



Thread milling without pre-drilled hole

WH(O)-EM-PNC

Volume 3



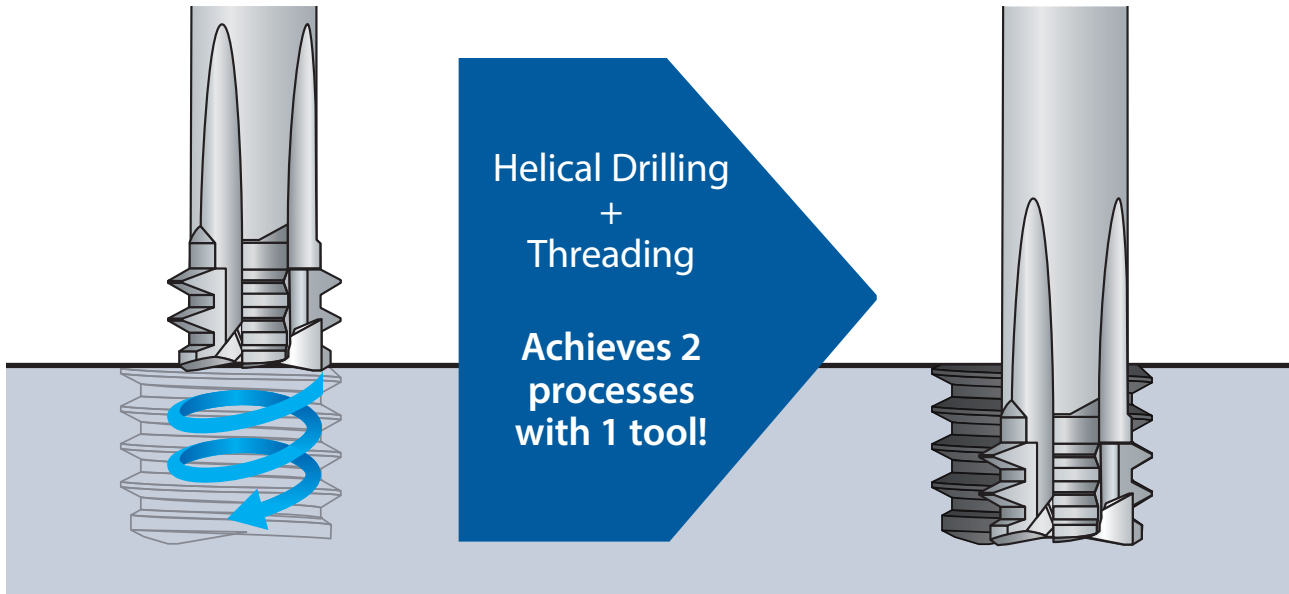
FEATURES: WH(O)-EM-PNC



WH(O)-EM-PNC: THREAD MILL WITH END-CUTTING EDGE FOR HIGH HARDNESS STEELS

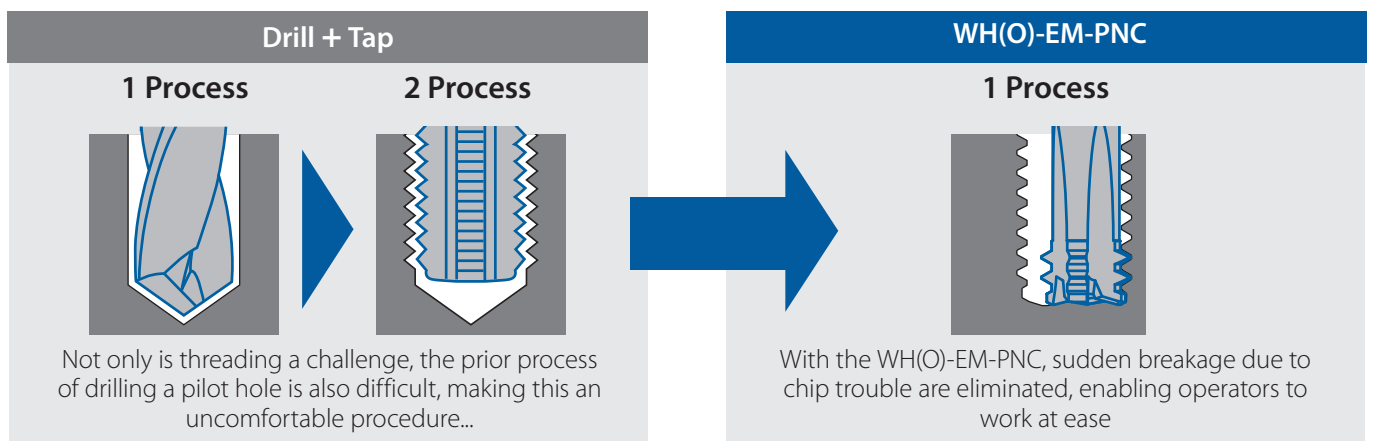
No pilot hole is required!
Stable machining without chip trouble

