

OUT NOW

DATRON THREAD MILLING TOOLS

Accurate fit. True to gauge. Process reliable.

The new DATRON thread milling tools complement the already existing DATRON thread milling cutters and offer optimal solution for machining a wide range of thread sizes.

Advantages of DATRON thread milling tools:

- Optimum ratio between cutting edge and shank diameter
- High stability for precise milling results
- Chip channel for clean chip removal

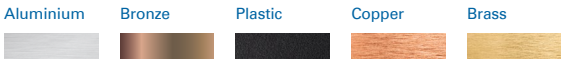
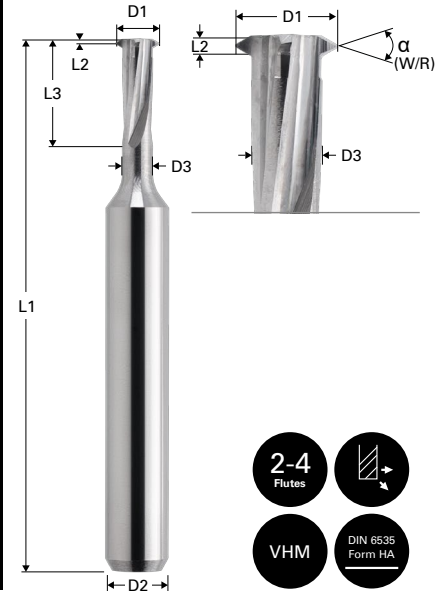


DATRON THREAD MILLING TOOLS

Our thread milling tools at a glance:

Thread milling cutters, short variant

Art.-No.	Type	D1 (mm)	D2 (mm)	D3 (mm)	L1 (mm)	L2 (mm)	L3 (mm)
00680010E	M 1	0,720	3	0,320	40	0,1	3
00680011E	M 1,1	0,825	3	0,425	40	0,1	3
00680012E	M 1,2	0,840	3	0,440	40	0,1	3
00680014E	M 1,4	0,980	3	0,530	40	0,2	4
00680016E	M 1,6	1,120	3	0,610	40	0,2	4
00680018E	M 1,8	1,260	3	0,750	40	0,2	4
00680020E	M 2	1,400	3	0,830	40	0,2	6
00680022E	M 2,2	1,540	3	0,910	40	0,2	6
00680025E	M 2,5	1,750	3	1,120	40	0,2	6
00680030E	M 3	2,100	6	1,310	50	0,3	8
00680035E	M 3,5	2,450	6	1,550	50	0,3	8
00680040E	M 4	2,800	6	1,800	50	0,3	11
00680045E	M 4,5	3,150	6	2,100	50	0,3	10
00680050E	M 5	3,500	6	2,400	50	0,4	10
00680060E	M 6	4,200	6	2,900	50	0,4	12
00680070E	M 7	4,900	6	3,600	54	0,4	14
00680080E	M 8	5,600	6	4,050	58	0,5	16
00680100E	M 10	7,000	8	5,200	60	0,6	21
00680120E	M 12	8,400	10	6,350	66	0,7	26



