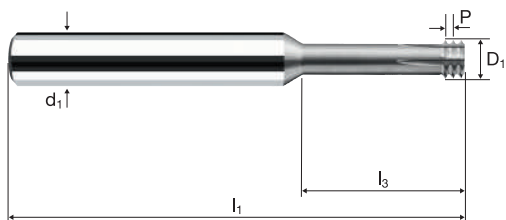
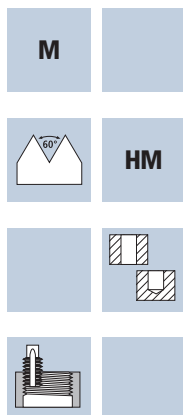


Thread whirler

3xd



TM

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Aluminium/Copper GG(G) Nickel-Alloys
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Example: Order-Nº. EU28500 010											UNICUT-4X	
											E28500	EU28500
Ø Code	d	P	l ₁	l ₃	d ₁ h6	D ₁	R _k 6H					
010	M 1	0.25	38	3.0	3	0.70	0.337	3	1		●	●
020	M 1.4	0.30	38	4.2	3	1.00	0.485	3	1		●	●
022	M 1.6	0.35	38	4.8	3	1.20	0.583	3	1		●	●
034	M 2	0.40	38	6.0	3	1.50	0.730	3	1		●	●
040	M 2.5	0.45	38	7.5	3	1.80	0.878	3	1		●	●
044	M 3	0.50	42	9.0	3	2.20	1.075	3	3		●	●
058	M 4	0.70	47	12.0	4	3.10	1.515	3	3		●	●
084	M 5	0.80	57	15.0	6	3.80	1.860	3	3		●	●
088	M 6	1.00	62	18.0	6	4.70	2.300	3	3		●	●
160	M 8	1.25	65	24.0	6	5.90	2.888	5	3		●	●
174	M10	1.50	86	30.0	8	7.90	3.875	5	3		●	●

Application



Material

Steel
850 - 1100 N/mm²

M	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [mm ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
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
M 10	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
M 10	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
M 10	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
M 10	7.90	1.50	5	60	0.0120	2420	30	145

Material

Wrought aluminium
alloys Si < 6%

M	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [mm ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
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
M 10	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
M 10	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
M 10	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
M 10	7.90	1.50	5	70	0.0120	2820	36	170