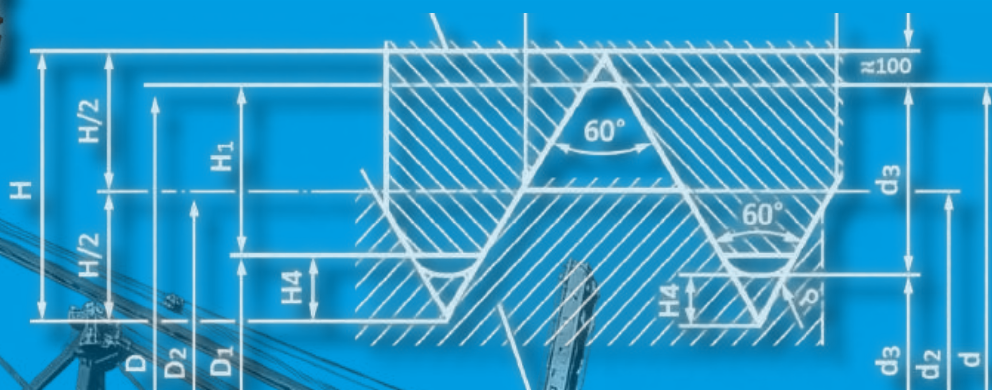


REIME NORIS



SHIPBUILDING

NORIS NES



CN | EN

Quality
Made in Germany
ISO 9001 CERTIFIED



船用发动机
SHIP-ENGINES

4 - 5



船舶螺旋桨
SHIP-PROPELLER

6 - 7



连杆
CONNECTING ROD

8 - 9



起重机齿轮箱
CRANE GEARBOX

10 - 11

应用示例

APPLICATION EXAMPLES



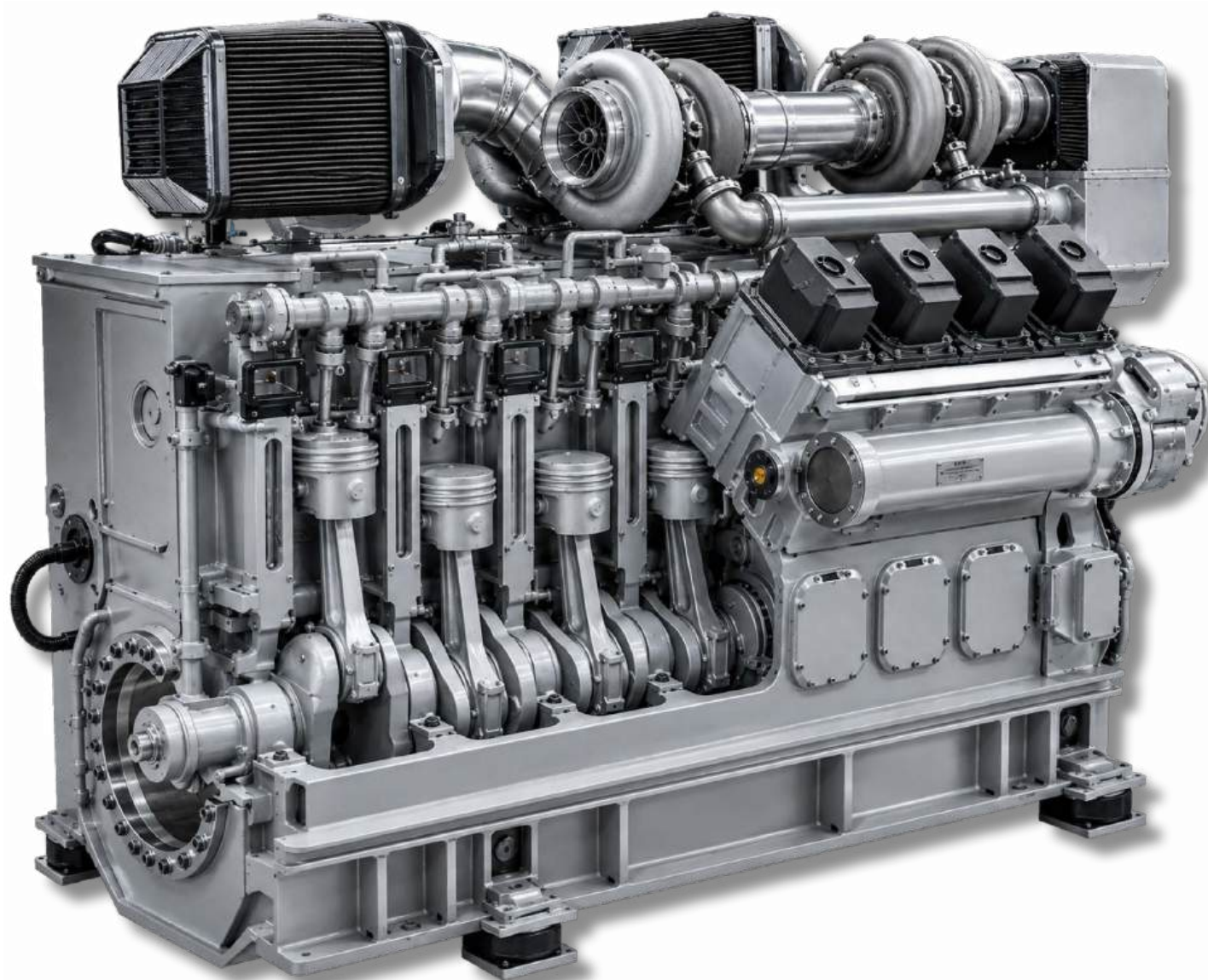
大型发动机中的GGG40材料

GGG40 MATERIAL IN LARGE SHIP-ENGINES

在船舶发动机制造中，加工GGG40材料，尤其是在切削大而深的螺纹时，需要可靠的排屑能力，NORIS INNENSPAN能有效去除加工区的切屑，确保螺纹生产的稳定性和可控性。其坚固的几何形状和耐磨表面确保即使在苛刻的条件下也能保持一贯的高品质。

In marine engine manufacturing, machining GGG40 requires reliable chip removal, particularly when cutting large and deep threads.

The NORIS INNENSPAN effectively removes chips from the machining zone, ensuring stable and controlled thread production. Its robust geometry and wear-resistant surface ensure consistently high quality – even under demanding conditions.



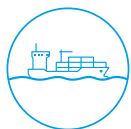


NORIS INNENSPAN

尺寸	M64x6	Size	M64x6
材料	EN-GJS-400-15	Material	EN-GJS-400-15
加工方向	立式	Working direction	Vertical
刀柄	攻丝刀柄	Adaptor	Tapping chuck
切削液	切削油	Lubricant	Cutting oil
切削速度	8 m/min	Cutting speed	8 m/min
螺纹形状	盲孔螺纹	Thread form	Blind hole thread
螺纹深度	90 mm	Thread depth	90 mm

您的获益 | YOUR BENEFITS

- 最大程度的工艺可靠性 | Maximum process reliability**
 可靠的排屑可防止切屑堆积、刀具破损和材料浪费，尤其是在切削深螺纹时。
 Reliable chip removal prevents chip buildup, tool breakage, and material waste—especially when cutting deep threads.
- 刀具使用寿命长 | Long tool life**
 坚固的几何形状和耐磨表面确保了刀具寿命长，并降低了加工成本。
 Robust geometry and a wear-resistant surface ensure a long tool life and reduced tooling costs.
- 螺纹质量一致 | Consistent thread quality**
 即使在发动机制造的严苛条件下，也能确保螺纹清洁且尺寸精确。
 Clean, dimensionally accurate threads, even under demanding conditions in engine manufacturing.



螺纹挑战 - 大螺旋桨

THREADING CHALLENGE - LARGE SHIP-PROPELLERS

船用螺旋桨的叶片巨大且跨度宽，使得轮毂上的螺纹位置极难接近。此外，坚硬的高强度镍铝青铜材料极难加工。NORIS INNENSPAN MODULAR刀具设计提供了一种经济高效的解决方案，以实现所需的悬伸长度。结合优化的切削几何槽型，容屑腔内的集屑功能确保了生产过程的安全可靠。

The massive, wide-spanning blades of marine propellers make the thread locations on the hub extremely difficult to access. Additionally, the tough, high-strength nickel-aluminum bronze is highly difficult to machine. The NORIS INNENSPAN MODULAR tool design delivers a cost-effective solution to achieve the necessary overhang lengths. Combined with optimized cutting geometry, the integrated chip evacuation in the cutting crown ensures a safe and reliable production process.





NORIS INNENSPAN MOD

尺寸	M 120x4-ISO 2X	Size	M 120x4-ISO 2X
材料	CuAl9Fe4	Material	CuAl9Fe4
加工方向	水平	Working direction	Horizontal
刀柄	攻丝刀柄	Adaptor	Tapping chuck
切削液	攻丝膏	Lubricant	Cutting paste
切削速度	5 m/min	Cutting speed	5 m/min
螺纹形状	盲孔螺纹	Thread form	Blind hole thread
螺纹深度	180 mm	Thread depth	180 mm

您的获益 | YOUR BENEFITS

- 通用且优化 | Universal and optimized**
 模块化刀具设计易于调整，能够以合理的成本从标准工具长度无缝扩展到专用配置。
 The modular tool design offers easy adaptability, seamlessly scaling from standard tool lengths to specialized configurations at reasonable costs.
- 刀具使用寿命长 | Long tool life**
 坚固的几何形状和耐磨表面确保了刀具寿命长，并降低了加工成本。
 Robust geometry and a wear-resistant surface ensure a long tool life and reduced tooling costs.
- 安全性 | Safe**
 容屑腔内的集屑功能确保了安全和洁净的生产过程，以及精准的螺纹加工尺寸。
 Chip removal in the cutting crown ensures a safe production and clean, dimensionally accurate threads.



