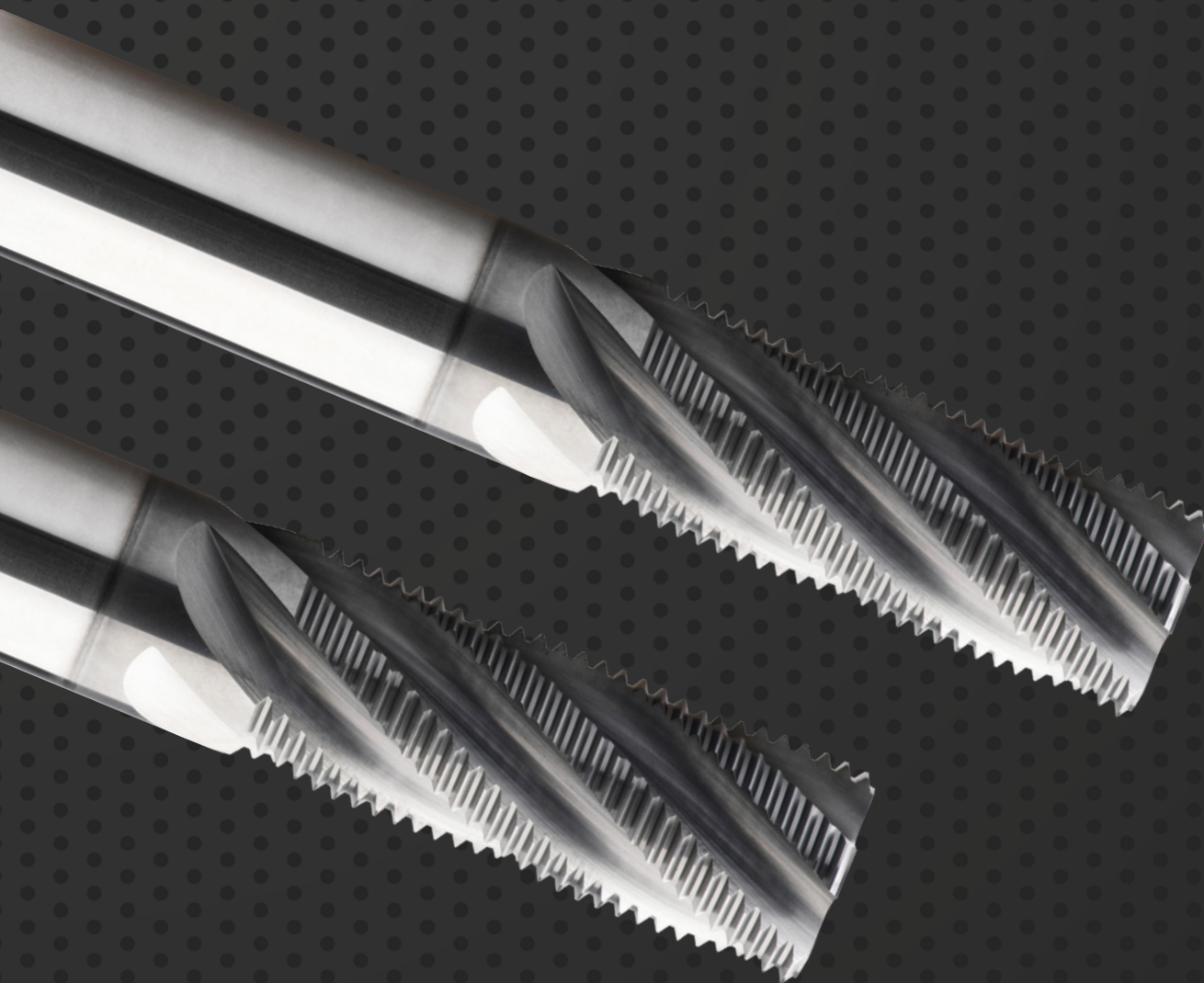




ENDMILLS

THREAD MILL

For material P, M, K, N, S application (≤ 35 HRC)

Index - Thread Mill, For ≤ 35 HRC

 Suitable for Material Groups
  Adapté pour les matériaux
  适用于材料
 Geeignet für die Materialgruppen
  Adatto per il materiale

