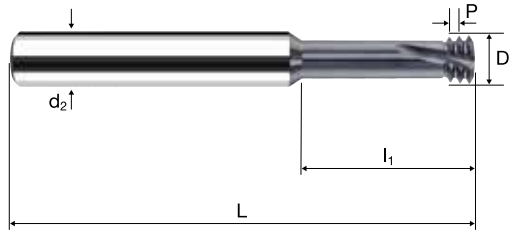
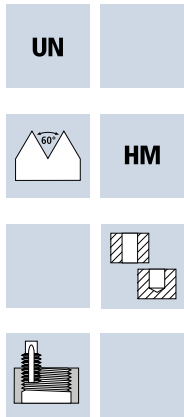


# Thread whirler

3xd

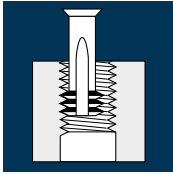


TM

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless		Aluminium / Copper GG(G)
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Example: Order-Nº. <b>EH27560 750</b>										TiCN
										<b>EH27560</b>
Ø Code	d	P(TPI)	L	l <sub>1</sub>	d <sub>2</sub> h <sub>6</sub>	D1	Rk 2B			
750	UNF Nr.1	72.0	39	5.8	3.0	1.45	0.700	3	3	●
751	UNC Nr.1 UNF Nr.2	64.0	39	6.0	3.0	1.40	0.670	3	3	●
752	UNC Nr.2 UNF Nr.3	56.0	39	7.0	3.0	1.65	0.800	4	3	●
753	UNC Nr.3 UNF Nr.4	48.0	39	8.0	3.0	1.90	0.920	4	3	●
755	UNC Nr.4	40.0	58	9.0	6.0	2.10	1.020	4	3	●
756	UNC Nr.5 UNF Nr.6	40.0	58	10.0	6.0	2.45	1.200	4	3	●
757	UNF Nr.8	36.0	58	12.0	6.0	3.30	1.620	4	3	●
758	UNC Nr.6	32.0	58	11.0	6.0	2.55	1.250	4	3	●
759	UNC Nr.8	32.0	58	13.0	6.0	3.20	1.570	4	3	●
760	UNF Nr.10	32.0	58	15.0	6.0	3.70	1.820	4	3	●
761	UNF Nr.12	28.0	58	16.0	6.0	4.20	2.070	4	3	●
762	UNF 1/4	28.0	58	19.6	6.0	5.00	2.470	4	3	●
763	UNC Nr.10-12	24.0	58	16.0	6.0	3.50	1.720	4	3	●
764	UNF 5/16-3/8	24.0	64	24.0	8.0	6.60	3.270	4	3	●
765	UNC 1/4	20.0	58	20.0	6.0	4.75	2.320	4	3	●
766	UNF 7/16	20.0	64	34.6	8.0	8.00	3.940	4	3	●
767	UNC 5/16	18.0	58	23.0	6.0	6.00	2.940	4	3	●
768	UNF 5/8	18.0	84	35.0	12.0	12.00	5.940	4	3	●
769	UNC 3/8	16.0	64	25.0	8.0	6.70	3.290	4	3	●
770	UNC 7/16	14.0	64	25.0	8.0	7.70	3.790	4	3	●

## Application



## Material

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



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



Steel  
1100 - 1300 N/mm<sup>2</sup>



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



Wrought aluminium  
alloys Si < 6%



Cast iron  
(lamellar / spheroidal)



Unalloyed copper



Stainless steel  
[Cr-Ni/1.4301]



