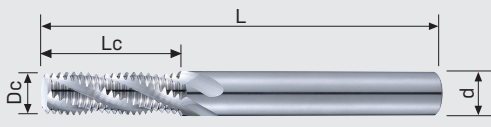






T783 超微粒鎢鋼微小徑螺紋銑刀 / 超微粒鎢鋼內冷螺紋銑刀

Micro Thread Mills / Oil-Feed Thread Mills

| ISO Metric Standard Thread. | | ISO公制標準螺紋 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|-----------------|--|-----|--|------|--|-----|--|---------------|--|---|--|---|--|---|--|---|--|---|--|---|--|--|--|--|--|--|--|
|  | | | | | | | | | | | | | | | |  | |  | |  | |  | | | | | | | |
| VHM Carbide | | Uncoated Bright | | 30° | | 3~5Z | | 78° | | Aluminium | | N | | N | | N | | N | | | | | | | | | | | |
| Suitable for cutting in different Aluminium materials. | | | | | | | | | | 適用切削於各種鋁合金材料。 | | | | | | | | | | | | | | | | | | | |

Standard Length

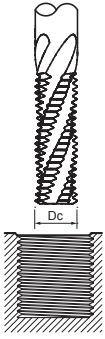

| Thread | | Pitch | Dc | Lc | L1 | L | d | t | Zt | T783 Bright | T783 Bright | | | | |
|-----------|--------------|-------|------|------|------|----|----|----|----|-------------|-------------|--|--|--|--|
| Coarse | Fine | mm | mm | mm | mm | mm | h6 | mm | | | | | | | |
| M1×0.25 | | 0.25 | 0.72 | 0.25 | 2.8 | 50 | 4 | 3 | 1 | ● | | | | | |
| M1.2×0.25 | | 0.25 | 0.91 | 0.25 | 3.3 | 50 | 4 | 3 | 1 | ● | | | | | |
| M1.4×0.3 | | 0.3 | 1.05 | 0.3 | 3.8 | 50 | 4 | 3 | 1 | ● | | | | | |
| M1.6×0.35 | | 0.35 | 1.2 | 0.35 | 4.3 | 50 | 4 | 3 | 1 | ● | | | | | |
| M1.8×0.35 | | 0.35 | 1.3 | 0.35 | 4.8 | 50 | 4 | 3 | 1 | ● | | | | | |
| M2×0.4 | | 0.4 | 1.5 | 1.2 | 4.5 | 50 | 4 | 3 | 3 | | ● | | | | |
| M2.5×0.45 | | 0.45 | 1.9 | 1.4 | 5.6 | 50 | 4 | 3 | 3 | | ● | | | | |
| M3×0.5 | M3.5~M16×0.5 | 0.5 | 2.4 | 1.5 | 6.5 | 50 | 4 | 3 | 3 | | ● | | | | |
| M4×0.7 | | 0.7 | 3.1 | 2.1 | 8.7 | 50 | 6 | 3 | 3 | | ● | | | | |
| M5×0.8 | | 0.8 | 4 | 2.4 | 10.8 | 50 | 6 | 3 | 3 | | ● | | | | |

Standard Length

| Thread | | Pitch | Dc | Lc | L1 | L | d | t | | | T783 Bright | T783 Bright | | | |
|----------|------|-------|-----|------|----|-----|----|----|--|--|-------------|-------------|--|--|--|
| Coarse | Fine | mm | mm | mm | mm | mm | h6 | mm | | | | | | | |
| M6×1 | | 1 | 4.5 | 13 | 15 | 60 | 6 | 4 | | | ● | | | | |
| M8×1.25 | | 1.25 | 6 | 17.8 | — | 65 | 6 | 4 | | | ● | | | | |
| M10×1.5 | | 1.5 | 7.5 | 22.5 | 25 | 70 | 8 | 4 | | | ● | | | | |
| M12×1.75 | | 1.75 | 9.5 | 26.3 | 27 | 80 | 10 | 5 | | | | ● | | | |
| M14×2 | | 2 | 10 | 30 | — | 90 | 10 | 5 | | | | ● | | | |
| M16×2 | | 2 | 12 | 34 | — | 100 | 12 | 5 | | | | ● | | | |
| M20×2.5 | | 2.5 | 16 | 42.5 | — | 110 | 16 | 5 | | | | ● | | | |

切削條件

Cutting Conditions

| | | | | | |
|---------------------------|---|---|-----------------------------|--------------------------|----------|
| T783 |  |  | | | |
| | cutting speed Vc (m/min) | feed per tooth fz(mm) | cutting speed Vc (m/min) | feed per tooth fz(mm) | |
| Aluminium Steel Materials | | | | | |
| N | GRI0-1 Wrought Aluminium alloys | 200 | 0.016xDc | 60 | 0.01xDc |
| | GRI0-2 Aluminium cast alloys <10% | 150 | 0.014xDc | 50 | 0.008xDc |
| | GRI0-3 Aluminium cast alloys >10% | 150 | 0.012xDc | 40 | 0.005xDc |

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location

1. Please work with good rigidity / high precision facilities and collet chuck.
 2. Please choose proper cutting fluid.
 3. The cutting data is reference value only. Please adjust it according to your real working conditions.
 4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
 5. If vibration occurs during cutting, please reduce cutting parameter.
1. 請使用剛性好、精度高的設備和夾具。
 2. 請選擇適用於工件材料的切削液。
 3. 此切削條件表中的數值為切削條件的基準值，實際加工時，請考慮加工形狀、目的、使用機台等因素，對切削條件進行調整。
 4. 如果機台轉速低於表中所列數值，則進給速度應與轉速按同一比例降低。
 5. 切削加工時如果發生振顫，請降低切削條件。