



Carmex
Precision Tools Ltd.

The optimal tools for your industry™

CMT

CMT 立装螺纹铣刀

Vertical Milling



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CMT Vertical Milling

CMT立装螺纹铣刀的优点

Advantages

- Ground profile inserts for high precision and excellent performance.
- Working at high machining parameters, with high surface quality.
- Solid and accurate clamping method enables full repeatability.
- Same insert and holder for right-hand or left-hand threads.
- Toolholders include weldon shank and coolant bore.

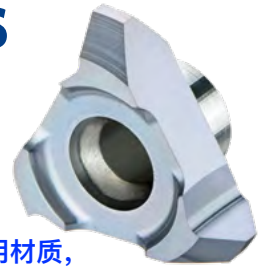
1、高精度磨制刀片，卓越的性能。2、工作在高加工参数下，高表面质量。3、整体和精确的夹紧方法，刀片换位重复精度高。4、相同刀片和刀杆可用于右手或左手螺纹刀片。5、刀杆增加削平柄和冷却孔。

CMT 直槽刀片 CMT Straight Flute Inserts

Carbide Grade: MT7 硬质合金材质: MT7

Inserts are available in MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, covering a very wide range of materials.

刀片材质MT7，亚微粒级钛铝化氮 (TiAlN) 多层涂层 (ISO K10-K20)。这是一个通用材质，覆盖材料范围非常宽。



CMT Spiral Multi Flute Inserts

CMT 多齿，螺旋槽刀片

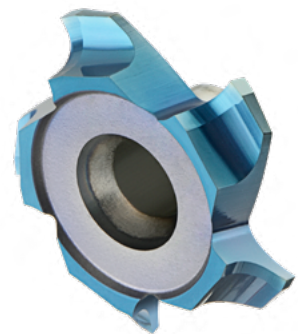
- Multi flute: 4-8 cutting edges 多齿，4-8个切削刃
- Spiral flute for smooth cutting 螺旋槽，切削平稳

The new cutters are designed for large range of materials including hardened steel up to 62 HRC.

新的切削设计是为了宽范围的材料，包括淬硬钢硬度可达62HRC。

Advantages 优点

- Longer tool life 长的刀具寿命
- High material removal and higher feeds results increased productivity 切屑移除率高和高进给提高效率
- Excellent surface finish 杰出的表面光洁度
- Reduced cycle time 减少加工时间
- Low cutting forces due to the spiral multi flutes 多螺旋槽，切削力低



Carbide Grade: MT8 硬质合金材质: MT8

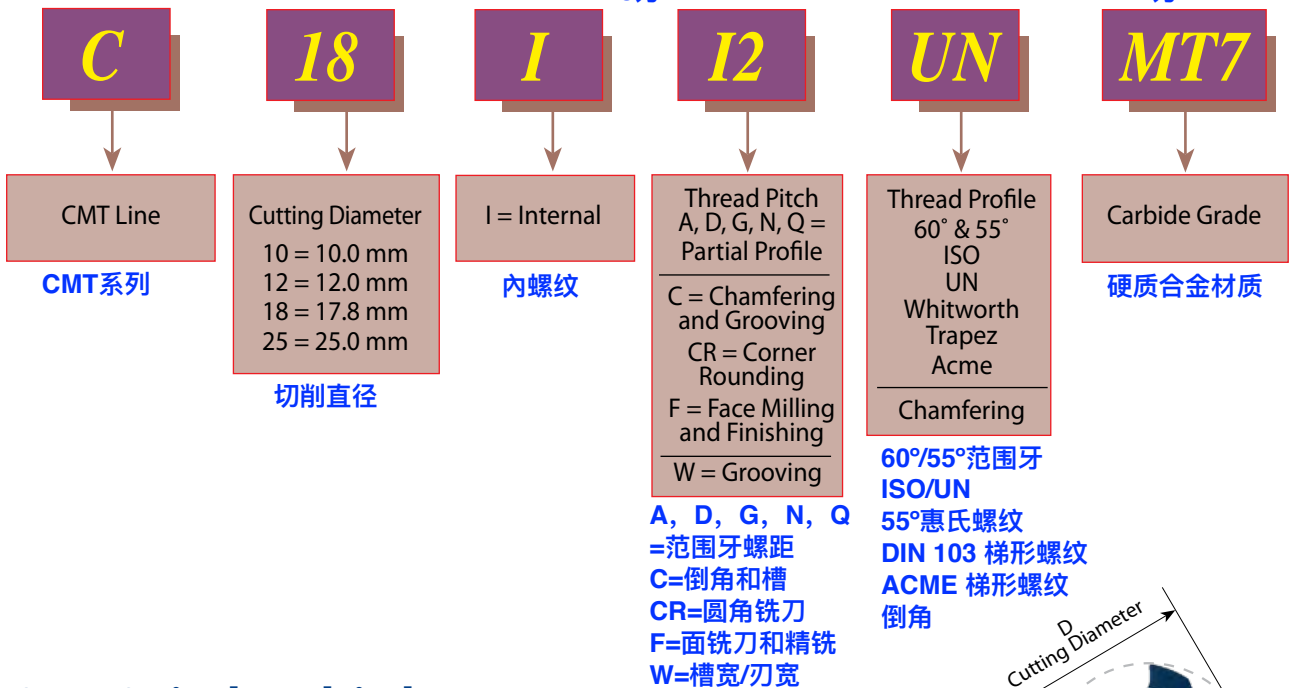
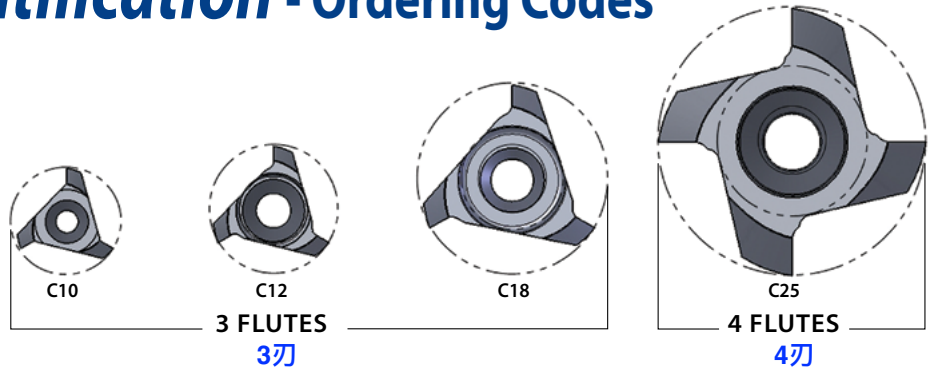
Sub Micron grade with advanced PVD triple coating (ISO K10-K20).

Extremely high heat resistant and smooth cutting operation, high performance, for all machining conditions.

亚微粒级，先进的PVD三层涂层 (K10-K20)。特别高的耐热性和平稳的切削，高性能，适用于所有加工条件。

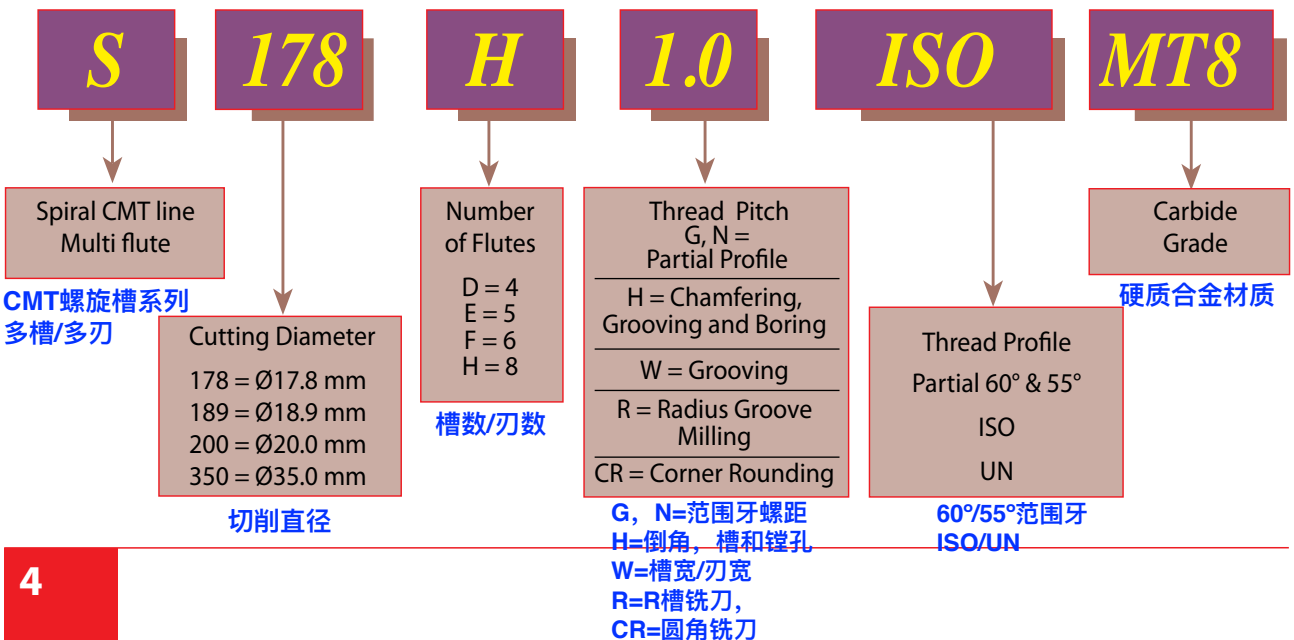
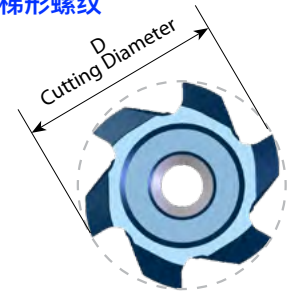
Product Identification - Ordering Codes

