



### PRODUCT DESCRIPTION

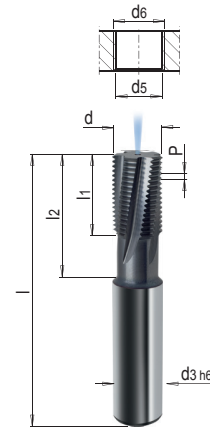
» For ISO metric threads with inner coolant supply

### MATERIAL

» Carbide, TiCN coated



d6	d5	Z	d3	l	l1	l2	d	P	No.	EUR
≥14	d6-P	4	10	70	16	25	9.95	1	WZG 17223/10x1	< >
≥14	d6-P	4	10	70	16	25	9.95	1.5	WZG 17223/10x1,5	< >
≥18	d6-P	4	12	80	20	31	11.95	1	WZG 17223/12x1	< >
≥18	d6-P	4	12	80	20	31	11.95	1.5	WZG 17223/12x1,5	< >
≥24	d6-P	5	16	90	25	40	15.95	1.5	WZG 17223/16x1,5	< >
≥24	d6-P	5	16	90	25	40	15.95	2	WZG 17223/16x2	< >
≥30	d6-P	5	20	105	33	50	19.95	1	WZG 17223/20x1	< >
≥30	d6-P	5	20	105	33	50	19.95	1.5	WZG 17223/20x1,5	< >
≥30	d6-P	5	20	105	33	50	19.95	2	WZG 17223/20x2	< >
≥30	d6-P	5	20	105	33	50	19.95	3	WZG 17223/20x3	< >
≥30	d6-P	5	20	105	33	50	19.95	3.5	WZG 17223/20x3,5	< >



**i** Information on thread milling from page PL

### REFERENCE VALUES FOR THREAD MILLING

WZG 17123 WZG 17223	Material	Strength	Vc <sup>1</sup> m/min.	d									
				d6									
				M 3	M 4	M 5	M 6	M 8	M 10	M 12	M 14	M 16	M 20
				f <sup>2</sup> (mm/z)									
1.1730	640 N/mm <sup>2</sup>	80	0.020	0.025	0.030	0.035	0.040	0.050	0.060	0.070	0.080	0.090	
1.2083	780 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2083	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045	
1.2085	1080 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2162	660 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2162	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045	
1.2311	1080 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2312	1080 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2316	1010 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2343	780 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2343	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045	
1.2379	780 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2714HH	1350 N/mm <sup>2</sup>	40	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2767	830 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
1.2767	52 HRC	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045	
1.2842	775 N/mm <sup>2</sup>	70	0.012	0.016	0.020	0.024	0.032	0.034	0.038	0.050	0.070	0.080	
Steel	1400 N/mm <sup>2</sup>	40	0.010	0.015	0.020	0.020	0.020	0.025	0.030	0.035	0.040	0.045	

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

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

» 52 HRC: The thread has to be machined in 3 equal sized infeeds.

» Use external coolant for through-hole threads.

**i** You can find further materials and cutting values in the cutting data calculator.