



### PRODUCT DESCRIPTION

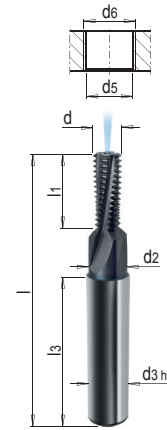
» For ISO metric threads with inner coolant supply

### MATERIAL

» Carbide, TiCN coated



Z	d2	d3	d5	l	l1	l3	d	P	d6	No.	EUR
3	3.4	6	2.5	48	6.8	36	2.3	0.5	M 3	WZG 17123/ 3	< >
3	4.5	6	3.3	48	8.8	36	3	0.7	M 4	WZG 17123/ 4	< >
3	5.5	6	4.2	54	10.8	36	4	0.8	M 5	WZG 17123/ 5	< >
3	6.6	8	5	62	13.5	36	4.8	1	M 6	WZG 17123/ 6	< >
3	9	10	6.8	74	18.1	40	6.4	1.25	M 8	WZG 17123/ 8	< >
4	11	12	8.5	80	21.8	45	7.95	1.5	M10	WZG 17123/10	< >
4	13.5	14	10.2	90	25.4	45	9.95	1.75	M12	WZG 17123/12	< >
4	15.5	16	12	102	31	48	11.2	2	M14	WZG 17123/14	< >
4	17.5	18	14	102	35	48	12.8	2	M16	WZG 17123/16	< >
4	21.5	20	17.5	125	41.3	50	14.5	2.5	M20	WZG 17123/20	< >



**i** Information on thread milling from page PL

### REFERENCE VALUES FOR THREAD MILLING

WZG 17123 WZG 17223	Material	Strength	Vc <sup>1</sup> m/min.	d										
				d6										
				M 3	M 4	M 5	M 6	M 8	M 10	M 12	M 14	M 16	M 20	
				f (mm/z)										
1.1730	640 N/mm <sup>2</sup>	80	0.020	0.025	0.030	0.035	0.040	0.050	0.060	0.070	0.080	0.090		
1.2083	780 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2083	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045		
1.2085	1080 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2162	660 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2162	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045		
1.2311	1080 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2312	1080 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2316	1010 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2343	780 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2343	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045		
1.2379	780 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2714HH	1350 N/mm <sup>2</sup>	40	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2767	830 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
1.2767	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045		
1.2842	775 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080		
Steel	1400 N/mm <sup>2</sup>	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045		

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

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

» 52 HRC: The thread has to be machined in 3 equal sized infeeds.

» Use external coolant for through-hole threads.

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