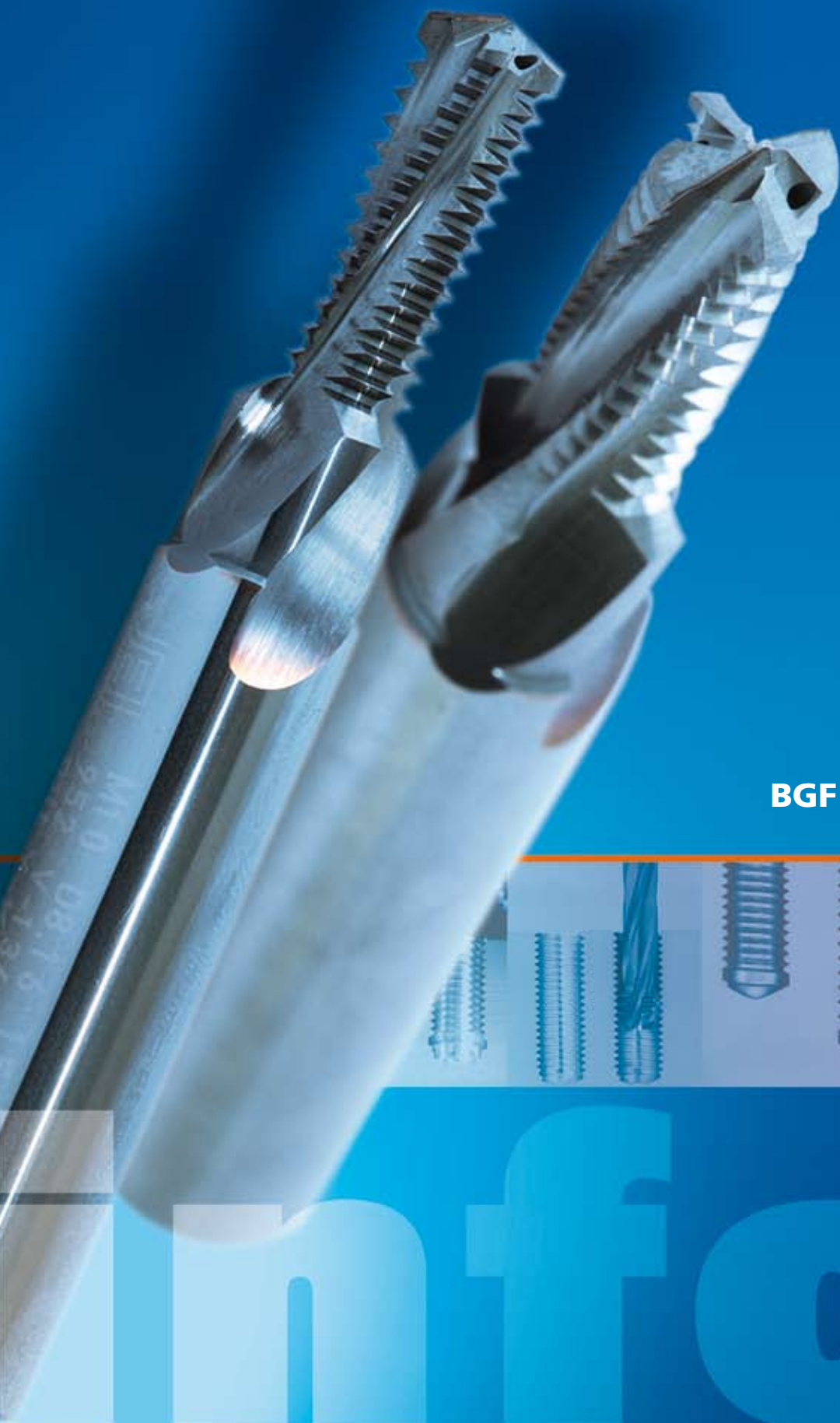


Drill Thread Milling Tool

BGF NZ4



info




Drill Thread Milling Tool NZ4 - Economic thread production

Advantages:

- up to 30% shorter cycle time vs. 2-fluted BGF into grey cast iron
- higher tool life

Recommended cutting data Drill thread milling

Guidelines			Drill thread milling cutters					
Material	Material groups	Hardness (HB)	Strength (N/mm ²)	v_c	f_b		f_z	
				AlCrN				
				Surface				
				Nominal Ø	≤6 mm	≤12 mm	≤6 mm	≤12 mm
								
3. Cast iron	K 3.1 Grey cast iron	≤150	≤500	80-120	0,10-0,14	0,15-0,30	0,02-0,08	0,05-0,16
	K 3.2 Grey cast iron , heat treated	>150, ≤300	>500, ≤1000	80-120	0,10-0,14	0,15-0,30	0,02-0,06	0,05-0,14
7. Aluminium/ Magnesium	N 7.4 Alu cast alloy, Si <10 %	<180	≤600	100-400	0,10-0,25	0,20-0,25	0,03-0,06	0,06-0,10
	N 7.5 Alu cast alloy, Si ≥10 %	≤180	≤600	100-300	0,10-0,25	0,20-0,25	0,03-0,06	0,06-0,10

v_c = Cutting speed in mm
 f_b = Drilling feed in mm/rev.
 f_z = Milling feed in mm/tooth

CNC programs can be configured on line at <http://tpt.kometgroup.com> or can be obtained on request from tel.: +49 (0) 711 78891-0

Note:

The application details given depend on the environmental and application conditions (e.g. machine, ambient temperature, lubricant/coolant used and machining result required): they are based on the correct application conditions, correct use and compliance with the spindle speed limits given for the tools.

