



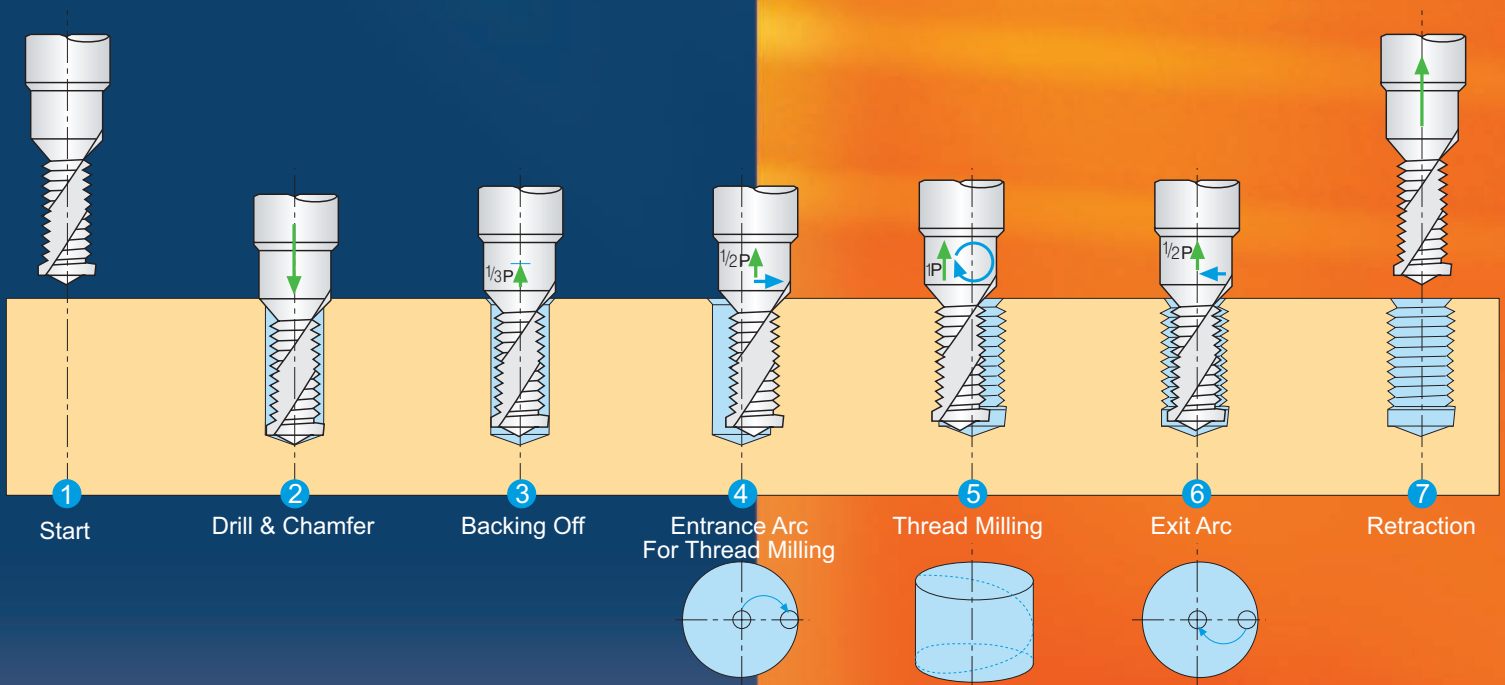
NEW!

Solid Carbide Thread Milling

HTC Thriller with Coolant



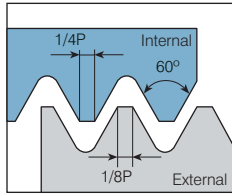
- Drilling, Chamfering and Threading in one tool
- Extremely fast machining for mass production
- For soft materials (Aluminum) and short chip materials (Cast Iron)



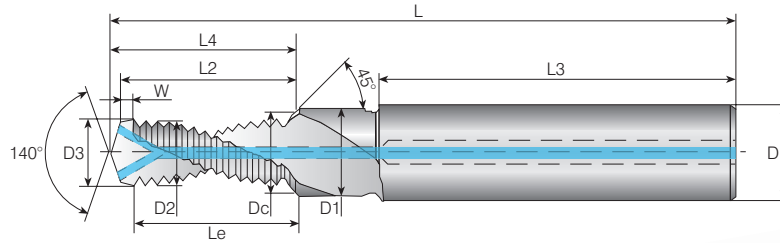
HTC - Thriller with Coolant

ISO Metric

Internal



Defined by: R626 (DIN 13)
Tolerance class: 6g/6H



NEW!



