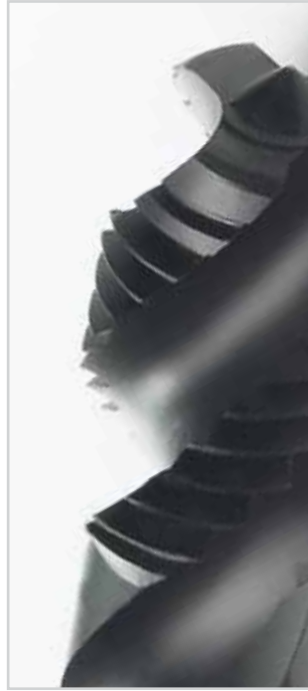


The Right Tool at the Right Time



多用途丝锥

用于不锈钢和难加工材料

特性和优点

材料

采用高等级的钴高速钢 (HSS-E) 制造，其优点是：

- 可提高硬度和韧性
- 可增加刀刃强度
- 可延长刀具寿命

表面处理

丝锥经蒸气回火 (ST) 或带 Super-B (TiAlN + WC/C) 涂层，再加上特别的刀刃处理，所以在加工大部分的不锈钢牌号时，都可确保优异的加工性能。这些丝锥不但拥有非常高的耐磨损性，还可防止切屑粘结在刀具上，这样就提高了生产率。

刀槽形状

可提供加工通孔的螺尖丝锥和加工盲孔的螺旋槽丝锥 (40° 螺旋角)。

螺纹类型

可提供公制粗牙、公制细牙和 G 螺纹的丝锥。

较短的螺纹部分

螺旋槽丝锥的螺纹部分长度较短，故产生的扭矩较低，并可提高排屑性能，这意味着该丝锥能在更高的切削条件下工作。

丝锥的夹持

此丝锥系列可采用刚性攻丝夹头，或高质量的带拉伸和压缩补偿的夹头。

尺寸范围

公制粗牙系列

M3 - M10：符合 DIN 371 标准

≥ M12：符合 DIN 376 标准

- 螺旋槽 ST - E238，M3 至 M30
- 螺旋槽 Super B - E239，M3 至 M20
- 螺尖 ST - E240，M3 至 M30
- 螺尖 Super B - E241，M3 至 M20

公制细牙系列

符合 DIN 374 标准

- 螺旋槽 ST - E383，M6 x 0.75 至 M20 x 1.5
- 螺尖 ST - E384，M6 x 0.75 至 M20 x 1.5

G (BSP) 螺纹系列

符合 DIN 5156 标准

- 螺旋槽 ST - E382，1/8 至 1”



给客户带来的好处

- 由于对丝锥的材料和几何形状作了最优的组合，确保在加工时不容易产生粘屑现象，这样可提高加工性能，延长刀具寿命。
- 丝锥的几何形状可提供充足的容屑空间，可进行快速而流畅的排屑，故切屑堵塞现象几乎可以忽略不计，可进行不间断的攻丝加工。
- 丝锥的表面处理可提高耐磨性，防止切屑粘结。
- 可对范围广泛的不锈钢材料进行高性能的加工。
- E238 和 E240 还可与 A108 钻头组成非常适用的塑料盒套装组合刀具：

