для размещения заказа - zakaz@widiahanita.ru

GTM11 and GTM21 • Metric

Thread Mill GTM11

Thread Mill • Chamfer GTM21

Material Group		Cutting Speed — vc Range — m/min			Feed/Tooth by Diameter			Cutting Speed — vc Range — m/min			Feed/Tooth by Diameter		
		min	Starting Value	max		<10mm	>10mm	min	Starting Value	max		<10mm	>10mm
P	1	90	**115**	150	mm	**0,05**	0,08	140	**185**	240	mm	**0,06**	0,10
	2	90	**115**	150	mm	**0,05**	0,08	140	**185**	240	mm	**0,06**	0,10
	3	40	**50**	70	mm	**0,02**	0,03	70	**90**	120	mm	**0,03**	0,04
	4	–	**–**	–	–	**–**	–	70	**90**	120	mm	**0,03**	0,04
	5	60	**80**	100	mm	**0,04**	0,06	70	**90**	120	mm	**0,05**	0,08
	6	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
M	1	60	**80**	100	mm	**0,04**	0,06	70	**90**	120	mm	**0,05**	0,08
	2	60	**80**	100	mm	**0,04**	0,06	70	**90**	120	mm	**0,05**	0,08
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
K	1	120	**150**	200	mm	**0,06**	0,10	130	**170**	220	mm	**0,06**	0,11
	2	120	**150**	200	mm	**0,06**	0,10	130	**170**	220	mm	**0,06**	0,11
	3	90	**115**	150	mm	**0,05**	0,07	110	**140**	180	mm	**0,05**	0,07
N	1	200	**225**	250	mm	**0,05**	0,06	270	**300**	330	mm	**0,08**	0,16
	2	170	**190**	210	mm	**0,04**	0,05	160	**175**	190	mm	**0,08**	0,16
	3	250	**275**	300	mm	**0,07**	0,09	270	**300**	330	mm	**0,08**	0,16
	4	250	**275**	300	mm	**0,07**	0,09	270	**300**	330	mm	**0,08**	0,16
	5	270	**300**	330	mm	**0,12**	0,13	250	**275**	300	mm	**0,11**	0,20
	6	170	**190**	210	mm	**0,05**	0,06	90	**100**	110	mm	**0,11**	0,20
S	1	60	**80**	100	mm	**0,04**	0,06	70	**90**	120	mm	**0,05**	0,08
	2	50	**65**	80	mm	**0,03**	0,04	50	**60**	80	mm	**0,03**	0,05
	3	50	**65**	80	mm	**0,03**	0,04	50	**60**	80	mm	**0,03**	0,05
	4	50	**65**	80	mm	**0,03**	0,04	50	**60**	80	mm	**0,03**	0,05

GTM31 • Metric

Drill • Chamfer • Thread Mill GTM31

Material Group		Cutting Speed — vc Range — m/min			Drilling				Milling			
					Recommended Feed by Diameter				Feed/Tooth by Diameter			
		min	Starting Value	max		<6mm	6–10mm	10–16mm		<6mm	6–10mm	10–16mm
K	1	130	**175**	230	mm/r	**0,10**	**0,16**	0,30	mm	**0,05**	**0,07**	0,10
N	1	270	**300**	330	mm/r	**0,15**	**0,25**	0,34	mm	**0,06**	**0,08**	0,12
	2	140	**150**	170	mm/r	**0,15**	**0,25**	0,34	mm	**0,06**	**0,08**	0,12
	4	270	**300**	330	mm/r	**0,15**	**0,25**	0,34	mm	**0,06**	**0,08**	0,12
	5	110	**120**	130	mm/r	**0,12**	**0,20**	0,32	mm	**0,06**	**0,08**	0,12

NOTE: For thread depths over 2 x D up to 3 x D, reduce speed and feed by 25%.

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