

NEW PRODUCT NEWS

mgt
MEGA TECH
METALWORK

Member IMC Group



For CNC automatic lathe

Thread Whirling **ECO**

High-efficiency threading

Expanded lineups of cutter with 3-blade and 6-blade cutter, as well as cutters for left-hand threads, to provide more cost options for a wider range of applications



CERTainly [but not only] **CERamics**
Outstanding solutions for demanding applications



Single-pass machining is possible,
and multi-lead threads are also supported.
Significantly reduces the machining time of threading.

High-efficiency threading I for CNC automatic lathes

Thread Whirling

Performance

In automatic lathes, threading is performed by repeating multiple cutting passes. Therefore, when machining long screws, it is necessary to ensure that the workpiece does not fall off from the guide bush. However, threadwhirling allows for single-pass machining, eliminating the need for subsequent joining process.

In addition, single-pass machining is possible even for multi-lead threads such as double and triple lead screws. This eliminates the need for multiple cutting passes and subsequent joining processes, thus achieving high efficiency threading.

Machining overview

In thread whirling, the whirling head is tilted to a specific helix angle, and the cutter is rotated at high speed while the bar stock (c axis) is rotated at a low speed. It is possible to machine the outer dimension by adding a wiper to the insert.

- Lineup of 3-blade and 6-blade cutter bodies
- 1-corner insert can be selected.

New
Thread Whirling **ECO**

- Lineup of cutter bodies for left-hand threads

	Double-lead threads	Triple-lead threads
Component	Bone Screw	Worm Screw
Work material	Ti-6Al-4V ELI	brass
Workpiece		
Insert shape		
Major Dia.	φ4.0	φ7.0
Minor Dia.	φ2.4	φ4.7
Lead	3.42mm	4.9mm

When machining multi-lead threads by in a single pass, numerous process requirements must be met. Please contact us to discuss mechanical, Spindle, Insert, tooling specification.

Thread whirling



For CNC automatic lathe

| Cutter body with selectable number of inserts

The number of inserts can now be selected according to the balance between machining time and cost.

Thread Whirling **ECO**



3 inserts

Emphasis on cost



6 inserts

Balance



9 inserts

Emphasis on machining efficiency

| Select the number of corners according to your needs

The number of corners can now be selected according to the number of workpieces produced.

Thread Whirling **ECO**



1 corner type

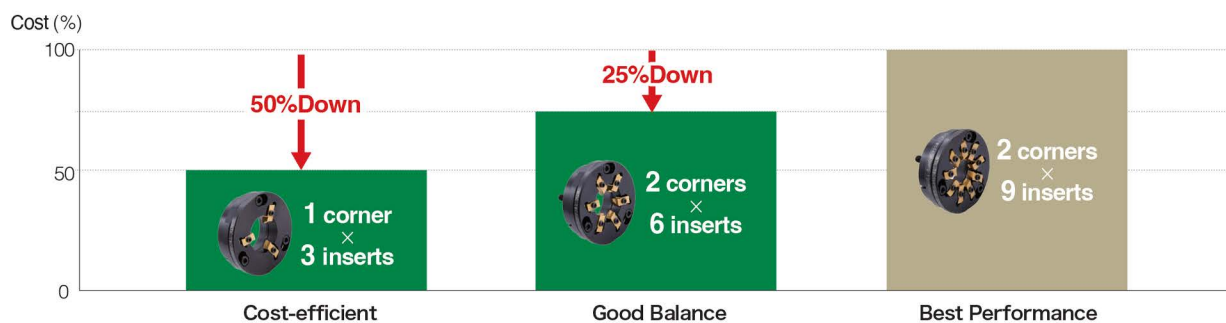
For prototyping and small-lot, high-mix production



2 corner type

For mass production

| Cost-saving effect



| Cutter bodies are available for Left/Right-hand screws

A head for left-hand threads has been added to accommodate a wide range of workpieces.