产品标识-订货标识



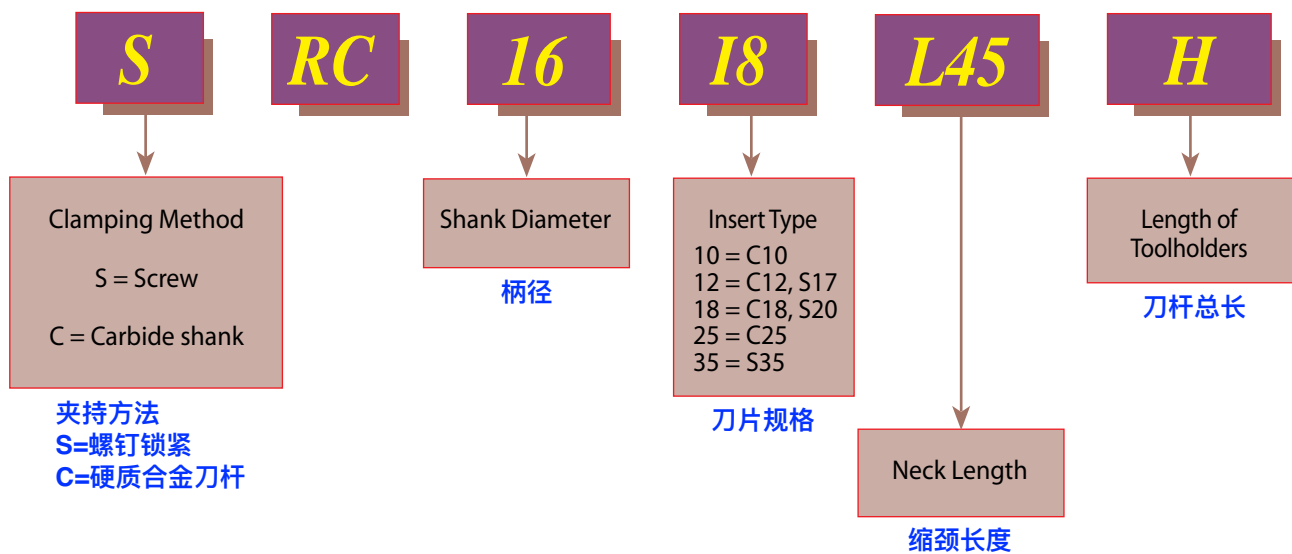
CMT Spiral Multi Flute Inserts

CMT螺旋槽多槽刀片



Product Identification - Ordering Codes 产品标识-订货标识

CMT Toolholders CMT刀杆

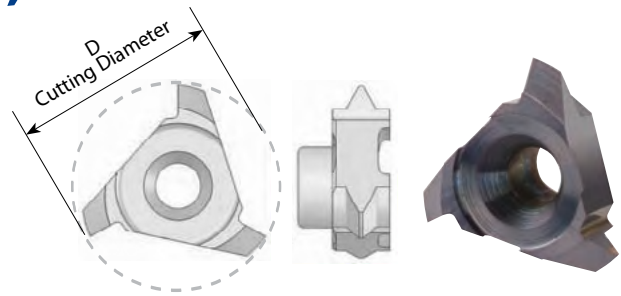


Partial Profile 60° - ISO, UN

Same insert for internal and external thread

60°范围牙 - ISO / UN通用

相同的刀片内/外螺纹通用



Insert Type 刀片型号	Ordering Code 订货标识	Pitch Range 螺距 mm	Pitch Range 牙数 TPI	D 刀片直径	Thread Diameter (min)		Holder Code* 刀杆型号	
					Pitch Low Range	Pitch High Range		
C10	C10 A60	Int. 0.5 - 0.8	56 - 28	10.0	最小直径范围		H1, 1.1, 2, 15, 16, 17	
		Ex. 0.4 - 0.8	64 - 32		$\varnothing \geq 11$	$\varnothing \geq 12$		
	C10 G60	Int. 1.0 - 2.0	28 - 13	10.0	$\varnothing \geq 12$	$\varnothing \geq 14$		H1, 2, 15, 17
		Ex. 0.8 - 1.75	32 - 15					
C12	C12 A60	Int. 0.5 - 0.8	56 - 28	12.0	$\varnothing \geq 13$	$\varnothing \geq 14$	H3, 3.1, 4, 5, 18, 19, 20	
		Ex. 0.4 - 0.8	64 - 32					
	C12 G60	Int. 1.0 - 2.0	28 - 13	12.4	$\varnothing \geq 14$	$\varnothing \geq 16$	H3,4,5,18, 19, 20	
		Ex. 0.8 - 1.75	32 - 15					
	C12 AG60	Int. 1.5-2.5	18-11	12.4	$\varnothing \geq 15$	$\varnothing \geq 17$	H3, 4, 5, 18, 20	
		Ex. 1.25-2.0	24-13					
C18	C18 A60	Int. 0.5 - 0.8	56 - 28	17.8	$\varnothing \geq 19$	$\varnothing \geq 19$	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23	
		Ex. 0.4 - 0.8	64 - 32					
	C18 G60	Int. 1.0 - 1.75	28 - 14	17.8	$\varnothing \geq 20$	$\varnothing \geq 21$		
		Ex. 0.8 - 1.5	32 - 16					
	C18 D60	Int. 2.0 - 3.0	13 - 8	17.8	$\varnothing \geq 21$	$\varnothing \geq 23$		
		Ex. 1.75 - 2.5	15 - 10					
C25	C25 G60	Int. 1.5 - 2.5	16 - 10	25.0	$\varnothing \geq 28$	$\varnothing \geq 30$	H10, 11, 24, 25	
		Ex. 1.0 - 2.0	28 - 13					
	C25 N60	Int. 3.0 - 5.0	8 - 5	25.0	$\varnothing \geq 30$	$\varnothing \geq 34$		
		Ex. 2.5 - 4.5	10 - 6					
	C25 Q60	Int. 5.0 - 6.0	5 - 4	25.0	$\varnothing \geq 34$	$\varnothing \geq 35$		
		Ex. 4.5 - 5.0	6 - 5					

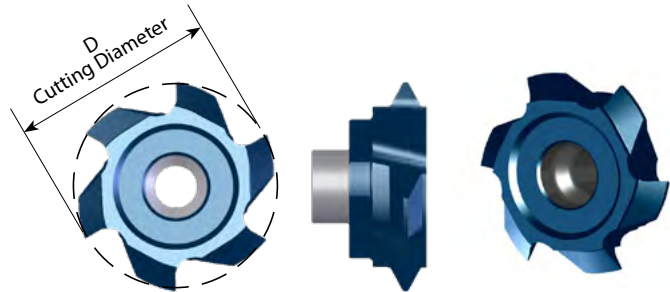
* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Partial Profile 60° - ISO, UN

Same insert for internal and external thread

Multi Flute 多槽/多刃

60°范围牙, ISO/UN通用
相同刀片可用于内或外螺纹

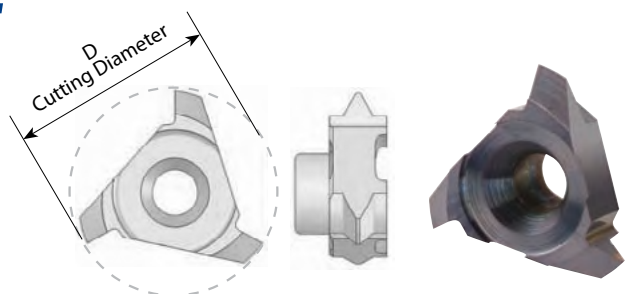


Insert Type 刀片型号	Ordering Code 订货标识	Pitch Range 螺距 mm	Pitch Range 牙数 TPI	D 刀片直径	No. of Flutes 槽数/刃数	Thread Dia (min)		Holder Code* 刀杆型号
						Pitch Low range	Pitch High range	
S17	S160 F AG60	Int. 1.0-3.5	28-7	16.0	6	最小直径范围		H3, 3.1, 4, 5, 18, 19, 20
		Ex. 0.8-3.0	32-8.5			Ø≥20	Ø≥22	
S20	S200 F G60	Int. 1.5-2.5	16-10	20.0	6	Ø ≥ 23	Ø ≥ 25	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
		Ex. 1.0-2.0	28-13					
	S200 D N60	Int. 3.0-5.0	8- 5	20.0	4	Ø ≥ 25	Ø ≥ 29	H5.1, 5.2, 21
		Ex. 2.5-4.5	10-6					
S35	S350 F N60	Int. 3.0-5.0	8-5	35.0	6	Ø≥38	Ø≥40	H12, 13, 14, 26
		Ex. 2.5-4.5	10-6					
	S350 F Q60	Int. 5.0-6.0	5-4	35.0	6	Ø≥40	Ø≥44	H12, 13, 14, 26
		Ex. 4.5-5.0	6-5					

Partial Profile 60° - NPT

Same insert for internal and external thread

60° NPT范围牙
相同刀片可用于内或外螺纹



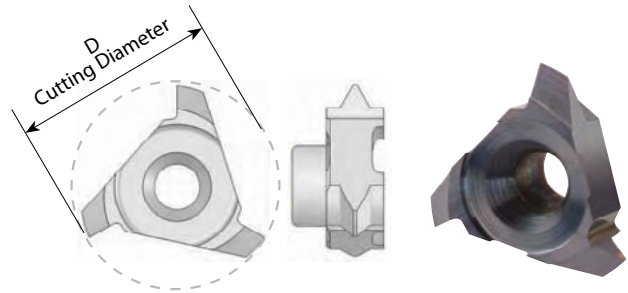
刀片型号 Insert Type	订货标识 Ordering Code	Pitch 螺距 TPI 牙数	规格 Standard	刀片直径 D	刀杆型号 Holder Code*
C10	C10 18 NPT	18	1/4 - 3/8	10.0	H1, 1.1, 2, 15, 17
C18	C18 14 NPT	14	1/2 - 3/4	15.8	H5.1, 5.2, 21
C25	C25 11.5NPT	11.5	1-2	25.0	H10, 11, 24, 25
	C25 8 NPT	8	≥ 2 1/2	25.0	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

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

Same insert for internal and external thread

55°范围牙-BSP (G) /BSF/BSW
相同刀片可用于内或外螺纹



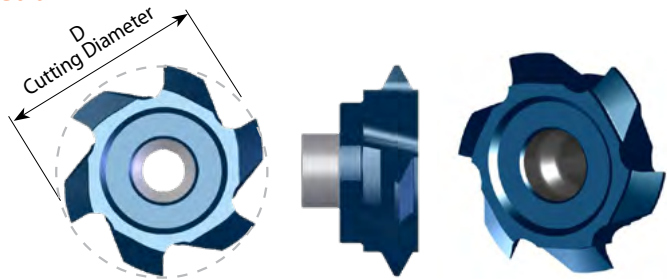
刀片型号 Insert Type	订货标识 Ordering Code	Pitch Range TPI 螺距 牙数	刀片直径 D	最小螺纹直径 Thread Dia. (min)	刀杆型号 Holder Code*
C10	C10 G55	19-14	10.0	$\varnothing \geq 13$	H1, 2, 15, 17
C12	C12 G55	28-19	12.0	$\varnothing \geq 14$	H3, 3.1, 4, 5, 18, 19, 20
	C12 N55	14- 11	12.2	$\varnothing \geq 16$	H3, 4, 5, 18, 20
C18	C18 G55	14- 8	18.0	$\varnothing \geq 23$	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
C25	C25 N55	7- 5	25.0	$\varnothing \geq 31$	H10, 11, 24, 25

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

Same insert for internal and external thread

Multi Flute

55°范围牙-BSP (G) /BSF/BSW
相同刀片可用于内或外螺纹
多槽/多刃



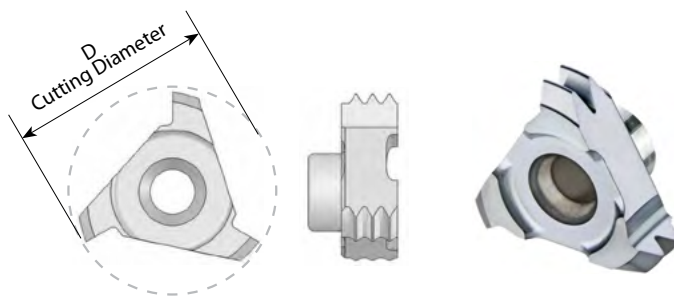
刀片型号 Insert Type	订货标识 Ordering Code	牙数范围 Pitch Range TPI	刀片直径 D	槽数/刃数 No. of Flutes	最小螺纹直径 Thread Dia (min)	刀杆型号 Holder Code*
S17	S170 F G55	11-8	17.0	6	$\varnothing \geq 18.5$	H3, 3.1, 4, 5, 18, 19, 20
S20	S195 F G55	14	19.5	6	$\varnothing \geq 23$	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	S200 D N55	8-6	20.0	4	$\varnothing \geq 25$	H5.1, 5.2, 21