Threading | Thread milling



WH(O)-EM-PNC: IDEAL FOR HIGHLY DIFFICULT HIGH HARDNESS STEEL APPLICATIONS!

Helical drilling + threading can be done simultaneously, which reduces the risk of potential machining problems in the processing of high hardness steels



The risk of sudden tool breakage can be minimized by breaking chips into small and manageable pieces and evacuating them smoothly. Since no pilot hole is required, process integration and the risk of breakage can be avoided.

CUTTING DATA

Tool	WH-EM-PNC M4
Work Material	1.2379 (Cold work tool steel) 60HRC
Cutting speed	30 m/min (3.082 min ⁻¹)
Feed	123 mm/min (0.01 mm/t)
Depth of cut	8 mm
Coolant	Airblow
Machine	Exeron HSC600
Interface	HSK-40
Holder	Shrink holder
Hole type	Blind hole

Tool	WH-EM-PNC M4
Work Material	1.6582 (Alloy engineering steel) 1400-1550 N/mm ²
Cutting speed	50 m/min (5.137 min ⁻¹)
Feed	205 mm/min (0.01 mm/t)
Depth of cut	9 mm
Coolant	Airblow
Machine	Hermle C32U
Interface	HSK63-A
Holder	Hydraulic chuck
Hole type	Blind hole

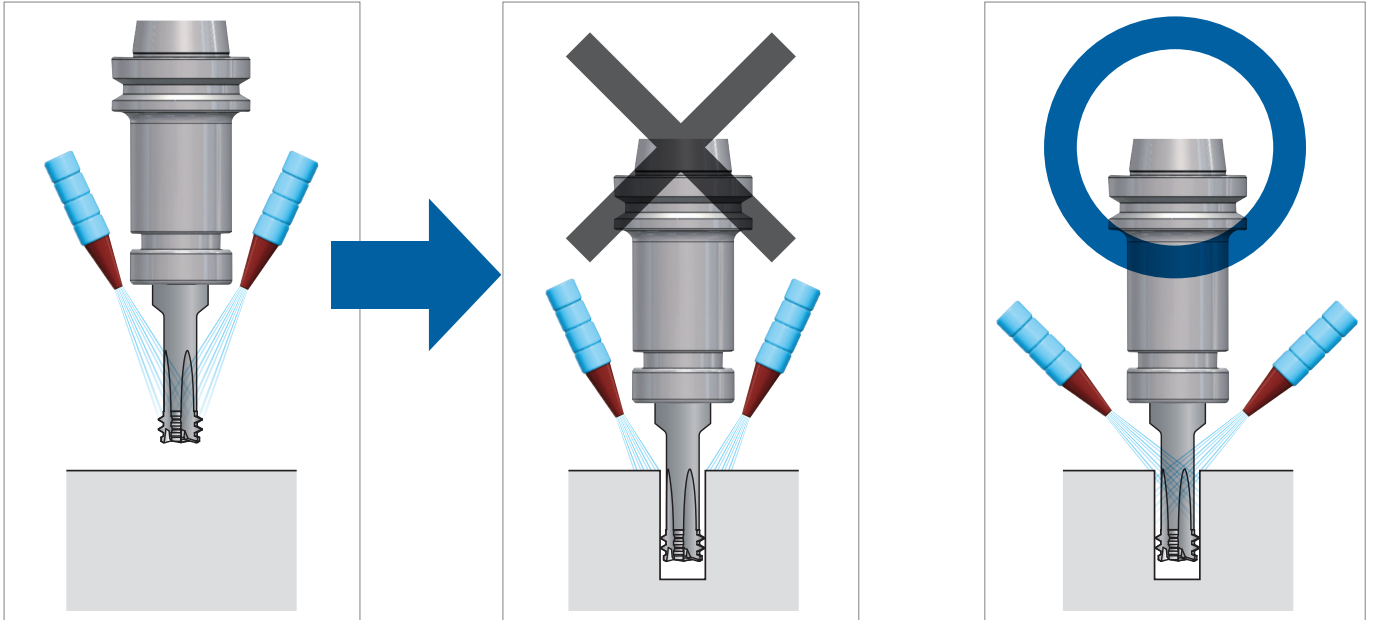
Tool	WH-EM-PNC M4
Work Material	Vanadis (Cold work steel) 64HRC
Cutting speed	30 m/min (3.082 min ⁻¹)
Feed	123 mm/min (0.01 mm/t)
Depth of cut	8 mm
Coolant	Airblow
Machine	n.a.
Interface	n.a.
Holder	Shrink holder
Hole type	Blind hole



