

# ***TwinCut***

***zum Innengewinde drehen***



Edition 200901



**Scandinavian  
Tool Systems**

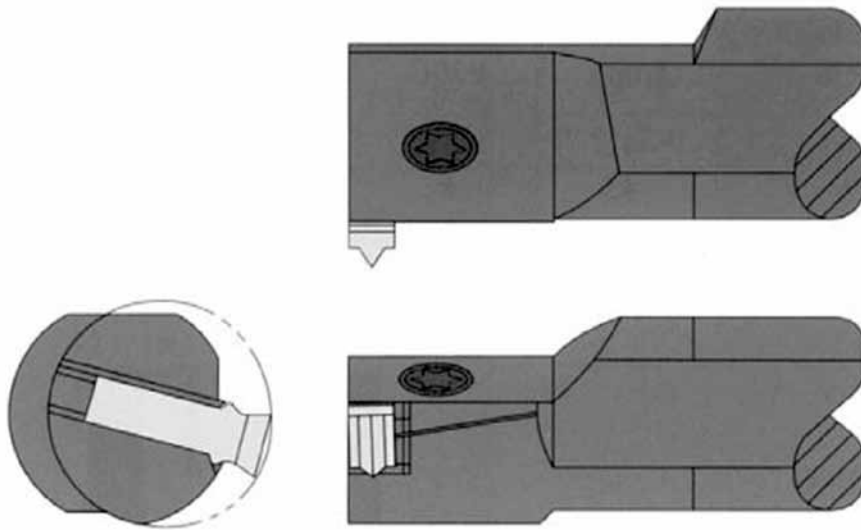
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## **TwinCut Gewindeplatten**

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## **TwinCut Gewindeplattenhalter**

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Scandinavian Tool System ist ein schwedischer Hersteller und Lieferant von Werkzeugen zum Gewindedrehen, Gewindefräsen, Abstechen und Ringnutdrehen. Das Hauptprodukt ist die *QuadCut* Serie, welche auf dem Noramerikanischen Markt unter dem Namen *QuadThread* verkauft wird. Diese Produkte werden über Fachhändler in mehr als 30 Ländern weltweit verkauft. Die Firma ist seit 1995 ein Teil der Ostling Gruppe, [www.ostling.com](http://www.ostling.com), mit Hauptsitz in Solingen, Deutschland.

Das *TwinCut* System kommt bei größeren Steigungen zur Anwendung. Es ermöglicht Innengewinde mit einem Kernlochdurchmesser ab 18 mm.

Die *TwinCut* Wendeschneidplatte hat zwei Schneiden, mit einem gesinterten Spanbrecher.

Die Schneide kann ohne großen Zeitaufwand gewechselt werden. *TwinCut* Einsätze können sowohl für Rechts- als auch für Linksgewinde verwendet werden. Die großen Klemmhalter haben austauschbare Kassetten für verschiedene Plattengrößen. Damit reduzieren Sie Kosten und Lagerhaltung.

**Die technischen Angaben wurden aus der englischen Fassung des Herstellers übernommen.**

## Technische Information

### Schnittdaten

Empfohlene Schnittgeschwindigkeiten in m/min

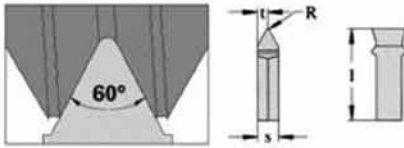
Material	P30C
Low-carbon steel $\leq 650\text{N/mm}^2$	180-220
Carbon steel 650-850N/mm <sup>2</sup>	130-190
Alloyed tool steel and heat-resistant steel	120-160
Stainless steel	90-170
Cast iron HB 180-250	
Non-ferrous materials	

### Anzahl der Zustellungen

Die Tabelle gibt nur allgemeine Empfehlungen

Pitch mm	3.5	4.0	4.5	5.0	5.5	6.0
Pitch TPI	7	6	5.5	5	4.5	4
Nr. of passes	11-18	11-18	11-19	12-20	12-20	12-20

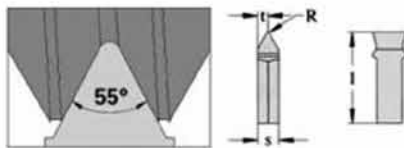
The above recommendations are for full profile UN, ISO and Withworth.  
For Trapezoidal, ACME, NPT please contact your local STS distributor.