提高大尺寸螺纹的加工效率

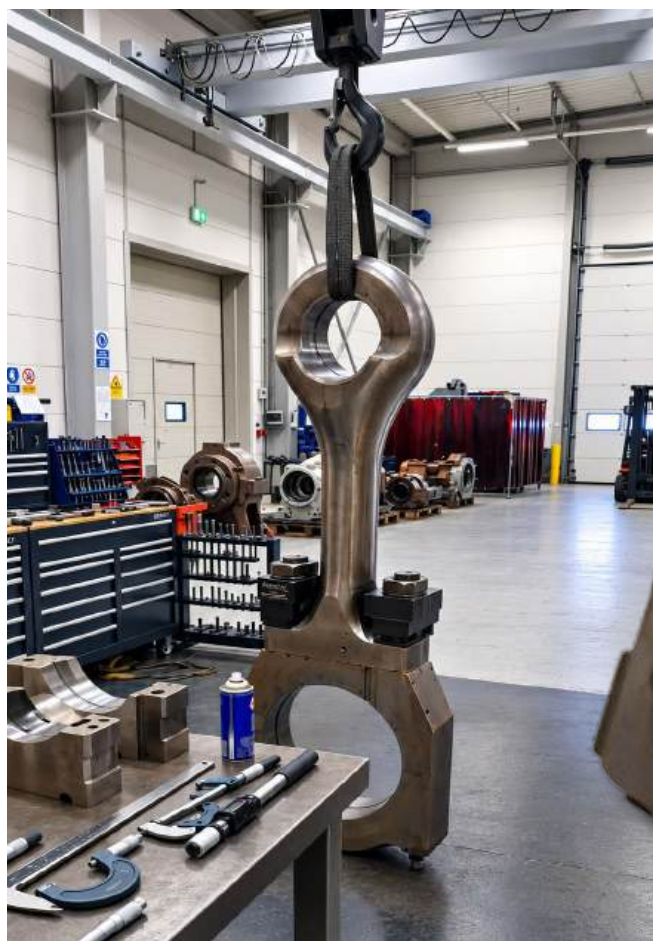
INCREASING PRODUCTIVITY FOR LARGE THREADS

在制造船用柴油机的连杆时，需要既精确又经济高效的加工。特别是对于大螺纹和具有挑战性的材料，对刀具寿命和工艺稳定性提出了很高的要求。

NORIS NES可转位刀片系统通过特别高效的螺纹加工优化了这些应用。使用具有多个切削刃的可转位刀片可显著延长刀具寿命，从而提高成本效益。坚固的刀具设计还保证了在高切削力下进行可靠的加工。一个关键优势是，磨损的切削刃可以快速轻松地更换，而无需更换整个刀具。

In the manufacture of con-rods for ship diesel engines require machining that is both, precise and cost-effective. Particularly large threads and challenging materials place high demands on tool life and process stability.

The NORIS NES indexable insert system optimises these applications through particularly efficient thread machining. The use of indexable inserts with multiple cutting edges significantly increases tool life, thereby improving cost-effectiveness. The robust tool design also guarantees reliable machining under high cutting forces. A key advantage is that worn cutting edges can be replaced quickly and easily without having to change the entire tool.





NORIS NES

尺寸	M36	Size	M36
材料	42CrMo4	Material	42CrMo4
加工方向	立式	Working direction	Vertical
切削液	乳化液	Lubricant	Emulsion
切削速度/fz	230 m/min / 0,13mm	Cutting speed/fz	230 m/min / 0,13mm
螺纹形状	盲孔螺纹	Thread form	Blind hole thread
螺纹深度	55 mm	Thread depth	55 mm

您的获益 | YOUR BENEFITS

- 高性价比 | High cost-effectiveness**
 每个刀片具有多个切削刃可显著降低刀具成本。
 Multiple cutting edges per insert significantly reduce tooling costs.
- 最大灵活性 | Maximum flexibility**
 无需更换刀具即可快速更换切削刀片。
 Quick change of cutting inserts without changing tools.
- 高工艺稳定性 | High process stability**
 即使在大直径和高负载的情况下，也能实现可靠的螺纹切削。
 Reliable thread cutting even with large diameters and high loads.





承重结构中的可靠螺纹

RELIABLE THREADS IN HEAVY DUTY CRANE COMPONENTS

在起重机制造中，由高强度钢材制成的大型结构部件需要进行螺纹加工，这些螺纹需能承受极端的静态和动态载荷。这些材料对工具的稳定性和耐磨性提出了极高的要求。

得益于其坚固的几何槽型和高性能涂层，NORIS SALOREX UNI S非常适合通用用途。其优化的排屑槽可确保可靠的排屑效果，即使在复杂的工件几何形状下也能保持稳定的切削条件。这使其成为结构部件的完美工具，在这些结构零件攻丝中，始终保持高螺纹质量和工艺可靠性至关重要。

In crane construction, large-scale structural components made from high-strength steels require threading that can withstand extreme static and dynamic loads. These materials place the highest demands on tool stability and wear resistance.

Thanks to its robust geometry and high-performance coating, the NORIS SALOREX UNI S is ideally suited for universal use. Its optimised flute ensures reliable chip evacuation and maintains stable cutting conditions even with complex component geometries. This makes it the perfect tool for structural components where consistently high thread quality and process reliability are essential.



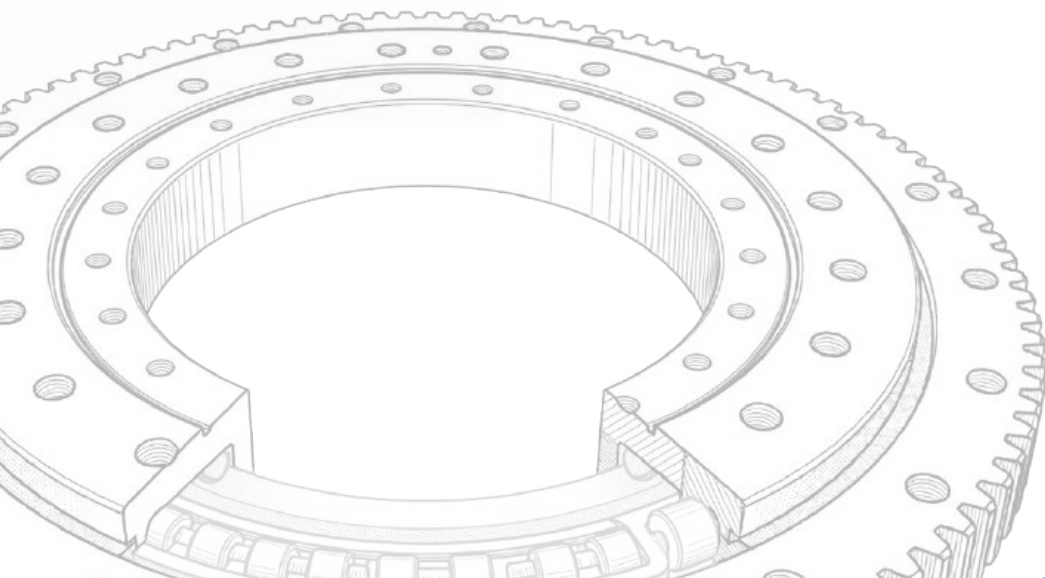


NORIS SALOREX UNI CNC S

尺寸	M36	Size	M36
材料	Q355D-Z25	Material	Q355D-Z25
加工方向	水平	Working direction	Horizontal
刀柄	攻丝刀柄	Adaptor	Tapping chuck
切削液	乳化液	Lubricant	Emulsion
切削速度	6,8 m/min	Cutting speed	6,8 m/min
螺纹形状	盲孔螺纹	Thread form	Blind hole thread
螺纹深度	72 mm	Thread depth	72 mm

您的收益 | YOUR BENEFITS

- 适合普遍使用 | Suitable for universal use**
 适用于起重机结构中使用的各种材料。
 Suitable for a variety of materials used in crane construction.
- 刀具使用寿命长 | Long tool life**
 耐磨涂层确保工具经久耐用。
 A wear-resistant coating ensures long-lasting tools.
- 稳定加工 | Stable machining**
 即使在加工复杂部件时，也能确保可靠的切屑去除，保障加工安全。
 Reliable chip removal for safe processes, even with complex components.