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Full Profile - ISO

Inserts for internal thread

完整牙-ISO，只能用于内螺纹



刀片型号 Insert Type	订货标识 Ordering Code	螺距 Pitch mm	公制粗牙 M coarse	公制细牙 M fine	齿数 Number of Teeth	刀片直径 D	刀杆型号 Holder Code*
C10	C10 I 0.5 ISO	0.5		M10, M12	6	9.0	H1, 1.1, 2, 15, 16, 17
	C10 I 0.75ISO	0.75		M12	4	10.0	
	C10 I 1.0 ISO	1.0		M12, M13	3	10.0	
	C10 I 1.5 ISO	1.5		M13, M14	2	10.0	
	C10 I 1.75ISO	1.75	M12		1	9.6	H1, 2, 15, 17
	C10 I 2.0 ISO	2.0	M14	M18	1	10.0	
C12	C12 I 0.5 ISO	0.5		M13-M18	6	12.0	H3, 3.1, 4, 5, 18, 19, 20
	C12 I 0.75ISO	0.75		M13-M18	4	12.0	
	C12 I 1.0 ISO	1.0		M14-M19	3	12.0	
	C12 I 1.5 ISO	1.5		M15-M19	2	12.0	
	C12 I 2.0 ISO	2.0	M16	M18, M20	1	12.4	
	C12 I 2.5 ISO	2.5	M18, M20		1	12.0	H3, 4, 5, 18, 20
	C12 I 3.0 ISO	3.0	M24		1	12.4	
C18	C18 I 0.5 ISO	0.5		M19-M60	9	17.8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	C18 I 0.75ISO	0.75		M19-M60	6	17.8	
	C18 I 1.0 ISO	1.0		M20-M60	5	17.8	
	C18 I 1.5 ISO	1.5		M20-M60	3	17.8	
	C18 I 2.0 ISO	2.0		M21-M60	2	17.8	
	C18 I 2.5 ISO	2.5	M22		2	17.8	
	C18 I 3.0 ISO	3.0	M24, M27	M28-M60	1	17.8	
	C18 I 3.5 ISO	3.5	M30, M33		1	17.8	
C25	C25 I 3.0 ISO	3.0	M32, M33	M30-M80	2	25.0	H10, 11, 24, 25
	C25 I 3.5 ISO	3.5	M33		1	25.0	
	C25 I 4.0 ISO	4.0	M36, M39	M48-M80	1	25.0	
	C25 I 4.5 ISO	4.5	M42, M45		1	25.0	
	C25 I 5.0 ISO	5.0	M48, M52		1	25.0	
	C25 I 5.5 ISO	5.5	M56, M60		1	25.0	
	C25 I 6.0 ISO	6.0	M64, M68	M70-M80	1	25.0	

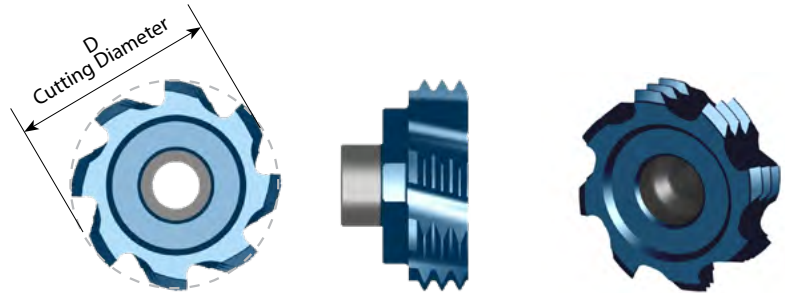
* For complete toolholder description see pages 23-24 [全部刀杆说明见第23-24页](#)

Full Profile - ISO

Inserts for internal thread

Multi Flute

完整牙-ISO, 只能用于内螺纹
多槽/多刃



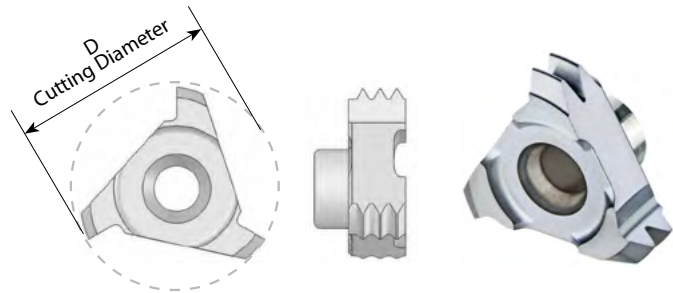
刀片型号 Insert Type	订货标识 Ordering Code	螺距 Pitch mm	公制粗牙 M coarse	公制细牙 M fine	齿数 Number of Teeth	刀片直径 D	齿数/刃数 No. of Flutes	刀杆型号 Holder Code*
S17	S160 F 2.5 ISO	2.5	M20		1	16.0	6	H3, 3.1, 4, 5, 18, 19, 20
S20	S163 H 1.0 ISO	1.0		M18-M60	5	16.3	8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	S175 H 1.5 ISO	1.5		M20-M60	3	17.5	8	
	S186 F 2.0 ISO	2.0		M22-M60	2	18.6	6	
	S178 F 2.5 ISO	2.5	M22		2	17.8	6	
	S189 F 3.0 ISO	3.0	M24, M27	M28-M60	1	18.9	6	
	S200 F 3.5 ISO	3.5	M30, M33		1	20.0	6	
	S200 F 4.0 ISO	4.0	M36, M39	M40-M60	1	20.0	6	
	S200 E 4.5 ISO	4.5	M42		1	20.0	5	
	S200 D 5.0 ISO	5.0	M48, M52		1	20.0	4	H5.1, 5.2, 21
S35	S350 F 4.5 ISO	4.5	M45	M54	1	35.0	6	H12, 13, 14, 26
	S350 F 6.0 ISO	6.0	M64, M68		1	35.0	6	
	S350 F 8.0 ISO	8.0		M130-M200	1	35.0	6	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Full Profile - UN

Inserts for internal thread

CMT完整牙-UN
只能用于内螺纹



刀片型号 Insert Type	订货标识 Ordering Code	螺距/牙数 Pitch TPI	标准规格 Nominal Size	UN粗牙 UNC	UN细牙 UNF	UN特细牙 UNEF	齿数 Number of Teeth	刀片直径 D	刀杆型号 Holder Code*
C10	C10 I 20 UN	20			1/2		2	10.0	H1, 1.1, 2, 15, 16, 17
	C10 I 18 UN	18			9/16		2	10.0	
	C10 I 13 UN	13		1/2			1	10.0	H1, 2, 15, 17
	C10 I 12 UN	12	5/8, 11/16, 3/4	9/16			1	10.0	
C12	C12 I 32 UN	32	9/16, 5/8				3	12.0	H3, 3.1, 4, 5, 18, 19, 20
	C12 I 28 UN	28	9/16, 5/8, 11/16				3	12.0	
	C12 I 24 UN	24				9/16, 5/8, 11/16	2	12.0	
	C12 I 20 UN	20	9/16, 5/8, 11/16			3/4	2	12.0	
	C12 I 18 UN	18			5/8		2	12.0	
	C12 I 16 UN	16	5/8, 11/16		3/4		1	12.0	
	C12 I 12 UN	12	5/8				1	12.4	H3, 4, 5, 18, 20
	C12 I 11 UN	11		5/8			1	12.0	
	C12 I 10 UN	10		3/4			1	12.0	
C18	C18 I 32 UN	32	3/4, 13/16, 7/8				6	17.8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	C18 I 28 UN	28	3/4, 13/16, 7/8				5	17.8	
	C18 I 24 UN	24					4	17.8	
	C18 I 20 UN	20	11/16, 11/8			13/16, 7/8, 15/16	3	17.8	
	C18 I 18 UN	18					3	17.8	
	C18 I 16 UN	16	7/8, 1				3	17.8	
	C18 I 14 UN	14			7/8		2	17.8	
	C18 I 12 UN	12	7/8		1, 1 1/8		2	17.8	
	C18 I 11 UN	11					2	17.8	
	C18 I 9 UN	9		7/8			1	17.8	
C18 I 8 UN	8		1			1	17.8		
C25	C25 I 8 UN	8	13/16, 11/4, 15/16				2	25.0	H10, 11, 24, 25
	C25 I 7 UN	7		1 1/4			1	25.0	
	C25 I 6 UN	6	17/16, 19/16	13/8, 11/2			1	25.0	
	C25 I 5 UN	5		1 3/4			1	25.0	
	C25 I 4 UN	4		2 1/2, 2 3/4			1	25.0	

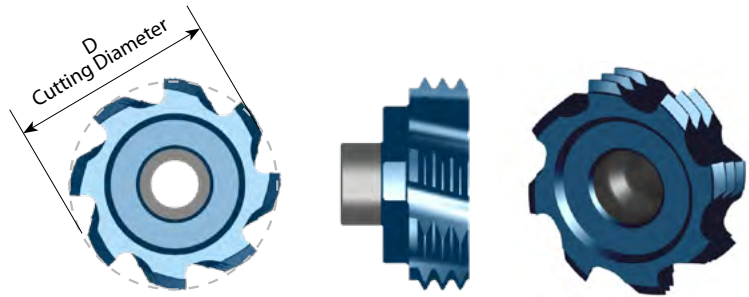
* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Full Profile - UN

Inserts for internal thread

Multi Flute

完整牙-UN, 只能用于内螺纹
多槽/多刃



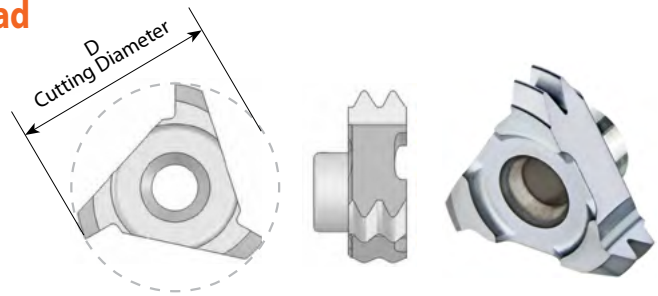
刀片型号	订货标识	螺距/牙数	标准规格	UN粗牙	UN细牙	UN特细牙	齿数	刀片直径	槽数/刃数	刀杆型号
Insert Type	Ordering Code	Pitch TPI	Nominal size	UNC	UNF	UNEF	Number of Teeth	D	No. of Flutes	Holder Code*
S17	S150 F 10UN	10		3/4			1	15.0	6	H3, 3.1, 4, 5, 18, 19, 20
S20	S160 H 24 UN	24				11/16	4	16.0	8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	S169 H 20 UN	20				3/4, 13/16, 7/8, 15/16, 1	4	16.9	8	
	S164 F 16 UN	16	7/8, 15/16, 1		3/4		3	16.4	6	
	S191 F 14 UN	14			7/8		2	19.1	6	
	S186 F 12 UN	12	7/8, 15/16		1		2	18.6	6	
	S178 F 9 UN	9		7/8			1	17.8	6	
	S200 F 8 UN	8	1 1/8	1			1	20.0	6	
	S200 F 7 UN	7		1 1/8, 1 1/4			1	20.0	6	
	S200 E 6 UN	6	1 7/16	1 3/8, 1 1/2			1	20.0	5	
	S200 D 5 UN	5		1 3/4			1	20.0	4	H5.1, 5.2, 21
S35	S350 F 8UN	8	1 5/8, 1 3/4				2	35.0	6	H12, 13, 14, 26
	S350 F 4 UN	4		2 1/2, 2 3/4, 3			1	35.0	6	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

