

鎢鋼銑牙刀 系列

Carbide Thread Mills Series

泛用鋼材 $\leq 50\text{HRC}$

不銹鋼

鋁合金 / 銅合金

鑄鐵

鈦合金

For general steel ($\leq 50\text{HRC}$), stainless steel, cast iron, aluminum/copper alloy and titanium alloy machining.



產品選擇表 Product Selection Table

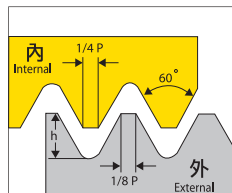
刀型 Type	刃數 Flute	型號 Model Number	產品類別 Product Classification	形狀 Appearance	尺寸 Size	頁數 Page
銑牙刀系列 Carbide Thread Mills						
多功能 鑽銑牙刀 Multipurpose Thread Cutter (Drill-Thread- Chamfer)	二刃 2 Flutes	CSHI200000-000A	內螺紋-ISO規格 -Internal-ISO		Ø5.0 ~ Ø10.3	182
	單刃 1 Flute	MSHIA100000-000A	內螺紋-ISO規格 -Internal-ISO		Ø0.60~Ø1.21	183
	二刃 2 Flutes	MSHIA200000-000A	內螺紋-ISO規格 -Internal-ISO		Ø1.55~Ø4.00	183
	三刃 3 Flutes	MSHIA300000-000A	內螺紋-ISO規格 -Internal-ISO		Ø4.85~Ø7.90	183
	一刃 1 Flute	MSHIDA100000-000A	內螺紋-ISO規格 -Internal-ISO		Ø0.60~Ø1.21	184
	二刃 2 Flutes	MSHIDA200000-000A	內螺紋-ISO規格 -Internal-ISO		Ø1.55~Ø4.00	184
	三刃 3 Flutes	MSHIDA300000-000A	內螺紋-ISO規格 -Internal-ISO		Ø4.85~Ø7.90	184
直刃銑牙刀 Thread Straight Flute	三刃 3 Flutes	CTSE300000-000A	外螺紋-ISO規格 -External-ISO		Ø5.9 ~ Ø7.9	185
	五刃 5 Flutes	CTSE500000-000A	外螺紋-ISO規格 -External-ISO		Ø9.9~Ø19.9	185
	三刃 3 Flutes	CTSI300000-000A	外/內螺紋-ISO規格 -External-Internal-ISO		Ø3.0 ~ Ø7.9	186
	五刃 5 Flutes	CTSI500000-000A	外/內螺紋-ISO規格 -External-Internal-ISO		Ø9.9 ~ Ø19.9	186
	三刃 3 Flutes	CTSEU300000-000A	外螺紋-UN美製規格 -External-UN		Ø5.9 ~ Ø7.9	187
	五刃 5 Flutes	CTSEU500000-000A	外螺紋-UN美製規格 -External-UN		Ø9.9 ~ Ø19.9	187
	三刃 3 Flutes	CTSIU300000-000A	外/內螺紋-UN美製規格 -External-Internal-UN		Ø3.0 ~ Ø7.9	188
	五刃 5 Flutes	CTSIU500000-000A	外/內螺紋-UN美製規格 -External-Internal-UN		Ø9.9 ~ Ø19.9	188
螺旋銑牙刀 Thread Helix Flute	三刃 3 Flutes	MTHIA000000-000A	外/內螺紋-ISO規格 -External-Internal-ISO		Ø1.2 ~ Ø15.9	189
	三刃 3 Flutes	CTHI300000-000A	外/內螺紋-ISO規格 -External-Internal-ISO		Ø2.2 ~ Ø7.7	190
	四刃 4 Flutes	CTHI400000-000A	外/內螺紋-ISO規格 -External-Internal-ISO		Ø3.9 ~ Ø15.9	190
	五刃 5 Flutes	CTHI500000-000A	外/內螺紋-ISO規格 -External-Internal-ISO		Ø13.9	190
	三刃 3 Flutes	MTHUA000000-000A	外/內螺紋-UN美製規格 -External-Internal-UN		Ø1.4 ~ Ø9.55	192
	三刃 3 Flutes	CTHIU300000-000A	外/內螺紋-UN美製規格 -External-Internal-UN		Ø3.0 ~ Ø7.4	191
	四刃 4 Flutes	CTHIU400000-000A	外/內螺紋-UN美製規格 -External-Internal-UN		Ø9.2 ~ Ø17.0	191
	五刃 5 Flutes	CTHIU500000-000A	外/內螺紋-UN美製規格 -External-Internal-UN		Ø13.5~Ø19.9	191
	三/四/五刃 3/4/5 Flutes	CTHPT000000-000A	外/內螺紋-NPT美製規格 -External-Internal-NPT		Ø5.3 ~ Ø19.9	193

