

# THREADING TOOLS

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THREADING  
TOOLS



## Thread milling cutters with chamfer

Type	Thread depth		Tool material	Surface	Standard	Diameter range	Catalog no.	Discount group	Standard range, page
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### Thread milling cutters for metric ISO threads



TMC SP	2xD		Solid Carbide	bright	Stock std.	M 3 - M20	<b>73810</b>	108	530
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TMC SP	2xD		Solid Carbide	TiCN	Stock std.	M 3 - M20	<b>53810</b>	108	530
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### Thread milling cutters for metric ISO fine threads



TMC SP	2xD		Solid Carbide	bright	Stock std.	M 4 X0,5 - M16 X1,5	<b>73820</b>	108	531
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TMC SP	2xD		Solid Carbide	TiCN	Stock std.	M 4 X0,5 - M16 X1,5	<b>53820</b>	108	531
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## Thread milling cutters without chamfer

Type	Thread depth		Tool material	Surface	Standard	Diameter range	Catalog no.	Discount group	Standard range, page
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## Thread milling cutters for metric ISO threads



TM SP	2xD		Solid Carbide	bright	Stock std.	M 6 - M20 X1,5	<b>73830</b>	108	532
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TM SP	2xD		Solid Carbide	TICN	Stock std.	M 6 - M20 X1,5	<b>53830</b>	108	532
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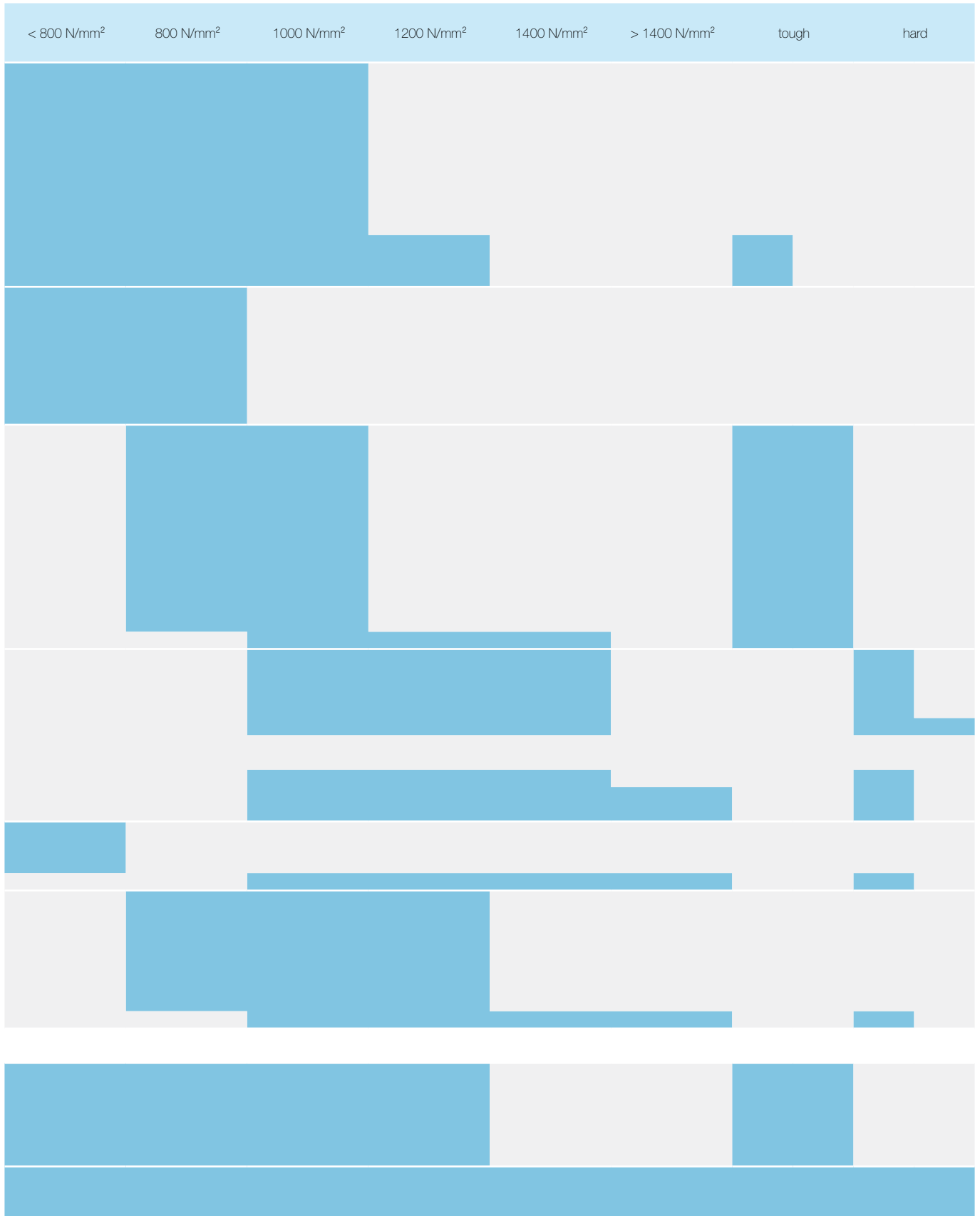
# Application

