

粉末冶金机用丝锥，常用型

	P N/mm ²	M N/mm ²	K HB	S N/mm ²	N N/mm ²	
132260	<850	<750	<200	Hastelloy <900	黄铜, 青铜, 铝<600	热塑料, GFK
vc = m/min.						
132260	15-17	8-10	20-22	2-3	100-120	100-120

M Metrisches Gewinde
 HSS-Co PM
 HARDLUBE
 DIN 371
 DIN 376 ab M12
 Form C
 Anachothorn C
 Metrisch
 DIN 13
 6HX
 Grundloch tief
 UNI
 50° Drill
 2-3 Gang

技术说明/应用:
加工底孔螺纹
C型切面, 2-3牙

其他类似132210
≤ M6=尖头
> M6=带内孔中心定位



132260 HighI, 粉末冶金, 常用型, Hardlube涂层

d ₁ mm	132260 (RG 1390)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M2	●	0,40	45	8	—	2,8	2,1	5	1,60
M2,5	●	0,45	50	9	—	2,8	2,1	5	2,05
M3	●	0,50	56	5	18	3,5	2,7	6	2,50
M4	●	0,70	63	7	21	4,5	3,4	6	3,30
M5	●	0,80	70	8	25	6,0	4,9	8	4,20
M6	●	1,00	80	10	30	6,0	4,9	8	5,00
M8	●	1,25	90	13	35	8,0	6,2	9	6,80
M10	●	1,50	100	15	39	10,0	11,0	8	8,50

d ₁ mm	132260 (RG 1390)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M12	●	1,75	110	18	—	9,0	7,0	10	10,20
M14	●	2,00	110	20	—	11,0	9,0	12	12,00
M16	●	2,00	110	20	—	12,0	9,0	12	14,00
M20	●	2,50	140	25	—	16,0	12,0	15	17,50
M24	●	3,00	160	30	—	18,0	14,5	17	21,00
M27	●	3,00	160	30	—	20,0	16,0	19	24,00
M30	●	3,50	180	35	—	22,0	18,0	21	26,50
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粉末冶金机用丝锥

	P N/mm ²	M N/mm ²	K HB	S N/mm ²	N N/mm ²
132262	<850	<750	<650	<900	<500
vc = m/min.					
132262	15	8	20	2	100

M Metrisches Gewinde
 HSS-Co PM
 HARDLUBE
 DIN 371
 DIN 376 ab M12
 Form E
 Anachothorn E
 Metrisch
 DIN 13
 6HX
 Grundloch tief
 UNI
 50° Drill
 1,5-2 Gang

技术说明/应用j
加工底孔螺纹
E型切面, 1.5-2牙

其他类似132260
≤ M6=尖头
> M6=带内部中心定位



132262 HighQ, 粉末冶金 常用型 hardlube涂层

d ₁ mm	132262 (RG 1390)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M3	●	0,50	56	5	18	3,5	2,7	6	2,50
M4	●	0,70	63	7	21	4,5	3,4	6	3,30
M5	●	0,80	70	8	25	6,0	4,9	8	4,20
M6	●	1,00	80	10	30	6,0	4,9	8	5,00
M8	●	1,25	90	13	35	8,0	6,2	9	6,80

d ₁ mm	132262 (RG 1390)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M10	●	1,50	100	15	39	10,0	8,0	11	8,50
M12	●	1,75	110	18	—	9,0	7,0	10	10,20
M16	●	2,00	110	20	—	12,0	9,0	12	14,00
M20	●	2,50	140	25	—	16,0	12,0	15	17,50
—	—	—	—	—	—	—	—	—	—

粉末冶金机用丝锥，自动同步常用型

	P N/mm ²	M N/mm ²	K HB	S N/mm ²	N N/mm ²	
132265	<850	<750	<200	Hastelloy <900	黄铜, 青铜, 铝<600	热塑料, GFK
vc = m/min.						
132265	15-17	8-10	20-22	2-3	100-120	100-120