## Partielles Profil 60°

Internal threading

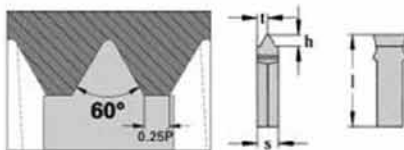
Pitch mm	TPI	Catalogue number	Dimensions				Coated P30C	Price- group
			l	s	t	R		
0.5-3.0	48-8	14N AG60	14	4.6	2.3	0.07	•	848
2.5-4.0	11-6	14N GN60	14	4.6	2.3	0.18	•	848
4.5-6.0	5-4	18N NV60	18	6.8	3.4	0.32	•	849



## Partielles Profil 55°

Internal threading

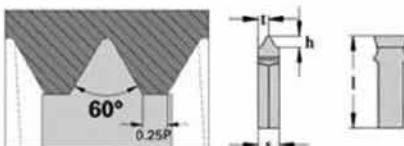
Pitch mm	TPI	Catalogue number	Dimensions				Coated P30C	Price- group
			l	s	t	R		
0.5-3.0	48-8	14N AG55	14	4.6	2.3	0.07	•	848
2.5-4.0	11-6	14N GN55	14	4.6	2.3	0.30	•	848
4.5-6.0	5-4	18N NV55	18	6.8	3.4	0.65	•	849



## ISO Metric (M)

Internal threading

Pitch mm	Catalogue number	Dimensions				Coated P30C	Price- group
		l	s	t	R		
3.5	14N 3.5ISO	14	4.6	2.3	2.05	•	848
4.0	14N 4.0ISO	14	4.6	2.3	2.34	•	848
4.5	18N 4.5ISO	18	6.8	3.4	2.63	•	849
5.0	18N 5.0ISO	18	6.8	3.4	2.92	•	849
5.5	18N 5.5ISO	18	6.8	3.4	3.22	•	849
6.0	18N 6.0ISO	18	6.8	3.4	3.51	•	849

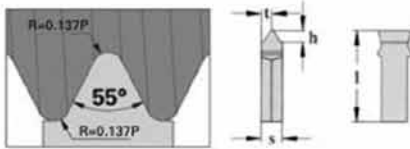


## ISO Unified (UN)

Internal threading

Pitch TPI	Catalogue number	Dimensions				Coated P30C	Price- group
		l	s	t	h		
7	14N 7UN	14	4.6	2.3	2.12	*	848
6	14N 6UN	14	4.6	2.3	2.48	*	848
5	18N 5UN	18	6.8	3.4	2.97	*	849
4.5	18N 4.5UN	18	6.8	3.4	3.30	*	849
4	18N 4UN	18	6.8	3.4	3.71	*	849

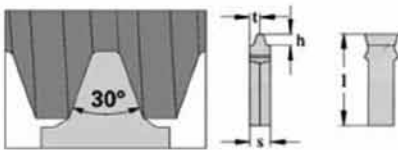
• = Standardware  
\* = Limitierte Ware



## Whitworth (BSW, BSP)

Internal threading

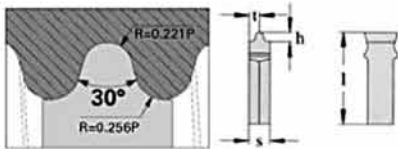
Pitch TPI	Catalogue number		Dimensions				Coated P30C	Price- group
			l	s	t	h		
7	14N	7W	14	4.6	2.3	2.35	*	848
6	14N	6W	14	4.6	2.3	2.75	*	848
5	18N	5W	18	6.8	3.4	3.30	*	849
4.5	18N	4.5W	18	6.8	3.4	3.66	*	849
4	18N	4W	18	6.8	3.4	4.12	*	849



## Trapezoidal DIN 103

Internal threading

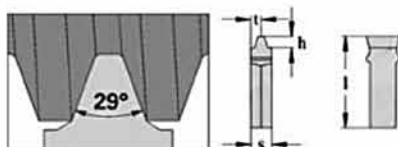
Pitch mm	Catalogue number		Dimensions				Coated P30C	Price- group
			l	s	t	h		
4.0	14N	4.0TR	14	4.6	2.3	2.25	*	849
5.0	18N	5.0TR	18	6.8	3.4	2.75	*	849
6.0	18N	6.0TR	18	6.8	3.4	3.50	*	850



