

GFS-ST, GFM-ST and GFM-STL

Solid Carbide Thread Milling Cutters for a wide range of soft & prehardened steels (to 58 HRC), stainless steels, cast iron and more.

GFS-ST

Two operations, just one tool

- 45° chamfering
- Thread milling
- Larger cutting diameter
- Greater number of flutes

GFM-ST

Each cutter is capable of a wide range of sizes with the same pitch. In addition the recessed neck makes it possible to cut deeper threads by axial cutter shift.

GFM-STL

All the same cutting features of the GFM-ST but the GFM-STL has a longer length of thread and no recessed neck. Longer threads can be produced without axial cutter shift.



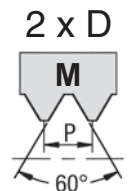
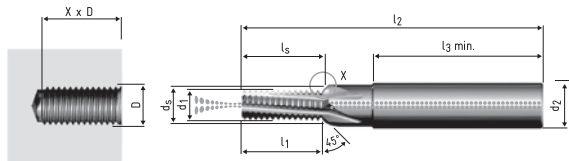
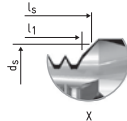
The Advantages:

- Shorter cutting time because of the greater number of flutes
- Up to 200% greater tool life
- Lower production and tooling costs
- Up to 58 HRC
- Coolant thru

GFS-ST - Solid carbide thread milling cutter for internal threads

ISO Metric Threads DIN 13

Specification: 2 x D, for steels and difficult to machine materials, 45° chamfer for countersinking, straight shank with internal coolant and right hand spiral flutes.

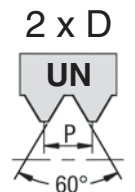


COATED

D (size)	P (pitch)	l1	l2	l3 min.	d1	d2	ds	ls	Z No. of flutes	Item Code
M4	0.70	8.75	48	36		6	4.2	9.3	4	305106
M5	0.80	10.75	54	36		6	5.3	11.5	4	305107
M6	1.00	13.45	62	36		8	6.3	14.3	5	305108
M8	1.25	18.10	74	40		10	8.4	19.1	5	305109
M10	1.50	21.70	80	45		12	10.5	22.9	5	305110
M12	1.75	25.30	90	45		14	12.6	26.7	6	305111
M14	2.00	30.95	102	48		16	14.7	32.5	6	305112

UNC Thread - Unified National Course Thread ANSI B 1.1

Specification: 2 x D, for steels and difficult to machine materials, 45° chamfer for countersinking, straight shank with internal coolant and right hand spiral flutes.



COATED

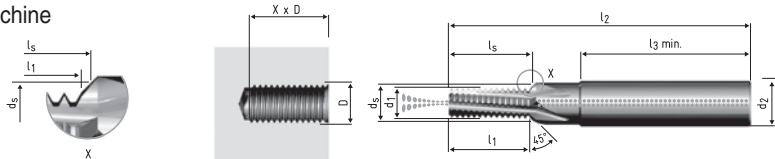
D (size)	TPI	l1	l2	l3 min.	d1	d2	ds	ls	Z No. of flutes	Item Code
UNC 1/4	20	14.6	62	36		8	7.8		5	305384
UNC 5/16	18	17.7	74	40		10	9.0		5	305385
UNC 3/8	16	21.4	80	45		12	10.1		5	305386
UNC 7/16	14	24.4	80	45		12	11.8		5	305387
UNC 1/2	13	28.3	90	45		14	13.5		6	305388
UNC 9/16	12	30.6	102	48		16	15.5		6	305389
UNC 5/8	11	35.7	102	48		18	17.5		6	305390



GFS-ST - Solid carbide thread milling cutter for internal threads

UNF Thread - Unified National Fine Thread ANSI B 1.1

Specification: 2 x D, for steels and difficult to machine materials, 45° chamfer for countersinking, straight shank with internal coolant and right hand spiral flutes.