by materials

Coloured ring	Catalog no.		Nonferrous metals, Aluminium	Steels	GG, GGG	Stainless and acid resistant steels	Nickel, Titanium alloys	Harded steels
	Produktiv	Intensiv						
Green	73033	73046						
	73038	73048						
	73183	73187						
	73308	73322						
	73309	73323						
	73310	73324						
	73321	73325						
	63033	63046						
Green Synchro	53053	53050						
	53054	53051						
	53055	53052						
		63048						
Yellow	73133	73146						
	73132	73145						
	73138	73148						
	73250	73173						
	73293	73286						
	63133	63146						
	63138	63148						
	63250	63173						
Blue	73176	73660						
	73177	73659						
	73178	73180						
	73297	73304						
	73298	73305						
	73299	73306						
	73300	73288						
	63176	73662						
	63177	73665						
	73641	63662						
	73643	53662						
	53641	53665						
53667	53666							
Red	73642	53661						
	73645	73619						
	73646	73661						
	53642	73664						
	73640	73666						
	63641	63010						
	63643							
	53640							
53670	53670							
53669	53668							
Black	73131	73156						
	73189	73136						
	73011	73011						
	53670	53670						
White	73201	73201						
	73211	73211						
	73194	73194						
	73326	73326						
	73327	73327						
	73345	73345						
	63201	63201						
	53670	53670						
for blind and trough holes								
Thread Forming Taps	73121	63122						
	63121	53620						
	63123	53621						
	73120	53622						
	63120	63013						
	63119							
Thread Milling Cutters	73810	53820						
	73820	73830						
	53810	53830						

optimal well suited

by tensile strength



# Application recommendations for thread milling cutters



Hole type

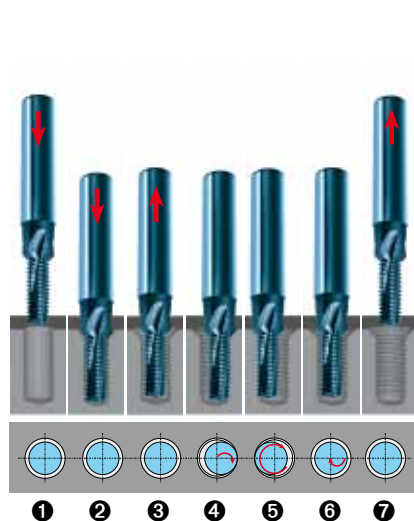


Material examples

for universal application:  
 structural steels, free-cutting steels,  
 case hardened steels, heat-treatable steels,  
 tool steels, high speed steels,  
 sulphured, austenitic and martensitic steels, special alloys  
 Al and Al-alloys,  
 cast materials, non-ferrous metals,  
 plastics, magnesium-alloys, Titanium

Tool material	Solid carbide		Solid carbide	
Type	TMC SP		TM SP	
Form	-	-	-	-
Surface finish	bright	TiCN	bright	TiCN
$v_c$ m/min	100 - 300 (Ti: 40-60)	50 - 200	100 - 300 (Ti: 40-60)	50 - 200

Thread type	Dimensions to DIN 2184-1	Tolerance zone	Catalog no./Ø-range			
			<b>M</b>	<b>Stock std.</b>	<b>2,0 x D</b>	73810 M3 - M20
<b>MF</b>	<b>Stock std.</b>	<b>2,0 x D</b>	73820 M4x0,5 - M16x1,5	53820 M4x0,5 - M16x1,5		



## Thread milling cutters with chamfer

### Thread milling cutters for metric ISO threads

#### Catalog no. 73810



Thread milling cutter with 45° chamfer, spiral flute and internal coolant (axial). Suitable for thread milling of through- and blind holes upto 2xD in Al-alloys, cast and cast iron, brass, Mg-alloys, Titan and Duroplastics as well as Thermoplastics.