碳素鋼 Carbon Steels (<20HRC)		合金鋼 Alloy Steels (20~30HRC)		合金鋼 Alloy Steels (30~45HRC)		調質鋼 Hardened Steels (45~55HRC)		調質鋼 Hardened Steels (55~65HRC)		不銹鋼 Stainless Steels		鑄鐵 Cast Iron		鋁合金 Aluminum Alloys		銅 Copper		非金屬 Non-metal		高溫合金 High-Temp Alloys		冷卻方式推薦 Suitable Coolant		加工型態 Type of Finishing			
 Carbon Steels (<20HRC)		 Alloy Steels (20~30HRC)		 Alloy Steels (30~45HRC)		 Hardened Steels (45~55HRC)		 Hardened Steels (55~65HRC)		 Stainless Steels		 Cast Iron		 Aluminum Alloys		 Copper		 Non-metal		 High Temp Alloys				A	B	C	D
			—	—	—	—	—	—	—		—	—	—	—	—	—	—	—	—	—	濕式(Wet)						
—	—	—	—	—	—	—	—	—	—	—			—	—	—	—	—	—	—	—	濕式(Wet)						
—	—	—	—	—	—	—	—	—	—	—	—			—	—	—	—	—	—	—	濕式(Wet)						
—	—	—	—	—	—	—	—	—	—	—	—			—	—	—	—	—	—	—	濕式(Wet)						
				—	—			—	—		—	—	—	—	—	—	—	—	—	—	乾式 / 濕式 (Dry / Wet)						
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鎢鋼多功能螺旋鑽銑牙刀(鑽孔-螺紋-倒角)- 內螺紋用(ISO規格)

CARBIDE MULTIPURPOSE THREAD MILLS- DRILL-THREAD-CHAMFER- Helix Flute- Internal(ISO Metric)

