



1st-cut

Andreas Stolze e.K.

Prozessoptimierung
Zerspanungslösung
Werkzeugvertrieb



Fragen zum Produkt oder
Individuelles Angebot?

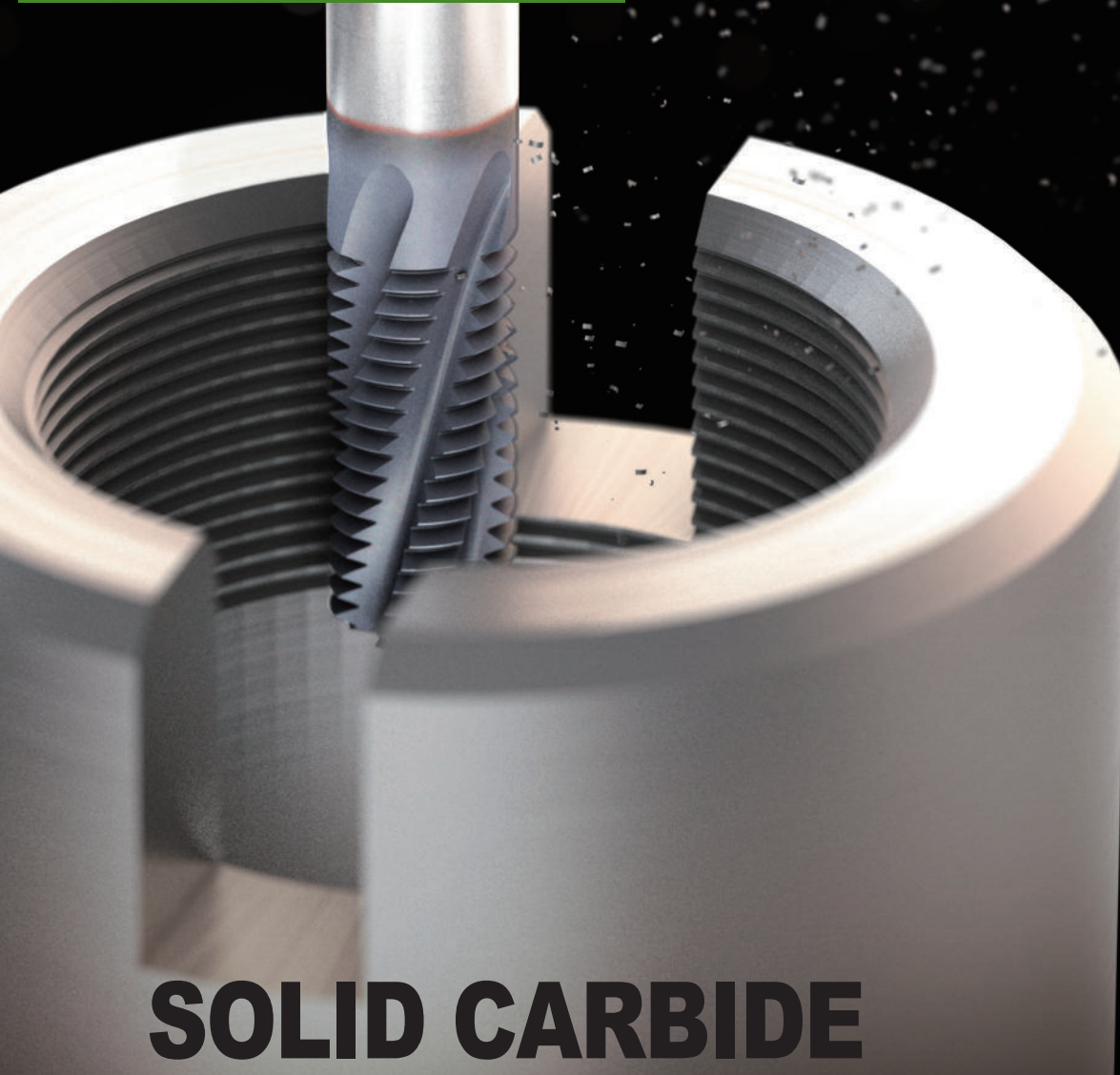
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Anwendungsspezialist

www.1st-cut.de



Leading Through Innovation



SOLID CARBIDE

THREAD MILL

GEWINDEFRÄSER

- Threading Large Diameter in High Quality Available with Chamfer
- Zur Fertigung von Gewinden mit großen Durchmessern in hoher Qualität, verfügbar mit Fase

YG THREAD MILL

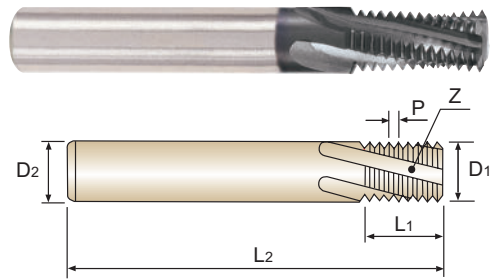
L1213 SERIES

UNC Solid Carbide Thread Mill for UNC Internal Thread - ANSI B 1.1

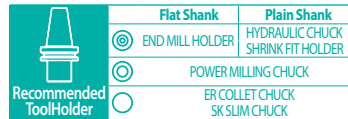
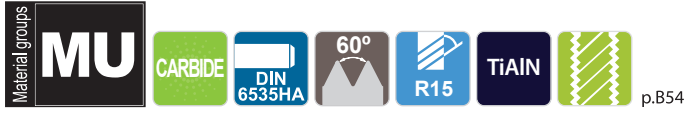
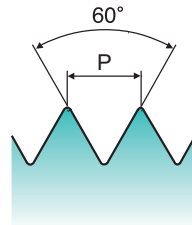
VOLLHARTMETALL GEWINDEFÄHRER für UNC INNENGEWINDE, ANSI B 1.1
 FRAISES A FILETER CARBURE MONOBLOC POUR FILETAGE INTER UNC - ANSI B 1.1
 Filettature interne, unificato, passo grosso - ANSI B 1.1