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符号说明

SYMBOL EXPLANATION

通用

GENERAL

	订货号 Order number
	最大深度1.5xD Usable length 1,5xD
	最大深度2xD Usable length 2xD
	最大深度3xD Usable length 3xD
	最大深度4xD Usable length 4xD
	同步CNC数控加工用的优化型丝锥 Optimized tools for the synchronous CNC machining
	加长和超长凹槽的丝锥，用于加工深孔螺纹和低底螺纹 Taps with over length and extra long grooves for the manufacture of deep and low based threads.
	锥形阶梯状导向螺纹-背齿 Conically stepped guide thread

机用丝锥 和 螺纹铣刀

MACHINE TAPS & THREAD MILLS

	通孔 Through hole
	通孔 和 盲孔 Through hole & Blind hole
	盲孔 Blind hole
	带有中心出水冷却孔的MKB丝锥 MKB Tools with internal coolant bore
	攻丝底孔直径 Tap drill diameter
	螺纹牙型角为55° Thread profile with 55° profile angle
	螺纹牙型角为60° Thread profile with 60° profile angle
	内螺纹 Internal threads
	圆螺纹 Round thread
	锯齿螺纹 Buttress thread

螺纹铣刀

THREAD MILLS

	梯形螺纹, ACME螺纹 Trapezoidal thread, ACME thread
	可转位刀片, 带有2个切削刃 Indexable insert with 2 cutting edges
	可转位刀片, 带有4个切削刃 Indexable insert with 4 cutting edges
	内六角螺丝 Hexagon socket screw
	内六角螺丝头 Hexagon socket screw head
	沿着丝锥柄部的MKN冷却供应 MKN Coolant supply along the tool shank

攻丝刀柄

TAP HOLDERS

	钻孔和沉头孔 Drilling and countersinking
	密封盘 Sealing disks
	压点机制 Pressure-point mechanism
	夹紧范围扩大 Extended clamping range
	最大冷却液压力 50 巴 Max. Coolant pressure 50 bar
	长度补偿 Length compensation
	最小长度补偿 Minimal length compensation
	快换夹头 Quick-change adapter
	锁紧螺母 Clamping nut
	夹套 Collet
	通过IE型快换夹头进行刀具适配 Tool adaptation by means of quick-change adapters type IE
	沿着丝锥柄部的MKBA冷却供应 MKBA Coolant supply along the tool shank
	前端释放 Front release



分类汇总

列出的切削速度 (VC, 单位为M/MIN) 为标准值.
该值必须根据实际加工情况进行调整

- ● 非常合适的 • VERY SUITABLE
- 合适的 • SUITABLE
- 有条件适合 • CONDITIONALLY SUITABLE



SUMMARY OF ASSORTMENT

THE LISTED CUTTING DATA ARE STANDARD VALUES.
THIS VALUES HAVE TO BE ADJUSTED TO INDIVIDUAL WORK
CONDITIONS.



P	钢材材料	STEEL MATERIALS
	非合金钢和低合金钢	Unalloyed and low-alloy steels
	高合金钢	High alloy steels
M	耐腐蚀和耐酸钢	CORROSION AND ACID PROOF STEELS
	奥氏体不锈钢+双相不锈钢	Stainless austenitic steels + DUPLEX steels
K	铸件材料	CAST MATERIALS
	铸铁、球墨铸铁、蠕墨铸铁、可锻铸铁	Cast iron, nodular cast iron, Vermicular graphite cast iron, malleable cast iron
	奥氏素体铸铁 (ADI) + 硬质铸件	Ausferritic cast iron (ADI) + Hard casting
N	有色金属材料	NON FERROUS MATERIALS
	锻铝合金	Aluminium wrought alloys
	铸铝合金	Aluminium cast alloys
	黄铜+铜合金 (长屑)	Copper + Copper alloys (long-chip.)
	铜合金 (短屑)	Copper alloys (short-chip.)
	高强度铜合金	High-strength copper alloys
	锌合金	Zinc alloys
	锻镁合金	Magnesium wrought alloys
	热塑性塑料	Thermoplastics
	纤维增强合成材料+热固性塑料	Fibre-reinforced synthetics + Duroplastics
S	特殊材料	SPECIAL MATERIALS
	镍基/铁基/钴基合金	Ni-, Fe- or Co-based superalloys
	钛+钛合金	Titanium + Titanium alloys
H	淬硬钢	HARDENED STEELS
	淬硬钢	Hardened steels

UNI CNC



S

ST CNC



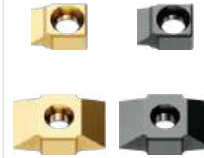
ELF

ST CNC



ELF

RA15

加工时间
TIME ADVANTAGE

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••

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•

灵活性
FLEXIBILITY

••

•

加工可靠性
PROCESS RELIABILITY

○

•

••

••

修磨服务
REGRINDING SERVICE

○

•

••

••

螺纹加工质量
THREAD QUALITY

•

○

○

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表面处理和涂层 · SURFACE	ALTINHD	TIN	TICN	VAP	TIN	TIALN		
材料 · MATERIAL	HSSE	HSSE	HSSE	HSSE	K20	K20		
M	20	21	21	22	28	28	26	26
MF				22	28	28	26	26
UNC					28	28	26	26
UNF					28	28	26	26
G					28	28	26	26

MAT.				Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]		fz [mm]	
≤ 800N/mm²	P1.1			10- 18	10- 18	10- 18	6- 12	200- 350	250- 400	0,15- 0,30	0,15- 0,30
≤ 1200N/mm²	P1.2	💧	💧	6- 10	6- 10	6- 10	2- 6	150- 250	200- 300	0,10- 0,25	0,10- 0,25
≤ 1400N/mm²	P1.3	💧	💧	4- 8				100- 150	150- 200	0,06- 0,12	0,06- 0,12
≤ 1400N/mm²	P2.1	💧	💧	2- 10	2- 10	2- 10		80- 160	100- 180	0,08- 0,12	0,08- 0,12
				Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]		fz [mm]	
≤ 800N/mm²	M1.1	💧	💧	6- 10	6- 10		2- 6	80- 120	80- 120	0,06- 0,12	0,06- 0,12
≤ 1300N/mm²	M1.2	💧	💧	2- 6	2- 6			50- 100	50- 100	0,04- 0,10	0,04- 0,10
				Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]		fz [mm]	
≤ 800N/mm²	K1.1	💧	🔧	10- 20	10- 20	10- 20		200- 350	250- 400	0,15- 0,30	0,15- 0,30
≤ 1400N/mm²	K2.1	💧	🔧					100- 250	150- 300	0,08- 0,12	0,08- 0,12
				Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]		fz [mm]	
	N1.1	💧						300- 500	300- 500	0,15- 0,30	0,15- 0,30
≤ 12%Si	N1.2	💧		15- 20	15- 20	15- 20		300- 500	300- 500	0,15- 0,30	0,15- 0,30
≥ 12%Si	N1.3							250- 350	300- 450	0,15- 0,25	0,15- 0,25
	N2.1	💧		15- 20	15- 20	15- 20		300- 400	300- 400	0,15- 0,30	0,15- 0,30
	N2.2	💧	🔧	20- 30	20- 30	20- 30		300- 400	300- 400	0,15- 0,30	0,15- 0,30
≥ 800N/mm²	N2.3	💧	💧		6- 12			100- 250	150- 300	0,08- 0,12	0,08- 0,12
	N3.1	💧		20- 30	20- 30	20- 30		300- 400	300- 400	0,15- 0,30	0,15- 0,30
	N4.1	🔧		15- 20	15- 20	15- 20		300- 400	300- 400	0,15- 0,30	0,15- 0,30
	N5.1	🔧	💧					300- 400	300- 400	0,15- 0,30	0,15- 0,30
	N5.2	🔧						250- 350	250- 350	0,15- 0,30	0,15- 0,30
				Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]		fz [mm]	
≤ 800N/mm²	S1.1	💧						60- 120	60- 120	0,06- 0,10	0,06- 0,10
≤ 1600N/mm²	S1.2	💧						50- 80	50- 80	0,04- 0,08	0,04- 0,08
≤ 800N/mm²	S2.1							80- 140	80- 140	0,08- 0,12	0,08- 0,12
≤ 1300N/mm²	S2.2	💧						60- 100	60- 100	0,06- 0,10	0,06- 0,10
				Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]	Vc [m/min]		fz [mm]	
≤ 55HRc	H1.1	💧						30- 60	30- 60	0,04- 0,08	0,04- 0,08
≤ 63HRc	H1.2	💧									
≤ 65HRc	H1.3	💧									

01

机用丝锥
MACHINE TAPS





3xD

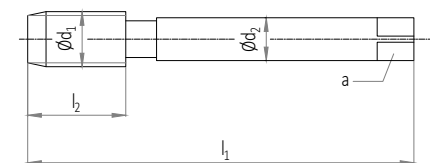
CNC

NORIS SALOREX

UNI CNC S



S



表面处理和涂层 · SURFACE

ALTINHD

材料 · MATERIAL

HSSE

切削锥类型 · CHAMFER FORM

C / 2-3

公差 · TOLERANCE

ISO2

RH

	d_1	P		l_1	l_2	l_3	$\varnothing d_2$	a
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
M 20	20	2,5	17,5	140	25	-	16	12
M 22	22	2,5	19,5	140	27	-	18	14,5
M 24	24	3	21	160	30	-	18	14,5
M 27	27	3	24	160	30	-	20	16
M 30	30	3,5	26,5	180	35	-	22	18
M 33	33	3,5	29,5	180	35	-	25	20
M 36	36	4	32	200	40	-	28	22
M 39	39	4	35	200	40	-	32	24
M 42	42	4,5	37,5	200	45	-	32	24
M 45	45	4,5	40,5	220	45	-	36	29
M 48	48	5	43	250	50	-	36	29
M 52	52	5	47	250	50	-	40	32

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7655.0B090136

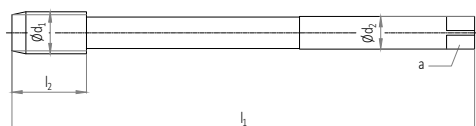
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7655.0B090152



NORIS SL15
ST CNC ELF MKB



NORIS TWIN
ST CNC ELF MKB



表面处理和涂层 · SURFACE

TIN

TICN

材料 · MATERIAL

HSSE

HSSE

切削锥类型 · CHAMFER FORM

C / 2-3

C / 2-3

公差 · TOLERANCE

ISO2X

ISO2X

RH

RH

	d_1	P		l_1	l_2	l_3	$\varnothing d_2$	a
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
M 20	2,5	17,5	190	25	-	16	12	
M 22	2,5	19,5	230	27	-	18	14,5	
M 24	3	21	240	30	-	18	14,5	
M 27	3	24	250	30	-	20	16	
M 30	3,5	26,5	270	35	-	22	18	
M 33	3,5	29,5	290	35	-	25	20	
M 36	4	32	310	40	-	28	22	
M 39	4	35	320	40	-	32	24	
M 42	4,5	37,5	340	45	-	32	24	
M 45	4,5	40,5	360	45	-	36	29	
M 48	5	43	380	50	-	36	29	
M 52	5	47	400	50	-	40	32	