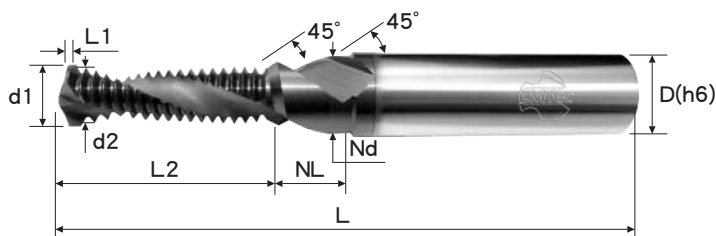
· CSHI200000-000A



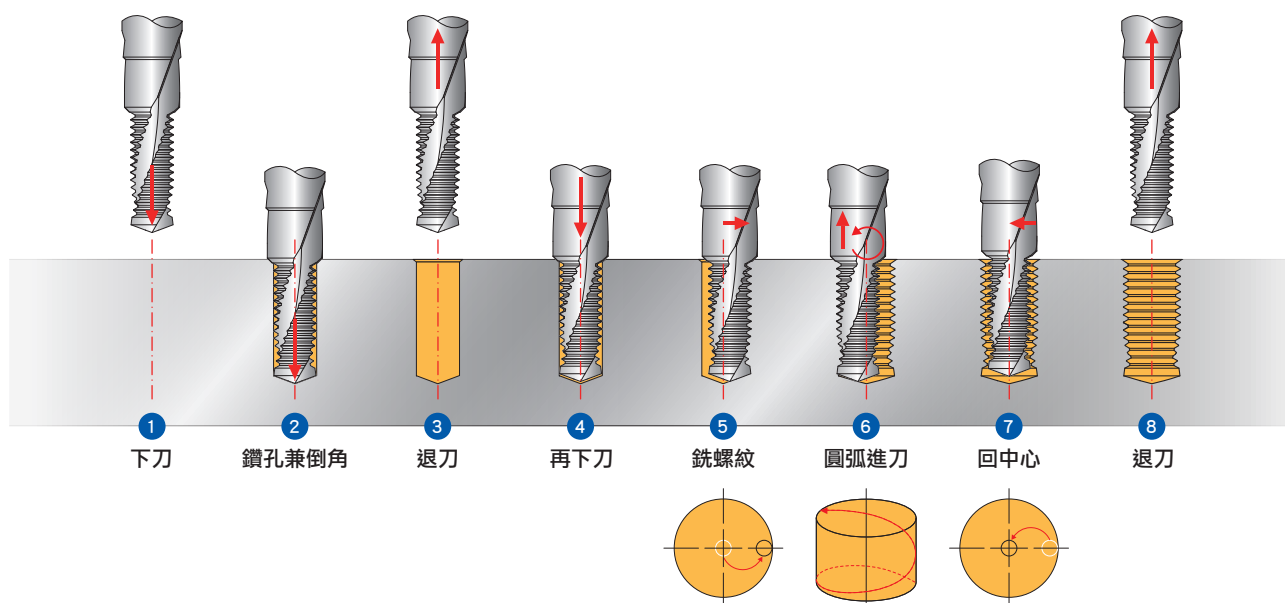
公差 Tolerance class
6g / 6H



60



螺紋 Thread	螺距 Pitch	d1	d2	L1	L2	Nd	NL	L	D	h (mm)	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
粗牙M													
M6	1.00	5.0	4.85	1.0	14.5	6.6	9.5	60	8	0.58	11	2	CSHI205008-100A
M8	1.25	6.8	6.45	1.3	18.2	9.0	16.8	75	10	0.72	11	2	CSHI206810-125A
M10	1.50	8.5	8.08	1.5	23.4	11.0	11.6	80	12	0.87	12	2	CSHI208512-150A
M12	1.75	10.3	9.74	1.5	27.1	13.5	17.9	90	14	1.01	12	2	CSHI210314-175A

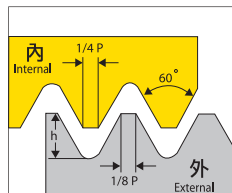


→ 切削條件表
Cutting Condition P.565

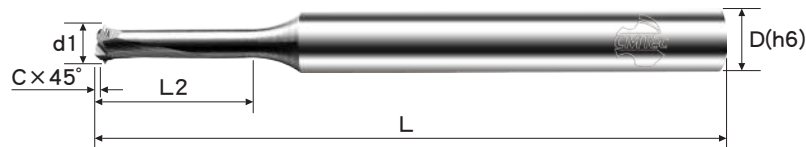
鎢鋼多功能單/雙牙螺旋鑽銑牙刀(鑽孔-螺紋-倒角)- 鋁用- 內螺紋用(ISO規格)

CARBIDE MULTIPURPOSE THREAD MILLS- DRILL-CHAMFER-THREAD
- Helix Flute- For Aluminum- Internal(ISO Metric)

