

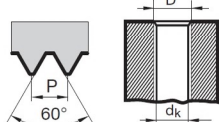
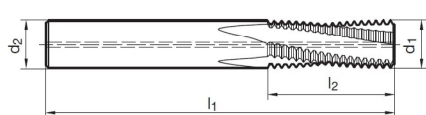


Gewindefräser ohne Senkfase für Metrische ISO-Gewinde



P	•	Schnittwerte siehe Seite 28
M	○	
K	•	
N	•	
S	○	
H	≤55	

Schneidstoff	VHM			
Oberfläche	Ⓢ	Ⓢ	Ⓢ	Ⓢ
Typ	TM SP	TM SP	TM SP	TM SP
Innenkühlung	☒	☒	☒	☒
Schaftform	HA	HB	HA	HB
		NEW		NEW



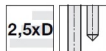
Werkstoff

Artikel-Nr. 3737 3743 4132 4133

D	P	d1	d2	dk	l1	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm		
M 6	1,000	4,800	6,000	5,00	54,000	13,500	3	6,000
M 8	1,250	6,400	8,000	6,80	62,000	18,100	3	8,000
M 8 X1	1,000	6,400	8,000	7,00	62,000	17,500	3	8,005
M10	1,500	7,950	10,000	8,50	74,000	21,800	3	10,000
M10 X1	1,000	7,950	10,000	9,00	74,000	21,500	3	10,005
M10 X1,25	1,250	7,950	10,000	8,80	74,000	21,900	3	10,006
M12	1,750	9,950	10,000	10,20	74,000	25,400	4	12,000
M12 X1,50	1,500	9,950	10,000	10,50	74,000	26,300	4	12,007
M14	2,000	11,200	12,000	12,00	90,000	31,000	4	14,000
M14 X1,5	1,500	11,200	12,000	12,50	90,000	30,800	4	14,007
M16	2,000	12,800	14,000	14,00	90,000	35,000	4	16,000
M16 X1,5	1,500	12,800	14,000	14,50	90,000	33,800	4	16,007
M20	2,500	14,950	16,000	17,50	102,000	41,300	4	20,000
M20 X1,5	1,500	14,950	16,000	18,50	102,000	42,800	4	20,007

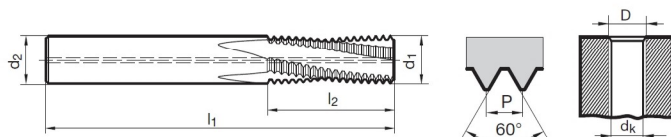


Gewindefräser ohne Senkfase für Metrische ISO-Gewinde



P	•	Schnittwerte siehe Seite 28
M	○	
K	•	
N	•	
S	○	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TM SP	TM SP
Innenkühlung		
Schaftform	HA	HB



Werkstoff	Artikel-Nr.	3735	3740
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D	P	d1	d2	dk	l1	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm		
M 6	1,000	4,800	6,000	5,00	54,000	16,500	3	6,000
M 8	1,250	6,400	8,000	6,80	62,000	21,900	3	8,000
M10	1,500	7,950	10,000	8,50	74,000	26,300	3	10,000
M12	1,750	9,950	10,000	10,20	74,000	32,400	4	12,000
M14	2,000	11,200	12,000	12,00	90,000	37,000	4	14,000
M16	2,000	12,800	14,000	14,00	90,000	43,000	4	16,000
M20	2,500	14,950	16,000	17,50	102,000	48,800	4	20,000

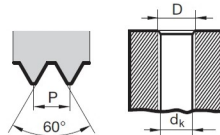
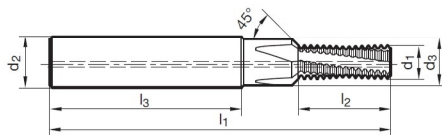
Gewindefräser mit Senkfase für Metrische ISO-Gewinde



P	•
M	•
K	•
N	•
S	•
H	≤55

Schnittwerte siehe Seite 28

Schneidstoff	VHM	
Oberfläche		
Typ	TMC SP	TMC SP
Innenkühlung		
Schaffform	HA	HB



Werksnorm

Artikel-Nr.