984C.0B040120

981C.0B050120

984C.0B040122

981C.0B050122

984C.0B040124

981C.0B050124

984C.0B040127

981C.0B050127

984C.0B040130

981C.0B050130

984C.0B040133

981C.0B050133

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984C.0B040142

981C.0B050142

984C.0B040145

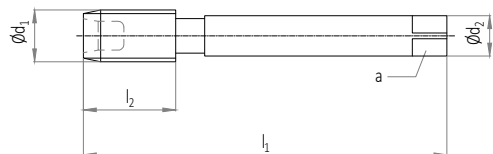
981C.0B050145



1,5xD



2xD



NORIS INNENSPAN

RA15



表面处理和涂层 · SURFACE	VAP
材料 · MATERIAL	HSSE
切削锥类型 · CHAMFER FORM	C / 2-3
公差 · TOLERANCE	ISO2X
	RH

	d1	P		l1	l2	l3	Ø d2	a	
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	
DIN 376	M 30	3,5	26,5	180	40	-	22	18	7682.OB010130
	M 33	3,5	29,5	180	40	-	25	20	7682.OB010133
	M 36	4	32	200	50	-	28	22	7682.OB010136
	M 39	4	35	200	50	-	32	24	7682.OB010139
	M 42	4,5	37,5	200	56	-	32	24	7682.OB010142
	M 45	4,5	40,5	220	58	-	36	29	7682.OB010145
	M 48	5	43	250	65	-	36	29	7682.OB010148
	M 52	5	47	250	65	-	40	32	7682.OB010152
	M 56	5,5	50,5	250	70	-	40	32	7682.OB010156
	M 60	5,5	54,5	280	70	-	45	35	7682.OB010160
	M 64	6	58	315	75	-	50	39	7682.OB010164
	M 68	6	62	315	78	-	50	39	7682.OB010168

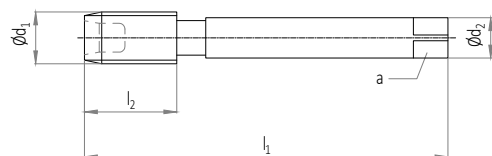
	d1	x	P		l1	l2	l3	Ø d2	a	
	[mm]		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	
DIN 374	MF 30	x	1,5	28,5	150	28	-	22	18	7682.OB010490
	MF 30	x	2	28	150	28	-	22	18	7682.OB010491
	MF 33	x	1,5	31,5	160	30	-	25	20	7682.OB010511
	MF 33	x	2	31	160	30	-	25	20	7682.OB010512
	MF 36	x	1,5	34,5	170	30	-	28	22	7682.OB010532
	MF 36	x	2	34	170	30	-	28	22	7682.OB010533
	MF 36	x	3	33	200	42	-	28	22	7682.OB010534
	MF 38	x	1,5	36,5	170	30	-	28	22	7682.OB010546
	MF 39	x	3	36	200	42	-	32	24	7682.OB010555
	MF 40	x	2	38	170	30	-	32	24	7682.OB010561
	MF 42	x	1,5	40,5	170	30	-	32	24	7682.OB010574
	MF 42	x	2	40	170	30	-	32	24	7682.OB010575
	MF 42	x	3	39	200	45	-	32	24	7682.OB010576
	MF 45	x	3	42	200	45	-	36	29	7682.OB010597
	MF 48	x	1,5	46,5	190	32	-	36	29	7682.OB010616
	MF 48	x	2	46	190	32	-	36	29	7682.OB010617
	MF 48	x	3	45	225	50	-	36	29	7682.OB010618
	MF 52	x	3	49	225	50	-	40	32	7682.OB010646
	MF 56	x	3	53	225	50	-	40	32	7682.OB010661



1,5xD



2xD



NORIS INNENSPAN

RA15



表面处理 and 涂层 · SURFACE

VAP

材料 · MATERIAL

HSSE

切削锥类型 · CHAMFER FORM

C / 2-3

公差 · TOLERANCE

ISO2X

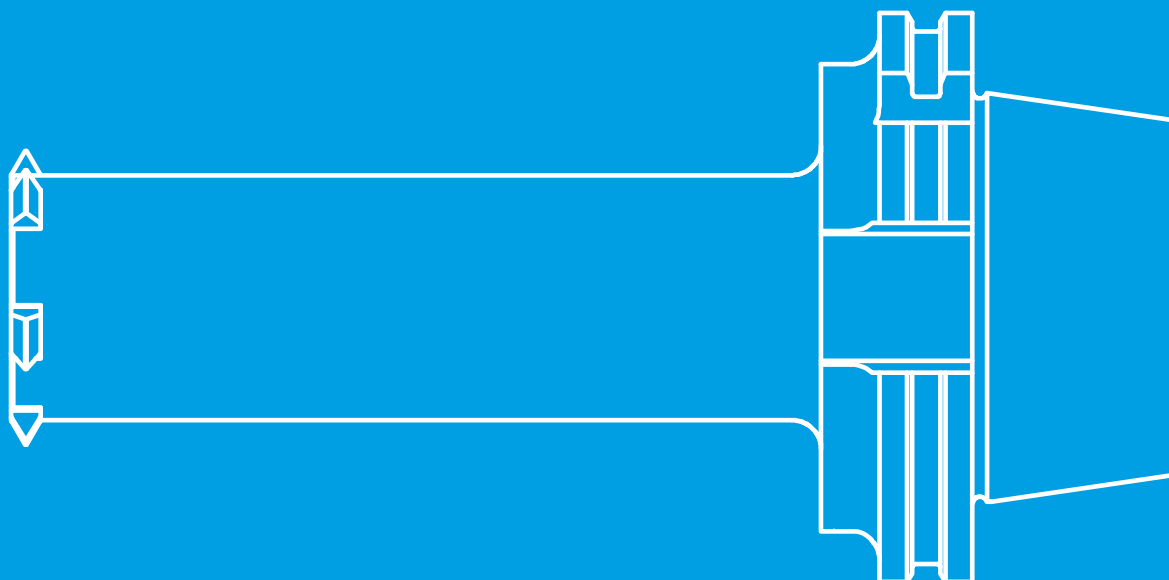
RH

	d_1	x	P		l_1	l_2	l_3	$\varnothing d_2$	a	
	[mm]		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	
DIN 374	MF 56	x	4	52	250	60	-	40	32	7682.0B010662
	MF 60	x	4	56	280	60	-	45	35	7682.0B010672
	MF 64	x	3	61	275	55	-	50	39	7682.0B010681
	MF 64	x	4	60	315	65	-	50	39	7682.0B010682
	MF 68	x	4	64	315	65	-	50	39	7682.0B010692
	MF 70	x	3	67	275	55	-	50	39	7682.0B010696
	MF 70	x	4	66	340	65	-	50	39	7682.0B010697
	MF 72	x	3	69	275	55	-	50	39	7682.0B010702
	MF 72	x	4	68	340	65	-	50	39	7682.0B010703
	MF 72	x	6	66	340	80	-	50	39	7682.0B010704
	MF 76	x	3	73	275	55	-	50	39	7682.0B010714
	MF 76	x	4	72	340	65	-	50	39	7682.0B010715
	MF 76	x	6	70	340	80	-	50	39	7682.0B010716
	MF 80	x	4	76	360	65	-	50	39	7682.0B010727
	MF 80	x	6	74	360	80	-	50	39	7682.0B010728
	MF 85	x	3	82	325	60	-	50	39	7682.0B010736
	MF 85	x	4	81	380	70	-	50	39	7682.0B010737
	MF 85	x	6	79	380	80	-	50	39	7682.0B010738
	MF 90	x	3	87	325	60	-	50	39	7682.0B010746
	MF 90	x	4	86	380	70	-	50	39	7682.0B010747
	MF 90	x	6	84	380	80	-	50	39	7682.0B010748
	MF 95	x	6	89	400	85	-	56	44	7682.0B010758
	MF 100	x	4	96	400	70	-	56	44	7682.0B010767
	MF 100	x	6	94	400	85	-	56	44	7682.0B010768
	MF 110	x	6	104	400	85	-	56	44	7682.0B010788
	MF 115	x	3	112	350	65	-	56	44	7682.0B010791
	MF 120	x	4	116	400	75	-	56	44	7682.0B010797
	MF 120	x	6	114	400	90	-	56	44	7682.0B010798

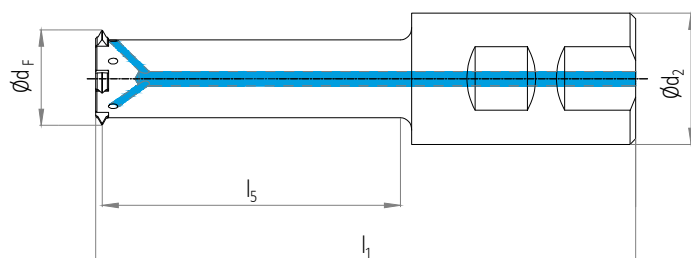
交货时间根据实际需求
Delivery time on request.

