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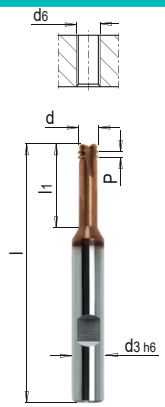
CARBIDE THREAD MILLING CUTTER FOR BSP THREADS, HARD MACHINING — WZG 175518

G | < 67 HRC | 4 | L | 55° P



PRODUCT DESCRIPTION

» For BSP threads in hardened steel
» Core hole and thread in one work step

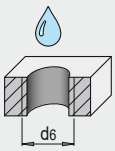
MATERIAL

» Carbide, TiAlSiN coated

P ● M ● K ● N ● S ●

Z	d3	l	l1	d	d6	P	No.	EUR
4	8	64	24	6.1	G 1/16″ G 1/8″	-	WZG 175518/28G	<>
4	12	90	40	10.3	G 1/4″ G 3/8″	-	WZG 175518/19G	<>

REFERENCE VALUES FOR THREAD MILLING



WZG 175518	Material	Strength	Vc[1] m/min.	d	
				6.1	10.3
				f[2] (mm/z)	
	1.2083	780 N/mm²	70	0.030	0.044
	1.2083	52 HRC	40	0.025	0.040
	1.2343	780 N/mm²	80	0.030	0.044
	1.2343	52 HRC	40	0.025	0.040
	1.2379	60 HRC	30	0.022	0.036
	1.2714HH	1350 N/mm²	50	0.025	0.040
	1.3343	64 HRC	30	0.022	0.036
	1.3344 PM	64 HRC	30	0.022	0.036
	M W10 PM	65 HRC	30	0.022	0.036
	1.2767	830 N/mm²	80	0.030	0.044
	1.2767	52 HRC	40	0.025	0.040
	1.2842	60 HRC	30	0.022	0.036

1) Vc: cutting speed (m/min.) 2) f: feed per cut (mm per tooth)

» The tool must be used in an anti-clockwise direction
» Use with air cooling from 55 HRC
i Further materials and cutting values can be found in the cutting data calculator.

Meusburger Georg GmbH & Co KG | Kesselstr. 42 | 6960 Wolfurt | Austria
T +43 5574 6706-0 | sales@meusburger.com | www.meusburger.com