	9.53	9	
		20	6.0EI20WTM...	8.89	7	
		19	6.0EI19WTM...	9.36	7	
1/4"	11	28	2EI28WTM2...	9.98	11	TMC...-2 TMSH...-2
		26	2EI26WTM2...	9.77	10	
		24	2EI24WTM2...	9.53	9	
		20	2EI20WTM2...	10.16	8	
		19	2EI19WTM2...	9.36	7	
3/8"	16	14	2EI14WTM2...	9.07	5	TMC...-3 TMSH...-3
		26	3EI26WTM2...	14.65	15	
		24	3EI24WTM2...	14.82	14	
		20	3EI20WTM2...	13.97	11	
		19	3EI19WTM2...	14.71	11	
		18	3EI18WTM2...	14.11	10	
		16	3EI16WTM2...	14.29	9	
		14	3EI14WTM2...	14.51	8	
3/8"B	22	12	3EI12WTM2...	14.82	7	TMC...-3B TMSH...-3B
		11	3EI11WTM2...	13.85	6	
		24	3BEI24WTM2...	21.17	20	
		20	3BEI20WTM2...	21.59	17	
		19	3BEI19WTM2...	21.39	16	
		18	3BEI18WTM2...	21.17	15	
		16	3BEI16WTM2...	20.64	13	
		14	3BEI14WTM2...	21.77	12	
5/8"	27	12	3BEI12WTM2...	21.17	10	TMC...-5 TMSH...-5
		11	3BEI11WTM2...	20.78	9	
		16	5EI16WTM2...	25.40	16	
		14	5EI14WTM2...	25.40	14	
		12	5EI12WTM2...	23.28	11	
		11	5EI11WTM2...	23.09	10	
		10	5EI10WTM2...	25.40	10	
		9	5EI9WTM2...	22.58	8	
3/4"	38.5	8	5EI8WTM2...	22.23	7	TMC...-6B TMSH...-6B
		7	5EI7WTM2...	21.77	6	
		6	5EI6WTM2...	21.17	5	
		11	6BEI11WTM2...	34.64	15	
		6	6BEI6WTM2...	33.87	8	
		5	6BEI5WTM2...	30.48	6	
3/4"B	38.5	4.5	6BEI4.5WTM2...	33.87	6	

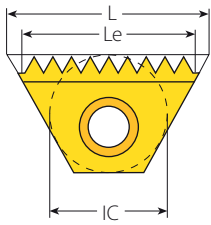
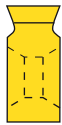
所有刀片有两个切削刃, 除了MiniTM (IC 6.0 mm)只含有两个刀刃
详细刀杆信息, 请参考280页

惠氏螺纹-仅针对BSW螺纹（续）

内螺纹



标准参照: B.S.84:1956, DIN259, ISO228/1:1982
公差等级: Medium class A



粗牙螺距 TM

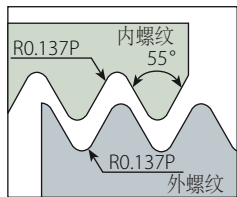
粗牙 TM

螺纹		刀片尺寸		订货代码	刃口数	Le	刀齿	镗孔直径范围
Inch	IC	L mm		内螺纹		mm	刀杆	mm
7/16"-18	6.0mm	10.4		6.0I18WTM...028/035	1	8.47	6 TMMC12-6.0	9.3-14.2
7/16"-18				6.0I18WTM...028/035	1	8.47	6 TMMC20-6.0	9.3-14.2
7/16"-26				6.0I26WTM... 028/036	1	8.79	9 TMMC12-6.0	9.8-10.5
7/16"-26				6.0I26WTM... 028/036	1	8.79	9 TMMC20-6.0	9.8-10.5
1/2"-16	1/4"	11		2I16WTM... 028/051	1	9.53	6 TMC20-2-124/005	10.6-12.2
1/2"-20	6.0mm	10.4		6.0I20WTM...028/037	1	8.89	7 TMMC12-6.0	11.0-11.4
1/2"-20				6.0I20WTM...028/037	1	8.89	7 TMMC20-6.0	11.0-11.4
9/16"-16	1/4"	11		2I16WTM...028/038	2	9.53	6 TMC12-2	12.2-18.5
9/16"-16				2I16WTM...028/038	2	9.53	6 TMC20-2	12.2-18.5
5/8"-14				2I14WTM...028/039	1	9.07	5 TMC20-2-124/006	13.5-19.0
11/16"-14				2I14WTM...028/039	1	9.07	5 TMC20-2-124/006	13.5-19.0
11/16"-16				2I16WTM...028/038	2	9.53	6 TMC12-2	12.2-18.5
11/16"-16				2I16WTM...028/038	2	9.53	6 TMC20-2	12.2-18.5
3/4"-12	3/8"	16		3I12WTM...028/040	1	14.82	7 TMC16-3-124/001	16.3-17.9
3/4"-16	1/4"	11		2I16WTM...028/038	2	9.53	6 TMC12-2	12.2-18.5
3/4"-16				2I16WTM...028/038	2	9.53	6 TMC20-2	12.2-18.5
13/16"-12	3/8"	16		3I12WTM...028/041	2	14.82	7 TMC16-3	17.9-21.0
7/8"-9	1/2"	22		4I9WTM...028/042	1	16.93	6 TMC25-4-124/002	18.6-32.5
7/8"-11				4I11WTM...028/043	1	18.47	8 TMC25-4-124/002	19.2-22.0
15/16"-12	3/8"	16		3I12WTM...028/041	2	14.82	7 TMC20-3	21.0-30.6
1"-8	1/2"	22		4I8WTM...028/044	1	15.88	5 TMC25-4-124/002	21.3-26.0
1"-10				4I10WTM...028/045	1	17.78	7 TMC25-4-124/002	22.1-31.6
1"-12	3/8"	16		3I12WTM...028/041	2	14.82	7 TMC20-3	21.0-30.6
1 1/16"-12				3I12WTM...028/041	2	14.82	7 TMC20-3	21.0-30.6
1 1/8"-7	5/8"	27		5I7WTM...028/046	1	21.77	6 TMC25-5-124/008	23.9-27.1
1 1/8"-9	1/2"	22		4I9WTM...028/042	1	16.93	6 TMC25-4-124/002	18.6-32.5
1 1/8"-12	3/8"	16		3I12WTM...028/041	2	14.82	7 TMC20-3	21.0-30.6
1 3/16"-8	5/8"	27		5I8WTM...028/047	2	22.23	7 TMC25-5-124/004	26.0-32.4
1 3/16"-12	3/8"	16		3I12WTM...028/041	2	14.82	7 TMC20-3	21.0-30.6
1 1/4"-7	5/8"	27		5I7WTM...028/048	2	21.77	6 TMC25-5-124/004	21.7-35.9
1 1/4"-9	1/2"	22		4I9WTM...028/042	1	16.93	6 TMC25-4-124/002	18.6-32.5
1 1/4"-12	3/8"	16		3I12WTM...028/041	2	14.82	7 TMC20-3	21.0-30.6
1 5/16"-6	5/8"	27		5I6WTM...028/049	2	21.17	5 TMC25-5-124/004	27.9-32.6
1 5/16"-8				5I8WTM...028/047	2	22.23	7 TMC25-5-124/004	26.0-32.4

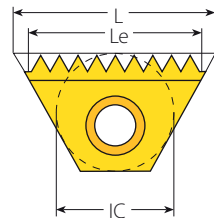
详细刀杆信息, 请参考280页

惠氏螺纹-仅针对BSW螺纹 (续)

内螺纹



标准参照: B.S.84:1956, DIN259, ISO228/1:1982
公差等级: Medium class A



粗牙螺距 TM Inserts

粗牙 TM

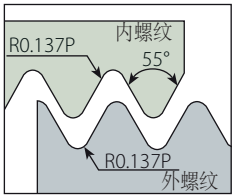
螺纹	刀片尺寸		订货代码	刃口数	Le	刀齿	镗孔直径范围	
	IC	L mm	内螺纹		mm	刀杆	mm	
1 5/16"-12	3/8"	16	3I12WTM...028/041	2	14.82	7	TMC20-3	21.0-30.6
1 3/8"-8	5/8"	27	5I8WTM...028/047	2	22.23	7	TMC25-5-124/004	26.0-32.4
1 3/8"-6			5I6WTM...028/049	2	21.17	5	TMC25-5-124/004	27.9-32.6
1 3/8"-12			5I12WTM...028/050	2	23.28	11	TMC25-5	32.2-34.6
1.4-6			5I6WTM...028/049	2	21.17	5	TMC25-5-124/004	27.9-32.6
1.4-8			5I8WTM...028/047	2	22.23	7	TMC25-5-124/004	26.0-32.4
1.4-12			5I12WTM...028/050	2	23.28	11	TMC25-5	32.2-34.6
1 7/16"-6			5I6WTM...028/049	2	21.17	5	TMC25-5-124/004	27.9-32.6
1 7/16"-8			5I8WTM...028/047	2	22.23	7	TMC25-5	32.4-39.0
1 7/16"-12			5I12WTM...028/050	2	23.28	11	TMC25-5	32.2-34.6
1 1/2"-6			5I6WTM...028/049	2	21.17	5	TMC25-5-124/004	27.9-32.7
1 1/2"-8			5I8WTM...028/047	2	22.23	7	TMC25-5	32.4-39.0
1.6-6			5I6WTM...028/049	2	21.17	5	TMC25-5	32.6-38.5
1.6-8			5I8WTM...028/047	2	22.23	7	TMC25-5	32.4-39.0
1 5/8"-8			5I8WTM...028/047	2	22.23	7	TMC25-5	32.4-39.0
1 5/8"-6			5I6WTM...028/049	2	21.17	5	TMC25-5	32.6-38.5
1 3/4"-7			5I7WTM...028/048	2	21.77	6	TMC25-5	39.8-42.0
1 7/8"-6			5I6 WTM...028/049	2	21.17	5	TMC32-5	42.2-45.0
1.9-6			5I6 WTM...028/049	2	21.17	5	TMC32-5	42.2-45.0

TM Standard

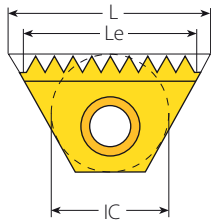
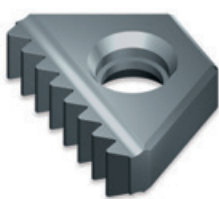
详细刀杆信息, 请参考280页

惠氏螺纹-仅针对BSW螺纹（续）

内螺纹/外螺纹



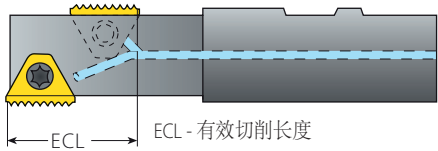
标准参照: B.S.84:1956, DIN259, ISO228/1:1982
公差等级: Medium class A



