

Thread milling cutters

14610 Solid carbide thread milling cutters



Type
 - Fixed dimension Type
 - Corrected thread profile for milling precise internal thread (ensure stable clamping)

Note:
 Types to thread depth 3xD and
 Types for hard machining to 62 HRC
 available on request.

M

VHM
TiAlN

15°

DIN
6535
HA

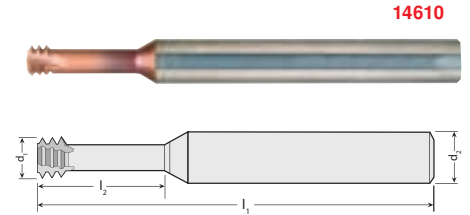
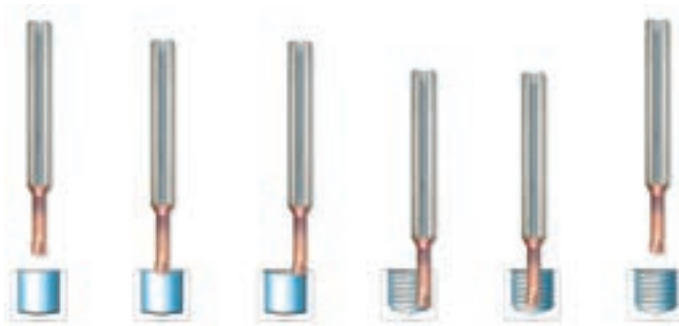
Z3-5

≤ 2xD

DIN
13

IR/IL

Uni



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-steel<900N	VA-steel>900N	Ti alloys	GG(G)	Plastics
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 cutters

Type
 - Fixed dimension Type
 - Corrected thread profile for milling precise internal thread (ensure stable clamping)

Note:
 Types to thread depth 3xD and
 Types for hard machining to 62
 HRC available on request.

M

VHM
TiAlN

15°

DIN
6535
HA

Z2-4

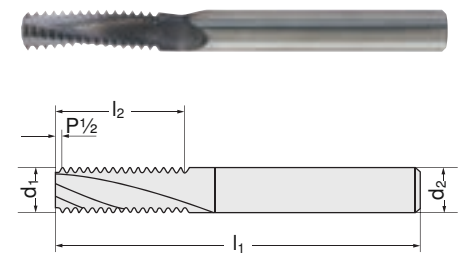
≤ 2xD

DIN
13

IR/IL

Uni

Size	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	IK	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-steel<900N	VA-steel>900N	Ti	GG(G)	Plastics
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	-

14612

Solid carbide thread milling cutters

MF VHM TiAlN 15° DIN 6535 HA Z3-4 ≤ 2xD DIN 13 IR/IL Uni

Type

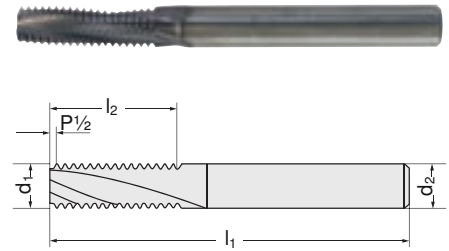
- Fixed dimension Type
- Corrected thread profile for milling precise internal thread (ensure stable clamping)

Note:

Types to thread depth 3xD and Types for hard machining to 62 HRC available on request.

14612

Size	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	IK	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-steel < 900 N	VA-steel > 900 N	Ti	GG(G)	Plastics
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 cutters

MF VHM TiAlN 15° DIN 6535 HA Z3-5 ≤ 2xD DIN 13 IR/IL Uni

Type

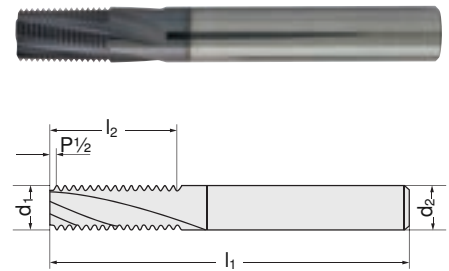
- Universal Type
- Corrected thread profile for milling precise internal thread (ensure stable clamping)

Note:

Types to thread depth 3xD and Types for hard machining to 62 HRC available on request.

