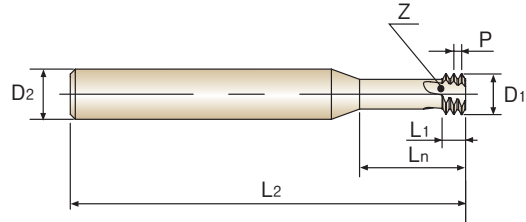


# M Solid Carbide Miniature Thread Mill for ISO Metric Internal Thread - DIN13

## VOLLHARTMETALL MINI-GEWINDEFÄRÄSER für ISO METRISCHE INNENGEWINDE - DIN13

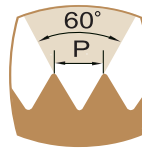
▶ Short thread length

▶ Kurze Gewindelänge



- ▶ Material : Solid Carbide
- ▶ Shank : DIN6535 HA
- ▶ Spiral Angle : 15°
- ▶ Thread Length : 3 × P

- ▶ Material : Vollhartmetall
- ▶ Schaft : DIN 6535 HA
- ▶ Drallwinkel : 15°
- ▶ Gewindelänge : 3 × P



Unit : mm

EDP No.	Nominal Diameter [ D ]	Pitch P	Cutter Diameter D <sub>1</sub>	Shank Diameter D <sub>2</sub>	Thread Length L <sub>1</sub>	Neck Length L <sub>n</sub>	Over All Length L <sub>2</sub>	No. of Flute Z
TiAlN								
<b>L12D1010</b>	M1	0.25	<b>0.70</b>	3	0.75	2.1	30	3
<b>L12D1050</b>	M1.2	0.25	<b>0.90</b>	3	0.75	2.5	30	3
<b>L12D1070</b>	M1.4	0.3	<b>1.04</b>	3	0.90	2.9	30	3
<b>L12D1090</b>	M1.6	0.35	<b>1.18</b>	3	1.05	3.4	30	3
<b>L12D1130</b>	M2	0.4	<b>1.52</b>	6	1.2	4.2	57	3
<b>L12D1150</b>	M2.2	0.45	<b>1.66</b>	6	1.35	4.6	57	3
<b>L12D1170</b>	M2.5	0.45	<b>1.96</b>	6	1.35	5.3	57	3
<b>L12D1200</b>	M3	0.5	<b>2.4</b>	6	1.5	6.3	57	3
<b>L12D1240</b>	M4	0.7	<b>3.16</b>	6	2.1	8.4	57	3
<b>L12D1280</b>	M5	0.8	<b>4.04</b>	6	2.4	10.5	57	3
<b>L12D1310</b>	M6	1.0	<b>4.8</b>	6	3.0	12.6	57	3
<b>L12D1360</b>	M8	1.25	<b>6.5</b>	8	3.75	16.8	63	3
<b>L12D1420</b>	M10	1.5	<b>8.2</b>	10	4.5	21.0	73	3
<b>L12D1500</b>	M12	1.75	<b>9.9</b>	10	5.25	25.2	73	3

\* 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