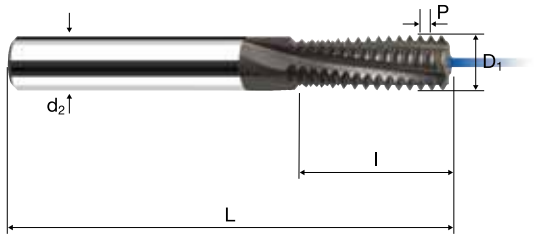
Thread milling cutters

2xd, Incool

UNC

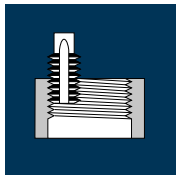
HM



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°. **EH20360** ø-Code **707**

Ø Code	d	P(TPI)	L	l	d_2 h6	D1	Rk 2B		TiCN EH20360
707	Nr.10	24.0	54	11.10	6.0	3.40	1.670	3	●
708	Nr.12	24.0	54	12.20	6.0	4.10	2.020	3	●
709	1/4	20.0	54	14.60	6.0	4.70	2.290	3	●
710	5/16	18.0	64	17.60	8.0	6.10	2.990	3	●
711	3/8	16.0	64	21.40	8.0	7.60	3.740	3	●
712	7/16	14.0	74	24.50	10.0	9.00	4.440	3	●
713	1/2	13.0	74	28.30	10.0	9.95	4.920	4	●
714	9/16	12.0	90	30.70	12.0	11.40	5.650	4	●
715	5/8	11.0	90	35.80	14.0	12.70	6.300	4	●

Application	Material	UNC	D_1 [mm]	P(TPI)	z	v_c [m/min]	f_z [mm]	n [min^{-1}]	v_{fc} [mm/min]	v_f [mm/min]
	Steel < 850 N/mm²	Nr.10	3.40	24.0	3	90	0.0160	8425	119	404
		Nr.12	4.10	24.0	3	90	0.0200	6985	106	419
		1/4	4.70	20.0	3	90	0.0240	6095	114	439
		5/16	6.10	18.0	3	90	0.0280	4695	91	394
		3/8	7.60	16.0	3	90	0.0360	3770	82	407
		7/16	9.00	14.0	3	90	0.0440	3185	80	420
		1/2	9.95	13.0	4	90	0.0480	2880	120	553
		9/16	11.40	12.0	4	90	0.0480	2515	98	483
		5/8	12.70	11.0	4	90	0.0480	2255	87	433
	Steel 850 - 1100 N/mm²	Nr.10	3.40	24.0	3	80	0.0160	7490	106	360
		Nr.12	4.10	24.0	3	80	0.0200	6210	94	373
		1/4	4.70	20.0	3	80	0.0240	5420	101	390
		5/16	6.10	18.0	3	80	0.0280	4175	81	351
		3/8	7.60	16.0	3	80	0.0360	3350	73	362
		7/16	9.00	14.0	3	80	0.0440	2830	71	374
		1/2	9.95	13.0	4	80	0.0480	2560	106	492
		9/16	11.40	12.0	4	80	0.0480	2235	87	429
		5/8	12.70	11.0	4	80	0.0480	2005	77	385
	Steel 1100 - 1300 N/mm²	Nr.10	3.40	24.0	3	60	0.0160	5615	80	270
		Nr.12	4.10	24.0	3	60	0.0200	4660	71	280
		1/4	4.70	20.0	3	60	0.0240	4065	76	293
		5/16	6.10	18.0	3	60	0.0240	3130	52	225
		3/8	7.60	16.0	3	60	0.0320	2515	49	241
		7/16	9.00	14.0	3	60	0.0400	2120	48	254
		1/2	9.95	13.0	4	60	0.0440	1920	73	338
		9/16	11.40	12.0	4	60	0.0440	1675	60	295
		5/8	12.70	11.0	4	60	0.0480	1505	58	289
	Steel 1300 - 1500 N/mm²	Nr.10	3.40	24.0	3	45	0.0160	4215	60	202
		Nr.12	4.10	24.0	3	45	0.0200	3495	53	210
		1/4	4.70	20.0	3	45	0.0240	3050	57	220
		5/16	6.10	18.0	3	45	0.0240	2350	39	169
		3/8	7.60	16.0	3	45	0.0320	1885	37	181
		7/16	9.00	14.0	3	45	0.0400	1590	36	191
		1/2	9.95	13.0	4	45	0.0440	1440	55	253
		9/16	11.40	12.0	4	45	0.0440	1255	45	221
		5/8	12.70	11.0	4	45	0.0480	1130	43	217
	Wrought aluminium alloys Si < 6% hardened	Nr.10	3.40	24.0	3	150	0.0280	14045	349	1180
		Nr.12	4.10	24.0	3	150	0.0320	11645	282	1118
		1/4	4.70	20.0	3	150	0.0360	10160	285	1097
		5/16	6.10	18.0	3	150	0.0400	7825	217	939
		3/8	7.60	16.0	3	150	0.0440	6280	168	829
		7/16	9.00	14.0	3	150	0.0520	5305	157	828
		1/2	9.95	13.0	4	150	0.0560	4800	233	1075
		9/16	11.40	12.0	4	150	0.0560	4190	190	939
		5/8	12.70	11.0	4	150	0.0640	3760	193	963
	Cast iron (lamellar / spheroidal)	Nr.10	3.40	24.0	3	120	0.0200	11235	199	674
		Nr.12	4.10	24.0	3	120	0.0240	9315	169	671
		1/4	4.70	20.0	3	120	0.0280	8125	177	683
		5/16	6.10	18.0	3	120	0.0320	6260	139	601
		3/8	7.60	16.0	3	120	0.0360	5025	110	543
		7/16	9.00	14.0	3	120	0.0480	4245	116	611
		1/2	9.95	13.0	4	120	0.0520	3840	173	799
		9/16	11.40	12.0	4	120	0.0520	3350	141	697
		5/8	12.70	11.0	4	120	0.0560	3010	135	674
	Unalloyed copper	Nr.10	3.40	24.0	3	130	0.0200	12170	216	730
		Nr.12	4.10	24.0	3	130	0.0240	10095	184	727
		1/4	4.70	20.0	3	130	0.0280	8805	192	740
		5/16	6.10	18.0	3	130	0.0320	6785	151	651
		3/8	7.60	16.0	3	130	0.0360	5445	119	588
		7/16	9.00	14.0	3	130	0.0480	4600	126	662
		1/2	9.95	13.0	4	130	0.0520	4160	187	865
		9/16	11.40	12.0	4	130	0.0520	3630	153	755
		5/8	12.70	11.0	4	130	0.0560	3260	146	730
	Stainless steel [Cr-Ni/1.4301]	Nr.10	3.40	24.0	3	55	0.0200	5150	91	309
		Nr.12	4.10	24.0	3	55	0.0240	4270	78	307
		1/4	4.70	20.0	3	55	0.0240	3725	70	268
		5/16	6.10	18.0	3	55	0.0240	2870	48	207
		3/8	7.60	16.0	3	55	0.0280	2305	39	194
		7/16	9.00	14.0	3	55	0.0400	1945	44	233
		1/2	9.95	13.0	4	55	0.0440	1760	67	310
		9/16	11.40	12.0	4	55	0.0440	1535	55	270
		5/8	12.70	11.0	4	55	0.0480	1380	53	265