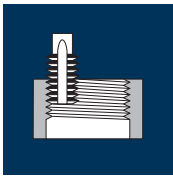


Application



Material

Steel
850 - 1100 N/mm²

Steel
1300 - 1500 N/mm²

Hardened tool steel
48 - 52 HRC

Stainless steel
[Cr-Ni/1.4301]

M	D1 [mm]	P [mm]	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]
≥ 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
≥ 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
≥ 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
≥ 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

Cast iron
GG(G)

Wrought aluminium
alloys Si < 6%

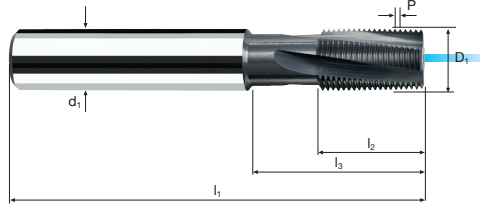
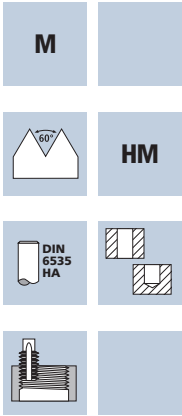
Cast aluminium

Titanium alloys
> 300 HB
[Ti6Al4V]

M	D1 [mm]	P [mm]	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]
≥ 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
≥ 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
≥ 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
≥ 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)
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Example: Order-N°.		Article-N°.		ø-Code						TiCN
		EH26020		.096						EH26020
ø Code	d min.	P	l ₁	l ₂	l ₃	d ₁ h6	D ₁			
.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

Steel
850 - 1100 N/mm²

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]
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

Cast iron
GG(G)

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]
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

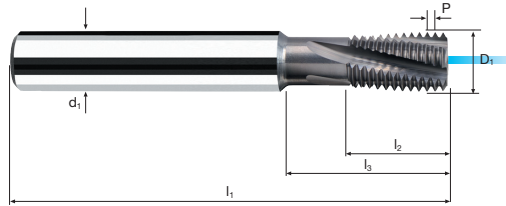
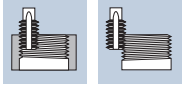
G1/4 - G3/8	9.95	19	4	200	0.0285	6400	243	365	487	548	584	730
G1/2 - G7/8	15.95	14	5	200	0.0455	3990	303	455	607	683	728	910
G1 - G3	19.95	11	5	200	0.0570	3190	303	455	607	683	728	910

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)
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Example: Order-N°. Article-N°. ø-Code .552 EH26040 .552									TiCN
Ø Code	d min.	P(TPI)	l1	l2	l3	d1 h6	D1		
.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	●