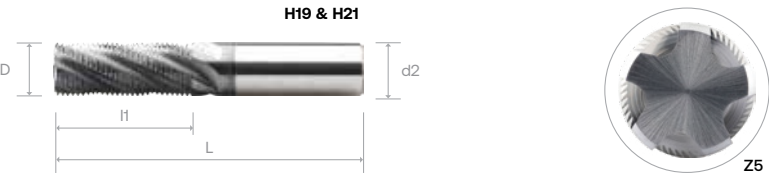
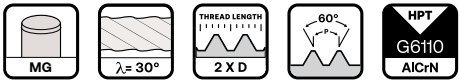
P	M	K
N	S	

EDP Number	Type	No. Z	Helix Angle	Coating	Performance	Page Number
H19 	Thread Mill M, Without Internal Oil Hole	3/4/5	30°	G6110	G	353
H21 	Thread Mill MF, Without Internal Oil Hole	3/4/5	30°	G6110	G	353
H15 	Thread Mill M, With Internal Oil Hole	3/4/5	30°	G6110	G	354
H17 	Thread Mill MF, With Internal Oil Hole	3/4/5	30°	G6110	G	354

G - General P - Performance

THREAD MILL M/MF ENDMILLS WITHOUT INTERNAL OIL HOLE, 3/4/5 FLUTES

- VHM Fräser M /MF Thread mill 3/4/5 Zähne
- Frese M /MF Thread mill in metallo duro integrale 3/4/5 taglienti
- Fraises M /MF Thread mill - 3/4/5 dents
- 整体硬质合金 M/MF 系列 密齿立铣刀3/4/5刃-标准长度



Order Number	Dimension (mm)								G6110
	M	I 1	I 2	P	d1	L	d2 (h6)	Z	
H19 0600	≥M6	13.00		1.00	4.5	57	6	3	°
H19 0800	≥M8	17.50		1.25	6	60	6	3	°
H19 1000	≥M10	21.00		1.50	7.5	75	8	4	°
H19 1200	≥M12	26.25		1.75	9.5	75	10	4	°
H19 1400	≥M14	30.00		2.00	10	83	10	4	°
H19 1600	≥M16	34.00		2.00	12	83	12	4	°

Order Number	Dimension (mm)								G6110
	M	I 1	I 2	P	d1	L	d2 (h6)	Z	
H21 0800	≥M8	17.00		1.00	6.0	57	6	3	°
H21 0800 057 06		17.25		0.75	6.0	57	6	3	°
H21 1000	≥M10	21.00		1.00	8.0	64	8	4	°
H21 1200	≥M12	25.50		1.50	9.5	72	10	4	°
H21 1200 072		26.25		1.25	9.5	72	10	4	°
H21 1200 072 10		25.00		1.00	9.5	72	10	4	°
H21 1400	≥M14	30.00		1.50	10.0	83	10	4	°
H21 1400 083 10		29.00		1.00	10.0	83	10	4	°
H21 1600	≥M16	34.50		1.50	12.0	83	12	4	°
H21 1600 083 12		33.00		1.00	12.0	83	12	4	°
H21 1800	≥M18	37.50		1.50	14.0	90	14	5	°
H21 1800 090 14		37.00		1.00	14.0	90	14	5	°
H21 2000	≥M20	42.00		1.50	16.0	92	16	5	°
H21 2000 092 16		41.00		1.00	16.0	92	16	5	°

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter

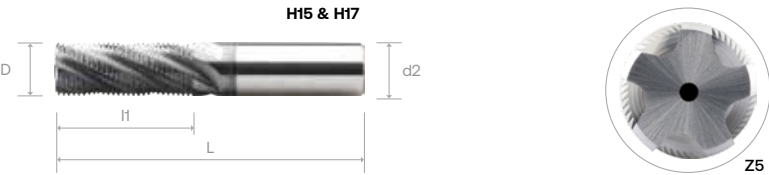
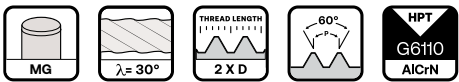
N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02	355
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H15 / H17



THREAD MILL M/MF ENDMILLS WITH INTERNAL OIL HOLE, 3/4/5 FLUTES

- VHM Fräser M /MF Thread mill 3/4/5 Zähne
- Frese M /MF Thread mill in metallo duro integrale 3/4/5 taglienti
- Fraises M /MF Thread mill - 3/4/5 dents
- 整体硬质合金 M/MF 系列 密齿立铣刀3/4/5刃-标准长度



Order Number	Dimension (mm)								G6f10
	M	I 1	I 2	P	d1	L	d2 (h6)	Z	
H15 0600	≥M6	13.00		1.00	4.5	57	6	3	◦
H15 0800	≥M8	17.50		1.25	6	60	6	3	◦
H15 1000	≥M10	21.00		1.50	7.5	75	8	4	◦
H15 1200	≥M12	26.25		1.75	9.5	75	10	4	◦
H15 1400	≥M14	30.00		2.00	10	83	10	4	◦
H15 1600	≥M16	34.00		2.00	12	83	12	4	◦