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
2×D



Unit : mm

EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flute
L1213400	1/4	20	4.5	6	14	57	3
L1213440	5/16	18	5.8	6	16.9	65	3
L1213480	3/8	16	7.0	8	20.6	72	4
L1213520	7/16	14	8.0	8	23.6	72	4
L1213560	1/2	13	9.5	10	27.4	80	4
L1213600	9/16	12	10.0	10	31.8	83	4
L1213640	5/8	11	12.0	12	34.6	92	4
L1213700	3/4	10	14.0	14	40.6	104	5

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	38	40	42	45	48	50	52	55	58	60	63	65	68	70	72	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	

ISO	N				S						H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○	○	○

YG THREAD MILL

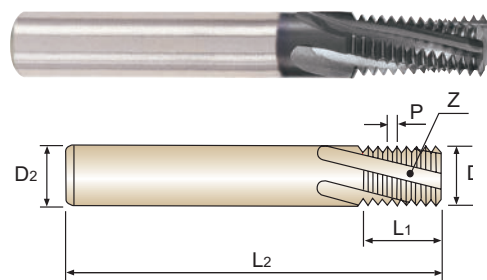
L1214 SERIES

UNF Solid Carbide Thread Mill for UNF Internal Thread - ANSI B 1.1

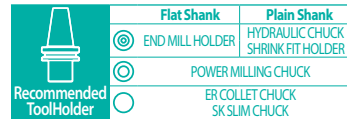
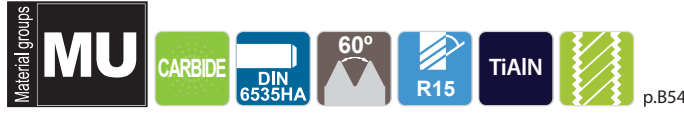
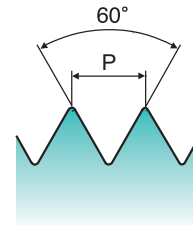
VOLLHARTMETALL GEWINDEFÄHRER für UNF INNENGEWINDE, ANSI B 1.1
 FRAISES A FILETER CARBURE MONOBLOC POUR FILETAGE INTER UNC - ANSI B 1.1
 Filettature interne, unificato, passo grosso - ANSI B 1.1

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
2×D



Unit : mm

EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flute
L1214420	1/4	28	5.0	6	13.6	57	3
L1214460	5/16	24	6.0	6	16.9	65	3
L1214500	3/8	24	8.0	8	20.1	72	4
L1214540	7/16	20	8.0	8	24.1	72	4
L1214580	1/2	20	10.0	10	26.7	80	4
L1214620	9/16	18	12.0	12	29.6	83	4
L1214660	5/8	18	12.0	12	33.9	92	4
L1214720	3/4	16	14.0	14	39.7	104	5

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	38	40	42	45	48	50	52	55	58	60	63	65	68	70	72	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	◎	◎	◎	◎	◎	◎	

ISO	N				S						H										
	Aluminum-wrought alloy		Aluminum-cast, alloyed		Copper and Copper Alloys (Bronze / Brass)		Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron		
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	○	○	○	○	○	○	○	○	○	○	○

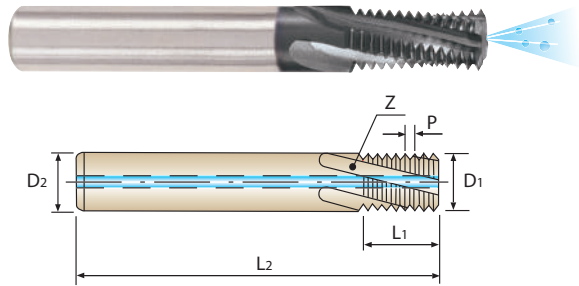
YG THREAD MILL

L4211 SERIES

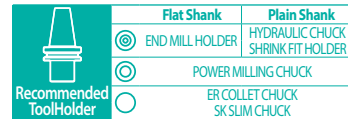
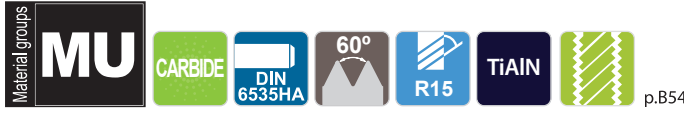
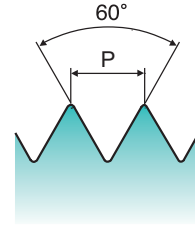
M Solid Carbide Thread Mill with Coolant Hole for ISO Metric Internal Thread - DIN 13
 VOLLHARTMETALL GEWINDEFÄHRER mit KÜHLKANAL für ISO METRISCHES INNENGEWINDE - DIN 13
 FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL POUR FILETAGE ISO INTER MÉTRIQUE - DIN13
 Con fori di lubrificazione, Filettature interne, ISO metriche, passo grosso - DIN 13

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
2×D



EDP No.	Nominal Diameter [D]	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flute
TiAlN	D1	P	D1	D2	L1	L2	Z
L4211310	M6	1.0	4.5	6	13.0	57	3
L4211360	M8	1.25	6.0	6	17.5	65	3
L4211420	M10	1.5	7.5	8	21.0	72	4
L4211500	M12	1.75	9.5	10	26.25	80	4
L4211540	M14	2.0	10.0	10	30.0	83	4
L4211600	M16	2.0	12.0	12	34.0	92	4
L4211700	M20	2.5	16.0	16	42.5	105	5

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M						K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel			Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	260	160	250	130	230			
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

ISO	N										S						H						
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

