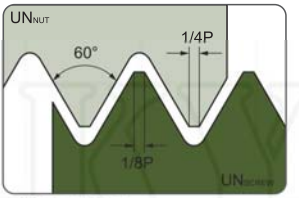
THREAD MILLING

ISO METRIC Internal Miniature Tools

Designation	Thread Size	Pitch mm	L	L1	D1	D2	N° of Flutes	Catalog Nr.
TMC03012L5 0.35 ISO	M1.6x0.35	0.35	39	5.1	3	1.20	3	TH400001
TMC06015L6 0.4 ISO	M2.0x0.4	0.40	39	6.1	3	1.54	3	TH400019
TMC06019L7 0.45 ISO	M2.5x0.45	0.45	39	7.6	4	1.96	3	TH400016
TMC06024L9 0. 5 ISO	M3.0x0.5	0.50	51	9.3	4	2.40	3	TH400013
TMC06031L12 0.7 ISO	M4.0x0.7	0.70	51	12.4	6	3.15	3	TH400004
TMC06040L15 0.8 ISO	M5.0x0.8	0.80	57	15.6	6	4.00	3	TH400010
TMC06047L19 1.0 ISO	M6.0x1.0	1.00	57	19.0	6	4.75	3	TH400007
TMC06059L24 1.25 ISO	M8.0x1.25	1.25	57	24.3	6	5.95	3	TH400022
TMC08079L31 1.5 ISO	M10x1.5	1.50	63	31.0	8	7.90	3	TH400025

Thread Length - Up to 3D

D = Nominal Thread size



ISO 965-1:1999-11
DIN 13: 2005-08

UN Internal Miniature Tools

Designation	Coarse UNC	Fine UNF	Pitch TPI	L	L1	D1	D2	N° of Flutes	Catalog Nr.
TMC03011L3 80UN	-	0-80UNF	80	39	3.9	3	1.18	3	TH400052
TMC03014L5 72UN	-	1-72UNF	72	39	5.8	3	1.44	3	TH400040
TMC03016L6 56UN	2-56UNC	3-56UNF	56	39	6.8	3	1.66	3	TH400034
TMC06021L8 40UN	4-40UNC	-	40	51	8.1	6	2.12	3	TH400028
TMC06024L9 40UN	5-40UNC	6-40UNF	40	51	9.8	6	2.46	3	TH400055
TMC06025L10 32UN	6-32UNC	-	32	51	10.7	6	2.57	3	TH400031
TMC06032L12 32UN	8-32UNC	10-32UNF	32	57	12.7	6	3.22	3	TH400037
TMC06052L19 28 UN	-	1/4-28UNF	28	57	19.3	6	5.20	3	TH400043
TMC08066L24 24 UN	-	5/16-24UNF	24	63	24.2	8	6.65	3	TH400049
TMC06048L19 20UN	1/4-20UNC	7/16-20UNF	20	57	19.4	6	4.85	3	TH400046

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Material Group		Gr. N°	VDI Group	Material Exemples	Hardness	V_c [m/min] min	V_c [m/min] max
Steel	Non Alloyed	1	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	80	130
			2		190 HB	70	110
			3		250 HB	60	100
	Low Alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	70	110
			4,6		230 HB	70	110
			5,7		280 HB	60	100
			8		350 HB	50	80
	High Alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	70	110
			10		280 HB	60	100
			11		320 HB	50	80
			11		350 HB	50	70
Stainless Steel	Austenitic	4	14	304, 316, X5CrNi18-9	180 HB	70	110
			14		240 HB	60	90
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	60	80
			14		310 HB	60	80
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	70	90
			13		42 HRc	60	80
Cast Iron	Grey	7	15	GG20, GG40, EN-GJL-250, No30B	150 HB	60	110
			15		200 HB	70	110
			16		250 HB	60	90
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	60	110
			17,19		200 HB	60	90
			18,20		250 HB	60	90
High Temp. Alloys	Fe, Ni & Co Based	9	31,32	Incoloy 800	240 HB	40	60
			33	Inconel 700	250 HB	30	50
			34	Stellite 21	350 HB	20	40
	Ti Based	10	36	TiAl6V4	-	40	70
			37	T40	-	25	50
Hardened Mat.	Steel	11	38	X100CrMo13, 440C, G-X260NiCr42	45 HRc	30	50
			38		50 HRc	25	50
			38		55 HRc	25	40
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	25	40
	White Cast Iron		41	G-X300CrMo15	55 HRc	25	40
NF	Al (>8%Si)	12	25	AlSi12	130 HB	80	300

Feed (mm/tooth) per cutting dia				
1.5-3.0	3.0-5.0	5.0-7.0	7.0-9.0	9.0-11
0.030	0.040	0.060	0.070	0.090
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.050	0.050
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.060	0.060
0.020	0.030	0.050	0.060	0.060
0.020	0.030	0.050	0.050	0.050
0.020	0.020	0.030	0.040	0.050
0.020	0.020	0.020	0.030	0.040
0.020	0.020	0.020	0.030	0.040
0.015	0.020	0.020	0.030	0.040
0.020	0.020	0.020	0.030	0.040
0.015	0.020	0.020	0.030	0.030
0.020	0.030	0.060	0.070	0.080
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.060	0.070	0.080
0.020	0.030	0.050	0.060	0.070
0.020	0.030	0.050	0.060	0.070
0.020	0.020	0.020	0.030	0.040
0.015	0.015	0.015	0.020	0.020
0.010	0.010	0.010	0.015	0.015
0.020	0.020	0.020	0.020	0.025
0.020	0.020	0.020	0.020	0.020
0.010	0.010	0.020	0.020	0.020
0.010	0.010	0.020	0.020	0.020
0.010	0.010	0.020	0.020	0.020
0.010	0.010	0.020	0.020	0.020
0.010	0.010	0.020	0.020	0.020
0.030	0.030	0.040	0.080	0.120