Order Number	Dimension (mm)								G6f10
	M	I 1	I 2	P	d1	L	d2 (h6)	Z	
H17 0800	≥M8	17.00		1.00	6.0	57	6	3	◦
H17 0800 057 06		17.25		0.75	6.0	57	6	3	◦
H17 1000	≥M10	21.00		1.00	8.0	64	8	4	◦
H17 1200	≥M12	25.50		1.50	9.5	72	10	4	◦
H17 1200 072		26.25		1.25	9.5	72	10	4	◦
H17 1200 072 10		25.00		1.00	9.5	72	10	4	◦
H17 1400	≥M14	30.00		1.50	10.0	83	10	4	◦
H17 1400 083 10		29.00		1.00	10.0	83	10	4	◦
H17 1600	≥M16	34.50		1.50	12.0	83	12	4	◦
H17 1600 083 12		33.00		1.00	12.0	83	12	4	◦
H17 1800	≥M18	37.50		1.50	14.0	90	14	5	◦
H17 1800 090 14		37.00		1.00	14.0	90	14	5	◦
H17 2000	≥M20	42.00		1.50	16.0	92	16	5	◦
H17 2000 092 16		41.00		1.00	16.0	92	16	5	◦

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

N01N02N03K01K02P01P02P03M01M02S01S02S03H01H02O01O02

355

ALU LINE
EZ LINE -
ENDMILL
SE 30
NITCo 30
OPTIMUM
SE 45
SE 45X
NITCo 45
SE 60
SE 60X
DM70 -
SE 70
SE GR
TE 45
PLUNGE
-MILL
THREAD
MILL

Recommended Cutting Data



Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



Thread Mill Endmills, 3 Flute - H15, H17, H19, H21

Thread Milling	N						K				S			
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Grey Cast Iron		Ductile Cast Iron		Titanium alloy		Nickel Alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-		-	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
6	120	0.010	200	0.020	120	0.010	120	0.010	90	0.010	50	0.010	40	0.010
8		0.015		0.030		0.015		0.018		0.018		0.014		0.014

Thread Mill Endmills, 3 Flute - H15, H17, H19, H21

Thread Milling	P						M			
Working Material	Carbon steel		Alloy steel		Prehardened steel		Stainless steel		Stainless steel	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
6	120	0.010	100	0.010	90	0.010	80	0.010	60	0.008
8		0.018		0.018		0.018		0.018		0.015

Thread Mill Endmills, 4 Flute - H15, H17, H19, H21

Thread Milling	N						K				S			
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Grey Cast Iron		Ductile Cast Iron		Titanium alloy		Nickel Alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-		-	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
10	120	0.020	200	0.040	120	0.020	120	0.026	90	0.026	50	0.012	40	0.013
12		0.025		0.050		0.025		0.034		0.034		0.015		0.016
14		0.030		0.060		0.030		0.042		0.042		0.018		0.018
16		0.035		0.070		0.035		0.050		0.050		0.021		0.021

Thread Mill Endmills, 4 Flute - H15, H17, H19, H21

Thread Milling	P						M			
Working Material	Carbon steel		Alloy steel		Prehardened steel		Stainless steel		Stainless steel	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
10	120	0.026	100	0.026	90	0.026	80	0.026	60	0.020
12		0.034		0.034		0.034		0.034		0.030
14		0.042		0.042		0.042		0.042		0.035
16		0.050		0.050		0.050		0.050		0.040

Thread Mill Endmills, 5 Flute - H15, H17, H19, H21

Thread Milling	N						K				S			
Working Material	Wrought Aluminium		Cast Aluminium		Copper alloy		Grey Cast Iron		Ductile Cast Iron		Titanium alloy		Nickel Alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-		-	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
18	120	0.035	200	0.070	120	0.035	120	0.050	90	0.050	50	0.021	40	0.021
20		0.040		0.080		0.040		0.055		0.055		0.025		0.025

Thread Mill Endmills, 5 Flute - H15, H17, H19, H21

Thread Milling	P						M			
Working Material	Carbon steel		Alloy steel		Prehardened steel		Stainless steel		Stainless steel	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability	
D	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz	Vc	Fz
18	120	0.050	100	0.050	90	0.050	80	0.050	60	0.040
20		0.055		0.055		0.058		0.055		0.045