M
Metrisches Gewinde

HSS-Co PM

TiCN

Werks-norm

Typ Synchro

Form C

Anschliffen C

50° Drall

2-3 Gang

Metrisch 60°

DIN 13

6HX

Grundloch Set

UNI

技术说明/应用
加工底孔螺纹，C型切面，2-3牙
与132260相似，适用于213203同步螺纹加工垫片

≤ M6=尖头
> M6=带内孔中心定位

UNIVERSAL-SYNCHRO



132265 HighQ, 粉末冶金，自同步常用型，TiCN涂层

d ₁ mm	132265 (RG 1390)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm	d ₁ mm	132265 (RG 1390)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M2	●	0,40	45	8	—	6,0	4,9	8	1,60	M8	●	1,25	90	13	35	8,0	6,2	9	6,80
M2,5	●	0,45	50	9	—	6,0	4,9	8	2,05	M10	●	1,50	100	15	39	10,0	8,0	11	8,50
M3	●	0,50	56	5	18	6,0	4,9	8	2,50	M12	●	1,75	110	18	—	12,0	9,0	12	10,20
M4	●	0,70	63	7	21	6,0	4,9	8	3,30	M14	●	2,00	110	20	—	14,0	11,0	14	12,00
M5	●	0,80	70	8	25	6,0	4,9	8	4,20	M16	●	2,00	110	20	—	16,0	12,0	15	14,00
M6	●	1,00	80	10	30	6,0	4,9	8	5,00	M20	●	2,50	140	25	—	16,0	12,0	15	17,50



粉末冶金机用丝锥 常用型

	P N/mm ²	M N/mm ²	K HB	S N/mm ²	N N/mm ²	
132270	<850	<750	<200	Hastelloy <900	黄铜, 青铜, 铝<600	热塑料, GFK
vc = m/min.						
132270	15-17	8-10	20-22	2-3	100-120	100-120

MF Metrisches Feingewinde
HSS-Co PM
HARDLUBE
DIN 374
Anschliffform B 3,5-5 Gang
Metrisch 60°
DIN 13

6HX
Durchgangsbolzen
UNI

技术说明/应用
加工通孔螺纹
类似132210, 加工公制ISO细
螺纹(MF)

≥ M8=内孔中心定位



132270 HighQ, 粉末冶金, 常用型, Hardlube涂层

d ₁ × P	132270 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M8 × 1	●	90	22	6	4,9	8	7,00
M10 × 1	●	90	20	7	5,5	8	9,00
M10 × 1,25	●	100	24	7	5,5	8	8,80
M12 × 1	●	100	22	9	7	10	11,00
M12 × 1,25	●	100	22	9	7	10	10,80

d ₁ × P	132270 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M12 × 1,5	●	100	22	9	7	10	10,50
M14 × 1,5	●	100	22	11	9	12	12,50
M16 × 1,5	●	100	22	12	9	12	14,50
M18 × 1,5	●	110	25	14	11	14	16,50
M20 × 1,5	●	125	25	16	12	15	18,50

粉末冶金机用丝锥, 常用型

	P N/mm ²	M N/mm ²	K HB	S N/mm ²	N N/mm ²	
132280	<850	<750	<200	Hastelloy <900	黄铜, 青铜, 铝<600	热塑料, GFK
vc = m/min.						
132280	15-17	8-10	20-22	2-3	100-120	100-120

MF Metrisches Feingewinde
HSS-Co PM
HARDLUBE
DIN 374
Form C 50° Drill
Anschliffform C 2-3 Gang
Metrisch 60°

DIN 13
6HX
Grundloch Bolzen
UNI

技术说明/应用
加工底孔螺纹
C型切面, 2-3牙
类似132260, 加工公制ISO细
螺纹(MF)

≥ M8=内孔中心定位



132280 HighQ, 粉末冶金, 常用型, hardlube涂层

d ₁ × P	132280 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M8 × 1	●	90	10	6	4,9	8	7,00
M10 × 1	●	90	12	7	5,5	8	9,00
M10 × 1,25	●	100	12	7	5,5	8	8,80
M12 × 1	●	100	14	9	7	10	11,00
M12 × 1,25	●	100	14	9	7	10	10,80

d ₁ × P	132280 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M12 × 1,5	●	100	14	9	7	10	10,50
M14 × 1,5	●	100	16	11	9	12	12,50
M16 × 1,5	●	100	16	12	9	12	14,50
M18 × 1,5	●	110	20	14	11	14	16,50
M20 × 1,5	●	125	20	16	12	15	18,50