14613

Size	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	IK	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 < 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-steel < 900 N	VA-steel > 900 N	Ti alloys	GG(G)	Plastics
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

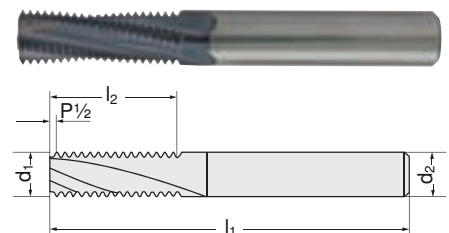
G VHM TiAlN 15° DIN 6535 HA Z3-4 ≤ 2xD DIN 228/1 IR/IL Uni

Type

- Fixed dimension Type
- Corrected thread profile for milling precise internal thread (ensure stable clamping)

14614

Size Inch	Pitch mm	d ₁ mm	l ₂ mm	l ₁ mm	d ₂ mm	Z	IK	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 < 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-steel < 900 N	VA-steel > 900 N	Ti	GG(G)	Plastics
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	-

14625 - 14628

Indexable insert thread milling cutters with ICF



ATORN®

Use

For cylindrical internal and external threads. For through-hole and blind hole threads. Multi-purpose use for left-hand and right-hand threads. Low cutting pressure, no chip problems, because the chips produced are short.

Scope of supply:
Incl. Wrench and clamping screw.

Note:

Reversible cutting inserts see cat.-no. 14630-14631.

14625

Type

Holder made of special steel.

14626

Type

Holder made of solid carbide.

14627

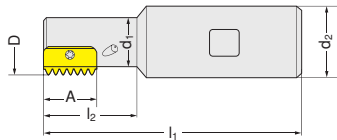
Type

Holder made of special steel with two mounts for high feed rates and especially for harder materials.

14628

Spare clamping screws

14625

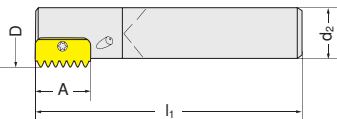


Holder made of special steel

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

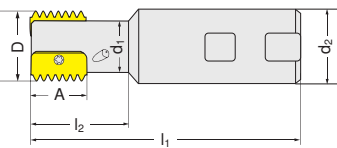


Holder made of solid carbide

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 mounts)

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



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Performance requires quality.

For example, with the diamond grinding wheels and CBN face wheels from ATORN.

- Longest service life with uniformly high stock removal rate
- Premium grinding wheels with vibration-damping body
- Universal implementation, wet grinding and dry grinding

ATORN®
Performance requires quality.



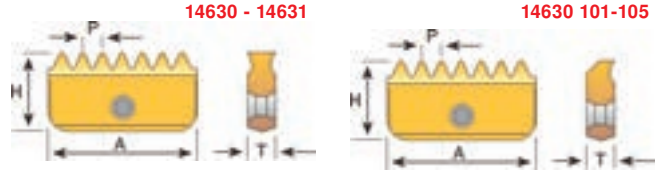


Type
Stable, 2x useable full profile indexable insert.
Use
Universal implementation in many materials.
Quality
VHM/AMT7 TiAlN-coated.

Note:
14630 101-105 cuts on one side.

14630
Type
Full profile 60° internal.
Use
For bores.

14631
Type
Full profile 60° external.
Use
For projections.



Designation	P mm	A mm	H mm	T mm	Internal		External	
					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-steel<900N	VA-steel>900N	Ti alloys	GG(G)	Plastics
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

14800

HELICOIL® plus repair assortment



Use
The world leader when it comes to quick thread repair solutions:
- For scrap recovery and thread repair
- For repair of damaged or worn-off thread
- For thread reinforcement, where materials of lower shear strength, e.g. aluminium, are used (machine tools, automotive engineering, electrical engineering and medical technology, etc.)
- Absolutely firm seat, even under extreme loads, abrasion-resistant threaded insert of corrosion-resistant, wear-resistant and heat resistant CrNi steel, ideal transmission of force, and increased load capacity of nut thread and bolt thread

230-part, set contents:
20 of each thread inserts
M 5 x 5 / M 5 x 7,5 / M 5 x 10 / M 6 x 6 / M 6 x 9 / M 6 x 12,
10 of each thread inserts
M 8 x 8 / M 8 x 12 / M 8 x 16 / M 10 x 10 / M 10 x 15 / M 10 x 20 / M 12 x 12 / M 12 x 18 / M 12 x 24,
5 twist drills,
5 hand taps,
5 setting tools,
5 pin breakers.

14800



Set contents	Set size	14800	...
230-part	M 5 - M 12	202	