

14610

Solid carbide thread milling cutter

M

VHM
TiAlNDIN
6535
HA

Z 3-5

≤ 2xD

DIN
13

IR/IL

**ATORN®**

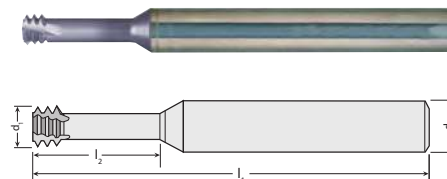
Design

- Fixed size design
- Corrected thread profile for milling precise female threads (ensure stable clamping)

Note:

Designs for up to 3xD thread depth and designs for hard machining up to 62 HRC deliverable on request.

14610



Size	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	14610	...
M 1	0.25	0.72	2.5	39	3	3		101
M 2	0.40	1.53	4.5	58	6	3		102
M 2.2	0.45	1.65	5.0	58	6	3		103
M 2.5	0.45	1.95	5.5	58	6	3		104
M 3	0.50	2.37	6.5	58	6	3		105
M 3.5	0.60	2.75	7.5	58	6	3		106
M 4	0.70	3.10	9.0	58	6	3		107
M 5	0.80	3.80	12.5	58	6	3		108
M 6	1.00	4.65	14.0	58	6	3		109
M 8	1.25	6.00	18.0	58	6	3		110
M 10	1.50	7.80	23.0	64	8	3		111
M 12	1.75	9.00	26.0	73	10	3		112
M 16	2.00	11.80	35.0	84	12	4		113
M 20	2.50	15.00	43.0	105	16	5		114



Al<10%Si	Al>10%Si	Cu	St<520N	St<750N	St<900N	St<1100N	St<1200N	St<1400N	<45HRC	<55HRC	<60HRC	<67HRC	VA<900N	VA>900N	Ti alloy	GG(G)	Plastic
200-400	200-350	200-400	100-180	80-160	70-140	55-110	50-100	60-80	-	-	-	-	50-100	60-80	40-60	80-160	-

14611

Solid carbide thread milling cutter

M

VHM
TiAlNDIN
6535
HA

Z 2-4

≤ 2xD

DIN
13

IR/IL



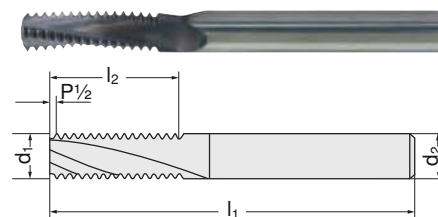
Design

- Fixed size design
- Corrected thread profile for milling precise female threads (ensure stable clamping)

Note:

Designs for up to 3xD thread depth and designs for hard machining up to 62 HRC deliverable on request.

14611



Size	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	IC	14611	...
M 3	0.50	2.40	7.0	42	4	2	-		101
M 4	0.70	3.15	9.8	55	6	3	-		102
M 5	0.80	4.00	12.0	55	6	3	-		103
M 6	1.00	4.80	14.0	55	6	3	-		104
M 8	1.25	5.95	18.75	60	6	3	x		105
M 10	1.50	7.95	22.5	70	8	3	x		106
M 12	1.75	9.90	28.0	75	10	4	x		107
M 14	2.00	11.60	32.0	85	12	4	x		108
M 16	2.00	12.00	36.0	85	12	4	x		109
M 18	2.50	14.00	42.5	90	14	4	x		110
M 20	2.50	16.00	42.5	90	16	4	x		111

Al<10%Si	Al>10%Si	Cu	St<520N	St<750N	St<900N	St<1100N	St<1200N	St<1400N	<45HRC	<55HRC	<60HRC	<67HRC	VA<900N	VA>900N	Ti	GG(G)	Plastic
200-400	200-350	200-400	100-180	80-160	70-140	55-110	50-100	60-80	-	-	-	-	50-100	60-80	40-60	80-160	-

Thread milling cutters

14615

Solid carbide thread milling cutter HARDCUT

VHM
TiAlNDIN
6535
HA

M

MF

≤ 2xD

≤ 2xD

62
HRC**ATORN®**

Design

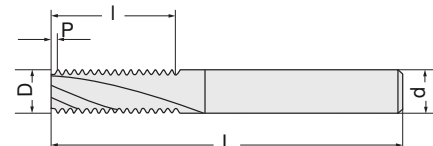
- Solid carbide ultra-fine grain
- TiAlN coating with high abrasion resistance

Advantages:

- Reduced machining time
- Smaller chips for increased process reliability
- Shorter machining time
- Higher productivity

Applications

For thread milling and countersinking.



