Thread milling cutters M / MF / G / UNC / UNF / UN / NPT / NPTF

Drill / thread milling cutters with 45° chamfer

N° E22200	M	1.5xd		Al Aluminium Cast	GG(G) Cast iron	381
N° E22300	M	2xd		Al Aluminium Cast	GG(G) Cast iron	383

Thread milling cutters with 45° chamfer

N° EH24200	M	1.5xd		HRC < 56	GG(G) Cast iron	385
N° EH24300	M	2xd		Rm <850-1500	GG(G) Cast iron	387
N° EH24220	MF	1.5xd		Rm <850-1500	GG(G) Cast iron	389
N° EH24320	MF	2xd		Rm <850-1500	GG(G) Cast iron	391
N° EH24340	G	2xd		Rm <850-1500	GG(G) Cast iron	393
N° EH24360	UNC	2xd		Rm <850-1500	GG(G) Cast iron	395
N° EH24370	UNF	2xd		Rm <850-1500	GG(G) Cast iron	397

passion
for precision

fraisa

Thread milling cutters M / MF / G / UNC / UNF / UN / NPT / NPTF

Thread milling cutters

N° EU2010	**M**	**1.5xd**		**Rm** <850-1500	**GG(G)** Cast iron	399
N° EU2060	**G**	**1.5xd**		**Rm** <850-1300	**GG(G)** Cast iron	401
N° EU2110	**UN**	**1.5xd**		**Rm** <850-1300	**GG(G)** Cast iron	403
N° EU2200 / EU2210	**NPT NPTF**			**Rm** <850-1300	**GG(G)** Cast iron	405

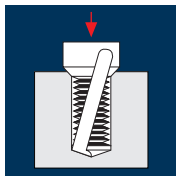
Multi-range thread milling cutters

N° EH26020	**M**			**Rm** <850-1500	**GG(G)** Cast iron	407
N° EH26040	**G**			**Rm** <850-1500	**GG(G)** Cast iron	409

Thread whirler

N° E28500	**M**	**3xd**		**Rm** <850-1500	**Inox Ti Ni**	411

Application



Material	M	d_2 [mm]	v_c [m/min]	f [mm]	L_K [mm]	n [min⁻¹]	v_f [mm/min]
Cast iron GG(G)	M 4	3.30	100	0.050	7.4	9645	480
	M 5	4.20	100	0.065	9.4	7580	495
	M 6	5.00	100	0.075	11.7	6365	475
	M 8	6.80	100	0.100	14.7	4680	470
	M10	8.50	100	0.125	19.3	3745	470
	M12	10.20	100	0.150	22.2	3120	470
	M16	14.00	100	0.210	27.8	2275	480
Cast aluminium	M 4	3.30	250	0.060	7.4	24115	1445
	M 5	4.20	250	0.075	9.4	18950	1420
	M 6	5.00	250	0.090	11.7	15915	1430
	M 8	6.80	250	0.120	14.7	11705	1405
	M10	8.50	250	0.150	19.3	9360	1405
	M12	10.20	250	0.180	22.2	7800	1405
	M16	14.00	250	0.250	27.8	5685	1420
Wrought aluminium alloys Si < 6% Recommandation: uncoated	M 4	3.30	200	0.060	7.4	19290	1155
	M 5	4.20	200	0.075	9.4	15160	1135
	M 6	5.00	200	0.090	11.7	12735	1145
	M 8	6.80	200	0.120	14.7	9360	1125
	M10	8.50	200	0.150	19.3	7490	1125
	M12	10.20	200	0.180	22.2	6240	1125
	M16	14.00	200	0.250	27.8	4545	1135
Short-chipping brass CuZn	M 4	3.30	250	0.060	7.4	24115	1445
	M 5	4.20	250	0.075	9.4	18950	1420
	M 6	5.00	250	0.090	11.7	15915	1430
	M 8	6.80	250	0.120	14.7	11705	1405
	M10	8.50	250	0.150	19.3	9360	1405
	M12	10.20	250	0.180	22.2	7800	1405
	M16	14.00	250	0.250	27.8	5685	1420

Cutting data for TiCN-coated tools

Application

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Cast iron GG(G)	M 4	3.20	0.70	2	100	0.025	9945	99	495
	M 5	4.00	0.80	2	100	0.030	7960	96	480
	M 6	4.75	1.00	2	100	0.035	6700	98	470
	M 8	6.35	1.25	2	100	0.050	5015	103	500
	M10	7.95	1.50	2	100	0.060	4005	98	480
	M12	9.95	1.75	2	100	0.075	3200	82	480
	M16	13.20	2.00	2	100	0.100	2410	84	480
Cast aluminium	M 4	3.20	0.70	2	250	0.030	24870	298	1490
	M 5	4.00	0.80	2	250	0.035	19895	279	1395
	M 6	4.75	1.00	2	250	0.045	16755	315	1510
	M 8	6.35	1.25	2	250	0.060	12530	310	1505
	M10	7.95	1.50	2	250	0.070	10010	287	1400
	M12	9.95	1.75	2	250	0.090	8000	246	1440
	M16	13.20	2.00	2	250	0.120	6030	253	1445
Wrought aluminium alloys Si < 6% Recommandation: uncoated	M 4	3.20	0.70	2	200	0.030	19895	239	1195
	M 5	4.00	0.80	2	200	0.035	15915	223	1115
	M 6	4.75	1.00	2	200	0.045	13405	251	1205
	M 8	6.35	1.25	2	200	0.060	10025	249	1205
	M10	7.95	1.50	2	200	0.070	8010	230	1120
	M12	9.95	1.75	2	200	0.090	6400	196	1150
	M16	13.20	2.00	2	200	0.120	4825	203	1160
Short-chipping brass CuZn	M 4	3.20	0.70	2	250	0.030	24870	298	1490
	M 5	4.00	0.80	2	250	0.035	19895	279	1395
	M 6	4.75	1.00	2	250	0.045	16755	315	1510
	M 8	6.35	1.25	2	250	0.060	12530	310	1505
	M10	7.95	1.50	2	250	0.070	10010	287	1400
	M12	9.95	1.75	2	250	0.090	8000	246	1440
	M16	13.20	2.00	2	250	0.120	6030	253	1445

Cutting data for TiCN-coated tools

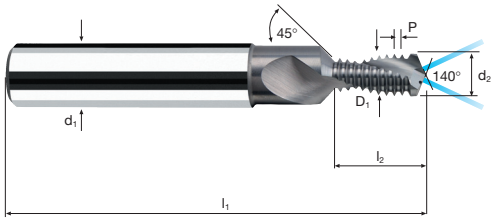
Drill/thread milling cutters

1.5xd, chamfer 45°, Incool

M

HM

DIN 6535 HA

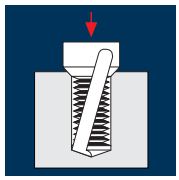


Al Aluminium Alloy	Al Aluminium Cast	Cu Copper	Plastic Thermoplast	GG(G) CuZn Brass

Example:
Order-N°. Article-N°. **EH22200** ø-Code **.058**

ø Code	d	P	l1	l2	d1 h6	d2	D1	Rk 6H		E22200	TiCN EH22200
.058	M 4	0.70	48	6.9	6	3.3	3.20	1.560	2	●	●
.084	M 5	0.80	54	8.8	6	4.2	4.00	1.950	2	●	●
.088	M 6	1.00	62	10.9	8	5.0	4.75	2.315	2	●	●
.160	M 8	1.25	74	13.7	10	6.8	6.35	3.095	2	●	●
.174	M10	1.50	80	18.0	12	8.5	7.95	3.875	2	●	●
.240	M12	1.75	90	20.9	14	10.2	9.95	4.855	2	●	●
.246	M16	2.00	102	26.0	18	14.0	13.20	6.440	2	●	●

Application



Material	M	d2 [mm]	vc [m/min]	f [mm]	LK [mm]	n [min-1]	vf [mm/min]
Cast iron GG(G)	M 4	3.30	100	0.050	9.5	9645	480
	M 5	4.20	100	0.065	11.8	7580	495
	M 6	5.00	100	0.075	14.7	6365	475
	M 8	6.80	100	0.100	19.7	4680	470
	M 10	8.50	100	0.125	23.8	3745	470
	M 12	10.20	100	0.150	27.4	3120	470
	M 16	14.00	100	0.210	37.8	2275	480
Cast aluminium	M 4	3.30	250	0.060	9.5	24115	1445
	M 5	4.20	250	0.075	11.8	18950	1420
	M 6	5.00	250	0.090	14.7	15915	1430
	M 8	6.80	250	0.120	19.7	11705	1405
	M10	8.50	250	0.150	23.8	9360	1405
	M12	10.20	250	0.180	27.4	7800	1405
	M16	14.00	250	0.250	37.8	5685	1420
Wrought aluminium alloys Si < 6% Recommandation: uncoated	M 4	3.30	200	0.060	9.5	19290	1155
	M 5	4.20	200	0.075	11.8	15160	1135
	M 6	5.00	200	0.090	14.7	12735	1145
	M 8	6.80	200	0.120	19.7	9360	1125
	M10	8.50	200	0.150	23.8	7490	1125
	M12	10.20	200	0.180	27.4	6240	1125
	M16	14.00	200	0.250	37.8	4545	1135
Short-chipping brass CuZn	M 4	3.30	250	0.060	9.5	24115	1445
	M 5	4.20	250	0.075	11.8	18950	1420
	M 6	5.00	250	0.090	14.7	15915	1430
	M 8	6.80	250	0.120	19.7	11705	1405
	M10	8.50	250	0.150	23.8	9360	1405
	M12	10.20	250	0.180	27.4	7800	1405
	M16	14.00	250	0.250	37.8	5685	1420

Cutting data for TiCN-coated tools

Application

Material	M	D1 [mm]	P [mm]	z	vc [m/min]	fz [mm]	n [mm-1]	vfc [mm/min]	vf [mm/min]
Cast iron GG(G)	M 4	3.20	0.70	2	100	0.020	9945	80	400
	M 5	4.00	0.80	2	100	0.025	7960	80	400
	M 6	4.75	1.00	2	100	0.030	6700	83	400
	M 8	6.35	1.25	2	100	0.040	5015	83	400
	M10	7.95	1.50	2	100	0.055	4005	90	440
	M12	9.95	1.75	2	100	0.065	3200	71	415
	M16	13.20	2.00	2	100	0.090	2410	76	435
Cast aluminium	M 4	3.20	0.70	2	250	0.025	24870	249	1245
	M 5	4.00	0.80	2	250	0.030	19895	239	1195
	M 6	4.75	1.00	2	250	0.035	16755	245	1175
	M 8	6.35	1.25	2	250	0.050	12530	259	1255
	M10	7.95	1.50	2	250	0.060	10010	246	1200
	M12	9.95	1.75	2	250	0.075	8000	205	1200
	M16	13.20	2.00	2	250	0.100	6030	211	1205
Wrought aluminium alloys Si < 6% Recommandation: uncoated	M 4	3.20	0.70	2	200	0.025	19895	199	995
	M 5	4.00	0.80	2	200	0.030	15915	191	955
	M 6	4.75	1.00	2	200	0.035	13405	196	940
	M 8	6.35	1.25	2	200	0.050	10025	207	1005
	M10	7.95	1.50	2	200	0.060	8010	197	960
	M12	9.95	1.75	2	200	0.075	6400	164	960
	M16	13.20	2.00	2	200	0.100	4825	169	965
Short-chipping brass CuZn	M 4	3.20	0.70	2	250	0.025	24870	249	1245
	M 5	4.00	0.80	2	250	0.030	19895	239	1195
	M 6	4.75	1.00	2	250	0.035	16755	245	1175
	M 8	6.35	1.25	2	250	0.050	12530	259	1255
	M10	7.95	1.50	2	250	0.060	10010	246	1200
	M12	9.95	1.75	2	250	0.075	8000	205	1200
	M16	13.20	2.00	2	250	0.100	6030	211	1205