3525

3543

D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm	mm		
M 3	0,500	2,300	6,000	3,400	2,50	48,000	36,000	5,300	3	3,000
M 4	0,700	3,000	6,000	4,500	3,30	48,000	36,000	7,400	3	4,000
M 5	0,800	4,000	6,000	5,500	4,20	54,000	36,000	9,200	3	5,000
M 6	1,000	4,800	8,000	6,600	5,00	62,000	36,000	10,500	3	6,000
M 8	1,250	6,400	10,000	9,000	6,80	74,000	40,000	13,100	3	8,000
M10	1,500	7,950	12,000	11,000	8,50	80,000	45,000	17,300	4	10,000
M12	1,750	9,950	14,000	13,500	10,20	90,000	45,000	20,100	4	12,000
M14	2,000	11,200	16,000	15,500	12,00	102,000	48,000	25,000	4	14,000
M16	2,000	12,800	18,000	17,500	14,00	102,000	48,000	27,000	4	16,000
M20	2,500	14,500	20,000	21,500	17,50	125,000	50,000	33,800	4	20,000

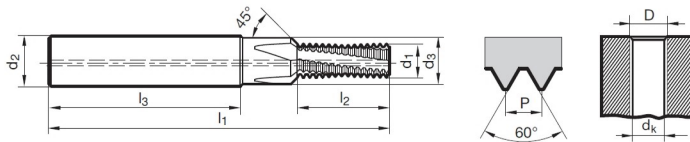


Gewindefräser mit Senkfase für Metrische ISO-Gewinde



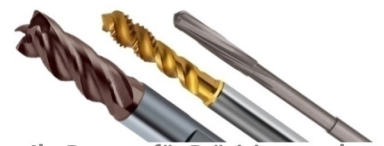
P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB

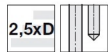


Werksnorm	Artikel-Nr.	3526	3544
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D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm	mm		
M 3	0,500	2,300	6,000	3,400	2,50	48,000	36,000	6,800	3	3,000
M 4	0,700	3,000	6,000	4,500	3,30	48,000	36,000	8,800	3	4,000
M 5	0,800	4,000	6,000	5,500	4,20	54,000	36,000	10,800	3	5,000
M 6	1,000	4,800	8,000	6,600	5,00	62,000	36,000	13,500	3	6,000
M 8	1,250	6,400	10,000	9,000	6,80	74,000	40,000	18,100	3	8,000
M10	1,500	7,950	12,000	11,000	8,50	80,000	45,000	21,800	4	10,000
M12	1,750	9,950	14,000	13,500	10,20	90,000	45,000	25,400	4	12,000
M14	2,000	11,200	16,000	15,500	12,00	102,000	48,000	31,000	4	14,000
M16	2,000	12,800	18,000	17,500	14,00	102,000	48,000	35,000	4	16,000
M20	2,500	14,500	20,000	21,500	17,50	125,000	50,000	41,300	4	20,000

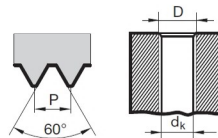
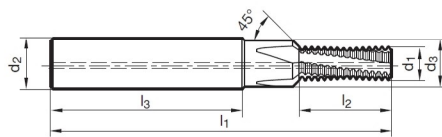


Gewindefräser mit Senkfase für Metrische ISO-Gewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werknorm	Artikel-Nr.	3759	3760
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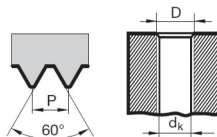
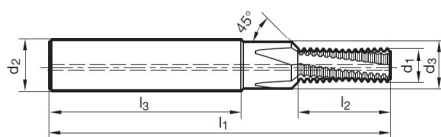
D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm	mm		
M 3	0,500	2,300	6,000	3,400	2,50	48,000	36,000	7,800	3	3,000
M 4	0,700	3,000	6,000	4,500	3,30	48,000	35,600	10,900	3	4,000
M 5	0,800	4,000	6,000	5,500	4,20	54,000	36,000	13,200	3	5,000
M 6	1,000	4,800	8,000	6,600	5,00	62,000	36,000	16,500	3	6,000
M 8	1,250	6,400	10,000	9,000	6,80	74,000	40,000	21,900	3	8,000
M10	1,500	7,950	12,000	11,000	8,50	80,000	45,000	26,300	4	10,000
M12	1,750	9,950	14,000	13,500	10,20	90,000	45,000	32,400	4	12,000
M14	2,000	11,200	16,000	15,500	12,00	102,000	48,000	37,000	4	14,000
M16	2,000	12,800	18,000	17,500	14,00	102,000	48,000	43,000	4	16,000
M20	2,500	14,500	20,000	21,500	17,50	125,000	50,000	48,800	4	20,000

