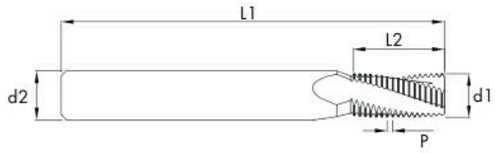
# SOLID CARBIDE THREAD MILLING CUTTERS

VOLLHARTMETALL GEWINDEFRASER

KARBÜR VIDA FREZE THREAD MILLING CUTTERS








## THREAD MILLING CUTTERS



QUALITY



NORM



DIAMETER



PITCH

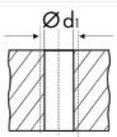


HELICAL



COATED

| M | P | $d_{1(e8)}$ | $L_2$ | $L_1$ | $d_{2(h6)}$ | Z | Uncoated Code | Coated Code |
|---|---|---|---|---|---|---|---|---|
| M5 | 0,80 | 3 | 8 | 42 | 4 | 4 | 4044580 | 4044590 |
| M6 | 1,00 | 4 | 9 | 57 | 6 | 4 | 4044600 | 4044610 |
| M8 | 1,25 | 5 | 12 | 57 | 6 | 4 | 4044620 | 4044630 |
| M10 | 1,50 | 7 | 15 | 63 | 8 | 4 | 4044640 | 4044650 |
| M12 | 1,75 | 8 | 19 | 72 | 10 | 4 | 4044660 | 4044670 |
| M16 | 2,00 | 10 | 24 | 72 | 10 | 5 | 4044680 | 4044690 |




| | P (20-30 Hrc) | | | P (30-40 Hrc) | | | M | | | GG | | | AL | | | CU | | | Titan | | | < 52 HRC | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 1.0050-2<br>1.0060-2<br>1.0070-2 | | | 1.5864<br>1.6580<br>1.7225 | | | 1.4405<br>1.4460<br>1.4505 | | | 0.6035<br>0.7080<br>0.8055 | | | 3.2151<br>3.2373<br>3.2382 | | | 2.1247<br>2.0580<br>2.0598 | | | 3.7035<br>3.7055<br>3.7065 | | | 1.3255<br>1.3265<br>1.3333 | | |
| | Vc= 60 m/dk. | | | Vc = 40 m/dk. | | | Vc = 50 m/dk. | | | Vc= 70 m/dk. | | | Vc = 140 m/dk. | | | Vc = 90 m/dk. | | | Vc = 40 m/dk. | | | Vc = 15 m/dk. | | |
| d1 | Fn | n | Vf | Fn | n | Vf | Fn | n | Vf | Fn | n | Vf | Fn | n | Vf | Fn | n | Vf | Fn | n | Vf | Fn | n | Vf |
| 5 | 0,04 | 3800 | 152 | 0,02 | 2500 | 50 | 0,02 | 3100 | 62 | 0,04 | 4500 | 180 | 0,06 | 8100 | 486 | 0,05 | 5750 | 280 | 0,02 | 2500 | 50 | 0,01 | 1000 | 10 |
| 6 | 0,04 | 3000 | 120 | 0,02 | 2000 | 40 | 0,02 | 2750 | 55 | 0,05 | 3700 | 185 | 0,08 | 7500 | 600 | 0,06 | 4750 | 280 | 0,02 | 2000 | 40 | 0,01 | 800 | 10 |
| 8 | 0,06 | 2508 | 150 | 0,03 | 1600 | 48 | 0,03 | 2000 | 60 | 0,07 | 2750 | 205 | 0,12 | 5500 | 660 | 0,07 | 3600 | 250 | 0,03 | 1600 | 48 | 0,015 | 600 | 8 |
| 10 | 0,06 | 2000 | 120 | 0,04 | 1250 | 50 | 0,04 | 1600 | 64 | 0,09 | 2300 | 207 | 0,14 | 4500 | 722 | 0,09 | 2900 | 260 | 0,04 | 1250 | 50 | 0,015 | 500 | 9 |
| 12 | 0,08 | 1600 | 128 | 0,05 | 1000 | 50 | 0,06 | 1350 | 81 | 0,11 | 1850 | 203 | 0,16 | 4000 | 640 | 0,10 | 2400 | 240 | 0,05 | 100 | 50 | 0,03 | 400 | 12 |
| 16 | 0,1 | 1200 | 120 | 0,07 | 800 | 56 | 0,08 | 1000 | 90 | 0,14 | 1400 | 196 | 0,20 | 2750 | 550 | 0,12 | 1800 | 250 | 0,07 | 800 | 56 | 0,04 | 300 | 12 |