G 55° BSW, BSF, BSP G 55° BSW/BSF/BSP

Same Insert for internal and external thread

相同刀片可用于内或外螺纹



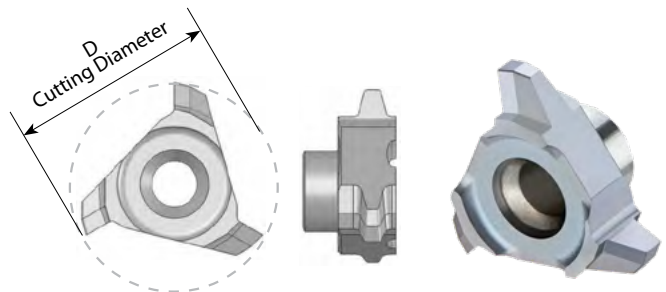
刀片型号 Insert Type	订货标识 Ordering Code	螺距/牙数 Pitch TPI	标准规格 Standard	齿数 Number of Teeth	刀片直径 D	刀杆型号 Holder Code*
C10	C10 19 W	19	G 1/4	2	10.0	H1, 1.1, 2, 15, 16, 17
C12	C12 19 W	19	G 3/8	2	12.0	H3, 3.1, 4, 5, 18, 19, 20
C18	C18 14 W	14	G 1/2 - 7/8	2	17.8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	C18 11 W	11	G ≥ 1	2	17.8	

Trapez - DIN 103

Inserts for internal thread

30° 梯形螺纹-DIN 103

只能用于内螺纹



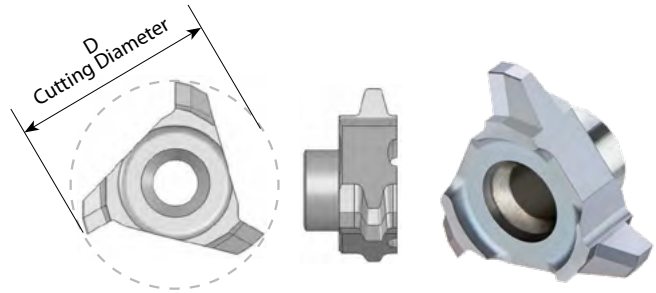
刀片型号 Insert Type	订货标识 Ordering Code	螺距 Pitch mm	标准规格 Standard	刀片直径 D	刀杆型号 Holder Code*
C10	C10 I 2 TR	2.0	Tr16x2, Tr18x2	10.0	H1, 2, 15, 17
C12	C12 I 2TR	2.0	Tr20x2	12.0	H3, 4, 5, 18, 20
C18	C18 I 3 TR	3.0	Tr24x3	17.8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	C18 I 4 TR	4.0	Tr26x4	17.8	
	C18 I 5 TR	5.0	Tr28x5	17.8	
C25	C25 I 6 TR	6.0	Tr36x6	25.0	H10, 11, 24, 25

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Acme

Inserts for internal thread

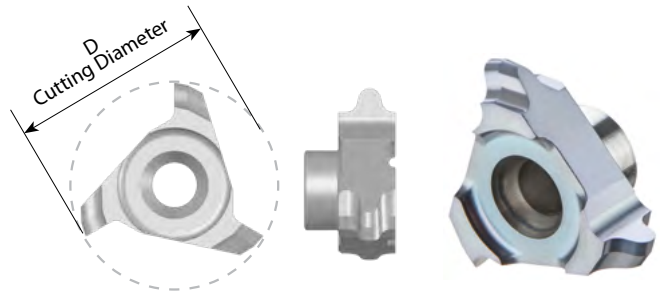
29° 美国ACME梯形螺纹
只能用于内螺纹



刀片型号 Insert Type	订货标识 Ordering Code	螺距/牙数 Pitch TPI	标准规格 Standard	刀片直径 D	刀杆型号 Holder Code*
C18	C18 I 5 ACME	5	1 ¹ / ₈ , 1 ¹ / ₄	18.0	H5.1, 5.2, 21
C25	C25 I 4 ACME	4	1 ¹ / ₂ , 1 ³ / ₄ , 2	25.0	H10, 11, 24, 25

Round-DIN 405

30° Round-圆弧齿-DIN405

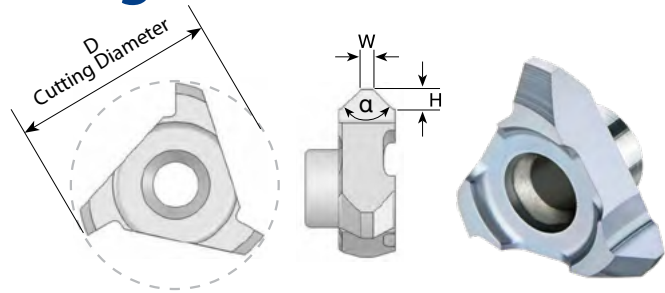


刀片型号 Insert Type	订货标识 Ordering Code	螺距/牙数 Pitch TPI	标准规格 Standard	刀片直径 D	刀杆型号 Holder Code*
C18	C18 1/8RD	8	1/8RD	17.8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	C18 1/6RD	6	1/6RD	17.8	H5.1, 5.2, 21
C25	C25 1/4RD	4	1/4RD	25.0	H10, 11, 24, 25

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Chamfering and Grooving

倒角和铣槽

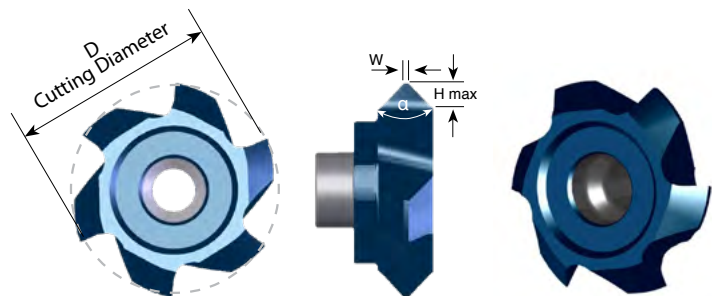


刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	切削刃宽 H	端刃宽 W	倒角角度 α	刀杆型号 Holder Code*
C10	C10 C90	10.0	1.30	0.4	90°	H1, 2, 15, 17
C12	C12 C90	12.0	1.35	0.3	90°	H3, 4, 5, 18, 20
C18	C18 C90	17.8	1.95	1.1	90°	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
C25	C25 C90	25.0	2.50	1.0	90°	H10, 11, 24, 25

Chamfering, Grooving and Boring

Multi Flute

倒角/铣槽/镗孔
多槽/多刃



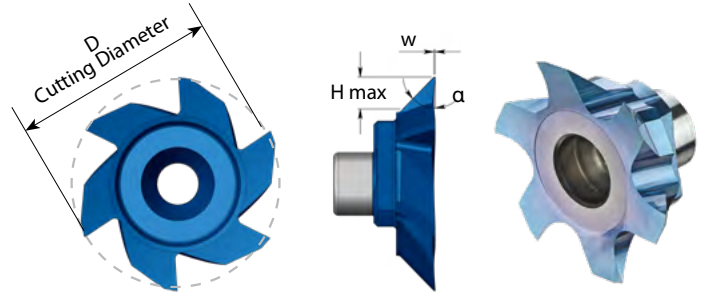
刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	切削刃宽 H max	端刃宽 W	倒角角度 α	槽数/刃数 No. of Flutes	刀杆型号 Holder Code*
S17	SC160 E H14	16.0	1.35	0.2	90°	5	H3, 3.1, 4, 5, 18, 19, 20
S20	SC170 E H14	17.0	1.35	0.2	90°	5	H6, 7, 8, 9, 21, 22, 23
	SC200 F H14	20.0	1.35	0.2	90°	6	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	SC200 F H24	20.0	2.35	0.2	90°	6	
	S35	SC350 F H42	35.0	4.20	0.2	90°	6
S20	SC200 F H20	20.0	1.95	1.0	90°	6	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	SC200 F H17	20.0	1.70	1.5	90°	6	
	SC200 F H15	20.0	1.50	2.0	90°	6	
	SC200 F H12	20.0	1.20	2.5	90°	6	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Dovetail 45°

Multi Flute

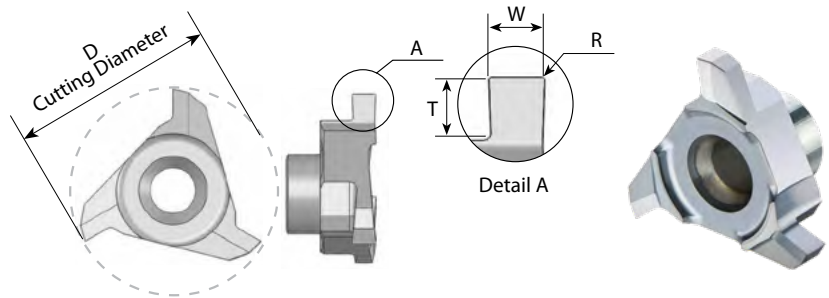
45° 燕尾槽铣刀
多槽/多刃



刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	切削刃宽 H	端刃宽 W	角度 α	槽数/刃数 No. of Flutes	刀杆型号 Holder Code*
S17	SC170 F A45	17.0	2.5	0.1	45°	6	H3, 3.1, 4, 5, 18, 19, 20
S20	SC200 F A45	20.0	3.0	0.1	45°	6	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23

Groove Milling

槽铣刀



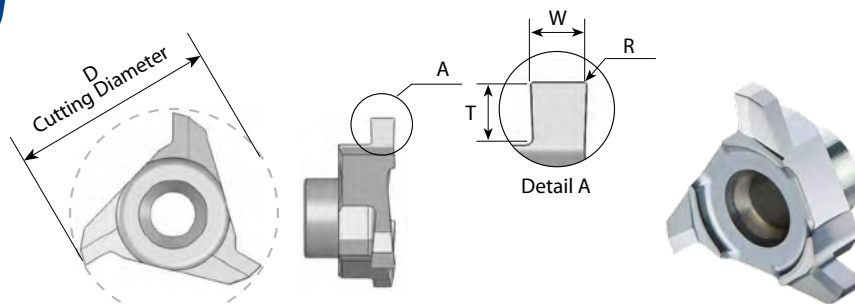
刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	槽宽 W ±0.02	切深 T max.	刀尖R R	最小槽径 Groove Dia. (min.)	刀杆型号 Holder Code*
C10	C10 W08	10.0	0.80	0.80	0.1	∅ > 10.0	H1, 1.1, 2, 15, 16, 17
	C10 W09	10.0	0.90	0.90	0.1	∅ > 10.0	
	C10 W10	10.0	1.00	0.90	0.1	∅ > 10.0	
	C10 W15	10.0	1.50	1.20	0.1	∅ > 10.0	
	C10 W20	10.0	2.00	1.20	0.1	∅ > 10.0	
C12	C12 W08	12.0	0.80	0.80	0.1	∅ > 12.0	H3, 3.1, 4, 5, 18, 19, 20
	C12 W10	12.0	1.00	0.90	0.1	∅ > 12.0	
	C12 W10T	12.3	1.00	1.60	0.2	∅ > 12.3	H3, 4, 5, 18, 20
	C12 W15	12.4	1.50	1.60	0.1	∅ > 12.4	
	C12 W20	12.4	2.00	1.60	0.1	∅ > 12.4	
	C12 W25	12.4	2.50	1.60	0.1	∅ > 12.4	
C18	C18 W10	17.8	1.00	1.50	0.1	∅ > 17.8	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	C18 W12	17.8	1.20	1.50	0.1	∅ > 17.8	
	C18 W15	17.8	1.50	1.95	0.1	∅ > 17.8	
	C18 W20	17.8	2.00	2.80	0.1	∅ > 17.8	H5.1, 5.2, 21
C25	C25 W20	25.0	2.00	3.00	0.2	∅ > 25.0	H10, 11, 24, 25
	C25 W25	25.0	2.50	3.00	0.2	∅ > 25.0	
	C25 W30	25.0	3.00	3.00	0.2	∅ > 25.0	
	C25 W35	25.0	3.50	3.50	0.2	∅ > 25.0	
	C25 W40	25.0	4.00	3.50	0.2	∅ > 25.0	
	C25 W50	25.0	5.00	3.50	0.2	∅ > 25.0	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Groove Milling