Gewindefräser mit Senkfase für Metrische ISO-Feingewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werknorm	Artikel-Nr.	3527	3545
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D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm	mm		
M 4 X0,5	0,500	3,000	6,000	4,500	3,50	48,000	36,000	7,300	3	4,003
M 5 X0,5	0,500	4,000	6,000	5,500	4,50	54,000	36,000	8,800	3	5,003
M 6 X0,5	0,500	4,800	8,000	6,600	5,50	62,000	36,000	9,800	3	6,003
M 6 X0,75	0,750	4,800	8,000	6,600	5,20	62,000	36,000	10,100	3	6,004
M 8 X0,75	0,750	6,400	10,000	9,000	7,20	74,000	40,000	13,100	3	8,004
M 8 X1	1,000	6,400	10,000	9,000	7,00	74,000	40,000	13,500	3	8,005
M10 X1	1,000	7,950	12,000	11,000	9,00	80,000	45,000	16,500	4	10,005
M10 X1,25	1,250	7,950	12,000	11,000	8,80	80,000	45,000	16,900	4	10,006
M12 X1	1,000	9,950	14,000	13,500	11,00	90,000	45,000	19,500	4	12,005
M12 X1,5	1,500	9,950	14,000	13,500	10,50	90,000	45,000	20,300	4	12,007
M14 X1,5	1,500	11,200	16,000	15,500	12,50	102,000	48,000	23,300	4	14,007
M16 X1,5	1,500	12,800	18,000	17,500	14,50	102,000	48,000	26,300	4	16,007

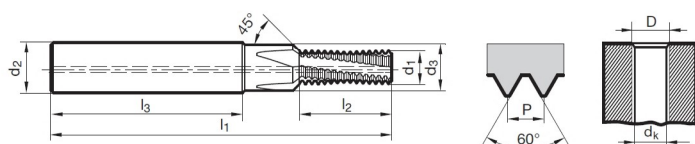


Gewindefräser mit Senkfase für Metrische ISO-Feingewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm	Artikel-Nr.	3528	3546
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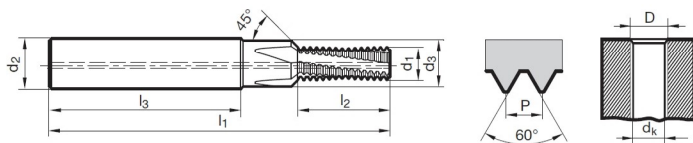
D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm	mm		
M 4 X0,5	0,500	3,000	6,000	4,500	3,50	48,000	36,000	8,800	3	4,003
M 5 X0,5	0,500	4,000	6,000	5,500	4,50	54,000	36,000	10,800	3	5,003
M 6 X0,5	0,500	4,800	8,000	6,600	5,50	62,000	36,000	12,800	3	6,003
M 6 X0,75	0,750	4,800	8,000	6,600	5,20	62,000	36,000	13,100	3	6,004
M 8 X0,75	0,750	6,400	10,000	9,000	7,20	74,000	40,000	16,900	3	8,004
M 8 X1	1,000	6,400	10,000	9,000	7,00	74,000	40,000	17,500	3	8,005
M10 X1	1,000	7,950	12,000	11,000	9,00	80,000	45,000	21,500	4	10,005
M10 X1,25	1,250	7,950	12,000	11,000	8,80	80,000	45,000	21,900	4	10,006
M12 X1	1,000	9,950	14,000	13,500	11,00	90,000	45,000	25,500	4	12,005
M12 X1,5	1,500	9,950	14,000	13,500	10,50	90,000	45,000	26,300	4	12,007
M14 X1,5	1,500	11,200	16,000	15,500	12,50	102,000	48,000	30,800	4	14,007
M16 X1,5	1,500	12,800	18,000	17,500	14,50	102,000	48,000	33,800	4	16,007

Gewindefräser mit Senkfase für Metrische ISO-Feingewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	C	C
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm	Artikel-Nr.	3762	3763
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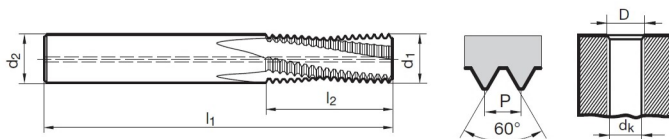
D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm	mm		
M 4 X0,5	0,500	3,000	6,000	4,500	3,50	48,000	36,000	10,300	3	4,003
M 5 X0,5	0,500	4,000	6,000	5,500	4,50	54,000	36,000	12,800	3	5,003
M 6 X0,5	0,500	4,800	8,000	6,600	5,50	62,000	36,000	15,300	3	6,003
M 6 X0,75	0,750	4,800	8,000	6,600	5,20	62,000	36,000	15,400	3	6,004
M 8 X0,75	0,750	6,400	10,000	9,000	7,20	74,000	40,000	20,600	3	8,004
M 8 X1	1,000	6,400	10,000	9,000	7,00	74,000	40,000	20,500	3	8,005
M10 X1	1,000	7,950	12,000	11,000	9,00	80,000	45,000	25,500	4	10,005
M10 X1,25	1,250	7,950	12,000	11,000	8,80	80,000	45,000	25,600	4	10,006
M12 X1	1,000	9,950	14,000	13,500	11,00	90,000	45,000	30,500	4	12,005
M12 X1,5	1,500	9,950	14,000	13,500	10,50	90,000	45,000	30,800	4	12,007
M14 X1,5	1,500	11,200	16,000	15,500	12,50	102,000	48,000	38,300	4	14,007
M16 X1,5	1,500	12,800	18,000	17,500	14,50	102,000	48,000	41,300	4	16,007

Gewindefräser ohne Senkfase für UNC-Gewinde



P	•	Schnittwerte siehe Seite 28
M	○	
K	•	
N	•	
S	○	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TM SP	TM SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm

Artikel-Nr.

