

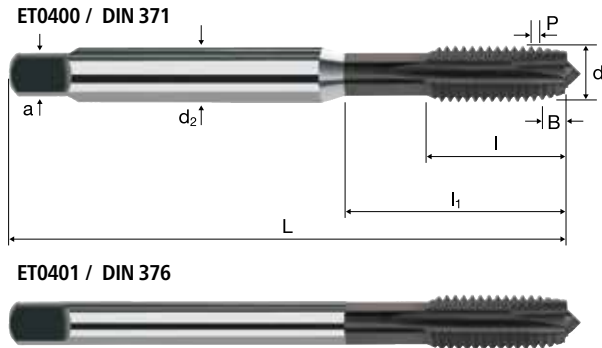


M ISO 2
(6H)

HSS
PM/F

DIN
371/376

X-P
Form B







ToolSchool

EC10540 / EC10541

M

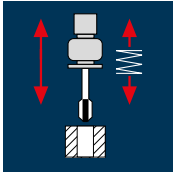


Example: Order-N°.										TRIBO
Article-N°. a-Code										ET0400
Ø Code	d	P	L	l	l ₁	d ₂	a			
034	M 2	0.40	45	8.00	-	2.8	2.1	2	1.70*	●
040	M 2.5	0.45	50	9.00	-	2.8	2.1	2	2.10	●
044	M 3	0.50	56	12.00	18.0	3.5	2.7	3	2.60*	●
058	M 4	0.70	63	13.00	21.0	4.5	3.4	3	3.40	●
084	M 5	0.80	70	15.00	25.0	6.0	4.9	3	4.30	●
088	M 6	1.00	80	17.00	30.0	6.0	4.9	3	5.10	●
160	M 8	1.25	90	20.00	35.0	8.0	6.2	3	6.90	●
174	M 10	1.50	100	22.00	39.0	10.0	8.0	3	8.60	●

Example: Order-N°.										TRIBO
Article-N°. a-Code										ET0401
Ø Code	d	P	L	l	l ₁	d ₂	a			
240	M 12	1.75	110	24.00	40.0	9.0	7.0	3	10.40	●
244	M 14	2.00	110	26.00	40.0	11.0	9.0	3	12.20	●
246	M 16	2.00	110	27.00	40.0	12.0	9.0	3	14.20	●
312	M 18	2.50	125	30.00	45.0	14.0	11.0	4	15.70	●
314	M 20	2.50	140	32.00	50.0	16.0	12.0	4	17.70	●
316	M 22	2.50	140	32.00	50.0	18.0	14.5	4	19.70	●
320	M 24	3.00	160	34.00	60.0	18.0	14.5	4	21.20	●

* The given dimension is out of norm

Application



Material

Stainless steel
ferritic/martensitic



Stainless steel
ferritic/martensitic



Stainless steel
[Cr-Ni/1.4301]



Stainless steel
[Cr-Ni/1.4301]



Stainless steel
[Cr-Ni-Mo-.../1.4571]



Stainless steel
[Cr-Ni-Mo-.../1.4571]



Heat resistant steel
[17-4PH]



Heat resistant steel
[17-4PH]



M	d [mm]	P [mm]	v_c 1.5 x d			v_c 2.0 x d			v_c 3.0 x d		
			n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	
M2	2.000	0.40	12	1910	764	10	1590	636	8	1275	510
M2.5	2.500	0.45	12	1530	689	10	1275	574	8	1020	459
M3	3.000	0.50	12	1275	638	10	1060	530	8	850	425
M4	4.000	0.70	12	955	669	10	795	557	8	635	445
M5	5.000	0.80	12	765	612	10	635	508	8	510	408
M6	6.000	1.00	12	635	635	10	530	530	8	425	425
M8	8.000	1.25	12	475	594	10	400	500	8	320	400
M10	10.000	1.50	12	380	570	10	320	480	8	255	383
M12	12.000	1.75	12	320	560	10	265	464	8	210	368
M14	14.000	2.00	12	275	550	10	225	450	8	180	360
M16	16.000	2.00	12	240	480	10	200	400	8	160	320
M18	18.000	2.50	12	210	525	10	175	438	8	140	350
M20	20.000	2.50	12	190	475	10	160	400	8	125	313
M22	22.000	2.50	12	175	438	10	145	363	8	115	288
M24	24.000	3.00	12	160	480	10	135	405	8	105	315
M2	2.000	0.40	7	1115	446	5	795	318	4	635	254
M2.5	2.500	0.45	7	890	401	5	635	286	4	510	230
M3	3.000	0.50	7	745	373	5	530	265	4	425	213
M4	4.000	0.70	7	555	389	5	400	280	4	320	224
M5	5.000	0.80	7	445	356	5	320	256	4	255	204
M6	6.000	1.00	7	370	370	5	265	265	4	210	210
M8	8.000	1.25	7	280	350	5	200	250	4	160	200
M10	10.000	1.50	7	225	338	5	160	240	4	125	188
M12	12.000	1.75	7	185	324	5	135	236	4	105	184
M14	14.000	2.00	7	160	320	5	115	230	4	90	180
M16	16.000	2.00	7	140	280	5	100	200	4	80	160
M18	18.000	2.50	7	125	313	5	90	225	4	70	175
M20	20.000	2.50	7	110	275	5	80	200	4	65	163
M22	22.000	2.50	7	100	250	5	70	175	4	60	150
M24	24.000	3.00	7	95	285	5	65	195	4	55	165
M2	2.000	0.40	8	1275	510	6	955	382	5	795	318
M2.5	2.500	0.45	8	1020	459	6	765	344	5	635	286
M3	3.000	0.50	8	850	425	6	635	318	5	530	265
M4	4.000	0.70	8	635	445	6	475	333	5	400	280
M5	5.000	0.80	8	510	408	6	380	304	5	320	256
M6	6.000	1.00	8	425	425	6	320	320	5	265	265
M8	8.000	1.25	8	320	400	6	240	300	5	200	250
M10	10.000	1.50	8	255	383	6	190	285	5	160	240
M12	12.000	1.75	8	210	368	6	160	280	5	135	236
M14	14.000	2.00	8	180	360	6	135	270	5	115	230
M16	16.000	2.00	8	160	320	6	120	240	5	100	200
M18	18.000	2.50	8	140	350	6	105	263	5	90	225
M20	20.000	2.50	8	125	313	6	95	238	5	80	200
M22	22.000	2.50	8	115	288	6	85	213	5	70	175
M24	24.000	3.00	8	105	315	6	80	240	5	65	195
M2	2.000	0.40	5	795	318	4	635	254	3	475	190
M2.5	2.500	0.45	5	635	286	4	510	230	3	380	171
M3	3.000	0.50	5	530	265	4	425	213	3	320	160
M4	4.000	0.70	5	400	280	4	320	224	3	240	168
M5	5.000	0.80	5	320	256	4	255	204	3	190	152
M6	6.000	1.00	5	265	265	4	210	210	3	160	160
M8	8.000	1.25	5	200	250	4	160	200	3	120	150
M10	10.000	1.50	5	160	240	4	125	188	3	95	143
M12	12.000	1.75	5	135	236	4	105	184	3	80	140
M14	14.000	2.00	5	115	230	4	90	180	3	70	140
M16	16.000	2.00	5	100	200	4	80	160	3	60	120
M18	18.000	2.50	5	90	225	4	70	175	3	55	138
M20	20.000	2.50	5	80	200	4	65	163	3	50	125
M22	22.000	2.50	5	70	175	4	60	150	3	45	113
M24	24.000	3.00	5	65	195	4	55	165	3	40	120