THREAD MILLS

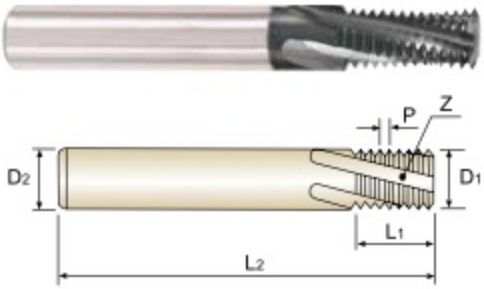
L1212 SERIES

MF

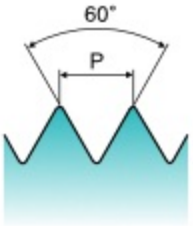
Solid Carbide Thread Mill for ISO Metric Internal Thread - DIN 13

VOLLHARTMETALL GEWINDEFRÄSER für ISO METRISCH - FEIN INNENGEWINDE - DIN 13
FRAISES A FILETER CARBURE MONOBLOC POUR FILETAGE ISO INTER MÉTRIQUE - DIN13
Filettature interne, ISO metriche, passo grosso - DIN 13

- Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.
- Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
1.5×D



Material groups **MU** | CARBIDE | DIN 6535HA | 60° | R15 | TiAIN | p.B52

Recommended ToolHolder	FlatShank	Page	PlainShank	Page
	ENDMILLHOLDER	D117-137	HYDRAULICCHUCK SHRINKFITHOLDER	D15-46 D47-72
	POWERMILLINGCHUCK			D161-176
	ERICOLLETCHUCK SKSLIMCHUCK			D73-115 D183-201

Unit : mm

EDP No.	Nominal Diameter [D]	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flute
TiAlN		P	D1	D2	L1	L2	Z
L1212370	M8	1.0	**6.0**	6	13	57	3
L1212380	M8	0.75	**6.0**	6	12.75	57	3
L1212440	M10	1.0	**8.0**	8	16	63	4
L1212510	M12	1.5	**9.5**	10	19.5	72	4
L1212520	M12	1.25	**9.5**	10	18.75	72	4
L1212530	M12	1.0	**9.5**	10	19	72	4
L1212550	M14	1.5	**10.0**	10	22.5	83	4
L1212570	M14	1.0	**10.0**	10	22	83	4
L1212610	M16	1.5	**12.0**	12	25.5	83	4
L1212620	M16	1.0	**12.0**	12	25	83	4
L1212670	M18	1.5	**14.0**	14	28.5	92	5
L1212680	M18	1.0	**14.0**	14	28	92	5
L1212720	M20	1.5	**16.0**	16	31.5	92	5
L1212730	M20	1.0	**16.0**	16	31	92	5

* Other coatings are available on your request

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
Recommendad	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎

ISO	N										S							H		
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommendad	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○				