



新产品 - 迷你螺旋槽螺纹铣刀



© Copyright CARMEX Precision Tools Ltd. 2015

CARMEX MINI SPIRAL MT NEWS 05/2015



Mini Spiral Mill-Thread New Products



Hacharoshet St. 1, Maalot Industrial Zone 2101302, ISRAEL
Tel: (972) 4-9077400, Fax: (972) 4-9077440.
E-mail: info@carmex.com Website: www.carmex.com
Postal address: P.O. Box 404, Maalot 2101302, ISRAEL.

Metric 2015

Carmex presents the new members of the Spiral Mill-Thread product line.

Carmex开发出螺纹铣削新成员 – 螺旋式螺纹铣刀

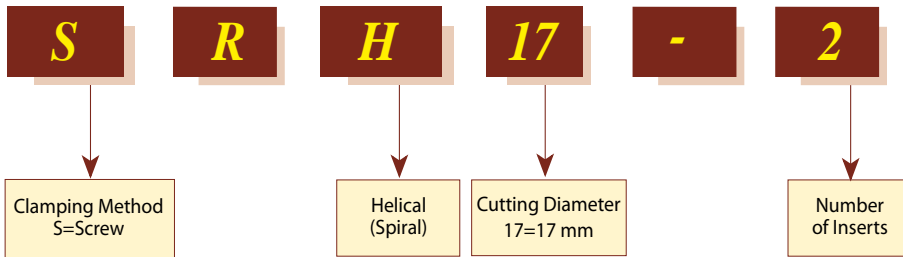
- Spiral fluted toolholders hold 1 to 3 inserts. 螺旋槽刀杆安装1-3个螺纹铣刀片
- Comparatively small cutting diameters. 相对比较小的切削直径
- Toolholders with internal coolant bore. 刀杆带内冷孔
- Smooth cutting operation at a high feed rate. 平滑的高进给率操作
- Reduced machining time. 减少加工时间
- Spiral design reduces vibrations and chatter. 螺旋设计减少振动和颤动
- High grade surface finish. 高表面精加工
- Inserts are available in MT7 Sub-Micron grade with TiAlN multi-layer coating.

亚微粒级MT7带TiAlN涂层

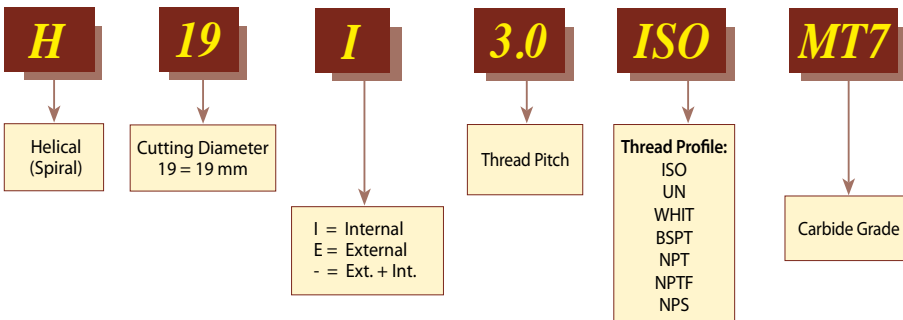
Product Identification

Ordering Codes

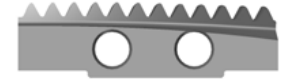
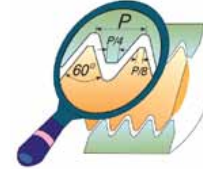
Toolholders



Inserts

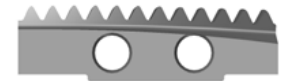
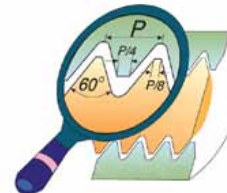


Inserts ISO



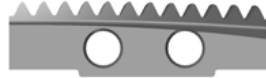
Insert Size	Pitch mm	M coarse	M fine	Ordering code	Toolholder
H13	1.0		≥ 15	H13 1.0 ISO	SRH 13 - 1
	1.5		≥ 16	H13 1.5 ISO	
	2.0	M16	≥ 16	H13 2.0 ISO	
H15	1.0		≥ 17	H15 1.0 ISO	SRH 15 - 1
	1.5		≥ 17	H15 1.5 ISO	
	2.0		≥ 18	H15 2.0 ISO	
	2.5	M18		H15 2.5 ISO	
H17	1.0		≥ 19	H17 1.0 ISO	SRH 17 - 2
	1.5		≥ 19	H17 1.5 ISO	
	2.0		≥ 20	H17 2.0 ISO	
	2.5	M20, M22		H17 2.5 ISO	
H19	2.0		≥ 22	H19 2.0 ISO	SRH 19 - 3
	3.0	M24, M27		H19 3.0 ISO	

