meusburger

CARBIDE THREAD MILLING CUTTER FOR BSP THREADS | WZG 17531

| G | | | < 1.400 N/mm² | | Z | 55° P |

PRODUCT DESCRIPTION
» For BSP threads
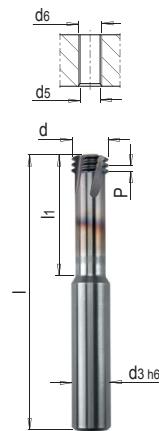
MATERIAL
» Carbide, TiCN coated

P	M	K	N	S	H
●	●	●	●	●	○
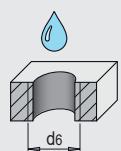
Z	d3	l	l1	d	d5	d6	Threads/inch	No.	EUR
4	8	64	19.5	6.2	6.8 8.8	G 1/16" G 1/8"	28	WZG 17531/28G	< >
4	10	73	25	9.95	11.8 15.25	G 1/4" G 3/8"	19	WZG 17531/19G	< >
4	12	84	37	11.95	19 21 24.5 28.25	G 1/2" G 5/8" G 3/4" G 7/8"	14	WZG 17531/14G	< >
5	16	105	44	15.95	30.75 35.5 39.5 45.25 51 57	G 1" G 1 1/8" G 1 1/4" G 1 1/2" G 1 3/4" G 2"	11	WZG 17531/11G	< >

ℹ Information on thread milling from page PL

REFERENCE VALUES FOR THREAD MILLING

WZG 17131 WZG 17531	Material	Strength	Vc[1] m/min.	Feed per tooth [fz] in mm, depending on the cutter´s Ø (conventional milling)										
				2	3	4	5	6	7	8	9	10	12	14
				f[2] (mm/z)										
	1.1730	640 N/mm²	80	0,015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
	1.2083	780 N/mm²	80	0,015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
	1.2085	1080 N/mm²	70	0,011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
	1.2162	660 N/mm²	80	0,015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
	1.2311	1080 N/mm²	70	0,011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
	1.2312	1080 N/mm²	70	0,011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
	1.2316	1010 N/mm²	70	0,011	0.015	0.015	0.020	0.025	0.025	0.030	0.035	0.040	0.040	0.040
	1.2343	780 N/mm²	80	0,015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
	1.2379	780 N/mm²	80	0,015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
	1.2714HH	1350 N/mm²	60	0,019	0.025	0.025	0.030	0.035	0.035	0.040	0.045	0.050	0.050	0.055
	1.2767	830 N/mm²	80	0,015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
	1.2842	775 N/mm²	80	0,015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.050	0.050
	Steel	1400 N/mm²	60	0,019	0.025	0.025	0.030	0.035	0.035	0.040	0.045	0.050	0.050	0.055

1) Vc: cutting speed (m/min.)　　　　2) f: feed per cut (mm per tooth)

» In principle, conventional milling (up-cut milling) is recommended.

» If the material's hardness is greater than 40 HRC [1300N/mm²], 2 runs are recommended (2/3 - 1/3, radial).

» Use peripheral cooling.

ℹ You can find further materials and cutting values in the cutting data calculator.