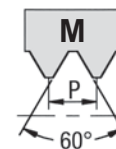
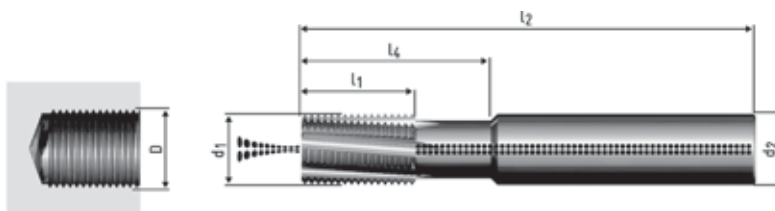
COATED

D (size)	TPI	l1	l2	l3 min.	d1	d2	ds	ls	Z No. of flutes	Item Code
UNF 1/4	28	14.0	62	36		8	6.6		5	305393
UNF 5/16	24	17.4	74	40		10	9.0		5	305394
UNF 3/8	24	20.6	80	45		12	11.0		5	305395
UNF 7/16	20	24.7	80	45		12	11.8		5	305396
UNF 1/2	20	27.3	90	45		14	13.5		6	305397
UNF 9/16	18	30.3	102	48		16	15.5		6	305398
UNF 5/8	18	33.1	102	48		18	17.5		6	305399

GFM-ST - Solid carbide thread milling cutter for internal threads

ISO Metric Threads DIN 13

Specification: for steels and difficult to machine materials, straight shank with internal coolant and right hand spiral flutes, recessed neck.



COATED

METRIC

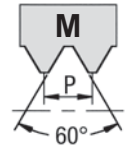
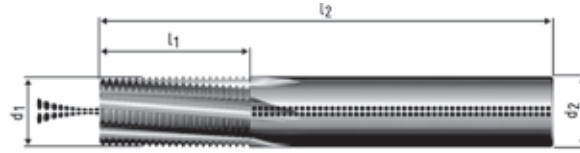
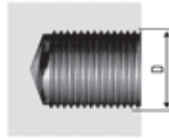
d1 (Cutter Dia.)	P (pitch)	l1	l2	D ≥	d2	l4	Z No. of flutes	Item Code
10	1	16	70	12	10	25	5	305091
10	1.5	16	70	14	10	25	5	305092
12	1	20	80	16	12	31	5	305093
12	1.5	20	80	16	12	31	5	305094
12	2	20	80	16	12	31	5	305095
16	1	20	90	20	16	40	6	305087
16	1.5	25	90	22	16	40	6	305088
16	2	25	90	22	16	40	6	305089
20	1.5	33	105	26	20	50	6	305084
20	2	33	105	27	20	50	6	305085
20	3	33	105	30	20	50	6	305086

GFM-STL - Solid carbide thread milling cutter for internal threads

ISO Metric Threads DIN 13

Specification: for steels and difficult to machine materials, straight shank with internal coolant and right hand spiral flutes, longer thread length.

COATED

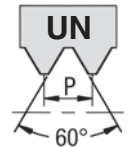


d1 (Cutter Dia.)	P (pitch)	l1	l2	D ≥	d2	Z No. of flutes	Item Code
10	1	20	80	12	10	5	305096
10	1.5	20	80	14	10	5	305097
12	1	25	90	16	12	5	305098
12	1.5	25	90	16	12	5	305099
12	2	25	90	16	12	5	305113
16	1	32	100	20	16	6	305100
16	1.5	32	100	22	16	6	305101
16	2	32	100	22	16	6	305102
20	1.5	40	115	26	20	6	305103
20	2	40	115	27	20	6	305104
20	3	40	115	30	20	6	305105

UN Thread - Unified National Course Thread ANSI B 1.1

Specification: for steels and difficult to machine materials, straight shank with internal coolant and right hand spiral flutes, longer thread length.

COATED



d1 (Cutter Dia.)	TPI	l1	l2	D ≥	d2	Z No. of flutes	Item Code
12	16	25	90	3/4	12	5	305371
12	10	25	90	3/4	12	5	305372
16	24	33	100	7/8	16	6	305373
16	20	33	100	7/8	16	6	305374
16	18	33	100	7/8	16	6	305375
16	16	33	100	7/8	16	6	305376
16	14	33	100	7/8	16	6	305377
16	12	33	100	7/8	16	6	305378
16	10	33	100	7/8	16	6	305379
16	9	33	100	7/8	16	6	305380
20	14	40	115	1.00	20	6	305381
20	12	40	115	1.00	20	6	305382
20	8	40	115	1.00	20	6	305383