标准型 TM

TMO刀杆的标准TM刀片

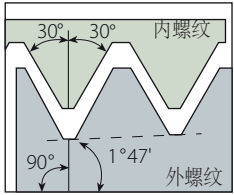
刀片尺寸		螺距	订货代码		有效切削长度
IC	L mm	tpi	外螺纹 + 内螺纹	刀杆	mm
1/4"	11	28	2EI28WTM2...	TMOC20-2-3	17.24
		26	2EI26WTM2...	TMOC20-2-5	18.56
		24	2EI24WTM2...	TMOC20-2-2	17.99
		20	2EI20WTM2...	TMOC20-2-6	19.05
		19	2EI19WTM2...	TMOC20-2-7	17.38
		14	2EI14WTM2...	TMOC20-2-3	16.33
3/8"	16	26	3EI26WTM2...	TMOC20-3-2	27.35
		26	3EI26WTM2...	TMOC20-3-6	26.38
		24	3EI24WTM2...	TMOC20-3-7	28.57
		20	3EI20WTM2...	TMOC20-3-6	26.67
		19	3EI19WTM2...	TMOC20-3-8	28.07
		18	3EI18WTM2...	TMOC20-3-6	26.81
		16	3EI16WTM2...	TMOC20-3-6	26.99
		14	3EI14WTM2...	TMOC20-3-6	27.21
		12	3EI12WTM2...	TMOC20-3-6	27.52
5/8"	27	11	3EI11WTM2...	TMOC20-3-9	27.71
		16	5EI16WTM2...	TMOC25-5-3	47.63
		14	5EI14WTM2...	TMOC25-5-1	50.80
		14	5EI14WTM2...	TMOC25-5-4	47.17
		12	5EI12WTM2...	TMOC25-5-2	44.45
		11	5EI11WTM2...	TMOC25-5-6	46.18
		10	5EI10WTM2...	TMOC25-5-7	45.72
		9	5EI9WTM2...	TMOC25-5-8	45.16
		8	5EI8WTM2...	TMOC25-5-9	44.45
		7	5EI7WTM2...	TMOC25-5-4	43.54
		6	5EI6WTM2...	TMOC25-5-11	42.33



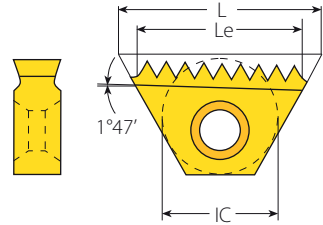
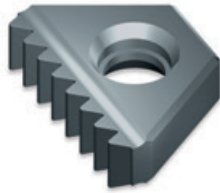
上述刀片的Le和齿数, 请参照269页上的标准表格
详细刀杆信息, 请参考289页

NPT

内螺纹/外螺纹



标准参照: USAS B2.1:1968
公差等级: 标准型 NPT



标准型 TM

标准型 TM

刀片尺寸		螺距	订货代码	Le	刀齿	刀杆	
IC	L mm	tpi	外螺纹 + 内螺纹	mm		RH	LH
3/8"	16	18	3E18NPT-TM2... *	14.11	10	TMNC...-3	TMNC...-3LH
		14	3E14NPT-TM2...	14.51	8		
		11.5	3E11.5NPT-TM2...	13.25	6		
3/8"B	22	14	3BE14NPT-TM2...	21.77	12	BTMNC...-3B	BTMNC...-3BLH
		11.5	3BE11.5NPT-TM2... **	19.88	9		
5/8"	27	11.5	5E11.5NPT-TM2...	24.30	11	TM.C...-5	TM.C...-5LH
		8	5E8NPT-TM2...	22.23	7	TMNC...-5	TMNC...-5LH
3/4"B	38.5	11.5	6BE11.5NPT-TM2...	35.34	16	TMC...-6B	TMC...-6BLH
		8	6BE8NPT-TM2...	31.75	10		

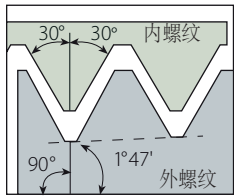
* 仅用于外螺纹加工。
采用刀口标记为“L”的刀片时, 选用左手刀杆
更多刀杆信息参阅286页

** 单面刀片-仅用于右手

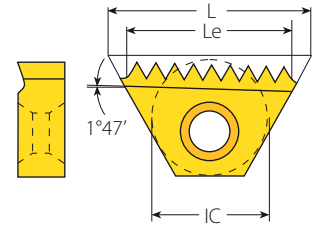
TM Standard

NPT

内螺纹



标准参照: USAS B2.1:1968
公差等级: 标准型 NPT



粗牙螺距 TM

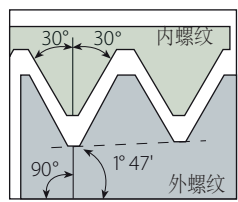
粗牙 TM

螺纹	刀片尺寸		订货代码	刃口数	Le	刀齿	刀杆
Inch	IC	L mm	内螺纹		mm		
1/4"-18	1/4"	11	2I18NPT-TM...028/074	1	9.88	7	TMC20-2-124/009
3/8"-18			2I18NPT-TM...028/074	1	9.88	7	TMC20-2-124/009

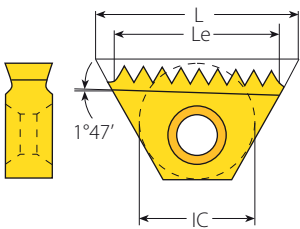
详细刀杆信息, 请参考284页

NPTF (干密封)

内螺纹/外螺纹



标准参照: ANSI 1.20.3-1976
公差等级: 标准型 NPTF



标准型 TM

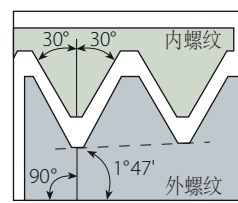
标准型 TM

刀片尺寸		螺距	订货代码	Le	刀齿	刀杆	
IC	L mm	tpi	外螺纹 + 内螺纹	mm		RH	LH
3/8"	16	14	3EI14NPTFTM2...	14.51	8	TMNC...-3	TMNC...-3LH
		11.5	3EI11.5NPTFTM2...	13.25	6		
3/8"B	22	14	3BEI14NPTFTM2...	21.77	12	BTMNC...-3B	BTMNC...-3BLH
		11.5	3BEI11.5NPTFTM2...	19.88	9		
5/8"	27	11.5	5EI11.5NPTFTM2...	24.30	11	TM.C...-5	TM.C...-5LH
		8	5EI8NPTFTM2...	22.23	7	TMNC...-5	TMNC...-5LH
3/4"B	38.5	11.5	6BEI11.5NPTFTM2...	35.34	16	TMC...-6B	TMC...-6BLH
		8	6BEI8NPTFTM2...	31.75	10		

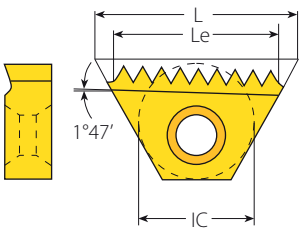
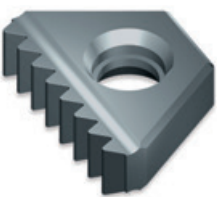
To thread with insert cutting edge marked "L", use LH toolholders.
For toolholder information, see page 286.

NPTF (干密封)

内螺纹



标准参照: ANSI 1.20.3-1976
公差等级: 标准型 NPTF



粗牙 螺距 TM

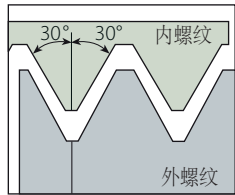
粗牙 TM

螺纹	刀片尺寸		订货代码	刃口数	Le	刀齿	刀杆
Inch	IC	L mm	内螺纹		mm		
1/4"-18	1/4"	11	2I18NPTFTM...028/078	1	9.88	7	TMC20-2-124/009
3/8"-18			2I18NPTFTM...028/078	1	9.88	7	TMC20-2-124/009

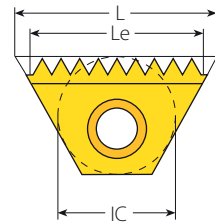
详细刀杆信息, 请参考284页

NPS

内螺纹/外螺纹



标准参照: USA NBS H28 (1957)
公差等级: 标准型 NPS



标准型 TM

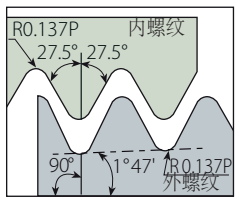
标准型 TM

刀片尺寸		螺距	订货代码	Le	刀齿	螺纹公称尺寸	
IC	L mm	tpi	外螺纹 + 内螺纹	mm			刀杆
3/8"	16	14	3EI14NPSTM2...	14.51	8	1/2"	TMNC16-3
		14	3EI14NPSTM2...	14.51	8	3/4"	TMNC20-3
		11.5	3EI11.5NPSTM2...	13.25	6	1", 1 1/4"	TMNC20-3
3/8"B	22	11.5	3BEI11.5NPSTM2...*	19.88	9	1", 1 1/4"	BTMNC20-3B
5/8"	27	11.5	5EI11.5NPSTM2...	24.30	11	1 1/2", 2"	TMC25-5
		8	5EI8NPSTM2...	22.23	7	2 1/2" & larger	TMC32-5

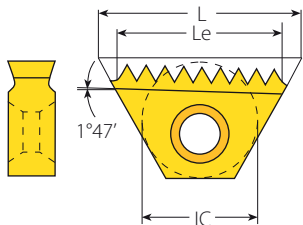
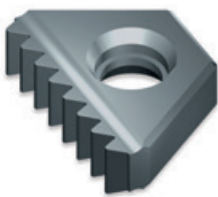
* 单一切削刃
所有刀片含两个切削刃
详细刀杆信息, 请参考280页

BSPT

内螺纹/外螺纹



标准参照: B.S. 21:1985
公差等级: 标准型 BSPT



标准型 TM

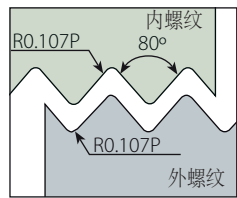
标准型 TM

刀片尺寸		螺距		订货代码	Le	刀齿	刀杆	
IC	L mm	tpi		外螺纹 + 内螺纹	mm		RH	LH
1/4"	11	19		2EI19BSPT-TM2...	9.36	7	TMC..-2	TMC..-2LH
3/8"	16	14		3EI14BSPT-TM2...	14.51	8	TMNC..-3	TMNC..-3LH
		11		3EI11BSPT-TM2...	13.85	6		
5/8"	27	11		5EI11BSPT-TM2...	23.09	10	TMC..-5	TMC..-5LH

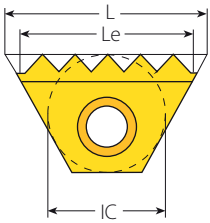
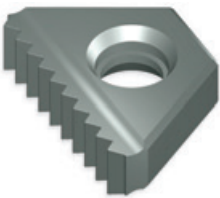
采用刀口标记为 "L" 的刀片时, 选用左手刀杆
详细刀杆信息, 请参考280页