· MSHIA1/2/300000-000

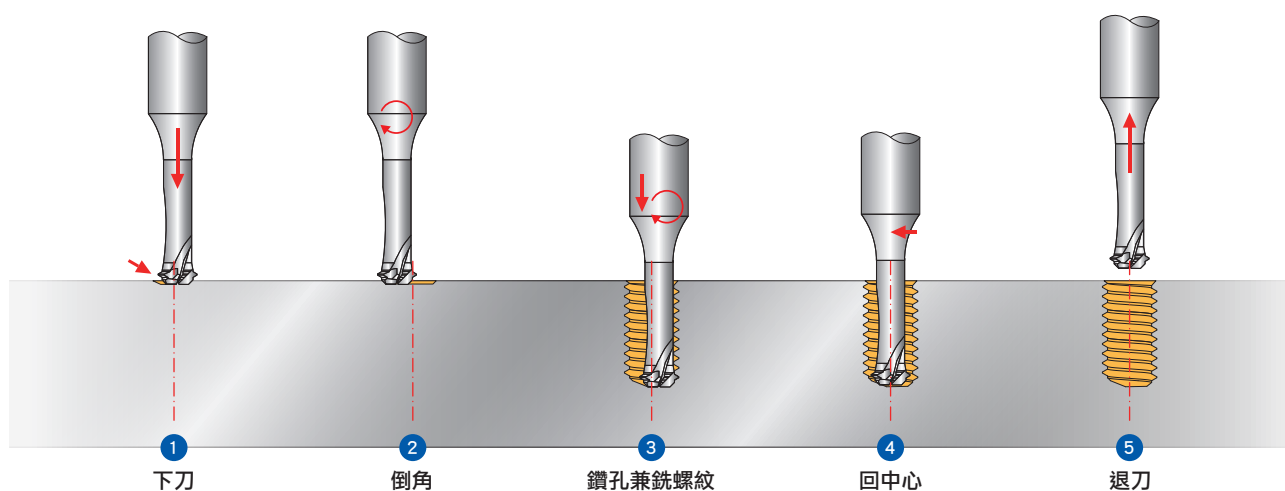


公差 Tolerance class
6g / 6H



切 削 實 例
CUT EXAMPLES

螺紋 Thread	螺距 Pitch	刃徑 d1	有效長 L2	全長 L	柄徑 D	倒角 Chamfer	牙數 Teeth	刃數 Flute	白刀訂購編號 Uncoated Order No.
M0.8	0.20	0.60	2.4	50	4	0.10	1	1	MSHIA100604-020
M0.9	0.225	0.66	2.7	50	4	0.12	1	1	MSHIA100604-022
M1.0	0.25	0.73	3.0	50	4	0.15	1	1	MSHIA100704-025
M1.2	0.25	0.92	3.6	50	4	0.15	1	1	MSHIA100904-025
M1.4	0.30	1.05	4.2	50	4	0.19	1	1	MSHIA101004-030
M1.6	0.35	1.21	4.8	50	4	0.22	1	1	MSHIA101204-035
M2.0	0.40	1.55	6.0	50	4	0.25	1	2	MSHIA201504-040
M2.5	0.45	2.00	7.5	50	4	0.29	1	2	MSHIA202004-045
M3.0	0.50	2.44	9.0	60	6	0.33	1	2	MSHIA202406-050
M4.0	0.70	3.20	12.0	60	6	0.45	1	2	MSHIA203206-070
M5.0	0.80	4.00	15.0	60	6	0.53	1	2	MSHIA204006-080
M6.0	1.00	4.85	18.0	75	6	0.65	2	3	MSHIA304806-100
M8.0	1.25	6.50	24.0	75	8	0.80	2	3	MSHIA306508-125
M10.0	1.50	7.90	30.0	75	8	1.00	2	3	MSHIA307908-150



→ 切削條件表
Cutting Condition P.576

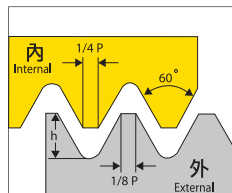
THREADING
Carbide Thread Mills

鎢鋼銑牙刀系列

鎢鋼多功能單/雙牙螺旋鑽銑牙刀(鑽孔-倒角-螺紋)- 硬材質用- 內螺紋用(ISO規格)

CARBIDE MULTIPURPOSE THREAD MILLS- DRILL-CHAMFER-THREAD
- Helix Flute- For Hard Materials- Internal(ISO Metric)