02

螺纹铣刀
THREAD MILLS



M DIN 13 | MF DIN 13 | UN ASME B1.1 | G (BSP) DIN EN ISO 228



NORIS NES
MKBR

NORIS NES-TS
MKBR



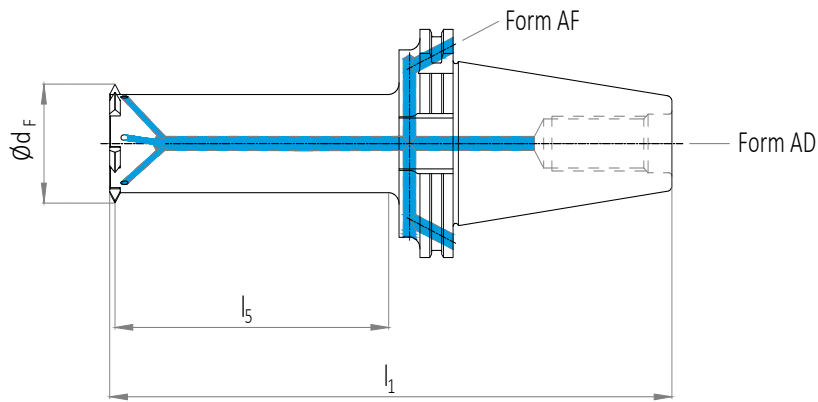
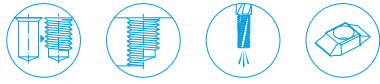
	M MF		UN UNC UNF		G				$\varnothing d_F$	l_1	l_5	$\varnothing d_2$	z			
	$\varnothing d_{1 \min}$	P	$\varnothing d_{1 \min}$	Gg/1"	$\varnothing d_{1 \min}$	Gg/1"										
	[mm]	[mm]	[inch]	[tpi]	[mm]	[tpi]			[mm]	[mm]	[mm]	[mm]				
DIN 1835-1 B+E	≥ M 20	1,5 - 3	≥ UNC 3/4	16 - 9	≥ G 1/2	28 - 9	F521	-	16,5	100	45	20	2	M2,5	F501F0003	
	≥ M 22	2,5 - 3,5	≥ UNC 7/8	10 - 7	-	-	F522	-	18	100	45	20	2	M2,5	F501F0003	
	≥ M 20	1,5 - 3	≥ UNC 3/4	16 - 9	≥ G 1/2	28 - 9	F521	-	16,5	114	60	20	2	M2,5	F501F0005	
	≥ M 22	2,5 - 3,5	≥ UNC 7/8	10 - 7	-	-	F522	-	18	114	60	20	2	M2,5	F501F0005	
	≥ M 24	1,5 - 3	≥ UNC 1"	16 - 9	≥ G 5/8	28 - 9	F521	-	20,5	100	50	16	3	M2,5	F501F0019	
	≥ M 27	2,5 - 3,5	≥ UNC 1"	10 - 7	-	-	F522	-	22	100	50	16	3	M2,5	F501F0019	
	≥ M 27	1 - 4	≥ UNC 1 1/8	24 - 6	≥ G 3/4	28 - 9	-	F510	23,85	124	60	32	3	M2,5	F501AANAA	
	≥ M 27	1 - 4	≥ UNC 1 1/8	24 - 6	≥ G 3/4	28 - 9	-	F510	23,85	140	80	25	3	M2,5	F501F0011	
	≥ M 27	1 - 4	≥ UNC 1 1/8	24 - 6	≥ G 3/4	28 - 9	-	F510	23,85	144	80	32	3	M2,5	F501AARAA	
	≥ M 27	1 - 4	≥ UNC 1 1/8	24 - 6	≥ G 3/4	28 - 9	-	F510	23,85	154	90	32	3	M2,5	F501AA8AA	
	≥ M 33	1 - 4	≥ UNC 1 1/4	24 - 6	≥ G 1"	28 - 9	-	F510	29,27	159	95	32	3	M2,5	F501E0841	
	≥ M 39	1,5 - 5,5	≥ UNC 1 1/2	16 - 4,5	≥ G 1 1/8	28 - 9	-	F511	32,85	155	95	25	3	M3	F501F0012	
	≥ M 39	1,5 - 5,5	≥ UNC 1 1/2	16 - 4,5	≥ G 1 1/8	28 - 9	-	F511	32,85	159	95	32	3	M3	F501AAPAA	
	≥ M 39	1,5 - 5,5	≥ UNC 1 1/2	16 - 4,5	≥ G 1 1/8	28 - 9	-	F511	32,85	179	115	32	3	M3	F501F0007	
	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	173	110	32	4	M4	F501F0013	
	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	208	145	32	4	M4	F501F0010	
DIN 1835-1 B+E	M MF		UN UNC UNF		G				$\varnothing d_F$	l_1	l_5	$\varnothing d_2$	z			
	$\varnothing d_{1 \min}$	P	$\varnothing d_{1 \min}$	Gg/1"	$\varnothing d_{1 \min}$	Gg/1"										
	[mm]	[mm]	[inch]	[tpi]	[mm]	[tpi]										
	≥ M 24	1,5 - 3	≥ UNC 1"	16 - 9	≥ G 5/8	28 - 9	F521	-	20,5	100	50	16	4	M2,5		F701F0016
	≥ M 27	2,5 - 3,5	≥ UNC 1"	10 - 7	-	-	F522	-	22	100	50	16	4	M2,5		F701F0016
DIN 1835-1 B+E	≥ M 27	2,5 - 4,5	≥ UNC 1 1/8	10 - 6	-	-	F710	-	23,85	124	60	32	5	M2,5		F701F0015
	≥ M 33	2,5 - 4	≥ UNC 1 1/4	10 - 6	-	-	-	F750	27	153	90	32	5	M2,5		F701F0003
	≥ M 39	2,5 - 5,5	≥ UNC 1 1/2	10 - 4,5	-	-	F711	-	32,85	179	115	32	5	M3		F701F0001

M DIN 13

MF DIN 13

UN ASME B1.1

G (BSP) DIN EN ISO 228



NORIS NES

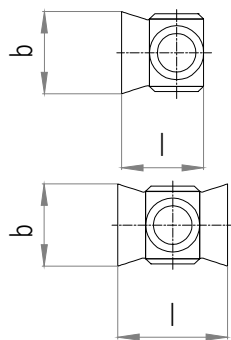
MKBR

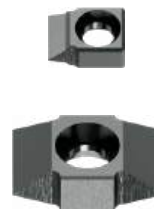


	M MF		UN UNC UNF		G													
	$\varnothing d_{1 \min}$ [mm]	P [mm]	$\varnothing d_{1 \min}$ [inch]	Gg/1" [tpi]	$\varnothing d_{1 \min}$ [mm]	Gg/1" [tpi]												
DIN ISO 7388-1 AD/AF	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	212	110	SK40	4	M4			F505AADAA	
	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	245	110	SK50	4	M4			F505AADAC	
	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	247	145	SK40	4	M4			F505AAWAA	
	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	280	145	SK50	4	M4			F505AAWAB	
	≥ M 60	1,5 - 6	≥ UNC 2 1/4	16 - 4	≥ G 2"	12 - 3,5	-	F513	52,55	286	150	SK50	4	M5			F505AAEAB	
	≥ M 60	1,5 - 6	≥ UNC 2 1/4	16 - 4	≥ G 2"	12 - 3,5	-	F513	52,55	331	195	SK50	4	M5			F505F0007	
	≥ M 72	1,5 - 6	≥ UNC 3"	16 - 4	≥ G 2 1/2	12 - 3,5	-	F513	66,55	308	170	SK50	7	M5			F505AACAA	
	≥ M 72	1,5 - 6	≥ UNC 3"	16 - 4	≥ G 2 1/2	12 - 3,5	-	F513	66,55	398	260	SK50	7	M5			F505E5553	
	≥ M 120	6 - 8	≥ UNC -	4 - -	- - -	- - -	-	F514	92	341	204	SK50	7	M5			F505AA2AA	
DIN ISO 7388-2 JD	≥ M 120	6 - 8	≥ UNC -	4 - -	- - -	- - -	-	F514	92	497	360	SK50	7	M5			F505F0008	
	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	264	110	BT50	4	M4			F505AADAF	
	≥ M 48	1,5 - 6	≥ UNC 1 3/4	16 - 4	≥ G 1 1/4	12 - 4,5	-	F512	40,25	299	145	BT50	4	M4			F505F0025	
	≥ M 60	1,5 - 6	≥ UNC 2 1/4	16 - 4	≥ G 2"	12 - 3,5	-	F513	52,55	305	150	BT50	4	M5			F505F0031	
	≥ M 60	1,5 - 6	≥ UNC 2 1/4	16 - 4	≥ G 2"	12 - 3,5	-	F513	52,55	350	195	BT50	4	M5			F505F0026	
	≥ M 72	1,5 - 6	≥ UNC 3"	16 - 4	≥ G 2 1/2	12 - 3,5	-	F513	66,55	327	170	BT50	7	M5			F505F0042	
	≥ M 72	1,5 - 6	≥ UNC 3"	16 - 4	≥ G 2 1/2	12 - 3,5	-	F513	66,55	417	260	BT50	7	M5			F505F0034	
	≥ M 72	1,5 - 6	≥ UNC 3"	16 - 4	≥ G 2 1/2	12 - 3,5	-	F513	66,55	417	260	BT50	7	M5			F505F0034	



