

Application



Material

Steel
850 - 1100 N/mm²

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]
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

Cast iron
GG(G)

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]
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

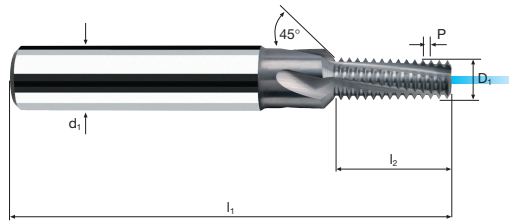
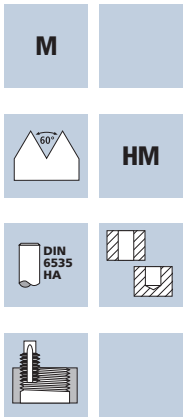
M 3	2.30	0.50	3	200	0.0070	7.2	27680	135	580
M 4	3.00	0.70	3	200	0.0095	9.4	21220	151	605
M 5	4.00	0.80	3	200	0.0125	11.4	15915	119	595
M 6	4.80	1.00	3	200	0.0155	14.3	13265	123	615
M 8	6.40	1.25	3	200	0.0205	19.1	9945	122	610
M 10	7.95	1.50	4	200	0.0250	23.1	8010	164	800
M 12	9.95	1.75	4	200	0.0315	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



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
		EH24300		.044						EH24300
ø Code	d	P	l ₁	l ₂	d ₁ h ₆	D ₁	R _k 6H			
.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										

TM

Application



Material

Steel
850 - 1100 N/mm²

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]
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

Wrought aluminium
alloys Si < 6%

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]
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

Application



Material

Steel
850 - 1100 N/mm²

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]
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

Cast iron
GG(G)

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]
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

Application



Material

Steel
850 - 1100 N/mm²

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]
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

Cast iron
GG(G)

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]
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

Application



Material

Steel
850 - 1100 N/mm²

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]
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

Cast iron
GG(G)

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]
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

