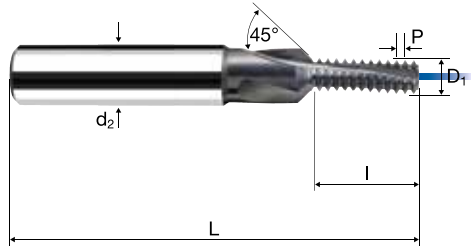
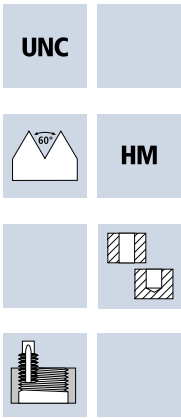


# Thread milling cutters

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)
----------	-------------	--------------	--------------	-----------	--	--	----------------	-------------	--------------------------

Example: Order-N°.		Article-N°.    ø-Code								TiCN
		<b>EH24360 709</b>								<b>EH24360</b>
Ø Code	d	P(TPI)	L	I	d <sub>2</sub> h6	D1	Rk <sub>2B</sub>			
709	1/4	20.0	62	14.60	8.0	4.80	2.337	3	●	
710	5/16	18.0	74	17.60	10.0	5.95	2.904	3	●	
711	3/8	16.0	80	21.40	12.0	7.10	3.471	4	●	
712	7/16	14.0	80	24.50	12.0	7.95	3.884	4	●	
713	1/2	13.0	90	28.30	14.0	9.95	4.877	4	●	

## Application



## Material

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



Steel  
1300 - 1500 N/mm<sup>2</sup>



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]



UNC	D <sub>1</sub> [mm]	P(TPI)	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	L <sub>K</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>fc</sub> [mm/min]	v <sub>f</sub> [mm/min]
1/4	4.80	20.0	3	80	0.0110	15.5	5305	43	175
5/16	5.95	18.0	3	80	0.0135	18.8	4280	43	173
3/8	7.10	16.0	4	80	0.0160	22.9	3585	58	229
7/16	7.95	14.0	4	80	0.0180	26.4	3205	66	231
1/2	9.95	13.0	4	80	0.0225	30.0	2560	50	230
1/4	4.80	20.0	3	50	0.0095	15.5	3315	23	95
5/16	5.95	18.0	3	50	0.0120	18.8	2675	24	96
3/8	7.10	16.0	4	50	0.0145	22.9	2240	33	130
7/16	7.95	14.0	4	50	0.0160	26.4	2000	36	128
1/2	9.95	13.0	4	50	0.0200	30.0	1600	28	128
1/4	4.80	20.0	3	30	0.0075	15.5	1990	11	45
5/16	5.95	18.0	3	30	0.0090	18.8	1605	11	43
3/8	7.10	16.0	4	30	0.0110	22.9	1345	15	59
7/16	7.95	14.0	4	30	0.0120	26.4	1200	16	58
1/2	9.95	13.0	4	30	0.0150	30.0	960	12	58
1/4	4.80	20.0	3	50	0.0075	15.5	3315	18	75
5/16	5.95	18.0	3	50	0.0090	18.8	2675	18	72
3/8	7.10	16.0	4	50	0.0110	22.9	2240	25	99
7/16	7.95	14.0	4	50	0.0120	26.4	2000	27	96
1/2	9.95	13.0	4	50	0.0150	30.0	1600	21	96
1/4	4.80	20.0	3	120	0.0110	15.5	7960	64	263
5/16	5.95	18.0	3	120	0.0135	18.8	6420	65	260
3/8	7.10	16.0	4	120	0.0160	22.9	5380	88	344
7/16	7.95	14.0	4	120	0.0180	26.4	4805	98	346
1/2	9.95	13.0	4	120	0.0225	30.0	3840	75	346
1/4	4.80	20.0	3	150	0.0150	15.5	9945	109	448
5/16	5.95	18.0	3	150	0.0190	18.8	8025	115	457
3/8	7.10	16.0	4	150	0.0225	22.9	6725	154	605
7/16	7.95	14.0	4	150	0.0250	26.4	6005	171	601
1/2	9.95	13.0	4	150	0.0315	30.0	4800	131	605
1/4	4.80	20.0	3	200	0.0150	15.5	13265	146	597
5/16	5.95	18.0	3	200	0.0190	18.8	10700	153	610
3/8	7.10	16.0	4	200	0.0225	22.9	8965	205	807
7/16	7.95	14.0	4	200	0.0250	26.4	8010	228	801
1/2	9.95	13.0	4	200	0.0315	30.0	6400	175	806
1/4	4.80	20.0	3	40	0.0075	15.5	2655	15	60
5/16	5.95	18.0	3	40	0.0090	18.8	2140	14	58
3/8	7.10	16.0	4	40	0.0110	22.9	1795	20	79
7/16	7.95	14.0	4	40	0.0120	26.4	1600	22	77
1/2	9.95	13.0	4	40	0.0150	30.0	1280	17	77