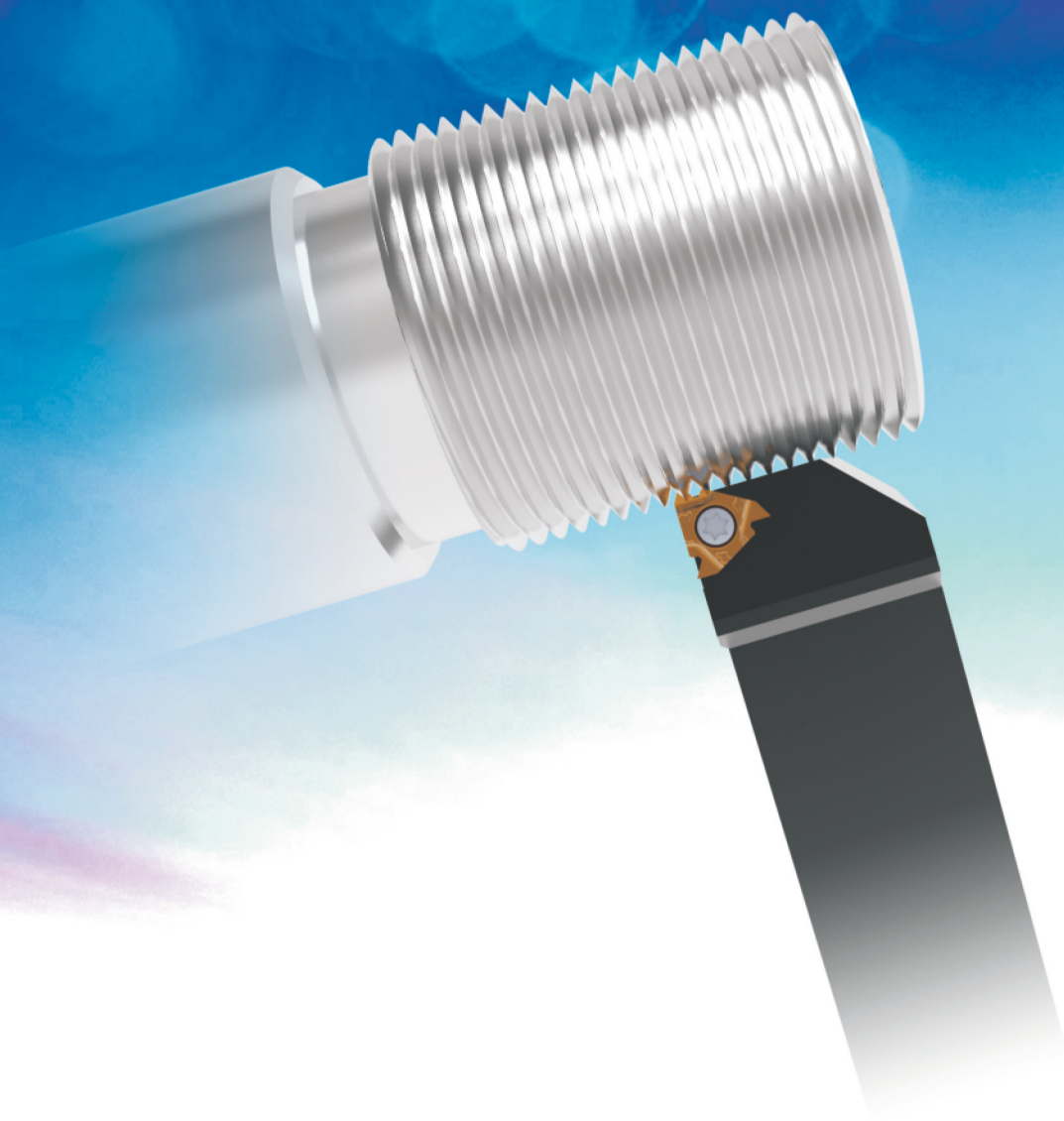


PULCUT[®]

