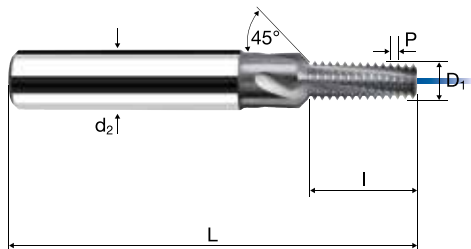
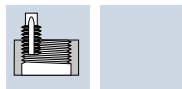
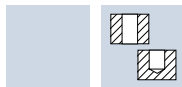
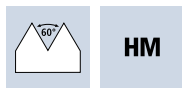


Thread milling cutters

2xd, chamfer 45°, Incool

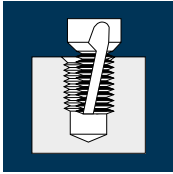


TM

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°. Article-N°. ø-Code EH24300 044										TiCN
Ø Code	d	P	L	I	d ₂ h ₆	D1	Rk 6H			
044*	M 3	0.50	48	6.80	6.0	2.30	1.125	3		●
058	M 4	0.70	48	8.80	6.0	3.00	1.465	3		●
084	M 5	0.80	54	10.80	6.0	4.00	1.960	3		●
088	M 6	1.00	62	13.50	8.0	4.80	2.350	3		●
160	M 8	1.25	74	18.10	10.0	6.40	3.138	3		●
174	M 10	1.50	80	21.80	12.0	7.95	3.900	4		●
240	M 12	1.75	90	25.40	14.0	9.95	4.887	4		●
246	M 16	2.00	102	35.00	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	0.0055	7.2	11070	43	183
M4	3.00	0.70	3	80	0.0070	9.4	8490	45	178
M5	4.00	0.80	3	80	0.0090	11.4	6365	34	172
M6	4.80	1.00	3	80	0.0110	14.3	5305	35	175
M8	6.40	1.25	3	80	0.0145	19.1	3980	35	173
M10	7.95	1.50	4	80	0.0180	23.1	3205	47	231
M12	9.95	1.75	4	80	0.0225	26.7	2560	39	230
M16	12.80	2.00	4	80	0.0290	37.0	1990	46	231
M3	2.30	0.50	3	50	0.0045	7.2	6920	22	93
M4	3.00	0.70	3	50	0.0060	9.4	5305	24	96
M5	4.00	0.80	3	50	0.0080	11.4	3980	19	96
M6	4.80	1.00	3	50	0.0095	14.3	3315	19	95
M8	6.40	1.25	3	50	0.0125	19.1	2485	19	93
M10	7.95	1.50	4	50	0.0160	23.1	2000	26	128
M12	9.95	1.75	4	50	0.0200	26.7	1600	22	128
M16	12.80	2.00	4	50	0.0255	37.0	1245	25	127
M3	2.30	0.50	3	30	0.0035	7.2	4150	10	44
M4	3.00	0.70	3	30	0.0045	9.4	3185	11	43
M5	4.00	0.80	3	30	0.0060	11.4	2385	9	43
M6	4.80	1.00	3	30	0.0070	14.3	1990	8	42
M8	6.40	1.25	3	30	0.0095	19.1	1490	9	43
M10	7.95	1.50	4	30	0.0120	23.1	1200	12	58
M12	9.95	1.75	4	30	0.0150	26.7	960	10	58
M16	12.80	2.00	4	30	0.0195	37.0	745	12	58
M3	2.30	0.50	3	50	0.0035	7.2	6920	17	73
M4	3.00	0.70	3	50	0.0045	9.4	5305	18	72
M5	4.00	0.80	3	50	0.0060	11.4	3980	14	72
M6	4.80	1.00	3	50	0.0070	14.3	3315	14	70
M8	6.40	1.25	3	50	0.0095	19.1	2485	14	71
M10	7.95	1.50	4	50	0.0120	23.1	2000	20	96
M12	9.95	1.75	4	50	0.0150	26.7	1600	16	96
M16	12.80	2.00	4	50	0.0195	37.0	1245	19	97
M3	2.30	0.50	3	120	0.0055	7.2	16605	64	274
M4	3.00	0.70	3	120	0.0070	9.4	12730	67	267
M5	4.00	0.80	3	120	0.0090	11.4	9550	52	258
M6	4.80	1.00	3	120	0.0110	14.3	7960	53	263
M8	6.40	1.25	3	120	0.0145	19.1	5970	52	260
M10	7.95	1.50	4	120	0.0180	23.1	4805	71	346
M12	9.95	1.75	4	120	0.0225	26.7	3840	59	346
M16	12.80	2.00	4	120	0.0290	37.0	2985	69	346
M3	2.30	0.50	3	150	0.0070	7.2	20760	102	436
M4	3.00	0.70	3	150	0.0095	9.4	15915	113	454
M5	4.00	0.80	3	150	0.0125	11.4	11935	90	448
M6	4.80	1.00	3	150	0.0155	14.3	9945	92	462
M8	6.40	1.25	3	150	0.0205	19.1	7460	92	459
M10	7.95	1.50	4	150	0.0250	23.1	6005	123	601
M12	9.95	1.75	4	150	0.0315	26.7	4800	103	605
M16	12.80	2.00	4	150	0.0405	37.0	3730	121	604
M3	2.30	0.50	3	200	0.0070	7.2	27680	136	581
M4	3.00	0.70	3	200	0.0095	9.4	21220	151	605
M5	4.00	0.80	3	200	0.0125	11.4	15915	119	597
M6	4.80	1.00	3	200	0.0155	14.3	13265	123	617
M8	6.40	1.25	3	200	0.0205	19.1	9945	122	612
M10	7.95	1.50	4	200	0.0250	23.1	8010	164	801
M12	9.95	1.75	4	200	0.0315	26.7	6400	138	806
M16	12.80	2.00	4	200	0.0405	37.0	4975	161	806
M3	2.30	0.50	3	40	0.0035	7.2	5535	14	58
M4	3.00	0.70	3	40	0.0045	9.4	4245	14	57
M5	4.00	0.80	3	40	0.0060	11.4	3185	11	57
M6	4.80	1.00	3	40	0.0070	14.3	2655	11	56
M8	6.40	1.25	3	40	0.0095	19.1	1990	11	57
M10	7.95	1.50	4	40	0.0120	23.1	1600	16	77
M12	9.95	1.75	4	40	0.0150	26.7	1280	13	77
M16	12.80	2.00	4	40	0.0195	37.0	995	16	78