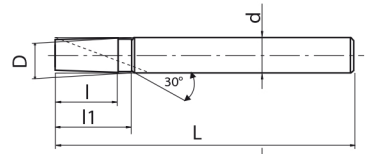


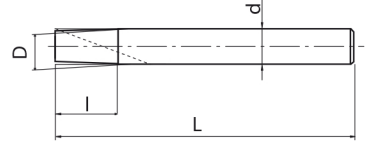
0.39002XX



Type 1



Type 2



- Carbide thread milling cutter
- WX coating
- For all materials
- "ThreadPro" NC code generator software available

P ○ C < 0,2%	P ○ 0,25 < C < 0,4	P ○ C > 0,45%	P ○ SCM	M ○ INOX	K ○ GG	K ○ GGG	N ○ Al	N ○ AC, ADC	S ● Ti	S ● Ni	H ○ 25-35 HRC	H ○ 35-45 HRC	m/min
50-75	50-75	40-70	15-30	20-40	50-100	50-65	50-70	65-130	20-60	20-60	15-30	15-30	

Rc (PT)
 CARBIDE
 WX
 30°
 h6

EDP	D	Minimum cutting bore Ø	P	L	l	l1	d	Z	Type
3900201	7,5	1/8	28	60	9,1	12,7	8	3	1
3900211	10	1/4~3/8	19	75	14,7	-	10	4	2
3900214	12	1/2~3/4	14	85	20	-	12	4	2
3900218	20	1~2	11	95	27,7	-	20	5	2

Work Material	Vc (m/min)	F (mm/tooth)
Low Tensile Strength Steel	C~0,25%	0,01~0,11
Medium Tensile Strength Steel	C~0,25% ~ 0,45%	0,01~0,11
High Tensile Strength Steel	C0,45%~	0,01~0,01
Alloy Steel	SCM	0,01~0,03
Hardened Steel	25~45 HRC	0,01~0,03
	45~55 HRC	-
	50~60 HRC	-
Stainless Steel	SUS	0,01~0,06
Tool Steel	SKD	-
Cast Steel	SC	0,02~0,09
Cast Iron	FC	0,03~0,1
Ductile Cast Iron	FCD	0,03~0,1
Copper	Cu	0,03~0,1
Brass	Bs	0,03~0,1
Brass Casting	BsC	0,03~0,1
Bronze	PB	0,03~0,1
Aluminium Rolled Steel	AL	0,03~0,1
Aluminium Alloy Casting	AC, ADC	0,03~0,1
Magnesium Alloy Casting	MC	0,03~0,1
Zinc Alloy Casting	ZDC	0,03~0,1
Titanium Alloys	Ti-6AL-4V	0,02~0,06
Nickel Alloys	Inconel®	0,01~0,03
Thermosetting plastic	-	0,03~0,13
Thermoplastic	-	0,03~0,13