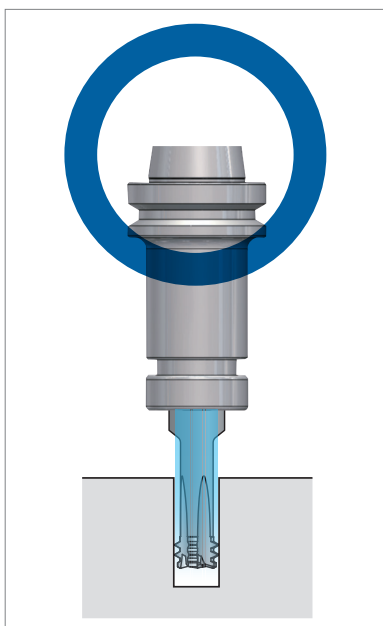
PROPER USAGE OF COOLANT

When using external coolant, ensure that the cutting fluid is properly positioned so that it is supplied into the hole.

Threading | Thread milling



If you are using a machining center with a through-spindle coolant system, the use of coolant through collet is recommended, or use WHO-EM-PNC



Please refer to the following table to select a suitable coolant for cutting.

Work Material	WH(O)-EM-PNC	
	Air Blow	Water-Soluble
High-hardness steel	◎	△
General steel	×	◎

◎ : Best
 △ : Shortening of tool life
 × : Not recommended

Water-soluble cutting fluids can be used with satisfactory result, although in some cases the durability is inferior to air-blow.

SUPPORT TOOLS FOR YOUR THREAD MILLING NEEDS

Troubled by the following problems?

Unsure of diameter correction value. Increase passes which results in longer setup time.

Visibility of internal thread pitch diameter at entry enables the reduction of passes to minimize setup time significantly.

Moreover, the DCT is able to measure pitch diameter smaller than the tolerance limit. The DCT can measure the pitch diameter of the female internal thread even if it does not fit into the Go-Gauge.

An incorrect diameter correction that result in a defective internal thread (gauge-out).

Visibility of internal thread pitch diameter at entry enables reliable diameter corrections.

The DCT is useful for reducing defective workpieces.

Unstable tool life

Digitized measurement ensures consistent internal thread pitch diameters after tool changes. The same starting and finishing position ensures consistent and stable tool life.

Solved with the Diameter Correction Tool DCT

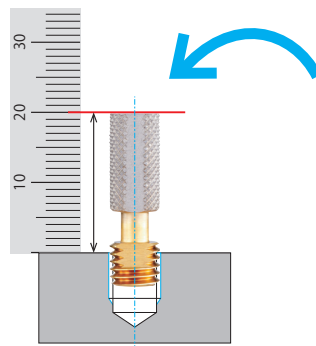
DCT

Simple measurement of pitch diameter by visual judgment



DCT75

Low-cost type
Measurement and calculation system



High-performance type
Digital display system

Eliminate measurement and calculation with the combination of a digital display.



