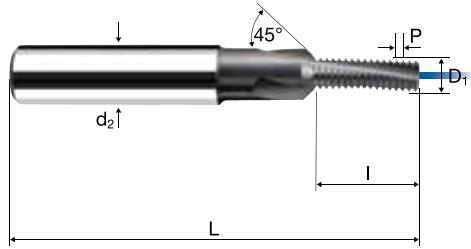
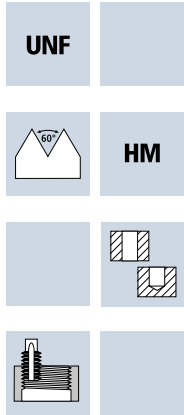


Thread milling cutters

2xd, chamfer 45°, Incool



TM

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56			Inox Stainless	Ti Titanium	Aluminium / Copper GG(G)
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Example: Order-Nº. EH24370 760										TiCN
Article-Nº. EH24370 ø-Code 760										EH24370
Ø Code	d	P(TPI)	L	I	d ₂ h6	D1	Rk _{2B}			
760	1/4	28.0	62	14.10	8.0	4.80	2.355	3		●
761	5/16	24.0	74	17.50	10.0	5.95	2.922	3		●
762	3/8	24.0	80	20.60	12.0	7.95	3.922	4		●
763	7/16	20.0	80	24.80	12.0	7.95	3.912	4		●
764	1/2	20.0	90	27.30	14.0	9.95	4.911	4		●

Application

Material



Steel
850 - 1100 N/mm²



Steel
1300 - 1500 N/mm²



Hardened tool steel
48 - 52 HRC



Stainless steel
[Cr-Ni/1.4301]



Cast iron
(lamellar / spheroidal)



Wrought aluminium alloys
Si < 6%
hardened



Cast aluminium



Titanium alloys
> 300 HB
[Ti6Al4V]



UNF	D ₁ [mm]	P(TPI)	z	v _c [m/min]	f _z [mm]	L _K [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
1/4	4.80	28.0	3	80	0.0110	15.0	5305	43	175
5/16	5.95	24.0	3	80	0.0135	18.7	4280	43	173
3/8	7.95	24.0	4	80	0.0180	21.6	3205	38	231
7/16	7.95	20.0	4	80	0.0180	26.7	3205	66	231
1/2	9.95	20.0	4	80	0.0225	29.0	2560	50	230
1/4	4.80	28.0	3	50	0.0095	15.0	3315	23	95
5/16	5.95	24.0	3	50	0.0120	18.7	2675	24	96
3/8	7.95	24.0	4	50	0.0160	21.6	2000	21	128
7/16	7.95	20.0	4	50	0.0160	26.7	2000	36	128
1/2	9.95	20.0	4	50	0.0200	29.0	1600	28	128
1/4	4.80	28.0	3	30	0.0075	15.0	1990	11	45
5/16	5.95	24.0	3	30	0.0090	18.7	1605	11	43
3/8	7.95	24.0	4	30	0.0120	21.6	1200	10	58
7/16	7.95	20.0	4	30	0.0120	26.7	1200	16	58
1/2	9.95	20.0	4	30	0.0150	29.0	960	12	58
1/4	4.80	28.0	3	50	0.0075	15.0	3315	18	75
5/16	5.95	24.0	3	50	0.0090	18.7	2675	18	72
3/8	7.95	24.0	4	50	0.0120	21.6	2000	16	96
7/16	7.95	20.0	4	50	0.0120	26.7	2000	27	96
1/2	9.95	20.0	4	50	0.0150	29.0	1600	21	96
1/4	4.80	28.0	3	120	0.0110	15.0	7960	64	263
5/16	5.95	24.0	3	120	0.0135	18.7	6420	65	260
3/8	7.95	24.0	4	120	0.0180	21.6	4805	57	346
7/16	7.95	20.0	4	120	0.0180	26.7	4805	98	346
1/2	9.95	20.0	4	120	0.0225	29.0	3840	75	346
1/4	4.80	28.0	3	150	0.0150	15.0	9945	109	448
5/16	5.95	24.0	3	150	0.0190	18.7	8025	115	457
3/8	7.95	24.0	4	150	0.0250	21.6	6005	99	601
7/16	7.95	20.0	4	150	0.0250	26.7	6005	171	601
1/2	9.95	20.0	4	150	0.0315	29.0	4800	131	605
1/4	4.80	28.0	3	200	0.0150	15.0	13265	146	597
5/16	5.95	24.0	3	200	0.0190	18.7	10700	153	610
3/8	7.95	24.0	4	200	0.0250	21.6	8010	132	801
7/16	7.95	20.0	4	200	0.0250	26.7	8010	228	801
1/2	9.95	20.0	4	200	0.0315	29.0	6400	175	806
1/4	4.80	28.0	3	40	0.0075	15.0	2655	15	60
5/16	5.95	24.0	3	40	0.0090	18.7	2140	14	58
3/8	7.95	24.0	4	40	0.0120	21.6	1600	13	77
7/16	7.95	20.0	4	40	0.0120	26.7	1600	22	77
1/2	9.95	20.0	4	40	0.0150	29.0	1280	17	77