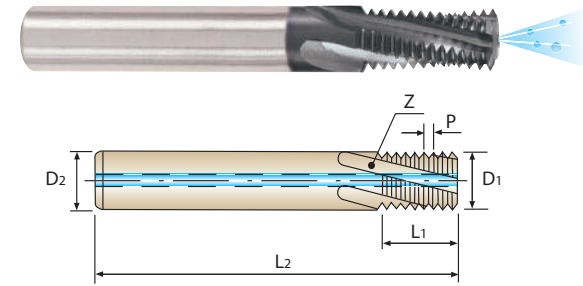
YG THREAD MILL

L4212 SERIES

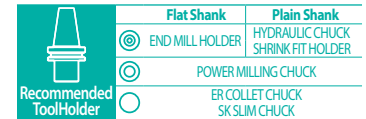
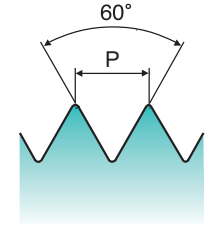
MF Solid Carbide Thread Mill with Coolant Hole for ISO Metric Internal Thread - DIN 13
 VOLLHARTMETALL GEWINDEFÄHRER mit KÜHLKANAL für ISO METRISCH - FEIN INNENGEWINDE - DIN 13
 FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL POUR FILETAGE ISO INTER MÉTRIQUE - DIN13
 Con fori di lubrificazione, Filettature interne, ISO metriche, passo grosso - DIN 13

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
1.5×D



EDP No.	Nominal Diameter [D]	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flute
TiAlN	D1	P	D1	D2	L1	L2	Z
L4212370	M8	1.0	6.0	6	13.0	57	3
L4212380	M8	0.75	6.0	6	12.75	57	3
L4212440	M10	1.0	8.0	8	16.0	63	4
L4212510	M12	1.5	9.5	10	19.5	72	4
L4212520	M12	1.25	9.5	10	18.75	72	4
L4212530	M12	1.0	9.5	10	19.0	72	4
L4212550	M14	1.5	10.0	10	22.5	83	4
L4212570	M14	1.0	10.0	10	22.0	83	4
L4212610	M16	1.5	12.0	12	25.5	83	4
L4212620	M16	1.0	12.0	12	25.0	83	4
L4212670	M18	1.5	14.0	14	28.5	92	5
L4212680	M18	1.0	14.0	14	28.0	92	5
L4212720	M20	1.5	16.0	16	31.5	92	5
L4212730	M20	1.0	16.0	16	31.0	92	5

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M						K					
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel			Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20		
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21			
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	260	160	250	130	230			
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

ISO	N										S						H						
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys				Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41		
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	55	60	42	55		
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550		
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	

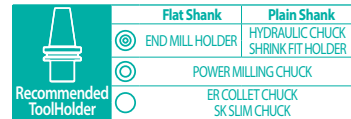
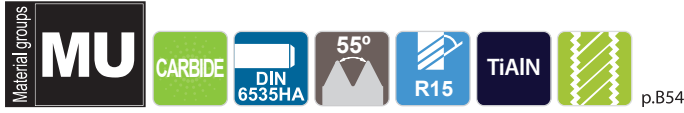
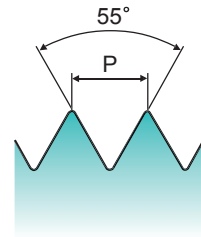
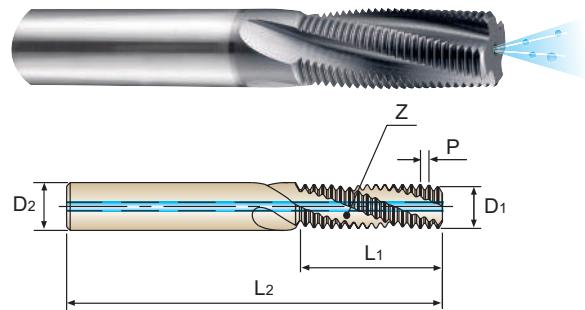
YG THREAD MILL

L6215 SERIES

BSP(G) Solid Carbide Thread Mill with Coolant Hole for BSP(G) Internal/External Thread
 ● VOLLHARTMETALL GEWINDEFÄRÄSER mit KÜHLKANAL für BSP (G) INNEN- /AUSSENGEWINDE
 ○ FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL POUR FILETAGE INTERNE/EXTERNE BSP(G)
 ○ Fresa con fori di lubrificazione, filettature interne ed esterne, BSP(G)

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Unit : mm

EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	No. of Flute
TiAlN	[D]		D1	D2	L1	L2	Z
L6215020	1/16	28	5.9	6	16.3	65	3
L6215200	1/8	28	7.9	8	20.0	70	4
L6215400	1/4	19	9.9	10	26.7	80	4
L6215480	3/8	19	13.9	14	33.4	92	4
L6215560	1/2	14	15.9	16	43.5	104	5
L6215700	3/4	14	17.9	18	34.5	100	5
L6215780	1	11	19.9	20	34.6	100	5

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

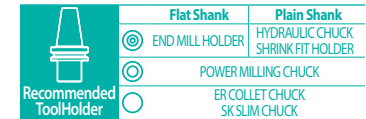
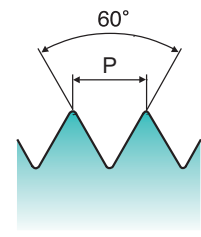
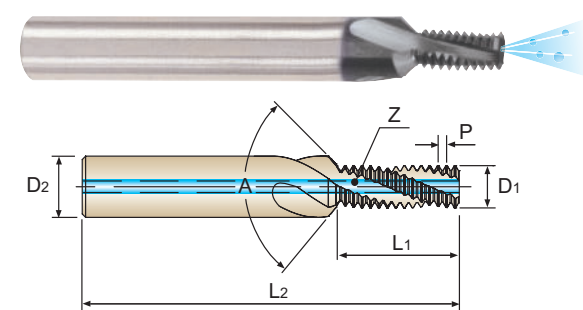
YG THREAD MILL