螺纹车刀

Threading turning insert

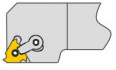


螺纹车刀型号编制规则 Naming System for Thread Tools

A

S	U	E	R	25	25	M	16
1	2	3	4	5	6	7	8

1 压紧方式Clamping

C	 压板压紧式 Top clamping
S	 螺钉压紧式 Screw

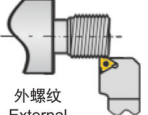
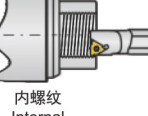
2 刀片形式 blade form

none:平装刀片Flat

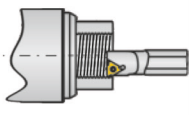
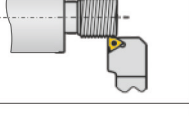
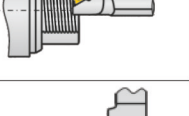
V:立装刀片Vertical

U:U形刀片 U type

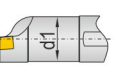

3 螺纹形式 Type

E	 外螺纹 External
I	 内螺纹 Internal

4 切削方向Cutting direction

R	内 Internal	
	外 External	
L	内 Internal	
	外 External	

5 刀尖高度Tool tip height

内 Internal	 内螺纹刀杆用00表示
外 External	 刀尖高度 Tool tip height

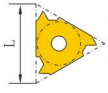
6 刀体宽度Insert width

内 Internal	 刀杆柄部直径 Tool shank diameter
外 External	 刀体宽度 Insert width

7 刀杆长度Tool rod length

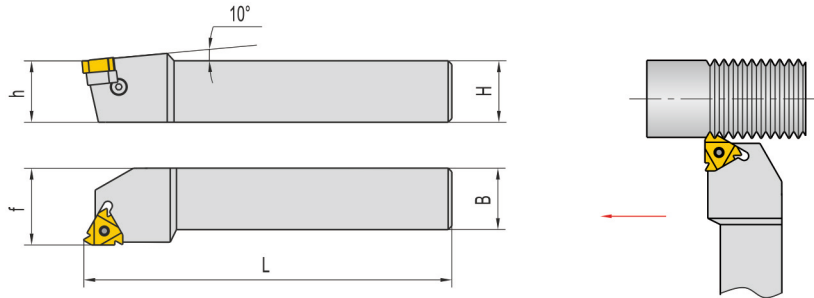
代号 Code	长度 Length
F	80
H	100
K	125
M	150
P	170
R	200

8 刀片尺寸Dimension

图例 Legend	代号 Code	三角形边长L Triangle side L	内切圆 Incircle
	08	4.76	8
	11	6.35	11
	16	9.525	16
	22	12.7	22
	27	15.875	27