DIN 471/472

DIN 471/472 槽铣刀



标准槽宽

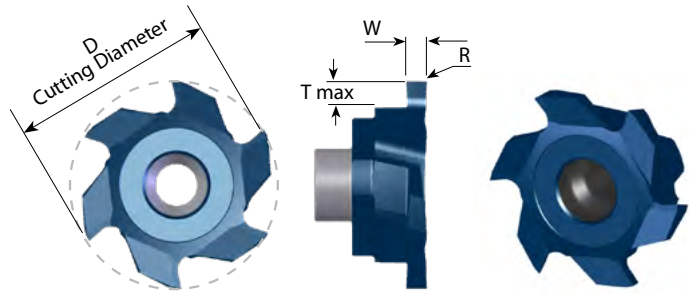
刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	Nom` groove width	槽宽 W -0.04	槽深 T max.	刀尖R R	最小槽径 Groove Dia. (min.)	刀杆型号 Holder Code*
C10	C10 W087	10.0	0.8	0.87	1.3	0	Ø > 10.0	H1, 2, 15, 17
	C10 W097	10.0	0.9	0.97	1.3	0	Ø > 10.0	
	C10 W121	10.0	1.10	1.21	1.3	0	Ø > 10.0	
	C10 W141	10.0	1.30	1.41	1.3	0.1	Ø > 10.0	
	C10 W171	10.0	1.60	1.71	1.3	0.1	Ø > 10.0	
C12	C12 W121	12.4	1.10	1.21	1.7	0	Ø > 12.4	H3, 4, 5, 18, 20
	C12 W141	12.4	1.30	1.41	1.7	0.1	Ø > 12.4	
	C12 W171	12.4	1.60	1.71	1.7	0.1	Ø > 12.4	
C18	C18 W121	17.8	1.10	1.21	2.9	0.1	Ø > 17.8	H5.1, 5.2, 21
	C18 W141	17.8	1.30	1.41	2.9	0.1	Ø > 17.8	
	C18 W171	17.8	1.60	1.71	2.9	0.1	Ø > 17.8	
	C18 W196	17.8	1.85	1.96	2.9	0.15	Ø > 17.8	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Groove Milling

Multi Flute

槽铣刀
多槽/多刃



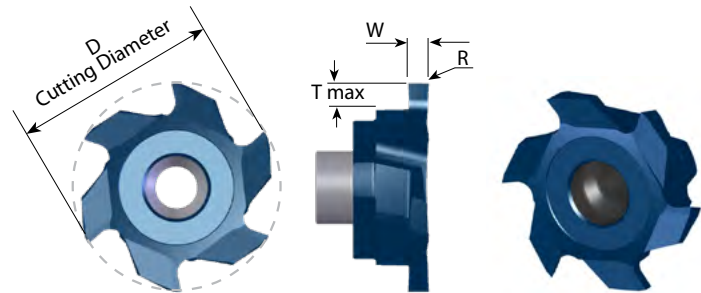
刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	槽宽 W ±0.02	槽深 T Max.	刀尖R R	最小槽径 Groove Dia. (min)	槽数/刃数 No. of Flutes	刀杆型号 Holder Code*
S17	SG170 F W15	17.0	1.5	2.8	0.2	∅ > 17	6	H3, 3.1, 4, 5, 18, 19, 20
	SG170 F W20	17.0	2.0	2.8	0.2	∅ > 17	6	
	SG170 F W25	17.0	2.5	2.8	0.2	∅ > 17	6	
S20	SG200 F W15	20.0	1.5	2.9	0.2	∅ > 20	6	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	SG200 F W20	20.0	2.0	2.9	0.2	∅ > 20	6	
	SG200 F W25	20.0	2.5	2.9	0.2	∅ > 20	6	
	SG200 F W30	20.0	3.0	2.9	0.2	∅ > 20	6	
	SG200 F W40	20.0	4.0	2.9	0.2	∅ > 20	6	
	SG200 F W49	20.0	4.9	2.9	0.2	∅ > 20	6	
S20	SG200 E W20T	20.0	2.0	3.7	0.2	∅ > 20	5	H5.1, 5.2, 21
	SG200 E W25T	20.0	2.5	3.7	0.2	∅ > 20	5	
	SG200 E W30T	20.0	3.0	3.7	0.2	∅ > 20	5	
S35	SG350 F W30T	35.0	3.0	6.3	0.2	∅ > 35	6	H12, 13, 14, 26
	SG350 F W40T	35.0	4.0	6.3	0.2	∅ > 35	6	
	SG350 F W50T	35.0	5.0	6.3	0.2	∅ > 35	6	
	SG350 F W60T	35.0	6.0	6.3	0.2	∅ > 35	6	
	SG350 F W80T	35.0	8.0	6.3	0.2	∅ > 35	6	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Groove Milling DIN 471/472 槽铣刀, 多槽/多刃

Multi Flute

DIN 471/472

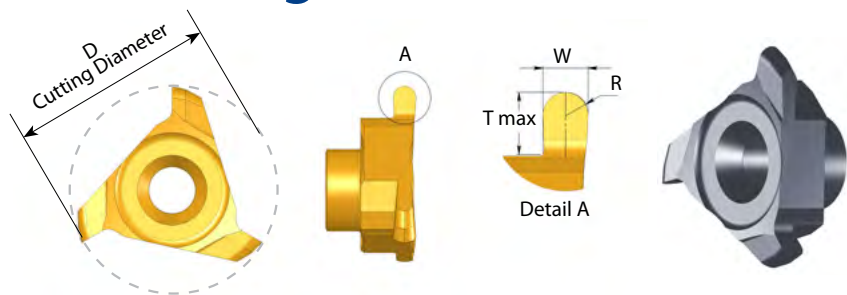


标准槽宽

刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	Nom` groove width	槽宽 W -0.04	槽深 T Max.	刀尖R R	最小槽径 Groove Dia. (min)	槽数/刃数 No. of Flutes	刀杆型号 Holder Code*
S20	SG200 F W121	20.0	1.10	1.21	4.0	0	Ø > 20	6	H5.1, 5.2, 21
	SG200 F W141	20.0	1.30	1.41	4.0	0.1	Ø > 20	6	
	SG200 F W171	20.0	1.60	1.71	4.0	0.1	Ø > 20	6	
	SG200 F W196	20.0	1.85	1.96	4.0	0.1	Ø > 20	6	

Full Radius Groove Milling

全尺寸 R 槽铣刀



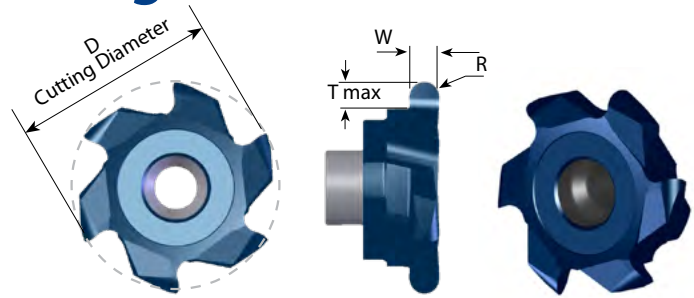
刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	R R	槽宽 W ±0.02	槽深 T Max.	最小槽径 Groove Dia. (min)	刀杆型号 Holder Code*
C12	C12 R11	12.4	1.1	2.2	1.7	Ø > 12.4	H3, 4, 5, 18, 20
C18	C18 R08	17.8	0.8	1.6	2.9	Ø > 17.8	H5.1, 5.2, 21
	C18 R11	17.8	1.1	2.2	2.9	Ø > 17.8	

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Full Radius Groove Milling

Multi Flute

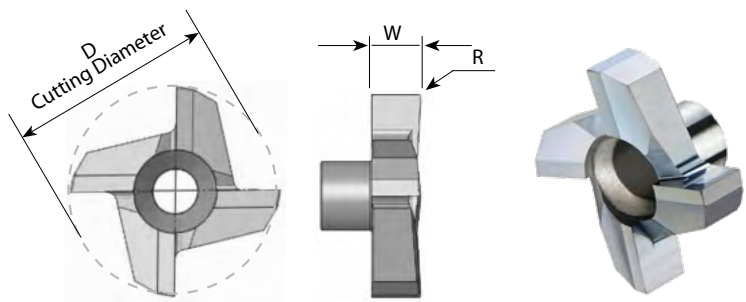
全尺寸 R 槽铣刀
多槽/多刃



刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	R R	槽宽 W ±0.02	槽深 T Max.	最小槽径 Groove Dia. (min)	槽数/刃数 No. of Flutes	刀杆型号 Holder Code*
S20	SG200 F R10	20.0	1.0	2.0	2.9	Ø > 20	6	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	SG200 F R12	20.0	1.2	2.4	2.9	Ø > 20	6	
	SG200 F R15	20.0	1.5	3.0	2.9	Ø > 20	6	
	SG200 F R20	20.0	2.0	4.0	2.9	Ø > 20	6	

Face Milling and Finishing

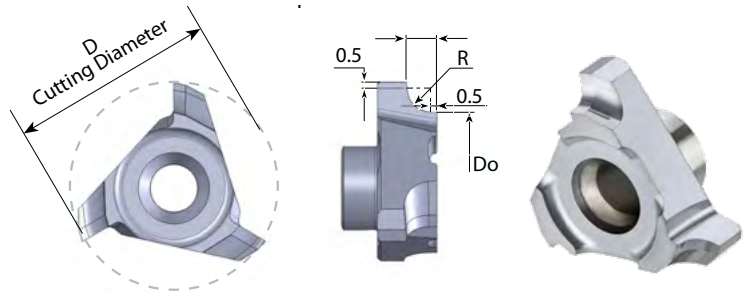
面铣刀和精铣刀



刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	刀片厚度 W ± 0.1	刀尖 R R	刀杆型号 Holder Code*
C10	C10 F R0.1	10	3.0	0.1	H1, 1.1, 2, 15, 16, 17
C12	C12 F R0.1	12	3.0	0.1	H3, 3.1, 4, 5, 18, 19, 20
C18	C18 F R0.1	17.8	5.0	0.1	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
C25	C25 F R0.2	25.0	6.0	0.2	H10, 11, 24, 25

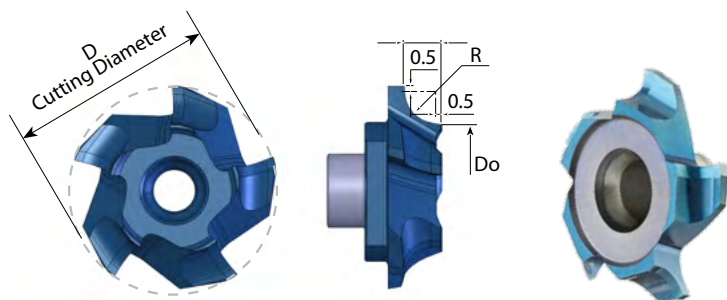
* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Corner Rounding 圆角铣刀



刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	边缘尺寸 Do	R R	有效范围 I	刀杆型号 Holder Code*
C10	C10 CR05	10.0	7.9	0.5	1.05	H1, 1.1, 2, 15, 16, 17
	C10 CR10	10.0	6.9	1.0	1.55	
C18	C18 CR13	17.8	14.2	1.25	1.80	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
	C18 CR15	17.8	13.7	1.5	2.05	
	C18 CR20	17.8	12.7	2.0	2.55	
C25	C25 CR30	25.0	17.7	3.0	3.60	H10, 11, 24, 25

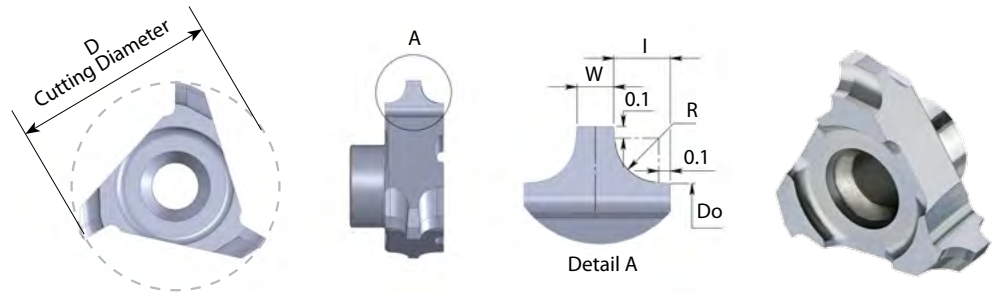
Corner Rounding 圆角铣刀 - 多槽/多刃 Multi Flute



刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	边缘尺寸 Do	R R	有效范围 I	槽数/刃数 No. of Flutes	刀杆型号 Holder Code*
S17	S170 E CR10	17.0	13.9	1.0	1.55	5	H3, 3.1, 4, 5, 18, 19, 20
	S170 E CR13	17.0	13.4	1.25	1.80	5	
	S170 E CR15	17.0	12.9	1.5	2.05	5	

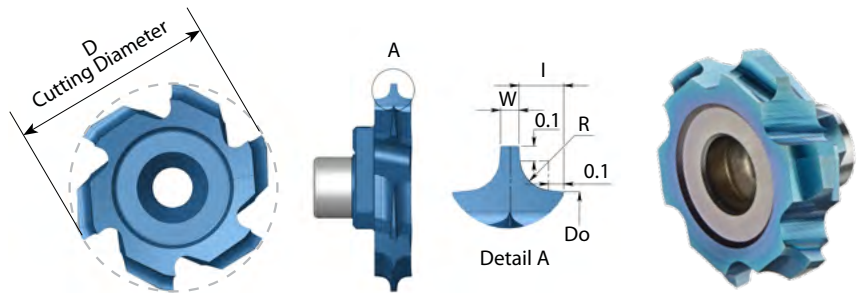
* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Front and Back Corner Rounding 前、后双面圆角铣刀



刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	边缘尺寸 Do	R R	端刀宽 W	有效刀刃 I	刀杆型号 Holder Code*
C10	C10 CRD08	10.0	8.2	0.8	1.2	0.90	H1, 1.1, 2, 15, 16, 17
C18	C18 CRD15	17.8	14.6	1.5	1.8	1.60	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23
C25	C25 CRD20	25.0	20.7	2.0	2.0	2.10	H10, 11, 24, 25

Front and Back Corner Rounding 前、后双面圆角铣刀 Multi Flute 多槽/多刃

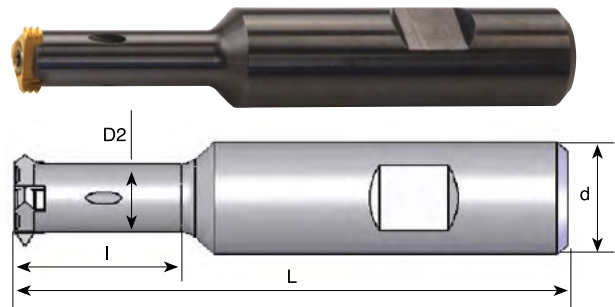


刀片型号 Insert Type	订货标识 Ordering Code	刀片直径 D	边缘尺寸 Do	R R	端刀宽度 W	有效刀刃 I	槽数/刃数 No. of Flutes	刀杆型号 Holder Code*
S17	S170 F CRD08	17.0	15.2	0.8	1.2	0.90	6	H3, 3.3, 4, 5, 18, 19, 20
S20	S200 F CRD15	20.0	16.8	1.5	1.8	1.60	6	H5.1, 5.2, 6, 7, 8, 9, 21, 22, 23

* For complete toolholder description see pages 23-24 全部刀杆说明见第23-24页

Steel Toolholders 钢制刀杆，带冷却孔

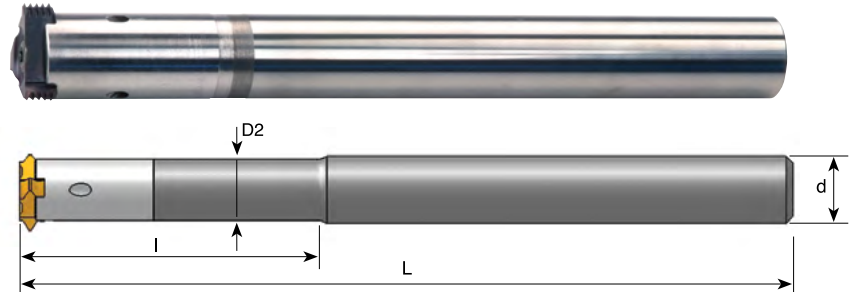
With internal coolant



刀杆型号 Tool No.	订货标识 Ordering Code	刀片型号 Insert Type	柄径 d	有效杆径 D2	有效长度 l	总长 L	刀片螺钉 Insert Screw	扭矩扳手 Torx Key
H1	SRC 1210 E	C10	12	7.3	19	70	S5	K5
H1.1	SRC 1210 F		12	8.0	25	80	S5	K5
H2	SRC 1610 G		16	7.3	19	90	S5	K5
H3	SRC 1212 E	C12, S17	12	9.0	25	70	S10	K10
H3.1	SRC 1212 G		12	10.0	40	90	S10	K10
H4	SRC 1612 G		16	9.0	25	90	S10	K10
H5	SRC 1612 H		16	9.0	35	100	S10	K10
H5.1	SRC 1618 F	C18, S20	16	12.0	25	80	S16	K16
H5.2	SRC 1618 G		16	12.0	40	90	S16	K16
H6	SRC 1618 H		16	13.8	48	100	S16	K16
H7	SRC 2018 H		20	13.8	32	100	S16	K16
H8	SRC 2018 J		20	13.8	48	110	S16	K16
H9	SRC 2018 L		20	13.8	74	140	S16	K16
H10	SRC 2525 J	C25	25	17.5	45	115	S27	K27
H11	SRC 2525 M		25	17.5	80	150	S27	K27
H12	SRC 2035 K	S35	20	22.0	44	130	S33	K33
H13	SRC 2535 H		25	22.0	40	100	S33	K33
H14	SRC 2535 K		25	22.0	60	130	S33	K33

Carbide Shank Toolholders **硬质合金刀杆，带冷却孔**

With internal coolant



刀杆型号 Tool No.	订货标识 Ordering Code	刀片型号 Insert Type	柄径 d	有效径 D2	有效长度 l	总长 L	刀片螺钉 Insert Screw	扭矩扳手 Torx Key
H15	CRC 0810 L35 K	C10	8	7.3	35	125	S5	K5
H16	CRC 0810 K		8	8.0	---	125	S5	K5
H17	CRC 1010 L45 M		10	7.3	45	150	S5	K5
H18	CRC 1012 L40 M	C12, S17	10	9.0	40	150	S10	K10
H19	CRC 1012 M		10	10.0	---	150	S10	K10
H20	CRC 1212 L57 P		12	9.0	57	165	S10	K10
H21	CRC 1218 P	C18, S20	12	12.0	---	170	S16	K16
H22	CRC 1618 L48 R		16	13.8	48	195	S16	K16
H23	CRC 1618 L74 R		16	13.8	74	195	S16	K16
H24	CRC 1625 R	C25	16	17.5	28	205	S27	K27
H25	CRC 2025 L85 S		20	17.5	85	250	S27	K27
H26	CRC 2035 S		S35	20	22.0	37	260	S33

Toolholders without Weldon **刀杆没有削平柄**

CMT Multi Insert Milling Cutters

CMT 多刀片铣切削

CMT indexable milling inserts and cutters for Grooving, Chamfering and Threading

CMT 可转位铣刀片和刀盘，用于铣槽、倒角和螺纹



Inserts 刀片

- Insert profiles are fully ground 刀片外形全部磨制
- Spiral inserts for smooth cutting operation 螺旋刀片可平稳加工
- Three cutting edges on each insert 每个刀片3个切削刃
- For a wide range of materials and applications 适合宽范围材料