L4271 SERIES

M Solid Carbide Thread Mill with Coolant Hole & Chamfer for ISO Metric Internal Thread - DIN 13
 ● VOLLHARTMETALL GEWINDEFÄRÄSER mit KÜHLKANAL & FASE für METRISCHES INNENGEWINDE - DIN 13
 ○ FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL ET CHANFREIN POUR FILETAGE ISO INTER MÉTRIQUE DIN13
 ○ Con fori di lubrificazione e taglienti per smussi, filettature interne, ISO metriche - DIN 13

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Unit : mm

EDP No.	Nominal Diameter [D]	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Overall Length	Angle	No. of Flute
TiAlN	[D]	P	D1	D2	L1	L2	A	Z
L4271310	M6	1.0	4.8	8	12.4	62	90°	3
L4271360	M8	1.25	6.5	10	16.8	74	90°	3
L4271420	M10	1.5	8.2	12	20.15	80	90°	4
L4271500	M12	1.75	9.9	14	25.25	90	90°	4
L4271540	M14	2.0	11.6	16	28.85	100	90°	4
L4271600	M16	2.0	13.6	18	32.85	102	90°	4

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

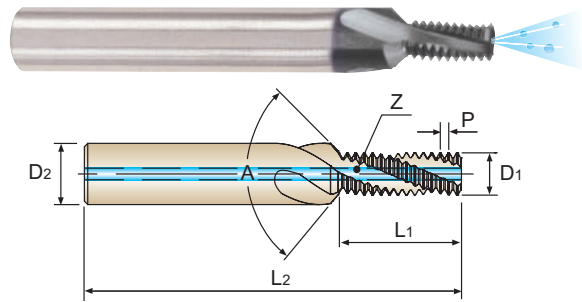
YG THREAD MILL

L4272 SERIES

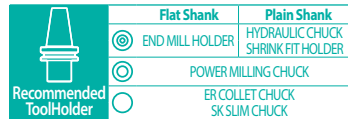
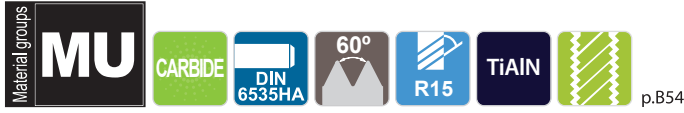
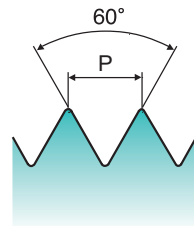
MF Solid Carbide Thread Mill with Coolant Hole & Chamfer for ISO Metric Internal Thread - DIN 13
 ● VOLLHARTMETALL GEWINDEFÄHRER mit KÜHLKANAL & FASE für METRISCH - FEIN INNENGEWINDE - DIN 13
 ○ FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL ET CHANFREIN POUR FILETAGE ISO INTER MÉTRIQUE DIN13
 ○ Con fori di lubrificazione e taglienti per smussi, filettature interne, ISO metriche, passo fine - DIN 13

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
1.5×D



EDP No.	Nominal Diameter [D]	Pitch P	Cutter Diameter D1	Shank Diameter D2	Thread Length L1	Overall Length L2	Angle A	No. of Flute Z	
L4272370	M8	1.0	6.7	10	12.4	74	90°	3	
L4272430	M10	1.25	8.3	12	15.9	80	90°	4	
L4272440	M10	1.0	8.7	12	15.4	80	90°	4	
L4272510	M12	1.5	10.0	14	18.65	90	90°	4	
L4272520	M12	1.25	10.3	14	18.3	80	90°	4	
L4272530	M12	1.0	10.7	14	18.4	90	90°	4	
L4272550	M14	1.5	12.0	16	21.65	100	90°	4	
L4272610	M16	1.5	14.0	18	24.65	102	90°	5	

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

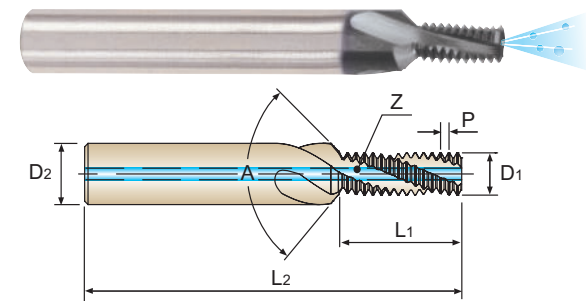
YG THREAD MILL

L4273 SERIES

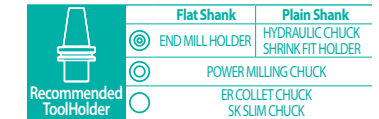
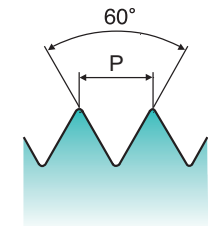
UNC Solid Carbide Thread Mill with Coolant Hole & Chamfer for UNC Internal Thread - ANSI B 1.1
 ● VOLLHARTMETALL GEWINDEFÄHRER mit KÜHLKANAL & FASE für UNC INNENGEWINDE - ANSI B 1.1
 ○ FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL ET CHANFREIN POUR FILETAGE INTER UNC - ANSI B 1.1
 ○ Con fori di lubrificazione e taglienti per smussi, filettature interne, unificato, passo grosso - ANSI B 1.1

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
2×D



EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter D1	Shank Diameter D2	Thread Length L1	Overall Length L2	Angle A	No. of Flute Z	
L4273400	1/4	20	4.8	8	13.3	62	90°	3	
L4273440	5/16	18	6.2	10	16.18	74	90°	3	
L4273480	3/8	16	7.6	12	19.8	80	90°	4	
L4273520	7/16	14	8.9	12	22.62	80	90°	4	
L4273560	1/2	13	10.3	14	26.32	90	90°	4	
L4273600	9/16	12	11.7	16	30.63	100	90°	4	
L4273640	5/8	11	13.1	18	33.41	102	90°	4	
L4273700	3/4	10	16.0	20	39.29	110	90°	5	

