

GÜHRING



- the specialist for thread milling in hard materials up to 66 HRC
- from M2 – M16 up to max. 2.5xD
- **50-percent increase in tool life** especially in climb milling operations due to the **new left-hand geometry**

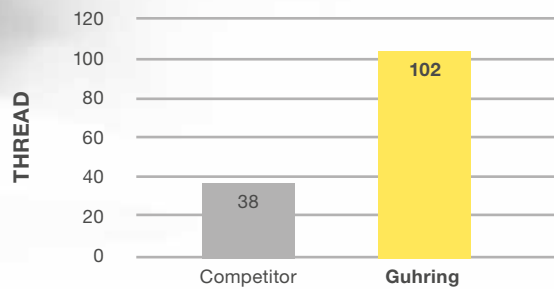
Solid carbide thread milling cutters for hard machining

GÜHRING – YOUR WORLDWIDE PARTNER

MTMH-3 SP

THREAD MILLING CUTTERS for hard machining (50–66 HRC)

Component:	supporting strip
Milling part diameter:	M6x(1), depth 14 mm, blind hole
Tool:	article 4496_M6 MTMH-3 SP 2.5xD
Material:	1.2379 / HRC 63 +2
Tapping size:	Ø 5.1 mm
Cooling:	dry
Parameter:	$v_c = 45 \text{ m/min}$, $f_z = 0.035 \text{ mm}$ (synchronous milling)
Distribution of cut:	2-stepped radial (2/3 – 1/3)
CNC radius correction:	2 corrections
Tool life:	102 threads



NEW

Programming software

for thread milling cutters and drill thread milling cutters

CNC Gührö ThreadMill

Application recommendation

MTMH-3 SP 2.5xD [Please note, M4 counter clockwise]

ISO	Material group	Tensile strength	Example materials	Material no.	Cutting speed v_c (m/min)	Milling part diameter / feed per tooth [f_z]													
						M2	M2.5	M3	M3.5	M4	M5	M6	M8	M10	M12	M14	M16		
						f_z	f_z	f_z	f_z	f_z	f_z	f_z	f_z	f_z	f_z	f_z	f_z	f_z	
P P3	Alloyed heat-treatable steels, tool steels, high speed steels	800-1200 N/mm ²	42CrMo4	1.7225	70	0.015	0.020	0.020	0.030	0.035	0.035	0.040	0.045	0.055	0.060	0.070	0.070		
			36CrNiMo4	1.6511															
			X36CrMo17	1.2316															
			HS 6-5-2	1.3343															
S S1 S2	Titanium and titanium alloys	< 1200 N/mm ²	Titanium	3.7025	55	0.015	0.020	0.020	0.030	0.035	0.035	0.040	0.045	0.055	0.060	0.070	0.070		
			TiAl5Sn2	3.7115															
			TiAl6V4	3.7165															
	Nickel, cobalt and iron-alloys	< 1400 N/mm ²	Hasteloy C4	2.461	45	0.015	0.020	0.020	0.030	0.030	0.035	0.040	0.045	0.055	0.060	0.070	0.070		
Inconel 718			2.4668																
Nimonic			2.4634																
H H1 H2	High tensile steels, hardened steels	50-55 HRC	Hardox	50	0.015	0.020	0.020	0.025	0.030	0.030	0.035	0.040	0.050	0.055	0.065	0.065			
		55-66 HRC	PM30														45	0.015	0.020



Micro-thread milling cutters



P	○
M	○
K	○
N	○
S	●
H	●

● suitable for hardened steels up to HRC 66 • M4 counter clockwise

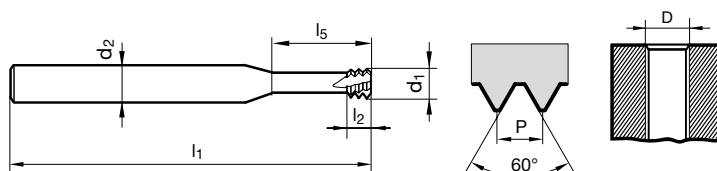
Tool material **Solid carbide**

Surface **A**

Type **MTMH3 SP**

Internal cooling

Shank form **HA**



Company std.

Article no.

4496

Discount group

108

D	P	d1	d2	l1	l2	l5	Z	Code no.	Availability
	mm	mm	mm	mm	mm	mm			
M2	0.400	1.550	3.000	39.000	1.200	5.000	4	2.000	●
M2,5	0.450	1.950	3.000	39.000	1.400	6.500	4	2.500	●
M3	0.500	2.350	6.000	58.000	1.500	7.500	4	3.000	●
M3,5	0.600	2.800	6.000	58.000	1.800	9.000	4	3.500	●
M4	0.700	3.100	6.000	58.000	2.100	10.000	4	4.000	●
M5	0.800	3.800	6.000	58.000	2.400	12.500	4	5.000	●
M6	1.000	4.800	6.000	58.000	3.000	15.000	4	6.000	●
M8	1.250	5.950	6.000	58.000	3.800	20.000	5	8.000	●
M10	1.500	7.800	8.000	64.000	4.500	25.000	5	10.000	●
M12	1.750	9.000	10.000	73.000	5.300	30.000	6	12.000	●
M16	2.000	11.800	12.000	84.000	6.000	35.000	6	16.000	●



GÜHRING

P.O. Box 100247 • 72423 Albstadt
Herderstrasse 50-54 • 72458 Albstadt

T +49 74 31 17-0
F +49 74 31 17-21279

info@guehring.de
www.guehring.de

No liability can be accepted for printing errors or technical changes of any kind.
Our Conditions of Sale and Terms of Payment apply. Available on request.