Cutting data for TiCN-coated tools

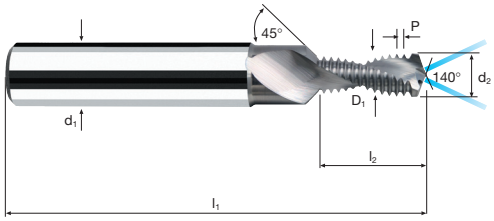
Drill/thread milling cutters

2.0xd, chamfer 45°, Incool

M

HM

DIN 6535 HA



				Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	GG(G) CuZn Brass

Example: **Order-N°.** **EH22300** (Article-N°.) **.058** (ø-Code)

ø Code	d	P	l1	l2	d1 h6	d2	D1	Rk 6H		E22300	TiCN EH22300
.058	M 4	0.70	48	9.0	6	3.3	3.20	1.560	2	●	●
.084	M 5	0.80	54	11.2	6	4.2	4.00	1.950	2	●	●
.088	M 6	1.00	62	13.9	8	5.0	4.75	2.315	2	●	●
.160	M 8	1.25	74	18.7	10	6.8	6.35	3.095	2	●	●
.174	M10	1.50	80	22.5	12	8.5	7.95	3.875	2	●	●
.240	M12	1.75	90	26.1	14	10.2	9.95	4.855	2	●	●
.246	M16	2.00	102	36.0	18	14.0	13.20	6.440	2	●	●

Application

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	M 3	2.30	0.50	3	80	0.0060	5.7	11070	47	200
	M 4	3.00	0.70	3	80	0.0075	8.0	8490	48	190
	M 5	4.00	0.80	3	80	0.0100	9.8	6365	38	190
	M 6	4.80	1.00	3	80	0.0120	11.3	5305	38	190
	M 8	6.40	1.25	3	80	0.0160	14.1	3980	38	190
	M 10	7.95	1.50	4	80	0.0200	18.6	3205	52	255
	M 12	9.95	1.75	4	80	0.0250	21.4	2560	44	255
	M 16	12.80	2.00	4	80	0.0320	29.0	1990	51	255
Steel 1300 - 1500 N/mm²	M 3	2.30	0.50	3	50	0.0050	5.7	6920	25	105
	M 4	3.00	0.70	3	50	0.0065	8.0	5305	26	105
	M 5	4.00	0.80	3	50	0.0090	9.8	3980	21	105
	M 6	4.80	1.00	3	50	0.0105	11.3	3315	21	105
	M 8	6.40	1.25	3	50	0.0140	14.1	2485	21	105
	M 10	7.95	1.50	4	50	0.0175	18.6	2000	29	140
	M 12	9.95	1.75	4	50	0.0220	21.4	1600	24	140
	M 16	12.80	2.00	4	50	0.0285	29.0	1245	28	140
Hardened tool steel 48 - 52 HRC	M 3	2.30	0.50	3	30	0.0040	5.7	4150	12	50
	M 4	3.00	0.70	3	30	0.0050	8.0	3185	13	50
	M 5	4.00	0.80	3	30	0.0065	9.8	2385	9	45
	M 6	4.80	1.00	3	30	0.0080	11.3	1990	10	50
	M 8	6.40	1.25	3	30	0.0105	14.1	1490	9	45
	M 10	7.95	1.50	4	30	0.0135	18.6	1200	13	65
	M 12	9.95	1.75	4	30	0.0165	21.4	960	11	65
	M 16	12.80	2.00	4	30	0.0215	29.0	745	13	65
Stainless steel [Cr-Ni/1.4301]	M 3	2.30	0.50	3	50	0.0040	5.7	6920	20	85
	M 4	3.00	0.70	3	50	0.0050	8.0	5305	20	80
	M 5	4.00	0.80	3	50	0.0065	9.8	3980	16	80
	M 6	4.80	1.00	3	50	0.0080	11.3	3315	16	80
	M 8	6.40	1.25	3	50	0.0105	14.1	2485	16	80
	M 10	7.95	1.50	4	50	0.0135	18.6	2000	23	110
	M 12	9.95	1.75	4	50	0.0165	21.4	1600	18	105
	M 16	12.80	2.00	4	50	0.0215	29.0	1245	21	105

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Cast iron GG(G)	M 3	2.30	0.50	3	120	0.0060	5.7	16610	70	300
	M 4	3.00	0.70	3	120	0.0075	8.0	12735	71	285
	M 5	4.00	0.80	3	120	0.0100	9.8	9550	57	285
	M 6	4.80	1.00	3	120	0.0120	11.3	7960	57	285
	M 8	6.40	1.25	3	120	0.0160	14.1	5970	57	285
	M 10	7.95	1.50	4	120	0.0200	18.6	4805	79	385
	M 12	9.95	1.75	4	120	0.0250	21.4	3840	66	385
	M 16	12.80	2.00	4	120	0.0320	29.0	2985	76	380
Wrought aluminium alloys Si < 6%	M 3	2.30	0.50	3	150	0.0080	5.7	20760	117	500
	M 4	3.00	0.70	3	150	0.0105	8.0	15915	125	500
	M 5	4.00	0.80	3	150	0.0140	9.8	11935	100	500
	M 6	4.80	1.00	3	150	0.0170	11.3	9945	101	505
	M 8	6.40	1.25	3	150	0.0225	14.1	7460	101	505
	M 10	7.95	1.50	4	150	0.0280	18.6	6005	138	675
	M 12	9.95	1.75	4	150	0.0350	21.4	4800	114	670
	M 16	12.80	2.00	4	150	0.0450	29.0	3730	134	670
Cast aluminium	M 3	2.30	0.50	3	200	0.0080	5.7	27680	155	665
	M 4	3.00	0.70	3	200	0.0105	8.0	21220	168	670
	M 5	4.00	0.80	3	200	0.0140	9.8	15915	134	670
	M 6	4.80	1.00	3	200	0.0170	11.3	13265	135	675
	M 8	6.40	1.25	3	200	0.0225	14.1	9945	134	670
	M 10	7.95	1.50	4	200	0.0280	18.6	8010	183	895
	M 12	9.95	1.75	4	200	0.0350	21.4	6400	153	895
	M 16	12.80	2.00	4	200	0.0450	29.0	4975	179	895
Titanium alloys > 300 HB [Ti6Al4V]	M 3	2.30	0.50	3	40	0.0040	5.7	5535	15	65
	M 4	3.00	0.70	3	40	0.0050	8.0	4245	16	65
	M 5	4.00	0.80	3	40	0.0065	9.8	3185	12	60
	M 6	4.80	1.00	3	40	0.0080	11.3	2655	13	65
	M 8	6.40	1.25	3	40	0.0105	14.1	1990	13	65
	M 10	7.95	1.50	4	40	0.0135	18.6	1600	17	85
	M 12	9.95	1.75	4	40	0.0165	21.4	1280	15	85
	M 16	12.80	2.00	4	40	0.0215	29.0	995	17	85

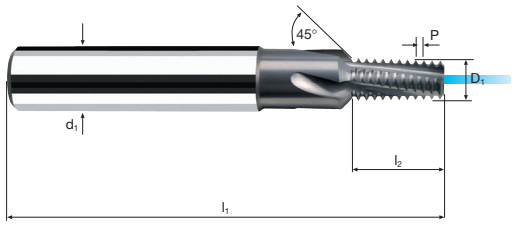
Thread milling cutters

1.5xd, chamfer 45°, Incool

M

HM

DIN 6535 HA



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

Example: **Order-N°.** **EH24200** (Article-N°.) **.044** (ø-Code)

ø Code	d	P	l1	l2	d1 h6	D1	Rk 6H		TiCN EH24200
.044*	M 3	0.50	48	5.3	6	2.30	1.125	3	●
.058	M 4	0.70	48	7.4	6	3.00	1.465	3	●
.084	M 5	0.80	54	9.2	6	4.00	1.960	3	●
.088	M 6	1.00	62	10.5	8	4.80	2.350	3	●
.160	M 8	1.25	74	13.1	10	6.40	3.138	3	●
.174	M10	1.50	80	17.3	12	7.95	3.900	4	●
.240	M12	1.75	90	20.1	14	9.95	4.887	4	●
.246	M16	2.00	102	27.0	18	12.80	6.300	4	●

* without internal cooling

Application

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	M 3	2.30	0.50	3	80	0.0055	7.2	11070	43	185
	M 4	3.00	0.70	3	80	0.0070	9.4	8490	45	180
	M 5	4.00	0.80	3	80	0.0090	11.4	6365	34	170
	M 6	4.80	1.00	3	80	0.0110	14.3	5305	35	175
	M 8	6.40	1.25	3	80	0.0145	19.1	3980	35	175
	M 10	7.95	1.50	4	80	0.0180	23.1	3205	47	230
	M 12	9.95	1.75	4	80	0.0225	26.7	2560	39	230
	M 16	12.80	2.00	4	80	0.0290	37.0	1990	46	230
Steel 1300 - 1500 N/mm²	M 3	2.30	0.50	3	50	0.0045	7.2	6920	22	95
	M 4	3.00	0.70	3	50	0.0060	9.4	5305	24	95
	M 5	4.00	0.80	3	50	0.0080	11.4	3980	19	95
	M 6	4.80	1.00	3	50	0.0095	14.3	3315	19	95
	M 8	6.40	1.25	3	50	0.0125	19.1	2485	19	95
	M 10	7.95	1.50	4	50	0.0160	23.1	2000	27	130
	M 12	9.95	1.75	4	50	0.0200	26.7	1600	22	130
	M 16	12.80	2.00	4	50	0.0255	37.0	1245	25	125
Hardened tool steel 48 - 52 HRC	M 3	2.30	0.50	3	30	0.0035	7.2	4150	11	45
	M 4	3.00	0.70	3	30	0.0045	9.4	3185	11	45
	M 5	4.00	0.80	3	30	0.0060	11.4	2385	9	45
	M 6	4.80	1.00	3	30	0.0070	14.3	1990	8	40
	M 8	6.40	1.25	3	30	0.0095	19.1	1490	8	40
	M 10	7.95	1.50	4	30	0.0120	23.1	1200	12	60
	M 12	9.95	1.75	4	30	0.0150	26.7	960	10	60
	M 16	12.80	2.00	4	30	0.0195	37.0	745	12	60
Stainless steel [Cr-Ni/1.4301]	M 3	2.30	0.50	3	50	0.0035	7.2	6920	18	75
	M 4	3.00	0.70	3	50	0.0045	9.4	5305	18	70
	M 5	4.00	0.80	3	50	0.0060	11.4	3980	14	70
	M 6	4.80	1.00	3	50	0.0070	14.3	3315	14	70
	M 8	6.40	1.25	3	50	0.0095	19.1	2485	14	70
	M 10	7.95	1.50	4	50	0.0120	23.1	2000	19	95
	M 12	9.95	1.75	4	50	0.0150	26.7	1600	16	95
	M 16	12.80	2.00	4	50	0.0195	37.0	1245	19	95