螺钉压紧式外螺纹车刀杆 Screw clamping holder for external threading

A

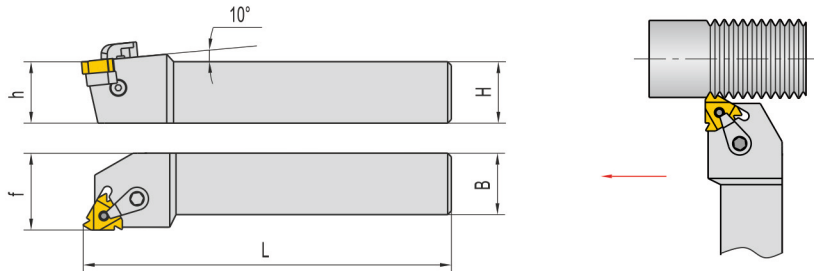


型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺寸(mm) Dimension					刀垫 Shim	刀片螺钉 Screw	刀垫螺钉 Shim screw	梅花板手 Ring spanner	板手 Wrench
右刀 Right hand	左刀 Left hand	R	L		h	L	H	B	f					
SER0808H11	SEL0808H11			11ER/L...	8	100	8	8	11	—	SC2.5	—	—	—
SER1010H11	SEL1010H11				10	100	10	10	11	—				
SER1212K11	SEL1212K11				12	125	12	12	12	—				
SER1212F16	SEL1212F16			16ER/L...	16	80	12	12	16	ANE/I16	SC3.5	M3*5	T15	S2.5
SER1616H16	SEL1616H16				16	100	16	16	16					
SER2020K16	SEL2020K16				20	125	20	20	20					
SER2525M16	SEL2525M16				25	150	25	25	25					
SER3232P16	SEL3232P16				32	170	32	32	32					
SER2525M22	SEL2525M22			22ER/L...	25	150	25	25	25	ANE/I22	SC4.0	M3*5	T15	S2.5
SER3232P22	SEL3232P22				32	170	32	32	32					
SER4040R22	SEL4040R22				40	200	40	40	40					
SER2525M27	SEL2525M27			27ER/L...	25	150	25	25	27	ANE/I27	SC6.0	M3*5	T15	S2.5
SER3232P27	SEL3232P27				32	170	32	32	32					
SER4040R27	SEL4040R27				40	200	40	40	40					

注：以上刀杆均有1.5°螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。

note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

压板压紧式外螺纹车刀杆 Press plate clamping holder for external threading

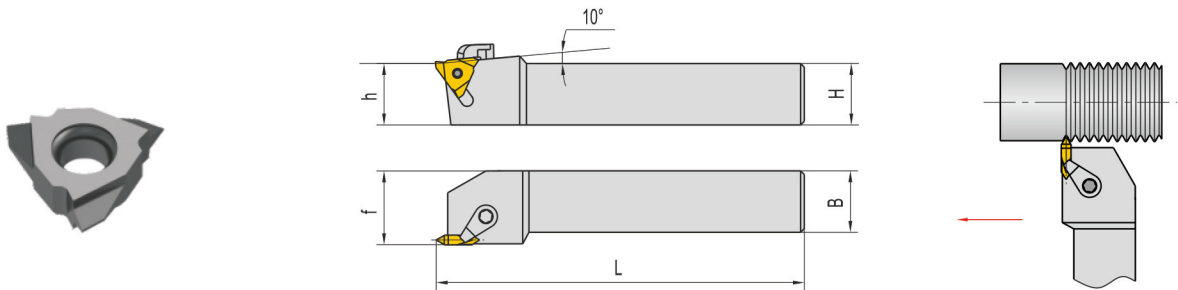


型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺寸(mm) Dimension					刀片螺钉 Screw	梅花板手 Ring spanner	刀垫 Shim	刀垫螺钉 Shim Screw	板手 Wrench	压板 Clamp
右刀 Right hand	左刀 Left hand	R	L		h	L	H	B	f						
CER1616H16	CEL1616H16			16ER/L...	16	100	16	16	16	SC3.5	T15	ANE/I16	—	—	CHP16
CER2020K16	CEL2020K16				20	125	20	20	20						
CER2525M16	CEL2525M16				25	150	25	25	25						
CER2525M22	CEL2525M22			22ER/L...	25	150	25	25	25	SC4.0	T15	ANE/I22	—	—	CHP22
CER3232P22	CEL3232P22				32	170	32	32	32						
SER4040R22	SEL4040R22				40	200	40	40	40						
SER2525M27	SEL2525M27			27ER/L...	25	150	25	25	27	SC6.0	T20	ANE/I27	—	—	CHP27
SER3232P27	SEL3232P27				32	170	32	32	32						
SER4040R27	SEL4040R27				40	200	40	40	40						