E238 - A108 : L114305

E240 - A108 : L114306

E239



E382



E241



E384



L114305



L114306



产品应用 材料分组

■ 性能优异

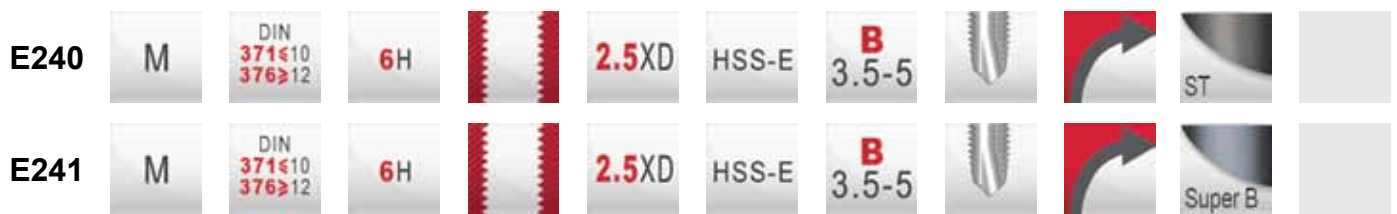
■ 性能良好

实例

10 = 外缘处的切削速度，米/分，+/- 10%

M	M	M	M	MF	MF	G	
DIN 3714:10 3749:12	DIN 3714:10 3749:12	DIN 3714:10 3749:12	DIN 3714:10 3749:12	DIN 374	DIN 374	DIN 5156	
6H	6H	6H	6H	6H	6H	Normal	
2.5XD	2.5XD	2XD	2XD	2.5XD	2XD	2XD	
HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	
B 3.5-5	B 3.5-5	C 2-3	C 2-3	B 3.5-5	C 2-3	C 2-3	
		$\lambda 40^\circ$	$\lambda 40^\circ$		$\lambda 40^\circ$	$\lambda 40^\circ$	
BT	Super B	BT	Super B	BT	BT	BT	
E240	E241	E238	E239	E384	E383	E382	L114
M3 - M30	M3 - M20	M3 - M30	M3 - M20	M6 - M20	M6 - M20	1/8 - 1"	Set
NEW	NEW	NEW	NEW	NEW	NEW	NEW	NEW

适用材料分组 (AMG)		硬度 HB	抗拉强度 N/mm2								ISO
1. 钢	1.1 铁磁性低碳钢	< 120	< 400								P
	1.2 结构钢, 表面渗碳钢	< 200	< 700								P
	1.3 普通碳钢	< 250	< 850								P
	1.4 合金钢	< 250	< 850		■32		■32				P
	1.5 合金钢, 淬火回火钢	> 250 < 350	> 850 < 1200	■10	■17	■10	■13	■10	■10	■10	P
	1.6 合金钢, 淬火回火钢	> 350	> 1200 < 1620	■5	■11	■5	■11	■5	■5	■5	P
	1.7 热处理合金钢	49-55 HRc	> 1620								H
	1.8 淬火合金钢, 耐磨钢	55-63 HRc	> 1980								H
2. 不锈钢	2.1 易切削不锈钢	< 250	< 850	■8	■14	■8	■14	■8	■8	■8	M
	2.2 奥氏体不锈钢	< 250	< 850	■7	■10	■7	■10	■7	■7	■7	M
	2.3 铁素体 + 奥氏体, 马氏体不锈钢	< 300	< 1000	■5	■6	■5	■6	■5	■5	■5	M
	2.4 沉淀硬化不锈钢	< 320 < 410	> 1100 < 4100								M
3. 铸铁	3.1 灰铸铁	> 150	> 500								K
	3.2 灰铸铁	> 150 ≤ 300	> 500 < 1000								K
	3.3 球墨铸铁, 可锻铸铁	< 200	< 700								K
	3.4 球墨铸铁, 可锻铸铁	> 200 < 300	> 700 < 1000								K
4. 钛	4.1 纯钛	< 200	< 700								S
	4.2 钛合金	< 270	< 900								S
	4.3 钛合金	> 270 < 350	> 900 ≤ 1250								S
5. 镍	5.1 纯镍	< 150	< 500								S
	5.2 镍合金	> 270	> 900								S
	5.3 镍合金	> 270 < 350	> 900 < 1200								S
6. 铜	6.1 紫铜	< 100	< 350								N
	6.2 β 黄铜, 青铜	< 200	< 700								N
	6.3 α 黄铜	< 200	< 700								N
	6.4 高强度青铜	< 470	< 1500								N
7. 铝 镁	7.1 纯铝, 纯镁	< 100	< 350								N
	7.2 铝合金, 硅含量 < 0.5%	< 150	< 500								N
	7.3 铝合金, 硅含量 > 0.5% < 10%	< 120	< 400								N
	7.4 铝合金, 硅含量 > 10% 晶须增强铝合金, 镁合金	< 120	< 400								N
8. 合成材料	8.1 热塑性塑料	---	---								O
	8.2 热固性塑料	---	---								O
	8.3 增强塑料	---	---								O
9. 硬质材料	9.1 金属陶瓷	< 550	< 1700								H
	10.1 标准石墨	---	< 100								O

