

# THREAD MILL

For material  
P, M, K, N, S  
application ( $\leq 35$  HRC)



application ( $\leq 35$  HRC)

For material

# THREAD-MILL



## Solid Carbide M / MF Thread-Mill

VHM Fräser M / MF Thread mill Frese M / MF Thread mill in metallo duro integrale Fraises 2 tailles M / MF en carbure monobloc 整体硬质合金硬质合金螺纹铣刀	EDP	Ø	N° Z	Helix Angle	Thread Length	G6110		RC	Weldon	Page
	H15	6 - 20	4	30°	2XD	•				349
	H17					•				349

## Solid Carbide M / MF Thread-Mill

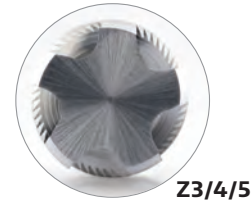
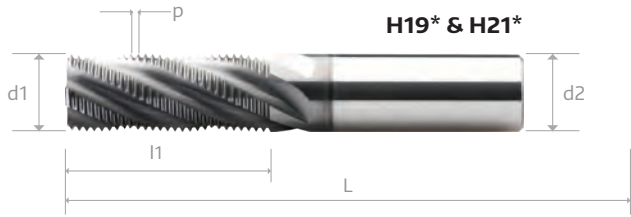
VHM Fräser M / MF Thread mill Frese M / MF Thread mill in metallo duro integrale Fraises 2 tailles M / MF en carbure monobloc 整体硬质合金硬质合金螺纹铣刀	EDP	Ø	N° Z	Helix Angle	Thread Length	G6110		RC	Weldon	Page
	H19	6 - 20	4	30°	2XD	•				348
	H21					•				348

# THREAD MILL

## for ISO Metric Internal Thread without Oil Hole



VHM Fräser M /MF Thread mill 4 Zähne	Fraises 2 tailles M /MF Thread mill - 4 dents en carbure monobloc
Frese M /MF Thread mill in metallo duro integrale 4 taglienti	整体硬质合金 硬质合金螺纹铣刀



THREAD MILL

**M**

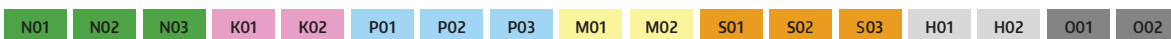
EDP No. / EDV-Nr. / CODE usine / Codice EDP	Dimension ( mm )								H19*
	M	l1	l2	P	d1	L	d2 ( h6 )	Z	G6110
0600	≥M6	13.00		1.00	4.5	57	6	3	•
0800	≥M8	17.50		1.25	6	60	6	3	•
1000	≥M10	21.00		1.50	7.5	75	8	4	•
1200	≥M12	26.25		1.75	9.5	75	10	4	•
1400	≥M14	30.00		2.00	10	83	10	4	•
1600	≥M16	34.00		2.00	12	83	12	4	•

**MF**

EDP No. / EDV-Nr. / CODE usine / Codice EDP	Dimension ( mm )								H21*
	M	l1	l2	P	d1	L	d2 ( h6 )	Z	G6110
0800	≥M8	17.00		1.00	6.0	57	6	3	•
0800 057 06	≥M8	17.25		0.75	6.0	57	6	3	•
1000	≥M10	21.00		1.00	8.0	64	8	4	•
1200	≥M12	25.50		1.50	9.5	72	10	4	•
1200 072	≥M12	26.25		1.25	9.5	72	10	4	•
1200 072 10	≥M12	25.00		1.00	9.5	72	10	4	•
1400	≥M14	30.00		1.50	10.0	83	10	4	•
1400 083 10	≥M14	29.00		1.00	10.0	83	10	4	•
1600	≥M16	34.50		1.50	12.0	83	12	4	•
1600 083 12	≥M16	33.00		1.00	12.0	83	12	4	•
1800	≥M18	37.50		1.50	14.0	90	14	5	•
1800 090 14	≥M18	37.00		1.00	14.0	90	14	5	•
2000	≥M20	42.00		1.50	16.0	92	16	5	•
2000 092 16	≥M20	41.00		1.00	16.0	92	16	5	•

