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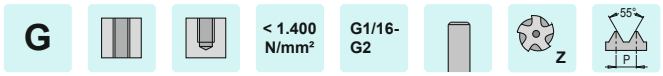
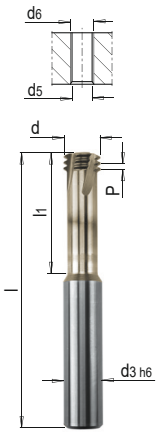
CARBIDE THREAD MILLING CUTTER FOR BSP THREADS — WZG 17531





PRODUCT DESCRIPTION

» For BSP threads

MATERIAL

» Carbide, TiAlZrN-coated

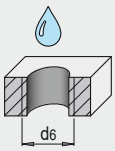
P	M	K	N	S	H
●	●	●	●	●	○

Z	d3	l	l1	d	d5	d6	Threads/inch	No.	EUR
4	8	64	19.5	6.2	6.8 8.8	G 1/16″ G 1/8″	**28**	WZG 17531/28G	<>
4	10	73	25	9.95	11.8 15.25	G 1/4″ G 3/8″	**19**	WZG 17531/19G	<>
4	12	84	37	11.95	19 21 24.5 28.25	G 1/2″ G 5/8″ G 3/4″ G 7/8″	**14**	WZG 17531/14G	<>
5	16	105	44	15.95	30.75 35.5 39.5 45.25 51 57	G 1″ G 1 1/8″ G 1 1/4″ G 1 1/2″ G 1 3/4″ G 2″	**11**	WZG 17531/11G	<>

Information on thread milling from page PL

REFERENCE VALUES FOR THREAD MILLING

WZG 17131
WZG 17531



Material	Strength	Vc[1] m/min.	Feed per tooth [fz] in mm, depending on the cutter´s ø (conventional milling)										
			2	3	4	5	6	7	8	9	10	12	14
			f[2] (mm/z)										
1.1730	640 N/mm²	80	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
1.2083	780 N/mm²	80	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
1.2085	1080 N/mm²	70	0.011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
1.2162	660 N/mm²	80	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
1.2311	1080 N/mm²	70	0.011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
1.2312	1080 N/mm²	70	0.011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
1.2316	1010 N/mm²	70	0.011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
1.2343	780 N/mm²	80	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
1.2379	780 N/mm²	80	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
1.2714HH	1350 N/mm²	60	0.019	0.025	0.025	0.030	0.035	0.035	0.040	0.045	0.050	0.050	0.055
1.2767	830 N/mm²	80	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
1.2842	775 N/mm²	80	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
Steel	1400 N/mm²	60	0.019	0.025	0.025	0.030	0.035	0.035	0.040	0.045	0.050	0.050	0.055

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 external cooling

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

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