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Cast iron GG(G)	M 3	2.30	0.50	3	120	0.0055	7.2	16610	64	275
	M 4	3.00	0.70	3	120	0.0070	9.4	12735	66	265
	M 5	4.00	0.80	3	120	0.0090	11.4	9550	52	260
	M 6	4.80	1.00	3	120	0.0110	14.3	7960	53	265
	M 8	6.40	1.25	3	120	0.0145	19.1	5970	52	260
	M 10	7.95	1.50	4	120	0.0180	23.1	4805	71	345
	M 12	9.95	1.75	4	120	0.0225	26.7	3840	59	345
	M 16	12.80	2.00	4	120	0.0290	37.0	2985	69	345
Wrought aluminium alloys Si < 6%	M 3	2.30	0.50	3	150	0.0070	7.2	20760	102	435
	M 4	3.00	0.70	3	150	0.0095	9.4	15915	114	455
	M 5	4.00	0.80	3	150	0.0125	11.4	11935	90	450
	M 6	4.80	1.00	3	150	0.0155	14.3	9945	92	460
	M 8	6.40	1.25	3	150	0.0205	19.1	7460	92	460
	M 10	7.95	1.50	4	150	0.0250	23.1	6005	123	600
	M 12	9.95	1.75	4	150	0.0315	26.7	4800	103	605
	M 16	12.80	2.00	4	150	0.0405	37.0	3730	121	605
Cast aluminium	M 3	2.30	0.50	3	200	0.0070	7.2	27680	135	580
	M 4	3.00	0.70	3	200	0.0095	9.4	21220	151	605
	M 5	4.00	0.80	3	200	0.0125	11.4	15915	119	595
	M 6	4.80	1.00	3	200	0.0155	14.3	13265	123	615
	M 8	6.40	1.25	3	200	0.0205	19.1	9945	122	610
	M 10	7.95	1.50	4	200	0.0250	23.1	8010	164	800
	M 12	9.95	1.75	4	200	0.0315	26.7	6400	138	805
	M 16	12.80	2.00	4	200	0.0405	37.0	4975	161	805
Titanium alloys > 300 HB [Ti6Al4V]	M 3	2.30	0.50	3	40	0.0035	7.2	5535	14	60
	M 4	3.00	0.70	3	40	0.0045	9.4	4245	14	55
	M 5	4.00	0.80	3	40	0.0060	11.4	3185	11	55
	M 6	4.80	1.00	3	40	0.0070	14.3	2655	11	55
	M 8	6.40	1.25	3	40	0.0095	19.1	1990	11	55
	M 10	7.95	1.50	4	40	0.0120	23.1	1600	15	75
	M 12	9.95	1.75	4	40	0.0150	26.7	1280	13	75
	M 16	12.80	2.00	4	40	0.0195	37.0	995	16	80

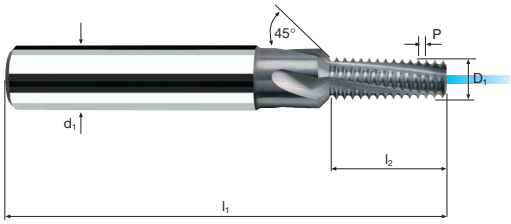
Thread milling cutters

2.0xd, chamfer 45°, Incool

M

HM

DIN 6535 HA



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

Example: **Order-N°.** **EH24300** (Article-N°.) **.044** (ø-Code)

ø Code	d	P	l1	l2	d1 h6	D1	Rk 6H		TiCN EH24300
.044*	M 3	0.50	48	6.8	6	2.30	1.125	3	●
.058	M 4	0.70	48	8.8	6	3.00	1.465	3	●
.084	M 5	0.80	54	10.8	6	4.00	1.960	3	●
.088	M 6	1.00	62	13.5	8	4.80	2.350	3	●
.160	M 8	1.25	74	18.1	10	6.40	3.138	3	●
.174	M10	1.50	80	21.8	12	7.95	3.900	4	●
.240	M12	1.75	90	25.4	14	9.95	4.887	4	●
.246	M16	2.00	102	35.0	18	12.80	6.300	4	●

* without internal cooling

Application

Material	MF	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	M 4	3.00	0.50	3	80	0.0075	7.9	8490	48	190
	M 5	4.00	0.50	3	80	0.0100	9.4	6365	38	190
	M 6	4.80	0.50	3	80	0.0120	10.6	5305	38	190
	M 6	4.80	0.75	3	80	0.0120	10.8	5305	38	190
	M 8	6.40	0.75	3	80	0.0160	14.1	3980	38	190
	M 8	6.40	1.00	3	80	0.0160	14.5	3980	38	190
	M 10	7.95	1.00	4	80	0.0200	17.8	3205	52	255
	M 10	7.95	1.25	4	80	0.0200	18.2	3205	52	255
	M 12	9.95	1.00	4	80	0.0250	20.8	2560	44	255
Steel 850 - 1100 N/mm²	M 12	9.95	1.50	4	80	0.0250	21.6	2560	44	255
	M 14	11.20	1.50	4	80	0.0280	25.1	2275	51	255
	M 16	12.80	1.50	4	80	0.0320	28.3	1990	51	255
Steel 1300 - 1500 N/mm²	M 4	3.00	0.50	3	50	0.0065	7.9	5305	26	105
	M 5	4.00	0.50	3	50	0.0090	9.4	3980	21	105
	M 6	4.80	0.50	3	50	0.0105	10.6	3315	21	105
	M 6	4.80	0.75	3	50	0.0105	10.8	3315	21	105
	M 8	6.40	0.75	3	50	0.0140	14.1	2485	21	105
	M 8	6.40	1.00	3	50	0.0140	14.5	2485	21	105
	M 10	7.95	1.00	4	50	0.0175	17.8	2000	29	140
	M 10	7.95	1.25	4	50	0.0175	18.2	2000	29	140
	M 12	9.95	1.00	4	50	0.0220	20.8	1600	24	140
Steel 1300 - 1500 N/mm²	M 12	9.95	1.50	4	50	0.0220	21.6	1600	24	140
	M 14	11.20	1.50	4	50	0.0250	25.1	1420	28	140
	M 16	12.80	1.50	4	50	0.0285	28.3	1245	28	140

Material	MF	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Wrought aluminium alloys Si < 6%	M 4	3.00	0.50	3	150	0.0105	7.9	15915	125	500
	M 5	4.00	0.50	3	150	0.0140	9.4	11935	100	500
	M 6	4.80	0.50	3	150	0.0170	10.6	9945	101	505
	M 6	4.80	0.75	3	150	0.0170	10.8	9945	101	505
	M 8	6.40	0.75	3	150	0.0225	14.1	7460	101	505
	M 8	6.40	1.00	3	150	0.0225	14.5	7460	101	505
	M 10	7.95	1.00	4	150	0.0280	17.8	6005	138	675
	M 10	7.95	1.25	4	150	0.0280	18.2	6005	138	675
	M 12	9.95	1.00	4	150	0.0350	20.8	4800	114	670
Wrought aluminium alloys Si < 6%	M 12	9.95	1.50	4	150	0.0350	21.6	4800	114	670
	M 14	11.20	1.50	4	150	0.0395	25.1	4265	135	675
	M 16	12.80	1.50	4	150	0.0450	28.3	3730	134	670
Cast iron GG(G)	M 4	3.00	0.50	3	120	0.0075	7.9	12735	71	285
	M 5	4.00	0.50	3	120	0.0100	9.4	9550	57	285
	M 6	4.80	0.50	3	120	0.0120	10.6	7960	57	285
	M 6	4.80	0.75	3	120	0.0120	10.8	7960	57	285
	M 8	6.40	0.75	3	120	0.0160	14.1	5970	57	285
	M 8	6.40	1.00	3	120	0.0160	14.5	5970	57	285
	M 10	7.95	1.00	4	120	0.0200	17.8	4805	79	385
	M 10	7.95	1.25	4	120	0.0200	18.2	4805	79	385
	M 12	9.95	1.00	4	120	0.0250	20.8	3840	66	385
Cast iron GG(G)	M 12	9.95	1.50	4	120	0.0250	21.6	3840	66	385
	M 14	11.20	1.50	4	120	0.0280	25.1	3410	76	380
	M 16	12.80	1.50	4	120	0.0320	28.3	2985	76	380

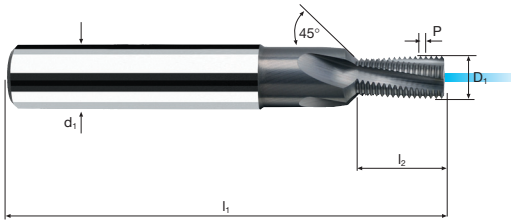
Thread milling cutters

1.5xd, chamfer 45°, Incool

MF

HM

DIN 6535 HA



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

Example: **Order-N°.** Article-N°. **EH24220** ø-Code **.046**

ø Code	d	P	l1	l2	d1 h6	D1	Rk 6H		TiCN EH24220
.046	M 4	0.50	48	7.3	6	3.00	1.475	3	●
.048	M 5	0.50	54	8.8	6	4.00	1.975	3	●
.050	M 6	0.50	62	9.8	8	4.80	2.375	3	●
.064	M 6	0.75	62	10.1	8	4.80	2.363	3	●
.066	M 8	0.75	74	13.1	10	6.40	3.163	3	●
.090	M 8	1.00	74	13.5	10	6.40	3.150	3	●
.092	M10	1.00	80	16.5	12	7.95	3.925	4	●
.162	M10	1.25	80	16.9	12	7.95	3.913	4	●
.094	M12	1.00	90	19.5	14	9.95	4.925	4	●
.176	M12	1.50	90	20.3	14	9.95	4.900	4	●
.178	M14	1.50	102	23.3	16	11.20	5.525	4	●
.180	M16	1.50	102	26.3	18	12.80	6.325	4	●

Application

Material	MF	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	M 4	3.00	0.50	3	80	0.0070	9.4	8490	45	180
	M 5	4.00	0.50	3	80	0.0090	11.4	6365	34	170
	M 6	4.80	0.50	3	80	0.0110	13.6	5305	35	175
	M 6	4.80	0.75	3	80	0.0110	13.9	5305	35	175
	M 8	6.40	0.75	3	80	0.0145	17.9	3980	35	175
	M 8	6.40	1.00	3	80	0.0145	18.5	3980	35	175
	M 10	7.95	1.00	4	80	0.0180	22.8	3205	47	230
	M 10	7.95	1.25	4	80	0.0180	23.2	3205	47	230
	M 12	9.95	1.00	4	80	0.0225	26.8	2560	39	230
Steel 850 - 1100 N/mm²	M 12	9.95	1.50	4	80	0.0225	27.6	2560	39	230
	M 14	11.20	1.50	4	80	0.0250	32.6	2275	46	230
	M 16	12.80	1.50	4	80	0.0290	35.8	1990	46	230
Steel 1300 - 1500 N/mm²	M 4	3.00	0.50	3	50	0.0060	9.4	5305	24	95
	M 5	4.00	0.50	3	50	0.0080	11.4	3980	19	95
	M 6	4.80	0.50	3	50	0.0095	13.6	3315	19	95
	M 6	4.80	0.75	3	50	0.0095	13.9	3315	19	95
	M 8	6.40	0.75	3	50	0.0125	17.9	2485	19	95
	M 8	6.40	1.00	3	50	0.0125	18.5	2485	19	95
	M 10	7.95	1.00	4	50	0.0160	22.8	2000	27	130
	M 10	7.95	1.25	4	50	0.0160	23.2	2000	27	130
	M 12	9.95	1.00	4	50	0.0200	26.8	1600	22	130
Steel 1300 - 1500 N/mm²	M 12	9.95	1.50	4	50	0.0200	27.6	1600	22	130
	M 14	11.20	1.50	4	50	0.0225	32.6	1420	26	130
	M 16	12.80	1.50	4	50	0.0255	35.8	1245	25	125

Material	MF	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Wrought aluminium alloys Si < 6%	M 4	3.00	0.50	3	150	0.0095	9.4	15915	114	455
	M 5	4.00	0.50	3	150	0.0125	11.4	11935	90	450
	M 6	4.80	0.50	3	150	0.0155	13.6	9945	92	460
	M 6	4.80	0.75	3	150	0.0155	13.9	9945	92	460
	M 8	6.40	0.75	3	150	0.0205	17.9	7460	92	460
	M 8	6.40	1.00	3	150	0.0205	18.5	7460	92	460
	M 10	7.95	1.00	4	150	0.0250	22.8	6005	123	600
	M 10	7.95	1.25	4	150	0.0250	23.2	6005	123	600
	M 12	9.95	1.00	4	150	0.0315	26.8	4800	103	605
Wrought aluminium alloys Si < 6%	M 12	9.95	1.50	4	150	0.0315	27.6	4800	103	605
	M 14	11.20	1.50	4	150	0.0355	32.6	4265	121	605
	M 16	12.80	1.50	4	150	0.0405	35.8	3730	121	605
Cast iron GG(G)	M 4	3.00	0.50	3	120	0.0070	9.4	12735	66	265
	M 5	4.00	0.50	3	120	0.0090	11.4	9550	52	260
	M 6	4.80	0.50	3	120	0.0110	13.6	7960	53	265
	M 6	4.80	0.75	3	120	0.0110	13.9	7960	53	265
	M 8	6.40	0.75	3	120	0.0145	17.9	5970	52	260
	M 8	6.40	1.00	3	120	0.0145	18.5	5970	52	260
	M 10	7.95	1.00	4	120	0.0180	22.8	4805	71	345
	M 10	7.95	1.25	4	120	0.0180	23.2	4805	71	345
	M 12	9.95	1.00	4	120	0.0225	26.8	3840	59	345
Cast iron GG(G)	M 12	9.95	1.50	4	120	0.0225	27.6	3840	59	345
	M 14	11.20	1.50	4	120	0.0250	32.6	3410	68	340
	M 16	12.80	1.50	4	120	0.0290	35.8	2985	69	345