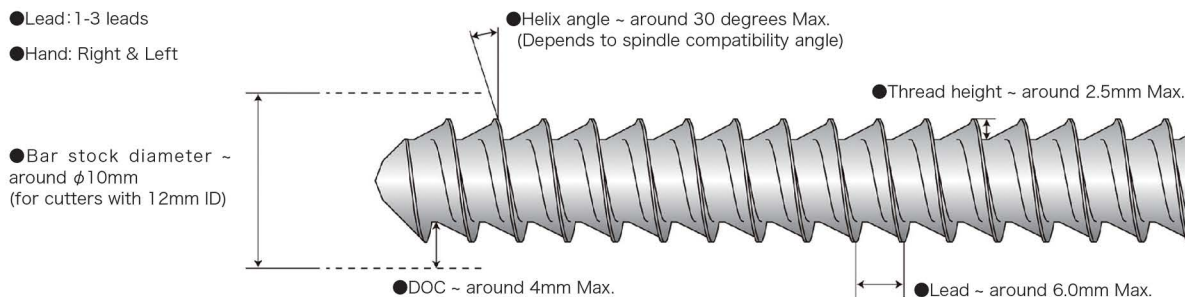
Left hand Screw



Right hand Screw

For CNC automatic lathe

Applicable Thread Geometry (Approximated)



The geometries shown above are approximated and could vary by actual applications

Recommended Cutting Conditions

Conditions / No. of teeth		9	6	3
Main spindle	min-1	10 - 40	10 - 25	5 - 12
Whirling cutter	min-1	1,500 - 4,000		
Feed rate		Same as thread lead = pitch		
Bar stock	mm	$-\phi 10$	$-\phi 10$	$-\phi 10$
Work Material		Ti-6Al-4V EL / SUS316 / 17-4PH / Titanium / Brass etc.		

Formula for calculating thread whirling process time

$$T(\text{seconds}) = \frac{60 \times \text{Thread length}}{\text{Main spindle rpm} \times \text{Feed rate (Thread Lead)}}$$

Ex.) Double lead / 50mm length / 2mm lead (2 x 1mm pitch) / 30rpm

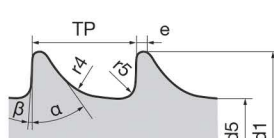
$$T(\text{seconds}) = \frac{60 \times 50\text{mm}}{30\text{rpm} \times 2\text{mm lead}} = 50 \text{ second}$$

Standard Thread Whirling Inserts (2 corner type) for Medical ISO Style Threads TWC.. series/Inserts Carbide

ISO5835 with chipbreaker

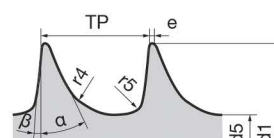


No.1



ISO5835 HA

No.2



ISO5835 HB

P	Steel	★
M	Stainless	★
N	Non-ferrous	★
S	Superalloys	★
H	Hard materials	★

★ : First choice

☆ : Second choice

Designation	HAND	Coated	ISO	Pitch	d1	d5	e	r4	r5	α	β	Figure
		ZM3										
			mm	mm	mm	mm	mm	mm	mm	mm	°	
TW5835-HA1.5-D12	R	●	HA1.5	0.5	1.5	1.1	0.1	0.3	0.1	35	3	1
TW5835-HA2.0-D12	R	●	HA2.0	0.6	2	1.3	0.1	0.4	0.1	35	3	1
TW5835-HA2.7-D12	R	●	HA2.7	1	2.7	1.9	0.1	0.6	0.2	35	3	1
TW5835-HA3.5-D12	R	●	HA3.5	1.25	3.5	2.4	0.1	0.8	0.2	35	3	1
TW5835-HA4.0-D12	R	●	HA4.0	1.5	4	2.9	0.1	0.8	0.2	35	3	1
TW5835-HA4.5-D12	R	●	HA4.5	1.75	4.5	3	0.1	1	0.3	35	3	1
TW5835-HA5.0-D12	R	●	HA5.0	1.75	5	3.5	0.1	1	0.3	35	3	1
TW5835-HB4.0-D12	R	●	HB4.0	1.75	4	1.9	0.1	0.8	0.3	25	5	2
TW5835-HB6.5-D12	R	●	HB6.5	2.75	6.5	3	0.2	1.2	0.8	25	5	2

