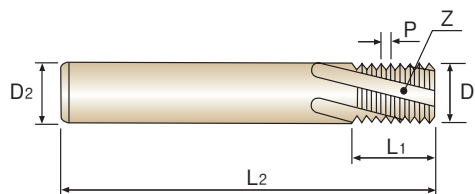


MF Solid Carbide Thread Mill for ISO Metric Internal Thread - DIN 13

VOLLHARTMETALL GEWINDEFÄSER für ISO METRISCH - FEIN INNENGEWINDE - DIN 13

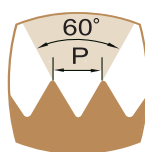
► Easy to cut threads even if exotic materials like Nickel, Titanium or their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



- Material : Solid Carbide
- Shank : DIN6535 HA
- Spiral Angle : 15°
- Thread Length : 1.5 × D

- Material : Vollhartmetall
- Schaft : DIN 6535 HA
- Drallwinkel : 15°
- Gewindelänge : 1.5 × D



Unit : mm

EDP No.	Nominal Diameter [D]	Pitch P	Cutter Diameter D ₁	Shank Diameter D ₂	Thread Length L ₁	Over All Length L ₂	No. of Flute Z
L1212370	M8	1.0	6.0	6	13	57	3
L1212380	M8	0.75	6.0	6	12.75	57	3
L1212440	M10	1.0	8.0	8	16	63	4
L1212510	M12	1.5	9.5	10	19.5	72	4
L1212520	M12	1.25	9.5	10	18.75	72	4
L1212530	M12	1.0	9.5	10	19	72	4
L1212550	M14	1.5	10.0	10	22.5	83	4
L1212570	M14	1.0	10.0	10	22	83	4
L1212610	M16	1.5	12.0	12	25.5	83	4
L1212620	M16	1.0	12.0	12	25	83	4
L1212670	M18	1.5	14.0	14	28.5	92	5
L1212680	M18	1.0	14.0	14	28	92	5
L1212720	M20	1.5	16.0	16	31.5	92	5
L1212730	M20	1.0	16.0	16	31	92	5

* Other coatings are available on your request

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Heat Treated Steels	High Hardened Steel	Cast Iron	Stainless Steels	Titanium Alloy	Chrome-Nickel Alloy	Non Ferrous Materials
◎	◎	◎		◎	○	○	○	◎

RECOMMENDED CUTTING SPEED
EMPFOHLENE SCHNEIDKONDITIONEN

RECOMMENDED CUTTING CONDITION for Thread Mills

unit : mm

Materials	Cutting Speed (m/min)	Feed per Tooth (fz)	
		Cutter Diameter ≤ Ø8.0	Cutter Diameter > Ø8.0
Low Carbon Steels Medium Carbon Steels	80 - 120	0.02 - 0.04	0.04 - 0.10
High Carbon Steels	80 - 120	0.02 - 0.04	0.04 - 0.10
Alloy Steels	80 - 120	0.02 - 0.04	0.04 - 0.10
Heat Treated Steels	60 - 100	0.02 - 0.04	0.04 - 0.10
Stainless Steels	40 - 80	0.01 - 0.02	0.02 - 0.06
Cast Iron	50 - 100	0.02 - 0.04	0.04 - 0.10
Chrome-Nickel Alloys Titanium Alloys	20 - 60	0.01 - 0.02	0.02 - 0.06
Non Ferrous Materials	100 - 300	0.03 - 0.07	0.05 - 0.10

RECOMMENDED CUTTING CONDITION for Drill and Thread Mills

unit : mm

Material	Cutting Speed (m/min)	Fz(Thread Milling) - Feed per tooth		Fdr(Drilling) - Feed per revolution	
		Cutter Diameter ≤ Ø8.0	Cutter Diameter > Ø8.0	Cutter Diameter ≤ Ø8.0	Cutter Diameter > Ø8.0
Cast Iron	80-150	0.03-0.08	0.08-0.12	0.10-0.20	0.20-0.25
Aluminium Aluminium-alloy Magnesium	100-300	0.05-0.10	0.10-0.15	0.10-0.20	0.20-0.30
Plastics	80-150	0.05-0.10	0.10-0.15	0.10-0.20	0.20-0.30

RECOMMENDED CUTTING CONDITION
for Hard Material Miniature Thread Mills

unit : mm

Materials	Cutting Speed (m/min)	Feed(mm/tooth)	
		Cutter Diameter ≤ Ø6.0	Cutter Diameter > Ø6.0
Alloy Steel ≥ HB325	80-120	0.02-0.04	0.04-0.06
Stainless Steel ≥ HB330	40-80	0.02-0.04	0.04-0.06
Cast Iron	50-100	0.03-0.05	0.05-0.07
Chrome-Nickel Alloys Titanium Alloys	20-60	0.02-0.03	0.03-0.05
Hardened Material	45~50HRc	25-70	0.03-0.05
	51~55HRc	25-60	0.02-0.04
	56~62HRc	25-50	0.01-0.03