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

YG THREAD MILL

L4274 SERIES

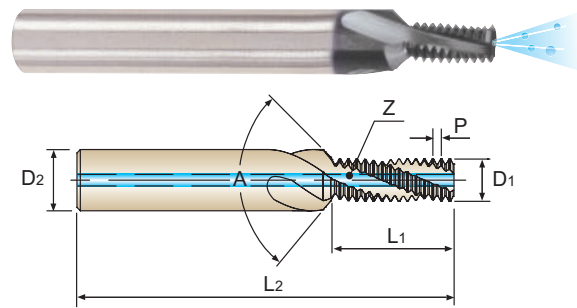
UNF

Solid Carbide Thread Mill with Coolant Hole & Chamfer for UNF Internal Thread - ANSI B 1.1

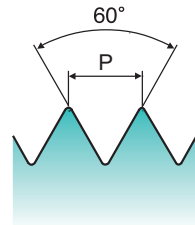
- VOLLHARTMETALL GEWINDEFÄHRER mit KÜHLKANAL & FASE für UNF INNENGEWINDE - ANSI B 1.1
- FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL ET CHANFREIN POUR FILETAGE INTER UNC - ANSI B 1.1
- Con fori di lubrificazione e taglienti per smussi, filettature interne, unificato, passo fine - ANSI B 1.1

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Thread Depth
2×D



Recommended ToolHolder	Flat Shank		Plain Shank	
	⊙	END MILL HOLDER	⊙	HYDRAULIC CHUCK SHRINK FIT HOLDER
	⊙	POWER MILLING CHUCK	⊙	POWER MILLING CHUCK
	⊙	ER COLLET CHUCK SK SLIM CHUCK	⊙	ER COLLET CHUCK SK SLIM CHUCK

Unit : mm

EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter D1	Shank Diameter D2	Thread Length L1	Overall Length L2	Angle A	No. of Flute Z
L4274420	1/4	28	5.1	8	13.21	62	90°	3
L4274460	5/16	24	6.5	10	16.37	74	90°	3
L4274500	3/8	24	8.1	12	19.54	80	90°	4
L4274540	7/16	20	9.4	12	22.19	80	90°	4
L4274580	1/2	20	11.0	14	26	90	90°	4
L4274620	9/16	18	12.4	16	28.88	100	90°	4
L4274660	5/8	18	14.0	18	33.12	102	90°	5
L4274720	3/4	16	17.0	20	38.86	110	90°	5

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	N										S					H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41			
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550			
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

YG THREAD MILL

L4276 SERIES

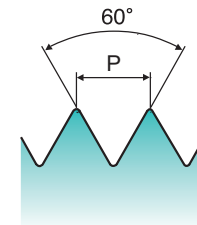
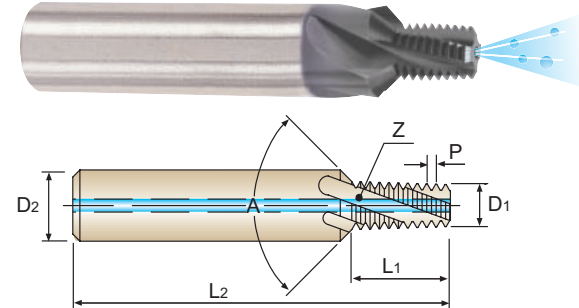
NPT

Solid Carbide Thread Mill with Coolant Hole & Chamfer for NPT Thread - ANSI B 1.20.1

- VOLLHARTMETALL GEWINDEFÄHRER mit KÜHLKANAL & FASE für NPT INNENGEWINDE - ANSI B 1.20.1
- FRAISES A FILETER CARBURE MONOBLOC AVEC ARROSAGE CENTRAL ET CHANFREIN POUR FILETAGE INTER NPT - ANSI B 1.20.1
- Con fori di lubrificazione e taglienti per smussi, filettature interne, unificato, passo fine - ANSI B 1.1

► Easy to cut threads even for exotic materials like Nickel, Titanium and their alloys.

► Problemloses Gewindeschneiden sogar in exotischen Werkstoffen, wie Nickel, Titan und ihre Legierungen.



Recommended ToolHolder	Flat Shank		Plain Shank	
	⊙	END MILL HOLDER	⊙	HYDRAULIC CHUCK SHRINK FIT HOLDER
	⊙	POWER MILLING CHUCK	⊙	POWER MILLING CHUCK
	⊙	ER COLLET CHUCK SK SLIM CHUCK	⊙	ER COLLET CHUCK SK SLIM CHUCK

Unit : mm

EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter D1	Shank Diameter D2	Thread Length L1	Overall Length L2	Angle A	No. of Flute Z
L4276020	NPT1/16	27	5.9	10	8.9	64	90°	3
L4276200	NPT1/8	27	7.8	12	8.9	70	90°	4
L4276400	NPT1/4	18	10.05	16	13.4	81	90°	4
L4276480	NPT3/8	18	13.45	18	13.4	81	90°	4

► Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO Material Description	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21		
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO Material Description	N										S					H								
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)					Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron		Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41			
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55	42	55			
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550			
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎		

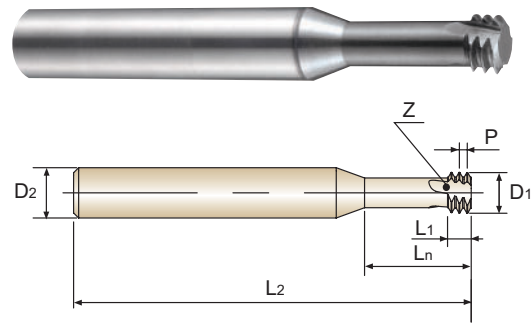
Y/G THREAD MILL

L12D1 SERIES

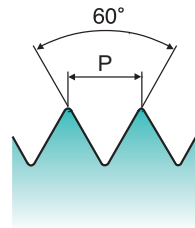
M Solid Carbide Miniature Thread Mill for ISO Metric Internal Thread - DIN 13
 ● VOLLHARTMETALL MINI-GEWINDEFÄRER für ISO METRISCHE INNENGEWINDE - DIN 13
 ● FRAISES A FILETER À TOUBILLONNER CARBURE MONOBLOC POUR FILETAGE ISO INTER MÉTRIQUE - DIN 13
 ● Mini frese per filettature interne ISO metriche passo grosso - DIN 13