粉末冶金机用丝锥，常用型

	P N/mm ²	M N/mm ²	K HB	S N/mm ²	N N/mm ²	
132290	<850	<750	<200	Hastelloy <900	黄铜, 青铜, 铝<600	热塑料, GFK
vc = m/min.						
132290	15-17	8-10	20-22	2-3	100-120	100-120

G Whitworth-Rohrgewinde
HSS-Co PM
HARDLUBE
DIN 5156
Aschneitturm B 3,5-5 Gang
G. Whitworth Rohrgewinde 55°
DIN ISO 228

6HX
Durchgangslöcher
UNI

技术说明/应用
加工底孔螺纹
类似132210, 加工惠氏管螺纹(G)

≥G1/8=内孔中心定位



132290 HighQ, 粉末冶金, 常用型, Hardlube涂层

d ₁ × P	132290 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
G1/8-28	●	90	20	7	5,5	8	8,80
G1/4-19	●	100	21	11	9	12	11,80
G3/8-19	●	100	21	12	9	12	15,25
G1/2-14	●	125	24	16	12	15	19,00

d ₁ × P	132290 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
G5/8-14	●	125	24	18	14,5	17	21,00
G3/4-14	●	140	26	20	16	19	24,50
G1-11	●	160	28	25	20	23	30,75
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粉末冶金机用丝锥，常用型

	P N/mm ²	M N/mm ²	K HB	S N/mm ²	N N/mm ²	
132295	<850	<750	<200	Hastelloy <900	黄铜, 青铜, 铝<600	热塑料, GFK
vc = m/min.						
132295	15-17	8-10	20-22	2-3	100-120	100-120

G Whitworth-Rohrgewinde
HSS-Co PM
HARDLUBE
DIN 5156
Form C 50° Drill
Aschneitturm C 2-3 Gang
G. Whitworth Rohrgewinde 55°

DIN ISO 228
6HX
Grundloch Set
UNI

技术说明/应用:
加工底孔螺纹
C型切面, 203牙
类似132260, 加工惠氏管螺纹(G)
≥1/8=内孔中心定位



132295 HighQ, 粉末冶金, 常用型, Hardlube涂层

d ₁ × P	132295 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
G1/8-28	●	90	12	7	5,5	8	8,80
G1/4-19	●	100	15	11	9	12	11,80
G3/8-19	●	100	15	12	9	12	15,25
G1/2-14	●	125	18	16	12	15	19,00

d ₁ × P	132295 (RG 1390)	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
G5/8-14	●	125	18	18	14,5	17	21,00
G3/4-14	●	140	20	20	16	19	24,50
G1-11	●	160	22	25	20	23	30,75
—	—	—	—	—	—	—	—

● = 德国中央仓库库存
○ = 德国工厂仓库供货

钻高速钢机用丝锥 常用型

	P N/mm ²	K HB	N N/mm ²	
132472	<1000	<200	铝 <600	钢
vc = m/min.				
132472	4-12	7-12	12-20	12-20



132472 PRECITOOL, 钻高速钢, TiN涂层

d ₁ mm	132472 (RG 1304)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻芯孔-Ø mm
M3	●	0,50	56	9	18	3,5	2,7	6	2,50
M4	●	0,70	63	12	21	4,5	3,4	6	3,30
M5	●	0,80	70	13	25	6,0	4,9	8	4,20
M6	●	1,00	80	15	30	6,0	4,9	8	5,00
M8	●	1,25	90	18	35	8,0	6,2	9	6,80
M10	●	1,50	100	20	39	10,0	8,0	11	8,50
M12	●	1,75	110	23	—	9,0	7,0	10	10,20
M14	●	2,00	110	25	—	11,0	9,0	12	12,00
M16	●	2,00	110	25	—	12,0	9,0	12	14,00
M20	●	2,50	140	30	—	16,0	12,0	15	17,50

钻高速钢机用丝锥 常用型

	P N/mm ²	K HB	N N/mm ²	
133472	<1000	<200	铝 <600	钢
vc = m/min.				
133472	4-12	7-12	12-20	12-20



