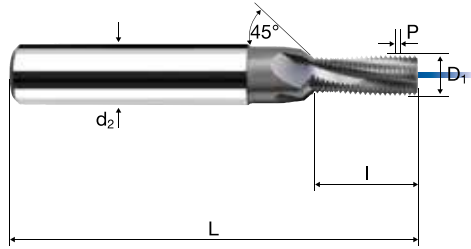
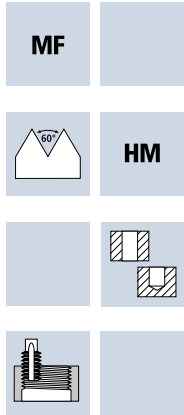


# Thread milling cutters

2xd, chamfer 45°, Incool



TM

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Aluminium / Copper GG(G)
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										TiCN
Example: Order-Nº. <span style="margin-left: 100px;">Article-Nº.</span> <span style="margin-left: 20px;">ø-Code</span> <b>EH24320 046</b>										<b>EH24320</b>
Ø Code	d	P	L	I	d <sub>2</sub> h <sub>6</sub>	D1	Rk 6H			
046	M 4	0.50	48	8.80	6.0	3.00	1.475	3		●
048	M 5	0.50	54	10.80	6.0	4.00	1.975	3		●
050	M 6	0.50	62	12.80	8.0	4.80	2.375	3		●
064	M 6	0.75	62	13.10	8.0	4.80	2.363	3		●
066	M 8	0.75	74	16.90	10.0	6.40	3.163	3		●
090	M 8	1.00	74	17.50	10.0	6.40	3.150	3		●
092	M 10	1.00	80	21.50	12.0	7.95	3.925	4		●
162	M 10	1.25	80	21.90	12.0	7.95	3.913	4		●
094	M 12	1.00	90	25.50	14.0	9.95	4.925	4		●
176	M 12	1.50	90	26.30	14.0	9.95	4.900	4		●
178	M 14	1.50	102	30.80	16.0	11.20	5.525	4		●
180	M 16	1.50	102	33.80	18.0	12.80	6.325	4		●

## Application



## Material

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



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



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



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



Wrought aluminium alloys  
Si < 6%  
hardened



Wrought aluminium alloys  
Si < 6%  
hardened



Cast iron  
(lamellar / spheroidal)



Cast iron  
(lamellar / spheroidal)



MF	D <sub>1</sub> [mm]	P [mm]	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]
M4	3.00	0.50	3	80	0.0070	9.4	8490	45	178
M5	4.00	0.50	3	80	0.0090	11.4	6365	34	172
M6	4.80	0.50	3	80	0.0110	13.6	5305	35	175
M6	4.80	0.75	3	80	0.0110	13.9	5305	35	175
M8	6.40	0.75	3	80	0.0145	17.9	3980	35	173
M8	6.40	1.00	3	80	0.0145	18.5	3980	35	173
M10	7.95	1.00	4	80	0.0180	22.8	3205	47	231
M10	7.95	1.25	4	80	0.0180	23.2	3205	47	231
M12	9.95	1.00	4	80	0.0225	26.8	2560	39	230
M12	9.95	1.50	4	80	0.0225	27.6	2560	39	230
M14	11.20	1.50	4	80	0.0250	32.6	2275	46	228
M16	12.80	1.50	4	80	0.0290	35.8	1990	46	231
M4	3.00	0.50	3	50	0.0060	9.4	5305	24	96
M5	4.00	0.50	3	50	0.0080	11.4	3980	19	96
M6	4.80	0.50	3	50	0.0095	13.6	3315	19	95
M6	4.80	0.75	3	50	0.0095	13.9	3315	19	95
M8	6.40	0.75	3	50	0.0125	17.9	2485	19	93
M8	6.40	1.00	3	50	0.0125	18.5	2485	19	93
M10	7.95	1.00	4	50	0.0160	22.8	2000	26	128
M10	7.95	1.25	4	50	0.0160	23.2	2000	26	128
M12	9.95	1.00	4	50	0.0200	26.8	1600	22	128
M12	9.95	1.50	4	50	0.0200	27.6	1600	22	128
M14	11.20	1.50	4	50	0.0225	32.6	1420	26	128
M16	12.80	1.50	4	50	0.0255	35.8	1245	25	127
M4	3.00	0.50	3	150	0.0095	9.4	15915	113	454
M5	4.00	0.50	3	150	0.0125	11.4	11935	90	448
M6	4.80	0.50	3	150	0.0155	13.6	9945	92	462
M6	4.80	0.75	3	150	0.0155	13.9	9945	92	462
M8	6.40	0.75	3	150	0.0205	17.9	7460	92	459
M8	6.40	1.00	3	150	0.0205	18.5	7460	92	459
M10	7.95	1.00	4	150	0.0250	22.8	6005	123	601
M10	7.95	1.25	4	150	0.0250	23.2	6005	123	601
M12	9.95	1.00	4	150	0.0315	26.8	4800	103	605
M12	9.95	1.50	4	150	0.0315	27.6	4800	103	605
M14	11.20	1.50	4	150	0.0355	32.6	4265	121	606
M16	12.80	1.50	4	150	0.0405	35.8	3730	121	604
M4	3.00	0.50	3	120	0.0070	9.4	12730	67	267
M5	4.00	0.50	3	120	0.0090	11.4	9550	52	258
M6	4.80	0.50	3	120	0.0110	13.6	7960	53	263
M6	4.80	0.75	3	120	0.0110	13.9	7960	53	263
M8	6.40	0.75	3	120	0.0145	17.9	5970	52	260
M8	6.40	1.00	3	120	0.0145	18.5	5970	52	260
M10	7.95	1.00	4	120	0.0180	22.8	4805	71	346
M10	7.95	1.25	4	120	0.0180	23.2	4805	71	346
M12	9.95	1.00	4	120	0.0225	26.8	3840	59	346
M12	9.95	1.50	4	120	0.0225	27.6	3840	59	346
M14	11.20	1.50	4	120	0.0250	32.6	3410	68	341
M16	12.80	1.50	4	120	0.0290	35.8	2985	69	346