SWEDEN

Branch office of OSG SCANDINAVIA
Singelgatan 7
212 28 Malmö
Sweden
Tel: +46 40 41 22 55
osg@osg-scandinavia.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde
Denmark
Tel: +45 46 75 65 55
osg@osg-scandinavia.com

OSG NETHERLANDS

Bedrijfsweg 5
3481 MG Harmelen
The Netherlands
Tel: +31 348 44 2764
info@osg-nl.com

OSG UK

Kelsey Close, Attleborough Fields Ind Est,
CV11 6RS, Nuneaton
United Kingdom
Tel: +44 (0) 1827 720 013
uk_sales@osg-uk.com

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel: +32 10 23 05 07
info@osgeurope.com

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord
Belgium
Tel: +32 10 23 05 11
info@osg-belgium.com

OSG IBÉRICA

Bekolarra 4
E - 01010 Vitoria-Gasteiz
Spain
Tel: +34 945 242 400
osg.iberica@osg-ib.com

OSG FRANCE

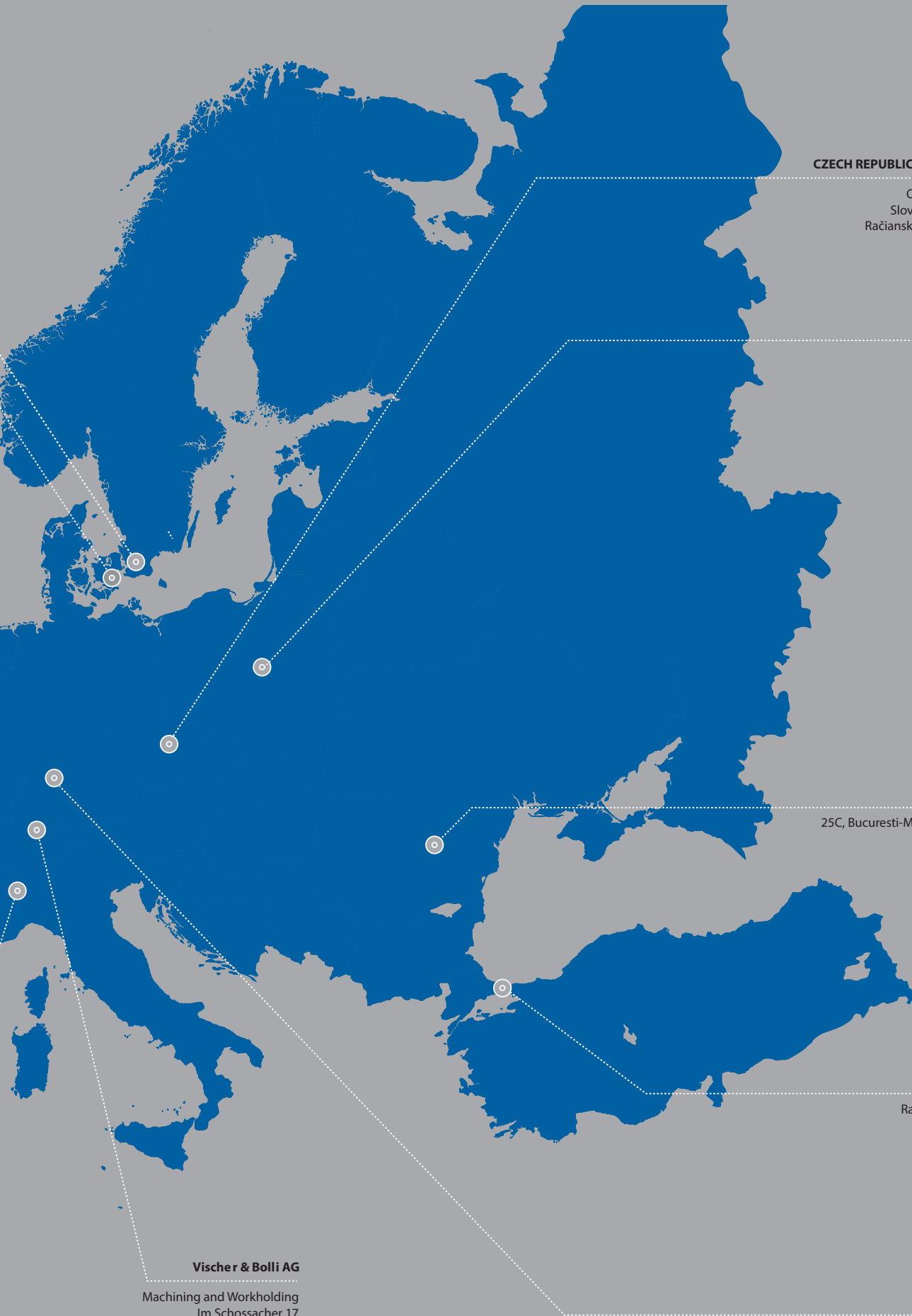
Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte
France
Tel: +33 1 49 90 10 10
sales@osg-france.com