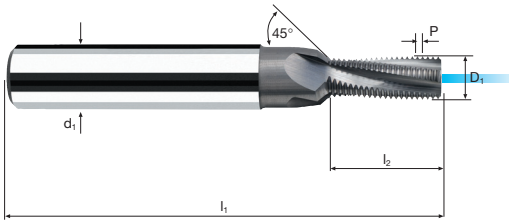
Thread milling cutters

2.0xd, chamfer 45°, Incool

MF

HM

DIN 6535 HA



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Aluminium GG(G)

Example: **Order-N°.** Article-N°. **EH24320** ø-Code **.046**

ø Code	d	P	l1	l2	d1 h6	D1	Rk 6H		TiCN EH24320
.046	M 4	0.50	48	8.8	6	3.00	1.475	3	●
.048	M 5	0.50	54	10.8	6	4.00	1.975	3	●
.050	M 6	0.50	62	12.8	8	4.80	2.375	3	●
.064	M 6	0.75	62	13.1	8	4.80	2.363	3	●
.066	M 8	0.75	74	16.9	10	6.40	3.163	3	●
.090	M 8	1.00	74	17.5	10	6.40	3.150	3	●
.092	M10	1.00	80	21.5	12	7.95	3.925	4	●
.162	M10	1.25	80	21.9	12	7.95	3.913	4	●
.094	M12	1.00	90	25.5	14	9.95	4.925	4	●
.176	M12	1.50	90	26.3	14	9.95	4.900	4	●
.178	M14	1.50	102	30.8	16	11.20	5.525	4	●
.180	M16	1.50	102	33.8	18	12.80	6.325	4	●

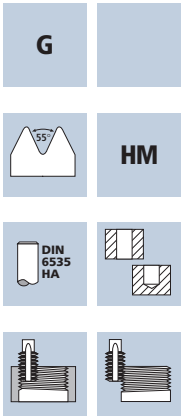
Application

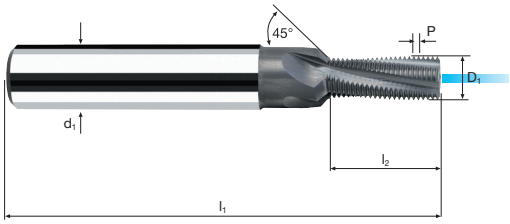
Material	G	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	G 1/8	7.95	28	4	80	0.0180	22.4	3205	42	230
	G 1/4	10.50	19	4	80	0.0240	30.4	2425	47	235
	G 3/8	13.60	19	4	80	0.0310	37.3	1870	42	230
Steel 1300 - 1500 N/mm²	G 1/8	7.95	28	4	50	0.0160	22.4	2000	24	130
	G 1/4	10.50	19	4	50	0.0210	30.4	1515	25	125
	G 3/8	13.60	19	4	50	0.0275	37.3	1170	24	130
Hardened tool steel 48 - 52 HRC	G 1/8	7.95	28	4	30	0.0120	22.4	1200	11	60
	G 1/4	10.50	19	4	30	0.0160	30.4	910	12	60
	G 3/8	13.60	19	4	30	0.0205	37.3	700	10	55
Stainless steel [Cr-Ni/1.4301]	G 1/8	7.95	28	4	50	0.0120	22.4	2000	17	95
	G 1/4	10.50	19	4	50	0.0160	30.4	1515	19	95
	G 3/8	13.60	19	4	50	0.0205	37.3	1170	17	95

Material	G	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Cast iron GG(G)	G 1/8	7.95	28	4	120	0.0180	22.4	4805	63	345
	G 1/4	10.50	19	4	120	0.0240	30.4	3640	71	350
	G 3/8	13.60	19	4	120	0.0310	37.3	2810	64	350
Wrought aluminium alloys Si < 6%	G 1/8	7.95	28	4	150	0.0250	22.4	6005	110	600
	G 1/4	10.50	19	4	150	0.0335	30.4	4545	123	610
	G 3/8	13.60	19	4	150	0.0430	37.3	3510	111	605
Cast aluminium	G 1/8	7.95	28	4	200	0.0250	22.4	8010	146	800
	G 1/4	10.50	19	4	200	0.0335	30.4	6065	165	815
	G 3/8	13.60	19	4	200	0.0430	37.3	4680	148	805
Titanium alloys > 300 HB [Ti6Al4V]	G 1/8	7.95	28	4	40	0.0120	22.4	1600	14	75
	G 1/4	10.50	19	4	40	0.0160	30.4	1215	16	80
	G 3/8	13.60	19	4	40	0.0205	37.3	935	14	75

Thread milling cutters

2.0xd, chamfer 45°, Incool





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

Example:
Order-N°. **EH24340** (Article-N°.) **.551** (ø-Code)

ø Code	d	P(TPI)	l_1	l_2	d_1 h6	D_1	R_k		TiCN
									EH24340
.551	G 1/8	28	80	21.3	12	7.95	3.930	4	●
.552	G 1/4	19	90	28.7	14	9.95	5.183	4	●
.553	G 3/8	19	102	35.4	18	13.60	6.733	4	●

Application

Material	UNC	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	1/4	4.80	20	3	80	0.0110	15.5	5305	43	175
	5/16	5.95	18	3	80	0.0135	18.8	4280	44	175
	3/8	7.10	16	4	80	0.0160	22.9	3585	59	230
	7/16	7.95	14	4	80	0.0180	26.4	3205	65	230
	1/2	9.95	13	4	80	0.0225	30.0	2560	50	230
Steel 1300 - 1500 N/mm²	1/4	4.80	20	3	50	0.0095	15.5	3315	23	95
	5/16	5.95	18	3	50	0.0120	18.8	2675	24	95
	3/8	7.10	16	4	50	0.0145	22.9	2240	33	130
	7/16	7.95	14	4	50	0.0160	26.4	2000	37	130
	1/2	9.95	13	4	50	0.0200	30.0	1600	28	130
Hardened tool steel 48 - 52 HRC	1/4	4.80	20	3	30	0.0075	15.5	1990	11	45
	5/16	5.95	18	3	30	0.0090	18.8	1605	11	45
	3/8	7.10	16	4	30	0.0110	22.9	1345	15	60
	7/16	7.95	14	4	30	0.0120	26.4	1200	17	60
	1/2	9.95	13	4	30	0.0150	30.0	960	13	60
Stainless steel [Cr-Ni/1.4301]	1/4	4.80	20	3	50	0.0075	15.5	3315	18	75
	5/16	5.95	18	3	50	0.0090	18.8	2675	18	70
	3/8	7.10	16	4	50	0.0110	22.9	2240	25	100
	7/16	7.95	14	4	50	0.0120	26.4	2000	27	95
	1/2	9.95	13	4	50	0.0150	30.0	1600	21	95

Material	UNC	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Cast iron GG(G)	1/4	4.80	20	3	120	0.0110	15.5	7960	65	265
	5/16	5.95	18	3	120	0.0135	18.8	6420	65	260
	3/8	7.10	16	4	120	0.0160	22.9	5380	88	345
	7/16	7.95	14	4	120	0.0180	26.4	4805	98	345
	1/2	9.95	13	4	120	0.0225	30.0	3840	75	345
Wrought aluminium alloys Si < 6%	1/4	4.80	20	3	150	0.0150	15.5	9945	110	450
	5/16	5.95	18	3	150	0.0190	18.8	8025	114	455
	3/8	7.10	16	4	150	0.0225	22.9	6725	154	605
	7/16	7.95	14	4	150	0.0250	26.4	6005	171	600
	1/2	9.95	13	4	150	0.0315	30.0	4800	131	605
Cast aluminium	1/4	4.80	20	3	200	0.0150	15.5	13265	145	595
	5/16	5.95	18	3	200	0.0190	18.8	10700	153	610
	3/8	7.10	16	4	200	0.0225	22.9	8965	205	805
	7/16	7.95	14	4	200	0.0250	26.4	8010	228	800
	1/2	9.95	13	4	200	0.0315	30.0	6400	174	805
Titanium alloys > 300 HB [Ti6Al4V]	1/4	4.80	20	3	40	0.0075	15.5	2655	15	60
	5/16	5.95	18	3	40	0.0090	18.8	2140	15	60
	3/8	7.10	16	4	40	0.0110	22.9	1795	20	80
	7/16	7.95	14	4	40	0.0120	26.4	1600	21	75
	1/2	9.95	13	4	40	0.0150	30.0	1280	16	75

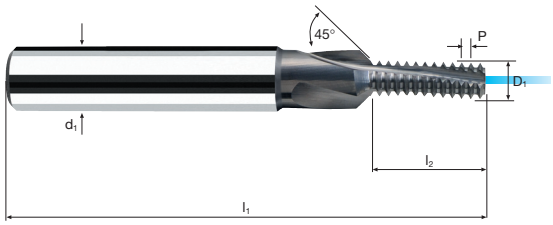
Thread milling cutters

2.0xd, chamfer 45°, Incool

UNC

HM

DIN 6535 HA



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

Example: **Order-N°.** **EH24360** (Article-N°.) **.709** (ø-Code)

ø Code	d	P(TPI)	l1	l2	d1 h6	D1	Rk 2B		TiCN EH24360
.709	1/4	20	62	14.6	8	4.80	2.337	3	●
.710	5/16	18	74	17.6	10	5.95	2.904	3	●
.711	3/8	16	80	21.4	12	7.10	3.471	4	●
.712	7/16	14	80	24.5	12	7.95	3.884	4	●
.713	1/2	13	90	28.3	14	9.95	4.877	4	●

Application

Material	UNF	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	1/4	4.80	28	3	80	0.0110	15.0	5305	43	175
	5/16	5.95	24	3	80	0.0135	18.7	4280	44	175
	3/8	7.95	24	4	80	0.0180	21.6	3205	38	230
	7/16	7.95	20	4	80	0.0180	26.7	3205	65	230
	1/2	9.95	20	4	80	0.0225	29.0	2560	50	230
Steel 1300 - 1500 N/mm²	1/4	4.80	28	3	50	0.0095	15.0	3315	23	95
	5/16	5.95	24	3	50	0.0120	18.7	2675	24	95
	3/8	7.95	24	4	50	0.0160	21.6	2000	21	130
	7/16	7.95	20	4	50	0.0160	26.7	2000	37	130
	1/2	9.95	20	4	50	0.0200	29.0	1600	28	130
Hardened tool steel 48 - 52 HRC	1/4	4.80	28	3	30	0.0075	15.0	1990	11	45
	5/16	5.95	24	3	30	0.0090	18.7	1605	11	45
	3/8	7.95	24	4	30	0.0120	21.6	1200	10	60
	7/16	7.95	20	4	30	0.0120	26.7	1200	17	60
	1/2	9.95	20	4	30	0.0150	29.0	960	13	60
Stainless steel [Cr-Ni/1.4301]	1/4	4.80	28	3	50	0.0075	15.0	3315	18	75
	5/16	5.95	24	3	50	0.0090	18.7	2675	18	70
	3/8	7.95	24	4	50	0.0120	21.6	2000	16	95
	7/16	7.95	20	4	50	0.0120	26.7	2000	27	95
	1/2	9.95	20	4	50	0.0150	29.0	1600	21	95

