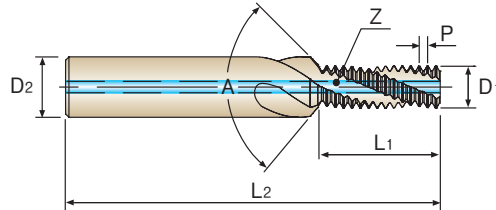


UNF

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

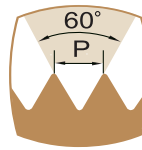
► Easy to cut threads even if exotic materials like Nickel, Titanium or their alloys.

► 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 ₁	Shank Diameter D ₂	Thread Length L ₁	Over All Length L ₂	Angle A	No. of Flute Z
L4274420	1/4"	28	5.1	8	13.21	62	90°	3
L4274460	5/16"	24	6.5	10	16.37	74	90°	3
L4274500	3/8"	24	8.1	12	19.54	80	90°	4
L4274540	7/16"	20	9.4	12	22.19	80	90°	4
L4274580	1/2"	20	11.0	14	26	90	90°	4
L4274620	9/16"	18	12.4	16	28.88	100	90°	4
L4274660	5/8"	18	14.0	18	33.12	102	90°	5
L4274720	3/4"	16	17.0	20	38.86	110	90°	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