OSG ITALY

Via Ferrero, 65 A/B
I - 10098 Rivoli
Italy
Tel: +39 0117705211
info@osg-italia.it



OSG IN EUROPE



CZECH REPUBLIC, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.
Slovakia, organizačná zložka
Račianska 22/A, Bratislava 831 02
Slovakia
Tel.: +421 24 32 91 295
info@osgeurope.com

OSG POLAND

ul. Spółdzielcza 57
05-074 Halinów
Polska
Tel: +22 760 82 71
Mob. +48 570 677 711
osg@osg-poland.com

OSG ROMANIA SRL

25C, Bucuresti-Magurele Street (Sector 5)
051431 Bucuresti
România
Tel: +40 21 322 07 47
info@osgromania.ro

OSG TURKEY

Rami Kişla Cad.No:56 Eyüp
Istanbul 34056
Turkey
Tel: +90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

Vischer & Bolli AG

Machining and Workholding
Im Schossacher 17
CH-8600 Dübendorf
Switzerland
Tel.: +41 44 802 15 15
info@vb-tools.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen
Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de



shaping your dreams

OSG EUROPE LOGISTICS

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 07
info@osgeurope.com

OSG POLAND Sp. z o.o.

Spółdzielcza 57
05-074 Halinów - Poland
Tel: +22 760 82 71
osg@osg-poland.com

OSG ROMANIA SRL

25C, Bucuresti-Magurele Street (Sector 5)
051431 Bucuresti - România
Tel: +40 21 322 07 47
info@osgromania.ro

OSG BELUX

Avenue Lavoisier 1
B-1300 Z.I. Wavre - Nord - Belgium
Tel: +32 10 23 05 11
info@osg-belgium.com

OSG GERMANY

Karl-Ehmann-Str. 25
D - 73037 Göppingen - Germany
Tel: +49 7161 6064 - 0
Fax: +49 7161 6064 - 444
info@osg-germany.de

AUSTRIA

Branch office of OSG GERMANY
Messestraße 11
A-6850 Dornbirn
Tel: +49 7161 6064-0
info@osg-germany.de

OSG FRANCE

Parc Icade, Paris Nord 2
Immeuble "Le Rimbaud"
22 Avenue des Nations
CS66191 - 93420 Villepinte - France
Tel: +33 1 49 90 10 10
sales@osg-france.com

OSG SCANDINAVIA

(For Scandinavian countries)
Langebjergvaenget 16
4000 Roskilde - Denmark
Tel: +45 46 75 65 55
osg@osg-scandinavia.com

OSG ITALIA

Via Ferrero, 65 A/B3
I - 10098 Rivoli - Italy
Tel: +39 0117705211
info@osg-italia.it

OSG NETHERLANDS

Bedrijfsweg 5 - 3481 MG Harmelen
Tel: +31 348 44 2764
info@osg-nl.com

SWEDEN

Branch office of OSG SCANDINAVIA
Singelgatan 7
212 28 Malmö - Sweden
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Im Schossacher 17
CH-8600 Dübendorf
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info@vb-tools.com

OSG UK

Kelsey Close, Attleborough Fields Ind Est,
CV11 6RS, Nuneaton, United Kingdom.
Tel: +44 1827 720 013
uk_sales@osg-uk.com

OSG IBERICA

Bekolarra 4
E - 01010 Vitoria-Gasteiz - Spain
Tel: +34 945 242 400
osg.iberica@osg-ib.com

CZECH, SLOVAKIA, HUNGARY

OSG Europe Logistics S.A.
Slovakia organizacna zlozka
Racianská 22/A, SK-83102 Bratislava
Slovakia
Tel. +421 24 32 91 295
Orders-osgsvk@osgeurope.com

OSG TURKEY

Rami Kışla Cad.No:56 Eyüp
Istanbul 34056 - Turkey
Tel+90 212 565 24 00
Fax: +90 212 565 44 00
info@osg-turkey.com

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