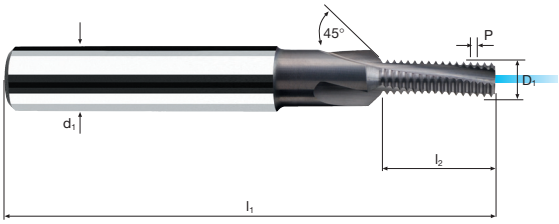
Material	UNF	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	L_K [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Cast iron GG(G)	1/4	4.80	28	3	120	0.0110	15.0	7960	65	265
	5/16	5.95	24	3	120	0.0135	18.7	6420	65	260
	3/8	7.95	24	4	120	0.0180	21.6	4805	57	345
	7/16	7.95	20	4	120	0.0180	26.7	4805	98	345
	1/2	9.95	20	4	120	0.0225	29.0	3840	75	345
Wrought aluminium alloys Si < 6%	1/4	4.80	28	3	150	0.0150	15.0	9945	110	450
	5/16	5.95	24	3	150	0.0190	18.7	8025	114	455
	3/8	7.95	24	4	150	0.0250	21.6	6005	99	600
	7/16	7.95	20	4	150	0.0250	26.7	6005	171	600
	1/2	9.95	20	4	150	0.0315	29.0	4800	131	605
Cast aluminium	1/4	4.80	28	3	200	0.0150	15.0	13265	145	595
	5/16	5.95	24	3	200	0.0190	18.7	10700	153	610
	3/8	7.95	24	4	200	0.0250	21.6	8010	132	800
	7/16	7.95	20	4	200	0.0250	26.7	8010	228	800
	1/2	9.95	20	4	200	0.0315	29.0	6400	174	805
Titanium alloys > 300 HB [Ti6Al4V]	1/4	4.80	28	3	40	0.0075	15.0	2655	15	60
	5/16	5.95	24	3	40	0.0090	18.7	2140	15	60
	3/8	7.95	24	4	40	0.0120	21.6	1600	12	75
	7/16	7.95	20	4	40	0.0120	26.7	1600	21	75
	1/2	9.95	20	4	40	0.0150	29.0	1280	16	75

Thread milling cutters

2.0xd, chamfer 45°, Incool

UNF

HM



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

Example:
Order-N°. Article-N°. **EH24370** ø-Code **.760**

ø Code	d	P(TPI)	l_1	l_2	d_1 h6	D_1	R_k 2B		TiCN EH24370
.760	1/4	28	62	14.1	8	4.80	2.355	3	●
.761	5/16	24	74	17.5	10	5.95	2.922	3	●
.762	3/8	24	80	20.6	12	7.95	3.922	4	●
.763	7/16	20	80	24.8	12	7.95	3.912	4	●
.764	1/2	20	90	27.3	14	9.95	4.911	4	●

Application

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	M 1.6	1.00	0.35	3	30	0.0015	9550	17	45
	M 2	1.30	0.40	3	30	0.0020	7345	16	45
	M 2.5	1.50	0.45	3	30	0.0025	6365	20	50
	M 3	2.10	0.50	3	30	0.0035	4545	15	50
	M 4	2.60	0.70	3	30	0.0065	3675	25	70
	M 5	3.60	0.80	3	30	0.0090	2655	20	70
	M 6	4.00	1.00	3	30	0.0100	2385	23	70
	M 8	5.00	1.25	3	30	0.0125	1910	26	70
	M 10	5.90	1.50	5	30	0.0150	1620	49	120
Steel 850 - 1100 N/mm²	M 12	7.90	1.75	5	30	0.0200	1210	41	120
	M 16	9.90	2.00	5	30	0.0250	965	46	120
Steel 1100 - 1300 N/mm²	M 1.6	1.00	0.35	3	20	0.0015	6365	11	30
	M 2	1.30	0.40	3	20	0.0020	4895	11	30
	M 2.5	1.50	0.45	3	20	0.0025	4245	12	30
	M 3	2.10	0.50	3	20	0.0035	3030	9	30
	M 4	2.60	0.70	3	20	0.0065	2450	18	50
	M 5	3.60	0.80	3	20	0.0090	1770	14	50
	M 6	4.00	1.00	3	20	0.0100	1590	17	50
	M 8	5.00	1.25	3	20	0.0125	1275	19	50
	M 10	5.90	1.50	5	20	0.0150	1080	33	80
Steel 1100 - 1300 N/mm²	M 12	7.90	1.75	5	20	0.0200	805	27	80
	M 16	9.90	2.00	5	20	0.0250	645	31	80

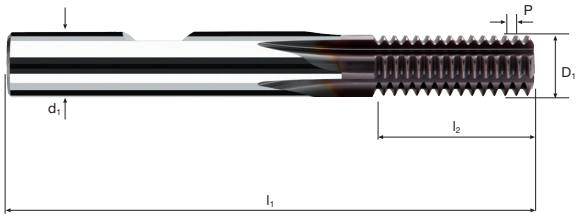
Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Wrought aluminium alloys Si < 6%	M 1.6	1.00	0.35	3	60	0.0015	19100	32	85
	M 2	1.30	0.40	3	60	0.0020	14690	32	90
	M 2.5	1.50	0.45	3	60	0.0025	12735	38	95
	M 3	2.10	0.50	3	60	0.0035	9095	29	95
	M 4	2.60	0.70	3	60	0.0065	7345	51	145
	M 5	3.60	0.80	3	60	0.0090	5305	41	145
	M 6	4.00	1.00	3	60	0.0100	4775	48	145
	M 8	5.00	1.25	3	60	0.0125	3820	54	145
	M 10	5.90	1.50	5	60	0.0150	3235	100	245
Wrought aluminium alloys Si < 6%	M 12	7.90	1.75	5	60	0.0200	2420	82	240
	M 16	9.90	2.00	5	60	0.0250	1930	92	240
Cast iron GG(G)	M 1.6	1.00	0.35	3	50	0.0015	15915	26	70
	M 2	1.30	0.40	3	50	0.0020	12245	26	75
	M 2.5	1.50	0.45	3	50	0.0025	10610	32	80
	M 3	2.10	0.50	3	50	0.0035	7580	24	80
	M 4	2.60	0.70	3	50	0.0065	6120	42	120
	M 5	3.60	0.80	3	50	0.0090	4420	34	120
	M 6	4.00	1.00	3	50	0.0100	3980	40	120
	M 8	5.00	1.25	3	50	0.0125	3185	45	120
	M 10	5.90	1.50	5	50	0.0150	2700	84	205
Cast iron GG(G)	M 12	7.90	1.75	5	50	0.0200	2015	68	200
	M 16	9.90	2.00	5	50	0.0250	1610	76	200

Thread milling cutters

1.5xd

M

HM



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Aluminium GG(G)

Example:
Order-N°. Article-N°. **EU2010** ø-Code **.022**

ø Code	d	P	l1	l2	d1 h6	D1	Rk 6H		UNICUT-4X EU2010
.022*	M 1.6	0.35	38	2.4	3	1.0	0.483	3	●
.034*	M 2	0.40	38	3.2	3	1.3	0.630	3	●
.040*	M 2.5	0.45	38	3.6	3	1.5	0.728	3	●
.044*	M 3	0.50	38	4.5	3	2.1	1.025	3	●
.058*	M 4	0.70	38	6.3	3	2.6	1.265	3	●
.084*	M 5	0.80	42	8.0	4	3.6	1.760	3	●
.088	M 6	1.00	57	9.0	6	4.0	1.950	3	●
.160	M 8	1.25	57	12.5	6	5.0	2.438	3	●
.174	M10	1.50	57	15.0	6	5.9	2.875	5	●
.240	M12	1.75	63	19.2	8	7.9	3.863	5	●
.246	M16	2.00	72	24.0	10	9.9	4.850	5	●

* without clamping flat only

Application

Material	G	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D1 3/2	v_{fc} d/D1 2/1	v_{fc} d/D1 3/1	v_{fc} d/D1 4/1	v_{fc} d/D1 > 5/1	v_f [mm/min]
Steel < 850 N/mm²	G1/16-G1/8	5.90	28	5	30	0.0150	1620	40	60	80	90	96	120
	G1/4 -G3/8	7.90	19	5	30	0.0200	1210	40	60	80	90	96	120
	G1/2 -G7/8	11.90	14	5	30	0.0300	800	40	60	80	90	96	120
	G1 -G3	15.90	11	5	30	0.0400	600	40	60	80	90	96	120
Steel 850 - 1100 N/mm²	G1/16-G1/8	5.90	28	5	20	0.0150	1080	27	40	53	60	64	80
	G1/4 -G3/8	7.90	19	5	20	0.0200	805	27	40	53	60	64	80
	G1/2 -G7/8	11.90	14	5	20	0.0300	535	27	40	53	60	64	80
	G1 -G3	15.90	11	5	20	0.0400	400	27	40	53	60	64	80
Stainless steel [Cr-Ni/1.4301]	G1/16-G1/8	5.90	28	5	25	0.0100	1350	23	35	47	53	56	70
	G1/4 -G3/8	7.90	19	5	25	0.0130	1005	22	33	43	49	52	65
	G1/2 -G7/8	11.90	14	5	25	0.0200	670	22	33	43	49	52	65
	G1 -G3	15.90	11	5	25	0.0265	500	22	33	43	49	52	65
Cast iron GG(G)	G1/16-G1/8	5.90	28	5	50	0.0150	2700	68	103	137	154	164	205
	G1/4 -G3/8	7.90	19	5	50	0.0200	2015	67	100	133	150	160	200
	G1/2 -G7/8	11.90	14	5	50	0.0300	1335	67	100	133	150	160	200
	G1 -G3	15.90	11	5	50	0.0400	1000	67	100	133	150	160	200

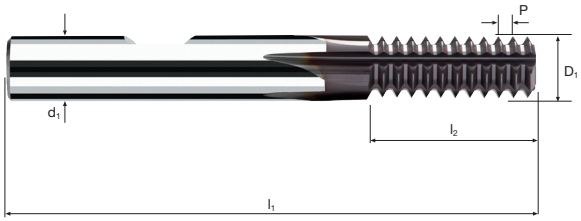
Material	G	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D1 3/2	v_{fc} d/D1 2/1	v_{fc} d/D1 3/1	v_{fc} d/D1 4/1	v_{fc} d/D1 > 5/1	v_f [mm/min]
Wrought aluminium alloys Si < 6%	G1/16-G1/8	5.90	28	5	60	0.0150	3235	82	123	163	184	196	245
	G1/4 -G3/8	7.90	19	5	60	0.0200	2420	80	120	160	180	192	240
	G1/2 -G7/8	11.90	14	5	60	0.0300	1605	80	120	160	180	192	240
	G1 -G3	15.90	11	5	60	0.0400	1200	80	120	160	180	192	240
Cast aluminium	G1/16-G1/8	5.90	28	5	80	0.0150	4315	108	163	217	244	260	325
	G1/4 -G3/8	7.90	19	5	80	0.0200	3225	108	163	217	244	260	325
	G1/2 -G7/8	11.90	14	5	80	0.0300	2140	107	160	213	240	256	320
	G1 -G3	15.90	11	5	80	0.0400	1600	107	160	213	240	256	320
Unalloyed copper	G1/16-G1/8	5.90	28	5	70	0.0150	3775	95	143	190	214	228	285
	G1/4 -G3/8	7.90	19	5	70	0.0200	2820	93	140	187	210	224	280
	G1/2 -G7/8	11.90	14	5	70	0.0300	1870	93	140	187	210	224	280
	G1 -G3	15.90	11	5	70	0.0400	1400	93	140	187	210	224	280
Thermoplastics	G1/16-G1/8	5.90	28	5	100	0.0150	5395	135	203	270	304	324	405
	G1/4 -G3/8	7.90	19	5	100	0.0200	4030	135	203	270	304	324	405
	G1/2 -G7/8	11.90	14	5	100	0.0300	2675	133	200	267	300	320	400
	G1 -G3	15.90	11	5	100	0.0400	2000	133	200	267	300	320	400

Thread milling cutters

1.5xd

G

HM



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	Aluminium GG(G)