▶ Short thread length

▶ Kurze Gewindelänge



Thread Depth
2×D



Material groups: **MU** CARBIDE DIN 6535HA 60° R15 TiAlN p.B55

Recommended ToolHolder: Flat Shank (END MILL HOLDER), Plain Shank (HYDRAULIC CHUCK SHRINK FIT HOLDER), POWER MILLING CHUCK, ER COLLET CHUCK SK SUM CHUCK

EDP No.	Nominal Diameter [D]	Pitch P	Cutter Diameter D1	Shank Diameter D2	Thread Length L1	Neck Length Ln	Overall Length L2	No. of Flute Z
L12D1010	M1	0.25	0.70	3	0.75	2.1	30	3
L12D1050	M1.2	0.25	0.90	3	0.75	2.5	30	3
L12D1070	M1.4	0.3	1.04	3	0.90	2.9	30	3
L12D1090	M1.6	0.35	1.18	3	1.05	3.4	30	3
L12D1130	M2	0.4	1.52	6	1.2	4.2	57	3
L12D1150	M2.2	0.45	1.66	6	1.35	4.6	57	3
L12D1170	M2.5	0.45	1.96	6	1.35	5.3	57	3
L12D1200	M3	0.5	2.4	6	1.5	6.3	57	3
L12D1240	M4	0.7	3.16	6	2.1	8.4	57	3
L12D1280	M5	0.8	4.04	6	2.4	10.5	57	3
L12D1310	M6	1.0	4.8	6	3.0	12.6	57	3
L12D1360	M8	1.25	6.5	8	3.75	16.8	63	3
L12D1420	M10	1.5	8.2	10	4.5	21.0	73	3
L12D1500	M12	1.75	9.9	10	5.25	25.2	73	3

▶ Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

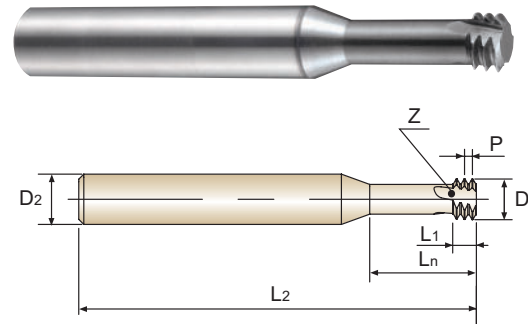
Y/G THREAD MILL

L12D3 SERIES

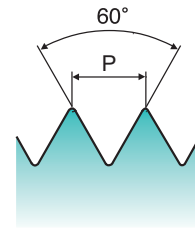
UNC Solid Carbide Miniature Thread Mill for UNC Internal Thread - ANSI B 1.1
 ● VOLLHARTMETALL MINI-GEWINDEFÄRER für UNC INNENGEWINDE - ANSI B 1.1
 ● FRAISES A FILETER À TOUBILLONNER CARBURE MONOBLOC POUR FILETAGE POUR FILETAGE INTER UNC-ANSI B 1.1
 ● Mini frese per filettature interne unificato passo grosso - ANSI B 1.1

▶ Short thread length

▶ Kurze Gewindelänge



Thread Depth
2×D



Material groups: **MU** CARBIDE DIN 6535HA 60° R15 TiAlN p.B55

Recommended ToolHolder: Flat Shank (END MILL HOLDER), Plain Shank (HYDRAULIC CHUCK SHRINK FIT HOLDER), POWER MILLING CHUCK, ER COLLET CHUCK SK SUM CHUCK

EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter D1	Shank Diameter D2	Thread Length L1	Neck Length Ln	Overall Length L2	No. of Flute Z
L12D3040	#1	64	1.38	6	1.19	3.9	57	3
L12D3080	#2	56	1.64	6	1.36	4.6	57	3
L12D3160	#4	40	2.08	6	1.91	6.0	57	3
L12D3240	#6	32	2.55	6	2.38	7.4	57	3
L12D3280	#8	32	3.21	6	2.38	8.7	57	3
L12D3320	#10	24	3.56	6	3.18	10.1	57	3
L12D3360	#12	24	4.22	6	3.18	11.5	57	3
L12D3400	1/4	20	4.83	6	3.81	13.3	57	3
L12D3440	5/16	18	6.24	8	4.23	16.7	63	3
L12D3480	3/8	16	7.62	8	4.76	20.0	63	3
L12D3520	7/16	14	8.94	10	5.44	23.3	73	3

▶ Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron	Nodular cast iron		Malleable cast iron	
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	38	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel	Chilled Cast Iron	Hardened Cast Iron		
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎

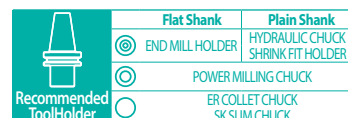
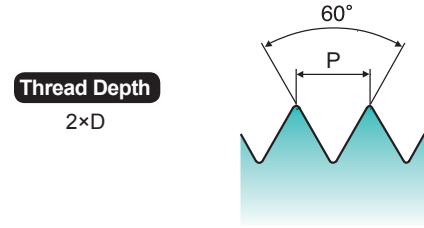
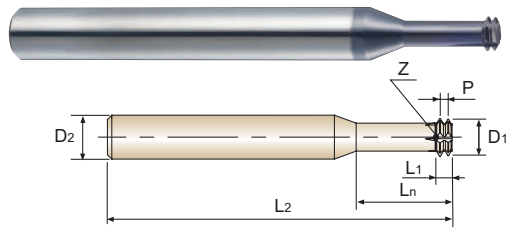
YG THREAD MILL