Setting values thread milling tools

Thread milling cutters, short variant

Art.-No.	RPM	Feed	H/8	NominalD1	ActualD1	D3	K	W/R	L2	Usable Length	Core hole
00680010E	40.000	150	0,027	0,720	0,750	0,320	40	60°	0,13	3,00	0,75
00680011E	40.000	150	0,027	0,825	0,850	0,425	40	60°	0,13	3,00	0,85
00680012E	40.000	150	0,027	0,840	0,880	0,440	40	60°	0,13	3,00	0,95
00680014E	40.000	200	0,032	0,980	0,990	0,530	40	60°	0,15	4,00	1,10
00680016E	40.000	200	0,038	1,120	1,150	0,610	40	60°	0,17	4,00	1,30
00680018E	40.000	250	0,038	1,260	1,300	0,750	40	60°	0,17	4,00	1,50
00680020E	39.000	250	0,043	1,400	1,440	0,830	40	60°	0,19	6,00	1,60
00680022E	39.000	300	0,049	1,540	1,600	0,910	40	60°	0,21	6,00	1,80
00680025E	39.000	300	0,049	1,750	1,800	1,120	40	60°	0,20	6,00	2,10
00680030E	38.000	350	0,054	2,100	2,180	1,310	40	60°	0,26	8,00	2,50
00680035E	38.000	350	0,065	2,450	2,500	1,550	40	60°	0,29	8,00	2,90
00680040E	37.000	400	0,076	2,800	2,900	1,800	40	60°	0,33	11,00	3,30
00680045E	37.000	400	0,081	3,150	3,200	2,100	40	60°	0,34	10,00	3,70
00680050E	36.000	500	0,087	3,500	3,630	2,400	40	60°	0,36	10,00	4,20
00680060E	35.000	600	0,108	4,200	4,380	2,900	40	60°	0,43	12,00	5,00
00680070E	35.000	650	0,108	4,900	5,050	3,600	40	60°	0,43	14,00	6,00
00680080E	34.000	700	0,135	5,600	5,810	4,050	40	60°	0,51	16,00	6,80
00680100E	32.000	800	0,162	7,000	7,260	5,200	40	60°	0,57	21,00	8,50
00680120E	32.000	850	0,189	8,400	8,700	6,350	40	60°	0,69	26,00	10,20

Core drilling tools*

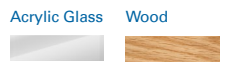
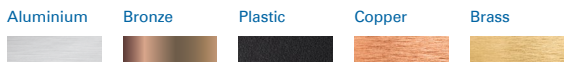
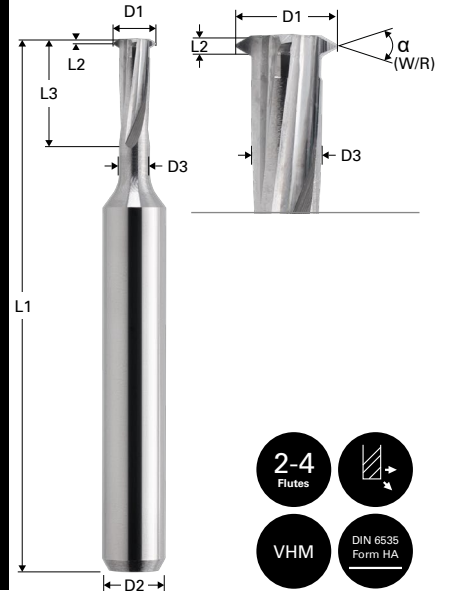
Art.-No.	RPM	Feed	Infeed Z
00682075	19.000	600	0,23
00682085	19.000	600	0,26
00682095	19.000	600	0,29
0068211	18.000	800	0,33
0068213	18.000	800	0,39
0068215	17.000	1.000	0,45
0068216	17.000	1.000	0,48
0068218	17.000	1.000	0,56
0068221	16.000	1.100	0,63
0068225	15.000	1.200	0,77
0068229	15.000	1.200	0,87
0068233	14.000	1.300	0,99
0068237	13.000	1.400	1,11
0068242	12.000	1.500	1,26
0068250L	10.000	1.700	1,5
0068260L	8.000	1.900	1,8
0068086E	35.000	1.000	1
0068086L	35.000	1.000	0,8
0068088E	34.000	1.500	1,1

The specified actual values are for orientation and may deviate under different conditions.

*DATRON ExpertTip: The core drilling tools mentioned are DATRON recommendations for optimum machining results.

