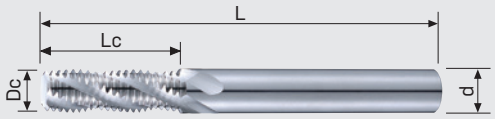
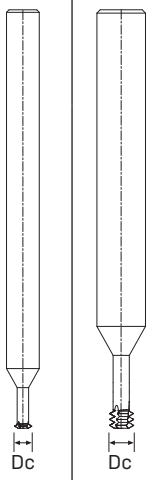
T783

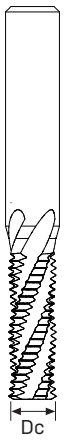
Micro Thread Mills / Oil-Feed Thread Mills

ISO Metric Standard Thread.



VHM Carbide | Uncoated Bright | 30° | 3~5Z | γ8° | Aluminium





Suitable for cutting in different Aluminium materials.

N | N | N | N

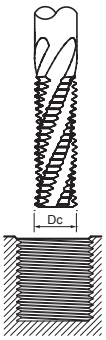
Standard Length

Thread		Pitch	Dc	Lc	Ll	L	d	t	Zt	T783 Bright	T783 Bright				
Coarse	Fine	mm	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	Ll	L	d	t			T783 Bright	T783 Bright		
Coarse	Fine	mm	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

T783					
		cutting speed Vc (m/min)	feed per tooth fz(mm)	cutting speed Vc (m/min)	feed per tooth fz(mm)
Aluminium Steel Materials					
N	GRI0-1 Wrought Aluminium alloys	200	0.016xDc	60	0.01xDc
N	GRI0-2 Aluminium cast alloys <10%	150	0.014xDc	50	0.008xDc
N	GRI0-3 Aluminium cast alloys >10%	150	0.012xDc	40	0.005xDc

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.