4134

4135

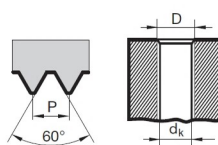
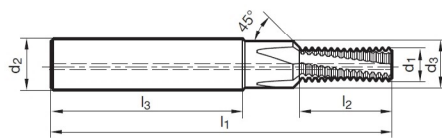
D	d1	d2	dk	l1	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm		
10 -24	3,400	6,000	3,90	54,000	11,100	3	4,826
12 -24	4,100	6,000	4,50	54,000	12,200	3	5,486
1/4 -20	4,700	6,000	5,10	54,000	14,600	3	6,350
5/16-18	6,100	8,000	6,60	64,000	17,600	3	7,938
3/8 -16	7,600	8,000	8,00	64,000	21,400	3	9,525
7/16-14	9,000	10,000	9,40	74,000	24,500	3	11,113
1/2 -13	9,950	10,000	10,80	74,000	28,300	4	12,700
9/16-12	11,400	12,000	12,20	90,000	30,700	4	14,288
5/8 -11	12,700	14,000	13,50	90,000	35,800	4	15,875

Gewindefräser mit Senkfase für UNC-Gewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TMC SP	TMC SP
Innenkühlung		
Schaffform	HA	HB



Werknorm Artikel-Nr. 3516 3534

D	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm		
1/4 -20	4,800	8,000	6,600	5,10	62,000	36,000	12,100	3	6,350
5/16-18	5,950	10,000	9,000	6,60	74,000	40,000	14,800	3	7,938
3/8 -16	7,100	12,000	11,000	8,00	80,000	45,000	16,700	4	9,525
7/16-14	7,950	12,000	11,000	9,40	80,000	45,000	19,000	4	11,113
1/2 -13	9,950	14,000	13,500	10,80	90,000	45,000	22,500	4	12,700

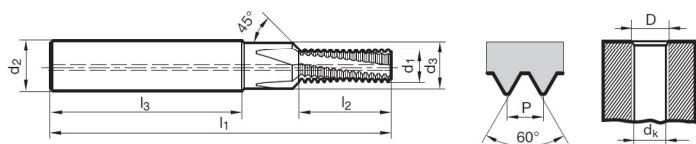


Gewindefräser mit Senkfase für UNC-Gewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm	Artikel-Nr.	3517	3535
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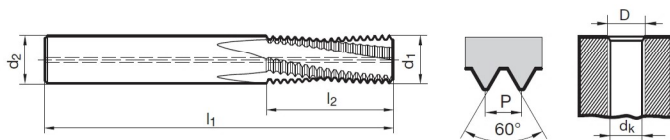
D	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm		
1/4 -20	4,800	8,000	6,600	5,10	62,000	36,000	14,600	3	6,350
5/16-18	5,950	10,000	9,000	6,60	74,000	40,000	17,600	3	7,938
3/8 -16	7,100	12,000	11,000	8,00	80,000	45,000	21,400	4	9,525
7/16-14	7,950	12,000	11,000	9,40	80,000	45,000	24,500	4	11,113
1/2 -13	9,950	14,000	13,500	10,80	90,000	45,000	28,300	4	12,700

Gewindefräser ohne Senkfase für UNF-Gewinde



P	•	Schnittwerte siehe Seite 28
M	○	
K	•	
N	•	
S	○	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TM SP	TM SP
Innenkühlung		
Schaftform	HA	HB



Werknorm	Artikel-Nr.	4136	4137
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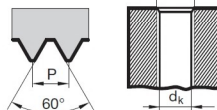
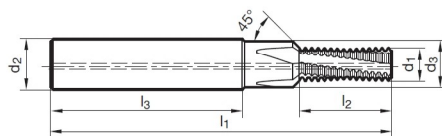
D	d1	d2	dk	l1	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm		
10 -32	3,800	6,000	4,10	54,000	11,500	3	4,826
12 -28	4,300	6,000	4,60	54,000	12,200	3	5,486
1/4 -28	5,100	6,000	5,50	54,000	14,100	3	6,350
5/16-24	6,300	8,000	6,90	64,000	17,500	3	7,938
3/8 -24	7,800	8,000	8,50	64,000	20,600	3	9,525
7/16-20	9,400	10,000	9,90	74,000	24,800	3	11,113
1/2 -20	9,950	10,000	11,50	74,000	27,300	4	12,700
9/16-18	11,400	12,000	12,90	90,000	30,300	4	14,288
5/8 -18	12,700	14,000	14,50	90,000	33,200	4	15,875

Gewindefräser mit Senkfase für UNF-Gewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm

Artikel-Nr.