Pg

内螺纹/外螺纹



标准参照: DIN 40430
公差等级: 标准型



标准型 TM

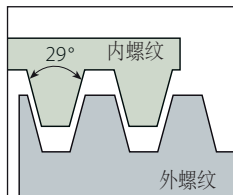
标准型 TM

刀片尺寸		螺距	订货代码	Le	刀齿	螺纹公称尺寸	
IC	L mm	tpi	外螺纹 + 内螺纹	mm			刀杆
6.0mm	10.4	20	6.0EI20PGTM...	8.99	7	Pg7	TMMC...-6.0
		20	2EI20PGTM2...	10.16	8	Pg7	
1/4"	11	18	2EI18PGTM2...	9.88	7	Pg9, Pg11, Pg13.5, Pg16	TMC...-2
		16	2EI16PGTM2...	9.53	6	Pg21, Pg29, Pg36, Pg42, Pg48	TMSH...-2
3/8"	16	20	3EI20PGTM2...	13.97	11	Pg7	
		18	3EI18PGTM2...	14.11	10	Pg9, Pg11, Pg13.5, Pg16	TMC...-3
		16	3EI16PGTM2...	14.29	9	Pg21, Pg29, Pg36, Pg42, Pg48	TMSH...-3
5/8"	27	16	5EI16PGTM2...	25.40	16	Pg21, Pg29, Pg36, Pg42, Pg48	TMC...-5, TMSH...-5

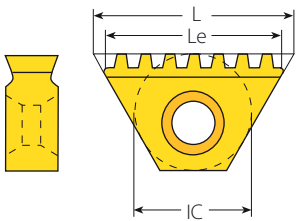
TM Standard

所有刀刃含有两个切削刃, 除了MiniTM (IC 6.0 mm) 只含有一个刀刃。
详细刀杆信息, 请参考280页

内螺纹



标准参照: ANSI B1/5:1988
公差等级: 3G



粗牙螺距 TM

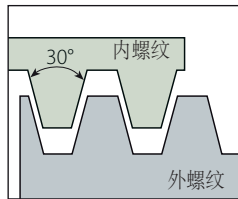
粗牙 TM

螺纹		刀片尺寸		订货代码	刃口数	Le	刀齿	镗孔直径范围
Inch	IC	L mm	内螺纹			mm	刀杆	mm
1/2"-16	6.0mm	10.4	6.0I16ACMETM...028/052	1	7.94	5	TMMC12-6.0	11.1
1/2"-16			6.0I16ACMETM...028/052	1	7.94	5	TMMC20-6.0	11.1
5/8"-16			2I16ACMETM...028/053	2	9.53	6	TMC12-2	14.2
5/8"-16			2I16ACMETM...028/053	2	9.53	6	TMC20-2	14.2
5/8"-14	1/4"	11	2I14ACMETM...028/054	1	9.07	5	TMC20-2-124/005	14.0
3/4"-16			2I16ACMETM...028/055	2	9.53	6	TMC12-2	17.4
3/4"-16			2I16ACMETM...028/055	2	9.53	6	TMC20-2	17.4
3/4"-14			2I14ACMETM...028/083	1	9.07	5	TMC20-2-124/006	17.2
3/4"-12			2I12ACMETM...028/056	1	8.47	4	TMC20-2-124/006	16.9
7/8"-14	3/8"	16	3I14ACMETM...028/057	2	14.51	8	TMNC16-3	20.4
7/8"-12	1/4"	11	2I12ACMETM...028/058	1	8.47	4	TMC20-2-124/006	20.1
1"-14	3/8"	16	3I14ACMETM...028/059	2	14.51	8	TMC16-3	23.5
1"-12			3I12ACMETM...028/060	2	14.82	7	TMNC16-3	23.2
1"-10	1/2"	22	4I10ACMETM...028/061	1	17.78	7	TMC25-4-124/002	22.8
1"-8			4I8ACMETM...028/062	1	19.05	6	TMC25-4-124/002	22.2
1 1/8"-12	3/8"	16	3I12ACMETM...028/060	2	14.82	7	TMC16-3	26.4
1 1/8"-10	1/2"	22	4I10ACMETM...028/084	1	17.78	7	TMC25-4-124/007	26.0
1 1/8"-8			4I8ACMETM...028/063	1	19.05	6	TMC25-4-124/002	25.4-28.5
1 1/4"-12	3/8"	16	3I12ACMETM...028/060	2	14.82	7	TMC20-3	29.6
1 1/4"-10	5/8"	27	5I10ACMETM...028/064	2	22.86	9	TMC25-5-124/004	29.2
1 1/4"-8	1/2"	22	4I8ACMETM...028/063	1	19.05	6	TMC25-4-124/002	25.4-28.5
1 3/8"-10	5/8"	27	5I10ACMETM...028/065	2	22.86	9	TMC25-5-124/004	32.3
1 3/8"-8			5I8ACMETM...028/066	2	22.23	7	TMC25-5-124/004	31.7
1 3/8"-6			5I6ACMETM...028/067	1	21.17	5	TMC25-5-124/008	30.6
1 1/2"-10			5I10ACMETM...028/068	2	22.86	9	TMC25-5	35.5
1 1/2"-8			5I8ACMETM...028/069	2	22.23	7	TMC25-5-124/004	34.9
1 1/2"-6			5I6ACMETM...028/070	2	21.17	5	TMC25-5-124/004	33.8
1 3/4"-10			5I10ACMETM...028/064	2	22.86	9	TMC32-5	41.9
1 3/4"-8			5I8ACMETM...028/069	2	22.23	7	TMC25-5	41.2
1 3/4"-6			5I6ACMETM...028/070	2	21.17	5	TMC25-5	40.2
1 3/4"-5			5I5ACMETM...028/071	2	20.32	4	TMC25-5-124/004	39.3
2"-8			5I8ACMETM...028/069	2	22.23	7	TMC32-5	47.6
2"-6			5I6ACMETM...028/072	2	21.17	5	TMC25-5	46.5
2"-5			5I5ACMETM...028/071	2	20.32	4	TMC25-5	45.7
2 1/4"-6			5I6ACMETM...028/072	2	21.17	5	TMC32-5	52.9
2 1/4"-5			5I5ACMETM...028/073	2	20.32	4	TMC25-5	52.0
2 1/2"-5			5I5ACMETM...028/073	2	20.32	4	TMC32-5	58.4

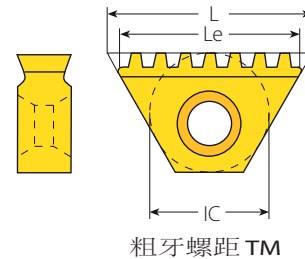
详细刀杆信息, 请参考280页

梯形螺纹

内螺纹



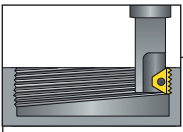
标准参照: Trapez DIN 103
公差等级: 7e/7H



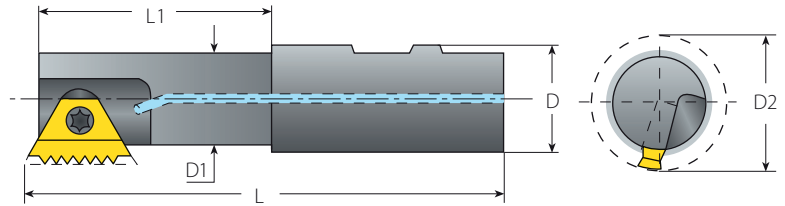
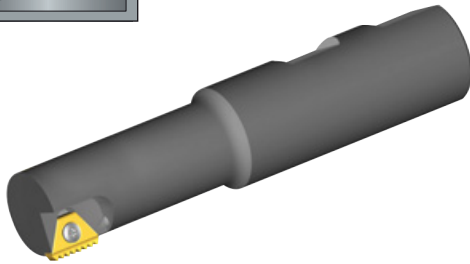
粗牙 TM

螺纹	刀片尺寸		订货代码	刃口数	Le	刀齿	镗孔直径范围	
mm	IC	L mm	内螺纹		mm	刀杆	mm	
TR 16X2.0	1/4"	11	2I2.0TRTM...028/028	1	10	5	TMC20-2-124/006	14.0
TR 18X2.0			2I2.0TRTM...028/029	1	10	5	TMC20-2-124/006	16.0-18.0
TR 20X2.0			2I2.0TRTM...028/029	1	10	5	TMC20-2-124/006	16.0-18.0
TR 24X3.0	1/2"	22	4I3.0TRTM...028/030	1	18	6	TMC25-4-124/002	21.0
TR 26X3.0			4I3.0TRTM...028/031	1	18	6	TMC25-4-124/002	23.0-27.0
TR 28X3.0			4I3.0TRTM...028/031	1	18	6	TMC25-4-124/002	23.0-27.0
TR 30X3.0			4I3.0TRTM...028/031	1	18	6	TMC25-4-124/002	23.0-27.0
TR 32X3.0			4I3.0TRTM...028/032	1	18	6	TMC25-4-124/007	29.0-33.0
TR 34X3.0			4I3.0TRTM...028/032	1	18	6	TMC25-4-124/007	29.0-33.0
TR 36X3.0			4I3.0TRTM...028/032	1	18	6	TMC25-4-124/007	29.0-33.0
TR 38X3.0	5/8"	27	5I3.0TRTM...028/033	2	24	8	TMC25-5-124/004	35.0-39.0
TR 40X3.0			5I3.0TRTM...028/033	2	24	8	TMC25-5-124/004	35.0-39.0
TR 42X3.0			5I3.0TRTM...028/033	2	24	8	TMC25-5-124/004	35.0-39.0
TR 44X3.0			5I3.0TRTM...028/033	2	24	8	TMC25-5	41.0-45.0
TR 46X3.0			5I3.0TRTM...028/033	2	24	8	TMC25-5	41.0-45.0
TR 48X3.0			5I3.0TRTM...028/033	2	24	8	TMC25-5	41.0-45.0
TR 50X3.0			5I3.0TRTM...028/033	2	24	8	TMC32-5	47.0-57.0
TR 52X3.0			5I3.0TRTM...028/033	2	24	8	TMC32-5	47.0-57.0
TR 55X3.0			5I3.0TRTM...028/033	2	24	8	TMC32-5	47.0-57.0
TR 60X3.0			5I3.0TRTM...028/033	2	24	8	TMC32-5	47.0-57.0
TR 65X4.0			5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0
TR 70X4.0			5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0
TR 75X4.0			5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0
TR 80X4.0			5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0
TR 85X4.0			5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0
TR 90X4.0			5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0
TR 95X4.0			5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0
TR 100X4.0	5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0		
TR 105X4.0	5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0		
TR 110X4.0	5I4.0TRTM...028/034	2	24	6	TMC32-5	61.0-106.0		