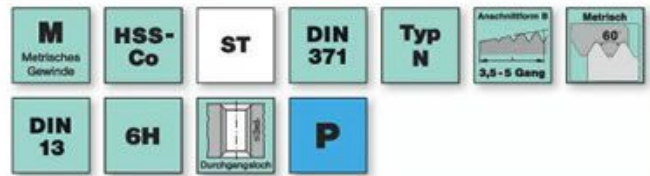
133472 PRECITOOL, 钻高速钢, R40, TiN涂层

d ₁ mm	133472 (RG 1304)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻芯孔Ø mm
M3	●	0,50	56	9	18	3,5	2,7	6	2,50
M4	●	0,70	63	12	21	4,5	3,4	6	3,30
M5	●	0,80	70	13	25	6,0	4,9	8	4,20
M6	●	1,00	80	15	30	6,0	4,9	8	5,00
M8	●	1,25	90	18	35	8,0	6,2	9	6,80
M10	●	1,50	100	20	39	10,0	8,0	11	8,50
M12	●	1,75	110	23	—	9,0	7,0	10	10,20
M14	●	2,00	110	25	—	11,0	9,0	12	12,00
M16	●	2,00	110	25	—	12,0	9,0	12	14,00
M20	●	2,50	140	30	—	16,0	12,0	15	17,50

钻高速钢机用丝锥

PRECITOOL
PRÄZISIONSWERKZEUGE

	P N/mm ²	N N/mm ²	
132310	<850	铝 <600	锌
vc = m/min.			
132310	6-15	14-20	10-12



Der **RENNER**
für die allgemeine
STAHL-Bearbeitung



132310 PRECITOOL, 钻高速钢, ST涂层

d ₁ mm	132310 (RG 1304)	P mm	l ₁ mm	l ₂ mm	l ₄ mm	d ₂ mm	a mm	l ₃ mm	钻芯孔-Ø mm
M3	●	0,50	56	9	18	3,5	2,7	6	2,50
M4	●	0,70	63	12	21	4,5	3,4	6	3,30
M5	●	0,80	70	13	25	6,0	4,9	8	4,20
M6	●	1,00	80	15	30	6,0	4,9	8	5,00
M8	●	1,25	90	18	35	8,0	6,2	9	6,80
M10	●	1,50	100	20	39	10,0	8,0	11	8,50

钻高速钢丝锥

PRECITOOL
PRÄZISIONSWERKZEUGE

	P N/mm ²	N N/mm ²	
132410	<850	铝 <600	锌
vc = m/min.			
132410	6-15	14-20	10-12



Der **RENNER**
für die allgemeine
STAHL-Bearbeitung



132410 PRECITOOL, 钻高速钢, ST涂层

d ₁ mm	132410 (RG 1304)	P mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M3	●	0,50	56	9	2,2	—	4	2,50
M4	●	0,70	63	12	2,8	2,1	5	3,30
M5	●	0,80	70	13	3,5	2,7	6	4,20
M6	●	1,00	80	15	4,5	3,4	6	5,00
M8	●	1,25	90	18	6,0	4,9	8	6,80
M10	●	1,50	100	20	7,0	5,5	8	8,50
M12	●	1,75	110	23	9,0	7,0	10	10,20
M14	●	2,00	110	25	11,0	9,0	12	12,00
M16	●	2,00	110	25	12,0	9,0	12	14,00
M18	●	2,50	125	30	14,0	11,0	14	15,50
M20	●	2,50	140	30	16,0	12,0	15	17,50
M22	●	2,50	140	30	18,0	14,5	17	19,50
M24	●	3,00	160	36	18,0	14,5	17	21,00
M27	●	3,00	160	36	20,0	16,0	19	24,00
M30	●	3,50	180	42	22,0	18,0	21	26,50

● = 德国中央仓库库存
○ = 德国工厂仓库供货

高速钢E-V3通孔丝锥

适用于加工材料强度 $\leq 850 \text{ N/mm}^2$



- 符合 DIN 371/376 B型
- 特殊断屑槽工艺
- 攻牙深度 $\leq 4,5 \times D$
- 蒸汽回火处理降低摩擦系数
- 适用于M2 – M20
- 采用优质的 HSSE V3钒钼高速钢