L19E1 SERIES

M Solid Carbide Miniature Thread Mill for Hard Materials, ISO Metric Internal Thread - DIN 13
 VOLLHARTMETALL MINI-GEWINDEFÄHRER für GEHÄRTETE MATERIALIEN, ISO METRISCHE INNENGEWINDE - DIN 13
 FRAISES À TOURBILLONNER CARBURE MONOBLOC POUR MATÉRIEAUX DURS, FILETAGE ISO INTER MÉTRIQUE - DIN13
 Mini frese per acciai temprati ISO metriche passo grosso - DIN 13

- ▶ Left hand Cut (CNC code : M04)
- ▶ Short thread length
- ▶ Straight Flute
- ▶ The work direction is from top to bottom (Climb Milling)
- ▶ For hard materials up to HRC62

- ▶ Linksschneidend (CNC Befehl : M04)
- ▶ Kurze Gewindelänge
- ▶ Linksschneidend, geradegenutet
- ▶ Die Fräsrichtung ist von oben nach unten (Gleichlauf)
- ▶ Für gehärtete Materialien bis zu HRC62



EDP No.	Nominal Diameter [D]	Pitch	Cutter Diameter	Shank Diameter	Thread Length	Neck Length	Overall Length	No. of Flute
AITiN	P	D1	D2	L1	Ln	L2	Z	
L19E1130	M2	0.4	1.52	6	0.8	4.2	57	4
L19E1150	M2.2	0.45	1.66	6	0.9	4.6	57	4
L19E1170	M2.5	0.45	1.96	6	0.9	5.3	57	4
L19E1200	M3	0.5	2.4	6	1.0	6.3	57	4
L19E1240	M4	0.7	3.16	6	1.4	8.4	57	4
L19E1280	M5	0.8	4.04	6	1.6	10.5	57	4
L19E1310	M6	1.0	4.8	6	2.0	12.6	57	5
L19E1360	M8	1.25	6.5	8	2.5	16.8	63	5
L19E1420	M10	1.5	8.2	10	3.0	21.0	73	6
L19E1500	M12	1.75	9.9	10	3.5	25.2	73	6

▶ Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended						○	○	○	○	○	○	○	○	○	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55	55	60	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended						◎	◎	◎	◎	◎	○	○	○	○	○	◎	◎	◎	◎	◎	◎	◎

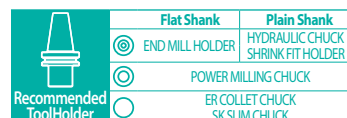
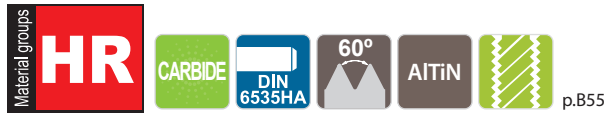
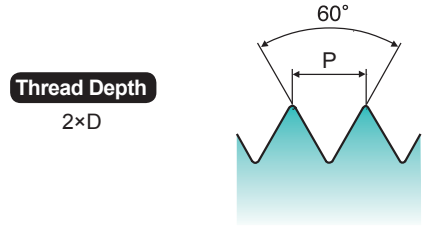
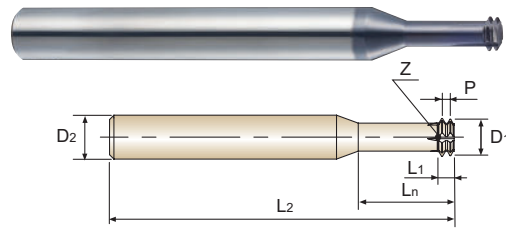
YG THREAD MILL

L19E3 SERIES

UNC Solid Carbide Miniature Thread Mill for Hard Materials, UNC Internal Thread - ANSI B 1.1
 VOLLHARTMETALL MINI-GEWINDEFÄHRER für GEHÄRTETE MATERIALIEN, UNC INNENGEWINDE - ANSI B 1.1
 FRAISES À TOURBILLONNER CARBURE MONOBLOC POUR MATÉRIEAUX DURS POUR FILETAGE INTER UNC - ANSI B 1.1
 Mini frese per acciai temprati unificato passo grosso - ANSI B 1.1

- ▶ Left hand Cut (CNC code : M04)
- ▶ Short thread length
- ▶ Straight Flute
- ▶ The work direction is from top to bottom (Climb Milling)
- ▶ For hard materials up to HRC62

- ▶ Linksschneidend (CNC Befehl : M04)
- ▶ Kurze Gewindelänge
- ▶ Linksschneidend, geradegenutet
- ▶ Die Fräsrichtung ist von oben nach unten (Gleichlauf)
- ▶ Für gehärtete Materialien bis zu HRC62



EDP No.	Nominal Diameter [D]	TPI	Cutter Diameter	Shank Diameter	Thread Length	Neck Length	Overall Length	No. of Flute
AITiN	D		D1	D2	L1	Ln	L2	Z
L19E3080	#2	56	1.64	6	0.91	4.6	57	4
L19E3160	#4	40	2.08	6	1.27	6.0	57	4
L19E3240	#6	32	2.55	6	1.59	7.4	57	4
L19E3280	#8	32	3.21	6	1.59	8.7	57	4
L19E3320	#10	24	3.56	6	2.12	10.1	57	4
L19E3360	#12	24	4.22	6	2.12	11.5	57	4
L19E3400	1/4	20	4.83	6	2.54	13.3	57	5
L19E3440	5/16	18	6.24	8	2.82	16.7	63	5
L19E3480	3/8	16	7.62	8	3.18	20.0	63	6
L19E3520	7/16	14	8.94	10	3.63	23.3	73	6

▶ Other coatings are available on your request.