详细刀杆信息, 请参考280页



内/外螺纹刀杆系列



TM 标准型

刀杆配件

刀片尺寸		订货代码		尺寸				
IC		L	L1	D	D1	D2	刀片螺丝	扳手
6.0mm	TMMC12-6.0	69.0	12.0	12	6.8	9.0	SN7T	K7T
	TMMC20-6.0	84.0	17.0	20	6.8	9.0		
1/4"	TMC12-2	70.0	12.0	12	8.9	11.5	SN2TM	K2T
	TMC20-2	85.0	20.0	20	8.9	11.5		
	TMC20-2LH	85.0	20.0	20	8.9	11.5		
3/8"	TMC16-3	90.0	22.0	16	13.6	17.0	SN3TM	K3T
	TMC20-3	95.0	43.0	20	16.6	20.0		
3/8"B	BTMC16-3B	79.5	29.0	16	13.5	17.0	SN3TM	K3T
	BTMC20-3B	81.5	29.0	20	15.5	19.0		
	BTMC25-3B	92.3	30.0	25	15.5	19.0	SN3T	K3T
	BTMWC25-3B	90.8	30.0	25	18.5	22.0		
5/8"	TMC25-5	110.0	52.0	25	24.0	30.0	SN5TM	K5T
	TMC25-5LH	110.0	52.0	25	24.0	30.0		
	TMC32-5	120.0	58.0	32	31.0	37.0		
3/4"B	TMC32-6B	115.0	53.0	32	27.0	35.0	SM7T	K30T
	TMC40-6B	135.0	63.0	40	38.0	46.0		

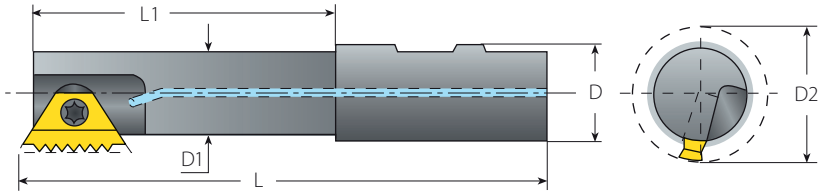
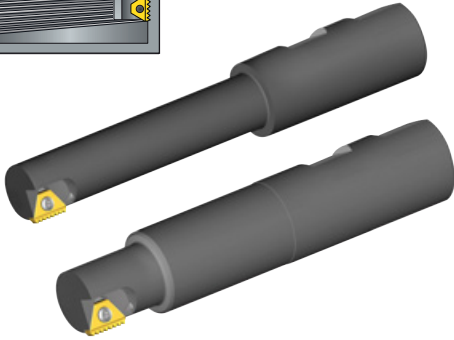
内螺纹加工标准刀杆

刀杆		最小加工直径				
	D2	ISO 粗牙	ISO 细牙	UNC	UN/UNF/UNEF/UNS	UNJ
TMMC12-6.0 TMMC20-6.0	9.0		M10x0.75; M12x1.0; M14x1.25; M14x1.5		$\frac{7}{16}$ -32UN; $\frac{7}{16}$ -28UNEF; $\frac{1}{2}$ -24UNS; $\frac{7}{16}$ -20UNF; $\frac{9}{16}$ -18UNF; $\frac{9}{16}$ -16UNF	$\frac{9}{16}$ -24UNJF; $\frac{1}{2}$ -20UNJF; $\frac{9}{16}$ -18UNJF; $\frac{9}{16}$ -16UNJF
TMC12-2 TMC20-2 TMC20-2LH	11.5		M15x1.0; M16x1.5		$\frac{9}{16}$ -32UN; $\frac{9}{16}$ -28UN; $\frac{9}{16}$ -24UNEF; $\frac{5}{8}$ -20UN; $\frac{9}{16}$ -18UNF; $\frac{9}{16}$ -16UNF; $\frac{7}{8}$ -14UNF	$\frac{9}{16}$ -24UNJF; $\frac{3}{4}$ -20UNJF; $\frac{5}{8}$ -18UNJF; $\frac{5}{8}$ -16UNJF; $\frac{7}{8}$ -14UNJF
TMC16-3	17.0		M20x1.0; M22x1.5; M24x2.0		$\frac{3}{4}$ -32UN; $\frac{13}{16}$ -28UN; $\frac{7}{8}$ -24UNS; $\frac{7}{8}$ -20UNEF; $\frac{7}{8}$ -18UNS $\frac{7}{8}$ -16UNS; 1-14UNS; $\frac{13}{16}$ -12UN	$\frac{15}{8}$ -24UNJ; $\frac{7}{8}$ -20UNJF; $\frac{11}{16}$ -18UNJF; $\frac{7}{8}$ -16UNJ; $\frac{15}{8}$ -14UNJ; $\frac{15}{16}$ -12UNJ
TMC20-3	20.0		M24x1.0; M25x1.5; M27x2.0		$\frac{7}{8}$ -32UN; $\frac{15}{16}$ -28UN; 1-24UNS; $\frac{15}{16}$ -20UNEF; 1-18UNS; 1-16 UNS; $\frac{11}{8}$ -14UNS; $\frac{11}{16}$ -12UN	$\frac{15}{8}$ -24 UNJ; $\frac{15}{16}$ -20UNJF; $\frac{11}{16}$ -18UNJF; 1-16UNJ; $\frac{15}{8}$ -14UNJ; $\frac{11}{16}$ -12UNJ
BTMC16-3B	17.0		M20x1.0; M22x1.5; M24x2.0		$\frac{7}{8}$ -24UNS; $\frac{7}{8}$ -20UNEF; $\frac{7}{8}$ -18UNS; $\frac{7}{8}$ -16UNS; 1-14UNS; $\frac{13}{16}$ -12UN	
BTMC20-3B BTMC25-3B	19.0		M22x1.0; M24x1.5; M25x2.0		$\frac{7}{8}$ -24UNS; $\frac{15}{16}$ -20UNEF; 1-18UNS; 1-16UNS; 1-14UNS; 1-12UNF	
BTMWC25-3B	22.0	M27x1.5	M25x1.0; M30x2		1-24UNS; $\frac{11}{16}$ -20UN; $\frac{11}{16}$ -18UNEF; $\frac{11}{16}$ -16UNEF; $\frac{11}{8}$ -14UNS; $\frac{11}{8}$ -12UNF	
TMC25-5 TMC25-5LH	30.0		M35x1.5; M39x2.0; M36x3.0; M36x4.0; M42x4.5; M48x5.0	$\frac{13}{4}$ -5	$\frac{13}{8}$ -24UNS; $\frac{13}{8}$ -20UN; $\frac{17}{16}$ -18UNEF; $\frac{17}{16}$ -16UNEF; $\frac{11}{2}$ -14UNS; $\frac{11}{2}$ -12UNF; $\frac{15}{8}$ -10UNS; $\frac{17}{16}$ -8UN; $\frac{15}{8}$ -6UN	$\frac{17}{16}$ -16UNJ; $\frac{11}{2}$ -12UNJF
TMC32-5	37.0		M45x1.5; M45x2.0; M50x3.0; M56x4.0		$\frac{15}{8}$ -24UNS; $\frac{111}{16}$ -20UN; $\frac{111}{16}$ -18UNEF; $\frac{111}{16}$ -16UNEF; $\frac{13}{4}$ -14UNS; $\frac{13}{4}$ -12 UN; $\frac{17}{8}$ -10UNS; 2-8 UN; $\frac{21}{4}$ -6UN	$\frac{111}{16}$ -16UNJ; $\frac{13}{4}$ -12UNJ
TMC32-6B	35.0	M64x6.0	M42x1.5; M42x2.0; M48x3.0; M55x4.0; M48x5.0; M56x5.5	2-4.5; $\frac{21}{2}$ -4	$\frac{21}{4}$ -6UN	
TMC40-6B	46.0	M64x6.0	M52x1.5; M55x2.0; M60x3.0; M60x4.0; M60x5.5	$\frac{21}{2}$ -4	$\frac{23}{8}$ -6UN	

	D2	BSW/BSF	BSP	BSPT	NPT	NPTF	PG	NPS	梯形螺纹	ACME
TMMC12-6.0 TMMC20-6.0	9.0	$\frac{7}{16}$ -26BSF; $\frac{1}{2}$ -20BSW; $\frac{7}{16}$ -18BSF;	$\frac{1}{4}$ -19				PG7			$\frac{1}{2}$ -16
TMC12-2 TMC20-2 TMC20-2LH	11.5	$\frac{5}{8}$ -26BSF; $\frac{5}{8}$ -20BSW; $\frac{9}{16}$ -16BSF; $\frac{11}{16}$ -14BSF	$\frac{3}{8}$ -19; $\frac{1}{2}$ -14	$\frac{3}{8}$ -19			PG9; PG21			$\frac{5}{8}$ -16;
TMC16-3	17.0	$\frac{13}{16}$ -26BSF; $\frac{7}{8}$ -20BSW; $\frac{7}{8}$ -16BSW; $\frac{13}{16}$ -12BSW	$\frac{5}{8}$ -14; $\frac{11}{4}$ -11				PG13.5; PG21	$\frac{1}{2}$ -14; 1-11.5		1-14; $\frac{11}{8}$ -12
TMC20-3	20.0	$\frac{15}{16}$ -26BSF; 1-20BSW; $\frac{111}{16}$ -16BSW; $\frac{15}{16}$ -12BSW;	$\frac{3}{4}$ -14; 1-11				PG16; PG21	$\frac{3}{4}$ -14; 1-11.5		$\frac{11}{4}$ -12
BTMC16-3B	17.0	$\frac{7}{8}$ -20BSW; $\frac{7}{8}$ -16BSW; $\frac{13}{16}$ -12BSW	$\frac{5}{8}$ -14; 1-11					1-11.5		
BTMC20-3B BTMC25-3B	19.0	$\frac{15}{16}$ -20BSW; 1-16BSW; $\frac{111}{16}$ -12BSW	$\frac{3}{4}$ -14; 1-11					1-11.5		
BTMWC25-3B	22.0	$\frac{111}{16}$ -20BSW; $\frac{11}{8}$ -16BSW	$\frac{7}{8}$ -14; 1-11					1-11.5		
TMC25-5 TMC25-5LH	30.0	1.4-16BSW; $\frac{13}{8}$ -12BSW; $\frac{17}{16}$ -8BSW; $\frac{13}{4}$ -7BSF; 1.6-6BSW	$\frac{11}{8}$ -11	$\frac{11}{4}$ -11	$\frac{11}{4}$ -11.5	$\frac{11}{4}$ -11.5	PG29	$\frac{11}{4}$ -11.5; $\frac{21}{2}$ -8	TR44-3.0	$\frac{11}{2}$ -10; $\frac{13}{4}$ -8; $\frac{13}{4}$ -6; 2-5
TMC32-5	37.0	$\frac{13}{4}$ -16BSW; $\frac{17}{8}$ -12BSW; 2.1-8BSW; $\frac{17}{8}$ -6BSW;	$\frac{11}{2}$ -11	$\frac{11}{2}$ -11	$\frac{11}{2}$ -11.5	$\frac{11}{2}$ -11.5	PG36	$\frac{11}{2}$ -11.5; $\frac{21}{2}$ -8	TR50-3.0; TR65-4.0	$\frac{13}{4}$ -10; 2-8; $\frac{21}{4}$ -6; $\frac{21}{2}$ -5
TMC32-6B	35.0	$\frac{21}{4}$ -6 BSF; 3-5BSF; $\frac{31}{2}$ -4.5BSF;	$\frac{11}{2}$ -11		$\frac{21}{2}$ -8	$\frac{21}{2}$ -8				
TMC40-6B	46.0	$\frac{25}{8}$ -6BSW; 3-5BSF; $\frac{31}{2}$ -4.5BSF	2-11		3-8	3-8				