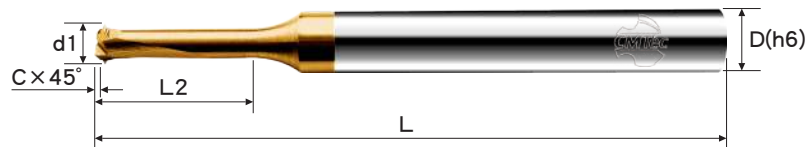
· MSHIDA1/2/300000-000A



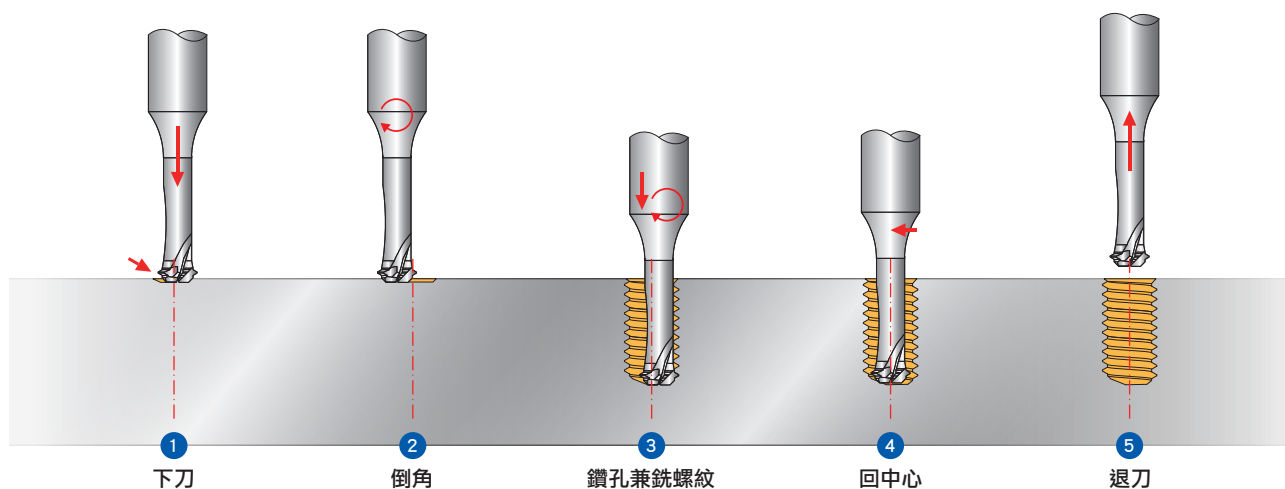
公差 Tolerance class
6g / 6H



切 削 實 例
CUT EXAMPLES



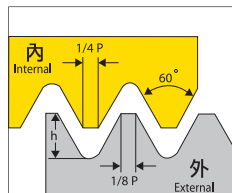
螺紋 Thread	螺距 Pitch	刃徑 d1	有效長 L2	全長 L	柄徑 D	倒角 Chamfer	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
M0.8	0.20	0.60	2.4	50	4	0.10	1	1	MSHIDA100604-020A
M0.9	0.225	0.66	2.7	50	4	0.12	1	1	MSHIDA100604-022A
M1.0	0.25	0.73	3.0	50	4	0.15	1	1	MSHIDA100704-025A
M1.2	0.25	0.92	3.6	50	4	0.15	1	1	MSHIDA100904-025A
M1.4	0.30	1.05	4.2	50	4	0.19	1	1	MSHIDA101004-030A
M1.6	0.35	1.21	4.8	50	4	0.22	1	1	MSHIDA101204-035A
M2.0	0.40	1.55	6.0	50	4	0.25	1	2	MSHIDA201504-040A
M2.5	0.45	2.00	7.5	50	4	0.29	1	2	MSHIDA202004-045A
M3.0	0.50	2.44	9.0	60	6	0.33	1	2	MSHIDA202406-050A
M4.0	0.70	3.20	12.0	60	6	0.45	1	2	MSHIDA203206-070A
M5.0	0.80	4.00	15.0	60	6	0.53	1	2	MSHIDA204006-080A
M6.0	1.00	4.85	18.0	75	6	0.65	2	3	MSHIDA304806-100A
M8.0	1.25	6.50	24.0	75	8	0.80	2	3	MSHIDA306508-125A
M10.0	1.50	7.90	30.0	75	8	1.00	2	3	MSHIDA307908-150A



→ 切削條件表
Cutting Condition P.576

CARBIDE THREAD MILLS- Straight Flute- External / Internal(ISO Metric)

Technical drawing of a CMTtec drill bit. The drawing shows the bit with its dimensions labeled: d (drill diameter), L_1 (flute length), L (total length), and $D(h6)$ (shank diameter). The CMTtec logo is visible on the shank.



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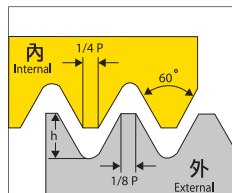
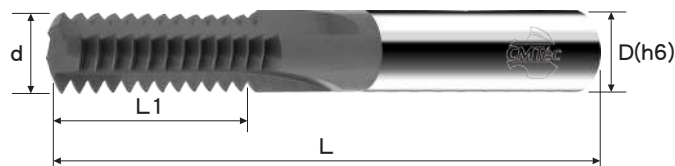
➡ 切削條件表 P.566
Cutting Condition

→ 下孔徑建議 P.652
Drill hole dia.

鎢鋼直刃銑牙刀- 外/內螺紋用(ISO規格)

CARBIDE THREAD MILLS- Straight Flute- External / Internal(ISO Metric)

