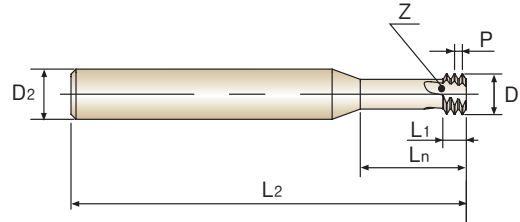


### UNF Solid Carbide Miniature Thread Mill for UNC Internal Thread - ANSI B 1.1 VOLLHARTMETALL MINI-GEWINDEFÄRÄSER für UNC INNENGEWINDE - ANSI B 1.1

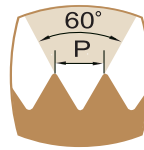
► Short thread length

► Kurze Gewindelänge



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

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



Unit : mm

EDP No.	Nominal Diameter [ D ]	T.P.I	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
L12D3040	#1	64	1.38	6	1.19	3.9	57	3
L12D3080	#2	56	1.64	6	1.36	4.6	57	3
L12D3160	#4	40	2.08	6	1.91	6.0	57	3
L12D3240	#6	32	2.55	6	2.38	7.4	57	3
L12D3280	#8	32	3.21	6	2.38	8.7	57	3
L12D3320	#10	24	3.56	6	3.18	10.1	57	3
L12D3360	#12	24	4.22	6	3.18	11.5	57	3
L12D3400	1/4	20	4.83	6	3.81	13.3	57	3
L12D3440	5/16	18	6.24	8	4.23	16.7	63	3
L12D3480	3/8	16	7.62	8	4.76	20.0	63	3
L12D3520	7/16	14	8.94	10	5.44	23.3	73	3

\* Other coatings are available on your request

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

◎ : Excellent ○ : Good

**RECOMMENDED CUTTING SPEED**  
**EMPFOHLENE SCHNEIDKONDITIONEN**
**RECOMMENDED CUTTING CONDITION for Thread Mills**

unit : mm

Materials	Cutting Speed (m/min)	Feed per Tooth (fz)	
		Cutter Diameter $\leq \varnothing 8.0$	Cutter Diameter $> \varnothing 8.0$
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 $\leq \varnothing 8.0$	Cutter Diameter $> \varnothing 8.0$	Cutter Diameter $\leq \varnothing 8.0$	Cutter Diameter $> \varnothing 8.0$
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 $\leq \varnothing 6.0$	Cutter Diameter $> \varnothing 6.0$
Alloy Steel $\geq \text{HB325}$	80-120	0.02-0.04	0.04-0.06
Stainless Steel $\geq \text{HB330}$	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