#### Stock std.

Tool material	Solid Carbide
Surface	bright
Type	TMC SP
Form	
Cutting direction	right-hand
Tolerance on Ø	
Flutes	

### Thread milling cutters for metric ISO threads

#### Catalog no. 53810

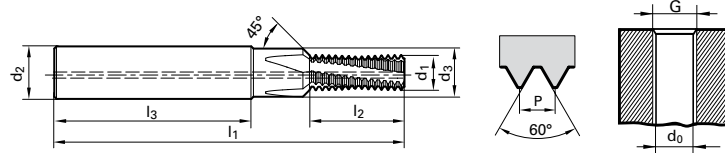


Thread milling cutter with 45° chamfer, spiral flute and internal coolant (axial).

Suitable for thread milling of through- and blind holes upto 2xD in steel and special alloys. High wear resistance thanks to TiCN coating.

#### Stock std.

Tool material	Solid Carbide
Surface	TiCN
Type	TMC SP
Form	
Cutting direction	right-hand
Tolerance on Ø	
Flutes	



Catalog no.	73810	53810
Tool material	Solid Carbide	
Carbide grade	K	K/P
Discount group	108	108
Surface	bright	TiCN
Type	TMC SP	TMC SP
Drilling depth	2xD	2xD
Cooling	axial >=M4	axial >=M4

G	P	d1	d2	d3	d0	l1	l2	l3	Z	Code no.	price per piece	
	mm	mm	mm	mm	mm	mm	mm	mm				
M 3	0.50	2.300	6.000	3.400	2.500	48.00	6.75	36.00	3	3.000	●	●
M 4	0.70	3.000	6.000	4.500	3.300	48.00	8.75	36.00	3	4.000	●	●
M 5	0.80	3.800	6.000	5.500	4.200	54.00	10.80	36.00	3	5.000	●	●
M 6	1.00	4.500	8.000	6.600	5.000	62.00	13.50	36.00	3	6.000	●	●
M 8	1.25	5.950	10.000	9.000	6.800	74.00	18.13	40.00	3	8.000	●	●
M10	1.50	7.950	12.000	11.000	8.500	80.00	21.75	45.00	4	10.000	●	●
M12	1.75	9.950	14.000	13.500	10.200	90.00	25.38	45.00	4	12.000	●	●
M14	2.00	10.800	16.000	15.500	12.000	102.00	31.00	48.00	4	14.000	●	●
M16	2.00	12.800	18.000	17.500	14.000	102.00	35.00	48.00	4	16.000	●	●
M20	2.50	13.950	20.000	21.500	17.500	125.00	41.25	50.00	4	20.000	●	●

## Thread milling cutters with chamfer

### Thread milling cutters for metric ISO fine threads

#### Catalog no. 73820



Thread milling cutter with 45° chamfer, spiral flute and internal coolant (axial). Suitable for thread milling of through- and blind holes upto 2xD in Al-alloys, cast and cast iron, brass, Mg-alloys, Titan and Duroplastics as well as Thermoplastics.

### Stock std.

Tool material	Solid Carbide
Surface	bright
Type	TMC SP
Form	
Cutting direction	right-hand
Tolerance on Ø	
Flutes	

### Thread milling cutters for metric ISO fine threads

#### Catalog no. 53820

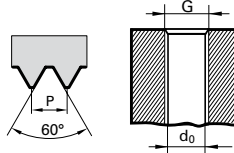
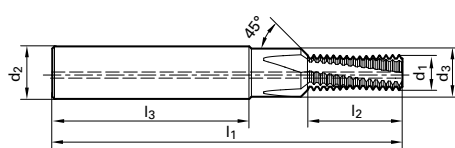


Thread milling cutter with 45° chamfer, spiral flute and internal coolant (axial).

Suitable for thread milling of through- and blind holes upto 2xD in steel and special alloys. High wear resistance thanks to TiCN coating.