外螺纹和内螺纹刀杆



TML长型刀杆

刀杆配件

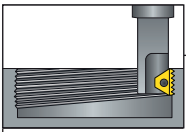
刀片尺寸		订货代码		尺寸				
IC		L	L1	D	D1	D2	刀片螺丝	扳手
1/4"	TMLC25-2	125.0	17.0	25	8.9	11.5	SN2TM	K2T
3/8"	TMLC25-3	125.0	25.0	25	18.6	22.0	SN3T	K3T
	BTMLC25-3	125.0	63.5	25	18.6	22.0		
3/8"B	BTMLC20-3B	96.5	44.0	20	15.5	19.0	SN3T	K3T
	BTMLC25-3B	125.0	63.5	25	18.6	22.0		
5/8"	TMLC25-5	150.0	92.0	25	24.0	30.0	SN5TM	K5T
	TMLC32-5	160.0	98.0	32	31.0	37.0		
3/4"B	TMLC40-6B	165.0	93.0	40	38.0	46.0	SM7T	K30T

TM Standard

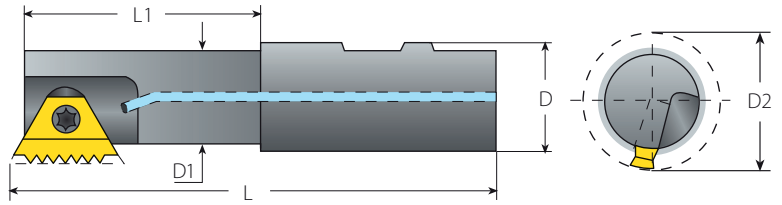
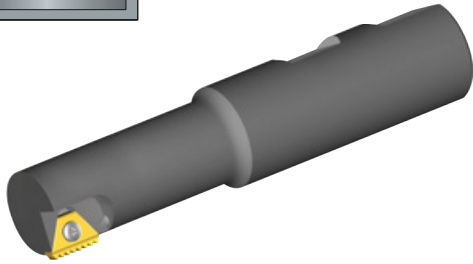
内螺纹加工TML刀杆

刀杆		最小 螺纹直径				
	D2	ISO 粗牙	ISO 细牙	UNC	UN/UNF/UNEF/UNS	UNJ
TMLC25-2	11.5		M15x1.0; M16x1.5		$\frac{9}{16}$ -32UN; $\frac{9}{16}$ -28UN; $\frac{9}{16}$ -24UNEF; $\frac{5}{8}$ -20UN; $\frac{9}{16}$ -18UNF; $\frac{9}{16}$ -16UNF; $\frac{7}{8}$ -14UNF	$\frac{9}{16}$ -24UNJEF; $\frac{3}{4}$ -20UNJEF; $\frac{5}{8}$ -18UNJF; $\frac{5}{8}$ -16UNJF; $\frac{7}{8}$ -14UNJF
TMLC25-3 BTMLC25-3	22.0	M27x1.5	M25x1.0; M30x2.0		1-32UN; 1-28UN; 1-24UNS; $1\frac{1}{16}$ -20UN; $1\frac{1}{16}$ -18UNEF; $1\frac{1}{16}$ -16UNEF; $1\frac{1}{8}$ -14UNS; $1\frac{1}{8}$ -12	$1\frac{5}{8}$ -24 UNJ; $1\frac{1}{16}$ -20UNJ; $1\frac{1}{16}$ -18UNJEF; $1\frac{1}{16}$ -16; $1\frac{1}{8}$ -12UNJF
BTMLC20-3B	19.0		M22x1.0; M24x1.5; M25x2.0		$\frac{7}{8}$ -24UNS; $1\frac{5}{16}$ -20UNEF; 1-18UNS; 1-16UNS; 1-14UNS; 1-12UNF	
BTMLC25-3B	22.0	M27x1.5	M25x1.0; M30x2.0		1-24UNS; $1\frac{1}{16}$ -20UN; $1\frac{1}{16}$ -18UNEF; $1\frac{1}{16}$ -16UNEF; $1\frac{1}{8}$ -14UNS; $1\frac{1}{8}$ -12UNF	
TMLC25-5	30.0		M35x1.5; M39x2.0; M36x3.0; M36x4.0; M42x4.5; M48x5.0	$1\frac{3}{4}$ -5	$1\frac{3}{8}$ -24UNS; $1\frac{3}{8}$ -20UN; $1\frac{7}{16}$ -18UNEF; $1\frac{7}{16}$ -16UNEF; $1\frac{1}{2}$ -14UNS; $1\frac{1}{2}$ -12UNF; $1\frac{5}{8}$ -10UNS; $1\frac{7}{16}$ -8UN; $1\frac{3}{8}$ -6UN	$1\frac{7}{16}$ -16UNJ; $1\frac{1}{2}$ -12UNJF
TMLC32-5	37.0		M45x1.5; M45x2.0; M50x3.0; M56x4.0		$1\frac{5}{8}$ -24UNS; $1\frac{11}{16}$ -20UN; $1\frac{11}{16}$ -18UNEF; $1\frac{11}{16}$ -16UNEF; $1\frac{3}{4}$ -14UNS; $1\frac{3}{4}$ -12UN; $1\frac{7}{8}$ -10UNS; 2-8 UN; $2\frac{1}{4}$ -6UN	$1\frac{11}{16}$ -16UNJ; $1\frac{3}{4}$ -12UNJ
TMLC40-6B	46.0	M64x6.0	M52x1.5; M55x2.0; M60x3.0; M60x4.0; M60x5.5	$2\frac{1}{2}$ -4	$2\frac{3}{8}$ -6UN	

	D2	BSW/BSF	BSP	BSPT	NPT	NPTF	PG	NPS	梯形螺纹	ACME
TMLC25-2	11.5	$\frac{5}{8}$ -26BSF; $\frac{5}{8}$ -20BSW; $1\frac{1}{16}$ -14BSF	$\frac{3}{8}$ -19; $\frac{1}{2}$ -14	$\frac{3}{8}$ -19			PG9; PG21			
TMLC25-3 BTMLC25-3	22.0	$1\frac{1}{16}$ -26BSF; $1\frac{1}{16}$ -20BSW; $1\frac{1}{8}$ -16BSW	$\frac{7}{8}$ -14; 1-11				PG21	1-11.5		
BTMLC20-3B	19.0	$1\frac{5}{16}$ -20BSW; 1-16BSW; $1\frac{1}{16}$ -12BSW	$\frac{3}{4}$ -14; 1-11					1-11.5		
BTMLC25-3B	22.0	$1\frac{1}{16}$ -20BSW; $1\frac{1}{8}$ -16BSW	$\frac{7}{8}$ -14; 1-11				PG21	1-11.5		
TMLC25-5	30.0	$1\frac{3}{4}$ -7BSF; $1\frac{7}{8}$ -6BSW	$1\frac{1}{4}$ -11	$1\frac{1}{4}$ -11	$1\frac{1}{4}$ -11.5	$1\frac{1}{4}$ -11.5	PG29	$1\frac{1}{4}$ -11.5; $2\frac{1}{2}$ -8	TR44-3.0	$1\frac{1}{2}$ -10; $1\frac{3}{4}$ -8; $1\frac{3}{4}$ -6; 2-5
TMLC32-5	37.0	$1\frac{7}{8}$ -6BSW	$1\frac{1}{2}$ -11	$1\frac{1}{2}$ -11	$1\frac{1}{2}$ -11.5	$1\frac{1}{2}$ -11.5	PG36	$1\frac{1}{2}$ -11.5; $2\frac{1}{2}$ -8	TR50-3.0; TR65-4.0	$1\frac{3}{4}$ -10; 2-8; $2\frac{1}{4}$ -6; $2\frac{1}{2}$ -5
TMLC40-6B	46.0	3-5BSF; $3\frac{1}{2}$ -4.5BSF	2-11		$2\frac{1}{2}$ -8	$2\frac{1}{2}$ -8				



内/外螺纹刀杆系列



粗牙螺纹124/...刀杆

刀杆配件

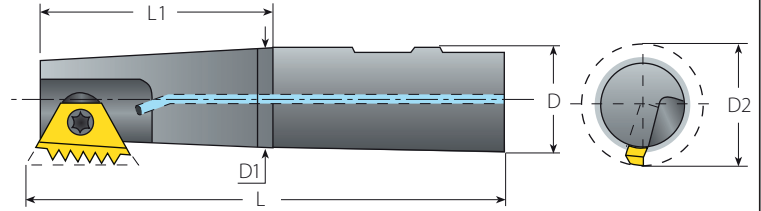
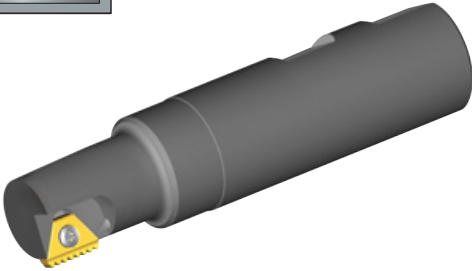
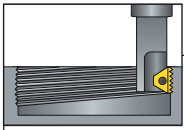
刀片尺寸		订货代码		尺寸				
IC		L	L1	D	D1	D2	刀片螺丝	扳手
6.0mm	TMMC20-6.0-124/003	85	15.0	20	6.7	9.0	SN7T	K7T
1/4"	TMC20-2-124/005	77	15.5	20	7.4	10.0	SN2TM	K2T
	TMC20-2-124/006	77	15.5	20	9.0	12.0		
	TMC20-2-124/009	77	15.5	20	7.4	10.0		
3/8"	TMC16-3-124/001	91	20.5	16	12.2	15.5	SN3TM	K3T
1/2"	TMC25-4-124/002	88	30.0	25	13.4	18.0	SN4TM	K4T
	TMC25-4-124/007	98	40.0	25	16.0	20.0	SA4TM	
5/8"	TMC25-5-124/004	98	40.0	25	19.0	25.0	SA5TM	K5T
	TMC25-5-124/008	98	40.0	25	16.4	22.0	SN5TM	

