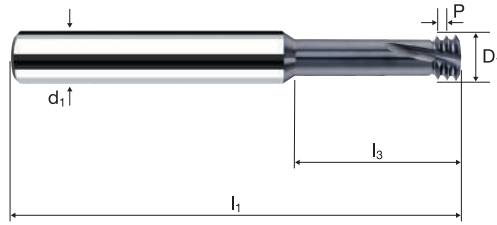
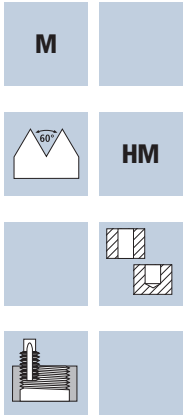


Thread whirler

3xd



new!

TM

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

Example:		Article-N°.		ø-Code							TiCN
Order-N°.		EH27502		022							EH27502
ø Code	d	P	l ₁	l ₃	d ₁ h6	D ₁	R _k 6H				
022	M 1.6	0.35	39	4.8	3	1.20	0.570	3	3		●
026	M 1.8	0.35	39	5.4	3	1.40	0.670	3	3		●
034	M 2	0.40	39	6.0	3	1.55	0.750	4	3		●
040	M 2.5	0.45	39	7.5	3	1.95	0.950	4	3		●
044	M 3	0.50	58	9.5	6	2.40	1.170	4	3		●
056	M 3.5	0.60	58	11.0	6	2.80	1.370	4	3		●
058	M 4	0.70	58	12.5	6	3.20	1.570	4	3		●
084	M 5	0.80	58	16.0	6	4.00	1.970	4	3		●
088	M 6	1.00	58	20.0	6	4.80	2.370	4	3		●
160	M 8	1.25	58	24.0	6	5.95	2.950	4	3		●
174	M10	1.50	73	33.0	8	7.80	3.840	4	3		●
240	M12	1.75	84	38.0	10	9.00	4.440	4	3		●
246	M16	2.00	84	35.0	12	11.80	5.840	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 2	1.55	0.40	4	80	0.010	16430	148	657
M 3	2.40	0.50	4	80	0.020	10610	170	849
M 4	3.20	0.70	4	80	0.020	7960	127	637
M 5	4.00	0.80	4	80	0.025	6365	127	637
M 6	4.80	1.00	4	80	0.030	5305	127	637
M 8	5.95	1.25	4	80	0.035	4280	153	599
M 10	7.80	1.50	4	80	0.050	3265	144	653
M 12	9.00	1.75	4	80	0.055	2830	156	623
M 16	11.80	2.00	5	80	0.060	2160	170	648

Steel
1300 - 1500 N/mm²

M 2	1.55	0.40	4	45	0.010	9240	83	370
M 3	2.40	0.50	4	45	0.020	5970	96	478
M 4	3.20	0.70	4	45	0.025	4475	90	448
M 5	4.00	0.80	4	45	0.030	3580	86	430
M 6	4.80	1.00	4	45	0.030	2985	72	358
M 8	5.95	1.25	4	45	0.030	2405	74	289
M 10	7.80	1.50	4	45	0.040	1835	65	294
M 12	9.00	1.75	4	45	0.050	1590	80	318
M 16	11.80	2.00	5	45	0.055	1215	88	334

Stainless steel
[Cr-Ni/1.4301]

M 2	1.55	0.40	4	55	0.010	11295	102	452
M 3	2.40	0.50	4	55	0.020	7295	117	584
M 4	3.20	0.70	4	55	0.025	5470	109	547
M 5	4.00	0.80	4	55	0.030	4375	105	525
M 6	4.80	1.00	4	55	0.030	3645	87	437
M 8	5.95	1.25	4	55	0.030	2940	90	353
M 10	7.80	1.50	4	55	0.035	2245	69	314
M 12	9.00	1.75	4	55	0.050	1945	97	389
M 16	11.80	2.00	5	55	0.055	1485	107	408

Nickel base alloys

M 2	1.55	0.40	4	30	0.010	6160	55	246
M 3	2.40	0.50	4	30	0.010	3980	32	159
M 4	3.20	0.70	4	30	0.015	2985	36	179
M 5	4.00	0.80	4	30	0.020	2385	38	191
M 6	4.80	1.00	4	30	0.025	1990	40	199
M 8	5.95	1.25	4	30	0.030	1605	49	193
M 10	7.80	1.50	4	30	0.035	1225	38	172
M 12	9.00	1.75	4	30	0.040	1060	43	170
M 16	11.80	2.00	5	30	0.045	810	48	182

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 2	1.55	0.40	4	150	0.020	30805	554	2464
M 3	2.40	0.50	4	150	0.030	19895	477	2387
M 4	3.20	0.70	4	150	0.035	14920	418	2089
M 5	4.00	0.80	4	150	0.040	11935	382	1910
M 6	4.80	1.00	4	150	0.045	9945	358	1790
M 8	5.95	1.25	4	150	0.050	8025	411	1605
M 10	7.80	1.50	4	150	0.055	6120	296	1346
M 12	9.00	1.75	4	150	0.065	5305	345	1379
M 16	11.80	2.00	5	150	0.075	4045	398	1517

Cast iron
GG(G)

M 2	1.55	0.40	4	120	0.010	24645	222	986
M 3	2.40	0.50	4	120	0.020	15915	255	1273
M 4	3.20	0.70	4	120	0.025	11935	239	1194
M 5	4.00	0.80	4	120	0.030	9550	229	1146
M 6	4.80	1.00	4	120	0.035	7960	223	1114
M 8	5.95	1.25	4	120	0.040	6420	263	1027
M 10	7.80	1.50	4	120	0.050	4895	215	979
M 12	9.00	1.75	4	120	0.060	4245	255	1019
M 16	11.80	2.00	5	120	0.070	3235	297	1132

Unalloyed copper

M 2	1.55	0.40	4	130	0.010	26695	240	1068
M 3	2.40	0.50	4	130	0.020	17240	276	1379
M 4	3.20	0.70	4	130	0.025	12930	259	1293
M 5	4.00	0.80	4	130	0.030	10345	248	1241
M 6	4.80	1.00	4	130	0.035	8620	241	1207
M 8	5.95	1.25	4	130	0.040	6955	285	1113
M 10	7.80	1.50	4	130	0.045	5305	210	955
M 12	9.00	1.75	4	130	0.055	4600	253	1012
M 16	11.80	2.00	5	130	0.060	3505	276	1052

Titanium alloys
> 300 HB
[Ti6Al4V]

M 2	1.55	0.40	4	40	0.010	8215	74	329
M 3	2.40	0.50	4	40	0.010	5305	42	212
M 4	3.20	0.70	4	40	0.015	3980	48	239
M 5	4.00	0.80	4	40	0.020	3185	51	255
M 6	4.80	1.00	4	40	0.025	2655	53	266
M 8	5.95	1.25	4	40	0.030	2140	66	257
M 10	7.80	1.50	4	40	0.035	1630	50	228
M 12	9.00	1.75	4	40	0.040	1415	57	226
M 16	11.80	2.00	5	40	0.045	1080	64	243