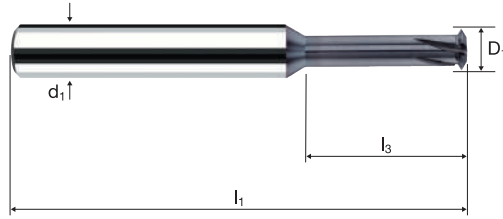
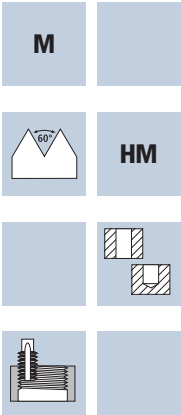


Thread whirler

3xd



new!

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-N°.											TiCN
Article-N°.											EH27500
ø-Code											EH27500
ø Code	d	P max.	l ₁	l ₃	d ₁ h ₆	D ₁	R _k 6H				
020	M 1.4 - M 1.8	0.35	39	3.8	3	1.05	0.500	3	1		•
034	M 2 - M 2.4	0.40	39	7.0	3	1.50	0.720	3	1		•
040	M 2.5 - M 3	0.50	39	9.0	3	2.00	0.970	4	1		•
056	M 3.5 - M 4.5	0.75	58	14.0	6	2.80	1.370	4	1		•
084	M 5 - M 7	1.00	58	19.0	6	4.00	1.970	4	1		•
160	M 8 - M 10	1.50	64	24.0	8	6.40	3.140	5	1		•

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 1.6	1.05	0.35	3	80	0.010	24250	250	728
M 2.0	1.50	0.40	3	80	0.010	16975	127	509
M 3.0	2.00	0.50	4	80	0.020	12730	339	1018
M 4.5	2.80	0.75	4	80	0.020	9095	275	728
M 6.0	4.00	1.00	4	80	0.025	6365	212	637
M 10.0	6.40	1.50	5	80	0.035	3980	251	697

Steel
1300 - 1500 N/mm²

M 1.6	1.05	0.35	3	45	0.010	13640	141	409
M 2.0	1.50	0.40	3	45	0.010	9550	72	287
M 3.0	2.00	0.50	4	45	0.020	7160	191	573
M 4.5	2.80	0.75	4	45	0.020	5115	155	409
M 6.0	4.00	1.00	4	45	0.030	3580	143	430
M 10.0	6.40	1.50	5	45	0.030	2240	121	336

Stainless steel
[Cr-Ni/1.4301]

M 1.6	1.05	0.35	3	55	0.010	16675	172	500
M 2.0	1.50	0.40	3	55	0.010	11670	88	350
M 3.0	2.00	0.50	4	55	0.020	8755	233	700
M 4.5	2.80	0.75	4	55	0.025	6255	236	626
M 6.0	4.00	1.00	4	55	0.030	4375	175	525
M 10.0	6.40	1.50	5	55	0.030	2735	148	410

Nickel base alloys

M 1.6	1.05	0.35	3	30	0.010	9095	94	273
M 2.0	1.50	0.40	3	30	0.010	6365	48	191
M 3.0	2.00	0.50	4	30	0.010	4775	64	191
M 4.5	2.80	0.75	4	30	0.015	3410	77	205
M 6.0	4.00	1.00	4	30	0.020	2385	64	191
M 10.0	6.40	1.50	5	30	0.030	1490	81	224

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 1.6	1.05	0.35	3	150	0.020	45475	938	2729
M 2.0	1.50	0.40	3	150	0.020	31830	478	1910
M 3.0	2.00	0.50	4	150	0.030	23875	955	2865
M 4.5	2.80	0.75	4	150	0.035	17050	902	2387
M 6.0	4.00	1.00	4	150	0.040	11935	637	1910
M 10.0	6.40	1.50	5	150	0.050	7460	671	1865

Cast iron
GG(G)

M 1.6	1.05	0.35	3	120	0.010	36380	375	1091
M 2.0	1.50	0.40	3	120	0.010	25465	191	764
M 3.0	2.00	0.50	4	120	0.020	19100	509	1528
M 4.5	2.80	0.75	4	120	0.025	13640	515	1364
M 6.0	4.00	1.00	4	120	0.030	9550	382	1146
M 10.0	6.40	1.50	5	120	0.040	5970	430	1194

Unalloyed copper

M 1.6	1.05	0.35	3	130	0.010	39410	406	1182
M 2.0	1.50	0.40	3	130	0.010	27585	207	828
M 3.0	2.00	0.50	4	130	0.020	20690	552	1655
M 4.5	2.80	0.75	4	130	0.025	14780	558	1478
M 6.0	4.00	1.00	4	130	0.030	10345	414	1241
M 10.0	6.40	1.50	5	130	0.040	6465	465	1293

Titanium alloys
> 300 HB
[Ti6Al4V]

M 1.6	1.05	0.35	3	40	0.010	12125	125	364
M 2.0	1.50	0.40	3	40	0.010	8490	64	255
M 3.0	2.00	0.50	4	40	0.010	6365	85	255
M 4.5	2.80	0.75	4	40	0.015	4545	103	273
M 6.0	4.00	1.00	4	40	0.020	3185	85	255
M 10.0	6.40	1.50	5	40	0.030	1990	108	299