注：以上刀杆均有1.5°螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。

note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

立装式外螺纹车刀杆 Vertical holder for external threading

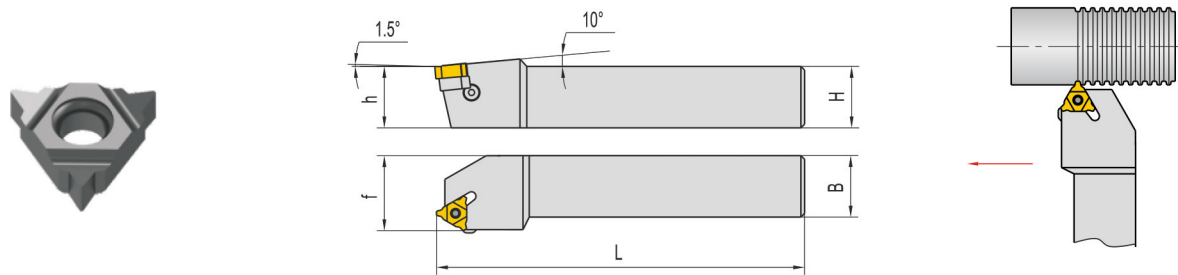


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型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺寸(mm) Dimension					刀片螺钉 Screw	梅花扳手 Ring spanner
右刀 Right hand	左刀 Left hand	R	L		h	L	H	B	f		
SVER1616H16	SVEL1616H16			16VER/L...	16	100	16	16	16	SC3.5	T15
SVER2020K16	SVEL2020K16				20	125	20	20	20		
SVER2525M16	SVEL2525M16				25	150	25	25	25		
SVER3232P16	SVEL3232P16				32	170	32	32	32		
SVER2525M22	SVEL2525M22			22VER/L...	25	150	25	25	25	SC4.0	T15
SVER3232P22	SVEL3232P22				32	170	32	32	32		
SVER4040R22	SVEL4040R22				40	200	40	40	40		
SVER2525M27	SVEL2525M27				25	150	25	25	27		
SVER3232P27	SVEL3232P27			27VER/L...	32	170	32	32	32	SC6.0	T20
SVER4040R27	SVEL4040R27				40	200	40	40	40		

注：以上刀杆均有1.5° 螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。
note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

螺钉压紧式U型外螺纹车刀杆 Screw clamping holder for U type external threading

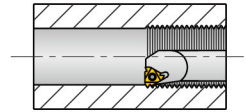
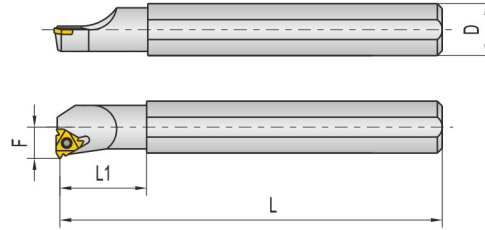
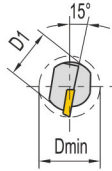


型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺寸(mm) Dimension					刀垫 Shim	刀片螺钉 Screw	梅花扳手 Ring spanner	螺钉 Screw	扳手 Wrench
右刀 Right hand	左刀 Left hand	R	L		h	L	H	B	f					
SUER2525P22	SUEL2525P22			22UER/L...	25	170	25	25	25	AUE/I/22	SC4.0	T15	M3*5	S2.5
SUER3232R22	SUEL3232R22				32	200	32	32	32					
SUER2525P27	SUEL2525P27				25	170	25	25	27					
SUER3232P27	SUEL3232P27				32	170	32	32	32					
SUER4040R27	SUEL4040R27			27UER/L...	40	200	40	40	40	AUE/I/27	SC6.0	T20	M3.5	S2.5

注：以上刀杆均有1.5° 螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。
note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