Must use Thread whirling cutters with 12mm ϕ Dm dimension

● : Line up

Cutter Lineup

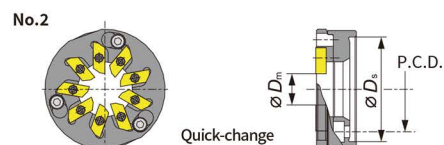
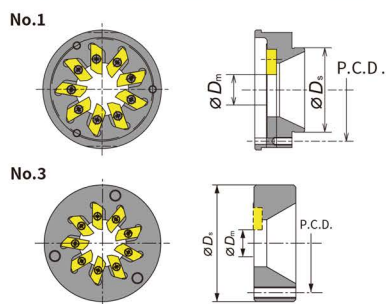
Machine maker	Model	Location	Spindle maker	Spindle model	Helix angle	No.	Cutter body	No. of teeth	φDm (mm)	φDs	P.C.D.	Mount adapter bolt	
CITIZEN	A20	Gang	CITIZEN	BTW-5000	0°-15°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)	
	A20(2F)/A20(3F)			BTW-2000	±25°		TWC3C1040HP1-LH	3	φ12				
							TWC6C1040HP1	6	φ12				
	A32			TWC9C1040HP1	9		φ12						
			TWC9C1040HP1-LH	9	φ12								
			TWC9C1040HP1-D16	9	φ16								
	C12/16		JARVIS	LTRO170	±15°	2	TWC9C1037P2	9	φ12	φ37	φ30.5	CS0310 (M3)	
	C20/C32(2M)		CITIZEN	BTW-1000	±25°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)	
	C32	TWC6C1040HP1					6	φ12					
	D25	BTW-3100		0°-15°	TWC6C1040HP1-LH		6	φ12					
	D25(1M)	BTW-6000		±25°	TWC9C1040HP1		9	φ12					
						TWC9C1040HP1-LH	9	φ12					
						TWC9C1040HP1-D16	9	φ16					
	K16	Attachment	PCM	GSW-101	±15°	1	TWC6P1620HP1-D9	6	φ9	φ32	φ26	M4 (Provided with spindle)	
	L20		CITIZEN	BTW-1000	±25°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)	
							TWC3C1040HP1-LH	3	φ12				
							TWC6C1040HP1	6	φ12				
							TWC6C1040HP1-LH	6	φ12				
							TWC9C1040HP1	9	φ12				
							TWC9C1040HP1-LH	9	φ12				
			JARVIS	LTRO183	±15°	2	TWC9J1040P2	9	φ12	φ40	φ32.5	H-M4 × 12 M4 (Provided with spindle)	
		PCM	LSW-101-L20	±10°	TWC9P1340P2		9	φ12					
		L20/L20E/L20X	Gang	CITIZEN	BTW-3000 BTW-3100	0°-15°	1	TWC9C0746HP1	9	φ12	φ46	φ35	M3 (Provided with spindle)
		L20/L20X			BTW-2000	±25°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)
								TWC3C1040HP1-LH	3	φ12			
								TWC6C1040HP1	6	φ12			
	L20(7M)	BTW-1000				TWC6C1040HP1-LH	6	φ12					
						TWC9C1040HP1	9	φ12					
						TWC9C1040HP1-LH	9	φ12					
						TWC9C1040HP1-D16	9	φ16					
	L20E(1M)	BTW-3000			±15°	1	TWC9C0746HP1	9	φ12	φ46	φ35	M3 (Provided with spindle)	
	L20E(2M)/L20E(3M)	BTW-1000			±25°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)	
		BTW-5000	TWC3C1040HP1-LH	3	φ12								
		BTW-3100	±15°	TWC6C1040HP1	6		φ12						
		BTW-2000	±25°	TWC6C1040HP1-LH	6		φ12						
	L20X	BTW-6000	±25°		TWC9C1040HP1	9	φ12						
				TWC9C1040HP1-D16	9	φ16							
	L32/L32X	Gang	CITIZEN	BTW-3000 BTW-3100	0°-15°	1	TWC9C0746HP1	9	φ12	φ46	φ35	M3 (Provided with spindle)	
	L32(1M)			BTW-2000	±25°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)	
				BTW-6000	±15°		TWC3C1040HP1-LH	3	φ12				
				BTW-3100	±15°		TWC6C1040HP1	6	φ12				
	L32(2M)			BTW-6200	±25°	TWC6C1040HP1-LH	6	φ12					
				BTW-6000		TWC9C1040HP1	9	φ12					
				BTW-3100	±15°	TWC9C1040HP1-LH	9	φ12					
	L32X			BTW-2000	±25°		TWC9C1040HP1-D16	9	φ16				
				BTW-6000									
	M12/M16(2M)			Turret		MSW105	±15°	2	TWC9C1037P2	9	φ12	φ37	φ30.5
	M16	Gang		BTW-5000	±25°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)	
							TWC3C1040HP1-LH	3	φ12				
							TWC6C1040HP1	6	φ12				
TWC6C1040HP1-LH							6	φ12					
TWC9C1040HP1							9	φ12					
TWC9C1040HP1-LH							9	φ12					
			TWC9C1040HP1-D16	9	φ16								
M2/16	Turret	JARVIS	LTRO128 LTRO168	±15°	2	TWC9C1037P2	9	φ12	φ37	φ30.5	CS0310 (M3)		