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter



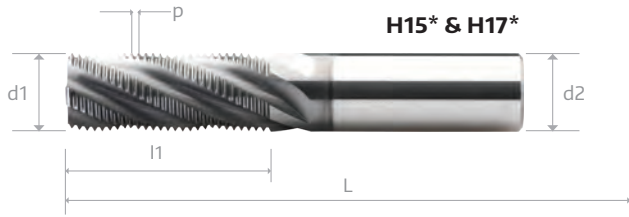
350

# THREAD MILL

## for ISO Metric Internal Thread with Oil Hole



VHM Fräser M /MF Thread mill 4 Zähne	Fraises 2 tailles M /MF Thread mill - 4 dents en carbure monobloc
Frese M /MF Thread mill in metallo duro integrale 4 taglienti	整体硬质合金 硬质合金螺纹铣刀



THREAD MILL

### M

EDP No. / EDV-Nr. / CODE usine / Codice EDP	Dimension (mm)								H15*
	M	l1	l2	P	d1	L	d2 (h6)	Z	G6110
0600	≥M6	13.00		1.00	4.5	57	6	3	•
0800	≥M8	17.50		1.25	6	60	6	3	•
1000	≥M10	21.00		1.50	7.5	75	8	4	•
1200	≥M12	26.25		1.75	9.5	75	10	4	•
1400	≥M14	30.00		2.00	10	83	10	4	•
1600	≥M16	34.00		2.00	12	83	12	4	•

### MF

EDP No. / EDV-Nr. / CODE usine / Codice EDP	Dimension (mm)								H17*
	M	l1	l2	P	d1	L	d2 (h6)	Z	G6110
0800	≥M8	17.00		1.00	6.0	57	6	3	•
0800 057 06	≥M8	17.25		0.75	6.0	57	6	3	•
1000	≥M10	21.00		1.00	8.0	64	8	4	•
1200	≥M12	25.50		1.50	9.5	72	10	4	•
1200 072	≥M12	26.25		1.25	9.5	72	10	4	•
1200 072 10	≥M12	25.00		1.00	9.5	72	10	4	•
1400	≥M14	30.00		1.50	10.0	83	10	4	•
1400 083 10	≥M14	29.00		1.00	10.0	83	10	4	•
1600	≥M16	34.50		1.50	12.0	83	12	4	•
1600 083 12	≥M16	33.00		1.00	12.0	83	12	4	•
1800	≥M18	37.50		1.50	14.0	90	14	5	•
1800 090 14	≥M18	37.00		1.00	14.0	90	14	5	•
2000	≥M20	42.00		1.50	16.0	92	16	5	•
2000 092 16	≥M20	41.00		1.00	16.0	92	16	5	•

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter



350

## For ISO Metric Thread 4 Flutes

Thread Milling	P						M				K			
Working Material	Carbon Steel		Alloy Steel		Prehardened Steel		Stainless Steel				Grey Cast Iron		Ductile Cast Iron	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High machinability		Low machinability		-		-	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
6	100	0.020	90	0.010	90	0.005	60	0.010	55	0.005	100	0.020	100	0.020
8		0.040		0.030		0.025		0.020		0.015		0.040		0.040
10		0.050		0.040		0.035		0.027		0.021		0.050		0.050
12		0.060		0.050		0.045		0.034		0.027		0.060		0.060
14		0.070		0.060		0.055		0.041		0.033		0.070		0.070
16		0.080		0.070		0.065		0.048		0.039		0.080		0.080
18		0.090		0.080		0.075		0.055		0.045		0.090		0.090
20		0.100		0.090		0.085		0.060		0.050		0.100		0.100

Thread Milling	N						S			
Working Material	Wrought Aluminium		Cast Aluminium		Copper Alloy		Titanium Alloy		Nickel Alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
6	200	0.030	200	0.030	200	0.030	40	0.010	35	0.010
8		0.050		0.050		0.050		0.020		0.020
10		0.058		0.058		0.058		0.027		0.027
12		0.066		0.066		0.066		0.034		0.034
14		0.074		0.074		0.074		0.041		0.041
16		0.082		0.082		0.082		0.048		0.048
18		0.090		0.090		0.090		0.055		0.055
20		0.100		0.100		0.100		0.060		0.060



Recommended Cutting Data

Note: These recommended cutting conditions indicate just references. It should be adjusted due to different cutting conditions.