粗牙螺纹124/...刀杆内螺纹加工范围

刀杆		最小螺纹直径				
	D2	ISO 粗牙	ISO 细牙	UNC	UN/UNF/UNEF/UNS	UNJ
TMMC20-6.0-124/003	9.0	M12x1.75	M12x1.0; M22x1.5; M12x1.75	$\frac{7}{16}$ -14	$\frac{11}{16}$ -32UN; $\frac{1}{2}$ -24UNS; $\frac{9}{16}$ -18UNF; $\frac{9}{16}$ -16UNF	$\frac{9}{16}$ -24UNJEF; $\frac{1}{2}$ -20UNJF; $\frac{9}{16}$ -18UNJF; $\frac{9}{16}$ -16UNJF
TMC20-2-124/005	10.0			$\frac{1}{2}$ -13	$\frac{5}{8}$ -12UN	
TMC20-2-124/006	12.0			$\frac{5}{8}$ -11		
TMC20-2-124/009	10.0					
TMC16-3-124/001	15.5	M20x2.5	M20x1.0; M22x1.5; M22x2.0	$\frac{3}{4}$ -10	$\frac{11}{16}$ -32UN; $\frac{3}{4}$ -28UN; $\frac{3}{4}$ -24UNS; $\frac{13}{16}$ -20UNEF; $\frac{7}{8}$ -18UNS; $\frac{7}{8}$ -16UNS; $\frac{7}{8}$ -14UNF; $\frac{7}{8}$ -12UN	$\frac{15}{8}$ -24UNJ; $\frac{13}{16}$ -20UNJEF; $\frac{11}{16}$ -18UNJEF; $\frac{13}{16}$ -16UNJ; $\frac{7}{8}$ -14UNJF; $\frac{7}{8}$ -12UNJ
TMC25-4-124/002	18.0	M22x2.5; M24x3.0		$\frac{7}{8}$ -9; $1\frac{1}{8}$ -7		
TMC25-4-124/007	20.0			1-8		
TMC25-5-124/004	25.0	M30x3.5	M30x1.5; M33x2.0; M39x3.0; M56x4.0	$1\frac{3}{8}$ -6	$1\frac{1}{8}$ -24UNS; $1\frac{3}{16}$ -20UN; $1\frac{3}{16}$ -18UNEF; $\frac{13}{16}$ -16UNEF; $1\frac{1}{4}$ -14UNS; $1\frac{1}{4}$ -12UNF; $1\frac{1}{2}$ -10UNS; $1\frac{1}{4}$ -8UN	$1\frac{3}{16}$ -16UNJ; $1\frac{1}{4}$ -12UNJF
TMC25-5-124/008	22.0					

	D2	BSW/BSF	BSP	BSPT	NPT	NPTF	PG	NPS	梯形螺纹	ACME
TMMC20-6.0-124/003	9.0	$\frac{7}{16}$ -26BSF; $\frac{7}{16}$ -18BSF;	$\frac{1}{4}$ -19				PG7	$\frac{1}{2}$ -14; 1-11.5		
TMC20-2-124/005	10.0	$\frac{1}{2}$ -16BSF								$\frac{5}{8}$ -14
TMC20-2-124/006	12.0	$\frac{5}{8}$ -14BSF							TR16-2	$\frac{3}{4}$ -14; $\frac{3}{4}$ -12
TMC20-2-124/009	10.0				$\frac{1}{4}$ -18	$\frac{1}{4}$ -18				
TMC16-3-124/001	15.5	$\frac{3}{4}$ -12BSF	$\frac{1}{2}$ -14	$\frac{3}{4}$ -14; 1-11	$\frac{3}{4}$ -14; 1-11.5	$\frac{3}{4}$ -14; 1-11.5	PG13.5; PG21	1-11.5		
TMC25-4-124/002	18.0	$\frac{7}{8}$ -11BSF; 1-10BSF; $\frac{7}{8}$ -9BSW; 1-8BSW							TR24-3.0	1-10; 1-8
TMC25-4-124/007	20.0								TR32-3.0	$1\frac{1}{8}$ -10
TMC25-5-124/004	25.0	$\frac{13}{16}$ -8BSW; $1\frac{1}{4}$ -7BSW; $\frac{15}{16}$ -6BSW	1-11	1-11	$1\frac{1}{4}$ -11.5; $2\frac{1}{2}$ -8	$1\frac{1}{4}$ -11.5; $2\frac{1}{2}$ -8	PG21	$1\frac{1}{4}$ -11.5; $2\frac{1}{2}$ -8	TR38-3.0	$1\frac{1}{4}$ -10; $1\frac{3}{8}$ -8; $1\frac{1}{2}$ -6; $1\frac{3}{4}$ -5
TMC25-5-124/008	22.0	$1\frac{1}{8}$ -7BSW								$1\frac{3}{8}$ -6

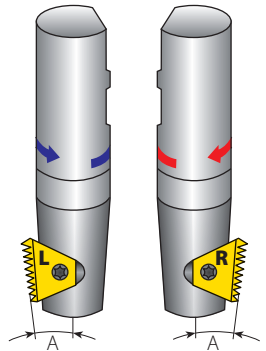
内/外螺纹刀杆系列



锥度螺纹(NPT, NPTF, BSPT) TMN刀杆

刀杆配件

刀片尺寸 订货代码 尺寸									
IC	RH	*LH	L	L1	D	D1	D2	刀片螺丝	扳手
3/8"	TMNC16-3	TMNC16-3 LH	90.0	22.0	16	12.5	15.5	SN3TM	K3T
	TMNC20-3	TMNC20-3 LH	85.0	23.0	20	15.0	19.0		
3/8"B	BTMNC16-3B	BTMNC16-3B LH	79.5	29.0	16	13.5	17.0	SN3TM	K3T
	BTMNC20-3B	BTMNC20-3B LH	81.5	29.0	20	15.5	19.0		
5/8"	TMNC32-5	TMNC32-5 LH	120.0	58.0	32	31.0	37.0	SN5TM	K5T



左手刀杆

右手刀杆

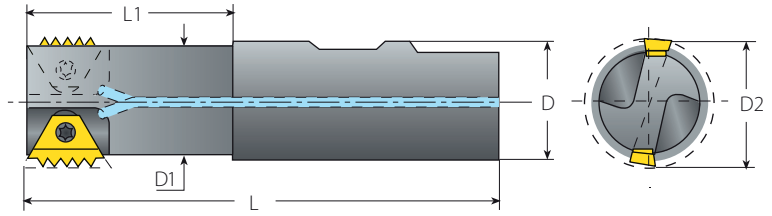
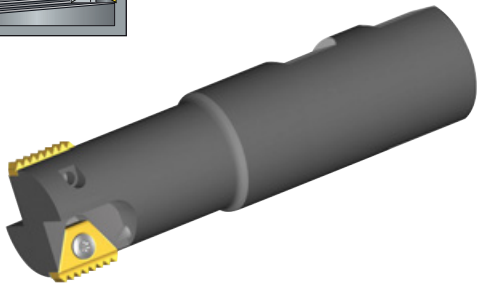
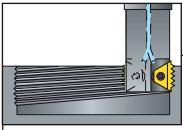
* 采用刃口标记为“L”的刀片时，选用左手刀杆

TMN刀杆内螺纹加工范围

刀杆		最小螺纹直径			
	D2	ISO 细牙	UNC	UN/UNF/UNEF/UNS	UNJ
TMNC16-3 TMNC16-3LH	15.5	M20x1.0; M22x1.5; M22x2.0		$\frac{11}{16}$ -32UN; $\frac{3}{4}$ -28UN; $\frac{3}{4}$ -24UNS; $\frac{13}{16}$ -20UNEF; $\frac{7}{8}$ -18UNS; $\frac{7}{8}$ -16UNS; $\frac{7}{8}$ -14UNF; $\frac{3}{4}$ -12UN	$\frac{15}{8}$ -24UNJ; $\frac{13}{16}$ -20UNJEF; $\frac{11}{16}$ -18UNJEF; $\frac{13}{16}$ -16 UNJ; $\frac{7}{8}$ -14UNJF; $\frac{7}{8}$ -12UNJ
TMNC20-3 TMNC20-3LH	19.0	M22x1.0; M24x1.5; M25x2.0		$\frac{7}{8}$ -32UN; $\frac{7}{8}$ -28UN; $\frac{7}{8}$ -24UNS; $\frac{15}{16}$ -20UNEF; 1-18UNS; 1-16UNS; 1-14UNS; 1-12UNF	$\frac{15}{8}$ -24UNJ; $\frac{15}{16}$ -20UNJEF; $\frac{11}{16}$ -18UNJEF; $\frac{15}{16}$ -16UNJ; 1 $\frac{3}{8}$ -14UNJ; 1-12UNJF
BTMNC16-3B BTMNC16-3BLH	17.0	M20x1.0; M22x1.5; M24x2.0		$\frac{7}{8}$ -24UNS; $\frac{7}{8}$ -20UNEF; $\frac{7}{8}$ -18UNS; $\frac{7}{8}$ -16UNS; 1-14UNS; $\frac{13}{16}$ -12UN	
BTMNC20-3B BTMNC20-3BLH	19.0	M22x1.0; M24x1.5; M25x2.0		$\frac{7}{8}$ -24UNS; $\frac{15}{16}$ -20UNEF; 1-18UNS; 1-16UNS; 1-14UNS; 1-12UNF	
TMNC32-5 TMNC32-5LH	37.0	M45x1.5; M45x2.0; M50x3.0; M56x4.0		$\frac{15}{8}$ -24UNS; $\frac{11}{16}$ -20UN; $\frac{11}{16}$ -18UNEF; $\frac{11}{16}$ -16UNEF; $\frac{13}{4}$ -14UNS; $\frac{13}{4}$ -12UN; $\frac{17}{8}$ -10UNS; 2-8UN; $\frac{21}{4}$ -6UN	

	D2	BSW/BSF	BSP	BSPT	NPT	NPTF	PG	NPS	梯形螺纹	ACME
TMNC16-3 TMNC16-3LH	15.5	$\frac{13}{16}$ -16BSW	$\frac{1}{2}$ -14	$\frac{1}{2}$ -14; 1-11	$\frac{1}{2}$ -14; 1-11.5	$\frac{1}{2}$ -14; 1-11.5	PG11; PG21	$\frac{1}{2}$ -14; 1-11.5		$\frac{7}{8}$ -14; 1-12
TMNC20-3 TMNC20-3LH	19.0	$\frac{15}{16}$ -26BSW; $\frac{15}{16}$ -20BSW; 1-16BSW; $\frac{11}{16}$ -12BSW	$\frac{3}{4}$ -14; 1-11	$\frac{3}{4}$ -14; 1-11	$\frac{3}{4}$ -14; 1-11.5	$\frac{3}{4}$ -14; 1-11.5	PG21	$\frac{3}{4}$ -14; 1-11.5		
BTMNC16-3B BTMNC16-3BLH	17.0	$\frac{7}{8}$ -20BSW; $\frac{7}{8}$ -16BSW; $\frac{13}{16}$ -12BSW	$\frac{5}{8}$ -14; 1-11		$\frac{3}{4}$ -14; 1-11.5	$\frac{3}{4}$ -14; 1-11.5		1-11.5		
BTMNC20-3B BTMNC20-3BLH	19.0	$\frac{15}{16}$ -20BSW; 1-16BSW; $\frac{11}{16}$ -12BSW	$\frac{3}{4}$ -14; 1-11		$\frac{3}{4}$ -14; 1-11.5	$\frac{3}{4}$ -14; 1-11.5		1-11.5		
TMNC32-5 TMNC32-5LH	37.0	$\frac{17}{8}$ -6BSW	$\frac{11}{2}$ -11	$\frac{11}{2}$ -11	$\frac{11}{2}$ -11.5; $\frac{21}{2}$ -8	$\frac{11}{2}$ -11.5; $\frac{21}{2}$ -8	PG36	$\frac{11}{2}$ -11.5; $\frac{21}{2}$ -8		