Pitch mm	M coarse	M fine	d1 mm	D mm	Df mm	Z	I mm	If mm	L mm	14615	...
0.5	M 3	Ø > 4	6	2.4	3.6	3	5.3	5.9	58		101
0.7	M 4	Ø > 5	6	3.1	4.3	3	7.4	8.0	58		102
0.8	M 5	Ø > 6	6	4.0	5.2	3	9.2	9.8	58		103
1.0	M 6	Ø > 7	8	4.8	6.4	4	10.5	11.3	64		104
1.0	-	Ø > 9	8	6.0	7.6	4	13.5	14.3	64		105
1.0	-	Ø > 10	8	8.0	9.6	4	16.5	17.3	73		106
1.25	M 8	Ø > 10	8	6.0	7.6	4	14.4	15.2	64		107
1.5	M 10	Ø > 12	10	8.0	9.8	4	17.3	18.2	73		108
1.5	-	Ø > 14	12	10.0	11.8	4	21.8	22.7	84		109
1.75	M 12	Ø > 12	12	9.5	11.5	4	20.1	21.1	84		110

Al<10%Si	Al>10%Si	Cu	St<520N	St<750N	St<900N	St<1100N	St<1200N	St<1400N	<45HRC	<55HRC	<60HRC	<67HRC	VA<900N	VA>900N	Ti alloy	GG(G)	Plastic
-	-	-	-	-	-	-	-	-	70-80	60-70	50-60	40-50	-	-	-	-	-

14612

Solid carbide thread milling cutter

MF

VHM
TiAlN

15°

DIN
6535
HA

Z 3-4

≤ 2xD

DIN
13

IR/IL

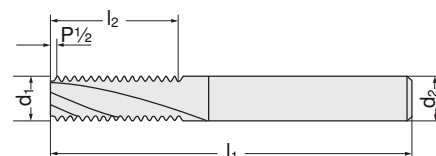
Uni

Design

- Fixed size design
- Corrected thread profile for milling precise female threads (ensure stable clamping)

Note:

Designs for up to 3xD thread depth and designs for hard machining up to 62 HRC deliverable on request.



Size	Pitch mm	d1 mm	l2 mm	l1 mm	d2 mm	Z	IC	14612	...
M 5	0.50	4.00	11.50	55	6	3	-		101
M 6	0.75	4.80	14.25	55	6	3	-		102
M 8	1.00	5.95	19.00	60	6	3	-		103
M 10	1.25	7.95	21.50	70	8	3	x		104
M 12	1.00	9.90	27.00	75	10	4	x		105
M 12	1.25	9.90	27.50	75	10	4	x		106
M 12	1.50	9.90	27.00	75	10	4	x		107
M 14	1.00	11.60	31.00	85	12	4	x		108
M 14	1.50	11.60	31.50	85	12	4	x		109
M 16	1.50	11.85	34.50	85	12	4	x		110
M 18	1.50	14.00	42.00	90	14	4	x		111
M 20	1.50	16.00	42.00	90	16	4	x		112

Al < 10% Si	Al > 10% Si	Cu	St < 520 N	St < 750 N	St < 900 N	St < 1100 N	St < 1200 N	St > 1400 N	< 45 HRC	< 55 HRC	< 60 HRC	< 67 HRC	VA < 900 N	VA > 900 N	Ti	GG(G)	Plastic
200-400	200-350	200-400	100-180	80-160	70-140	55-110	50-100	60-80	-	-	-	-	50-100	60-80	40-60	80-160	-

14613

Solid carbide thread milling cutter

MF

VHM
TiAlN

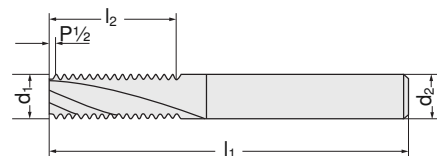


Design

- Universal design
- **Corrected thread profile** for milling precise female threads (ensure stable clamping)

Note:

Designs for up to 3xD thread depth and designs for hard machining up to 62 HRC deliverable on request.



