



PRODUCT DESCRIPTION

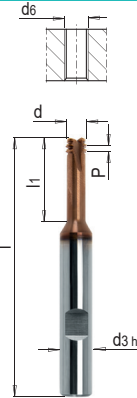
- » For BSP threads in hardened steel
- » Core hole and thread in one work step

MATERIAL

- » Carbide, TiSiN coated

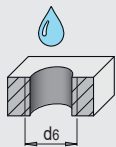


Z	d3	l	l1	d	d6	P	No.	EUR
4	8	64	24	6.1	G 1/16" G 1/8"	28	WZG 175518/28G	< >
4	12	90	40	10.3	G 1/4" G 3/8"	19	WZG 175518/19G	< >



REFERENCE VALUES FOR THREAD MILLING

WZG 175518	Material	Strength	Vc ¹ m/min.	d	
				6.1	10.3
				f (mm/z)	
	1.2083	780 N/mm ²	70	0.030	0.044
	1.2083	52 HRC	40	0.025	0.040
	1.2343	780 N/mm ²	80	0.030	0.044
	1.2343	52 HRC	40	0.025	0.040
	1.2379	60 HRC	30	0.022	0.036
	1.2714HH	1350 N/mm ²	50	0.025	0.040
	1.3343	64 HRC	30	0.022	0.036
	1.3344 PM	64 HRC	30	0.022	0.036
	M W10 PM	65 HRC	30	0.022	0.036
	1.2767	830 N/mm ²	80	0.030	0.044
	1.2767	52 HRC	40	0.025	0.040
	1.2842	60 HRC	30	0.022	0.036



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

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

- » The tool must be used in an anti-clockwise direction
- » Use with air cooling from 55 HRC

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