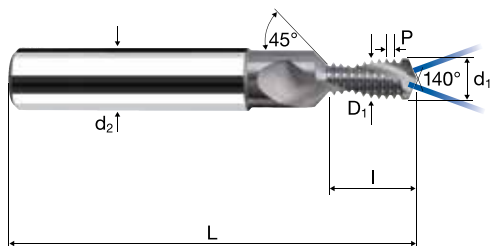
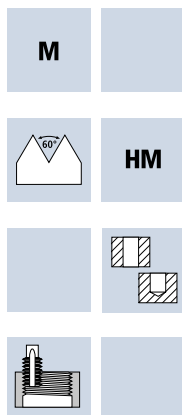


Drill/thread milling cutters

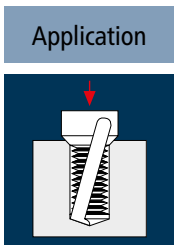
1.5xd, chamfer 45°, Incool



TM



										TiCN	
										E22200	EH22200
∅ Code	d	P	L	l	d ₂ h6	d ₁	D1	Rk 6H			
058	M 4	0.70	48	6.90	6.0	3.30	3.20	1.560	2	●	●
084	M 5	0.80	54	8.80	6.0	4.20	4.00	1.950	2	●	●
088	M 6	1.00	62	10.90	8.0	5.00	4.75	2.315	2	●	●
160	M 8	1.25	74	13.70	10.0	6.80	6.35	3.095	2	●	●
174	M 10	1.50	80	18.00	12.0	8.50	7.95	3.875	2	●	●
240	M 12	1.75	90	20.90	14.0	10.20	9.95	4.855	2	●	●
246	M 16	2.00	102	26.00	18.0	14.00	13.20	6.440	2	●	●



Material

Cast iron
GG(G)

M	d ₁ [mm]	v _c [m/min]	f _z [mm]	L _K [mm]	n [min ⁻¹]	v _f [mm/min]
M4	3.30	100	0.0500	7.4	9645	482
M5	4.20	100	0.0650	9.4	7580	493
M6	5.00	100	0.0750	11.7	6365	477
M8	6.80	100	0.1000	14.7	4680	468
M10	8.50	100	0.1250	19.3	3745	468
M12	10.20	100	0.1500	22.2	3120	468
M16	14.00	100	0.2100	27.8	2275	478

Cast aluminium

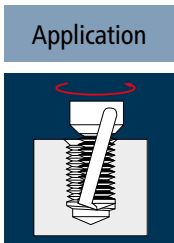
M4	3.30	250	0.0600	7.4	24115	1447
M5	4.20	250	0.0750	9.4	18945	1421
M6	5.00	250	0.0900	11.7	15915	1432
M8	6.80	250	0.1200	14.7	11705	1405
M10	8.50	250	0.1500	19.3	9360	1404
M12	10.20	250	0.1800	22.2	7800	1404
M16	14.00	250	0.2500	27.8	5685	1421

Wrought aluminium alloys
Si < 6%
hardened

M4	3.30	200	0.0600	7.4	19290	1157
M5	4.20	200	0.0750	9.4	15160	1137
M6	5.00	200	0.0900	11.7	12730	1146
M8	6.80	200	0.1200	14.7	9360	1123
M10	8.50	200	0.1500	19.3	7490	1124
M12	10.20	200	0.1800	22.2	6240	1123
M16	14.00	200	0.2500	27.8	4545	1136

Short-chipping brass
[CuZn]

M4	3.30	250	0.0600	7.4	24115	1447
M5	4.20	250	0.0750	9.4	18945	1421
M6	5.00	250	0.0900	11.7	15915	1432
M8	6.80	250	0.1200	14.7	11705	1405
M10	8.50	250	0.1500	19.3	9360	1404
M12	10.20	250	0.1800	22.2	7800	1404
M16	14.00	250	0.2500	27.8	5685	1421



Material

Cast iron
GG(G)

M	D ₁ [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fz} [mm/min]	v _f [mm/min]
M4	3.20	0.70	2	100	0.0250	9945	99	497
M5	4.00	0.80	2	100	0.0300	7960	96	478
M6	4.75	1.00	2	100	0.0350	6700	98	469
M8	6.35	1.25	2	100	0.0500	5015	103	502
M10	7.95	1.50	2	100	0.0600	4005	99	481
M12	9.95	1.75	2	100	0.0750	3200	82	480
M16	13.20	2.00	2	100	0.1000	2410	84	482

Cast aluminium

M4	3.20	0.70	2	250	0.0300	24870	298	1492
M5	4.00	0.80	2	250	0.0350	19895	279	1393
M6	4.75	1.00	2	250	0.0450	16755	314	1508
M8	6.35	1.25	2	250	0.0600	12530	310	1504
M10	7.95	1.50	2	250	0.0700	10010	287	1401
M12	9.95	1.75	2	250	0.0900	8000	246	1440
M16	13.20	2.00	2	250	0.1200	6030	253	1447

Wrought aluminium alloys
Si < 6%
hardened

M4	3.20	0.70	2	200	0.0300	19895	239	1194
M5	4.00	0.80	2	200	0.0350	15915	223	1114
M6	4.75	1.00	2	200	0.0450	13405	251	1207
M8	6.35	1.25	2	200	0.0600	10025	248	1203
M10	7.95	1.50	2	200	0.0700	8010	230	1121
M12	9.95	1.75	2	200	0.0900	6400	197	1152
M16	13.20	2.00	2	200	0.1200	4825	203	1158

Short-chipping brass
[CuZn]

M4	3.20	0.70	2	250	0.0300	24870	298	1492
M5	4.00	0.80	2	250	0.0350	19895	279	1393
M6	4.75	1.00	2	250	0.0450	16755	314	1508
M8	6.35	1.25	2	250	0.0600	12530	310	1504
M10	7.95	1.50	2	250	0.0700	10010	287	1401
M12	9.95	1.75	2	250	0.0900	8000	246	1440
M16	13.20	2.00	2	250	0.1200	6030	253	1447