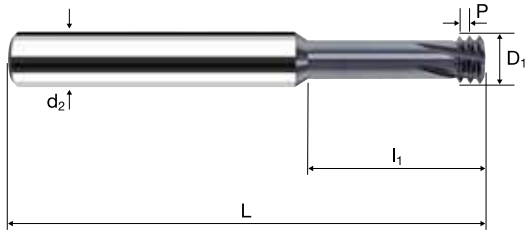
Thread whirler

3xd

M

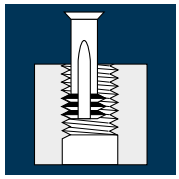
HM



Rm 1300-1500 | HRC 48-56 | HRC 56-60 | HRC > 60

Example:
Order-N°. Article-N°. **EI27504** ø-Code **034**

Ø Code	d	P	L	l_1	d_2 h6	D1	Rk 6H			INTEGRAL
										EI27504
034	M 2	0.40	39	6.0	3.0	1.55	0.750	4	3	●
040	M 2.5	0.45	39	7.5	3.0	1.95	0.950	4	3	●
044	M 3	0.50	58	9.5	6.0	2.35	1.150	4	3	●
058	M 4	0.70	58	12.5	6.0	3.10	1.520	4	3	●
084	M 5	0.80	58	16.0	6.0	3.80	1.870	4	3	●
088	M 6	1.00	58	20.0	6.0	4.80	2.370	4	3	●
160	M 8	1.25	58	24.0	6.0	5.95	2.950	4	3	●
174	M 10	1.50	64	23.0	8.0	7.80	3.840	4	3	●
240	M 12	1.75	73	26.0	10.0	9.00	4.440	5	3	●

Application	Material	M	D_1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [min^{-1}]	v_{fc} [mm/min]	v_f [mm/min]
	Hardened tool steel 48 - 52 HRC	M 2	1.55	0.40	4	45	0.0100	9240	83	370
		M 2.5	1.95	0.45	4	45	0.0100	7345	65	294
		M 3	2.35	0.50	4	45	0.0100	6095	53	244
		M 4	3.10	0.70	4	45	0.0150	4620	62	277
		M 5	3.80	0.80	4	45	0.0200	3770	72	302
		M 6	4.80	1.00	4	45	0.0250	2985	60	299
		M 8	5.95	1.25	4	45	0.0300	2405	74	289
		M 10	7.80	1.50	4	45	0.0350	1835	57	257
		M 12	9.00	1.75	5	45	0.0400	1590	80	318
	Hardened tool steel 52 - 56 HRC	M 2	1.55	0.40	4	45	0.0100	9240	83	370
		M 2.5	1.95	0.45	4	45	0.0100	7345	65	294
		M 3	2.35	0.50	4	45	0.0100	6095	53	244
		M 4	3.10	0.70	4	45	0.0150	4620	62	277
		M 5	3.80	0.80	4	45	0.0200	3770	72	302
		M 6	4.80	1.00	4	45	0.0250	2985	60	299
		M 8	5.95	1.25	4	45	0.0300	2405	74	289
		M 10	7.80	1.50	4	45	0.0350	1835	57	257
		M 12	9.00	1.75	5	45	0.0400	1590	80	318
	Hardened tool steel 56 - 60 HRC	M 2	1.55	0.40	4	40	0.0100	8215	74	329
		M 2.5	1.95	0.45	4	40	0.0100	6530	57	261
		M 3	2.35	0.50	4	40	0.0100	5420	47	217
		M 4	3.10	0.70	4	40	0.0150	4105	55	246
		M 5	3.80	0.80	4	40	0.0200	3350	64	268
		M 6	4.80	1.00	4	40	0.0250	2655	53	266
		M 8	5.95	1.25	4	40	0.0300	2140	66	257
		M 10	7.80	1.50	4	40	0.0350	1630	50	228
		M 12	9.00	1.75	5	40	0.0400	1415	71	283
	Hardened tool steel > 60 HRC	M 2	1.55	0.40	4	35	0.0100	7190	65	288
		M 2.5	1.95	0.45	4	35	0.0100	5715	50	229
		M 3	2.35	0.50	4	35	0.0100	4740	41	190
		M 4	3.10	0.70	4	35	0.0150	3595	49	216
		M 5	3.80	0.80	4	35	0.0200	2930	56	234
		M 6	4.80	1.00	4	35	0.0250	2320	46	232
		M 8	5.95	1.25	4	35	0.0300	1870	58	224
		M 10	7.80	1.50	4	35	0.0350	1430	44	200
		M 12	9.00	1.75	5	35	0.0400	1240	62	248