根据需求，可提供其他螺纹标准和特殊牙型
Other thread standards and special profiles upon request


NORIS WP
UNI

NORIS WP
UNI


表面处理 and 涂层 · SURFACE								TIN	TIALN
材料 · MATERIAL								K20	K20
M MF UN			P [mm]	 Gg/1" [tpi]	l [mm]	b [mm]	h [mm]		
	F521		1,5 - 3	16 - 9	7	5	3,18	F521F0002	F521F0004
	F522		2,5 - 3,5	10 - 7	7,8	5	3,18	F522F0001	F522F0002
		F510	1 - 2,5	24 - 10	9,52	6,35	3,3		F510F0012
		F510	1,5 - 2,5	16 - 10	9,52	6,35	3,3	F510AAAAA	F510F0003
		F510	2,5 - 4	10 - 6	9,52	6,35	3,3	F510AABAA	F510F0004
		F511	1,5 - 2,5	16 - 10	13,5	8,5	3,97	F511AAAAA	F511F0001
		F511	2,5 - 5,5	10 - 4,5	13,5	8,5	3,97	F511AABAA	F511F0002
		F512	1,5 - 3	16 - 9	15,5	9,5	5	F512AAAAA	F512F0001
		F512	3 - 6	9 - 4	15,5	9,5	5	F512AABAA	F512F0002
		F513	1,5 - 3	16 - 9	19	12,5	6	F513AAAAA	F513F0001
		F513	3 - 6	9 - 4	19	12,5	6	F513AABAA	F513F0002
		F514	6 - 8	4	28,58	14,3	9,5	F514AAAAA	F514F0005
	F710		2,5 - 4,5	10 - 6	9,52	5	3,3		F710F0001
		F750	2,5 - 4	10 - 6	9,52	5	3,3		F750F0002
	F711		2,5 - 5,5	10 - 4,5	10	7	3,97		F711F0001
G W				 Gg/1" [tpi]	l [mm]	b [mm]	h [mm]		
	F521		-	28 - 9	7	5	3,18	F521F0005	F521F0008
		F510	-	28 - 9	9,52	6,35	3,3	F510AACAA	F510F0005
		F511	-	28 - 9	13,5	8,5	3,97	F511AACAA	F511F0003
		F512	-	12 - 4,5	15,5	9,5	5	F512AACAA	F512F0003
		F513	-	12 - 3,5	19	12,5	6	F513AACAA	F513F0003



根据需求，可提供其他螺纹标准和特殊牙型
Other thread standards and special profiles upon request

NORIS NES
螺丝 · SCREW



NORIS
螺丝刀 · SCREWDRIVER



					M_d [Nm]	
M2,5	x	8,5	7 IP	0,9	F550F0001	1033F0001
M3	x	11	9 IP	2,5	F550F0002	1033F0002
M4	x	13	15 IP	5,5	F550F0003	1033F0003
M5	x	15	20 IP	8	F550F0004	1033F0004

拧紧螺栓时，必须遵守推荐的扭矩值
When tightening the screw, the recommended torque must be used

适用于苛刻条件的模块化系统

MODULAR SYSTEMS FOR DEMANDING CONDITIONS

NORIS INNENSPAN | TWIN MODULAR

灵活适用于从M52-M120的大螺纹加工-标准产品
各种不同标准的螺纹 M|MF|G|UNC|UN, 还可根据需求非
标定制

- 悬伸长度可变: 一个安装柄, 装载多种不同应用丝锥头
- 经济高效: 模块化设计, 而不用购买整套全新刀具
- 非标定制解决方案: 完全适应您的需求
- NORIS品质: 即使对于最大的螺纹尺寸, 也能保持最高的精度

Flexibility for large threads from M52 to M120—standardized.
Variants for M|MF|G|UNC|UN, customizable to meet individual
needs.

- Variable overhang lengths: One mounting shaft, multiple applications
- Cost-effectiveness: Modular design instead of purchasing a completely new unit
- Custom solutions: Fully adaptable to your requirements
- NORIS quality: Highest precision even for the largest thread sizes



有人说, “这不可能做到。”我们则问, “哪种解决方案最适合你?”

请通过L.tong@noris-reime.com.cn联系我们

NORIS NES-SYSTEM MODULAR

适用于M20及以上大螺纹的模块式螺纹铣削系统——经济高效、功能多样且精确。

- 适用于所有直径和螺距：一套系统满足各种尺寸需求
- 高表面质量：一次加工即可实现高精度螺纹
- 经济高效：由于采用了多个可转位刀片，加工时间大幅缩短
- 应用广泛：能够加工所有常见材料
- 模块化且灵活：可适应不同的螺纹深度和直径

The modular circular thread milling system for large threads starting at M20—cost-effective, versatile, and precise.

- Across all diameters and pitches: One system for various dimensions
- High surface quality: Precise threads in a single pass
- Cost-effectiveness: Short machining times thanks to multiple indexable inserts
- Versatile application: Capable of machining all common materials
- Modular & flexible: Adaptable to different thread depths and diameters



有人说，“这不可能做到。”我们则问，“哪种解决方案最适合你？”

请通过L.tong@noris-reime.com.cn联系我们



刀柄类型 · SHANK		DIN 1835-1 B+E	HSK-A DIN 69893-1	DIN 228-1 B
夹持范围 · RANGE		M1- M48 (7/8- 1 3/4)	M1- M48 (7/8- 1 3/4)	M1- M48 (7/8- 1 3/4)
页数 · PAGE		36	36	36
应用范围 · APPLICATION RANGE	适用于配备同步主轴的机床 For use on machines with synchronous spindle	○	○	○
	适用于其他类型的机床 For use on other machine tools	● ●	● ●	● ●
	适用于摇臂钻 For use on pillar drilling machines	●	●	●
冷却和润滑 COOLING AND LUBRICATION				
功能 FUNCTIONS				
夹套 ADAPTATION				

- ●

非常合适的 • VERY SUITABLE
- 合适的 • SUITABLE
- 有条件适合 • CONDITIONALLY SUITABLE

NORIS HELIXPRO



DIN 1835-1 B+E	HSK-A DIN 69893-1	HSK-A DIN 69893-1
M0,5- M30 (Nr.0- 1 1/8)	M0,5- M48 (Nr.0- 1 3/4)	M45- M76 (1 3/8- 2 3/8)
37	37	37
• •	• •	•



NORIS ISP



DIN 2080-1	DIN 228-1 B
M24- M160 (1" - 3 1/2)	
38	





页数 · PAGE

39

39

40

攻丝刀柄类型 · TAP HOLDERS TYP

NORIS UNI

•

•

•

NORIS UNI HP

•

•

•

NORIS UNI HP ER

NORIS HELIXPRO μ -5

NORIS HELIXPRO 6

NORIS ISP

冷却和润滑
COOLING AND LUBRICATION功能
FUNCTIONS夹套
ADAPTATION

NORIS
WE-U E



40

•

•



NORIS ER | ER GB
NORIS DS



42

•

•



NORIS IE



41

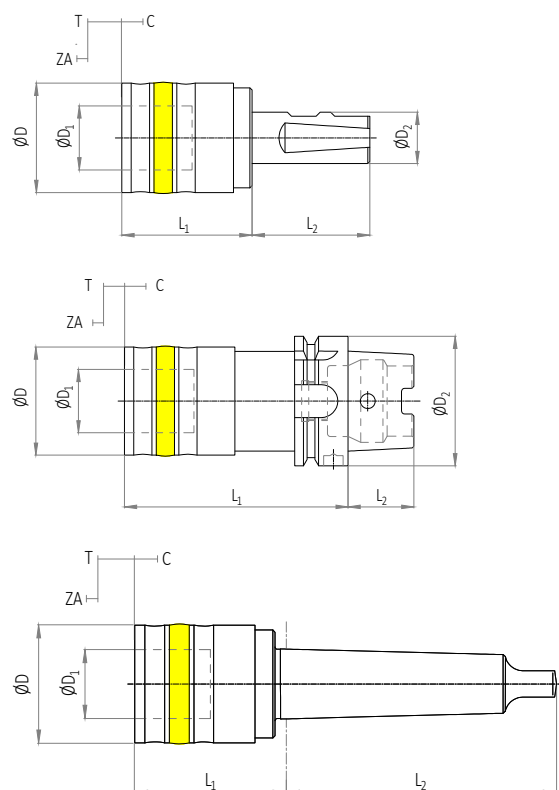
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IE 20+ HELIXPRO 6