3518

3536

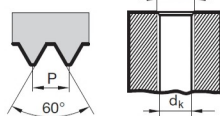
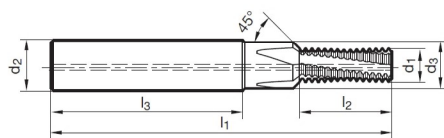
D	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm		
1/4 -28	4,800	8,000	6,600	5,50	62,000	36,000	11,300	3	6,350
5/16-24	5,950	10,000	9,000	6,90	74,000	40,000	13,200	3	7,938
3/8 -24	7,950	12,000	11,000	8,50	80,000	45,000	16,400	4	9,525
7/16-20	7,950	12,000	11,000	9,90	80,000	45,000	18,400	4	11,113
1/2 -20	9,950	14,000	13,500	11,50	90,000	45,000	21,000	4	12,700

Gewindefräser mit Senkfase für UNF-Gewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm

Artikel-Nr.

3519

3537

D	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	mm	mm	mm	mm	mm	mm	mm		
1/4 -28	4,800	8,000	6,600	5,50	62,000	36,000	14,100	3	6,350
5/16-24	5,950	10,000	9,000	6,90	74,000	40,000	17,500	3	7,938
3/8 -24	7,950	12,000	11,000	8,50	80,000	45,000	20,600	4	9,525
7/16-20	7,950	12,000	11,000	9,90	80,000	45,000	24,800	4	11,113
1/2 -20	9,950	14,000	13,500	11,50	90,000	45,000	27,300	4	12,700

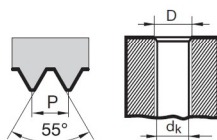
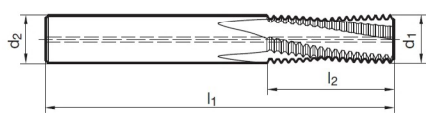


Gewindefräser ohne Senkfase für Whitworth-Rohrgewinde



P	•	Schnittwerte siehe Seite 28
M	○	
K	•	
N	•	
S	○	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TM SP	TM SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm

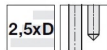
Artikel-Nr.

3745

3748

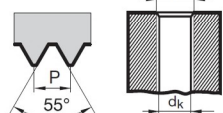
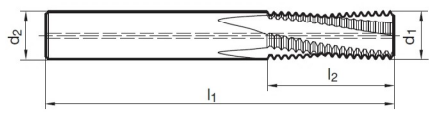
D	P	d1	d2	dk	l1	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm		
G 1/8	28	7,950	8,000	8,80	64,000	21,300	3	9,728
G 1/4	19	10,500	12,000	11,80	90,000	28,700	4	13,157
G 3/8	19	13,600	14,000	15,25	90,000	35,400	4	16,662

Gewindefräser ohne Senkfase für Whitworth-Rohrgewinde



P	•	Schnittwerte siehe Seite 28
M	○	
K	•	
N	•	
S	○	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TM SP	TM SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm	Artikel-Nr.	3746	3750
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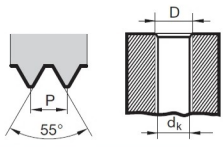
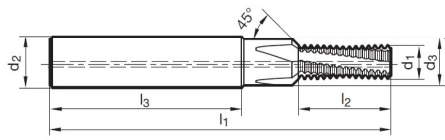
D	P	d1	d2	dk	l1	l2	Z	Code-Nr.
	G/inch							
G 1/8	28	7,950	8,000	8,80	64,000	24,900	3	9,728
G 1/4	19	10,500	12,000	11,80	90,000	35,400	4	13,157
G 3/8	19	13,600	14,000	15,25	90,000	43,500	4	16,662

Gewindefräser mit Senkfase für Whitworth-Rohrgewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

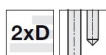
Schneidstoff	VHM	
Oberfläche		
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werknorm Artikel-Nr. 3514 3529