◎ : Excellent ○ : Good

ISO	P										M				K						
	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel				Stainless steel		Grey cast iron		Nodular cast iron		Malleable cast iron
Material Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	
HRc	13	25	28	32	35	10	29	32	38	15	35	15	23	10	10	26	3	25	21	21	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	
Recommended						○	○	○	○	○	○	○	○	○	◎	◎	◎	◎	◎	◎	◎

ISO	N					S					H											
	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron	
Material Description	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	
HRc	21	22	23	24	25	26	27	28	29	30	15	30	25	38	34	55	60	42	55	55	60	
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400Rm	1050Rm	550	630	400	550	
Recommended						◎	◎	◎	◎	◎	○	○	○	○	○	◎	◎	◎	◎	◎	◎	◎



**RECOMMENDED CUTTING CONDITIONS
EMPFOLGENE SCHNEIDKONDITIONEN**

					L1211	L1212	L1213	L1214	L4211	L4212	L6215	L4271	L4272	
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min.)									
P	1	Non-alloy steel	125		80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	2		190	13	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	3		250	25	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	4		270	28	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	5		300	32	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	6	Low alloy steel	180	10	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	7		275	29	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	8		300	32	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	9		350	38	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	10	High alloyed steel, and tool steel	200	15	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
	11		325	35	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	80-120	
M	12	Stainless steel	200	15	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	
	13		240	23	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	
	14		180	10	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	40-80	
K	15	Grey cast iron	180	10	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	
	16		260	26	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	
	17	Nodular cast iron	160	3	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	
	18		250	25	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	
	19		130		50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	
20	Malleable cast iron	230	21	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100	50-100		
N	21	Aluminum-wrought alloy	60		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	22		100		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	23	Aluminum-cast, alloyed	75		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	24		90		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	25		130		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	26		110		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	27		Copper and Copper Alloys (Bronze / Brass)	90		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300
	28			100		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300
	29		Non Metallic Materials			100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300
	30					100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300
S	31	Heat Resistant Super Alloys	200	15	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	32		280	30	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	33		250	25	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	34		350	38	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	35		320	34	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	36	Titanium Alloys	400Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
	37		1050Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	20-60	
H	38	Hardened steel	550	55						25-60	25-60			
	39		630	60						25-50	25-50			
	40	Chilled Cast Iron	400	42						25-70	25-70			
	41		550	55						25-60	25-60			



**RECOMMENDED CUTTING CONDITIONS
EMPFOLGENE SCHNEIDKONDITIONEN**

					L4273	L4274	L4276	L12D1	L12D3	L19E1	L19E3	L41A1 L42A1	
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min.)								
P	1	Non-alloy steel	125		80-120	80-120	80-120	80-120	80-120				
	2		190	13	80-120	80-120	80-120	80-120	80-120				
	3		250	25	80-120	80-120	80-120	80-120	80-120				
	4		270	28	80-120	80-120	80-120	80-120	80-120				
	5		300	32	80-120	80-120	80-120	80-120	80-120				
	6	Low alloy steel	180	10	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	7		275	29	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	8		300	32	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	9		350	38	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	10	High alloyed steel, and tool steel	200	15	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
	11		325	35	80-120	80-120	80-120	80-120	80-120	80-120	80-120		
M	12	Stainless steel	200	15	40-80	40-80	40-80	40-80	40-80	40-80	40-80		
	13		240	23	40-80	40-80	40-80	40-80	40-80	40-80	40-80		
	14		180	10	40-80	40-80	40-80	40-80	40-80	40-80	40-80		
K	15	Grey cast iron	180	10	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150	
	16		260	26	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150	
	17	Nodular cast iron	160	3	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150	
	18		250	25	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150	
	19		130		50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150	
20	Malleable cast iron	230	21	50-100	50-100	50-100	50-100	50-100	50-100	50-100	80-150		
N	21	Aluminum-wrought alloy	60		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	22		100		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	23	Aluminum-cast, alloyed	75		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	24		90		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	25		130		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	26		110		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300	
	27		Copper and Copper Alloys (Bronze / Brass)	90		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300
	28			100		100-300	100-300	100-300	100-300	100-300	100-300	100-300	100-300
	29		Non Metallic Materials			100-300	100-300	100-300	100-300	100-300	100-300	100-300	80-150
	30					100-300	100-300	100-300	100-300	100-300	100-300	100-300	80-150
S	31	Heat Resistant Super Alloys	200	15	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
	32		280	30	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
	33		250	25	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
	34		350	38	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
	35		320	34	20-60	20-60	20-60	20-60	20-60	20-60	20-60		
	36	Titanium Alloys	400Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60		
	37		1050Rm		20-60	20-60	20-60	20-60	20-60	20-60	20-60		
H	38	Hardened steel	550	55							25-60	25-60	
	39		630	60							25-50	25-50	
	40	Chilled Cast Iron	400	42							25-70	25-70	
	41		550	55							25-60	25-60	

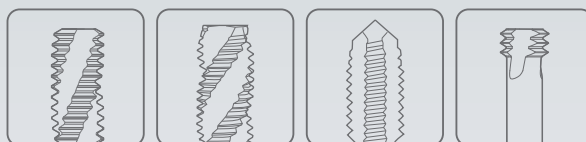
**TO CALCULATE SPEED & FEED RATES
SCHNITTGESCHWINDIGKEIT & VORSCHUB KALKULIEREN**

Calculate RPM of Cutter	Calculate Feed per Revolution	Finally Calculate Feed at Tool Center Line
$n = \frac{1000 \times V}{d \times \pi}$	$F_1 = F_z \times Z \times N$	$F_2 = \frac{F_1 \times (D - d)}{D}$

- N** RPM
- V** Recommended Cutting Speed
- d** Diameter of Cutter
- Fz** Recommended Feed per Tooth
- Z** Number of Teeth
- F2** Feed at Center Line of Cutting
- F1** Feed at Cutting Edge
- D** Major Diameter of Component



Global Cutting Tool Leader **YG-1**



THREADING