Example:
Order-N°. **EU2060** **.550**

(Article-N°. / ø-Code)

ø Code	d	P(TPI)	l1	l2	d1 h6	D1		UNICUT-4X EU2060
.550	G 1/16 - G1/8	28	57	14.5	6	5.9	5	●
.552	G 1/4 - G3/8	19	63	18.7	8	7.9	5	●
.554	G 1/2 - G7/8	14	83	29.0	12	11.9	5	●
.558	G1" - G3"	11	92	34.6	16	15.9	6	●

VIII

Application

Material	UNC	UNF	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D_1 3/2	v_{fc} d/D_1 2/1	v_{fc} d/D_1 3/1	v_{fc} d/D_1 4/1	v_{fc} d/D_1 > 5/1	v_f [mm/min]
Steel < 850 N/mm²	2	3	1.50	56	3	30	0.0025	6365	17	25	33	38	40	50
	3	4	1.50	48	3	30	0.0025	6365	17	25	33	38	40	50
	4-5	6	2.10	40	3	30	0.0035	4545	17	25	33	38	40	50
	8	10	3.00	32	3	30	0.0050	3185	17	25	33	38	40	50
	12	5/16-3/8	4.00	24	3	30	0.0065	2385	15	23	30	34	36	45
	1/4	7/16-1/2	4.00	20	3	30	0.0065	2385	15	23	30	34	36	45
	5/16	9/16-5/8	5.00	18	3	30	0.0085	1910	17	25	33	38	40	50
	3/8	3/4	5.90	16	3	30	0.0100	1620	17	25	33	38	40	50
	7/16	7/8	7.90	14	3	30	0.0130	1210	15	23	30	34	36	45
Steel < 850 N/mm²	9/16	1- 1 1/2	9.90	12	3	30	0.0165	965	17	25	33	38	40	50
	5/8		9.90	11	3	30	0.0165	965	17	25	33	38	40	50
	3/4		11.90	10	5	30	0.0200	800	27	40	53	60	64	80
	7/8		15.90	9	5	30	0.0265	600	27	40	53	60	64	80
	1		15.90	8	5	30	0.0265	600	27	40	53	60	64	80
	1 1/8-1 1/4		15.90	7	5	30	0.0265	600	27	40	53	60	64	80
	1 3/8-1 1/2		19.90	6	5	30	0.0330	480	27	40	53	60	64	80
	1 3/4		19.90	5	5	30	0.0330	480	27	40	53	60	64	80
	2		19.90	5	6	30	0.0330	480	32	48	63	71	76	95
Steel 850 - 1100 N/mm²	2	3	1.50	56	3	20	0.0025	4245	10	15	20	23	24	30
	3	4	1.50	48	3	20	0.0025	4245	10	15	20	23	24	30
	4-5	6	2.10	40	3	20	0.0035	3030	10	15	20	23	24	30
	8	10	3.00	32	3	20	0.0050	2120	10	15	20	23	24	30
	12	5/16-3/8	4.00	24	3	20	0.0065	1590	10	15	20	23	24	30
	1/4	7/16-1/2	4.00	20	3	20	0.0065	1590	10	15	20	23	24	30
	5/16	9/16-5/8	5.00	18	3	20	0.0085	1275	12	18	23	26	28	35
	3/8	3/4	5.90	16	3	20	0.0100	1080	10	15	20	23	24	30
	7/16	7/8	7.90	14	3	20	0.0130	805	10	15	20	23	24	30
Steel 850 - 1100 N/mm²	9/16	1- 1 1/2	9.90	12	3	20	0.0165	645	10	15	20	23	24	30
	5/8		9.90	11	3	20	0.0165	645	10	15	20	23	24	30
	3/4		11.90	10	5	20	0.0200	535	18	28	37	41	44	55
	7/8		15.90	9	5	20	0.0265	400	18	28	37	41	44	55
	1		15.90	8	5	20	0.0265	400	18	28	37	41	44	55
	1 1/8-1 1/4		15.90	7	5	20	0.0265	400	18	28	37	41	44	55
	1 3/8-1 1/2		19.90	6	5	20	0.0330	320	18	28	37	41	44	55
	1 3/4		19.90	5	5	20	0.0330	320	18	28	37	41	44	55
	2		19.90	5	6	20	0.0330	320	22	33	43	49	52	65

Material	UNC	UNF	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D_1 3/2	v_{fc} d/D_1 2/1	v_{fc} d/D_1 3/1	v_{fc} d/D_1 4/1	v_{fc} d/D_1 > 5/1	v_f [mm/min]
Wrought aluminium alloys Si < 6%	2	3	1.50	56	3	50	0.0025	10610	27	40	53	60	64	80
	3	4	1.50	48	3	50	0.0025	10610	27	40	53	60	64	80
	4-5	6	2.10	40	3	50	0.0035	7580	27	40	53	60	64	80
	8	10	3.00	32	3	50	0.0050	5305	27	40	53	60	64	80
	12	5/16-3/8	4.00	24	3	50	0.0065	3980	27	40	53	60	64	80
	1/4	7/16-1/2	4.00	20	3	50	0.0065	3980	27	40	53	60	64	80
	5/16	9/16-5/8	5.00	18	3	50	0.0085	3185	27	40	53	60	64	80
	3/8	3/4	5.90	16	3	50	0.0100	2700	27	40	53	60	64	80
	7/16	7/8	7.90	14	3	50	0.0130	2015	27	40	53	60	64	80
Wrought aluminium alloys Si < 6%	9/16	1- 1 1/2	9.90	12	3	50	0.0165	1610	27	40	53	60	64	80
	5/8		9.90	11	3	50	0.0165	1610	27	40	53	60	64	80
	3/4		11.90	10	5	50	0.0200	1335	45	68	90	101	108	135
	7/8		15.90	9	5	50	0.0265	1000	45	68	90	101	108	135
	1		15.90	8	5	50	0.0265	1000	45	68	90	101	108	135
	1 1/8-1 1/4		15.90	7	5	50	0.0265	1000	45	68	90	101	108	135
	1 3/8-1 1/2		19.90	6	5	50	0.0330	800	43	65	87	98	104	130
	1 3/4		19.90	5	5	50	0.0330	800	43	65	87	98	104	130
	2		19.90	5	6	50	0.0330	800	53	80	107	120	128	160
Cast iron GG(G)	2	3	1.50	56	3	40	0.0025	8490	22	33	43	49	52	65
	3	4	1.50	48	3	40	0.0025	8490	22	33	43	49	52	65
	4-5	6	2.10	40	3	40	0.0035	6065	22	33	43	49	52	65
	8	10	3.00	32	3	40	0.0050	4245	22	33	43	49	52	65
	12	5/16-3/8	4.00	24	3	40	0.0065	3185	20	30	40	45	48	60
	1/4	7/16-1/2	4.00	20	3	40	0.0065	3185	20	30	40	45	48	60
	5/16	9/16-5/8	5.00	18	3	40	0.0085	2545	22	33	43	49	52	65
	3/8	3/4	5.90	16	3	40	0.0100	2160	22	33	43	49	52	65
	7/16	7/8	7.90	14	3	40	0.0130	1610	22	33	43	49	52	65
Cast iron GG(G)	9/16	1- 1 1/2	9.90	12	3	40	0.0165	1285	22	33	43	49	52	65
	5/8		9.90	11	3	40	0.0165	1285	22	33	43	49	52	65
	3/4		11.90	10	5	40	0.0200	1070	35	53	70	79	84	105
	7/8		15.90	9	5	40	0.0265	800	35	53	70	79	84	105
	1		15.90	8	5	40	0.0265	800	35	53	70	79	84	105
	1 1/8-1 1/4		15.90	7	5	40	0.0265	800	35	53	70	79	84	105
	1 3/8-1 1/2		19.90	6	5	40	0.0330	640	35	53	70	79	84	105
	1 3/4		19.90	5	5	40	0.0330	640	35	53	70	79	84	105
	2		19.90	5	6	40	0.0330	640	42	63	83	94	100	125

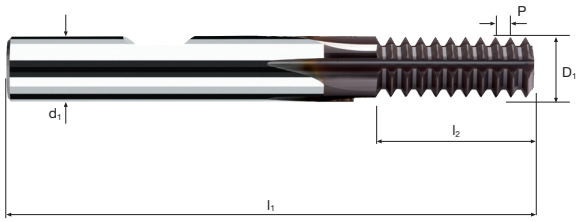
Thread milling cutters

1.5xd

UN

HM

DIN 6535 HB



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	Aluminium GG(G)

Example: **Order-N°.** Article-N°. **EU2110** ø-Code **.750**

ø Code	UNC	UNF	P(TPI)	l1	l2	d1 h6	D1		UNICUT-4X EU2110
.750*		Nr. 2	64	38	3.1	3	1.5	3	●
.751*	Nr. 2	Nr. 3	56	38	3.1	3	1.5	3	●
.752*	Nr. 3	Nr. 4	48	38	3.7	3	1.5	3	●
.753*		Nr. 5	44	38	4.6	3	2.1	3	●
.754*	Nr. 4 - 5	Nr. 6	40	38	4.4	3	2.1	3	●
.755*		Nr. 8	36	42	6.3	4	3.0	3	●
.756*	Nr. 8	Nr. 10	32	42	6.3	4	3.0	3	●
.759*		Nr. 12 - 1/4	28	42	8.1	4	3.6	3	●
.761	Nr. 12	5/16 - 3/8	24	57	8.4	6	4.0	3	●
.762	1/4	7/16 - 1/2	20	57	10.1	6	4.0	3	●
.764	5/16	9/16 - 5/8	18	57	12.7	6	5.0	3	●
.766	3/8	3/4	16	57	14.2	6	5.9	5	●
.769	7/16	7/8	14	63	16.3	8	7.9	5	●
.770	1/2		13	63	19.5	8	7.9	5	●
.771	9/16	1" - 1 1/2	12	72	23.2	10	9.9	5	●
.773	5/8		11	72	23.0	10	9.9	5	●

* without clamping flat only

Application

Material

Material	NPT NPTF		D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D_1 3/2	v_{fc} d/D_1 2/1	v_{fc} d/D_1 3/1	v_{fc} d/D_1 4/1	v_{fc} d/D_1 > 5/1	v_f [mm/min]
Steel < 850 N/mm²	1/16	- 1/8	5.90	27	5	30	0.0100	1620	27	40	53	60	64	80
	1/4	- 3/8	7.90	18	5	30	0.0130	1210	27	40	53	60	64	80
	1/2	- 3/4	11.90	14	5	30	0.0200	800	27	40	53	60	64	80
	1	- 2	15.90	12	6	30	0.0265	600	32	48	63	71	76	95
	2 1/2	- 4	15.90	8	6	30	0.0265	600	32	48	63	71	76	95
Steel 850 - 1100 N/mm²	1/16	- 1/8	5.90	27	5	20	0.0100	1080	18	28	37	41	44	55
	1/4	- 3/8	7.90	18	5	20	0.0130	805	17	25	33	38	40	50
	1/2	- 3/4	11.90	14	5	20	0.0200	535	18	28	37	41	44	55
	1	- 2	15.90	12	6	20	0.0265	400	22	33	43	49	52	65
	2 1/2	- 4	15.90	8	6	20	0.0265	400	22	33	43	49	52	65
Stainless steel [Cr-Ni/1.4301]	1/16	- 1/8	5.90	27	5	15	0.0100	810	13	20	27	30	32	40
	1/4	- 3/8	7.90	18	5	15	0.0130	605	13	20	27	30	32	40
	1/2	- 3/4	11.90	14	5	15	0.0200	400	13	20	27	30	32	40
	1	- 2	15.90	12	6	15	0.0265	300	17	25	33	38	40	50
	2 1/2	- 4	15.90	8	6	15	0.0265	300	17	25	33	38	40	50
Cast iron GG(G)	1/16	- 1/8	5.90	27	5	40	0.0100	2160	37	55	73	83	88	110
	1/4	- 3/8	7.90	18	5	40	0.0130	1610	35	53	70	79	84	105
	1/2	- 3/4	11.90	14	5	40	0.0200	1070	35	53	70	79	84	105
	1	- 2	15.90	12	6	40	0.0265	800	42	63	83	94	100	125
	2 1/2	- 4	15.90	8	6	40	0.0265	800	42	63	83	94	100	125