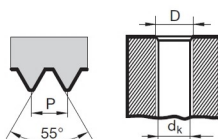
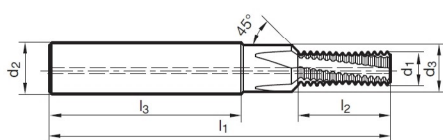
D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm	mm	mm		
G 1/8	28	7,950	12,000	11,000	8,80	80,000	45,000	15,900	4	9,728
G 1/4	19	9,950	14,000	13,900	11,80	90,000	45,000	22,100	4	13,157
G 3/8	19	13,600	18,000	17,500	15,25	102,000	48,000	27,400	4	16,662

Gewindefräser mit Senkfase für Whitworth-Rohrgewinde



- P** • Schnittwerte siehe Seite 29
- M** •
- K** •
- N** •
- S** •
- H** ≤55

Schneidstoff	VHM	
Oberfläche	C	C
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm	Artikel-Nr.	3515	3533
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D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm	mm	mm		
G 1/8	28	7,950	12,000	11,000	8,80	80,000	45,000	21,300	4	9,728
G 1/4	19	9,950	14,000	13,900	11,80	90,000	45,000	28,700	4	13,157
G 3/8	19	13,600	18,000	17,500	15,25	102,000	48,000	35,400	4	16,662

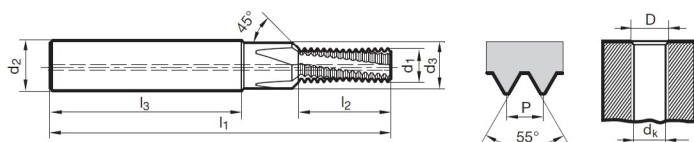


Gewindefräser mit Senkfase für Whitworth-Rohrgewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm

Artikel-Nr.

3765

3766

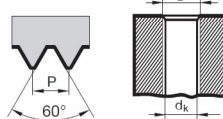
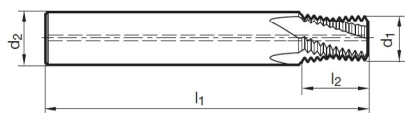
D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm	mm	mm		
G 1/8	28	7,950	12,000	11,000	8,80	80,000	45,000	24,900	4	9,728
G 1/4	19	9,950	14,000	13,900	11,80	90,000	45,000	35,400	4	13,157
G 3/8	19	13,600	18,000	17,500	15,25	102,000	48,000	43,500	4	16,662

Gewindefräser ohne Senkfase für NPT-Gewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TM SP	TM SP
Innenkühlung		
Schaftform	HA	HB



Werknorm	Artikel-Nr.	3753	3754
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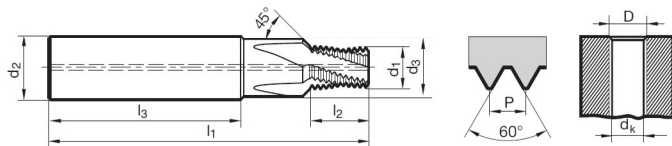
D	P	d1	d2	dk	l1	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm		
1/16	27	5,900	8,000	6,15	54,000	9,900	3	8,190
1/8	27	7,300	8,000	8,40	64,000	9,900	3	10,620
1/4	18	9,950	12,000	11,10	72,000	19,000	4	14,140
3/8	18	12,500	14,000	14,30	80,000	14,800	4	17,570

Gewindefräser mit Senkfase für NPT-Gewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werknorm	Artikel-Nr.	3520	3538
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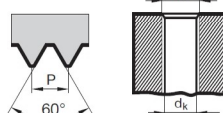
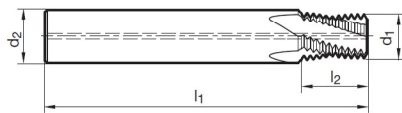
D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm	mm	mm		
1/8	27	7,300	12,000	11,000	8,40	70,000	45,000	9,900	4	10,620
1/4	18	9,950	16,000	14,500	11,10	80,000	48,000	14,800	4	14,140
3/8	18	12,500	18,000	17,500	14,30	80,000	48,000	14,800	4	17,570

Gewindefräser ohne Senkfase für NPTF-Gewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TM SP	TM SP
Innenkühlung		
Schaftform	HA	HB



Werkstoff	Artikel-Nr.	3756	3757
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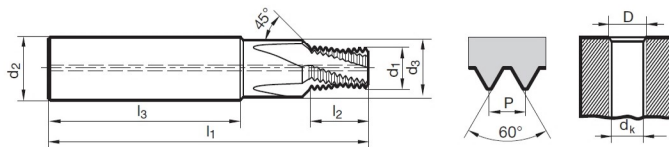
D	P	d1	d2	dk	l1	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm		
1/16	27	5,900	8,000	6,15	54,000	9,900	3	8,190
1/8	27	7,300	8,000	8,40	64,000	9,900	3	10,620
1/4	18	9,950	12,000	11,10	72,000	19,000	4	14,140
3/8	18	12,500	14,000	14,30	80,000	14,800	4	17,570