14613

Size	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	IC	14613	...
> M 10	0.50	8.00	12	70	8	3	x		101
> M 11	0.75	8.00	12	70	8	3	x		102
> M 12	1.00	10.00	16	75	10	4	x		103
> M 14	1.00	12.00	20	85	12	4	x		104
> M 18	1.00	16.00	25	90	16	5	x		105
> M 22	1.00	20.00	32	105	20	5	x		106
> M 14	1.50	10.00	16	75	10	4	x		107
> M 16	1.50	12.00	20	85	12	4	x		108
> M 20	1.50	16.00	25	90	16	5	x		109
> M 24	1.50	20.00	32	105	20	5	x		110
> M 16	2.00	12.00	20	85	12	4	x		111
> M 20	2.00	16.00	25	90	16	5	x		112
> M 24	2.00	20.00	32	105	20	5	x		113
> M 24	3.00	16.00	25	90	16	5	x		114
> M 27	3.00	20.00	32	105	20	5	x		115

Al<10%Si	Al>10%Si	Cu	St<520N	St<750N	St<900N	St<1100N	St<1200N	St<1400N	<45HRC	<55HRC	<60HRC	<67HRC	VA<900N	VA>900N	Ti alloy	GG(G)	Plastic
200-400	200-350	200-400	100-180	80-160	70-140	55-110	50-100	60-80	-	-	-	-	50-100	60-80	40-60	80-160	-

14614

Solid carbide thread milling cutter

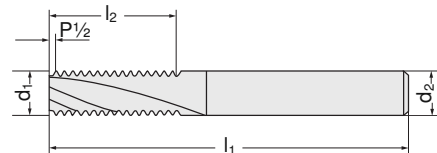
G

VHM
TiAlN



Design

- Fixed size design
- **Corrected thread profile** for milling precise female threads (ensure stable clamping)



14614

Size inch	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	IC	14614	...
G 1/8	28.0	8.00	20.80	70	8	3	x		101
G 1/4	19.0	9.90	28.00	75	10	4	x		102
G 3/8	19.0	14.00	41.45	90	14	4	x		103
G 1/2	14.0	16.00	43.50	90	16	4	x		104

Al<10%Si	Al>10%Si	Cu	St<520N	St<750N	St<900N	St<1100N	St<1200N	St>1400N	<45HRC	<55HRC	<60HRC	<67HRC	VA<900N	VA>900N	Ti	GG(G)	Plastic
200-400	200-300	200-400	100-180	80-100	70-140	55-110	50-100	60-80	-	-	-	-	50-100	60-80	40-60	80-160	-

Indexable insert thread milling cutters | Thread milling plates

14625 - 14628

Indexable insert thread milling cutter with internal cooling supply


ATORN®

Applications

For cylindrical female and male threads.

For through-bores and blind holes. Can be used universally for left-hand and right-hand threads.

Low cutting pressure, no chipping problems as only short chips are produced.

Scope of delivery:

Incl. spanner and clamping screw.

Note:

Indexable inserts see art. no. 14630–14631.

14625

Design

Holder made of special steel.

14626

Design

Holder made of solid carbide.

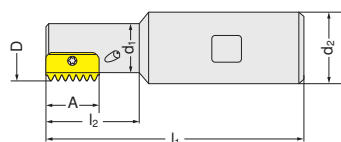
14627

Design

Holder made of special steel with two insert seats for higher feeds and, in particular, for harder materials.

14628

Replacement clamping screws

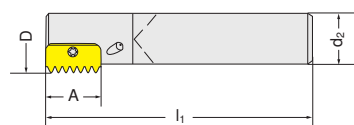


14625

Holder made of special steel

Clamping screw

Designation	A mm	D mm	d ₂ mm	d ₁ mm	l ₁ mm	l ₂ mm	14625	...	14628	...
SR009H12	12	9.5	20	7.5	85	14		101		101
SR0012F14	14	12.0	20	8.9	75	20		103		102
SR0014H14	14	14.5	20	11.2	85	25		104		102
SR0017H14	14	17.0	20	13.4	85	30		105		102
SR0021H21	21	21.0	20	16.5	94	40		107		103
SR0029J30	30	29.0	25	22.4	110	50		109		104