内/外螺纹刀杆系列



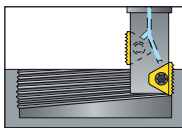
双排屑槽TM2刀杆

刀杆配件

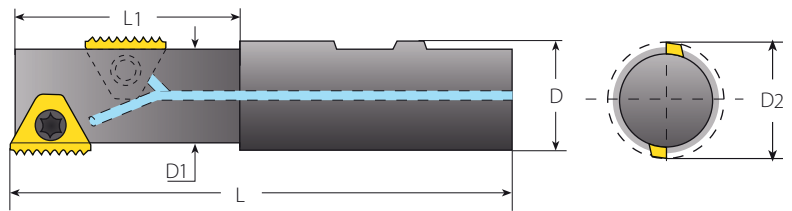
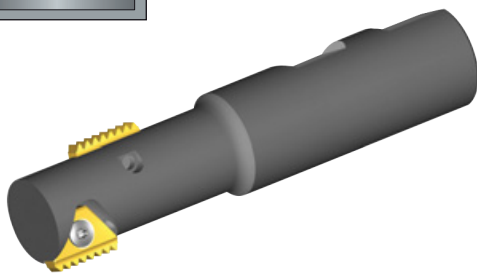
刀片尺寸		订货代码		尺寸				
IC		L	L1	D	D1	D2	刀片螺丝	扳手
1/4"	TM2C20-2	85	20.0	20	14.4	17.0	SN2TM	K2T
3/8"	TM2C25-3	100	43.0	25	22.5	26.0	SN3T	K3T
3/8"B	BTM2C25-3B	104.2	46.0	25	22.5	26.0		
5/8"	TM2C32-5	120	45.0	32	36.0	42.0	SN5TM	K5T
3/4"B	TM2C40-6B	137.2	65.0	40	44.0	52.0	SM7T	K30T

双排屑槽TM2刀杆内螺纹加工范围

刀杆		最小螺纹直径										
	D2 (mm)	ISO 细牙	UNC	UN/UNF/UNEF/UNS	UNJ	BSW/BSF	BSP	BSPT	NPT	NPTF	PG	NPS
TM2C20-2	17.0	M22x1.5		3/4-32UN; 13/16-28UN; 7/8-24UNS; 7/8-20UNEF; 7/8-18UNS; 7/8-16UNS; 1-14UNS	15/8-24UNJ; 7/8-20UNJEF; 11/16-18UNJEF; 7/8-16UNJ; 15/8-14UNJ		5/8-14				PG16; PG21	
TM2C25-3 BTM2C25-3B	26.0	M32x1.5; M33x2.0		1 1/4-24UNS; 1 3/16-20UN; 1 1/4-18UNEF; 1 1/4-16UNEF; 1 3/8-14UNS; 1 5/16-12UN	1 5/8-24UNJ; 1 3/16-20UNJ; 1 1/4-18UNJEF; 1 1/4-16UNJ; 1 5/16-12UNJ	1 3/16-26BSF; 1 1/4-20BSW; 1 5/16-16BSW	1 1/8-11				PG36	1 1/4-11.5
TM2C32-5	42.0	M48x1.5; M50x2.0; M55x3.0; M64x4.0		1 7/8-20UN; 2-18UNS; 2-16UNS; 2-14UNS; 2-12UN; 2 1/4-10UNS; 2 1/2-8UN; 2 1/2-6UN	1 15/16-16UNJ; 2-12UNJ	2-16BSW; 2-12BSW; 2 1/4-8BSW	2-11	2-11	2-11.5	2-11.5	PG36	2-11.5; 2 1/2-8
TM2C40-6B	52.0	M58x1.5; M68x4.0; M70x6.0	2 3/4-4	2 5/8-6UN		2 7/8-6BSW; 2 7/8-5BSW; 3 3/4-4.5BSF	2 1/4-11		2 1/2-8	2 1/2-8		



内/外螺纹刀杆系列



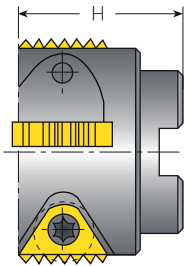
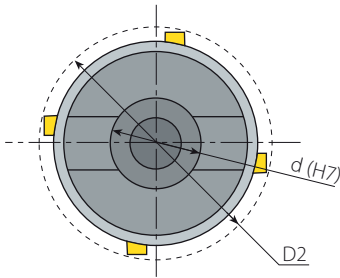
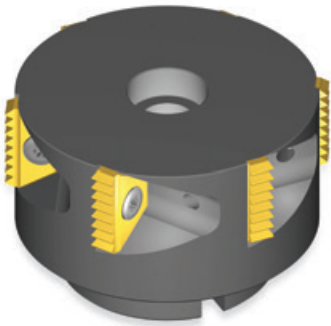
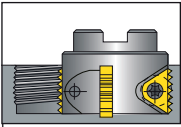
偏置双排屑槽TMO刀杆

刀杆配件

刀片尺寸	订货代码	螺纹应用范围			尺寸					刀杆配件	
		外螺纹	内螺纹	外螺纹 & 内螺纹	L	L1	D	D1	D2	刀片螺钉	扳手
1/4"	TMOC20-2-1	16UN	48/32/16UN		90	25	20	11.9	14.5	SN2TM	K2T
	TMOC20-2-2	24/18UN	48/24/18UN	24W							
	TMOC20-2-3	28/14UN	28/14UN	28/14W							
	TMOC20-2-4	20UN	20UN								
	TMOC20-2-5			26W							
	TMOC20-2-6			20W							
	TMOC20-2-7			19W							
	TMOC20-2-8	1.0/1.5ISO	0.5/1.0/1.5ISO								
	TMOC20-2-9	0.75ISO	48UN, 0.75ISO								
	TMOC20-2-10	1.25ISO	1.25ISO								
3/8"	TMOC20-3-1	1.5ISO	0.5/1.5ISO		95	43	20	16.6	20.0	SN3T	K3T
	TMOC20-3-2	13UN	13UN	26W							
	TMOC20-3-3	28UN	32/28UN								
	TMOC20-3-4	27UN	27UN								
	TMOC20-3-5		11.5UN	11.5NPS							
	TMOC20-3-6	24/20/18/16/14/12UN	24/20/18/16/14/12UN	26/20/18/16/14/12W, 14NPS							
	TMOC20-3-7	1.25ISO	1.25ISO	24W							
	TMOC20-3-8			19W							
	TMOC20-3-9			11W							
	TMOC20-3-10	1.0/2.0ISO	0.5/1.0/2.0ISO								
	TMOC20-3-11	0.75ISO	32UN, 0.75ISO								
	TMOC20-3-12	1.75ISO	1.75ISO								
5/8"	TMOC25-5-1	24/20/18/14/13/12UN	24/20/18/14/13/11UN	14W	110	52	25	24	30.0	SN5TM	K5T
	TMOC25-5-2	24/18/12UN	24/18/12/6UN	12W							
	TMOC25-5-3	16UN	16UN	16W, 8NPS							
	TMOC25-5-4	14/7UN	14UN	14/7W							
	TMOC25-5-5		11.5UN	11.5NPS							
	TMOC25-5-6	11UN	11UN	11W							
	TMOC25-5-7	10UN	10/5UN	10W							
	TMOC25-5-8	9UN	9UN	9W							
	TMOC25-5-9	8UN	8UN	8W							
	TMOC25-5-10		7UN								
	TMOC25-5-11	6UN		6W							
	TMOC25-5-12	1.0/2.0/2.5/4.0ISO	1.0/2.0/2.5/4.0/5.0ISO								
	TMOC25-5-13	1.25ISO	1.25ISO								
	TMOC25-5-14	1.5/2.5/4.5ISO	1.5/2.5/4.5/ISO								
	TMOC25-5-15	1.75ISO	1.75ISO								
	TMOC25-5-16	1.0/1.5/3.0/3.5ISO	1.0/1.5/3.0/3.5ISO								

TM Standard

内/外螺纹刀杆系列



Cutter Drive
ISO 240-1975 (mm)

TM 盘铣刀

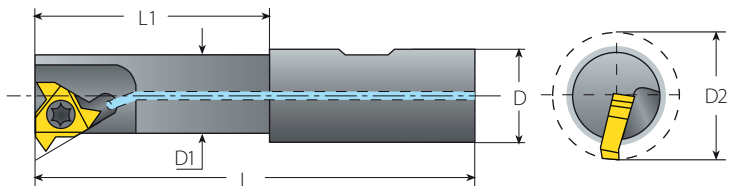
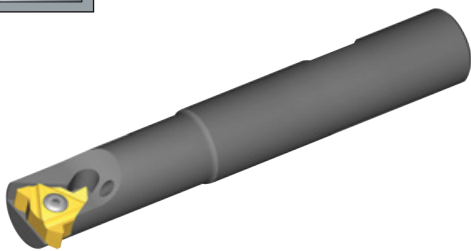
刀杆配件

刀片尺寸	订货代码	刀片数量	尺寸					
IC			D2	d(H7)	H	刀片螺丝	扳手	连接螺钉
1/4"	TMSH-D38-16-2	6	38.0	16.0	40.0	SN2T	HK2T	M8x1.25x35
1/4"	TMSH-D50-22-2	8	50.0	22.0	40.0			M10x1.50x35
3/8"	TMSH-D50-22-3	6	50.0	22.0	40.0	SN3TM	HK3T	M10x1.50x35
3/8B"	TMSH-D63-22-3B	6	63.0	22.0	40.0			
5/8"	TMSH-D63-22-5	4	63.0	22.0	45.0	SN5TM	HK5T	M10x1.50x35
3/4B"	TMSH-D63-22-6B	4	63.0	22.0	50.0	SM7T	HK7T	M10x1.50x35
5/8"	TMSH-D80-27-5	6	80.0	27.0	50.0	SN5TM	HK5T	M12x1.75x40
3/4B"	TMSH-D80-27-6B	5	80.0	27.0	50.0	SM7T	HK7T	M12x1.75x40
5/8"	TMSH-D100-32-5	7	100.0	32.0	55.0	SN5TM	HK5T	M16x2.00x40
3/4B"	TMSH-D100-32-6B	6	100.0	32.0	55.0	SM7T	HK7T	M16x2.00x40
5/8"	TMSH-D125-40-5	9	125.0	40.0	63.0	SN5TM	HK5T	M20x2.50x50
3/4B"	TMSH-D125-40-6B	8	125.0	40.0	63.0	SM7T	HK7T	M20x2.50x50

