

## THREAD MILLING 1.4404

tool	WH-EM-PNC M4
material	1.4404 (X2CrNiMo17-12-2)
cutting speed	35 m/min
feed	0,01 per tooth
thread depth	10 mm
cooling	emulsion
machine/interface	Hermle C50 U/ HSK63
holding fixture	shrinking device
thread	blind hole



PRODUCTIVITY  
MANAGEMENT

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## THREAD MILLING 1.4301

tool	WH-EM-PNC M4
material	1.4301 (X5CrNi18-10)
cutting speed	40 m/min
feed	0,01 per tooth
thread depth	10 mm
cooling	emulsion
machine/interface	Hermle C50 U/ HSK63
holding fixture	shrinking device
thread	blind hole

PRODUCTIVITY  
MANAGEMENT

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## THREAD MILLING HASTELLOY

tool	WH-EM-PNC M4
material	Hastelloy
cutting speed	23 m/min
feed	0,005 per tooth
thread depth	8 mm
cooling	emulsion
machine/interface	Hermle C50 U/ HSK63
holding fixture	shrinking device
thread	blind hole

PRODUCTIVITY  
MANAGEMENT



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## THREAD MILLING VANADIS

tool	WH-EM-PNC M4
material	Vanadis (64 HRC)
cutting speed	25 m/min
feed	0,008 per tooth
thread depth	8 mm
cooling	air
machine/interface	Hermle C50 U/ HSK63
holding fixture	hydraulic expansion chucks
thread	blind hole

PRODUCTIVITY  
MANAGEMENT



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