Material

Material	NPT NPTF		D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D_1 3/2	v_{fc} d/D_1 2/1	v_{fc} d/D_1 3/1	v_{fc} d/D_1 4/1	v_{fc} d/D_1 > 5/1	v_f [mm/min]
Wrought aluminium alloys Si < 6%	1/16	- 1/8	5.90	27	5	50	0.0100	2700	45	68	90	101	108	135
	1/4	- 3/8	7.90	18	5	50	0.0130	2015	43	65	87	98	104	130
	1/2	- 3/4	11.90	14	5	50	0.0200	1335	45	68	90	101	108	135
	1	- 2	15.90	12	6	50	0.0265	1000	53	80	107	120	128	160
	2 1/2	- 4	15.90	8	6	50	0.0265	1000	53	80	107	120	128	160
Cast aluminium	1/16	- 1/8	5.90	27	5	60	0.0100	3235	53	80	107	120	128	160
	1/4	- 3/8	7.90	18	5	60	0.0130	2420	52	78	103	116	124	155
	1/2	- 3/4	11.90	14	5	60	0.0200	1605	53	80	107	120	128	160
	1	- 2	15.90	12	6	60	0.0265	1200	63	95	127	143	152	190
	2 1/2	- 4	15.90	8	6	60	0.0265	1200	63	95	127	143	152	190
Unalloyed copper	1/16	- 1/8	5.90	27	5	70	0.0100	3775	63	95	127	143	152	190
	1/4	- 3/8	7.90	18	5	70	0.0130	2820	62	93	123	139	148	185
	1/2	- 3/4	11.90	14	5	70	0.0200	1870	62	93	123	139	148	185
	1	- 2	15.90	12	6	70	0.0265	1400	75	113	150	169	180	225
	2 1/2	- 4	15.90	8	6	70	0.0265	1400	75	113	150	169	180	225
Thermoplastics	1/16	- 1/8	5.90	27	5	90	0.0100	4855	82	123	163	184	196	245
	1/4	- 3/8	7.90	18	5	90	0.0130	3625	78	118	157	176	188	235
	1/2	- 3/4	11.90	14	5	90	0.0200	2405	80	120	160	180	192	240
	1	- 2	15.90	12	6	90	0.0265	1800	95	143	190	214	228	285
	2 1/2	- 4	15.90	8	6	90	0.0265	1800	95	143	190	214	228	285

Thread milling cutters

NPT
NPTF

HM

Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	Aluminium GG(G)

Example:
Order-N°. EU2200 .840

(Article-N°. / ø-Code)

ø Code		d	P(TPI)	l1	l2	d1 h6	D1		UNICUT-4X EU2200
.840	NPT	1/16 - 1/8	27	57	9.4	6	5.9	5	●
.842	NPT	1/4 - 3/8	18	63	14.1	8	7.9	5	●
.844	NPT	1/2 - 3/4	14	83	19.9	12	11.9	5	●
.846	NPT	1" - 2"	11.5	92	26.5	16	15.9	6	●

Example:
Order-N°. EU2210 .840

(Article-N°. / ø-Code)

ø Code		d	P(TPI)	l1	l2	d1 h6	D1		UNICUT-4X EU2210
.840	NPTF	1/16 - 1/8	27	57	9.4	6	5.9	5	●
.842	NPTF	1/4 - 3/8	18	63	14.1	8	7.9	5	●
.844	NPTF	1/2 - 3/4	14	83	19.9	12	11.9	5	●
.846	NPTF	1" - 2"	11.5	92	26.5	16	15.9	6	●

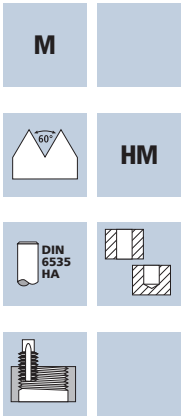
Application

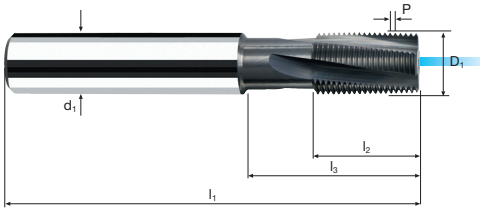
Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D_1 3/2	v_{fc} d/D_1 2/1	v_{fc} d/D_1 3/1	v_{fc} d/D_1 4/1	v_{fc} d/D_1 > 5/1	v_f [mm/min]
Steel 850 - 1100 N/mm²	≥ M14	9.95	1.00	4	80	0.0250	2560	85	128	170	191	204	255
	≥ M14	9.95	1.25	4	80	0.0250	2560	85	128	170	191	204	255
	≥ M14	9.95	1.50	4	80	0.0250	2560	85	128	170	191	204	255
	≥ M18	11.95	1.00	4	80	0.0300	2130	85	128	170	191	204	255
	≥ M18	11.95	1.50	4	80	0.0300	2130	85	128	170	191	204	255
	≥ M24	15.95	1.00	5	80	0.0400	1595	107	160	213	240	256	320
	≥ M24	15.95	2.00	5	80	0.0400	1595	107	160	213	240	256	320
	≥ M30	19.95	1.50	5	80	0.0500	1275	107	160	213	240	256	320
	≥ M30	19.95	2.00	5	80	0.0500	1275	107	160	213	240	256	320
Steel 1300 - 1500 N/mm²	≥ M14	9.95	1.00	4	50	0.0200	1600	43	65	87	98	104	130
	≥ M14	9.95	1.25	4	50	0.0200	1600	43	65	87	98	104	130
	≥ M14	9.95	1.50	4	50	0.0200	1600	43	65	87	98	104	130
	≥ M18	11.95	1.00	4	50	0.0240	1330	43	65	87	98	104	130
	≥ M18	11.95	1.50	4	50	0.0240	1330	43	65	87	98	104	130
	≥ M24	15.95	1.00	5	50	0.0320	1000	53	80	107	120	128	160
	≥ M24	15.95	2.00	5	50	0.0320	1000	53	80	107	120	128	160
	≥ M30	19.95	1.50	5	50	0.0400	800	53	80	107	120	128	160
	≥ M30	19.95	2.00	5	50	0.0400	800	53	80	107	120	128	160
Hardened tool steel 48 - 52 HRC	≥ M14	9.95	1.00	4	30	0.0165	960	22	33	43	49	52	65
	≥ M14	9.95	1.25	4	30	0.0165	960	22	33	43	49	52	65
	≥ M14	9.95	1.50	4	30	0.0165	960	22	33	43	49	52	65
	≥ M18	11.95	1.00	4	30	0.0200	800	22	33	43	49	52	65
	≥ M18	11.95	1.50	4	30	0.0200	800	22	33	43	49	52	65
	≥ M24	15.95	1.00	5	30	0.0265	600	27	40	53	60	64	80
	≥ M24	15.95	2.00	5	30	0.0265	600	27	40	53	60	64	80
	≥ M30	19.95	1.50	5	30	0.0335	480	27	40	53	60	64	80
	≥ M30	19.95	2.00	5	30	0.0335	480	27	40	53	60	64	80
Stainless steel [Cr-Ni/1.4301]	≥ M14	9.95	1.00	4	45	0.0200	1440	38	58	77	86	92	115
	≥ M14	9.95	1.25	4	45	0.0200	1440	38	58	77	86	92	115
	≥ M14	9.95	1.50	4	45	0.0200	1440	38	58	77	86	92	115
	≥ M18	11.95	1.00	4	45	0.0240	1200	38	58	77	86	92	115
	≥ M18	11.95	1.50	4	45	0.0240	1200	38	58	77	86	92	115
	≥ M24	15.95	1.00	5	45	0.0320	900	48	73	97	109	116	145
	≥ M24	15.95	2.00	5	45	0.0320	900	48	73	97	109	116	145
	≥ M30	19.95	1.50	5	45	0.0400	720	48	73	97	109	116	145
	≥ M30	19.95	2.00	5	45	0.0400	720	48	73	97	109	116	145

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D_1 3/2	v_{fc} d/D_1 2/1	v_{fc} d/D_1 3/1	v_{fc} d/D_1 4/1	v_{fc} d/D_1 > 5/1	v_f [mm/min]
Cast iron GG(G)	≥ M14	9.95	1.00	4	120	0.0250	3840	128	193	257	289	308	385
	≥ M14	9.95	1.25	4	120	0.0250	3840	128	193	257	289	308	385
	≥ M14	9.95	1.50	4	120	0.0250	3840	128	193	257	289	308	385
	≥ M18	11.95	1.00	4	120	0.0300	3195	128	193	257	289	308	385
	≥ M18	11.95	1.50	4	120	0.0300	3195	128	193	257	289	308	385
	≥ M24	15.95	1.00	5	120	0.0400	2395	160	240	320	360	384	480
	≥ M24	15.95	2.00	5	120	0.0400	2395	160	240	320	360	384	480
	≥ M30	19.95	1.50	5	120	0.0500	1915	160	240	320	360	384	480
	≥ M30	19.95	2.00	5	120	0.0500	1915	160	240	320	360	384	480
Wrought aluminium alloys Si < 6%	≥ M14	9.95	1.00	4	150	0.0285	4800	182	273	363	409	436	545
	≥ M14	9.95	1.25	4	150	0.0285	4800	182	273	363	409	436	545
	≥ M14	9.95	1.50	4	150	0.0285	4800	182	273	363	409	436	545
	≥ M18	11.95	1.00	4	150	0.0340	3995	182	273	363	409	436	545
	≥ M18	11.95	1.50	4	150	0.0340	3995	182	273	363	409	436	545
	≥ M24	15.95	1.00	5	150	0.0455	2995	227	340	453	510	544	680
	≥ M24	15.95	2.00	5	150	0.0455	2995	227	340	453	510	544	680
	≥ M30	19.95	1.50	5	150	0.0570	2395	228	343	457	514	548	685
	≥ M30	19.95	2.00	5	150	0.0570	2395	228	343	457	514	548	685
Cast aluminium	≥ M14	9.95	1.00	4	200	0.0285	6400	243	365	487	548	584	730
	≥ M14	9.95	1.25	4	200	0.0285	6400	243	365	487	548	584	730
	≥ M14	9.95	1.50	4	200	0.0285	6400	243	365	487	548	584	730
	≥ M18	11.95	1.00	4	200	0.0340	5330	242	363	483	544	580	725
	≥ M18	11.95	1.50	4	200	0.0340	5330	242	363	483	544	580	725
	≥ M24	15.95	1.00	5	200	0.0455	3990	303	455	607	683	728	910
	≥ M24	15.95	2.00	5	200	0.0455	3990	303	455	607	683	728	910
	≥ M30	19.95	1.50	5	200	0.0570	3190	303	455	607	683	728	910
	≥ M30	19.95	2.00	5	200	0.0570	3190	303	455	607	683	728	910
Titanium alloys > 300 HB [Ti6Al4V]	≥ M14	9.95	1.00	4	35	0.0200	1120	30	45	60	68	72	90
	≥ M14	9.95	1.25	4	35	0.0200	1120	30	45	60	68	72	90
	≥ M14	9.95	1.50	4	35	0.0200	1120	30	45	60	68	72	90
	≥ M18	11.95	1.00	4	35	0.0240	930	30	45	60	68	72	90
	≥ M18	11.95	1.50	4	35	0.0240	930	30	45	60	68	72	90
	≥ M24	15.95	1.00	5	35	0.0320	700	37	55	73	83	88	110
	≥ M24	15.95	2.00	5	35	0.0320	700	37	55	73	83	88	110
	≥ M30	19.95	1.50	5	35	0.0400	560	37	55	73	83	88	110
	≥ M30	19.95	2.00	5	35	0.0400	560	37	55	73	83	88	110

