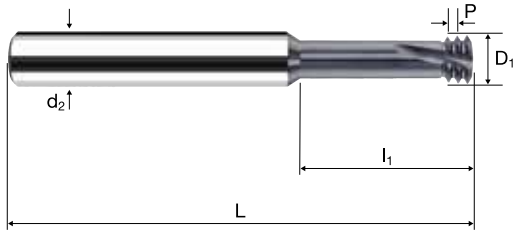
Thread whirler

3xd

G

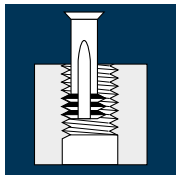
HM



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°. **EH27540** ø-Code **550**

Ø Code	d	P(TPI)	L	l_1	d_2 h6	D1	Rk			TiCN EH27540
550	G 1/8	28.0	64	19.5	8.0	6.20	3.070	4	3	●
552	G 3/8	19.0	73	25.0	10.0	9.95	4.920	4	3	●
554	G 7/8	14.0	84	37.0	12.0	11.95	5.920	4	3	●
558	G 2''	11.0	105	44.0	16.0	15.95	7.930	5	3	●

Application	Material	G	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 - 1100 N/mm²	G 1/8	6.20	28.0	4	80	0.0350	4105	208	575
		G 3/8	9.95	19.0	4	80	0.0600	2560	248	614
		G 7/8	11.95	14.0	4	80	0.0600	2130	309	511
		G 2"	15.95	11.0	5	80	0.0650	1595	380	518
	Steel 1300 - 1500 N/mm²	G 1/8	6.20	28.0	4	45	0.0300	2310	101	277
		G 3/8	9.95	19.0	4	45	0.0550	1440	128	317
		G 7/8	11.95	14.0	4	45	0.0600	1200	174	288
		G 2"	15.95	11.0	5	45	0.0650	900	214	293
	Stainless steel [Cr-Ni/1.4301]	G 1/8	6.20	28.0	4	55	0.0300	2825	123	339
		G 3/8	9.95	19.0	4	55	0.0550	1760	156	387
		G 7/8	11.95	14.0	4	55	0.0600	1465	212	352
		G 2"	15.95	11.0	5	55	0.0650	1100	262	358
	Nickel base alloys	G 1/8	6.20	28.0	4	30	0.0300	1540	67	185
		G 3/8	9.95	19.0	4	30	0.0400	960	62	154
		G 7/8	11.95	14.0	4	30	0.0500	800	97	160
		G 2"	15.95	11.0	5	30	0.0600	600	132	180
	Wrought aluminium alloys Si < 6%	G 1/8	6.20	28.0	4	150	0.0500	7700	559	1540
		G 3/8	9.95	19.0	4	150	0.0700	4800	541	1344
		G 7/8	11.95	14.0	4	150	0.0800	3995	773	1278
		G 2"	15.95	11.0	5	150	0.0900	2995	987	1348
	Cast iron (lamellar / spheroidal)	G 1/8	6.20	28.0	4	120	0.0400	6160	357	986
		G 3/8	9.95	19.0	4	120	0.0650	3840	402	998
		G 7/8	11.95	14.0	4	120	0.0700	3195	541	895
		G 2"	15.95	11.0	5	120	0.0900	2395	789	1078
	Unalloyed copper	G 1/8	6.20	28.0	4	130	0.0400	6675	387	1068
		G 3/8	9.95	19.0	4	130	0.0600	4160	402	998
		G 7/8	11.95	14.0	4	130	0.0650	3465	544	901
		G 2"	15.95	11.0	5	130	0.0750	2595	713	973
	Titanium alloys > 300 HB [Ti6Al4V]	G 1/8	6.20	28.0	4	40	0.0300	2055	89	247
		G 3/8	9.95	19.0	4	40	0.0400	1280	83	205
		G 7/8	11.95	14.0	4	40	0.0500	1065	129	213
		G 2"	15.95	11.0	5	40	0.0600	800	176	240