螺钉压紧式内螺纹车刀杆 Screw clamping holder for Internal threading

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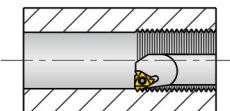
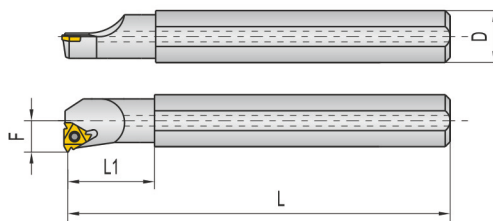
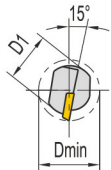


型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺寸(mm) Dimension						刀片螺钉 Screw	梅花扳手 Ring spanner	刀垫 Shim
右刀 Right hand	左刀 Left hand	R	L		D	DI	L	L1	F	Dmin			
SIR0007H08	SIL0007H08			08IR/L...	16	6.6	100	18	5.3	7.8	SC2.0	T6	—
SIR0010H11	SIL0010H11			11IR/L...	10	10	100	—	7.4	12	SC2.5	T8	—
SIR0010K11	SIL0010K11				16	10	125	25	7.4	12			—
SIR0013M11	SIL0013M11				16	13	150	32	8.9	15			—
SIR0013M16	SIL0013M16				16	13	150	32	10.2	16			—
SIR0016P16	SIL0016P16			16IR/L...	20	16	170	40	11.7	19	SC3.5	T15	ANI/E16
SIR0020P16	SIL0020P16				20	20	170	—	13.7	24			
SIR0025R16	SIL0025R16				25	25	200	—	16.2	29			
SIR0032S16	SIL0032S16				32	32	250	—	19.7	36			
SIR0040T16	SIL0040T16				40	40	300	—	23.7	44			
SIR0050W16	SIL0050W16				50	50	350	—	28.7	54			
SIR0020P22	SIL0020P22			22IR/L...	20	20	170	—	15.6	24	SC4.0	T15	—
SIR0025R22	SIL0025R22				25	25	200	—	18.1	29			ANI/E22
SIR0032S22	SIL0032S22				32	32	250	—	21.6	38			
SIR0040T22	SIL0040T22				40	40	300	—	25.6	46			
SIR0050W22	SIL0050W22				50	50	350	—	30.6	56			
SIR0032S27	SIL0032S27			27IR/L...	32	32	250	—	22.6	40	SC6.0	T20	ANI/E27
SIR0040T27	SIL0040T27				40	40	300	—	26.6	48			
SIR0050W27	SIL0050W27				50	50	350	—	31.6	58			

注：以上刀杆均有1.5°螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。

note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

螺钉压紧式内螺纹车刀杆（带内冷） Screw clamping holder (with inner-cooling) for Internal threading