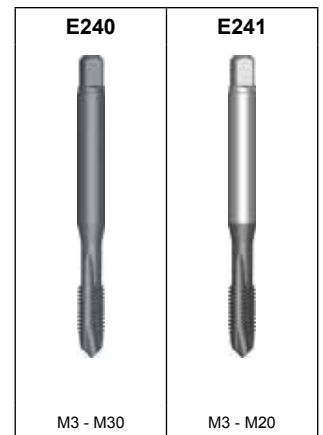
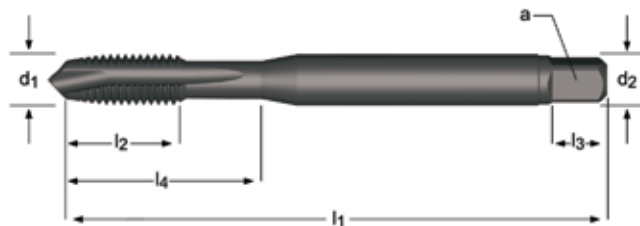


- M 机用螺尖丝锥
- M Tarauds machine Coupe gun
- M Maschinen-Gewindebohrer, geradegenutet mit Schälanschnitt
- M Macho Máquina Ponta Helicoidal
- M Machos de máquina Entrada en hélice
- M Machine Tap Spiral Point

E240

E241

E240	▪	2.1	2.2	2.3	
	▪	1.5	1.6		
E241	▪	2.1	2.2	2.3	
	▪	1.3	1.4	1.5	1.6



M	P mm	l ₁ mm	l ₂ mm	d ₂ ∅ mm	∠ a mm	l ₃ mm	z		l ₄ mm	E240	E241
3	0.50	56	9	3.5	2.7	6	3	2.5	18	E240M3	E241M3
4	0.70	63	12	4.5	3.4	6	3	3.3	21	E240M4	E241M4
5	0.80	70	13	6.0	4.9	8	3	4.2	25	E240M5	E241M5
6	1.00	80	15	6.0	4.9	8	3	5.0	30	E240M6	E241M6
8	1.25	90	18	8.0	6.2	9	3	6.8	35	E240M8	E241M8
10	1.50	100	20	10.0	8.0	11	3	8.5	39	E240M10	E241M10
12	1.75	110	23	9.0	7.0	10	4	10.3		E240M12	E241M12
14	2.00	110	25	11.0	9.0	12	4	12.0		E240M14	E241M14
16	2.00	110	25	12.0	9.0	12	4	14.0		E240M16	E241M16
18	2.50	125	30	14.0	11.0	14	4	15.5		E240M18	E241M18
20	2.50	140	30	16.0	12.0	15	4	17.5		E240M20	E241M20
22	2.50	140	34	18.0	14.5	17	4	19.5		E240M22	
24	3.00	160	38	18.0	14.5	17	4	21.0		E240M24	
27	3.00	160	38	20.0	16.0	19	4	24.0		E240M27	
30	3.50	180	45	22.0	18.0	21	4	26.5		E240M30	



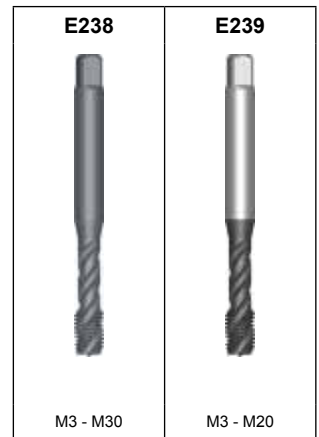
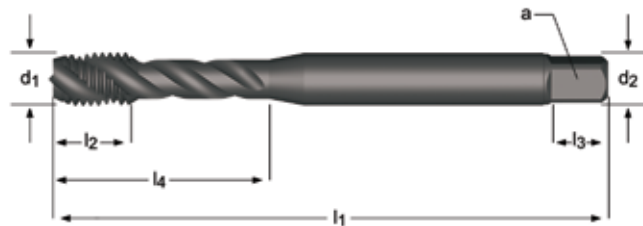
- M 机用 40° 螺旋槽丝锥
- M Tarauds machine goujures hélicoïdales 40°
- M Maschinen-Gewindebohrer, Rechtsgedallte Nuten 40°
- M Macho Máquina Canal Helicoidal 40°
- M Machos de máquina Estrías helicoidales a 40°
- M Machine Tap Spiral Flute 40°

