



PRODUCT DESCRIPTION

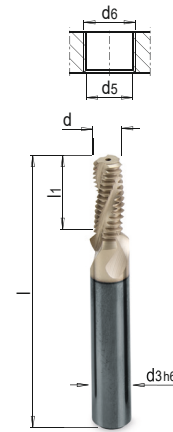
- » For ISO metric threads with inner coolant supply
- » With inner coolant supply from M 4

MATERIAL

» Carbide, TiAlZrN-coated

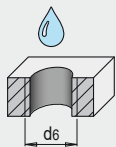


Z	d3	d5	l	l1	d	P	d6	No.	EUR
3	4	2.5	40	6.8	2.3	0.5	M 3	WZG 17143/ 3	<>
3	6	3.3	48	8.8	3	0.7	M 4	WZG 17143/ 4	<>
3	6	4.2	54	10.8	4	0.8	M 5	WZG 17143/ 5	<>
3	6	5	54	13.5	4.8	1	M 6	WZG 17143/ 6	<>
3	8	6.8	62	18.1	6.4	1.25	M 8	WZG 17143/ 8	<>
3	8	7	62	17.5	6.4	1	MF 8x1	WZG 17143/ 8 x 1	<>
3	10	8.5	74	21.8	7.95	1.5	M 10	WZG 17143/ 10	<>
3	10	9	74	21.5	7.95	1	MF 10x1	WZG 17143/10 x 1	<>
3	10	8.8	74	21.9	7.95	1.25	MF 10x1,25	WZG 17143/10 x 1,25	<>
4	10	10.2	74	25.4	9.95	1.75	M 12	WZG 17143/12	<>
4	10	10.5	74	26.3	9.95	1.5	MF 12x1,5	WZG 17143/12 x 1,5	<>
4	14	14	90	35	12.8	2	M 16	WZG 17143/16	<>
4	14	14.5	90	33.8	12.8	1.5	MF 16x1,5	WZG 17143/16 x 1,5	<>



REFERENCE VALUES FOR THREAD MILLING

WZG 17143	Material	Strength	Vc m/min.	d								
				M 3	M 4	M 5	M 6	M 8	M 10	M 12	M 14	M 16
				f (mm/z)								
1.1730	640 N/mm ²	90	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2083	780 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2083	52 HRC	50	0.015	0.020	0.025	0.030	0.035	0.045	0.050	0.060	0.065	
1.2085	1080 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2162	660 N/mm ²	80	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2162	52 HRC	50	0.015	0.020	0.025	0.030	0.035	0.045	0.050	0.060	0.065	
1.2311	1080 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2312	1080 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2316	1010 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2343	780 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2343	52 HRC	50	0.015	0.020	0.025	0.030	0.035	0.045	0.050	0.060	0.065	
1.2379	780 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2714 HH	1350 N/mm ²	50	0.015	0.020	0.025	0.030	0.035	0.045	0.050	0.060	0.065	
1.2767	830 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
1.2767	52 HRC	50	0.015	0.020	0.025	0.030	0.035	0.045	0.050	0.060	0.065	
1.2842	775 N/mm ²	70	0.020	0.025	0.035	0.040	0.050	0.055	0.055	0.060	0.065	
Steel	1400 N/mm ²	50	0.015	0.020	0.025	0.030	0.035	0.045	0.050	0.060	0.065	
1.4301	660 N/mm ²	60	0.020	0.025	0.030	0.030	0.040	0.050	0.050	0.055	0.055	
1.4305	620 N/mm ²	60	0.020	0.025	0.030	0.030	0.040	0.050	0.050	0.055	0.055	
1.4571	600 N/mm ²	60	0.020	0.025	0.030	0.030	0.040	0.050	0.050	0.055	0.055	
3.3547	270 N/mm ²	250	0.035	0.045	0.045	0.050	0.065	0.075	0.080	0.090	0.105	
3.4365	520 N/mm ²	250	0.035	0.045	0.045	0.050	0.065	0.075	0.080	0.090	0.105	



1) Vc: cutting speed (m/min.)

2) f: feed per cut (mm per tooth)

- » In principle, conventional milling (up-cut milling) is recommended.
- » From >40 HRC (1300 N/mm²) it is advisable to mill in 2 passes (2/3-1/3 in ø)
- » Use internal cooling (blind hole)

i Further materials and cutting values can be found in the cutting data calculator.