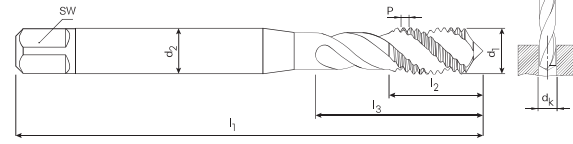


Metric Helix



Teknik Çizim / Technical Drawing:



Cutting Speed _{m/min}	P.1	P.2	P.3	P.4	P.5	P.6	P.7	M.1	M.2	N.1	N.2
Bright F.	10-15	10-15	10-12	-	-	-	-	-	-	-	8-16
TiN	15-23	11-17	11-17	8-10	8-10	-	-	-	-	-	8-16
TiCN	18-25	15-20	15-20	9-12	9-12	6-8	6-8	3-7	3-7	20-28	10-20
Mayura	-	-	-	-	-	-	-	-	-	20-28	20-28
Cutting Speed _{m/min}	N.3	N.4	N.5	N.6	N.7	N.8	N.9	N.10	K.1	K.2	K.3
Bright F.	-	-	-	-	-	-	-	-	-	-	-
TiN	8-16	8-16	8-16	8-16	8-16	8-16	8-16	8-16	-	-	-
TiCN	10-20	10-20	10-20	10-20	10-20	10-20	10-20	10-20	9-17	9-17	9-17
Mayura	20-28	20-28	20-28	20-28	20-28	20-28	20-28	20-28	-	-	-

Sunulan değerler referans niteliğindedir; en uygun ayarlar, kullanıcının işleme koşullarına göre belirlenmelidir.

The provided values are for reference; the most suitable settings should be determined according to the user's machining conditions.

Article No	Tolerance	Coating	Form
74703204	4HX		C
74713204	4HX		C
74733204	4HX		C
74773204	4HX		C

Article No	Tolerance	Coating	Form
74703205	6CX		C
74713205	6CX		C
74733205	6CX		C
74773205	6CX		C

Article No	Tolerance	Coating	Form
74703208	6HX		C
74713208	6HX		C
74733208	6HX		C
74773208	6HX		C

Article No	Tolerance	Coating	Form
74703209	7GX		C
74713209	7GX		C
74733209	7GX		C
74773209	7GX		C

Article No	Tolerance	Coating	Form
74703217	7G		C
74713217	7G		C
74733217	7G		C
74773217	7G		C

Article No	Tolerance	Coating	Form
74703219	ISO2 4H		C
74713219	ISO2 4H		C
74733219	ISO2 4H		C
74773219	ISO2 4H		C

Article No	Tolerance	Coating	Form
74703220	ISO2 5G		C
74713220	ISO2 5G		C
74733220	ISO2 5G		C
74773220	ISO2 5G		C

Article No	Tolerance	Coating	Form
74703218	ISO2 4H		C
74713218	ISO2 4H		C
74733218	ISO2 4H		C
74773218	ISO2 4H		C

d1 / Çap	Thread Pitch (P) Diş Adımı (P)	Diameter Threading Core (DK) Ön Delik Çapı (DK)	Square Width (SW) Kare Geniřlięi (SW)	Diameter Shank (D2) řaft Çapı (d2)	Full Length (L1) Tam Uzunluk (L1)	Length Threading (L2) Diş Uzunluęu (L2)	Flute Length (L3) Kanal Uzunluęu (L3)	Standard Standart
M03	0,50 mm	2,50 mm	2,70 mm	3,50 mm	56,00 mm	6,00 mm	14,00 mm	DIN 371
M04	0,70 mm	3,30 mm	3,40 mm	4,50 mm	63,00 mm	7,50 mm	17,00 mm	DIN 371
M05	0,80 mm	4,20 mm	4,90 mm	6,00 mm	70,00 mm	8,50 mm	21,00 mm	DIN 371
M06	1,00 mm	5,00 mm	4,90 mm	6,00 mm	80,00 mm	11,00 mm	26,00 mm	DIN 371
M08	1,25 mm	6,80 mm	6,20 mm	8,00 mm	90,00 mm	14,00 mm	31,00 mm	DIN 371
M10	1,50 mm	8,50 mm	8,00 mm	10,00 mm	100,00 mm	16,00 mm	35,00 mm	DIN 371
M12	1,75 mm	10,20 mm	7,00 mm	9,00 mm	110,00 mm	18,50 mm	45,00 mm	DIN 376
M14	2,00 mm	12,00 mm	9,00 mm	11,00 mm	110,00 mm	20,00 mm	49,00 mm	DIN 376
M16	2,00 mm	14,00 mm	9,00 mm	12,00 mm	110,00 mm	20,00 mm	50,00 mm	DIN 376
M18	2,50 mm	15,50 mm	11,00 mm	14,00 mm	125,00 mm	25,00 mm	58,00 mm	DIN 376
M20	2,50 mm	17,50 mm	12,00 mm	16,00 mm	140,00 mm	25,00 mm	58,00 mm	DIN 376
M22	2,50 mm	17,50 mm	12,00 mm	16,00 mm	140,00 mm	25,00 mm	58,00 mm	DIN 376
M24	3,00 mm	21,00 mm	14,50 mm	18,00 mm	160,00 mm	30,00 mm	69,00 mm	DIN 376