THREAD MILLS

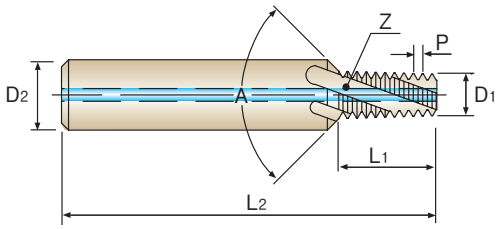
L4276 SERIES

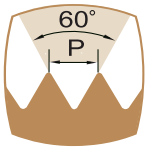
NPT Solid Carbide Thread Mill with Coolant Hole & Chamfer for NPT Thread - ANSI B 1.20.1

VOLLHARTMETALL GEWINDEFRÄSER mit KÜHLKANAL & FASE für NPT INNENGEWINDE - ANSI B 1.20.1

▶ 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 : 9×P

▶ Material : Vollhartmetall
▶ Schaft : DIN 6535 HA
▶ Drallwinkel : 15°
▶ Gewindeläge : 9×P

Unit : mm

EDP No.	Nominal Diameter [D]	T.P.I	Cutter Diameter	Shank Diameter	Thread Length	Over All Length	Angle	No. of Flute
TiAlN			D_1	D_2	L_1	L_2	A	Z
L4276020	NPT1/16"	27	5.9	10	8.9	64	90°	3
L4276200	NPT1/8"	27	7.8	12	8.9	70	90°	4
L4276400	NPT1/4"	18	10.05	16	13.4	81	90°	4
L4276480	NPT3/8"	18	13.45	18	13.4	81	90°	4

* 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
◎	◎	◎		◎	○	○	○	◎

THREAD MILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

RECOMMENED 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	0.05-0.07
	51~55HRc	25-60	0.02-0.04	0.04-0.06
	56~62HRc	25-50	0.01-0.03	0.03-0.05