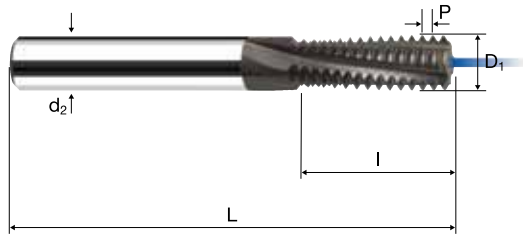
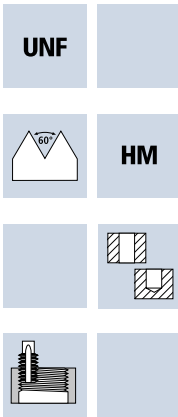


Thread milling cutters

2xd, Incool

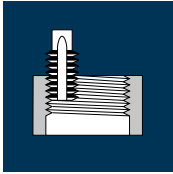


TM

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56			Inox Stainless	Ti Titanium	Aluminium / Copper GG(G)
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		Article-N°		ø-Code						TiCN
Example: Order-N°.		EH20370		758						EH20370
Ø Code	d	P(TPI)	L	I	d ₂ h6	D1	Rk 2B			
758	Nr.10	32.0	54	11.50	6.0	3.80	1.870	3		●
759	Nr.12	28.0	54	12.20	6.0	4.30	2.120	3		●
760	1/4	28.0	54	14.10	6.0	5.10	2.520	3		●
761	5/16	24.0	64	17.50	8.0	6.30	3.120	3		●
762	3/8	24.0	64	20.60	8.0	7.80	3.870	3		●
763	7/16	20.0	74	24.80	10.0	9.40	4.640	3		●
764	1/2	20.0	74	27.30	10.0	9.95	4.920	4		●
765	9/16	18.0	90	30.30	12.0	11.40	5.640	4		●
766	5/8	18.0	90	33.20	14.0	12.70	6.290	4		●

Application



Material

Steel
< 850 N/mm²

Steel
850 - 1100 N/mm²

Steel
1100 - 1300 N/mm²

Steel
1300 - 1500 N/mm²

Wrought aluminium alloys
Si < 6%
hardened

Cast iron
(lamellar / spheroidal)

Unalloyed copper

Stainless steel
[Cr-Ni/1.4301]

UNF	D ₁ [mm]	P(TPI)	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
Nr.10	3.80	32.0	3	90	0.0200	7540	96	452
Nr.12	4.30	28.0	3	90	0.0200	6660	86	400
1/4	5.10	28.0	3	90	0.0240	5615	80	404
5/16	6.30	24.0	3	90	0.0280	4545	79	382
3/8	7.80	24.0	3	90	0.0400	3675	80	441
7/16	9.40	20.0	3	90	0.0440	3050	62	403
1/2	9.95	20.0	4	90	0.0480	2880	120	553
9/16	11.40	18.0	4	90	0.0480	2515	98	483
5/8	12.70	18.0	4	90	0.0480	2255	87	433
Nr.10	3.80	32.0	3	80	0.0200	6700	85	402
Nr.12	4.30	28.0	3	80	0.0200	5920	77	355
1/4	5.10	28.0	3	80	0.0240	4995	71	360
5/16	6.30	24.0	3	80	0.0280	4040	70	339
3/8	7.80	24.0	3	80	0.0400	3265	71	392
7/16	9.40	20.0	3	80	0.0440	2710	55	358
1/2	9.95	20.0	4	80	0.0480	2560	106	492
9/16	11.40	18.0	4	80	0.0480	2235	87	429
5/8	12.70	18.0	4	80	0.0480	2005	77	385
Nr.10	3.80	32.0	3	60	0.0200	5025	64	302
Nr.12	4.30	28.0	3	60	0.0200	4440	58	266
1/4	5.10	28.0	3	60	0.0240	3745	53	270
5/16	6.30	24.0	3	60	0.0240	3030	45	218
3/8	7.80	24.0	3	60	0.0320	2450	43	235
7/16	9.40	20.0	3	60	0.0400	2030	38	244
1/2	9.95	20.0	4	60	0.0440	1920	73	338
9/16	11.40	18.0	4	60	0.0440	1675	60	295
5/8	12.70	18.0	4	60	0.0480	1505	58	289
Nr.10	3.80	32.0	3	45	0.0200	3770	48	226
Nr.12	4.30	28.0	3	45	0.0200	3330	43	200
1/4	5.10	28.0	3	45	0.0240	2810	40	202
5/16	6.30	24.0	3	45	0.0240	2275	34	164
3/8	7.80	24.0	3	45	0.0320	1835	32	176
7/16	9.40	20.0	3	45	0.0400	1525	28	183
1/2	9.95	20.0	4	45	0.0440	1440	55	253
9/16	11.40	18.0	4	45	0.0440	1255	45	221
5/8	12.70	18.0	4	45	0.0480	1130	43	217
Nr.10	3.80	32.0	3	150	0.0320	12565	256	1206
Nr.12	4.30	28.0	3	150	0.0320	11105	230	1066
1/4	5.10	28.0	3	150	0.0360	9360	199	1011
5/16	6.30	24.0	3	150	0.0400	7580	188	910
3/8	7.80	24.0	3	150	0.0480	6120	160	881
7/16	9.40	20.0	3	150	0.0520	5080	122	793
1/2	9.95	20.0	4	150	0.0560	4800	233	1075
9/16	11.40	18.0	4	150	0.0560	4190	190	939
5/8	12.70	18.0	4	150	0.0640	3760	193	963
Nr.10	3.80	32.0	3	120	0.0240	10050	154	724
Nr.12	4.30	28.0	3	120	0.0240	8885	138	640
1/4	5.10	28.0	3	120	0.0280	7490	124	629
5/16	6.30	24.0	3	120	0.0320	6065	120	582
3/8	7.80	24.0	3	120	0.0400	4895	106	587
7/16	9.40	20.0	3	120	0.0480	4065	90	585
1/2	9.95	20.0	4	120	0.0520	3840	173	799
9/16	11.40	18.0	4	120	0.0520	3350	141	697
5/8	12.70	18.0	4	120	0.0560	3010	135	674
Nr.10	3.80	32.0	3	130	0.0240	10890	167	784
Nr.12	4.30	28.0	3	130	0.0240	9625	150	693
1/4	5.10	28.0	3	130	0.0280	8115	134	682
5/16	6.30	24.0	3	130	0.0320	6570	130	631
3/8	7.80	24.0	3	130	0.0400	5305	115	637
7/16	9.40	20.0	3	130	0.0480	4400	98	634
1/2	9.95	20.0	4	130	0.0520	4160	187	865
9/16	11.40	18.0	4	130	0.0520	3630	153	755
5/8	12.70	18.0	4	130	0.0560	3260	146	730
Nr.10	3.80	32.0	3	55	0.0240	4605	70	332
Nr.12	4.30	28.0	3	55	0.0240	4070	63	293
1/4	5.10	28.0	3	55	0.0240	3435	49	247
5/16	6.30	24.0	3	55	0.0240	2780	41	200
3/8	7.80	24.0	3	55	0.0320	2245	39	216
7/16	9.40	20.0	3	55	0.0400	1860	34	223
1/2	9.95	20.0	4	55	0.0440	1760	67	310
9/16	11.40	18.0	4	55	0.0440	1535	55	270
5/8	12.70	18.0	4	55	0.0480	1380	53	265