

HSS

CARBIDE

COMBO
TAPSSPIRAL
FLUTE TAPSSPIRAL
POINT TAPSSTRAIGHT
FLUTE TAPSCOLD
FORMING
TAPS

NUT TAPS

STI TAPS

HAND TAPS

PIPE TAPS

CARBIDE
TAPSTHREAD
MILLSTECHNICAL
DATA

THREAD MILLS

L41A1 SERIES

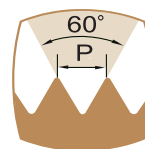
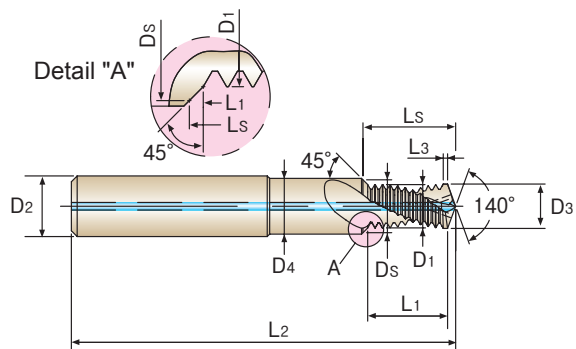
UNCOATED

L42A1 SERIES

TiAIN

M

Solid Carbide Drill and Thread Mill with Chamfer for ISO Metric Internal Thread - DIN 13
VOLLHARTMETALL BOHRGEWINDEFÄRÄSER MIT SENKFASE für ISO METRISCHE INNENGEWINDE - DIN 13



- Material : Solid Carbide
- Shank : DIN6535 HA
- Thread Length : $2 \times D$
- No. of Flute : 2
- 140° Drill Point, 90° Countersink
- Drilling, Chamfering and Thread milling

- Material : Vollhartmetall
- Schaft : DIN 6535 HA
- Gewindelänge : $2 \times D$
- Anz. der Nuten : 2
- 140° Spitzenwinkel, 90° Senkwinkel
- Bohren, Senken und Gewindefräsen

Unit : mm

EDP No.		Nominal Diameter [D]	Pitch P	Cutter Diameter D1	Shank Diameter D2	Effect. Diameter Ds	Drill Diameter D3	Max. C'sink D4	Thread Length L1	Effect. Length Ls	Drill Length L3	Over All Length L2
UNCOATED	TiAIN											
L41A1310	L42A1310	M6	1.0	4.75	8	6.3	5.00	6.6	13.00	14.68	1.00	62
L41A1360	L42A1360	M8	1.25	6.35	10	8.3	6.75	9.0	16.27	18.48	1.25	74
L41A1420	L42A1420	M10	1.5	7.95	12	10.3	8.50	11.0	21.05	23.77	1.50	79
L41A1500	L42A1500	M12	1.75	9.95	14	12.3	10.25	13.5	24.21	27.25	1.50	89
L41A1540	L42A1540	M14	2.0	11.20	16	14.3	12.00	15.5	29.58	33.32	1.50	102

* 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 CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

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	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