· CTSI000000-000A

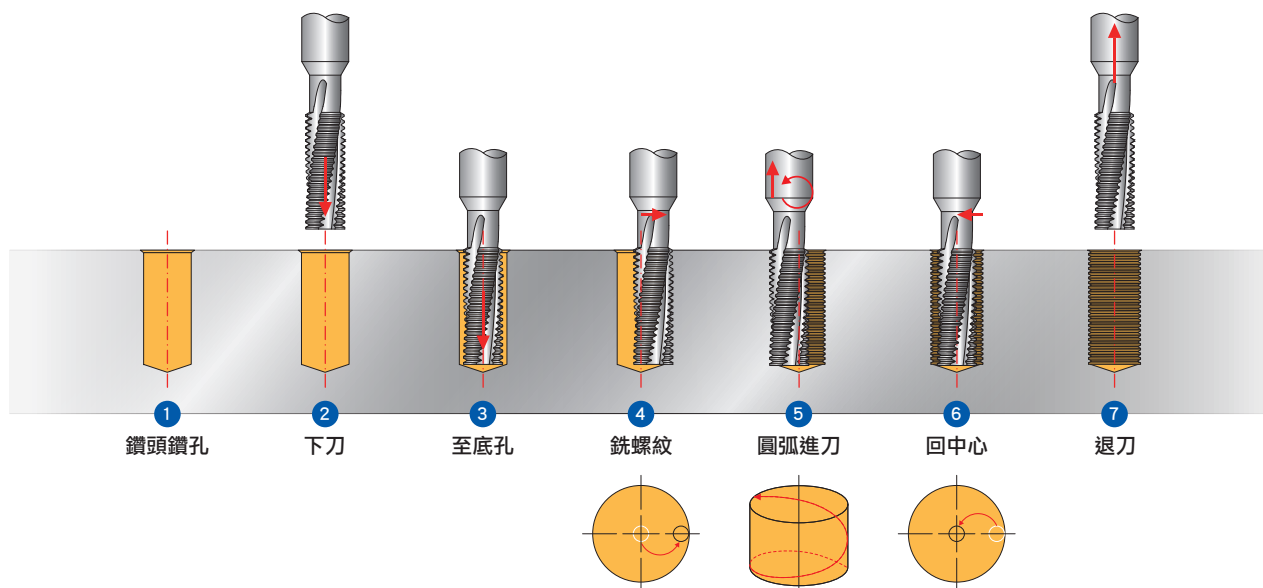


公差 Tolerance class
6g / 6H



61

螺紋 Thread	螺距 Pitch	刃徑 d	刃長 L1	全長 L	柄徑 D	h (mm)	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
M4.5	0.75	3.0	6.7	50	4	0.43	9	3	CTSI303004-075A
M8	0.75	5.9	15.0	60	6	0.43	20	3	CTSI305906-075A
M5	0.80	3.6	8.0	50	4	0.46	10	3	CTSI303604-080A
M6	1.00	4.0	9.0	60	6	0.58	9	3	CTSI304006-100A
M12	1.00	7.9	20.0	60	8	0.58	20	3	CTSI307908-100A
M8	1.25	5.0	12.5	60	6	0.72	10	3	CTSI305006-125A
M10	1.50	5.9	15.0	60	6	0.87	10	3	CTSI305906-150A
M14	1.50	9.9	24.0	75	10	0.87	16	5	CTSI509910-150A
M18	1.50	11.9	30.0	100	12	0.87	20	5	CTSI511912-150A
M12	1.75	7.9	19.2	60	8	1.01	11	3	CTSI307908-175A
M16	2.00	9.9	24.0	75	10	1.15	12	5	CTSI509910-200A
M18	2.00	11.9	30.0	100	12	1.15	15	5	CTSI511912-200A
M20	2.50	11.9	30.0	100	12	1.44	12	5	CTSI511912-250A
M24	3.00	15.9	36.0	100	16	1.73	12	5	CTSI515916-300A
M30	3.50	15.9	38.5	100	16	2.02	11	5	CTSI515916-350A
M36	4.00	15.9	40.0	100	16	2.31	10	5	CTSI515916-400A
M48	5.00	19.9	40.0	100	20	2.89	8	5	CTSI519920-500A
M64	6.00	19.9	36.0	100	20	3.46	6	5	CTSI519920-600A

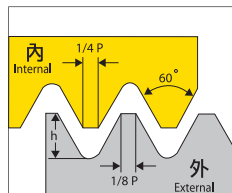


→ 切削條件表
Cutting Condition P.566

→ 下孔徑建議
Drill hole dia. P.652

CARBIDE THREAD MILLS- Straight Flute- External / Internal(American UN)

Technical drawing of a CMTtec drill bit. The drawing shows the bit with its dimensions labeled: d (drill diameter), L_1 (flute length), L (total length), and $D(h6)$ (shank diameter). The CMTtec logo is visible on the shank.



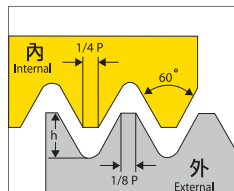
61

※ 25.4 ÷ Tpi (英制單位 Inch) = Pitch (公制單位 Metric)

→ 下孔徑建議
Drill hole dia. P.657

CARBIDE THREAD MILLS- Straight Flute- External / Internal(American UN)

Technical drawing of a CMTtec drill bit. The drawing shows the bit with its dimensions labeled: d (drill diameter), L_1 (flute length), L (total length), and $D(h6)$ (shank diameter). The CMTtec logo is visible on the shank.



公差 Tolerance class
2A / 2B



61

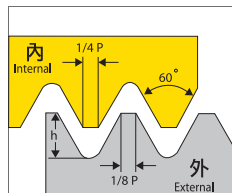
※ 25.4 ÷ Tpi (英制單位 Inch) = Pitch (公制單位 Metric)

→ 下孔徑建議 P.657
Drill hole dia.