## Round DIN 405

Internal threading

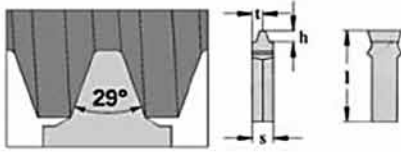
Pitch TPI	Catalogue number		Dimensions				Coated P30C	Price- group
			l	s	t	h		
6	14N	6RD	14	4.6	2.3	2.12	*	849
4	18N	4RD	18	6.8	3.4	3.18	*	850



## ACME

Internal threading

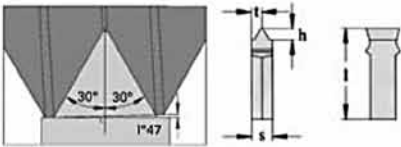
Pitch TPI	Catalogue number		Dimensions				Coated P30C	Price- group
			l	s	t	h		
6	14N	6ACME	14	4.6	2.3	2.54	*	849
5	18N	5ACME	18	6.8	3.4	2.99	*	850
4	18N	4ACME	18	6.8	3.4	3.63	*	850



## STUB ACME

Internal threading

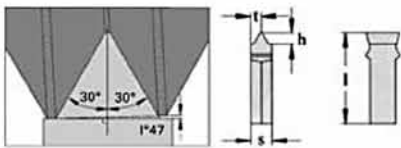
Pitch TPI	Catalogue number		Dimensions				Coated P30C	Price- group
			l	s	t	h		
6	14N	6STACME	14	4.6	2.3	1.69	*	849
5	18N	5STACME	18	6.8	3.4	1.98	*	850
4	18N	4STACME	18	6.8	3.4	2.36	*	850



## NPT

Internal threading

Pitch TPI	Catalogue number		Dimensions				Coated P30C	Price- group
			l	s	t	h		
8	14N	8NPT	14	4.6	2.3	2.43	•	849

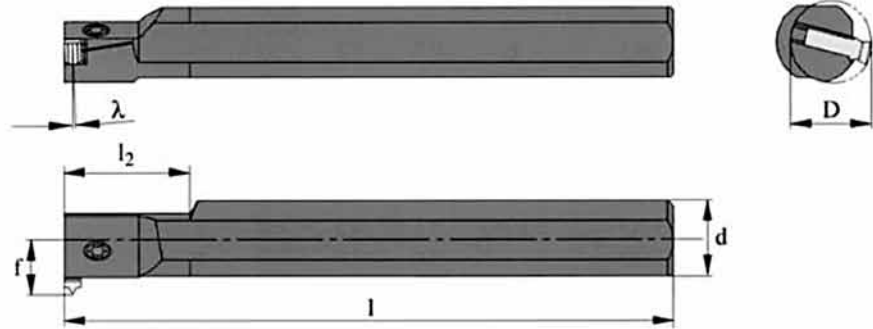
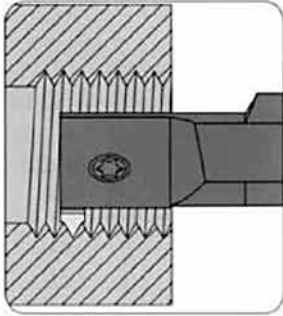


## NPTF Dryseal

Internal threading

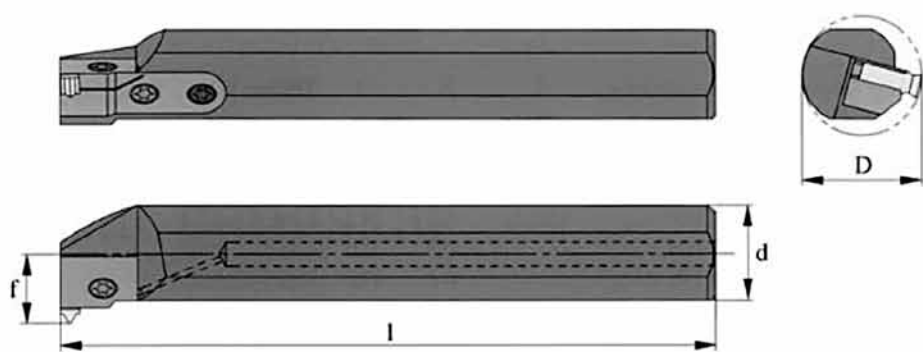
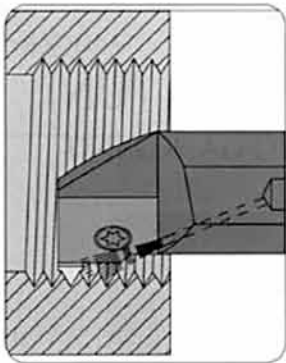
Pitch TPI	Catalogue number		Dimensions				Coated P30C	Price- group
			l	s	t	h		
8	14N	8NPTF	14	4.6	2.3	2.41	•	849

