




Thread Milling Cutters

WX-ST-PNC-3P

Metric, Metric fine, G(as)



WX-ST-PNC-3P Thread Milling cutters



1 Due to use of high-hardness materials exceeding 50HRC, heat resistant steel, and even brittle materials, small-diameter internal threads are becoming increasingly difficult to machine.

2 Along with the need for ultra-high speed and high precision operations, small machining centers without reverse function (tap cycles) have emerged.

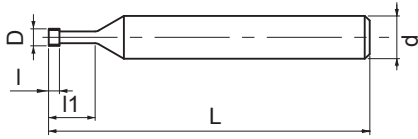
3 The demands for internal threads are becoming increasingly difficult, such as “no room in pilot holes”, “high quality with no burrs”, and “high precision internal threads”.

4 Standard taps have difficulties machining nickel based alloys with water-soluble coolant.

WX-ST-PNC-3P



The 3-crest thread length reduces cutting forces and applies a low load to the tool and equipment. A short overall length of 40mm for superb ease of use. The WXS Coating, with a proven track record on end mills for high hardened materials, and an exclusive carbide base material.



EDP No.	Min. Cutting bore dia	P	D	d	L	l	l1	z	Price
48216000	M1,8	0,35	1,3	3	40	1,2	5,4	3	
48216001	M2	0,4	1,5	3	40	1,2	6	3	
48216002	M2,5	0,45	1,9	6	40	1,35	7,5	3	
48216003	M3	0,5	2,4	6	60	1,5	9,5	3	
48216004	M4	0,7	3,1	6	60	2,1	12,5	3	
48216005	M5	0,8	4,0	6	60	2,4	16	3	
48216006	M6	1	4,5	6	60	3	20	4	
48216007	M8	1,25	6,0	6	60	3,75	24	4	
48216008	M10	1,5	7,5	8	80	4,5	33	4	
48216011	M12	1,75	9,0	10	80	5,3	38	4	

EDP No.	Min. Cutting bore dia	P	D	d	L	l	l1	z	Price
48216100	G1/8" G1/16	28	6,2	8	64	2,72	19,5	4	
48216101	G1/4" G3/8"	19	10	10	80	4,01	25	5	
48216102	G1/2" - G7/8"	14	12	12	100	5,44	37	5	
48216103	G1" - G2"	11	16	16	100	6,93	44	5	

EDP No.	Min. Cutting bore dia	P	D	d	L	l	l1	z	Price
48216009	MF16	1,5	12	12	100	4,5	50	5	
48216012	MF16	2	12	12	100	6	50	5	
48216010	MF20	1,5	16	16	100	4,5	50	5	
48216013	MF20	2	16	16	100	6	50	5	

Work Material	Tapping Speed (m/min)	Feed (mm/tooth)	
Low Tensile Strength Steel	C~0,25%	60~90	0,02~0,08
Medium Tensile Strength Steel	C~0,25% ~ 0,45%	60~90	0,02~0,08
High Tensile Strength Steel	C0,45%~	60~90	0,02~0,08
Alloy Steel	SCM	30~60	0,01~0,03
Hardened Steel	25~45 HRC	30~60	0,01~0,03
	45~55 HRC	30~60	0,01~0,03
	50~60 HRC	-	-
Stainless Steel	SUS	60~90	0,02~0,08
Tool Steel	SKD	-	-
Cast Steel	SC	40~65	0,02~0,09
Cast Iron	FC	50~100	0,03~0,1
Ductile Cast Iron	FCD	50~70	0,03~0,1
Copper	Cu	-	-
Brass	Bs	-	-
Brass Casting	BsC	50~100	0,02~0,06
Bronze	PB	50~100	0,02~0,06
Aluminium Rolled Steel	AL	50~100	0,02~0,06
Aluminium Alloy Casting	AC, ADC	50~100	0,02~0,06
Magnesium Alloy Casting	MC	50~100	0,02~0,06
Zinc Alloy Casting	ZDC	50~100	0,02~0,06
Titanium Alloys	Ti-6AL-4V	20~60	0,01~0,03
Nickel Alloys	Inconel	20~60	0,01~0,03
Thermo Setting Plastic	-	50~100	0,02~0,06



shaping your dreams

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