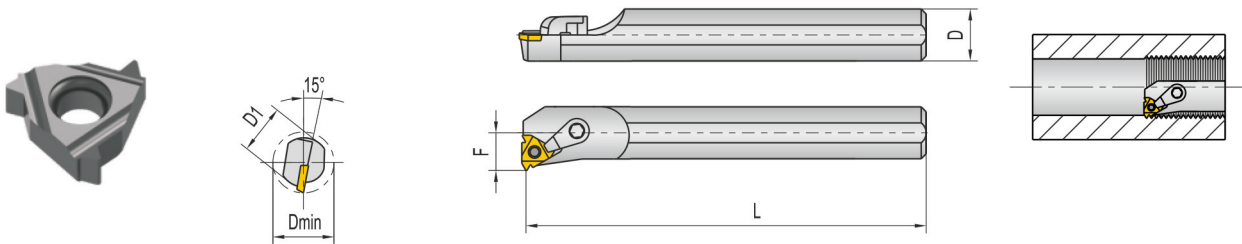


型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺寸(mm) Dimension						刀片螺钉 Screw	梅花扳手 Ring spanner	刀垫 Shim
右刀 Right hand	左刀 Left hand	R	L		D	DI	L	L1	F	Dmin			
SIR0010K11B	SIL0010K11B			11IR/L...	16	10	125	25	7.4	12	SC2.5	T8	—
SIR0013M16B	SIL0013M16B			16IR/L...	16	13	150	32	10.2	16			—
SIR0016P16B	SIL0016P16B				20	16	170	40	11.7	19			—
SIR0020P16B	SIL0020P16B				20	20	170	—	13.7	24	SC3.5	T15	ANI/E16
SIR0025R16B	SIL0025R16B				25	25	200	—	16.2	29			
SIR0032S16B	SIL0032S16B				32	32	250	—	19.7	36			
SIR0025R22B	SIL0025R22B			22IR/L...	25	25	200	—	18.1	29	SC4.0	T15	ANI/E22

注：以上刀杆均有1.5°螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。

note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

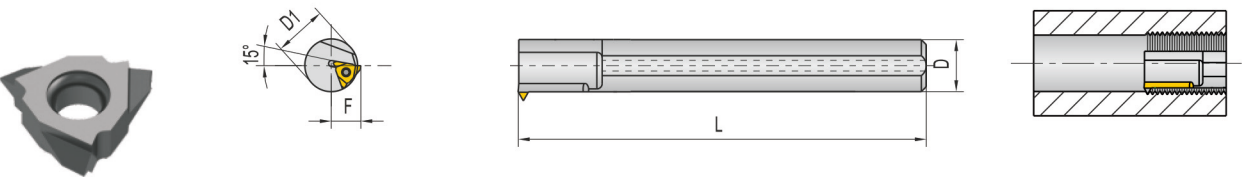
压板压紧式内螺纹车刀杆 Top clamping holder for Internal threading



型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺 寸(mm) Dimension						刀片螺钉 Screw	梅花板手 Ring spanner	刀垫 Shim	刀垫螺钉 Shim screw	板手 Wrench	压板 Clamp
右刀 Right hand	左刀 Left hand	R	L		D	DI	L	L1	F	Dmin						
CIR0020P16	CIR0020P16			16IR/L...	20	20	170	—	13.7	24	SC3.5	T15	—	—	—	CHP16
CIR0025R16	CIR0020P16				25	25	200	—	16.2	29						
CIR0032S16	CIR0020P16				32	32	250	—	19.7	36						
CIR0025R22	CIL0025R22			22IR/L...	25	25	200	—	18.1	29	SC4.0	T15	ANI/E22	—	—	CHP22
CIR0032S22	CIL0032S22				32	32	250	—	21.6	38						
CIR0040T22	CIL0040T22				40	40	300	—	25.6	46						
CIR0032S27	CIL0032S27			27IR/L...	32	32	250	—	22.6	40	SC6.0	T20	ANI/E27	—	—	CHP27
CIR0040T27	CIL0040T27				40	40	300	—	26.6	48						

注：以上刀杆均有1.5°螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。
note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

V型内螺纹车刀杆 V type holder for Internal threading



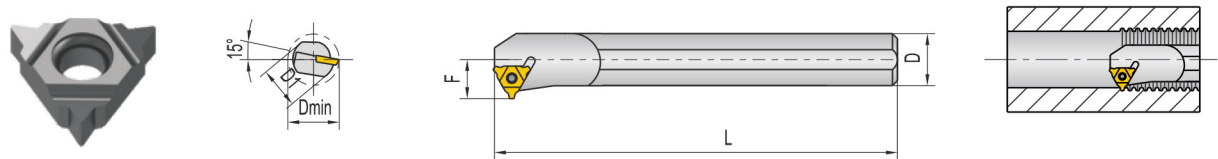
型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺 寸(mm) Dimension						刀片螺钉 Screw	梅花板手 Ring spanner
右刀 Right hand	左刀 Left hand	R	L		D	DI	L	L1	F	Dmin		
SVIR0040T27	SVIL0040T27			27VIR/L...	40	40	300	—	28.4		SC6.0	T20
SVIR0050W27	SVIL0050W27			27VIR/L...	50	50	350	—	33.4		SC6.0	
SVIR0060W27	SVIL0060W27			27VIR/L...	60	60	350	—	38		SC6.0	

注：以上刀杆均有1.5°螺旋角。
note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.