Machine maker	Model	Location	Spindle maker	Spindle model	Helix angle	No.	Cutter body	No. of teeth	φDm (mm)	φDs	P.C.D.	Mount adapter bolt	
	M2/16III	Turret	CITIZEN	MSW105	±15°	2	TWC9C1037P2	9	φ12	φ37	φ30.5	CS0310 (M3)	
	M20	Gang		BTW-2000	±25°	1	TWC3C1040HP1	3	φ12	φ33	φ40	M3 (Provided with spindle)	
				BTW-1000	+20° -25°		TWC3C1040HP1-LH	3	φ12				
							TWC6C1040HP1	6	φ12				
	M20/16	Turret	PCM	NSW-101	±10°		2	TWC9C1040HP1	6				φ12
								TWC9C1040HP1-LH	9				φ12
								TWC9C1040HP1-D16	9				φ16
	M20/32	Gang	JARVIS	LTRO183	±15°	2	TWC9J1040P2	9	φ12	φ40	φ32.5	M4 (Provided with spindle)	
	M20/32III	Turret	CITIZEN	LTRO169			TWC9C1037P2					H-M4 × 12	
			M20/M32	Turret	PCM		KSW110					±10°	TWC9C1037P2
	M20/M32(3M)	Gang				CITIZEN	KSW-101	±10°	TWC9P1340P2	φ40	φ32.5	M4 (Provided with spindle)	
			M20/M32(4M)	Turret	PCM		KSW110	±15°	TWC9C1037P2	φ37	φ30.5	CS0310 (M3)	
	M32	Gang				CITIZEN	BTW-1000	±25°	1	TWC3C1040HP1	3	φ12	φ33
			M32(5M)	Gang	CITIZEN		BTW-4000	±15°		TWC3C1040HP1-LH	3	φ12	
	M32(5M)	Gang				CITIZEN	BTW-2000	±25°		TWC6C1040HP1	6	φ12	
			M32(5M)	Gang	CITIZEN		BTW-6000	±25°		TWC6C1040HP1-LH	6	φ12	
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1		9	φ12		
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-LH		9	φ12		
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5M)	Gang	CITIZEN				BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
			M32(5M)	Gang	CITIZEN	BTW-2000	±25°	TWC9C1040HP1-D16	9	φ16			
M32(5													

Machine maker	Model	Location	Spindle maker	Spindle model	Helix angle	No.	Cutter body	No. of teeth	φDm (mm)	φDs	P.C.D.	Mount adapter bolt
TSUGAMI	BH20/BH38	Turret	TSUGAMI	3263-Y481	±10°	2	TWC3TS2252P2 TWC3TS2252P2-LH TWC6TS2252P2 TWC6TS2252P2-LH TWC9TS2252P2 TWC9TS2252P2-LH	3 3 6 6 9 9	φ12	φ52	φ42	CS0515 (M5)
	B038T			3263-Y2481								
	BS20			3214-Y1371		2	TWC9TS20550P2	9				
	SS20/SS26/SS32	Attachment		3268-Y451	0°-10° 0°-20° 0°-25° 0°-30°	3	TWC3TS2244HP1 TWC3TS2244HP1-LH TWC6TS2244HP1 TWC6TS2244HP1-LH TWC9TS2244HP1 TWC9TS2244HP1-LH TWC9TS1944HP1 TWC9TS1644HP1 TWC9TS1044HP1	3 3 6 6 9 9 9 9 9	φ12	φ52	φ44	CS0520 (M5) CS0520 (M5) CS0520 (M5) CS0520 (M5) CS0520 (M5) CS0520 (M5) CS0520 (M5) CS0515 (M5) CS0515 (M5)
	B0265/B0266-II											
	B0325/B0326-II											
	B0265/B0266(V)-III											
	B0325/B0326(V)-III											
	BW329Z/B0385386(L)-III											
	S205/S206											
	S205/S206-II											
	B0123/124/126-II											
	B0-V/B0-VR											
	B0203/204/205205-III /206-II											
	SS20/SS26/SS32											
	SS207/SS267/SS327	B-axis		Using B-axis	4	TWC4TS3010HP1	4	φ7	φ10	For single-corner inserts only		
	SS267/SS327-III	Attachment		3293-Y3031	3	TWC9TS1944HP1	9	φ12	φ52	φ44	CS0520 (M5)	
TORNOS	DECO 10/10a	Attachment	TORNOS	224-1900	±15°	3	TWC6TO11542HP1	6	φ12	φ42	φ32	CS0410 (M4)
	Evo DECO 10/10			242-1900								
	DECO 13a/13e			226-1900								
	Evo DECO 16/10			243-1900	±15°	2	TWC9TO10540P2	9	φ12	φ40	φ31	CS0410 (M4)
	Swiss ST26			246-1900								
	DECO 20a			223-1900								
	DECO 26a			225-1900	±25°	2	TWC9TO12050P2-D18	9	φ18	φ50	φ40	CS0410 (M4)
	Sigma 20			234-2750								
Sigma 32	236-2750											
HASEGAWA	JS-1W	-	HASEGAWA	-	0° -20°	2	TWC9HA22594P2	9	φ16	φ94	φ76	CS0620 (M6)
Various Machines	-	-	WTO	42BJ	-22°	1	TWC9WT42BJ20D12RH	9	φ12	-	-	-
	-	-		54BJ	30°	1	TWC9WT54BJ30D12RH	9	φ12	-	-	-
	-	-			30°	1	TWC9WT54BJ25D22RH	9	φ22	-	-	-