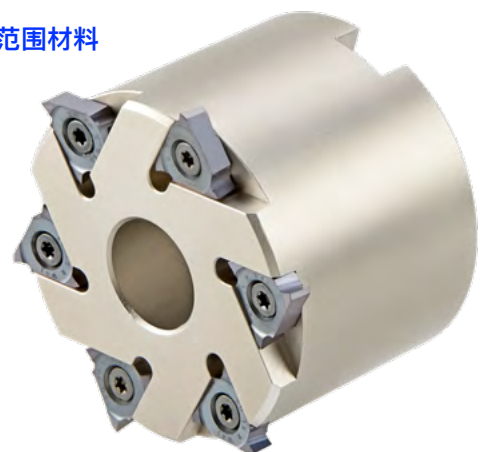
Carbide grade: MT7 硬质合金材质 MT7

Milling cutters / Disc milling cutter

套式铣刀/盘片式刀盘

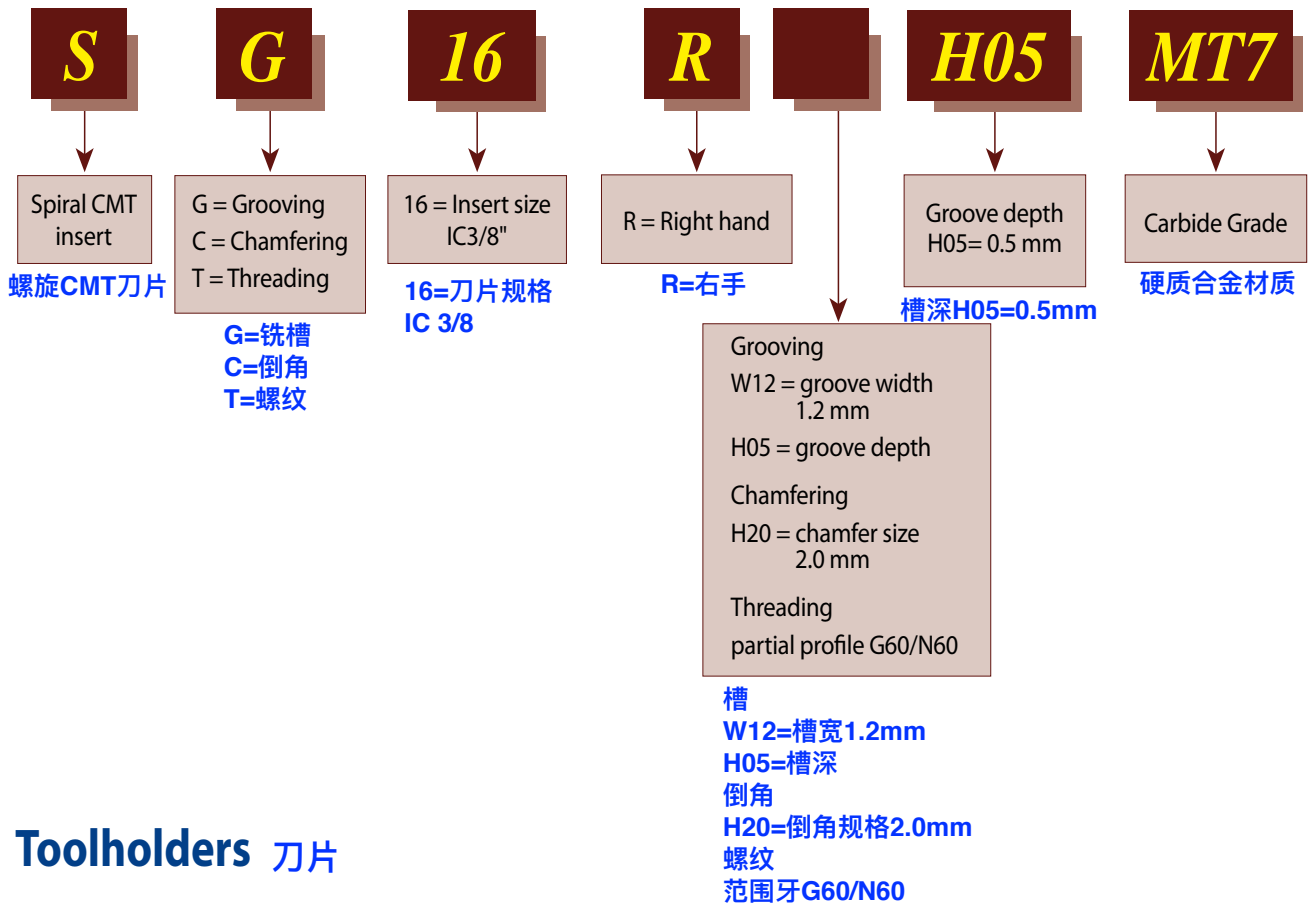
- 4 - 8 inserts per holder, for high productivity
- For use with Carmex standard CMT S35 toolholders
- The milling cutters are coated with a special layer (silver color) for high anti-corrosive resistance and extra protection against cutting burrs

- 1、刀杆或刀片安装4-8个刀片，高效率生产。
- 2、使用Carmex标准 CMT S35刀杆。
- 3、这个铣刀带一个银色涂层，高耐磨蚀、耐磨损和特别的防切削毛刺。

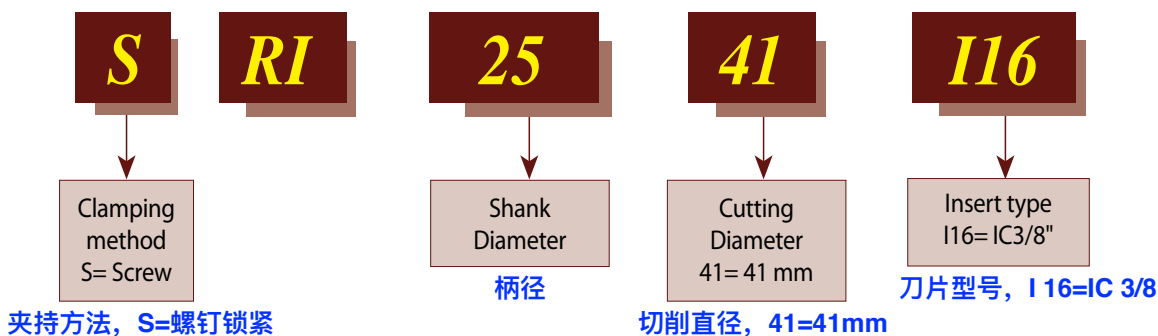


Product Identification - Ordering Codes 产品标识-订货标识

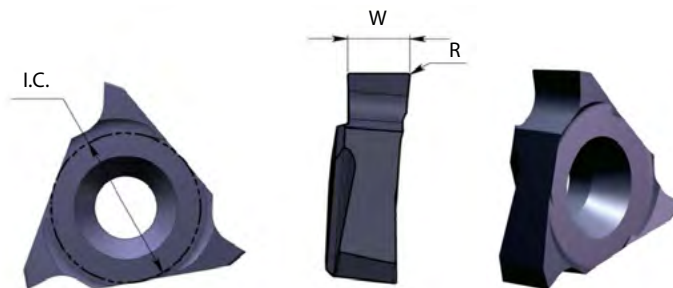
Inserts 刀片



Toolholders 刀片



Groove Milling 槽铣



DIN 471 / 472

刀片型号 Insert Type	内切圆 I.C.	订货标识 Ordering Code	槽宽 W	刀尖R R	刀杆型号 Holder Code*
SI16	3/8"	SG 16 R W14	1.40	0.10	H27, 28, 29
		SG 16 R W17	1.70	0.10	
		SG 16 R W19	1.95	0.15	
		SG 16 R W22	2.25	0.15	
		SG 16 R W27	2.75	0.20	
		SG 16 R W32	3.25	0.20	
		SG 16 R W42	4.25	0.20	H27, 29, 30
		SG 16 R W43	4.35	0.20	

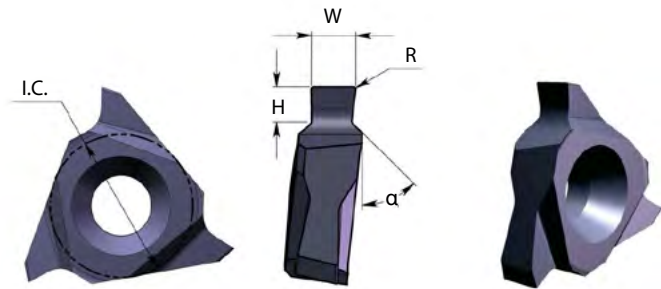
Right hand cutting 右手切削

刀片型号 Insert Type	内切圆 I.C.	订货标识 Ordering Code	槽宽 W	刀尖R R	刀杆型号 Holder Code*
SI16	3/8"	SG 16 L W43	4.35	0.20	H30

Left hand cutting 左手切削

*Maximum groove depth (T max) according to the toolholder. 最大槽深取决于刀杆

Groove Milling with Chamfer 槽铣包括倒角

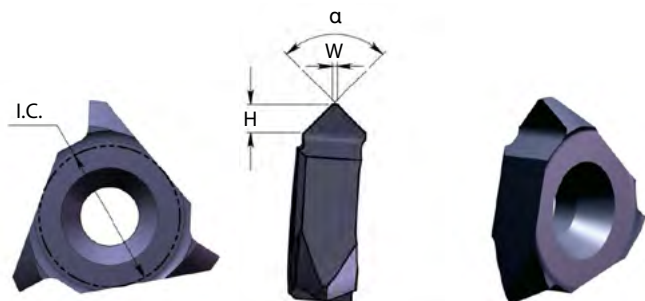


DIN 471 / 472

刀片型号 Insert Type	内切圆 I.C.	订货标识 Ordering Code	槽宽 W	最大槽深 H max	刀尖R R	倒角角度 α	刀杆型号 Holder Code*
SI16	3/8"	SG 16 R W12 H05	1.20	0.50	0.10	45°	H27, 28, 29
		SG 16 R W14 H07	1.40	0.70			
		SG 16 R W14 H08	1.40	0.85			
		SG 16 R W17 H08	1.70	0.85			
		SG 16 R W17 H10	1.70	1.00			
		SG 16 R W19 H12	1.95	1.25	0.15		
		SG 16 R W22 H15	2.25	1.50			
		SG 16 R W27 H15	2.75	1.50			
		SG 16 R W27 H17	2.75	1.75			
		SG 16 R W32 H17	3.25	1.75			
		SG 16 R W42 H20	4.25	2.00			
SG 16 R W42 H25	4.25	2.50					

Right hand cutting 右手切削

Chamfering 倒角



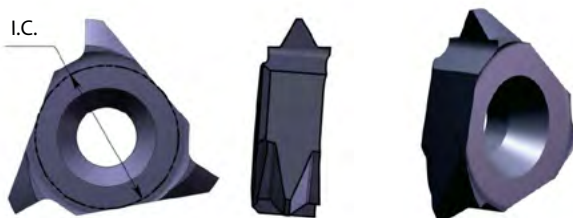
刀片型号 Insert Type	内切圆 I.C.	订货标识 Ordering Code	切削刃宽 H max	端刃宽 W	倒角角度 α	刀杆型号 Holder Code*
SI16	3/8"	SC 16 R H20	2.00	0.2	90°	H27, 28, 29
		SC 16 R H19	1.90	0.5		

Right hand cutting 右手切削

* For complete toolholder description see pages 30-31 全部刀杆说明见第30-31页

Partial Profile 60° - ISO, UN 60°范围牙-ISO/UN通用

Same Insert for internal and external thread 相同刀片可用于内或外螺纹



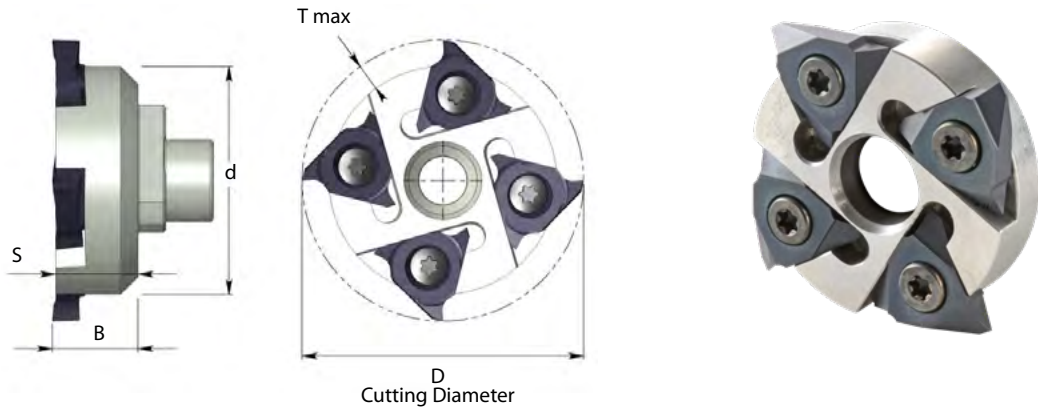
刀片型号 Insert Type	内切圆 I.C.	订货标识 Ordering Code	螺距范围 Pitch Range mm	牙数范围 Pitch Range TPI	刀杆型号 Holder Code*
SI16	3/8"	ST 16 R G60	Int. 1.5-3.0	Int. 16-8	H27, 28, 29
			Ex. 1.25-3.0	Ex. 20-8	
		ST 16 R N60	Int. 3.5-5.0	Int. 7-5	
			Ex. 3.0-4.5	Ex. 8-6	

