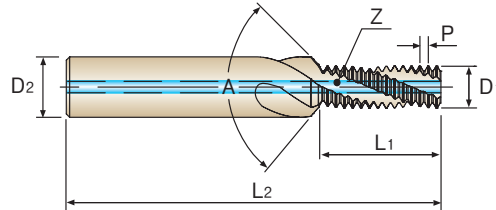


### UNC Solid Carbide Thread Mill with Coolant Hole & Chamfer for UNC Internal Thread - ANSI B 1.1 VOLLHARTMETALL GEWINDEFÄSER mit KÜHLKANAL & FASE für UNC INNENGEWINDE - ANSI B 1.1

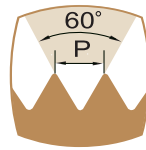
► Easy to cut threads even if exotic materials like Nickel, Titanium or their alloys.

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



- Material : Solid Carbide
- Shank : DIN6535 HA
- Spiral Angle : 15°
- Thread Length : 2 × D

- Material : Vollhartmetall
- Schaft : DIN 6535 HA
- Drallwinkel : 15°
- Gewindelänge : 2 × D



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>	Over All Length L <sub>2</sub>	Angle A	No. of Flute Z
L4273400	1/4"	20	4.8	8	13.3	62	90°	3
L4273440	5/16"	18	6.2	10	16.18	74	90°	3
L4273480	3/8"	16	7.6	12	19.8	80	90°	4
L4273520	7/16"	14	8.9	12	22.62	80	90°	4
L4273560	1/2"	13	10.3	14	26.32	90	90°	4
L4273600	9/16"	12	11.7	16	30.63	100	90°	4
L4273640	5/8"	11	13.1	18	33.41	102	90°	4
L4273700	3/4"	10	16.0	20	39.29	110	90°	5

\* 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