鎢鋼螺旋銑牙刀- 外/內螺紋用(ISO規格)

CARBIDE THREAD MILLS- Helix Flute- External / Internal(ISO Metric)

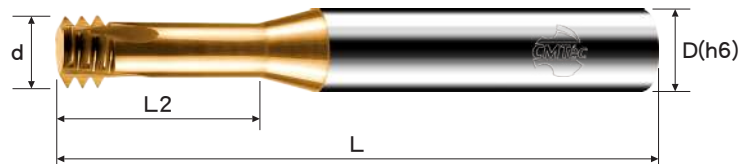
· MTHIA000000-000A



公差 Tolerance class
6g / 6H



61



螺紋加工深度可到2d | 2d ($L2 \leq 2 \times \text{Thread Diameter}$)

螺紋 Thread		螺距 Pitch	刃徑 d	有效長 L2	全長 L	柄徑 D	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
M 粗牙	Mx1 細牙								
M1.6		0.35	1.20	3.4	50	3	3	3	MTHIA301203-035A
M2.0		0.40	1.55	4.2	60	6	3	3	MTHIA301506-040A
M2.2		0.45	1.65	4.6	60	6	3	3	MTHIA301606-045A
M2.5		0.45	1.95	5.2	60	6	3	3	MTHIA301906-045A
M3.0	M3.5~M16	0.50	2.40	6.2	60	6	3	3	MTHIA302406-050A
M3.5		0.60	2.75	7.3	60	6	3	3	MTHIA302706-060A
M4.0		0.70	3.15	8.3	60	6	3	3	MTHIA303106-070A
M5.0		0.80	4.05	10.4	60	6	3	3	MTHIA304006-080A
M6.0	M8.0~M40	1.00	4.80	12.5	60	6	3	3	MTHIA304806-100A
M8.0		1.25	6.50	16.6	60	8	3	3	MTHIA306508-125A
M10	M12~M48	1.50	8.20	20.8	75	10	3	3	MTHIA308210-150A
M12		1.75	9.90	25.0	75	10	3	3	MTHIA309910-175A
M16		2.00	11.90	33.0	100	12	3	3	MTHIA311912-200A
M20		2.50	15.90	41.3	100	16	3	3	MTHIA315916-250A

螺紋加工深度可到3d | 3d ($L2 \leq 3 \times \text{Thread Diameter}$)

螺紋 Thread		螺距 Pitch	刃徑 d	有效長 L2	全長 L	柄徑 D	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
M 粗牙	Mx1 細牙								
M1.6		0.35	1.20	5.0	50	3	3	3	MTHIA301203050-035A
M2.0		0.40	1.55	6.2	60	6	3	3	MTHIA301506062-040A
M2.5		0.45	1.95	7.7	60	6	3	3	MTHIA301906077-045A
M3.0	M3.5~M16	0.50	2.40	9.2	60	6	3	3	MTHIA302406092-050A
M4.0		0.70	3.15	12.3	60	6	3	3	MTHIA303106123-070A
M5.0		0.80	4.05	15.4	60	6	3	3	MTHIA304006154-080A
M6.0	M8.0~M40	1.00	4.80	18.5	60	6	3	3	MTHIA304806185-100A
M8.0		1.25	6.50	24.6	60	8	3	3	MTHIA306508246-125A

THREADING

Carbide Thread Mills

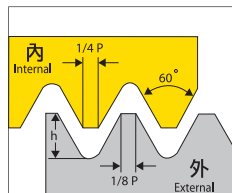
鎢鋼銑牙刀系列

→ 切削條件表 P.566
Cutting Condition

→ 下孔徑建議 P.652
Drill hole dia.

CARBIDE THREAD MILLS- Helix Flute- External / Internal(ISO Metric)

Technical drawing of a double-flute drill bit. The drawing shows the bit from the side, highlighting its double-flute design. Key dimensions are labeled: d for the cutting edge diameter, L_1 for the length of the cutting edge, L for the total length, and $D(h6)$ for the shank diameter. The brand logo "CMTEC" is visible on the shank.



6g / 6H



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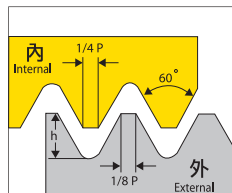


➡ 切削條件表 P.566
Cutting Condition

→ 下孔徑建議
Drill hole dia. P.652

CARBIDE THREAD MILLS- Helix Flute- External / Internal(American UN)

Technical drawing of a CMTAC double-flute drill bit. The drawing shows the bit with dimensions: d (flute diameter), L_1 (flute length), L (total length), and $D(h6)$ (shank diameter). The CMTAC logo is visible on the shank.