**WARNING!** Always determine if NPT or NPTF profile should be used. Be sure you use the right one.



## Schmale Werkzeughalter

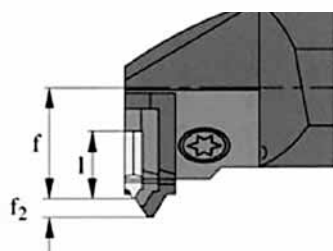
Catalogue number	Dimensions					Insert	Stock standard ( $\lambda$ )						Price-group
	d	l	l <sub>2</sub>	f	D min		4.5	3	1.5	0	98.5	97	
QNR 0016K-14	16	125	32	11	18	14N	•	•	•	•	•	•	862
QNR 0020M-14	20	150	-	13	24	14N		•	•	•	•	•	862
QNR 0016K-18	16	125	52	14	19.5	18N			*				862
QNL 0016K-14	16	125	32	11	18	14N	•	•	•	•	•	•	862
QNL 0020M-14	20	150	-	13	24	14N		•	•	•	•	•	862



## Kassetten Werkzeughalter

Catalogue number	Dimensions				Cassettes		Stock standard	Price-group
	d	l	f	D min	Insert 14N	Insert 18N		
QNR 0025P-C25	25	170	16.5	30	QNR 25-14	QNR 25-18	•	862
QNR 0032R-C25	32	200	20.5	37	QNR 25-14	QNR 25-18	•	863
QNR 0040S-C25	40	250	24.0	45	QNR 25-14	QNR 25-18	•	864
QNL 0025P-C25	25	170	16.5	30	QNL 25-14	QNL 25-18	•	862
QNL 0032R-C25	32	200	20.0	37	QNL 25-14	QNL 25-18	•	863
QNL 0040S-C25	40	250	24.0	45	QNL 25-14	QNL 25-18	•	864

Toolholders delivered without cassette, to be ordered separately.



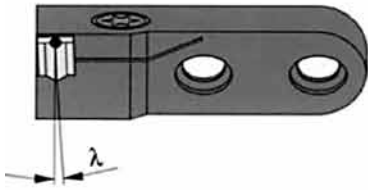
For cassette-type toolholders, the f-dimension is displaced dependent upon the insert size according to the f<sub>2</sub>-dimension in the table.

## f-Dimension

Dimensions	
l	f <sub>2</sub>
14	0
18	1.5

- = Standardware
- \* = Limitierte Ware





## Innen Kassetten

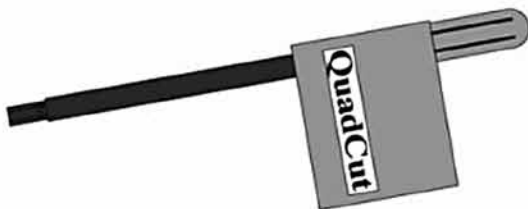
Catalogue number	Insert	Stock standard (λ)						Price-group
		4.5	3	1.5	0	98.5	97	
QNR 25-14	14N		•	•	•	•	•	861
QNR 25-18	18N	•	•	•	•	•	•	861
QNL 25-14	14N		•	•	•	•	•	861
QNL 25-18	18N	•	•	•	•	•	•	861

## Schrauben



Catalogue number	Used for	Price-group
STST15xM5	Insert 14N	221
STST15xM5	Insert 18N	221
STST15xM5	Cassettes	221

## Schlüssel



Catalogue number	Used for	Price-group
TorxT15	STST15xM5	222

- = Standardware
- \* = Limitierte Ware



# ACANTER-Werkzeug

Dammwiesenstraße 10 · 22045 Hamburg  
 Tel.: 040-675 86 6-0 · Fax: 040-675 86 6-29  
 E-Mail: info@acanter.de · www.acanter.de