

T781HX

Micro Thread Mills / Oil-Feed Thread Mills

ISO Metric Standard Thread
 Good wear resistance effect with Nano multilayer coating.



VHM Carbide
AlTiCrN HX
11°
3-5Z
78°
Steel <48HRC

Dc	Dc	Dc	Dc	P	P
				H	H
				M	M
				K	K

Suitable for carbon steel, below 48HRC hardened steel, stainless steel, cast iron...etc.

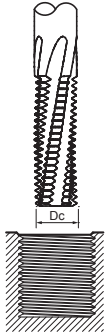

Standard Length

Thread	Pitch	Dc	Lc	L1	L	d	t	Zt	T781HX	T781HX				
									AlTiCrN	AlTiCrN				
Coarse	Fine	mm	mm	mm	mm	h6	mm							
M1×0.25		0.25	0.72	0.25	2.8	50	4	3	1	●				
M1.2×0.25		0.25	0.91	0.25	3.3	50	4	3	1	●				
M1.4×0.3		0.3	1.05	0.3	3.8	50	4	3	1	●				
M1.6×0.35		0.35	1.2	0.35	4.3	50	4	3	1	●				
M1.8×0.35		0.35	1.3	0.35	4.8	50	4	3	1	●				
M2×0.4		0.4	1.5	1.2	4.5	50	4	3	3		●			
M2.5×0.45		0.45	1.9	1.4	5.6	50	4	3	3		●			
M3×0.5	M3.5~M16×0.5	0.5	2.4	1.5	6.5	50	4	3	3		●			
M4×0.7		0.7	3.1	2.1	8.7	50	6	3	3		●			
M5×0.8		0.8	4	2.4	10.8	50	6	3	3		●			

Standard Length

Thread	Pitch	Dc	Lc	L1	L	d	t	T781HX	T781HX				
								AlTiCrN	AlTiCrN				
Coarse	Fine	mm	mm	mm	mm	h6	mm						
M6×1		1	4.5	13	15	60	6	4		●			
M8×1.25		1.25	6	17.8	—	65	6	4		●			
M10×1.5		1.5	7.5	22.5	25	70	8	4		●			
M12×1.75		1.75	9.5	26.3	27	80	10	5			●		
M14×2		2	10	30	—	90	10	5			●		
M16×2		2	12	34	—	100	12	5			●		
M20×2.5		2.5	16	42.5	—	110	16	5			●		

Cutting Conditions

T781HX					
		cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)
Carbon Steel Materials					
P	GR1 Carbon Steel	120	0.016xDc	40	0.006xDc
	GR2 <24HRC Low-alloyed Steel	100	0.016xDc	30	0.005xDc
	GR3 <30HRC Hi-alloyed Steel	80	0.016xDc	20	0.005xDc
Hardened Steel Materials					
H	GR4 30-38HRC Hardened Steel	90	0.01xDc	10	0.003xDc
	GR5 38-48HRC Hardened Steel	80	0.01xDc	10	0.003xDc
Stainless Steel Materials					
M	GR8-1 Ferritic \ Martensitic	70	0.01xDc	20	0.004xDc
	GR8-2 Austenitic	60	0.01xDc	20	0.003xDc
	GR8-3 Austenitic-ferritic	50	0.01xDc	20	0.003xDc
	GR8-4 Austenitic-ferritic Heat-resistant	40	0.01xDc	20	0.003xDc
Cast Iron Materials					
K	GR9-1 Grey cast iron	110	0.016xDc	40	0.006xDc
	GR9-2 Nodular cast iron	120	0.016xDc	30	0.006xDc

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.