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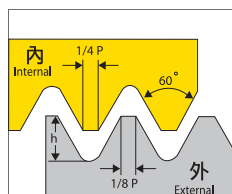
※ 25.4 ÷ Tpi (英制單位 Inch) = Pitch (公制單位 Metric)

→ 下孔徑建議
Drill hole dia. P.657

鎢鋼螺旋銑牙刀- 外/內螺紋用(UN美製規格)

CARBIDE THREAD MILLS- Helix Flute- External / Internal(American UN)

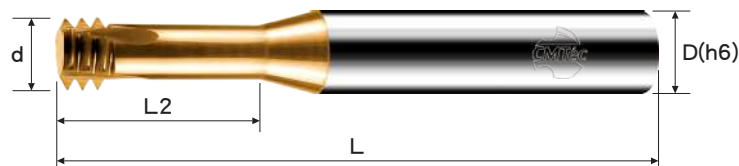
· MTHUA000000-000A



公差 Tolerance class
2A / 2B



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螺紋加工深度可到2d | 2d ($L2 \leq 2 \times \text{Thread Diameter}$)

螺紋 Thread		牙/吋 Tpi	刃徑 d	有效長 L2	全長 L	柄徑 D	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
UNC 粗牙	UNF 細牙								
	No.1	72	1.45	3.9	60	6	3	3	MTHUA301406-720A
No.1	No.2	64	1.40	4.2	60	6	3	3	MTHUA301406-640A
No.2	No.3	56	1.65	5.0	60	6	3	3	MTHUA301606-560A
No.3	No.4	48	1.90	6.0	60	6	3	3	MTHUA301906-480A
No.4, No.5	No.6	40	2.10	6.0	60	6	3	3	MTHUA302106-400A
No.5	No.6	40	2.45	7.2	60	6	3	3	MTHUA302406-400A
	No.8	36	3.30	8.7	60	6	3	3	MTHUA303306-360A
No.6, No.8	No.10	32	2.55	7.4	60	6	3	3	MTHUA302506-320A
No.8	No.10	32	3.20	10.0	60	6	3	3	MTHUA303206-320A
	No.10	32	3.80	10.3	60	6	3	3	MTHUA303806-320A
	1/4"	28	5.25	13.2	60	6	3	3	MTHUA305206-280A
No.10	5/16"	24	3.58	10.2	60	6	3	3	MTHUA303506-240A
	5/16"	24	6.68	16.5	60	8	3	3	MTHUA306608-240A
1/4"	7/16"	20	4.88	13.4	60	6	3	3	MTHUA304806-200A
	7/16"	20	9.55	23.0	75	10	3	3	MTHUA309510-200A
5/16"		18	6.15	16.9	60	8	3	3	MTHUA306108-180A
3/8"		16	6.70	19.1	60	8	3	3	MTHUA306708-160A
7/16"		14	9.00	23.3	75	10	3	3	MTHUA309010-140A

螺紋加工深度可到3d | 3d ($L2 \leq 3 \times \text{Thread Diameter}$)

螺紋 Thread		牙/吋 Tpi	刃徑 d	有效長 L2	全長 L	柄徑 D	牙數 Teeth	刃數 Flute	鍍膜訂購編號 Coated Order No.
UNC 粗牙	UNF 細牙								
	No.1	72	1.45	5.75	60	6	3	3	MTHUA301406057-720A
No.2	No.3	56	1.65	7.00	50	3	3	3	MTHUA301603070-560A
No.4, No.5	No.6	40	2.10	9.00	50	3	3	3	MTHUA302103090-400A
No.4, No.5	No.6	40	2.10	9.00	60	6	3	3	MTHUA302106090-400A
No.5	No.6	40	2.45	10.0	60	6	3	3	MTHUA302406100-400A
No.6, No.8	No.10	32	2.55	11.0	60	6	3	3	MTHUA302506110-320A
No.8	No.10	32	3.20	13.0	60	6	3	3	MTHUA303206130-320A
	No.10	32	3.80	15.1	60	6	3	3	MTHUA303806151-320A
No.12	1/4"	28	4.40	17.0	60	6	3	3	MTHUA304406170-280A
	1/4"	28	5.25	19.6	60	6	3	3	MTHUA305206196-280A
	5/16"	24	6.68	24.5	60	8	3	3	MTHUA306608245-240A
1/4"	7/16"	20	4.88	19.8	60	6	3	3	MTHUA304806198-200A
5/16"		18	6.15	24.0	60	8	3	3	MTHUA306108240-180A

※ 25.4 ÷ Tpi (英制單位 Inch) = Pitch (公制單位 Metric)

→ 切削條件表
Cutting Condition P.566

→ 下孔徑建議
Drill hole dia. P.657



Carbide Thread Mills

鎢鋼銑牙刀系列