Multi-range thread milling cutters

Incool





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

Example:
Order-N°. **EH26020** (Article-N°.) **.096** (ø-Code)

ø Code	d min.	P	l1	l2	l3	d1 h6	D1		TiCN EH26020
.096	14	1.00	70	16	25	10	9.95	4	●
.166	14	1.25	70	16	25	10	9.95	4	●
.178	14	1.50	70	16	25	10	9.95	4	●
.100	18	1.00	80	20	31	12	11.95	4	●
.182	18	1.50	80	20	31	12	11.95	4	●
.106	24	1.00	90	25	40	16	15.95	5	●
.188	24	1.50	90	25	40	16	15.95	5	●
.254	24	2.00	90	25	40	16	15.95	5	●
.194	30	1.50	105	33	50	20	19.95	5	●
.260	30	2.00	105	33	50	20	19.95	5	●

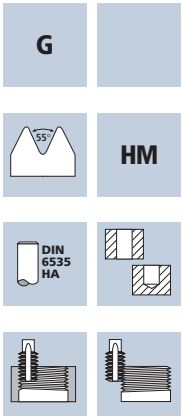
Application

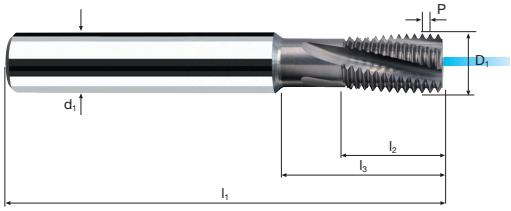
Material	G	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D1 3/2	v_{fc} d/D1 2/1	v_{fc} d/D1 3/1	v_{fc} d/D1 4/1	v_{fc} d/D1 > 5/1	v_f [mm/min]
Steel 850 - 1100 N/mm²	G1/4 - G3/8	9.95	19	4	80	0.0250	2560	85	128	170	191	204	255
	G1/2 - G7/8	15.95	14	5	80	0.0400	1595	107	160	213	240	256	320
	G1 - G3	19.95	11	5	80	0.0500	1275	107	160	213	240	256	320
Steel 1300 - 1500 N/mm²	G1/4 - G3/8	9.95	19	4	50	0.0200	1600	43	65	87	98	104	130
	G1/2 - G7/8	15.95	14	5	50	0.0320	1000	53	80	107	120	128	160
	G1 - G3	19.95	11	5	50	0.0400	800	53	80	107	120	128	160
Hardened tool steel 48 - 52 HRC	G1/4 - G3/8	9.95	19	4	30	0.0165	960	22	33	43	49	52	65
	G1/2 - G7/8	15.95	14	5	30	0.0265	600	27	40	53	60	64	80
	G1 - G3	19.95	11	5	30	0.0335	480	27	40	53	60	64	80
Stainless steel [Cr-Ni/1.4301]	G1/4 - G3/8	9.95	19	4	45	0.0200	1440	38	58	77	86	92	115
	G1/2 - G7/8	15.95	14	5	45	0.0320	900	48	73	97	109	116	145
	G1 - G3	19.95	11	5	45	0.0400	720	48	73	97	109	116	145

Material	G	D1 [mm]	P (TPI)	z	v_c [m/min]	f_z [mm]	n [min⁻¹]	v_{fc} d/D1 3/2	v_{fc} d/D1 2/1	v_{fc} d/D1 3/1	v_{fc} d/D1 4/1	v_{fc} d/D1 > 5/1	v_f [mm/min]
Cast iron GG(G)	G1/4 - G3/8	9.95	19	4	120	0.0250	3840	128	193	257	289	308	385
	G1/2 - G7/8	15.95	14	5	120	0.0400	2395	160	240	320	360	384	480
	G1 - G3	19.95	11	5	120	0.0500	1915	160	240	320	360	384	480
Wrought aluminium alloys Si < 6%	G1/4 - G3/8	9.95	19	4	150	0.0285	4800	182	273	363	409	436	545
	G1/2 - G7/8	15.95	14	5	150	0.0455	2995	227	340	453	510	544	680
	G1 - G3	19.95	11	5	150	0.0570	2395	228	343	457	514	548	685
Cast aluminium	G1/4 - G3/8	9.95	19	4	200	0.0285	6400	243	365	487	548	584	730
	G1/2 - G7/8	15.95	14	5	200	0.0455	3990	303	455	607	683	728	910
	G1 - G3	19.95	11	5	200	0.0570	3190	303	455	607	683	728	910
Titanium alloys > 300 HB [Ti6Al4V]	G1/4 - G3/8	9.95	19	4	35	0.0200	1120	30	45	60	68	72	90
	G1/2 - G7/8	15.95	14	5	35	0.0320	700	37	55	73	83	88	110
	G1 - G3	19.95	11	5	35	0.0400	560	37	55	73	83	88	110

Multi-range thread milling cutters

Incool





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

Example: **Order-N°.** **EH26040** (Article-N°.) **.552** (ø-Code)

ø Code	d min.	P(TPI)	l1	l2	l3	d1 h6	D1		TiCN EH26040
.552	1/4	19	70	16	25	10	9.95	4	●
.554	1/2	14	90	25	40	16	15.95	5	●
.558	1"	11	105	33	50	20	19.95	5	●

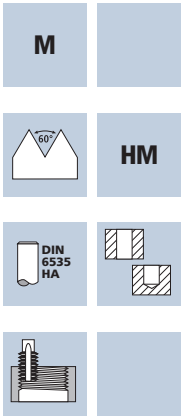
Application

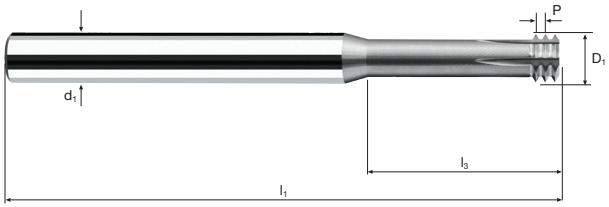
Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Steel 850 - 1100 N/mm²	M 1	0.70	0.25	3	120	0.0020	54570	98	325
	M 2	1.50	0.40	3	120	0.0040	25465	76	305
	M 3	2.20	0.50	3	120	0.0055	17365	76	285
	M 4	3.10	0.70	3	120	0.0080	12320	66	295
	M 5	3.80	0.80	3	120	0.0095	10050	68	285
	M 6	4.70	1.00	3	120	0.0120	8125	64	295
	M 8	5.90	1.25	5	120	0.0150	6475	127	485
	M10	7.90	1.50	5	120	0.0200	4835	102	485
Steel 1300 - 1500 N/mm²	M 1	0.70	0.25	3	100	0.0010	45475	41	135
	M 2	1.50	0.40	3	100	0.0025	21220	40	160
	M 3	2.20	0.50	3	100	0.0035	14470	40	150
	M 4	3.10	0.70	3	100	0.0050	10270	35	155
	M 5	3.80	0.80	3	100	0.0065	8375	40	165
	M 6	4.70	1.00	3	100	0.0080	6775	36	165
	M 8	5.90	1.25	5	100	0.0100	5395	71	270
	M10	7.90	1.50	5	100	0.0130	4030	55	260
Stainless steel [Cr-Ni/1.4301]	M 1	0.70	0.25	3	80	0.0010	36380	33	110
	M 2	1.50	0.40	3	80	0.0025	16975	31	125
	M 3	2.20	0.50	3	80	0.0035	11575	32	120
	M 4	3.10	0.70	3	80	0.0050	8215	28	125
	M 5	3.80	0.80	3	80	0.0060	6700	29	120
	M 6	4.70	1.00	3	80	0.0070	5420	25	115
	M 8	5.90	1.25	5	80	0.0090	4315	51	195
	M10	7.90	1.50	5	80	0.0120	3225	41	195
Nickel base alloys	M 1	0.70	0.25	3	60	0.0010	27285	24	80
	M 2	1.50	0.40	3	60	0.0025	12735	24	95
	M 3	2.20	0.50	3	60	0.0035	8680	24	90
	M 4	3.10	0.70	3	60	0.0050	6160	20	90
	M 5	3.80	0.80	3	60	0.0060	5025	22	90
	M 6	4.70	1.00	3	60	0.0070	4065	18	85
	M 8	5.90	1.25	5	60	0.0090	3235	38	145
	M10	7.90	1.50	5	60	0.0120	2420	30	145

Material	M	D1 [mm]	P [mm]	z	v_c [m/min]	f_z [mm]	n [mm⁻¹]	v_{fc} [mm/min]	v_f [mm/min]
Wrought aluminium alloys Si < 6%	M 1	0.70	0.25	3	150	0.0015	60000	81	270
	M 2	1.50	0.40	3	150	0.0035	31830	84	335
	M 3	2.20	0.50	3	150	0.0050	21705	87	325
	M 4	3.10	0.70	3	150	0.0070	15405	73	325
	M 5	3.80	0.80	3	150	0.0085	12565	77	320
	M 6	4.70	1.00	3	150	0.0105	10160	69	320
	M 8	5.90	1.25	5	150	0.0130	8095	138	525
	M10	7.90	1.50	5	150	0.0175	6045	111	530
Cast aluminium	M 1	0.70	0.25	3	180	0.0020	60000	108	360
	M 2	1.50	0.40	3	180	0.0040	38200	115	460
	M 3	2.20	0.50	3	180	0.0055	26045	115	430
	M 4	3.10	0.70	3	180	0.0080	18485	100	445
	M 5	3.80	0.80	3	180	0.0095	15080	103	430
	M 6	4.70	1.00	3	180	0.0120	12190	95	440
	M 8	5.90	1.25	5	180	0.0150	9710	192	730
	M10	7.90	1.50	5	180	0.0200	7255	152	725
Unalloyed copper	M 1	0.70	0.25	3	100	0.0015	45475	62	205
	M 2	1.50	0.40	3	100	0.0030	21220	48	190
	M 3	2.20	0.50	3	100	0.0045	14470	52	195
	M 4	3.10	0.70	3	100	0.0060	10270	42	185
	M 5	3.80	0.80	3	100	0.0075	8375	46	190
	M 6	4.70	1.00	3	100	0.0095	6775	42	195
	M 8	5.90	1.25	5	100	0.0120	5395	85	325
	M10	7.90	1.50	5	100	0.0160	4030	67	320
Titanium alloys > 300 HB [Ti6Al4V]	M 1	0.70	0.25	3	70	0.0010	31830	29	95
	M 2	1.50	0.40	3	70	0.0025	14855	28	110
	M 3	2.20	0.50	3	70	0.0035	10130	28	105
	M 4	3.10	0.70	3	70	0.0050	7190	25	110
	M 5	3.80	0.80	3	70	0.0060	5865	25	105
	M 6	4.70	1.00	3	70	0.0070	4740	22	100
	M 8	5.90	1.25	5	70	0.0090	3775	45	170
	M10	7.90	1.50	5	70	0.0120	2820	36	170

Thread whirler

3.0xd





Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Aluminium GG(G) Nickel-Alloys

Example: **Order-N°.** Article-N°. **EU28500** ø-Code **.010**

ø Code	d	P	l_1	l_3	d_1 h6	D_1	R_k 6H		E28500	UNICUT-4X EU28500
.010	M 1	0.25	38	3.0	3	0.70	0.337	3	●	●
.020	M 1.4	0.30	38	4.2	3	1.00	0.485	3	●	●
.022	M 1.6	0.35	38	4.8	3	1.20	0.583	3	●	●
.034	M 2	0.40	38	6.0	3	1.50	0.730	3	●	●
.040	M 2.5	0.45	38	7.5	3	1.80	0.878	3	●	●
.044	M 3	0.50	42	9.0	3	2.20	1.075	3	●	●
.058	M 4	0.70	47	12.0	4	3.10	1.515	3	●	●
.084	M 5	0.80	57	15.0	6	3.80	1.860	3	●	●
.088	M 6	1.00	62	18.0	6	4.70	2.300	3	●	●
.160	M 8	1.25	65	24.0	6	5.90	2.888	5	●	●
.174	M10	1.50	86	30.0	8	7.90	3.875	5	●	●