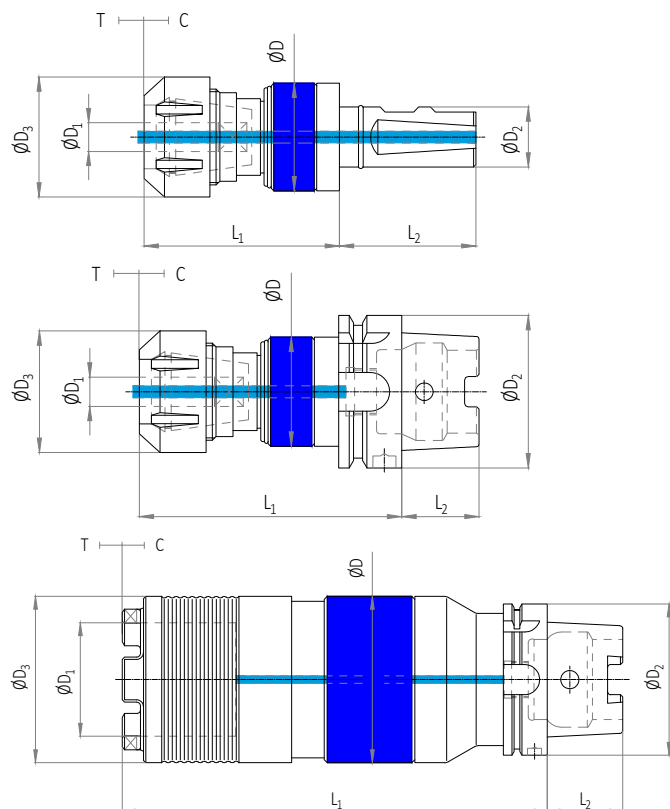
NORIS UNI

NORIS UNI

NORIS UNI



Nr.			Ø D ₁ [mm]	Ø D ₂ [mm]	Ø D [mm]	L ₁ [mm]	L ₂ [mm]	C [mm]	T [mm]	ZA [mm]			
DIN 1835-1 B+E	4	M14- M36 (9/16- 1 3/8)	WE 04	48	Ø 32	78	124	61	15	23,5	4,1	A170E0432*	
	5	M22- M48 (7/8- 1 3/4)	WE 05	60	Ø 40	96	135,5	71	16,5	25	5,7	A170E0540	
Nr.			Ø D ₁ [mm]	Ø D ₂ [mm]	Ø D [mm]	L ₁ [mm]	L ₂ [mm]	C [mm]	T [mm]	ZA [mm]			
DIN 69893-1	4	M14- M36 (9/16- 1 3/8)	WE 04	48	HSK-A63	78	164	32	15	23,5	4,1		A190E0463
				48	HSK-A100	78	170,5	50	15	23,5	4,1		A190E0400
	5	M22- M48 (7/8- 1 3/4)	WE 05	60	HSK-A100	96	205	50	16,5	25	5,7		A190E0500
Nr.			Ø D ₁ [mm]	Ø D ₂ [mm]	Ø D [mm]	L ₁ [mm]	L ₂ [mm]	C [mm]	T [mm]	ZA [mm]			
DIN 228-1 B	4	M14- M36 (9/16- 1 3/8)	WE 04	48	MK 4	78	105	117,5	15	23,5	4,1		A110E0404
				48	MK 5	78	105,5	149,5	15	23,5	4,1		A110E0405
	5	M22- M48 (7/8- 1 3/4)	WE 05	60	MK 5	96	116,5	149,5	16,5	25	5,7		A110E0505
				60	MK 6	96	118,5	210	16,5	25	5,7		A110E0506



NORIS HELIXPRO

NORIS HELIXPRO

NORIS HELIXPRO



Nr.				Ø D ₁ [mm]	Ø D ₂ [mm]	Ø D ₃ [mm]	Ø D [mm]	L ₁ ER [mm]	L ₁ ERGB [mm]	L ₂ [mm]	C [mm]	T [mm]
-----	--	--	--	--------------------------	--------------------------	--------------------------	-------------	---------------------------	-----------------------------	------------------------	-----------	-----------

DIN 1835-1 B+E	4				M12- M30 (7/16- 1 1/8)	ER 40	DS 40	9- 22	Ø 32	63	63	–	113,5	61	0,7	0,7	A770Z4032*

Nr.				Ø D ₁ [mm]	Ø D ₂ [mm]	Ø D ₃ [mm]	Ø D [mm]	L ₁ ER [mm]	L ₁ ERGB [mm]	L ₂ [mm]	C [mm]	T [mm]
-----	--	--	--	--------------------------	--------------------------	--------------------------	-------------	---------------------------	-----------------------------	------------------------	-----------	-----------

DIN 69893-1	4				M12- M30 (7/16- 1 1/8)	ER 40	DS 40	9- 22	HSK-A63	63	63	–	146,5	32	0,7	0,7	A790Z4063
									HSK-A80	63	63	–	136	40	0,7	0,7	A790Z4080
									HSK-A100	63	63	–	138	50	0,7	0,7	A790Z4000
5					M30- M48 (1 3/8- 1 3/4)	ER 50	DS 50	22- 36	HSK-A100	78	103	269	265,6	50	2	2	A790Z5000

Nr.				Ø D ₁ [mm]	Ø D ₂ [mm]	Ø D ₃ [mm]	Ø D [mm]	L ₁ [mm]	L ₂ [mm]	C [mm]	T [mm]
-----	--	--	--	--------------------------	--------------------------	--------------------------	-------------	------------------------	------------------------	-----------	-----------

DIN 69893-1	6				M45- M76 (1 3/8- 2 3/8)	IE 20	-	75	HSK-A100	110	110	281	50	2	2		A790ZH200
-------------	---	--	--	--	----------------------------	-------	---	----	----------	-----	-----	-----	----	---	---	--	-----------

*

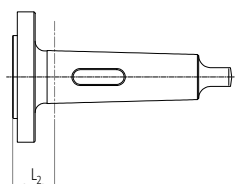
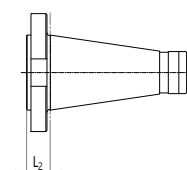
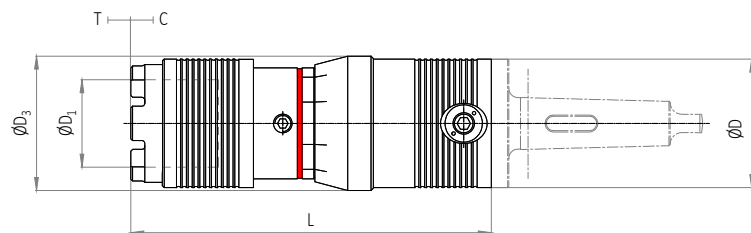
其他转接柄可供选择，详情请见第43页
Other shaft shapes are available through adaptation; see page 43.



交付时包含夹紧螺母
Clamping nut is included in the delivery.



夹套，密封盘和IE夹头，详见第40页
Collets, sealing disks and IE inserts; see page 40.



NORIS ISP

NORIS FS

NORIS FS



Nr.



[Nm]

Ø D₁

Ø D₃

Ø D

L

C

T

[mm] [mm] [mm] [mm] [mm] [mm] [mm] [kg]



20 M24- M76 (1"- 2 1/2) IE 20 1300 Nm

75 115 110 308 15 15 14,8

AFH0E0220

30 M36- M160 (1 3/8- 3 1/2) IE 30 3000 Nm

90 160 160 372 20 20 36,5

AFH0E0330

DIN 2080-1 A

Nr.

Ø D₂

L₂

[mm]

[kg]

20

SK 50

18

3



AFYH2E1850

30

SK 50

19

4,3

AFYH3E1950

DIN 228-1 B

Nr.

Ø D₂

L₂

[mm]

[kg]

20

MK 5

32

2,8

MK 6

31

4,8

30

MK 5

30

3,9

MK 6

32

6,2



AFYH2E3205

AFYH2E3106

AFYH3E3005

AFYH3E3206

DIN ISO 7388-2 JD

Nr.

Ø D₂

L₂

[mm]

[kg]

20

BT 50

85,15

4,7



AFYH2E2450

30

BT 50

64,2

6,7

AFYH3E6850



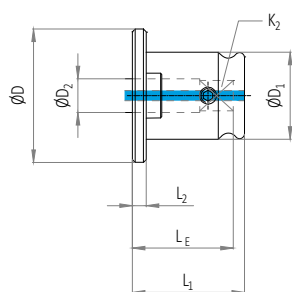
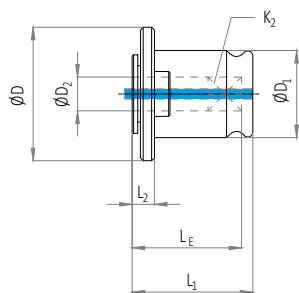
IE夹头，详见第41页

IE inserts, see page 41



根据要求，可提供高达10巴的内部冷却液润滑剂供应

Available with internal coolant-lubricant supply up to 10 bar upon request



NORIS WE

NORIS WE

E



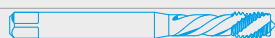
NR.

04

05

04

05



M14 - M36

M22 - M48

M39- M48

M52 - M60

$\varnothing D$ [mm]

70

92

70

92

$\varnothing D_1$ [mm]

48

60

48

60

L_1 [mm]

67

111

61,5

84

L_2 [mm]

11

48

6

21



$\varnothing D_2$

K_2

L_E



L_E



[mm]

[mm]

[mm]

[mm]

DIN

M14

11

9

53

A1104E0411

M16

12

9

53

A1104E0412

M18

14

11

55

A1104E0413

M20

16

12

56

A1104E0414

M22- M24

18

14,5

58

A1104E0415

94

A1105E0515

M27

20

16

60

A1104E0416

96

A1105E0516

M30

22

18

62

A1104E0417

98

A1105E0517

M33

25

20

64

A1104E0418

100

A1105E0518

M36

28

22

66

A1104E0419

102

A1105E0519

M39- M42

32

24

104

A1105E0520

M45- M48

36

29

109

A1105E0521

DIN



$\varnothing D_2$

K_2

L_E



L_E



[mm]

[mm]

[mm]

[mm]

M39- M42

32

24

61

A1104E0420

M45- M48

36

29

60

A1104E0421

M52- M56

40

32

83

A1105E0522

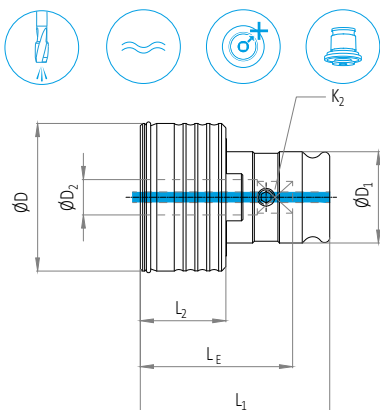
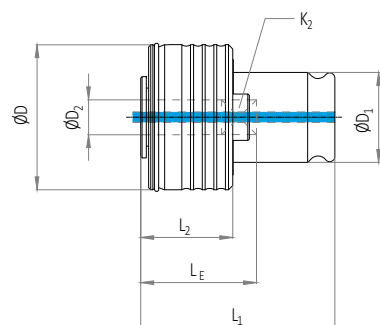
M68

