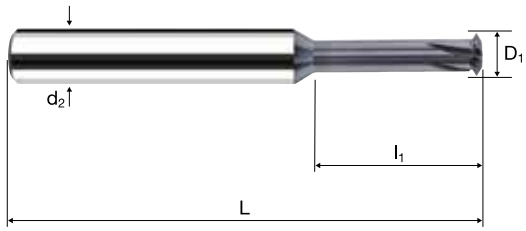
Thread whirler

3xd

M

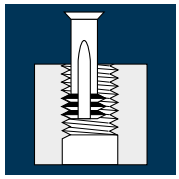
HM



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°. **EH27500** ø-Code **020**

Ø Code	d	P max.	L	l_1	d_2 h6	D1	Rk 6H			TiCN EH27500
020	M 1.4 - M 1.8	0.35	39	3.8	3.0	1.05	0.500	3	1	●
034	M 2 - M 2.4	0.40	39	7.0	3.0	1.50	0.720	3	1	●
040	M 2.5 - M 3	0.50	39	9.0	3.0	2.00	0.970	4	1	●
056	M 3.5 - M 4.5	0.75	58	14.0	6.0	2.80	1.370	4	1	●
084	M 5 - M 7	1.00	58	19.0	6.0	4.00	1.970	4	1	●
160	M 8 - M 10	1.50	64	24.0	8.0	6.40	3.140	5	1	●

Application	Material	M	D_1 [mm]	P max.	z	v_c [m/min]	f_z [mm]	n [min^{-1}]	v_{fc} [mm/min]	v_f [mm/min]
	Steel 850 - 1100 N/mm²	M 1.4 - M 1.8	1.05	0.35	3	80	0.0100	24250	250	728
		M 2 - M 2.4	1.50	0.40	3	80	0.0100	16975	127	509
		M 2.5 - M 3	2.00	0.50	4	80	0.0200	12730	339	1018
		M 3.5 - M 4.5	2.80	0.75	4	80	0.0200	9095	275	728
		M 5 - M 7	4.00	1.00	4	80	0.0250	6365	212	637
		M 8 - M 10	6.40	1.50	5	80	0.0350	3980	251	697
	Steel 1300 - 1500 N/mm²	M 1.4 - M 1.8	1.05	0.35	3	45	0.0100	13640	141	409
		M 2 - M 2.4	1.50	0.40	3	45	0.0100	9550	72	287
		M 2.5 - M 3	2.00	0.50	4	45	0.0200	7160	191	573
		M 3.5 - M 4.5	2.80	0.75	4	45	0.0200	5115	155	409
		M 5 - M 7	4.00	1.00	4	45	0.0300	3580	143	430
		M 8 - M 10	6.40	1.50	5	45	0.0300	2240	121	336
	Stainless steel [Cr-Ni/1.4301]	M 1.4 - M 1.8	1.05	0.35	3	55	0.0100	16675	172	500
		M 2 - M 2.4	1.50	0.40	3	55	0.0100	11670	88	350
		M 2.5 - M 3	2.00	0.50	4	55	0.0200	8755	233	700
		M 3.5 - M 4.5	2.80	0.75	4	55	0.0250	6255	236	626
		M 5 - M 7	4.00	1.00	4	55	0.0300	4375	175	525
		M 8 - M 10	6.40	1.50	5	55	0.0300	2735	148	410
	Nickel base alloys	M 1.4 - M 1.8	1.05	0.35	3	30	0.0100	9095	94	273
		M 2 - M 2.4	1.50	0.40	3	30	0.0100	6365	48	191
		M 2.5 - M 3	2.00	0.50	4	30	0.0100	4775	64	191
		M 3.5 - M 4.5	2.80	0.75	4	30	0.0150	3410	77	205
		M 5 - M 7	4.00	1.00	4	30	0.0200	2385	64	191
		M 8 - M 10	6.40	1.50	5	30	0.0300	1490	80	224
	Wrought aluminium alloys Si < 6%	M 1.4 - M 1.8	1.05	0.35	3	150	0.0200	45475	938	2729
		M 2 - M 2.4	1.50	0.40	3	150	0.0200	31830	477	1910
		M 2.5 - M 3	2.00	0.50	4	150	0.0300	23875	955	2865
		M 3.5 - M 4.5	2.80	0.75	4	150	0.0350	17050	902	2387
		M 5 - M 7	4.00	1.00	4	150	0.0400	11935	637	1910
		M 8 - M 10	6.40	1.50	5	150	0.0500	7460	671	1865
	Cast iron GG(G)	M 1.4 - M 1.8	1.05	0.35	3	120	0.0100	36380	375	1091
		M 2 - M 2.4	1.50	0.40	3	120	0.0100	25465	191	764
		M 2.5 - M 3	2.00	0.50	4	120	0.0200	19100	509	1528
		M 3.5 - M 4.5	2.80	0.75	4	120	0.0250	13640	515	1364
		M 5 - M 7	4.00	1.00	4	120	0.0300	9550	382	1146
		M 8 - M 10	6.40	1.50	5	120	0.0400	5970	430	1194
	Unalloyed copper	M 1.4 - M 1.8	1.05	0.35	3	130	0.0100	39410	406	1182
		M 2 - M 2.4	1.50	0.40	3	130	0.0100	27585	207	828
		M 2.5 - M 3	2.00	0.50	4	130	0.0200	20690	552	1655
		M 3.5 - M 4.5	2.80	0.75	4	130	0.0250	14780	558	1478
		M 5 - M 7	4.00	1.00	4	130	0.0300	10345	414	1241
		M 8 - M 10	6.40	1.50	5	130	0.0400	6465	465	1293
	Titanium alloys > 300 HB [Ti6Al4V]	M 1.4 - M 1.8	1.05	0.35	3	40	0.0100	12125	125	364
		M 2 - M 2.4	1.50	0.40	3	40	0.0100	8490	64	255
		M 2.5 - M 3	2.00	0.50	4	40	0.0100	6365	85	255
		M 3.5 - M 4.5	2.80	0.75	4	40	0.0150	4545	103	273
		M 5 - M 7	4.00	1.00	4	40	0.0200	3185	85	255
		M 8 - M 10	6.40	1.50	5	40	0.0300	1990	107	299