Gewindefräser mit Senkfase für NPTF-Gewinde



P	•	Schnittwerte siehe Seite 28
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMC SP	TMC SP
Innenkühlung		
Schaftform	HA	HB



Werknorm	Artikel-Nr.	3521	3539
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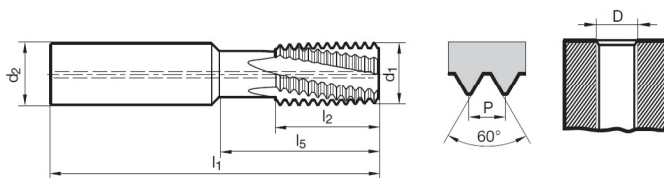
D	P	d1	d2	d3	dk	l1	l3	l2	Z	Code-Nr.
	G/inch	mm	mm	mm	mm	mm	mm	mm		
1/8	27	7,300	12,000	11,000	8,40	70,000	45,000	9,900	4	10,620
1/4	18	9,950	16,000	14,500	11,10	80,000	48,000	14,800	4	14,140
3/8	18	12,500	18,000	17,500	14,30	80,000	48,000	14,800	4	17,570

Mehrbereichs-Gewindefräser für Metrische ISO-Gewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMU SP	TMU SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm	Artikel-Nr.	3541	3556
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P	D	d1	d2	l1	l5	l2	Z	Code-Nr.
mm		mm	mm	mm	mm	mm		
0,500	≥ 10	7,950	8,000	64,000		20,000	4	8,050
1,000	≥ 12	9,950	10,000	70,000	25,000	16,000	4	10,100
1,250	≥ 12	9,950	10,000	70,000	25,000	16,000	4	10,125
1,500	≥ 12	9,950	10,000	70,000	25,000	16,000	4	10,150
1,000	≥ 14	11,950	12,000	80,000	31,000	20,000	4	12,100
1,250	≥ 14	11,950	12,000	80,000	31,000	20,000	4	12,125
1,500	≥ 14	11,950	12,000	80,000	31,000	20,000	4	12,150
1,000	≥ 18	15,950	16,000	90,000	40,000	25,000	5	16,100
1,500	≥ 18	15,950	16,000	90,000	40,000	25,000	5	16,150
2,000	≥ 18	15,950	16,000	90,000	40,000	25,000	5	16,200
3,000	≥ 24	17,950	18,000	102,000	50,000	33,000	5	18,300
1,000	≥ 24	19,950	20,000	105,000	50,000	33,000	5	20,100
1,500	≥ 26	19,950	20,000	105,000	50,000	33,000	5	20,150
2,000	≥ 27	19,950	20,000	105,000	50,000	33,000	5	20,200
2,500	≥ 30	19,950	20,000	105,000	50,000	33,000	5	20,250
3,000	≥ 30	19,950	20,000	105,000	50,000	33,000	5	20,300
3,500	≥ 30	19,950	20,000	105,000	50,000	33,000	5	20,350

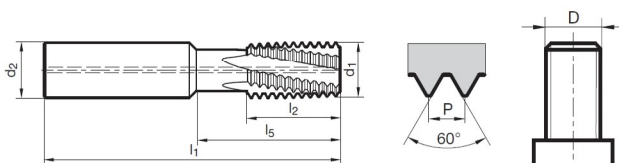


Aussen-Gewindefräser



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	C	C
Typ	TMU SP	TMU SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm Artikel-Nr. **4162** **4163**

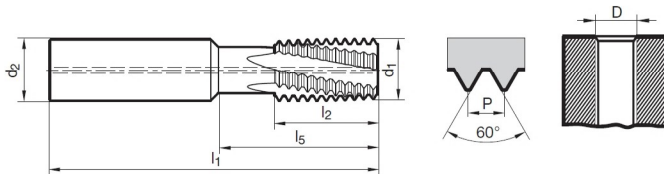
P	D	d1	d2	l1	l5	l2	Z	Code-Nr.
mm		mm	mm	mm	mm	mm		
0,500	≥ 3	9,950	10,000	70,000	25,000	16,000	4	10,050
0,750	≥ 5	9,950	10,000	70,000	25,000	16,000	4	10,075
1,000	≥ 6	11,950	12,000	80,000	31,000	20,000	4	12,100
1,250	≥ 8	11,950	12,000	80,000	31,000	20,000	4	12,125
1,500	≥ 10	11,950	12,000	80,000	31,000	20,000	4	12,150
1,500	≥ 10	15,950	16,000	90,000	40,000	25,000	5	16,150
2,000	≥ 14	15,950	16,000	90,000	40,000	25,000	5	16,200
2,500	≥ 18	15,950	16,000	90,000	40,000	25,000	5	16,250
3,000	≥ 24	19,950	20,000	105,000	50,000	33,000	5	20,300

