

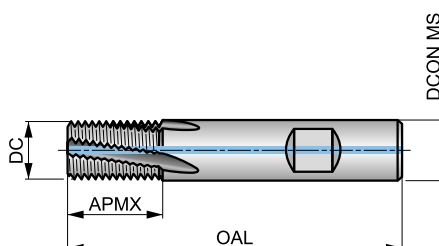
J245

DORMER



Solid Carbide Thread Mill with Through Coolant, UNF

Universal high performance tool to machine same or bigger diameters than the TDZ with the same pitch. Left or right-hand, through or blind holes almost down to the bottom. With Alcrona Pro coated for the best machining result and through coolant for better chip evacuation.



Workpiece material group suitability, starting values for cutting speed (m/min) and Alpha Code. Tables with feed per tooth and correction factors can be found starting from page 234.

P1.1 ■ 181 K	P1.2 ■ 203 K	P1.3 ■ 210 K	P2.1 ■ 156 K	P2.2 ■ 137 K	P2.3 ■ 121 K	P3.1 ■ 140 K	P3.2 ■ 112 K	P3.3 ■ 95 K	P4.1 ■ 83 K	P4.2 ■ 70 K	P4.3 ■ 58 K	M1.1 ■ 65 K	M1.2 ■ 55 K
M2.1 ■ 58 K	M2.2 ■ 47 K	M2.3 ■ 40 K	M3.1 ■ 50 J	M3.2 ■ 42 J	M3.3 ■ 38 J	M4.1 ■ 32 J	M4.2 ■ 27 J	K1.1 ■ 137 K	K1.2 ■ 101 K	K1.3 ■ 76 K	K2.1 ■ 129 K	K2.2 ■ 105 K	K2.3 ■ 84 K
K3.1 ■ 115 K	K3.2 ■ 87 K	K3.3 ■ 71 K	K4.1 ■ 106 J	K4.2 ■ 80 J	K4.3 ■ 59 J	K4.4 ■ 51 J	K4.5 ■ 42 J	K5.1 ■ 120 K	K5.2 ■ 90 K	K5.3 ■ 70 K	N1.1 ■ 420 L	N1.2 ■ 315 L	N1.3 ■ 210 L
N2.1 ■ 275 L	N2.2 ■ 247 L	N2.3 ■ 179 L	N3.1 ■ 640 L	N3.2 ■ 378 L	N3.3 ■ 189 L	N4.1 ■ 305 L	N4.2 ■ 153 L	N4.3 ■ 69 L	S1.1 ■ 42 J	S1.2 ■ 42 J	S1.3 ■ 32 J	S2.1 ■ 35 J	S2.2 ■ 26 J
S3.1 ■ 26 J	S3.2 ■ 22 J	S4.1 ■ 21 J	S4.2 ■ 17 J	H1.1 ■ 63 J	H3.1 ■ 45 J								

Internal Thread.

Product	TDZ	TPI	DC	APMX	OAL	DCON MS	NOF
			[mm]	[mm]	[mm]	[mm]	
J2454.8-28	1/4	28	4.80	14.00	57.0	6.00	3
J2456.0-24	5/16. 3/8	24	6.00	14.00	57.0	6.00	3
J2458.0-20	7/16. 1/2	20	8.00	19.00	63.0	8.00	4
J24510.0-18	9/16. 5/8	18	10.00	22.00	72.0	10.00	4
J24514.0-16	3/4	16	14.00	32.00	83.0	14.00	5