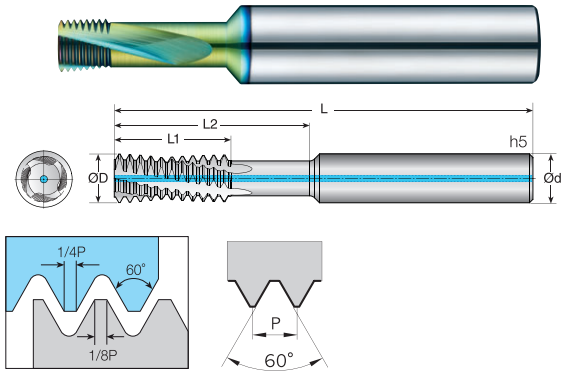


4HTM

4 Flutes Helix Thread Mill for Generality



- Thread Mill for hardened and pre-hardened steel (~Hrc50), alloy steel, carbon steel, cast iron.
- Helical flutes with coolant thru for extra deep threading applications.
- Multi-tooth geometry.
- Maximum thread length : 3xD2 (thread diameter)
- Reduced machining times for long threads.
- We do not recommend using a ER Chuck.



4HTM

Cutting Condition

Material	Alloy Steel/ Tool Steel		Hardened Steels		Aluminum		Stainless Steel	
	V/C	FZ	V/C	FZ	V/C	FZ	V/C	FZ
Hardness	~ 30HRC		35 ~ 45HRC					
TAP								
M3	50 ~ 70	0.01 ~ 0.02	50 ~ 60	0.005 ~ 0.008	100 ~ 130	0.03 ~ 0.04	70 ~ 85	0.01 ~ 0.02
M4	50 ~ 70	0.01 ~ 0.02	50 ~ 60	0.005 ~ 0.008	100 ~ 130	0.03 ~ 0.04	70 ~ 85	0.01 ~ 0.02
M5	50 ~ 70	0.01 ~ 0.02	50 ~ 60	0.01 ~ 0.02	100 ~ 130	0.03 ~ 0.04	70 ~ 85	0.01 ~ 0.02
M6	50 ~ 70	0.01 ~ 0.02	50 ~ 60	0.01 ~ 0.02	100 ~ 130	0.04 ~ 0.05	70 ~ 85	0.02 ~ 0.03
M8	50 ~ 70	0.02 ~ 0.03	50 ~ 60	0.02 ~ 0.03	100 ~ 130	0.04 ~ 0.05	70 ~ 85	0.02 ~ 0.03
M10	50 ~ 70	0.02 ~ 0.03	50 ~ 60	0.02 ~ 0.03	100 ~ 130	0.05 ~ 0.06	70 ~ 85	0.03 ~ 0.04
M12	50 ~ 70	0.02 ~ 0.03	50 ~ 60	0.02 ~ 0.03	100 ~ 130	0.06 ~ 0.07	70 ~ 85	0.05 ~ 0.06
M16	50 ~ 70	0.03 ~ 0.04	50 ~ 60	0.03 ~ 0.04	100 ~ 130	0.06 ~ 0.07	70 ~ 85	0.05 ~ 0.06

- Using shrink-fit chuck is recommended.
- When the tool approaches the work material, reduce the feed by 30%.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- Internal and external coolants are recommended for milling.