UN	D <sub>1</sub> [mm]	P(TPI)	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>fc</sub> [mm/min]	v <sub>f</sub> [mm/min]
UNC Nr.1 UNF Nr.2	1.40	64.0	3	90	0.0100	20465	150	614
UNC Nr.3 UNF Nr.4	1.90	48.0	4	90	0.0200	15080	295	1206
UNC Nr.5 UNF Nr.6	2.45	40.0	4	90	0.0200	11695	214	936
UNC Nr.8	3.20	32.0	4	90	0.0200	8950	166	716
UNC Nr.10-12	3.50	24.0	4	90	0.0250	8185	225	819
UNC 1/4	4.75	20.0	4	90	0.0300	6030	182	724
UNF 7/16	8.00	20.0	4	90	0.0500	3580	201	716
UNF 5/8	12.00	18.0	4	90	0.0600	2385	140	572
UNC 3/8	6.70	16.0	4	90	0.0450	4275	228	770
UNC Nr.1 UNF Nr.2	1.40	64.0	3	80	0.0100	18190	134	546
UNC Nr.3 UNF Nr.4	1.90	48.0	4	80	0.0200	13405	262	1072
UNC Nr.5 UNF Nr.6	2.45	40.0	4	80	0.0200	10395	190	832
UNC Nr.8	3.20	32.0	4	80	0.0200	7960	148	637
UNC Nr.10-12	3.50	24.0	4	80	0.0250	7275	200	728
UNC 1/4	4.75	20.0	4	80	0.0300	5360	162	643
UNF 7/16	8.00	20.0	4	80	0.0500	3185	178	637
UNF 5/8	12.00	18.0	4	80	0.0600	2120	124	509
UNC 3/8	6.70	16.0	4	80	0.0450	3800	203	684
UNC Nr.1 UNF Nr.2	1.40	64.0	3	60	0.0100	13640	100	409
UNC Nr.3 UNF Nr.4	1.90	48.0	4	60	0.0200	10050	197	804
UNC Nr.5 UNF Nr.6	2.45	40.0	4	60	0.0200	7795	142	624
UNC Nr.8	3.20	32.0	4	60	0.0250	5970	138	597
UNC Nr.10-12	3.50	24.0	4	60	0.0250	5455	150	546
UNC 1/4	4.75	20.0	4	60	0.0300	4020	122	482
UNF 7/16	8.00	20.0	4	60	0.0400	2385	107	382
UNF 5/8	12.00	18.0	4	60	0.0600	1590	93	382
UNC 3/8	6.70	16.0	4	60	0.0350	2850	118	399
UNC Nr.1 UNF Nr.2	1.40	64.0	3	45	0.0100	10230	75	307
UNC Nr.3 UNF Nr.4	1.90	48.0	4	45	0.0200	7540	148	603
UNC Nr.5 UNF Nr.6	2.45	40.0	4	45	0.0200	5845	107	468
UNC Nr.8	3.20	32.0	4	45	0.0250	4475	104	448
UNC Nr.10-12	3.50	24.0	4	45	0.0250	4095	113	410
UNC 1/4	4.75	20.0	4	45	0.0300	3015	91	362
UNF 7/16	8.00	20.0	4	45	0.0400	1790	80	286
UNF 5/8	12.00	18.0	4	45	0.0600	1195	70	287
UNC 3/8	6.70	16.0	4	45	0.0350	2140	89	300
UNC Nr.1 UNF Nr.2	1.40	64.0	3	150	0.0200	34105	501	2046
UNC Nr.3 UNF Nr.4	1.90	48.0	4	150	0.0300	25130	737	3016
UNC Nr.5 UNF Nr.6	2.45	40.0	4	150	0.0300	19490	534	2339
UNC Nr.8	3.20	32.0	4	150	0.0350	14920	484	2089
UNC Nr.10-12	3.50	24.0	4	150	0.0400	13640	600	2182
UNC 1/4	4.75	20.0	4	150	0.0450	10050	456	1809
UNF 7/16	8.00	20.0	4	150	0.0600	5970	401	1433
UNF 5/8	12.00	18.0	4	150	0.0800	3980	311	1274
UNC 3/8	6.70	16.0	4	150	0.0550	7125	465	1568
UNC Nr.1 UNF Nr.2	1.40	64.0	3	120	0.0100	27285	200	819
UNC Nr.3 UNF Nr.4	1.90	48.0	4	120	0.0200	20105	393	1608
UNC Nr.5 UNF Nr.6	2.45	40.0	4	120	0.0200	15590	285	1247
UNC Nr.8	3.20	32.0	4	120	0.0250	11935	277	1194
UNC Nr.10-12	3.50	24.0	4	120	0.0250	10915	300	1092
UNC 1/4	4.75	20.0	4	120	0.0350	8040	284	1126
UNF 7/16	8.00	20.0	4	120	0.0500	4775	267	955
UNF 5/8	12.00	18.0	4	120	0.0700	3185	218	892
UNC 3/8	6.70	16.0	4	120	0.0450	5700	304	1026
UNC Nr.1 UNF Nr.2	1.40	64.0	3	130	0.0100	29555	217	887
UNC Nr.3 UNF Nr.4	1.90	48.0	4	130	0.0100	21780	213	871
UNC Nr.5 UNF Nr.6	2.45	40.0	4	130	0.0200	16890	309	1351
UNC Nr.8	3.20	32.0	4	130	0.0250	12930	300	1293
UNC Nr.10-12	3.50	24.0	4	130	0.0250	11825	325	1183
UNC 1/4	4.75	20.0	4	130	0.0350	8710	307	1219
UNF 7/16	8.00	20.0	4	130	0.0500	5175	290	1035
UNF 5/8	12.00	18.0	4	130	0.0650	3450	219	897
UNC 3/8	6.70	16.0	4	130	0.0400	6175	293	988
UNC Nr.1 UNF Nr.2	1.40	64.0	3	55	0.0100	12505	92	375
UNC Nr.3 UNF Nr.4	1.90	48.0	4	55	0.0200	9215	180	737
UNC Nr.5 UNF Nr.6	2.45	40.0	4	55	0.0200	7145	131	572
UNC Nr.8	3.20	32.0	4	55	0.0250	5470	127	547
UNC Nr.10-12	3.50	24.0	4	55	0.0250	5000	137	500
UNC 1/4	4.75	20.0	4	55	0.0300	3685	111	442
UNF 7/16	8.00	20.0	4	55	0.0400	2190	98	350
UNF 5/8	12.00	18.0	4	55	0.0600	1460	86	350
UNC 3/8	6.70	16.0	4	55	0.0350	2615	109	366