

T740TX

Oil-Feed Thread Mills Drills

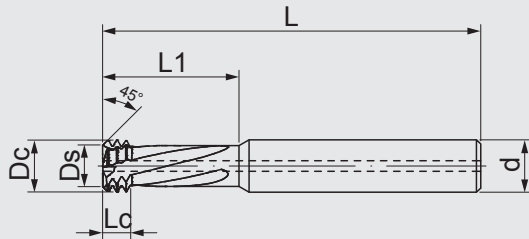
ISO Metric Standard Thread

Design with left-handed and right-cutting edge is beneficial for cutting and getting better chip removal rate.

Cutter tip with chamfering function.

Internal oil-feed design to provide with better cooling effect and chip removal.

Good wear resistance effect with Nano multilayer coating.



VHM Carbide

AlTiSiN TX

15°

3-4Z

78°

Steel <52HRC



Milling with Thread holes with plunging Helix directly.
 Suitable for carbon steel, below 52HRC hardened steel, stainless steel, cast iron...etc.

P

H

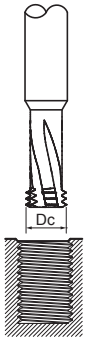
M

K

Standard Length

Thread		Pitch	Dc	Lc	L1	L	d	Ds	t	T740TX					
Coarse	Fine	mm	mm	mm	mm	mm	h6	mm		AlTiSiN					
M3×0.5	M4×0.5	0.5	2.4	1.5	7	57	6	2.1	3	●					
		0.7	3.2	2.1	9.2	57	6	2.9	3	●					
		0.8	3.9	2.4	11.5	57	6	3.5	3	●					
M6~M7×1	M8~M9×1	1	4.7	3	14	57	6	4.2	3	●					
		1.25	6.1	3.75	18	63	8	5.6	4	●					
M10×1.5	M11~M15×1.5	1.5	7.8	4.5	23	63	8	7.2	4	●					
		1.75	9	5.25	26	72	10	8.4	4	●					
M16×2	M17~M23×2	2	11.8	6	35	83	12	11.2	4	●					

Cutting Conditions

T740TX			
		cutting speed Vc (m/min)	feed per tooth fz (mm)
Carbon Steel Materials			
P	GR1 Carbon Steel	60	0.016xDc
	GR2 <24HRC Low-alloyed Steel	60	0.016xDc
	GR3 <30HRC Hi-alloyed Steel	60	0.016xDc
Hardened Steel Materials			
H	GR4 30-38HRC Hardened Steel	30	0.01xDc
	GR5 38-48HRC Hardened Steel	20	0.01xDc
Stainless Steel Materials			
M	GR8-1 Ferritic \ Martensitic	30	0.01xDc
	GR8-2 Austenitic	30	0.01xDc
	GR8-3 Austenitic-ferritic	20	0.01xDc
	GR8-4 Austenitic-ferritic Heat-resistant	15	0.01xDc
Cast Iron Materials			
K	GR9-1 Grey cast iron	60	0.016xDc
	GR9-2 Nodular cast iron	60	0.016xDc

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.