Right hand cutting 右手切削

* For complete toolholder description see pages 30-31 全部刀杆说明见第30-31页

Toolholders 刀杆

Milling Cutter- Arbor 盘式铣刀架



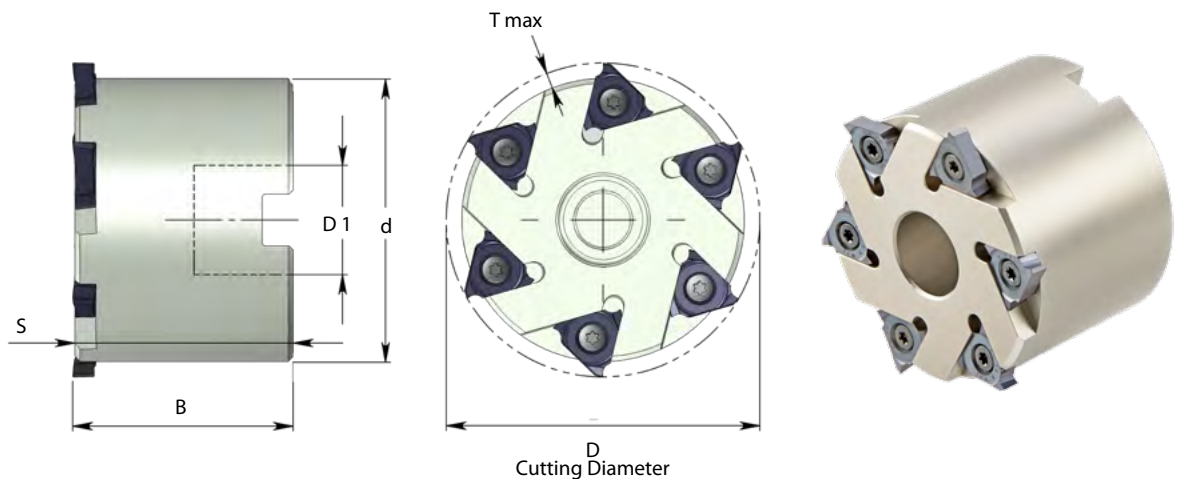
刀杆型号 Tool No.	订货标识 Ordering Code	刀片型号 Insert type	铣刀直径 D	柄径 d	最大切深 T max	铣刀厚度 B	刀盘厚度 S	刀片螺钉 Insert Screw	扭矩扳手 Torx Key
H27	SRI 41- I16	SI16	41	33.2	3.6	12.5	12.0	S16S	K16

Right hand cutting 右手切削

To connect to the standard CMT toolholders S35: SRC 2035 K, SRC 2535 H, SRC 2535 K, CRC 2035 S

连接标准CMT刀杆 S35: SRC 2035K, SRC 2535 H, SRC 2535 K, CRC 2035 S

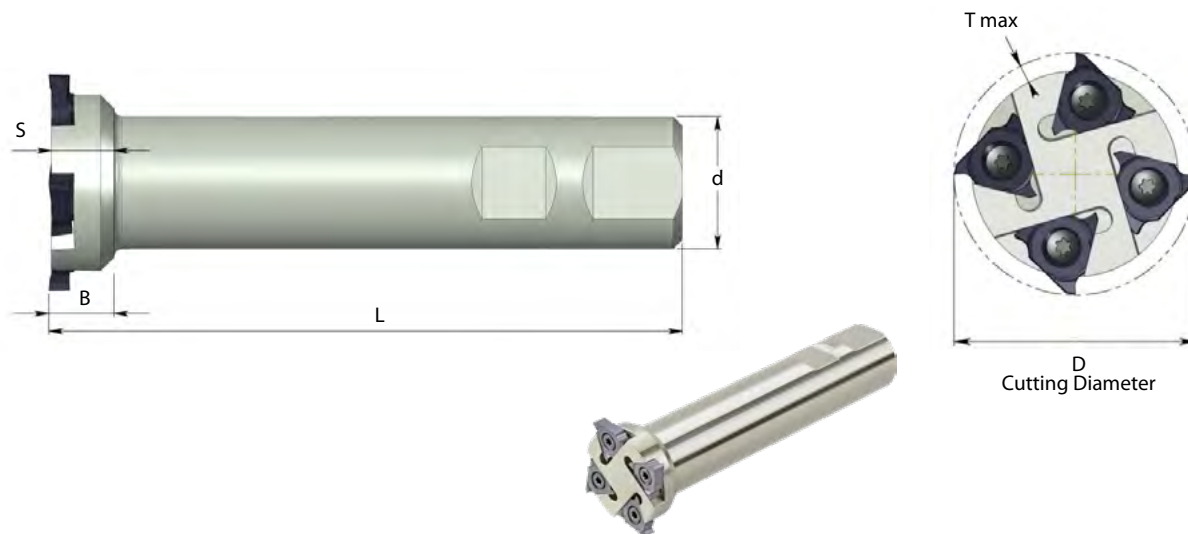
Milling Cutter- Shell Mill 套式铣刀架



刀杆型号 Tool No.	订货标识 Ordering Code	刀片型号 Insert type	铣刀直径 D	刀盘直径 d	最大切深 T max	铣刀厚度 B	刀盘厚度 S	刀柄轴径 D1	刀片螺钉 Insert Screw	扭矩扳手 Torx Key
H28	SRI 0063-I16	SI16	63	57	3.0	44.5	44.0	22	S16S	K16

Right hand cutting 右手切削

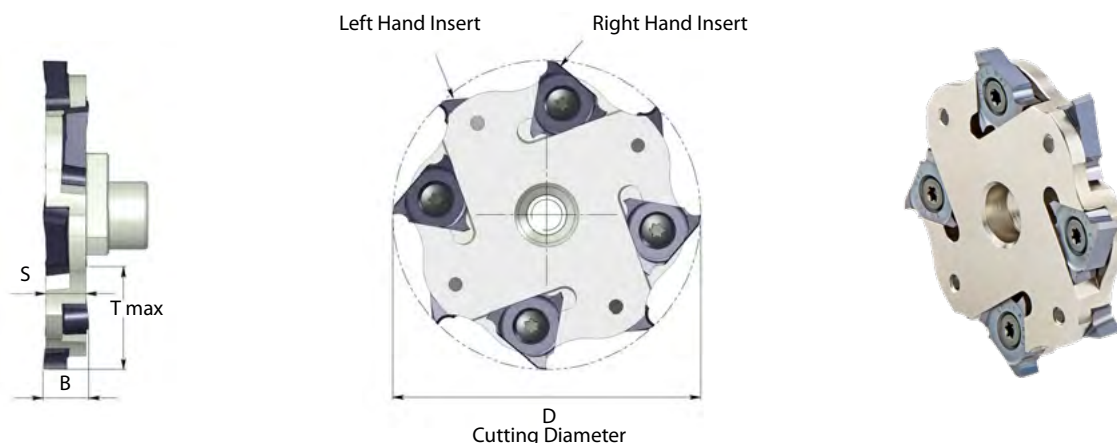
Milling Cutter- Weldon Shank 削平柄铣刀



刀杆型号 Tool No.	订货标识 Ordering Code	刀片型号 Insert type	铣刀直径 D	柄径 d	最大切深 T max	铣刀厚度 B	刀盘厚度 S	刀杆总长 L	刀片螺钉 Insert Screw	扭矩扳手 Torx Key
H29	SRI 2541-I16	SI16	41	25	3.6	12.5	12.0	125	S16S	K16

Right hand cutting 右手切削

Milling Cutter - Disc Milling 盘片式铣刀盘



刀杆型号 Tool No.	订货标识 Ordering Code	刀片型号 Insert type	铣刀直径 D	最大切深 T max	铣刀厚度 B	刀盘厚度 S	刀片螺钉 Insert Screw	扭矩扳手 Torx Key
H30	SRI 55-I16	SI16	55	15.5	8.2	7.2	S16M	K16

Right hand cutting 右手切削

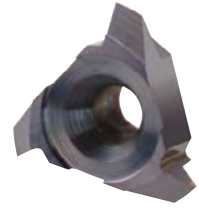
To use only with inserts SG 16 R W43, and SG 16 L W43 只能与刀片SG 16 R W43和SG 16 L W43一起使用

To connect to the standard CMT toolholders S35: SRC 2035 K, SRC 2535 H, SRC 2535 K, CRC 2035 S

连接标准CMT刀杆 S35: SRC 2035K, SRC 2535 H, SRC 2535 K, CRC 2035 S

Technical Section 技术说明部分

CMT type CMT系列



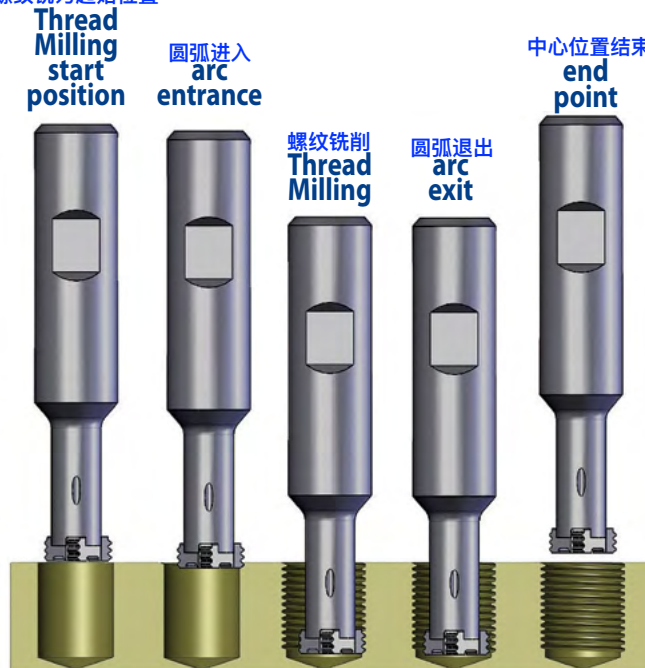
MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

MT7 亚微粒级钛铝氮多层涂层 (K10-K20)。通用材质，能用于所有材料；在中、高切削速度。

Cutting Data 切削参数

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

螺纹铣刀起始位置



CMT螺旋槽、多槽/多刃刀片

CMT Spiral Multi Flute Inserts



MT8 Sub-Micron Grade with Aluminum Titanium Nitride (AlTiN) multi-layer coating (ISO K10-K20).

Extremely high heat resistant and smooth cutting operation, for high performance, and normal machining conditions. General purpose for all materials.

MT8 亚微粒级，铝钛氮 (AlTiN) 多层涂层 (K 10-K 20)。高耐热和平稳切削，用于高效率 and 标准加工。通用所有材料。

Cutting Data 切削参数

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



CMT Milling cutter CMT铣切削

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

MT7 亚微粒级钛铝氮多层涂层 (K10-K20)。通用材质，能用于所有材料；在中、高切削速度。

Cutting Data 切削参数

标 ISO 准 Standard	材料 Material	切削速度: m/min Cutting Speed m/min	Feed 每齿进给 mm/tooth
P 钢	Low and Medium Carbon Steels <0.55%C 低碳钢和中碳钢, 碳含量小于0.55%	60-120	0.05-0.15
	High Carbon Steels ≥0.55%C 高碳钢, 碳含量大于0.55%	60-90	0.05-0.10
	Alloy Steels, Treated Steels 合金钢、热处理钢	50-80	0.05-0.10
M 不锈钢	Stainless Steel-Free Cutting 易切不锈钢	70-100	0.04-0.13
	Stainless Steel-Austenitic 奥氏体不锈钢	60-90	0.04-0.10
	Cast Steels 铸造不锈钢	70-90	0.04-0.13
K 铸铁	Cast Iron 铸铁	40-80	0.05-0.15
N 非铁金属	Aluminum ≤12%Si, Copper 硅含量小于12%铝, 铜	100-200	0.05-0.25
	Aluminum >12%Si 硅含量大于12%铝 合成纤维 硬塑料	60-140	0.03-0.10
	Synthetics, Duroplastics, Thermoplastics 热塑料	50-200	0.05-0.25
高温 S 合金	Nickel alloys, Titanium Alloys. 镍基合金、铁合金	20-40	0.03-0.10
H 硬钢	Hardened Steel, ≤ 45 HRc 硬钢小于HRC45	60-70	0.03-0.10

