



Thread milling without pre-drilled hole

WH-EM-PNC

Volume 1

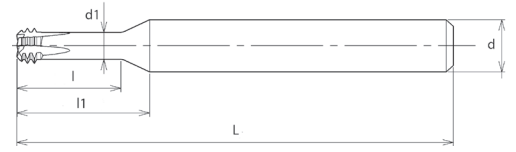


FEATURES: WH-EM-PNC



WH-EM-PNC NEW

Threading | Thread milling | Metric



- Thread milling without pre-drilled hole
- WXS coating
- Left-hand (spindle rotation left)
- Direction of tool feed: right
- 4 flutes, strong & negative rake angle

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 ● 25-45 HRC	H ● 45-55 HRC	
40-100	40-100	40-100	40-100	40-100	40-120	40-100	40-100	40-160	40-80	40-80	40-100	30-80	m/min
0,01~0,03	0,01~0,03	0,01~0,03	0,01~0,03	0,01~0,03	0,01~0,1	0,01~0,05	0,01~0,05	0,01~0,1	0,01~0,03	0,01~0,03	0,01~0,03	0,01~0,03	mm/t



EDP	M	P	L	EDP	l	l1	d1	d	Z	Price
T1606081	3	0,5	50		7,5	12,3	1,70	6	4	
T1606082	4	0,7	50		9,9	14,2	2,18	6	4	
T1606083	5	0,8	50		12	15,5	2,97	6	4	
T1606084	6	1	50		14,5	17,5	3,36	6	4	
T1606085	8	1,25	70		19,2	24,1	4,66	10	4	
T1606086	10	1,5	70		23,7	27,7	5,78	10	4	
T1606087	12	1,75	80		28,4	31,4	6,92	10	4	

CUTTING DATA

Tool	WH-EM-PNC M4
Work Material	1.2379 (Cold work tool steel) 60HRC
Cutting speed	30 m/min (3.082 min ⁻¹)
Feed	123 mm/min (0.01 mm/t)
Depth of cut	8 mm
Coolant	Airblow
Machine	Exeron HSC600
Interface	HSK-40
Holder	Shrink holder
Hole type	Blind hole

Tool	WH-EM-PNC M4
Work Material	1.6582 (Alloy engineering steel) 1400-1550 N/mm ²
Cutting speed	50 m/min (5.137 min ⁻¹)
Feed	205 mm/min (0.01 mm/t)
Depth of cut	9 mm
Coolant	Airblow
Machine	Hermle C32U
Interface	HSK63-A
Holder	Hydraulic chuck
Hole type	Blind hole

Tool	WH-EM-PNC M4
Work Material	Vanadis (Cold work steel) 64HRC
Cutting speed	30 m/min (3.082 min ⁻¹)
Feed	123 mm/min (0.01 mm/t)
Depth of cut	8 mm
Coolant	Airblow
Machine	n.a.
Interface	n.a.
Holder	Shrink holder
Hole type	Blind hole



shaping your dreams

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