Thread milling cutters, long variant

Art.-No.	Type	D1 (mm)	D2 (mm)	D3 (mm)	L1 (mm)	L2 (mm)	L3 (mm)
00680010L	M 1	0,720	3	0,320	40	0,13	5
00680011L	M 1,1	0,825	3	0,425	40	0,13	5
00680012L	M 1,2	0,840	3	0,440	40	0,13	5
00680014L	M 1,4	0,980	3	0,530	46	0,15	6
00680016L	M 1,6	1,120	3	0,610	46	0,17	6
00680018L	M 1,8	1,260	3	0,750	46	0,17	8
00680020L	M 2	1,400	3	0,830	46	0,19	8
00680022L	M 2,2	1,540	3	0,910	46	0,21	10
00680025L	M 2,5	1,750	3	1,120	46	0,20	10
00680030L	M 3	2,100	6	1,310	50	0,26	12
00680035L	M 3,5	2,450	6	1,550	54	0,29	14
00680040L	M 4	2,800	6	1,800	54	0,33	16
00680045L	M 4,5	3,150	6	2,100	58	0,34	18
00680050L	M 5	3,500	6	2,400	58	0,36	20
00680060L	M 6	4,200	6	2,900	63	0,43	24
00680070L	M 7	4,900	6	3,600	68	0,43	28
00680080L	M 8	5,600	6	4,050	70	0,51	32
00680100L	M 10	7,000	8	5,200	80	0,57	40
00680120L	M 12	8,400	10	6,350	90	0,69	48



Setting values thread milling tools

Thread milling cutters, long variant

Art.-No.	RPM	Feed	H/8	NominalD1	ActualD1	D3	K	W/R	L2	Usable Length	Core hole
00680010L	40.000	100	0,027	0,720	0,750	0,320	40	60°	0,13	5,00	0,75
00680011L	40.000	100	0,027	0,825	0,850	0,425	40	60°	0,13	5,00	0,85
00680012L	40.000	100	0,027	0,840	0,880	0,440	40	60°	0,13	5,00	0,95
00680014L	40.000	150	0,032	0,980	0,980	0,530	40	60°	0,15	6,00	1,10
00680016L	40.000	150	0,038	1,120	1,150	0,610	40	60°	0,17	6,00	1,30
00680018L	40.000	200	0,038	1,260	1,300	0,750	40	60°	0,17	8,00	1,50
00680020L	39.000	200	0,043	1,400	1,420	0,830	40	60°	0,19	8,00	1,60
00680022L	39.000	250	0,049	1,540	1,600	0,910	40	60°	0,21	10,00	1,80
00680025L	39.000	250	0,049	1,750	1,800	1,120	40	60°	0,20	10,00	2,10
00680030L	38.000	300	0,054	2,100	2,140	1,310	40	60°	0,26	12,00	2,50
00680035L	38.000	300	0,065	2,450	2,500	1,550	40	60°	0,29	14,00	2,90
00680040L	37.000	350	0,076	2,800	2,880	1,800	40	60°	0,33	16,00	3,30
00680045L	37.000	350	0,081	3,150	3,200	2,100	40	60°	0,34	18,00	3,70
00680050L	36.000	400	0,087	3,500	3,590	2,400	40	60°	0,36	20,00	4,20
00680060L	35.000	500	0,108	4,200	4,380	2,900	40	60°	0,43	24,00	5,00
00680070L	35.000	550	0,108	4,900	5,020	3,600	40	60°	0,43	28,00	6,00
00680080L	34.000	600	0,135	5,600	5,810	4,050	40	60°	0,51	32,00	6,80
00680100L	32.000	700	0,162	7,000	7,260	5,200	40	60°	0,57	40,00	8,50
00680120L	32.000	800	0,189	8,400	8,700	6,350	40	60°	0,69	48,00	10,20

Core drilling tools*

Art.-No.	RPM	Feed	Infeed Z
00682075	19.000	600	0,23
00682085	19.000	600	0,26
00682095	19.000	600	0,29
0068211	18.000	800	0,33
0068213	18.000	800	0,39
0068215	17.000	1.000	0,45
0068216	17.000	1.000	0,48
0068218	17.000	1.000	0,56
0068221	16.000	1.100	0,63
0068725X	15.000	1.100	0,65
0068729X	15.000	1.100	0,68
0068233L	14.000	1.300	0,99
0068237L	13.000	1.400	1,11
0068242L	12.000	1.500	1,26
0068250X	10.000	1.700	1,5
0068260X	8.000	1.900	1,8
0068086Z	35.000	800	0,6
0068088X	34.000	800	0,7
0068090S	32.000	800	0,8

The specified actual values are for orientation and may deviate under different conditions.

*DATRON ExpertTip: The core drilling tools mentioned are DATRON recommendations for optimum machining results.

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