UN 美制UN



Insert Size	Pitch TPI	UN	UNC	UNF	UNS	Ordering code	Toolholder
H13	16	5/8, 11/16				H13 16 UN	SRH 13 - 1
	14				5/8	H13 14 UN	
	12	11/16				H13 12 UN	
H15	16			3/4		H15 16 UN	SRH 15 - 1
	14				3/4	H15 14 UN	
	12	3/4, 13/16				H15 12 UN	
	10				7/8, 1	H15 10 UN	
H17	16	13/16				H17 16 UN	SRH 17 - 2
	14			7/8, 1		H17 14 UN	
	12	7/8				H17 12 UN	
	9		7/8			H17 9 UN	
H19	12	15/16		1		H19 12 UN	SRH 19 - 3
	8	11/16, 11/8	1			H19 8 UN	

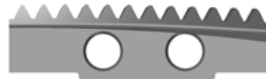
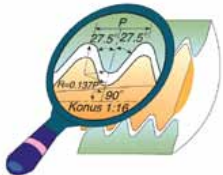
BSP (G) 英制BSP(G)螺纹



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	19	G 3/8	H13- 19 W	SRH 13 - 1
H15	14	G 1/2	H15- 14 W	SRH 15 - 1
H17	14	G 1/2 - 5/8	H17- 14 W	SRH 17 - 2
	11	G ≥ 1"	H17- 11 W	
H19	14	G 3/4 - 7/8	H19- 14 W	SRH 19 - 3
	11	G ≥ 1"	H19- 11 W	

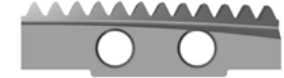
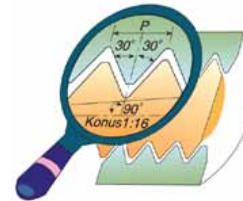
BSPT 英制BSPT锥管螺纹



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	19	3/8	H13- 19 BSPT	SRH 13 - 1
H15	14	1/2 - 3/4	H15- 14 BSPT	SRH 15 - 1
H17	14	1/2 - 3/4	H17- 14 BSPT	SRH 17 - 2

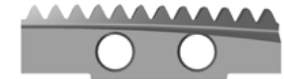
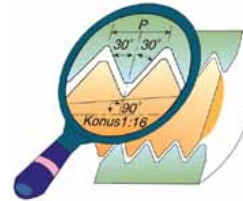
NPT 美制NPT锥管螺纹



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	18	3/8	H13- 18 NPT	SRH 13 - 1
H15	14	1/2 - 3/4	H15- 14 NPT	SRH 15 - 1
H17	14	1/2 - 3/4	H17- 14 NPT	SRH 17 - 2

NPTF 美制NPTF自密封锥管螺纹



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	18	3/8	H13- 18 NPTF	SRH 13 - 1
H15	14	1/2 - 3/4	H15- 14 NPTF	SRH 15 - 1
H17	14	1/2 - 3/4	H17- 14 NPTF	SRH 17 - 2

NPS 美制NPS圆柱平行管螺纹

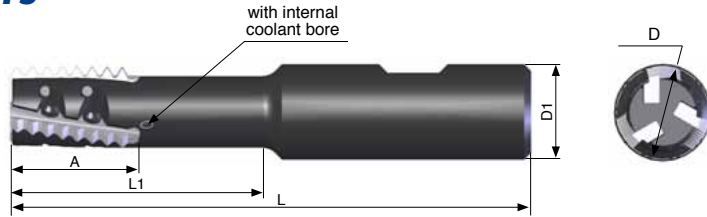


Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	18	3/8	H13- 18 NPS	SRH 13 - 1
H15	14	1/2 - 3/4	H15- 14 NPS	SRH 15 - 1
H17	14	1/2 - 3/4	H17- 14 NPS	SRH 17 - 2

Toolholders

刀杆



Ordering Code	Insert Type	Insert size A	D	D1	L	L1	No. of Inserts	Screw	Key
SRH13-1	H13	27	13	20	90	35	1	S13	K11
SRH15-1	H15	27	15	20	95	40	1	S15	K11
* SRH17-2	H17	27	17	20	85	30	2	S17	K11
* SRH17J-2	H17	27	17	20	100	45	2	S17	K11
SRH19-3	H19	27	19	20	85	30	3	S19	K11
SRH19J-3	H19	27	19	20	110	55	3	S19	K11

* When using NPT, NPTF, BSPT inserts the cutting diameter D = 18 mm

Spiral Mill-Thread Inserts Speed and Feed Selection

螺旋螺纹铣刀片速度与进给选择

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

ISO	Materials	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels	145-360
	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
M	Stainless Steels	165-245
	Cast Steels	190-245
K	Cast Iron	100-220
N	Non-Ferrous and Aluminium	230-440
	Synthetics, Duroplastics, Thermoplastics	145-590
S	Nickel Alloys, Titanium Alloys	30-115

Recommended FEED RATE: 0.05 - 0.15 mm

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

For hard metals reduce cutting speed.