### Stock std.

Tool material	Solid Carbide
Surface	TiCN
Type	TMC SP
Form	
Cutting direction	right-hand
Tolerance on Ø	
Flutes	



Catalog no.	73820	53820
Tool material	Solid Carbide	
Carbide grade	K	K/P
Discount group	108	108
Surface	bright	TiCN
Type	TMC SP	TMC SP
Drilling depth	2xD	2xD
Cooling	axial	axial

G	d1	d2	d3	d0	l1	l2	l3	Z	Code no.	price per piece	
mm	mm	mm	mm	mm	mm	mm	mm				
M 4 X0,5	3.000	6.000	4.500	3.500	48.00	8.75	36.00	3	4.003	●	●
M 5 X0,5	3.800	6.000	5.500	4.500	54.00	10.75	36.00	3	5.003	●	●
M 6 X0,5	4.500	8.000	6.600	5.500	62.00	12.75	36.00	3	6.003	●	●
M 6 X0,75	4.500	8.000	6.600	5.250	62.00	13.13	36.00	3	6.004	●	●
M 8 X0,75	5.950	10.000	9.000	7.250	74.00	16.88	40.00	3	8.004	●	●
M 8 X1	5.950	10.000	9.000	7.000	74.00	17.50	40.00	3	8.005	●	●
M10 X1	7.950	12.000	11.000	9.000	80.00	21.50	45.00	4	10.005	●	●
M10 X1,25	7.950	12.000	11.000	8.800	80.00	21.88	45.00	4	10.006	●	●
M12 X1	9.950	14.000	13.500	11.000	90.00	25.50	45.00	4	12.005	●	●
M12 X1,5	9.950	14.000	13.500	10.500	90.00	26.25	45.00	4	12.007	●	●
M14 X1,5	10.800	16.000	15.500	12.500	102.00	30.75	48.00	4	14.007	●	●
M16 X1,5	12.800	18.000	17.500	14.500	102.00	33.75	48.00	4	16.007	●	●



## Thread milling cutters without chamfer

### Thread milling cutters for metric ISO threads

#### Catalog no. 73830



Thread milling cutter without chamfer, with spiral flute and internal coolant (axial). Suitable for thread milling of through- and blind holes up to 2xD in Al-alloys, cast and cast iron, brass, Mg-alloys, Titan and Duroplastics as well as Thermoplastics.

#### Stock std.

Tool material	Solid Carbide
Surface	bright
Type	TM SP
Form	
Cutting direction	right-hand
Tolerance on Ø	
Flutes	

### Thread milling cutters for metric ISO threads

#### Catalog no. 53830

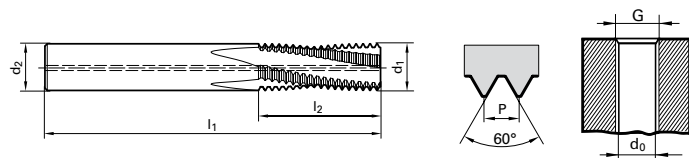


Thread milling cutter without chamfer, with spiral flute and internal coolant (axial).

Suitable for thread milling of through- and blind holes up to 2xD in steel and special alloys. High wear resistance thanks to TiCN coating.

#### Stock std.

Tool material	Solid Carbide
Surface	TiCN
Type	TM SP
Form	
Cutting direction	right-hand
Tolerance on Ø	
Flutes	



Catalog no.	73830	53830
Tool material	Solid Carbide	
Carbide grade	K	K/P
Discount group	108	108
Surface	bright	TiCN
Type	TM SP	TM SP
Drilling depth	2xD	2xD
Cooling	axial	axial

G	P	d1	d2	d0	l1	l2	Z	Code no.	price per piece	
	mm	mm	mm	mm	mm	mm				
M 6	1.00	4.800	6.000	5.000	54.00	13.50	3	6.000	●	●
M 8	1.25	6.400	8.000	6.800	62.00	18.10	3	8.000	●	●
M 8 X1	1.00	6.400	8.000	7.000	62.00	14.50	3	8.005	●	●
M10	1.50	7.950	10.000	8.500	74.00	21.80	3	10.000	●	●
M10 X1	1.00	7.950	10.000	9.000	74.00	14.50	3	10.005	●	●
M10 X1,25	1.25	7.950	10.000	8.800	74.00	18.10	3	10.006	●	●
M12	1.75	9.950	10.000	10.200	74.00	25.40	4	12.000	●	●
M14	2.00	11.200	12.000	12.000	80.00	31.00	4	14.000	●	●
M14 X1,50	1.50	11.200	12.000	12.500	80.00	23.30	4	14.007	●	●
M16	2.00	12.800	14.000	14.000	90.00	35.00	4	16.000	●	●
M16 X1,50	1.50	12.800	14.000	14.500	90.00	26.30	4	16.007	●	●
M20	2.50	14.950	16.000	17.500	102.00	41.30	4	20.000	●	●
M20 X1,50	1.50	14.950	16.000	18.500	102.00	24.80	4	20.007	●	●