45

35

83

A1105E0523



NORIS WE
U



NORIS WE
U E



NR.	04	05	04	05
	M14 - M36	M22 - M48	M39- M48	M52 - M60
Ø D [mm]	72	95	72	95
Ø D1 [mm]	48	60	48	60
L1 [mm]	101	138	96	125
L2 [mm]	45	75	40,5	62

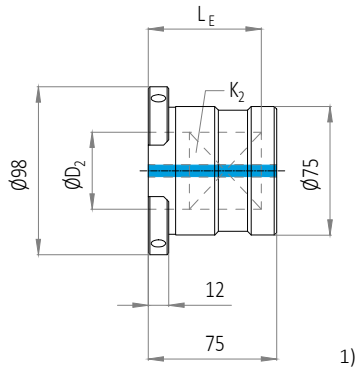
		Ø D ₂ [mm]	K ₂ [mm]	L _E [mm]		L _E [mm]	
DIN	M14	11	9	56	A4104E04A1		
	M16	12	9	56	A4104E04A2		
	M18	14	11	58	A4104E04A3		
	M20	16	12	59	A4104E04A4		
	M22- M24	18	14,5	61	A4104E04A5	94	A4105E05A5
	M27	20	16	63	A4104E04A6	96	A4105E05A6
	M30	22	18	65	A4104E04A7	98	A4105E05A7
	M33	25	20	67	A4104E04A8	100	A4105E05A8
	M36	28	22	69	A4104E04A9	102	A4105E05A9
	M39- M42	32	24			104	A4105E05B0
	M45- M48	36	29			109	A4105E05B1
	M52- M56	40	32				

		Ø D ₂ [mm]	K ₂ [mm]	L _E [mm]		L _E [mm]	
DIN	M39- M42	32	24	66	A4104E04B0		
	M45- M48	36	29	71	A4104E04B1		
	M52- M56	40	32			91	A4105E05B2
	M60	45	35			94	A4105E05B3

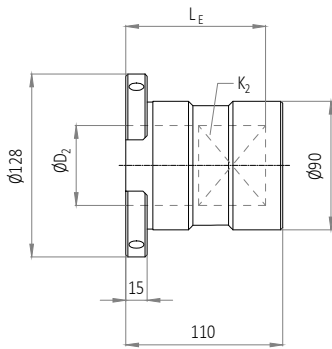


过载保护的扭矩调节, 请参阅我司网站

Adjustable overload clutch see operating instructions on our website



1)



DIN



Ø D₂
[mm]

K₂
[mm]

L_E
[mm]

[kg]

M24
M27
M30
M33
M36
M39- M42
M45- M48
M52- M56
M60
M64- M76 | M80 ¹⁾- M90 ¹⁾
M92 ¹⁾- M120 ¹⁾

18
20
22
25
28
32
36
40
45
50
56

14,5
16
18
20
22
24
29
32
35
39
44

53
53
53
53
53
53
66
66
66
66
66

2,2
2,2
2,1
2,1
2,1
2
1,9
1,8
1,7
1,6
1,4



AFXH2.E0501
AFXH2.E0502
AFXH2.E0503
AFXH2.E0504
AFXH2.E0505
AFXH2.E0506
AFXH2.E0507
AFXH2.E0508
AFXH2.E0509
AFXH2.E0510
AFXH2.E0511

NORIS IE
20



NORIS IE
30



2)



Ø D₂
[mm]

K₂
[mm]

L_E
[mm]

[kg]

M36
M39- M42
M45- M48
M52- M56
M60
M64- M90
M92- M120
M122- M150
M155- M160

28
32
36
40
45
50
56
63
70

22
24
29
32
35
39
44
49
55

76
76
76
76
76
76
98
98
98

4,4
4,3
4,2
4
3,9
3,7
3,4
3
2,7

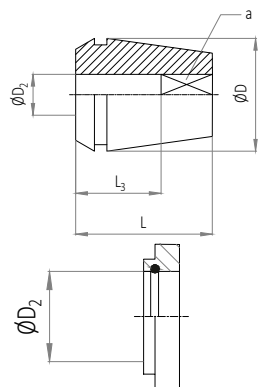


AFXH3E0101
AFXH3E0102
AFXH3E0103
AFXH3E0104
AFXH3E0105
AFXH3E0106
AFXH3E0107
AFXH3E0108
AFXH3E0109

DIN

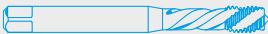
1) 注意刀柄的最大扭矩
Take note of the maximum torque of the holder

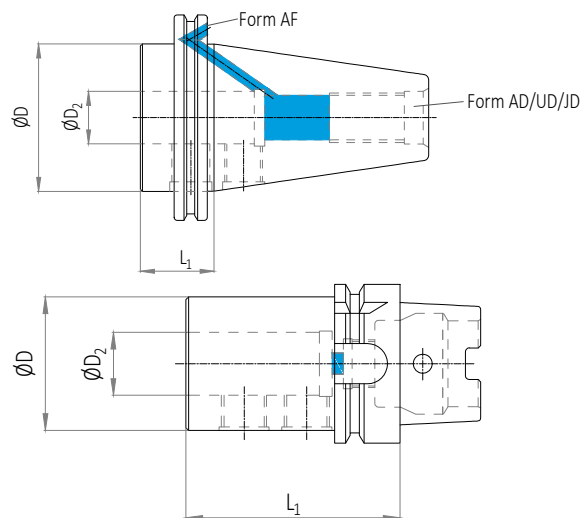
2) 根据要求，可提供高达10巴的内部冷却液润滑剂供应
Available with internal coolant-lubricant supply up to 10 bar upon request



NORIS ER | DS



NR.					40		50		
					ER 40 GB		ER 50 GB		
					DS 40		DS 50		
					M 10 - M30		M30 - M42		
Ø D [mm]					40		51		
L [mm]					46		60		
DIN			Ø D ₂ [mm]	K ₂ [mm]		L ₃ [mm]		L ₃ [mm]	
	M7	M9- M10	7	5,5	ER	18	AD440Z4070		
	-	-	-	-	DS		AK7Z0Z4070		
	M8	M11	8	6,2	ER	22	AD440Z4080		
	-	-	-	-	DS		AK7Z0Z4080		
	M9	M12	9	7	ER	22	AD440Z4090		
	-	-	-	-	DS		AK7Z0Z4090		
	M10	-	10	8	ER	25	AD440Z40A0		
	-	-	-	-	DS		AK7Z0Z40A0		
	-	M14	11	9	ER	25	AD440Z40B1		
	-	-	-	-	DS		AK7Z0Z40B0		
	-	M16	12	9	ER	25	AD440Z40C2		
	-	-	-	-	DS		AK7Z0Z40C0		
	-	M18	14	11	ER	25	AD440Z40E4		
	-	-	-	-	DS		AK7Z0Z40E0		
	-	M20	16	12	ER	25	AD440Z40G6		
	-	-	-	-	DS		AK7Z0Z40G0		
	-	M22- M24	18	14,5	ER	25	AD440Z40J8		
	-	-	-	-	DS		AK7Z0Z40J0		
	-	M27	20	16	ER	28	AD440Z40L0		
	-	-	-	-	DS		AK7Z0Z40L0		
	-	M30	22	18	ER	28	AD440Z40N0	41	AD450Z50B2
	-	-	-	-	DS		AK7Z0Z40Z2		AK7Z0Z50Z2
-	M33	25	20	ER			41	AD450Z50B5	
-	-	-	-	DS				AK7Z0Z50Z5	
-	M36	28	22	ER			41	AD450Z50B8	
-	-	-	-	DS				AK7Z0Z50Z8	
-	M39- M42	32	24	ER			41	AD450Z50C2	
-	-	-	-	DS				AK7Z0Z50Z3	



NORIS AS
DIN 1835 B



NORIS AS
DIN 1835 B



DIN 2080-1 AD	Ø D ₂	SK HSK	Ø D	L ₁		
	[mm]		[mm]	[mm]		
	Ø 20	SK 30	36	34	AK41E0503	
	Ø 25	SK 40	44	22	AK41E0501	
	Ø 25	SK 50	70	16	AK41E0502	
DIN 69893-1	Ø 32	SK 50	70	16	AK41E0504	
	Ø D ₂	SK HSK	Ø D	L ₁		
	[mm]		[mm]	[mm]		
	Ø 20	HSK-A40	52	75		AK91E0C02
	Ø 20	HSK-A50	52	80		AK91E0C04
	Ø 25	HSK-A40	65	105		AK91E0C03
	Ø 25	HSK-A50	65	107		AK91E0C05
	Ø 25	HSK-A63	53	85		AK91E0C07
	Ø 25	HSK-A80	65	90		AK91E0C09
	Ø 25	HSK-A100	65	100		AK91E0C11
	Ø 32	HSK-A50	77	114		AK91E0C06
	Ø 32	HSK-A63	72	110		AK91E0C08
	Ø 32	HSK-A80	72	110		AK91E0C10
DIN ISO 7388-2	Ø 32	HSK-A100	72	96		AK91E0C12
	Ø D ₂	SK HSK	Ø D	L ₁		
	[mm]		[mm]	[mm]		
	Ø 32	BT 50	70	44	AKE1E0803	



交付时包含夹紧螺丝
Clamping screws are included in the delivery



攻丝刀柄，详情请见第36和37页
Suitable for adapting to thread-cutting chucks; see pages 36 and 37



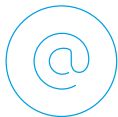
诺瑞思螺纹工具（上海）有限公司
REIME NORIS Threading Tools (Shanghai) Co.,Ltd.



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