Mehrbereichs-Gewindefräser für UN-Gewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMU UN	TMU UN
Innenkühlung		
Schaffform	HA	HB



Werkstoff	Artikel-Nr.	3595	3596
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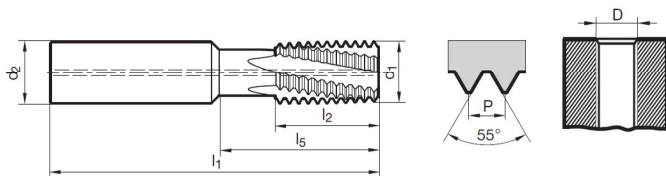
P	D	d1	d2	l1	l5	l2	Z	Code-Nr.
G/inch		mm	mm	mm	mm	mm		
24	≥ 1/2	9,950	10,000	70,000	25,000	16,000	4	10,240
10	≥ 3/4	11,950	12,000	80,000	31,000	20,000	4	12,100
16	≥ 5/8	11,950	12,000	80,000	31,000	20,000	4	12,160
18	≥ 5/8	11,950	12,000	80,000	31,000	20,000	4	12,180
20	≥ 11/16	11,950	12,000	80,000	31,000	20,000	4	12,200
24	≥ 5/8	11,950	12,000	80,000	31,000	20,000	4	12,240
12	≥ 7/8	15,950	16,000	90,000	40,000	25,000	5	16,120
14	≥ 7/8	15,950	16,000	90,000	40,000	25,000	5	16,140
16	≥ 7/8	15,950	16,000	90,000	40,000	25,000	5	16,160
18	≥ 7/8	15,950	16,000	90,000	40,000	25,000	5	16,180
20	≥ 13/16	15,950	16,000	90,000	40,000	25,000	5	16,200
7	≥ 1	19,950	20,000	105,000	50,000	33,000	5	20,070
8	≥ 1	19,950	20,000	105,000	50,000	33,000	5	20,080
12	≥ 1	19,950	20,000	105,000	50,000	33,000	5	20,120
14	≥ 1	19,950	20,000	105,000	50,000	33,000	5	20,140
16	≥ 1	19,950	20,000	105,000	50,000	33,000	5	20,160

Mehrbereichs-Gewindefräser für Whitworth-Rohrgewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche	Ⓢ	Ⓢ
Typ	TMU SP	TMU SP
Innenkühlung		
Schaftform	HA	HB



Werknorm	Artikel-Nr.	3542	3557
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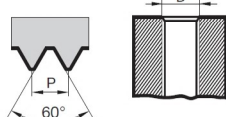
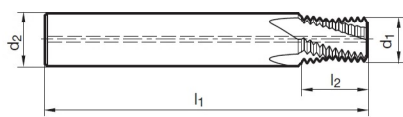
P	D	d1	d2	l1	l5	l2	Z	Code-Nr.
G/inch		mm	mm	mm	mm	mm		
19	≥ 1/4	9,950	10,000	70,000	25,000	16,000	4	10,190
14	≥ 1/2	15,950	16,000	90,000	40,000	25,000	5	16,140
11	≥ 1	19,950	20,000	105,000	50,000	33,000	5	20,110

Mehrbereichs-Gewindefräser für NPT-Gewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMU SP	TMU SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm	Artikel-Nr.	3768	3769
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P	D	d1	d2	l1	l2	Z	Code-Nr.
G/inch		mm	mm	mm	mm		
14	≥ 1/2	14,500	16,000	90,000	19,050	5	21,900
11,5	≥ 1	18,500	20,000	90,000	23,190	5	34,180

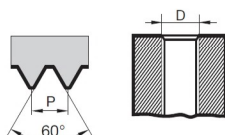
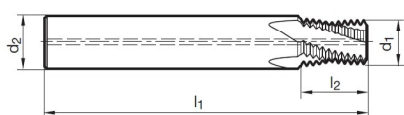


Mehrbereichs-Gewindefräser für NPTF-Gewinde



P	•	Schnittwerte siehe Seite 29
M	•	
K	•	
N	•	
S	•	
H	≤55	

Schneidstoff	VHM	
Oberfläche		
Typ	TMU SP	TMU SP
Innenkühlung		
Schaftform	HA	HB



Werksnorm

Artikel-Nr.

3772

3773

P	D	d1	d2	l1	l2	Z	Code-Nr.
G/inch		mm	mm	mm	mm		
14	≥ 1/2	14,500	16,000	90,000	19,050	5	21,900
11,5	≥ 1	18,500	20,000	90,000	23,190	5	34,180