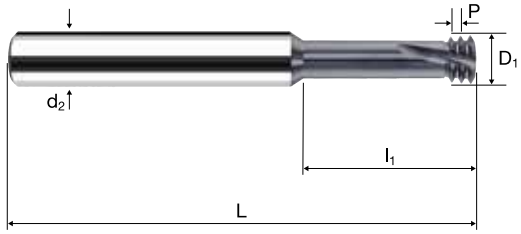
Thread whirler

3xd

M

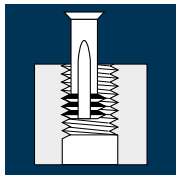
HM



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Aluminium/Copper GG(G) Nickel-Alloys

Example: **Order-N°.** Article-N°. **EH27502** ø-Code **022**

Ø Code	d	P	L	l_1	d_2 h6	D1	Rk 6H			TiCN EH27502
022	M 1.6	0.35	39	4.8	3.0	1.20	0.570	3	3	●
026	M 1.8	0.35	39	5.4	3.0	1.40	0.670	3	3	●
034	M 2	0.40	39	6.0	3.0	1.55	0.750	4	3	●
040	M 2.5	0.45	39	7.5	3.0	1.95	0.950	4	3	●
044	M 3	0.50	58	9.5	6.0	2.40	1.170	4	3	●
056	M 3.5	0.60	58	11.0	6.0	2.80	1.370	4	3	●
058	M 4	0.70	58	12.5	6.0	3.20	1.570	4	3	●
084	M 5	0.80	58	16.0	6.0	4.00	1.970	4	3	●
088	M 6	1.00	58	20.0	6.0	4.80	2.370	4	3	●
160	M 8	1.25	58	24.0	6.0	5.95	2.950	4	3	●
174	M 10	1.50	73	33.0	8.0	7.80	3.840	4	3	●
240	M 12	1.75	84	38.0	10.0	9.00	4.440	4	3	●
246	M 16	2.00	84	35.0	12.0	11.80	5.840	5	3	●