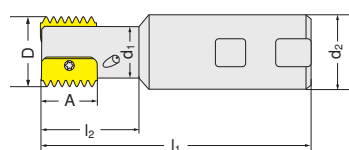


14626

Holder made of solid carbide

Clamping screw

Designation	A mm	D mm	d ₂ mm	l ₁ mm	14626	...	14628	...
SR0010K12C	12	9.9	8	125		101		101
SR0013J14C	14	13.2	10	150		103		102
SR0015K14C	14	15.2	12	175		104		102
SR0021M21C	21	21.0	16	200		106		103
SR0027S30C	30	27	20	270		107		104



14627

Holder made of special steel (2 insert seats)

Clamping screw

Designation	A mm	D mm	d ₂ mm	d ₁ mm	l ₁ mm	l ₂ mm	14627	...	14628	...
SR0020H14-2	14	20	20	16	93	41		101		101
SR0030J21-2	21	30	25	24	108	52		102		103
SR0040L30-2	30	40	32	30	130	70		103		104

ATORN®**Design**

Robust, full-profile indexable insert can be used
2 ways.

Applications

For universal use in many materials.

Quality

Solid carbide/AMT7 TiAlN-coated.

Note:

14630 101-105 single-sided cutting.

14630**Design**

Full profile 60° female.

Applications

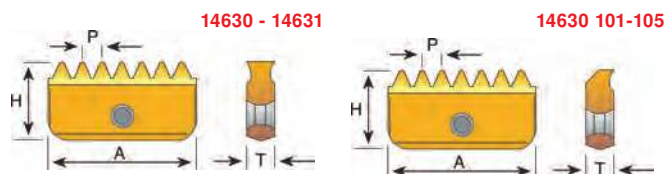
For bores.

14631**Design**

Full profile 60° male.

Applications

For shoulders.



Designation	P mm	A mm	H mm	T mm	Female		Male	
					14630	...	14631	...
12 I 0.5 ISO	0.50	12	6.3	2.9		101		
12 I 0.75 ISO	0.75	12	6.3	2.9		102		
12 I 1.0 ISO	1.00	12	6.3	2.9		103		
12 I 1.25 ISO	1.25	12	6.3	2.9		104		
12 I 1.5 ISO	1.50	12	6.3	2.9		105		
14 I 0.5 ISO	0.50	14	7.5	3.1		106		
14 I/E 0.75 ISO	0.75	14	7.5	3.1		107		107
14 I/E 1.0 ISO	1.00	14	7.5	3.1		108		108
14 I/E 1.25 ISO	1.25	14	7.5	3.1		109		109
14 I/E 1.5 ISO	1.50	14	7.5	3.1		110		110
14 I/E 1.75 ISO	1.75	14	7.5	3.1		111		111
14 I/E 2.0 ISO	2.00	14	7.5	3.1		112		112
14 I/E 2.5 ISO	2.50	14	7.5	3.1		113		113
21 I/E 1.0 ISO	1.00	21	12	4.7		114		114
21 I/E 1.5 ISO	1.50	21	12	4.7		115		115
21 I 1.75 ISO	1.75	21	12	4.7		116		
21 I/E 2.0 ISO	2.00	21	12	4.7		117		117
21 I/E 2.5 ISO	2.50	21	12	4.7		118		118
21 I/E 3.0 ISO	3.00	21	12	4.7		119		119
21 I 3.5 ISO	3.50	21	12	4.7		120		
30 I/E 1.5 ISO	1.50	30	16	5.5		121		121
30 I/E 2.0 ISO	2.00	30	16	5.5		122		122
30 I/E 3.0 ISO	3.00	30	16	5.5		123		123
30 I/E 3.5 ISO	3.50	30	16	5.5		124		124
30 I/E 4.0 ISO	4.00	30	16	5.5		125		125
30 I 4.5 ISO	4.50	30	16	5.5		126		
30 I 5.0 ISO	5.00	30	16	5.5		127		

Al<10%Si	Al>10%Si	Cu	St<520N	St<750N	St<900N	St<1100N	St<1200N	St<1400N	<45HRC	<55HRC	<60HRC	<67HRC	VA<900N	VA>900N	Ti alloy	GG(G)	Plastic
180-460	180-460	115-460	130-280	120-240	115-200	110-190	105-180	105-180	-	-	-	-	130-190	130-190	25-80	60-170	115-460