E238

E239

E238 ■ 2.1 2.2 2.3
 ■ 1.5 1.6

E239 ■ 2.1 2.2 2.3
 ■ 1.3 1.4 1.5 1.6



M	P mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	□ a mm	l ₃ mm	z		l ₄ mm	E238	E239
3	0.50	56	6	3.5	2.7	6	3	2.5	18	E238M3	E239M3
4	0.70	63	7	4.5	3.4	6	3	3.3	21	E238M4	E239M4
5	0.80	70	8	6.0	4.9	8	3	4.2	25	E238M5	E239M5
6	1.00	80	10	6.0	4.9	8	3	5.0	30	E238M6	E239M6
8	1.25	90	13	8.0	6.2	9	3	6.8	33	E238M8	E239M8
10	1.50	100	15	10.0	8.0	11	3	8.5	39	E238M10	E239M10
12	1.75	110	18	9.0	7.0	10	4	10.3		E238M12	E239M12
14	2.00	110	20	11.0	9.0	12	4	12.0		E238M14	E239M14
16	2.00	110	20	12.0	9.0	12	4	14.0		E238M16	E239M16
18	2.50	125	25	14.0	11.0	14	4	15.5		E238M18	
20	2.50	140	25	16.0	12.0	15	4	17.5		E238M20	E239M20
22	2.50	140	25	18.0	14.5	17	4	19.8		E238M22	
24	3.00	160	30	18.0	14.5	17	4	21.0		E238M24	
27	3.00	160	30	20.0	16.0	19	4	24.0		E238M27	
30	3.50	180	36	22.0	18.0	21	4	26.5		E238M30	

E384

MF

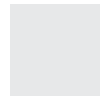
DIN
374

6H



2.5XD

HSS-E

B
3.5-5

- MF 机用螺旋丝锥
- MF Tarauts machine Coupe gun
- MF Maschinen-Gewindebohrer, geradegenutet mit Schälanschnitt
- MF Macho Máquina Ponta Helicoidal
- MF Machos de máquina Entrada en hélice
- MF Machine Tap Spiral Point

E384

E384


- 2.1 2.2 2.3
- 1.5 1.6



E384



M6 - M20

MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z		E384
6	0.75	80	15	4.5	3.4	6	3	5.3	E384M6X.75
8	1.00	90	18	6.0	4.9	8	3	7.0	E384M8X1.0
10	1.00	90	20	7.0	5.5	8	3	9.0	E384M10X1.0
10	1.25	100	20	7.0	5.5	8	3	8.8	E384M10X1.25
12	1.00	100	21	9.0	7.0	10	4	11.0	E384M12X1.0
12	1.25	100	21	9.0	7.0	10	4	10.8	E384M12X1.25
12	1.50	100	21	9.0	7.0	10	4	10.5	E384M12X1.5
14	1.50	100	21	11.0	9.0	12	4	12.5	E384M14X1.5
16	1.50	100	21	12.0	9.0	12	5	14.5	E384M16X1.5
18	1.50	110	24	14.0	11.0	14	5	16.5	E384M18X1.5
20	1.50	125	24	16.0	12.0	15	5	18.5	E384M20X1.5

E383

MF

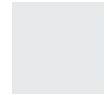
DIN
374

6H



2XD

HSS-E

C
2-3

- MF 机用 40° 螺旋槽丝锥
- MF Tarauts machine goujures hélicoidales 40°
- MF Maschinen-Gewindebohrer, Rechtsgedrallte Nuten 40°
- MF Macho Máquina Canal Helicoidal 40°
- MF Machos de máquina Estrías helicoidales a 40°
- MF Machine Tap Spiral Flute 40°

E383


E383 ■ 2.1 2.2 2.3
■ 1.5 1.6



E383



M6 - M20

MF	P mm	l_1 mm	l_2 mm	d_2 Ø mm	a mm	l_3 mm	z		E383
6	0.75	80	10	4.5	3.4	6	3	5.3	E383M6X.75
8	1.00	90	13	6.0	4.9	8	3	7.0	E383M8X1.0
10	1.00	90	12	7.0	5.5	8	3	9.0	E383M10X1.0
10	1.25	100	15	7.0	5.5	8	3	8.8	E383M10X1.25
12	1.00	100	13	9.0	7.0	10	4	11.0	E383M12X1.0
12	1.25	100	13	9.0	7.0	10	4	10.8	E383M12X1.25
12	1.50	100	13	9.0	7.0	10	4	10.5	E383M12X1.5
14	1.50	100	21	11.0	9.0	12	4	12.5	E383M14X1.5
16	1.50	100	21	12.0	9.0	12	5	14.5	E383M16X1.5
18	1.50	110	24	14.0	11.0	14	5	16.5	E383M18X1.5
20	1.50	125	24	16.0	12.0	15	5	18.5	E383M20X1.5

