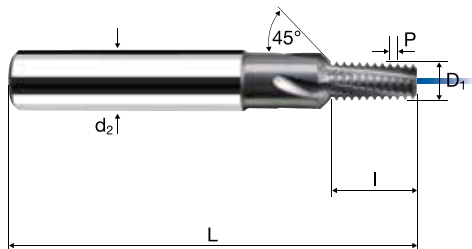
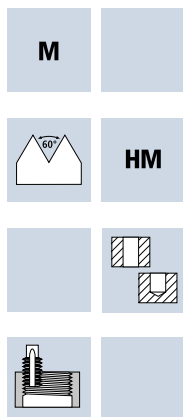


Thread milling cutters

1.5xd, chamfer 45°, 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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Example: Order-N°.										TiCN
Article-N°. Ø-Code										Eh24200
EH24200 044										
Ø Code	d	P	L	I	d ₂ h6	D1	Rk 6H			
044*	M 3	0.50	48	5.30	6.0	2.30	1.125	3		●
058	M 4	0.70	48	7.40	6.0	3.00	1.465	3		●
084	M 5	0.80	54	9.20	6.0	4.00	1.960	3		●
088	M 6	1.00	62	10.50	8.0	4.80	2.350	3		●
160	M 8	1.25	74	13.10	10.0	6.40	3.138	3		●
174	M 10	1.50	80	17.30	12.0	7.95	3.900	4		●
240	M 12	1.75	90	20.10	14.0	9.95	4.887	4		●
246	M 16	2.00	102	27.00	18.0	12.80	6.300	4		●
* without internal cooling										

Application



Material

Steel
850 - 1100 N/mm²



Steel
1300 - 1500 N/mm²



Hardened tool steel
48 - 52 HRC



Stainless steel
[Cr-Ni/1.4301]



Cast iron
(lamellar / spheroidal)



Wrought aluminium alloys
Si < 6%
hardened



Cast aluminium



Titanium alloys
> 300 HB
[Ti6Al4V]



M	D ₁ [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	L _K [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M3	2.30	0.50	3	80	0.0060	5.7	11070	47	199
M4	3.00	0.70	3	80	0.0075	8.0	8490	48	191
M5	4.00	0.80	3	80	0.0100	9.8	6365	38	191
M6	4.80	1.00	3	80	0.0120	11.3	5305	38	191
M8	6.40	1.25	3	80	0.0160	14.1	3980	38	191
M10	7.95	1.50	4	80	0.0200	18.6	3205	53	256
M12	9.95	1.75	4	80	0.0250	21.4	2560	44	256
M16	12.80	2.00	4	80	0.0320	29.0	1990	51	255
M3	2.30	0.50	3	50	0.0050	5.7	6920	24	104
M4	3.00	0.70	3	50	0.0065	8.0	5305	26	103
M5	4.00	0.80	3	50	0.0090	9.8	3980	22	108
M6	4.80	1.00	3	50	0.0105	11.3	3315	21	104
M8	6.40	1.25	3	50	0.0140	14.1	2485	21	104
M10	7.95	1.50	4	50	0.0175	18.6	2000	29	140
M12	9.95	1.75	4	50	0.0220	21.4	1600	24	141
M16	12.80	2.00	4	50	0.0285	29.0	1245	28	142
M3	2.30	0.50	3	30	0.0040	5.7	4150	12	50
M4	3.00	0.70	3	30	0.0050	8.0	3185	12	48
M5	4.00	0.80	3	30	0.0065	9.8	2385	9	47
M6	4.80	1.00	3	30	0.0080	11.3	1990	10	48
M8	6.40	1.25	3	30	0.0105	14.1	1490	9	47
M10	7.95	1.50	4	30	0.0135	18.6	1200	13	65
M12	9.95	1.75	4	30	0.0165	21.4	960	11	63
M16	12.80	2.00	4	30	0.0215	29.0	745	13	64
M3	2.30	0.50	3	50	0.0040	5.7	6920	19	83
M4	3.00	0.70	3	50	0.0050	8.0	5305	20	80
M5	4.00	0.80	3	50	0.0065	9.8	3980	16	78
M6	4.80	1.00	3	50	0.0080	11.3	3315	16	80
M8	6.40	1.25	3	50	0.0105	14.1	2485	16	78
M10	7.95	1.50	4	50	0.0135	18.6	2000	22	108
M12	9.95	1.75	4	50	0.0165	21.4	1600	18	106
M16	12.80	2.00	4	50	0.0215	29.0	1245	21	107
M3	2.30	0.50	3	120	0.0060	5.7	16605	70	299
M4	3.00	0.70	3	120	0.0075	8.0	12730	72	286
M5	4.00	0.80	3	120	0.0100	9.8	9550	57	287
M6	4.80	1.00	3	120	0.0120	11.3	7960	57	287
M8	6.40	1.25	3	120	0.0160	14.1	5970	57	287
M10	7.95	1.50	4	120	0.0200	18.6	4805	79	384
M12	9.95	1.75	4	120	0.0250	21.4	3840	66	384
M16	12.80	2.00	4	120	0.0320	29.0	2985	76	382
M3	2.30	0.50	3	150	0.0080	5.7	20760	116	498
M4	3.00	0.70	3	150	0.0105	8.0	15915	125	501
M5	4.00	0.80	3	150	0.0140	9.8	11935	100	501
M6	4.80	1.00	3	150	0.0170	11.3	9945	101	507
M8	6.40	1.25	3	150	0.0225	14.1	7460	101	504
M10	7.95	1.50	4	150	0.0280	18.6	6005	138	673
M12	9.95	1.75	4	150	0.0350	21.4	4800	115	672
M16	12.80	2.00	4	150	0.0450	29.0	3730	134	671
M3	2.30	0.50	3	200	0.0080	5.7	27680	155	664
M4	3.00	0.70	3	200	0.0105	8.0	21220	167	668
M5	4.00	0.80	3	200	0.0140	9.8	15915	134	668
M6	4.80	1.00	3	200	0.0170	11.3	13265	135	677
M8	6.40	1.25	3	200	0.0225	14.1	9945	134	671
M10	7.95	1.50	4	200	0.0280	18.6	8010	184	897
M12	9.95	1.75	4	200	0.0350	21.4	6400	153	896
M16	12.80	2.00	4	200	0.0450	29.0	4975	179	896
M3	2.30	0.50	3	40	0.0040	5.7	5535	15	66
M4	3.00	0.70	3	40	0.0050	8.0	4245	16	64
M5	4.00	0.80	3	40	0.0065	9.8	3185	12	62
M6	4.80	1.00	3	40	0.0080	11.3	2655	13	64
M8	6.40	1.25	3	40	0.0105	14.1	1990	13	63
M10	7.95	1.50	4	40	0.0135	18.6	1600	18	86
M12	9.95	1.75	4	40	0.0165	21.4	1280	14	85
M16	12.80	2.00	4	40	0.0215	29.0	995	17	86