

GFA Solid Carbide Arbor Mounted Shell Thread Milling Cutters

More cutter teeth, faster production

A large cutter diameter is necessary for cost-effective thread milling, particularly for threads with diameters greater than 50 mm. Customarily, the shank on solid carbide cutters, which just serves to mount the tool, accounts for approximately 60-70% of the cutter's carbide content. That means high expenditure on the cutter material for relatively little functional benefit.

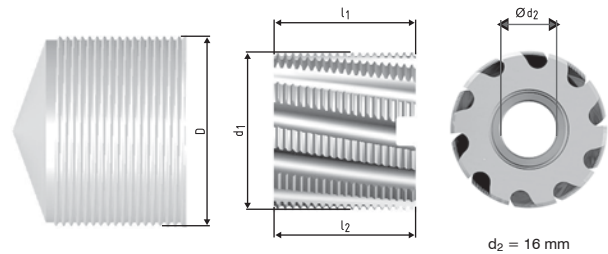
As a rule, a 45 mm diameter cutter with throw-away inserts will have 6 inserts. By contrast, JBO solid carbide mounted shell thread milling cutters have 10 flutes. Feed rate is doubled. Also, several regrinds are possible.

Advantages

- Rapid and simple tool changing on machine
- Lower tooling costs, even for large diameter threads (50-1000 mm)
- Existing arbors can be used
- High rate of metal removal due to large cutter diameter and high number of cutter teeth

METRIC

d1	P	l1	l2	D ≥	Z No. of flutes
45	1	40.0	40.2	50	10
45	1.5	39.0	40.2	50	10
45	2	40.0	40.2	55	10
45	3	39.0	40.2	55	10
45	4	40.0	40.2	60	10
45	5	40.0	40.2	62	8
45	6	36.0	40.2	64	8



INCH

d1	TPI	l1	l2	D ≥	Z No. of flutes
45	20	39.4	40.2	1 15/16	10
45	16	39.7	40.2	2	10
45	12	40.2	40.2	2 1/8	10
45	8	38.1	40.2	2 1/4	10
45	6	38.1	40.2	2 3/8	10
45	4	38.1	40.2	2 5/8	8