※Screws for insert-thickness 4.0/6.5mm are supplied with the cutter body.
Use screws for the thickness of the insert you are using.

Number of inserts and product appearance vary by part number.



Guideline: Raw material diameter up to φ6, machinable up to length 18mm
(Contact for further information)

Spare Insert Holder (Cartridge)

Designation	No. of teeth	φDm (mm)
TWC6HP2	6	12
TWC9HP2	9	12
TWC9HP2-D16	9	12

※Cannot be used for TWC9TS20550P2, TWC9TO12050P2-D18 and TWC9HA22594P2

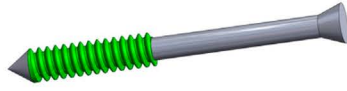
Note: Insert holder comes with insert screws and wrench Insert holder mounting screw is not included

Spare Parts

Description	Designation
Insert Screw	for insert thickness: 4mm
	FS117-2.2×6.0
Wrench	for insert thickness: 6.5mm
	FS124-2.2×7.9
Cutter body Mounting Bolt	T-07
	CS0309-TW

For CNC automatic lathe

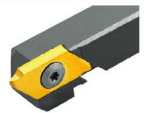
Practical examples

Single-lead Bone Screw					
Work Material	Titanium alloys	Major Dia.	φ3.6		
Material Diameter	φ4.0	Minor Dia.	φ2.4		
Spindle Speed	15rpm	Number of Threads	1	Thread Whirling ECO	50%
Cutter Speed	4,000rpm	Edge per insert	1	Competitor Thread Whirling	100%
Pitch/Feed	1.25mm	Thread Direction	Right-hand thread		

Cost ratio / workpiece (%)

The **Thread Whirling ECO** allows for more economical performance. In this case, by reducing the number of teeth from 9 to 3 and the number of insert corners from 2 to 1, total machining costs can be reduced by 48% while maintaining the same tool life.

Double-lead Bone Screw					
Work Material	Titanium alloys	Major Dia.	φ4.0	NTK Thread Whirling 9-Blade Specification	
Material Diameter	φ9.5	Minor Dia.	φ0.5		
Spindle Speed	15rpm	Number of Threads	2	Competitor Chasing Processing	170 sec
Cutter Speed	3,500rpm	Edge per insert	2		
Pitch/Feed	5.5mm	Thread Direction	Right-hand thread		

Single-lead Bone Screw					
Work Material	SUS316	Major Dia.	φ3.5	NTK Thread Whirling 9-Blade Specification	
Material Diameter	φ8.0	Minor Dia.	φ2.5		
Spindle Speed	23rpm	Number of Threads	1	Competitor Thread Whirling 6 Blade Specification	1,000 pcs
Cutter Speed	2,000rpm	Edge per insert	2		
Pitch/Feed	1.2mm	Thread Direction	Right-hand thread		

2,600 pcs



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For more information

