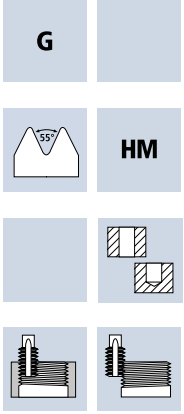
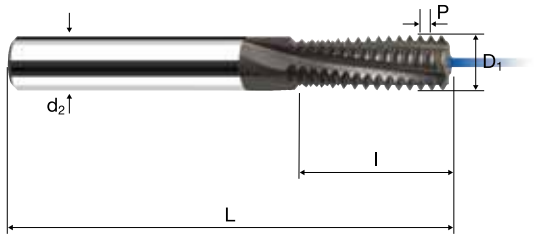
Thread milling cutters

2xd, Incool

G

HM

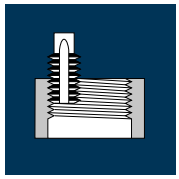




Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56			Inox Stainless	Ti Titanium	Aluminium / Copper GG(G)

Example: **Order-N°.** Article-N°. **EH20340** ø-Code **551**

Ø Code	d	P(TPI)	L	l	d_2 h6	D1	Rk		TiCN
									EH20340
551	G 1/8	28.0	64	21.30	8.0	7.95	3.950	3	●
552	G 1/4	19.0	90	28.70	12.0	10.50	5.190	4	●
553	G 3/8	19.0	90	35.40	14.0	13.60	6.740	4	●

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 N/mm²	G 1/8	7.95	28.0	3	90	0.0400	3605	79	433
		G 1/4	10.50	19.0	4	90	0.0480	2730	106	524
		G 3/8	13.60	19.0	4	90	0.0520	2105	80	438
	Steel 850 - 1100 N/mm²	G 1/8	7.95	28.0	3	80	0.0400	3205	70	385
		G 1/4	10.50	19.0	4	80	0.0480	2425	94	466
		G 3/8	13.60	19.0	4	80	0.0520	1870	71	389
	Steel 1100 - 1300 N/mm²	G 1/8	7.95	28.0	3	60	0.0320	2400	42	230
		G 1/4	10.50	19.0	4	60	0.0440	1820	65	320
		G 3/8	13.60	19.0	4	60	0.5200	1405	537	2922
	Steel 1300 - 1500 N/mm²	G 1/8	7.95	28.0	3	45	0.0320	1800	32	173
		G 1/4	10.50	19.0	4	45	0.0440	1365	49	240
		G 3/8	13.60	19.0	4	45	0.0520	1055	40	219
	Wrought aluminium alloys Si < 6% hardened	G 1/8	7.95	28.0	3	150	0.0480	6005	158	865
		G 1/4	10.50	19.0	4	150	0.0560	4545	206	1018
		G 3/8	13.60	19.0	4	150	0.0680	3510	175	955
	Cast iron (lamellar / spheroidal)	G 1/8	7.95	28.0	3	120	0.0400	4805	105	577
		G 1/4	10.50	19.0	4	120	0.0520	3640	153	757
		G 3/8	13.60	19.0	4	120	0.0640	2810	132	719
	Unalloyed copper	G 1/8	7.95	28.0	3	130	0.0400	5205	114	625
		G 1/4	10.50	19.0	4	130	0.0520	3940	165	820
		G 3/8	13.60	19.0	4	130	0.0640	3045	143	780
	Stainless steel [Cr-Ni/1.4301]	G 1/8	7.95	28.0	3	55	0.0320	2200	39	211
		G 1/4	10.50	19.0	4	55	0.0440	1665	59	293
		G 3/8	13.60	19.0	4	55	0.0520	1285	49	267