Thread	Ordering Code	Pitch	Dimensions											No. of Flutes	Teeth		
			L	L4	L2	L3	W	Le	D3	D	D1	Dc	D2			Z	Zt
ISO 2xDo Coarse	Internal	(mm)															
M6x1.0	HTC M6x1.0x2D...	1.00	62.0	14.5	13.7	36	1.0	12.7	5.0	8	6.6	6.3	4.85	2	11		
M8x1.25	HTC M8x1.25x2D...	1.25	74.0	18.2	17.1	40	1.3	15.8	6.8	10	9.0	8.3	6.45	2	11		
M10x1.5	HTC M10x1.5x2D...	1.50	79.0	23.4	22.1	45	1.5	20.6	8.5	12	11.0	10.3	8.08	2	12		
M12x1.75	HTC M12x1.75x2D...	1.75	89.0	27.1	25.5	45	1.5	24.0	10.3	14	13.5	12.3	9.74	2	12		
ISO 2.5xDo Coarse																	
M6x1.0	HTC M6x1.0x2.5D...	1.00	62.0	16.5	15.7	36	1.0	14.7	5.0	8	6.6	6.3	4.85	2	13		
M8x1.25	HTC M8x1.25x2.5D...	1.25	74.0	23.2	22.1	40	1.3	20.8	6.8	10	9.0	8.3	6.45	2	15		
M10x1.5	HTC M10x1.5x2.5D...	1.50	79.0	27.9	26.6	45	1.5	25.1	8.5	12	11.0	10.3	8.08	2	15		

Recommended Grades, Cutting Speeds and Feeds

		Hardness Brinell (HB)	Strength (N-mm ²)	Vc [m/min]		fb [mm/rev]		fz [mm/tooth]		
				VTN	VTS	≤6mm	≤12mm	≤6mm	≤12mm	
K	Cast Iron	Grey cast iron	≤150	≤500	50-80	80-120	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
		Grey cast iron, heat treated	150-300	500-1000	50-80	80-120	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
		Spher. graph. Cast Iron	≤200	≤700	50-80	80-120	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10
	Copper	Short Chips, Brass, Bronze, Red Brass	≤200	≤700	100-300	—	0.10-0.30	0.06-0.10	0.03-0.06	0.06-0.10
K	Aluminum / Magnesium	Aluminum, Magnesium non-alloy	≤100	≤350	100-400	100-400	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
		Aluminum, Wrought Alloy, Breaking Strain (A5) < 14%	≤180	≤600	100-400	100-400	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
		Aluminum, Wrought Alloy, Breaking Strain (A5) ≥ 14%	≤180	≤600	100-400	100-400	0.03-0.06	0.06-0.12	0.03-0.06	0.06-0.10
		Aluminum, Cast Alloy, Si < 10%	≤180	≤600	100-300	100-400	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
		Aluminum, Cast Alloy, Si ≥ 10%	≤180	≤600	—	100-300	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
K	Plastics	Thermoplastics	—	—	60-120	60-120	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
		Thermosetting plastic	—	—	60-100	60-100	0.10-0.25	0.25-0.30	0.03-0.06	0.06-0.10
		Fibre Reinforced Plastic	—	—	40-60	60-80	0.10-0.15	0.15-0.22	0.02-0.05	0.05-0.10

Vc - Cutting Speed [m/min]

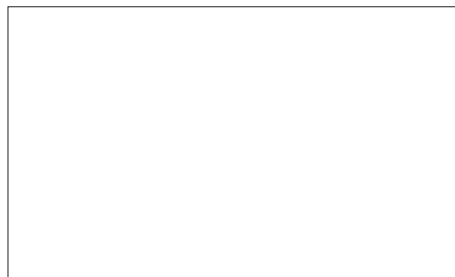
fb (Drilling) - Feed per Revolution [mm/rev]

fz (Threading) - Feed per Tooth [mm/tooth]

Grade	Application
VTN	Uncoated grade, First choice for Aluminum and general use.
VTS	TiAlN coated grade, First choice for Cast iron, and general use.

VARDEX
Threading Solutions

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