钢



不锈钢



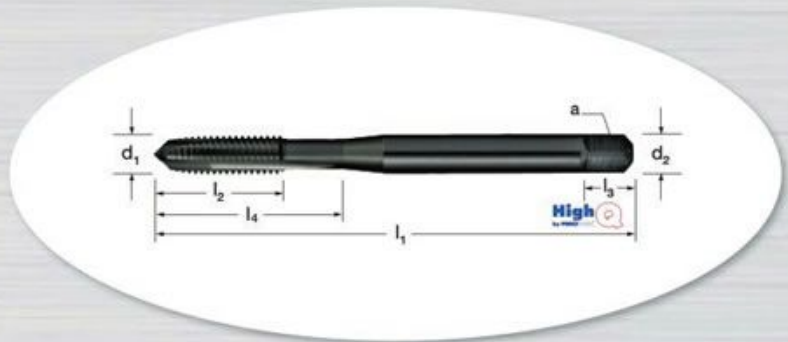
铸铁

特殊钒钼高速钢工艺有效提高耐磨性和韧性

HSSE-V3机用丝锥

High Q
by PRECIT

技术说明/应用:
特殊钨钼高速钢工艺有效提高机用丝锥的耐磨性和韧性和加工可靠性。
蒸汽回火处理降低摩擦系数



132315 HighQ, HSSE-V3, ST涂层

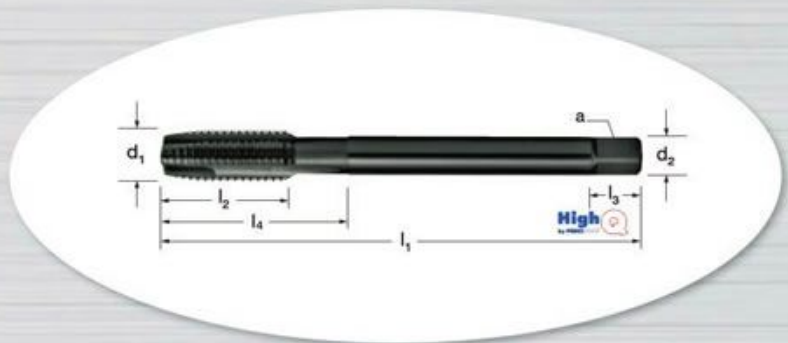
d ₁ mm	132315 (RG 1353)	P mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M2	●	0,40	45	8	2,8	2,1	5	1,75
M2,2	●	0,45	45	9	2,8	2,1	5	1,90
M2,3	●	0,40	45	9	2,8	2,1	5	2,10
M2,5	●	0,45	50	9	2,8	2,1	5	2,05
M3	●	0,50	56	11	3,5	2,7	6	2,50

d ₁ mm	132315 (RG 1353)	P mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M4	●	0,70	63	13	4,5	3,4	6	3,30
M5	●	0,80	70	16	6,0	4,9	8	4,20
M6	●	1,00	80	19	6,0	4,9	8	5,00
M8	●	1,25	90	22	8,0	6,2	9	6,80
M10	●	1,50	100	24	10,0	8,0	11	8,50

HSSE-V3机用丝锥

High Q
by PRECIT

技术说明/应用:
特殊钨钼高速钢工艺有效提高机用丝锥的耐磨性和韧性和加工可靠性。
蒸汽回火处理降低摩擦系数



132415 HighQ, HSSE-V3, ST涂层

d ₁ mm	132415 (RG 1353)	P mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M6	●	1,00	80	19	4,5	3,4	6	5,00
M8	●	1,25	90	22	6,0	4,9	8	6,80
M10	●	1,50	100	24	7,0	5,5	8	8,50
M12	●	1,75	110	29	9,0	7,0	10	10,20

d ₁ mm	132415 (RG 1353)	P mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm	l ₃ mm	钻心空-Ø mm
M14	●	2,00	110	30	11,0	9,0	12	12,00
M16	●	2,00	110	32	12,0	9,0	12	14,00
M18	●	2,50	125	34	14,0	11,0	14	15,50
M20	●	2,50	140	34	16,0	12,0	15	17,50

切削参数

ISO	工件材质	抗拉强度 [N/mm ²]	切削速度 V _c [m/min]
P	St52, C45, 16MnCr5, 42CrMo4	<850	10
M	1.4305, 1.4301, 1.4571, 1.4034, 1.4435	<750	5
K	GG20, GG40, GGG40, GGG80	<650	12

根据加工工况和工件材料选择合适的参数

● = 德国中央仓库库存
○ = 德国工厂仓库供货