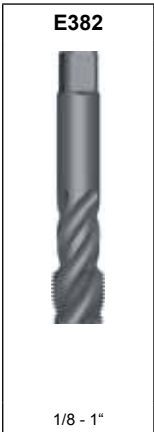
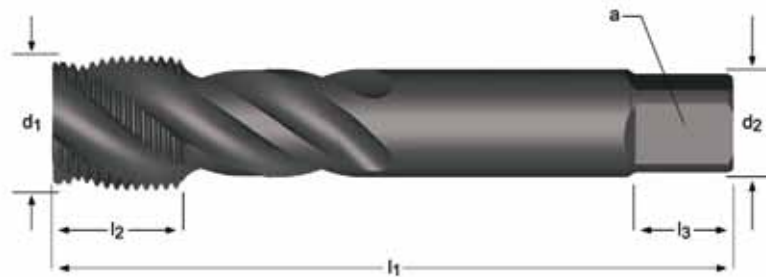
E382



- G(BSP) 机用 40° 螺旋槽丝锥
- G(BSP) Tarauts machine goujures hélicoidales 40°
- G(BSP) Maschinen-Gewindebohrer, Rechtsgedrallte Nuten 40°
- G(BSP) Macho Máquina Canal Helicoidal 40°
- G(BSP) Machos de máquina Estrías helicoidales a 40°
- G(BSP) Machine Tap Spiral Flute 40°

E382

- E382 ■ 2.1 2.2 2.3
 ■ 1.5 1.6



G(BSP)	TPI	d ₁ nom mm	l ₁ mm	l ₂ mm	d ₂ Ø mm	∠ a mm	l ₃ mm	z		E382
1/8	28	9.73	90	12	7.0	5.5	8	3	8.8	E3821/8
1/4	19	13.16	100	15	11.0	9.0	12	4	11.8	E3821/4
3/8	19	16.66	100	15	12.0	9.0	12	4	15.2	E3823/8
1/2	14	20.96	125	24	16.0	12.0	15	4	19.0	E3821/2
3/4	14	26.44	140	20	20.0	16.0	19	4	24.5	E3823/4
1"	11	33.25	160	24	25.0	20.0	23	4	30.7	E3821

L114

- DIN 标准套装钻头 and 丝锥
- DIN Jeu de forets-tarauds
- DIN Gewinde-Kernlochbohrer Set
- DIN Jogo de Broca + Macho
- DIN Juego de Broca-Macho
- DIN Tap-Drill set

A = 套件中的型号, M = 套件中的丝锥尺寸, D = 套件中的钻头直径
 A= modèle dans le coffret M=Diamètres des tarauds dans le coffret
 D= Diamètres des forets dans le coffret
 A=Typen in Satz, M=Gewindebohrer Durchmesser im Satz, D=Bohrer Durchmesser im Satz
 A=Família de produto no jogo, M=Diâmetro do Macho no Jogo, D=Diâmetro da Broca no Jogo
 A=Tipos en el juego, M=Machos diámetros en el Juego, D=Brocas diámetros en el Juego
 A=Styles in Set, M=Tap diameters in Set, D=Drill diameters in Set



				L114
Nr.	A	M	D	
Nr.305	E238 + A108	E238M3, E238M4, E238M5, E238M6, E238M8, E238M10, E238M12	A1082.5, A1083.3, A1084.2, A1085.0, A1086.8, A1088.5, A10810.2	L114305
Nr.306	E240 + A108	E240M3, E240M4, E240M5, E240M6, E240M8, E240M10, E240M12	A1082.5, A1083.3, A1084.2, A1085.0, A1086.8, A1088.5, A10810.2	L114306



The Right Tool at the Right Time



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