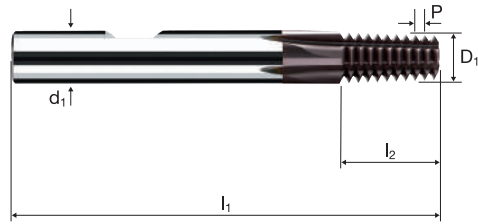
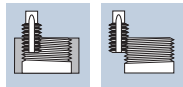
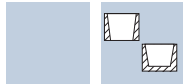


# Thread milling cutters



TM

ToolSchool

Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	Aluminium GG(G)
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Example: Order-N°.		Article-N°.	ø-Code							UNICUT-4X
Order-N°.		EU2200	840							EU2200
Ø Code	d	P(TPI)	l <sub>1</sub>	l <sub>2</sub>	d <sub>1</sub> h <sub>6</sub>	D <sub>1</sub>				
840	NPT 1/16 - 1/8	27	57	9.4	6	5.9	5		●	
842	NPT 1/4 - 3/8	18	63	14.1	8	7.9	5		●	
844	NPT 1/2 - 3/4	14	83	19.9	12	11.9	5		●	
846	NPT 1" - 2"	11.5	92	26.5	16	15.9	6		●	

Example: Order-N°.		Article-N°.	ø-Code							UNICUT-4X
Order-N°.		EU2210	840							EU2210
Ø Code	d	P(TPI)	l <sub>1</sub>	l <sub>2</sub>	d <sub>1</sub> h <sub>6</sub>	D <sub>1</sub>				
840	NPTF 1/16 - 1/8	27	57	9.4	6	5.9	5		●	
842	NPTF 1/4 - 3/8	18	63	14.1	8	7.9	5		●	
844	NPTF 1/2 - 3/4	14	83	19.9	12	11.9	5		●	
846	NPTF 1" - 2"	11.5	92	26.5	16	15.9	6		●	

## Application



## Material

Steel  
< 850 N/mm<sup>2</sup>

Steel  
850 - 1100 N/mm<sup>2</sup>

Stainless steel  
[Cr-Ni/1.4301]

Cast iron  
GG(G)

## Material

Wrought aluminium  
alloys Si < 6%

Cast aluminium

Unalloyed copper

Thermoplastics

NPT NPTF	D1 [mm]	P (TPI)	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>fc</sub>	v <sub>fc</sub>	v <sub>fc</sub>	v <sub>fc</sub>	v <sub>fc</sub>	V <sub>f</sub> [mm/min]	
							dD1 3/2	dD1 2/1	dD1 3/1	dD1 4/1	dD1 > 5/1		
1/16	- 1/8	5.90	27	5	30	0.0100	1620	27	40	53	60	64	80
1/4	- 3/8	7.90	18	5	30	0.0130	1210	27	40	53	60	64	80
1/2	- 3/4	11.90	14	5	30	0.0200	800	27	40	53	60	64	80
1	- 2	15.90	12	6	30	0.0265	600	32	48	63	71	76	95
1/16	- 1/8	5.90	27	5	20	0.0100	1080	18	28	37	41	44	55
1/4	- 3/8	7.90	18	5	20	0.0130	805	17	25	33	38	40	50
1/2	- 3/4	11.90	14	5	20	0.0200	535	18	28	37	41	44	55
1	- 2	15.90	12	6	20	0.0265	400	22	33	43	49	52	65
1/16	- 1/8	5.90	27	5	15	0.0100	810	13	20	27	30	32	40
1/4	- 3/8	7.90	18	5	15	0.0130	605	13	20	27	30	32	40
1/2	- 3/4	11.90	14	5	15	0.0200	400	13	20	27	30	32	40
1	- 2	15.90	12	6	15	0.0265	300	17	25	33	38	40	50
1/16	- 1/8	5.90	27	5	40	0.0100	2160	37	55	73	83	88	110
1/4	- 3/8	7.90	18	5	40	0.0130	1610	35	53	70	79	84	105
1/2	- 3/4	11.90	14	5	40	0.0200	1070	35	53	70	79	84	105
1	- 2	15.90	12	6	40	0.0265	800	42	63	83	94	100	125

NPT NPTF	D1 [mm]	P (TPI)	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>fc</sub>	v <sub>fc</sub>	v <sub>fc</sub>	v <sub>fc</sub>	v <sub>fc</sub>	V <sub>f</sub> [mm/min]	
							dD1 3/2	dD1 2/1	dD1 3/1	dD1 4/1	dD1 > 5/1		
1/16	- 1/8	5.90	27	5	50	0.0100	2700	45	68	90	101	108	135
1/4	- 3/8	7.90	18	5	50	0.0130	2015	43	65	87	98	104	130
1/2	- 3/4	11.90	14	5	50	0.0200	1335	45	68	90	101	108	135
1	- 2	15.90	12	6	50	0.0265	1000	53	80	107	120	128	160
1/16	- 1/8	5.90	27	5	60	0.0100	3235	53	80	107	120	128	160
1/4	- 3/8	7.90	18	5	60	0.0130	2420	52	78	103	116	124	155
1/2	- 3/4	11.90	14	5	60	0.0200	1605	53	80	107	120	128	160
1	- 2	15.90	12	6	60	0.0265	1200	63	95	127	143	152	190
1/16	- 1/8	5.90	27	5	70	0.0100	3775	63	95	127	143	152	190
1/4	- 3/8	7.90	18	5	70	0.0130	2820	62	93	123	139	148	185
1/2	- 3/4	11.90	14	5	70	0.0200	1870	62	93	123	139	148	185
1	- 2	15.90	12	6	70	0.0265	1400	75	113	150	169	180	225
1/16	- 1/8	5.90	27	5	90	0.0100	4855	82	123	163	184	196	245
1/4	- 3/8	7.90	18	5	90	0.0130	3625	78	118	157	176	188	235
1/2	- 3/4	11.90	14	5	90	0.0200	2405	80	120	160	180	192	240
1	- 2	15.90	12	6	90	0.0265	1800	95	143	190	214	228	285