U型内螺纹刀杆 U Type holder for Internal threading

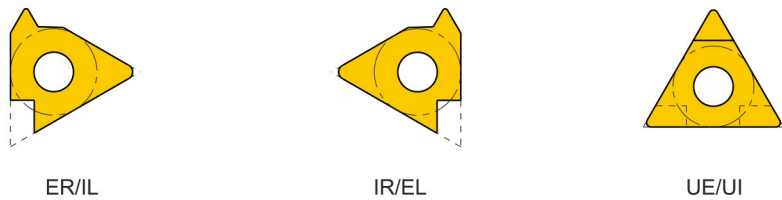
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型 号 Type		库存 Stock Item		适用刀片 Available inserts	尺寸(mm) Dimension						刀片螺钉 Screw	梅花扳手 Ring spanner	刀垫 Shim
右刀 Right hand	左刀 Left hand	R	L		D	DI	L	L1	F	Dmin			
SUIR0032S22	—			22UIR...	32	32	250	—	25.5	42	SC4.0	T15	AUI/E22
SUIR0040T22	—				40	40	300	—	29.5	51			
SUIR0032S27	—			27UIR...	32	32	250	—	24.7	42	SC6.0	T20	AUI/E27
SUIR0040T27	—				40	40	300	—	29.4	53			
SUIR0050W27	—				50	50	350	—	34.3	63			
SUIR0060W27	—				60	60	350	—	39.3	74			

注：以上刀杆均有1.5°螺旋角，请参考技术资料选择不同刀垫以形成不同的螺旋角。
note: All the tool holders above have a 1.5° helix angle, Please choose proper shim for different helix angle reference to the technical documents.

螺纹刀垫 Shim for threading inserts



刀片尺寸 Insert size		刀杆 Tool holder	刀垫编号 Shim Dimension							
IC.	L		$\beta = 4.5^\circ$	$\beta = 3.5^\circ$	$\beta = 2.5^\circ$	$\beta = 1.5^\circ$	$\beta = 0.5^\circ$	$\beta = -0.5^\circ$	$\beta = -1.5^\circ$	
3/8"	16	ER/IL16	ANE16-3P	ANE16-2P	ANE16-1P	ANE16	ANE16-1N	ANE16-2N	ANE16-3N	
		IR/EL16	ANI16-3P	ANI16-2P	ANI16-1P	ANI16	ANI16-1N	ANI16-2N	ANI16-3N	
1/2"	22	ER/IL22	ANE22-3P	ANE22-2P	ANE22-1P	ANE22	ANE22-1N	ANE22-2N	ANE22-3N	
		IR/EL22	ANI22-3P	ANI22-2P	ANI22-1P	ANI22	ANI22-1N	ANI22-2N	ANI22-3N	
		UE22	AUE22-3P	AUE22-2P	AUE22-1P	AUE22	AUE22-1N	AUE22-2N	AUE22-3N	
		UI22	AUI22-3P	AUI22-2P	AUI22-1P	AUI22	AUI22-1N	AUI22-2N	AUI22-3N	
5/8"	27	ER/IL27	ANE27-3P	ANE27-2P	ANE27-1P	ANE27	ANE27-1N	ANE27-2N	ANE27-3N	
		IR/EL27	ANI27-3P	ANI27-2P	ANI27-1P	ANI27	ANI27-1N	ANI27-2N	ANI27-3N	
		UE27	AUE27-3P	AUE27-2P	AUE27-1P	AUE27	AUE27-1N	AUE27-2N	AUE27-3N	
		UI27	AUI27-3P	AUI27-2P	AUI27-1P	AUI27	AUI27-1N	AUI27-2N	AUI27-3N	