盘铣刀内螺纹加工范围

刀杆		最小螺纹直径										
	D2 (mm)	ISO 细牙	UNC	UN/UNF/UNEF/UNS	UNJ	BSW/BSF	BSP	BSPT	NPT	NPTF	PG	NPS
TMSH-D38-16-2	38.0	M45x1.5		1 ¹¹ / ₁₆ -20UN; 1 ³ / ₄ -18UNS; 1 ³ / ₄ -16UNS; 1 ⁷ / ₈ -14UNS	1 ⁵ / ₈ -24UNJ; 1 ¹¹ / ₁₆ -20UNJ; 1 ³ / ₄ -16UNJ	1 ³ / ₄ -26BSF; 1 ³ / ₄ -20BSW					PG36	
TMSH-D50-22-2	50.0	M56x1.5		2 ¹ / ₄ -20UN; 2 ¹ / ₄ -18UNS; 2 ¹ / ₄ -16UNS; 2 ¹ / ₄ -14UNS	2 ¹ / ₄ -20UNJ; 2 ¹ / ₄ -16UNJ							
TMSH-D50-22-3	50.0	M56x1.5; M58x2.0		2 ¹ / ₄ -20UN; 3 ¹ / ₄ -18UNS; 3 ¹ / ₄ -16UNS; 3 ¹ / ₄ -14UNS; 2 ³ / ₈ -12UN	2 ¹ / ₄ -20UNJ; 2 ¹ / ₄ -16UNJ; 2 ³ / ₈ -12UNJ	2 ¹ / ₄ -20BSW; 2 ³ / ₈ -16BSW; 2 ³ / ₈ -12BSW	2 ¹ / ₄ -11				PG42	2-11.5
TMSH-D63-22-3B	63.0	M70x1.5; M70x2.0		2 ³ / ₄ -20UN; 2 ³ / ₄ -18UNS; 2 ³ / ₄ -16UNS; 2 ³ / ₄ -14UNS; 2 ⁷ / ₈ -12UN			2 ¹ / ₂ -11					
TMSH-D63-22-5	63.0	M70x1.5; M70x2.0; M75x3.0; M80x4.0		2 ³ / ₄ -20UN; 3 ³ / ₄ -18UNS; 3 ³ / ₄ -16UNS; 3 ³ / ₄ -14UNS; 2 ⁷ / ₈ -12UN; 3-10UNS; 3-8UN	2 ³ / ₄ -16UNJ; 2 ⁷ / ₈ -12UNJ	2 ⁷ / ₈ -16BSW; 2 ⁷ / ₈ -12BSW; 3 ¹ / ₈ -8BSW	2 ¹ / ₂ -11	3-11				3-8
TMSH-D63-22-6B	63.0	M70x2.0; M80x4.0; M85x6.0	3 ¹ / ₄ -4	3 ¹ / ₄ -6UN		3 ³ / ₈ -6BSW; 3 ¹ / ₂ -4.5BSF	2 ¹ / ₂ -11		3-8	3-8		
TMSH-D80-27-5	80.0	M90x2.0; M95x3.0; M95x4.0		3 ¹ / ₂ -18UNS; 3 ¹ / ₂ -16UNS; 3 ¹ / ₂ -14UNS; 3 ¹ / ₂ -12UN; 3 ³ / ₄ -10UNS; 3 ³ / ₄ -8UN	3 ³ / ₈ -16UNJ; 3 ¹ / ₂ -12UNJ	3 ¹ / ₂ -16BSW; 3 ¹ / ₂ -12BSW; 3 ³ / ₄ -8BSW	3 ¹ / ₄ -11	4-11				3 ¹ / ₂ -8
TMSH-D80-27-6B	80.0	M90x2.0; M95x4.0; M105x6.0		3 ⁷ / ₈ -6UN		4-6BSW	3 ¹ / ₄ -11		3 ¹ / ₂ -8	3 ¹ / ₂ -8		
TMSH-D100-32-5	100.0	M110x2.0; M115x3.0; M115x4.0			4 ¹ / ₄ -16UNJ; 4 ³ / ₈ -12UNJ	4 ¹ / ₄ -16BSW; 4 ¹ / ₄ -12BSW; 4 ⁵ / ₈ -8BSW	4-11	4-11				
TMSH-D100-32-6B	100.0	M110x2.0; M115x4.0; M125x6.0				4 ⁷ / ₈ -6BSW	4-11		5-8	5-8		
TMSH-D125-40-5	125.0	M135x2.0; M140x3.0; M140x4.0			5 ¹ / ₄ -16UNJ; 5 ³ / ₈ -12UNJ	5 ¹ / ₄ -16BSW; 5 ¹ / ₄ -12BSW; 5 ⁵ / ₈ -8BSW	5-11	5-11				
TMSH-D125-40-6B	125.0	M135x2.0; M140x4.0; M150x6.0				5 ⁷ / ₈ -6BSW	5-11		5-8	5-8		

内/外螺纹刀杆系列



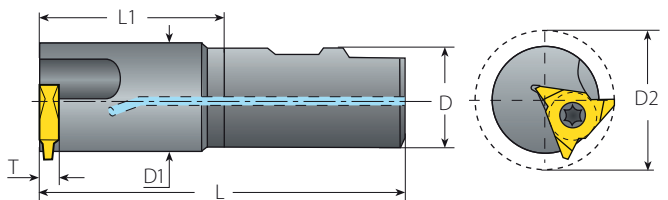
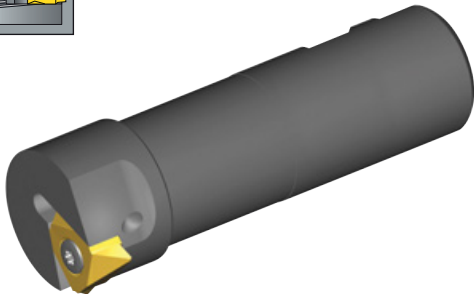
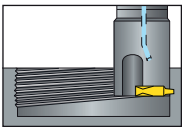
单齿(标准刀片) TMS铣刀

刀杆配件

刀片尺寸		订货代码		尺寸				
IC		L	L1	D	D1	D2	刀片 螺丝	扳手
1/4"	TMSC10-2	65	25	10	9.3	12.5	SN2TK	K2T

采用标准卧装螺纹车刀刀片, 参阅螺纹车刀刀片章节-17页
使用左手刀片加工外螺纹, 右手刀片加工内螺纹刀片

内/外螺纹刀杆系列



单齿(立装刀片) TMV铣刀

刀杆配件

刀片尺寸		订货代码		尺寸				
IC		L	L1	D	D1	D2	刀片 螺丝	扳手
5/8"V	TMVC32-5	120	60	32	35.6	46	SN6T	K6T

需安装ICS/8°立装车削刀片 (宽度T=6), 使用左手刀片加工外螺纹, 右手刀片加工内螺纹刀片
参阅螺纹车刀刀片章节-17页

推荐材质, 切削速度Vc[m/min]和进给f[mm/tooth]

材料组	序号	材料		硬度 布氏 HB	Vc [m/min]			进给 f[mm/tooth]
					涂层		非涂层	
					VBX	VTX	VK2	
P 钢	1	非合金钢	低碳 (C=0.1-0.25%)	125	100-210	90-180		0.05-0.3
	2		中碳 (C=0.25-0.55%)	150	100-180	90-170		0.05-0.25
	3		高碳 (C=0.55-0.85%)	170	100-170	90-160		0.05-0.2
	4	低合金钢 (合金含量≤5%)	非硬化	180	90-160	90-155		0.05-0.25
	5		淬硬	275	80-180	80-160		0.05-0.2
	6		淬硬	350	70-140	70-150		0.05-0.15
	7	高合金钢 (合金含量>5%)	退火	200	60-130	70-115		0.05-0.2
	8		淬硬	325	70-110	60-100		0.05-0.1
	9	铸钢	低合金 (合金含量 <5%)	200	100-170	100-170	100-150	0.05-0.15
	10		高合金 (合金含量 >5%)	225	70-120	70-130	60-130	0.05-0.1
M 不锈钢	11	不锈钢铁素体	非硬化	200	100-170	120-180		0.05-0.15
	12		淬硬	330	100-170	120-180		0.05-0.1
	13	不锈钢奥氏体	奥氏体	180	70-140	100-140		0.05-0.15
	14		超级奥氏体	200	70-140	100-140		0.05-0.1
	15	不锈钢铁素体铸件	非硬化	200	70-140	100-140		0.05-0.15
	16		淬硬	330	70-140	100-140		0.05-0.1
	17	不锈钢奥氏体铸件	奥氏体	200	70-120	100-120		0.05-0.15
	18		淬硬	330	70-120	100-120		0.05-0.1
K 铸铁	28	可锻铸铁	铁素体 (短屑)	130	60-130	100-120		0.02-0.8
	29		珠光体 (长屑)	230	60-120	80-100		0.02-0.05
	30	灰铸铁	低拉伸强度	180	60-130	80-100		0.05-0.15
	31		高拉伸强度	260	60-100	80-100		0.05-0.1
	32	球磨铸铁	铁素体	160	60-125	80-100		0.05-0.15
	33		珠光体	260	50-90	60-90		0.05-0.1
N Non-非铁金属	34	铝合金-锻造件	未时效	60	100-250		200-300	0.1-0.4
	35		时效	100	100-180		60-110	0.1-0.3
	36	铝合金	铸件	75	150-400		60-120	0.1-0.3
	37		铸件 & 时效	90	150-280		60-100	0.05-0.25
	38	铝合金	铸件 硅含量 13-22%	130	80-150		20-50	0.1-0.3
	39	铜和铜合金	黄铜	90	120-210	100-200	50-70	0.1-0.3
	40		青铜和不含铅铜	100	120-210	100-200	50-70	0.05-0.25
S 抗热、耐热材料	19	高温合金	退火 (铁基)	200	20-45	20-40	20-30	0.05-0.1
	20		时效 (铁基)	280	20-30	20-30	15-25	0.02-0.05
	21		退火 (镍或钴基)	250	20-50	15-20	15-20	0.02-0.05
	22		时效 (镍或钴基)	350	10-15	10-15	10-15	0.02-0.05
	23	钛合金	纯度 99.5 钛	400Rm	70-140	70-120	40-60	0.02--0.05
	24		α+β 合金	1050Rm	20-50	20-50	20-40	0.02-0.05
H 淬硬材料	25	高硬钢	淬硬& 退火	45-50HRc	20-45	20-45		0.01-0.03
	26			51-55HRc	20-45	20-45		0.01-0.02

材质

材质	应用	示例
VBX	钢件和铸铁加工首选, 高韧性亚微粒基体带TiCN涂层	
VTX	不锈钢加工首选, 高韧性亚微粒基体带TiAlN涂层	
VK2	非涂层材质适用于加工有色金属和非铁材质	