

T781HX 超微粒鎢鋼塗層微小徑螺紋銑刀 / 超微粒鎢鋼塗層內冷螺紋銑刀

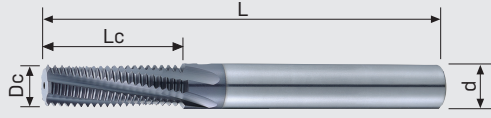
Micro Thread Mills / Oil-Feed Thread Mills

ISO Metric Standard Thread

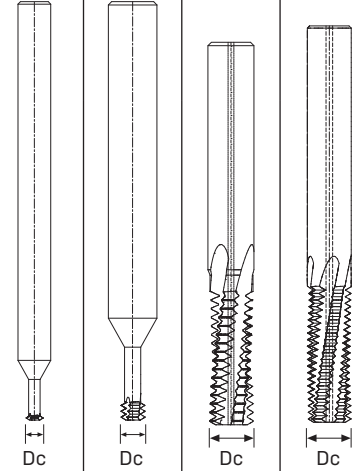
ISO公制標準螺紋

Good wear resistance effect with Nano multilayer coating.

採用奈米多層膜塗層具有優異的耐磨性。



VHM Carbide
AlTiCrN HX
11°
3~5Z
γ8°
Steel <48HRC



Suitable for carbon steel, below 48HRC hardened steel, stainless steel, cast iron...etc.

適用切削於碳鋼、48HRC以下硬化鋼、不銹鋼、鑄鐵...等各種材料。

P	P	P	P
H	H	H	H
M	M	M	M
K	K	K	K

Standard Length

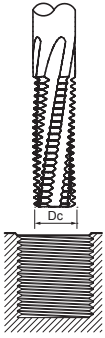

Thread	Pitch	Dc	Lc	Ll	L	d	t	Zt	T781HX AlTiCrN	T781HX AlTiCrN				
M1×0.25	0.25	0.72	0.25	2.8	50	4	3	1	●					
M1.2×0.25	0.25	0.91	0.25	3.3	50	4	3	1	●					
M1.4×0.3	0.3	1.05	0.3	3.8	50	4	3	1	●					
M1.6×0.35	0.35	1.2	0.35	4.3	50	4	3	1	●					
M1.8×0.35	0.35	1.3	0.35	4.8	50	4	3	1	●					
M2×0.4	0.4	1.5	1.2	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	Ll	L	d	t			T781HX AlTiCrN	T781HX AlTiCrN			
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

T781HX					
	cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)	
Carbon Steel Materials					
P	GR1 Carbon Steel	120	0.016xDc	40	0.006xDc
	GR2 <24HRC Low-alloyed Steel	100	0.016xDc	30	0.005xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.016xDc	20	0.005xDc
Hardened Steel Materials					
H	GR4 30-38HRC Hardened Steel	90	0.01xDc	10	0.003xDc
	GR5 38-48HRC Hardened Steel	80	0.01xDc	10	0.003xDc
Stainless Steel Materials					
M	GR8-1 Ferritic、Martensitic	70	0.01xDc	20	0.004xDc
	GR8-2 Austenitic	60	0.01xDc	20	0.003xDc
	GR8-3 Austenitic-ferritic	50	0.01xDc	20	0.003xDc
	GR8-4 Austenitic-ferritic Heat-resistant	40	0.01xDc	20	0.003xDc
Cast Iron Materials					
K	GR9-1 Grey cast iron	110	0.016xDc	40	0.006xDc
	GR9-2 Nodular cast iron	120	0.016xDc	30	0.006xDc

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。