Application Example: Housing out of grey cast iron GG25

Drill-/Thread Milling Cutter M10, Z=4, 2,0D, coolant through, AlCrN coated

Drilling, Chamfering and Thread Milling

Cutting speed: 80 m/min

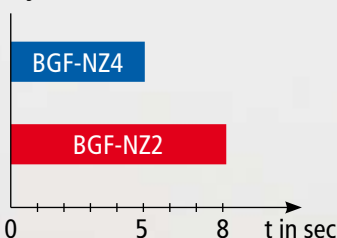
Drilling: $f=0.3$ mm/rev.

Thread milling: $fz=0.12$ mm/tooth

Cycle time: 5,4 s

Tool life: 25.000 threads

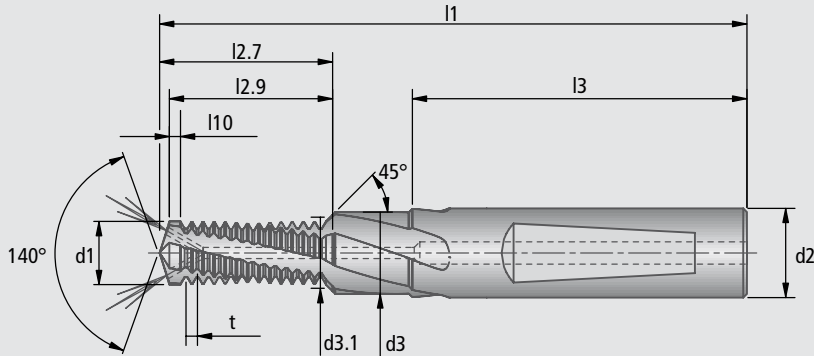
Cycle time:



with 4 cutting edges with rear chamfer 1.5xD; 2.0xD and 2.5xD

For metric ISO thread DIN 13
Shank Ø DIN 6535 Form HE/HA

Tools with internal coolant supply
Cutting material: solid carbide



M-BGF 1,5xD													AICrN - HE	AICrN - HA
Nominal Ø	t	l1	l2.7	l2.9	l3	l10	d1	d2	d3	d3.1	AD	Z	Order No.	Order No.
M6	1,00	59,0	11,5	10,7	36	1,0	5,0	8	6,6	6,3	4,85	4	80369001000018	88369001000018
M8	1,25	70,3	14,3	13,3	40	1,3	6,8	10	9,0	8,3	6,61	4	80369001000020	88369001000020
M10	1,50	74,7	18,8	17,5	45	1,5	8,5	12	11,0	10,3	8,29	4	80369001000022	88369001000022
M12	1,75	83,8	21,6	20,0	45	1,5	10,3	14	13,5	12,3	10,00	4	80369001000024	88369001000024
M14	2,00	94,0	24,8	22,9	48	1,5	12,0	16	15,5	14,3	11,35	4		
M16	2,00	94,0	29,1	27,0	48	1,5	14,0	18	17,5	16,3	13,28	4		

M-BGF 2,0xD													AICrN - HE	AICrN - HA
Nominal Ø	t	l1	l2.7	l2.9	l3	l10	d1	d2	d3	d3.1	AD	Z	Order No.	Order No.
M6	1,00	62,0	14,5	13,7	36	1,0	5,0	8	6,6	6,3	4,85	4	80373001000018	88373001000018
M8	1,25	74,0	18,1	17,1	40	1,3	6,8	10	9,0	8,3	6,61	4	80373001000020	88373001000020
M10	1,50	79,0	23,4	22,0	45	1,5	8,5	12	11,0	10,3	8,29	4	80373001000022	88373001000022
M12	1,75	89,0	26,9	25,3	45	1,5	10,3	14	13,5	12,3	10,00	4	80373001000024	88373001000024
M14	2,00	102,0	32,8	30,9	48	1,5	12,0	16	15,5	14,3	11,35	4		
M16	2,00	102,0	37,1	35,0	48	1,5	14,0	18	17,5	16,3	13,28	4		

M-BGF 2,5xD													AICrN - HE	AICrN - HA
Nominal Ø	t	l1	l2.7	l2.9	l3	l10	d1	d2	d3	d3.1	AD	Z	Order No.	Order No.
M6	1,00	62,0	16,5	15,7	36	1,0	5,0	8	6,6	6,3	4,85	4	80380001000018	88380001000018
M8	1,25	74,0	23,1	22,0	40	1,3	6,8	10	9,0	8,3	6,61	4	80380001000020	88380001000020
M10	1,50	79,0	27,8	26,5	45	1,5	8,5	12	11,0	10,3	8,29	4	80380001000022	88380001000022
M12	1,75	89,0	33,9	32,3	45	1,5	10,3	14	13,5	12,3	10,00	4	80380001000024	88380001000024
M14	2,00	102,0	38,8	36,9	48	1,5	12,0	16	15,5	14,3	11,35	4		
M16	2,00	102,0	45,1	43,0	48	1,5	14,0	18	17,5	16,3	13,28	4		



... the turn to quality

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presented by:

