



PRODUCT DESCRIPTION

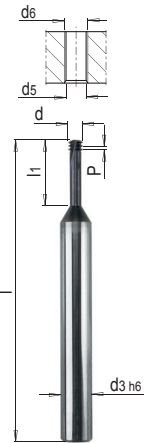
» For ISO metric threads in hardened steel

MATERIAL

» Carbide, TiAlN coated



Z	d3	d5	l	l1	d	P	d6	No.	EUR
4	6	2.6	58	9.5	2.35	0.5	M 3	WZG 17151/ 3	< >
4	6	3.4	58	12.5	3.1	0.7	M 4	WZG 17151/ 4	< >
4	6	4.3	58	16	3.8	0.8	M 5	WZG 17151/ 5	< >
4	6	5.1	58	20	4.8	1	M 6	WZG 17151/ 6	< >
4	6	6.9	58	24	5.95	1.25	M 8	WZG 17151/ 8	< >
4	8	8.6	61	23	7.8	1.5	M10	WZG 17151/10	< >
5	10	10.3	73	26	9	1.75	M12	WZG 17151/12	< >



i Information on thread milling from page PL

REFERENCE VALUES FOR THREAD MILLING

WZG 17151	Material	Strength	Vc ¹ m/min.	Feed per tooth [fz] in mm, depending on the cutter's Ø (conventional milling)									
				3	4	5	6	7	8	9	10	12	14
				f ² (mm/z)									
	1.2083	52 HRC	50	0.025	0.030	0.030	0.030	0.035	0.035	0.040	0.040	0.045	0.045
	1.2162	52 HRC	50	0.025	0.030	0.030	0.030	0.035	0.035	0.040	0.040	0.045	0.045
	1.2343	52 HRC	50	0.025	0.030	0.030	0.030	0.035	0.035	0.040	0.040	0.045	0.045
	1.2379	60 HRC	45	0.020	0.025	0.025	0.025	0.030	0.030	0.035	0.035	0.040	0.040
	1.2714HH	43 HRC	55	0.030	0.030	0.035	0.040	0.040	0.045	0.050	0.055	0.060	0.060
	1.2767	52 HRC	50	0.025	0.030	0.030	0.030	0.035	0.035	0.040	0.040	0.045	0.045
	1.2842	60 HRC	45	0.020	0.025	0.025	0.025	0.030	0.030	0.035	0.035	0.040	0.040
Steel	1400 N/mm ²	60	0.030	0.030	0.035	0.040	0.040	0.045	0.050	0.055	0.060	0.060	

1) Vc: cutting speed (m/min.)

2) f: feed per cut (mm per tooth)

- » In principle, conventional milling (up-cut milling) is recommended.
- » If the material's hardness is greater than 40 HRC [1300N/mm²], 2 runs are recommended (2/3 - 1/3, radial).
- » Use peripheral cooling.

i You can find further materials and cutting values in the cutting data calculator.