Application	Material	M	D_1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [min^{-1}]	v_{fc} [mm/min]	v_f [mm/min]
	Steel 850 - 1100 N/mm²	M 2	1.55	0.40	4	80	0.0100	16430	148	657
		M 3	2.40	0.50	4	80	0.0200	10610	170	849
		M 4	3.20	0.70	4	80	0.0200	7960	127	637
		M 5	4.00	0.80	4	80	0.0250	6365	127	637
		M 6	4.80	1.00	4	80	0.0300	5305	127	637
		M 8	5.95	1.25	4	80	0.0350	4280	154	599
		M 10	7.80	1.50	4	80	0.0500	3265	144	653
		M 12	9.00	1.75	4	80	0.0550	2830	156	623
		M 16	11.80	2.00	5	80	0.0600	2160	170	648
	Steel 1300 - 1500 N/mm²	M 2	1.55	0.40	4	45	0.0100	9240	83	370
		M 3	2.40	0.50	4	45	0.0200	5970	96	478
		M 4	3.20	0.70	4	45	0.0250	4475	90	448
		M 5	4.00	0.80	4	45	0.0300	3580	86	430
		M 6	4.80	1.00	4	45	0.0300	2985	72	358
		M 8	5.95	1.25	4	45	0.0300	2405	74	289
		M 10	7.80	1.50	4	45	0.0400	1835	65	294
		M 12	9.00	1.75	4	45	0.0500	1590	80	318
		M 16	11.80	2.00	5	45	0.0550	1215	88	334
	Stainless steel [Cr-Ni/1.4301]	M 2	1.55	0.40	4	55	0.0100	11295	102	452
		M 3	2.40	0.50	4	55	0.0200	7295	117	584
		M 4	3.20	0.70	4	55	0.0250	5470	109	547
		M 5	4.00	0.80	4	55	0.0300	4375	105	525
		M 6	4.80	1.00	4	55	0.0300	3645	87	437
		M 8	5.95	1.25	4	55	0.0300	2940	90	353
		M 10	7.80	1.50	4	55	0.0350	2245	69	314
		M 12	9.00	1.75	4	55	0.0500	1945	97	389
		M 16	11.80	2.00	5	55	0.0550	1485	107	408
	Nickel base alloys	M 2	1.55	0.40	4	30	0.0100	6160	55	246
		M 3	2.40	0.50	4	30	0.0100	3980	32	159
		M 4	3.20	0.70	4	30	0.0150	2985	36	179
		M 5	4.00	0.80	4	30	0.0200	2385	38	191
		M 6	4.80	1.00	4	30	0.0250	1990	40	199
		M 8	5.95	1.25	4	30	0.0300	1605	49	193
		M 10	7.80	1.50	4	30	0.0350	1225	38	172
		M 12	9.00	1.75	4	30	0.0400	1060	42	170
		M 16	11.80	2.00	5	30	0.0450	810	48	182
	Wrought aluminium alloys Si < 6%	M 2	1.55	0.40	4	150	0.0200	30805	554	2464
		M 3	2.40	0.50	4	150	0.0300	19895	477	2387
		M 4	3.20	0.70	4	150	0.0350	14920	418	2089
		M 5	4.00	0.80	4	150	0.0400	11935	382	1910
		M 6	4.80	1.00	4	150	0.0450	9945	358	1790
		M 8	5.95	1.25	4	150	0.0500	8025	411	1605
		M 10	7.80	1.50	4	150	0.0550	6120	296	1346
		M 12	9.00	1.75	4	150	0.0650	5305	345	1379
		M 16	11.80	2.00	5	150	0.0750	4045	398	1517
	Cast iron (lamellar / spheroidal)	M 2	1.55	0.40	4	120	0.0100	24645	222	986
		M 3	2.40	0.50	4	120	0.0200	15915	255	1273
		M 4	3.20	0.70	4	120	0.0250	11935	239	1194
		M 5	4.00	0.80	4	120	0.0300	9550	229	1146
		M 6	4.80	1.00	4	120	0.0350	7960	223	1114
		M 8	5.95	1.25	4	120	0.0400	6420	263	1027
		M 10	7.80	1.50	4	120	0.0500	4895	215	979
		M 12	9.00	1.75	4	120	0.0600	4245	255	1019
		M 16	11.80	2.00	5	120	0.0700	3235	297	1132
	Unalloyed copper	M 2	1.55	0.40	4	130	0.0100	26695	240	1068
		M 3	2.40	0.50	4	130	0.0200	17240	276	1379
		M 4	3.20	0.70	4	130	0.0250	12930	259	1293
		M 5	4.00	0.80	4	130	0.0300	10345	248	1241
		M 6	4.80	1.00	4	130	0.0350	8620	241	1207
		M 8	5.95	1.25	4	130	0.0400	6955	285	1113
		M 10	7.80	1.50	4	130	0.0450	5305	210	955
		M 12	9.00	1.75	4	130	0.0550	4600	253	1012
		M 16	11.80	2.00	5	130	0.0600	3505	276	1052
	Titanium alloys > 300 HB [Ti6Al4V]	M 2	1.55	0.40	4	40	0.0100	8215	74	329
		M 3	2.40	0.50	4	40	0.0100	5305	42	212
		M 4	3.20	0.70	4	40	0.0150	3980	48	239
		M 5	4.00	0.80	4	40	0.0200	3185	51	255
		M 6	4.80	1.00	4	40	0.0250	2655	53	266
		M 8	5.95	1.25	4	40	0.0300	2140	66	257
		M 10	7.80	1.50	4	40	0.0350	1630	50	228
		M 12	9.00	1.75	4	40	0.0400	1415	57	226
		M 16	11.80	2.00	5	40	0.0450	1080	64	243