

# ZÁVITOVÉ FRÉZY VHM MONOLITNÉ DMT 3 v 1

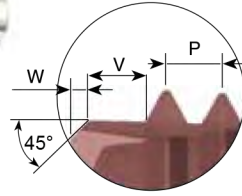
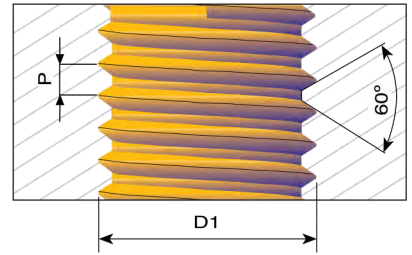
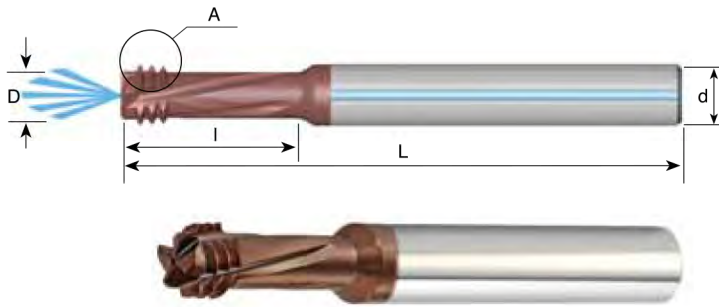
vrtanie, frézovanie, zrážanie



# DMT - 3 in 1

## ISO with internal coolant bore

### Tools for Internal Thread



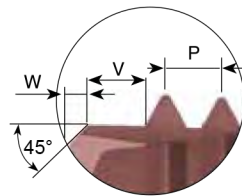
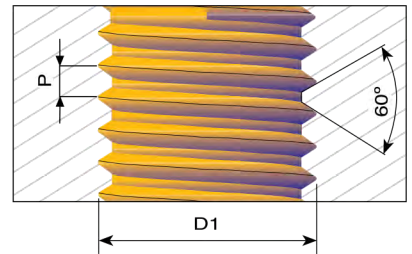
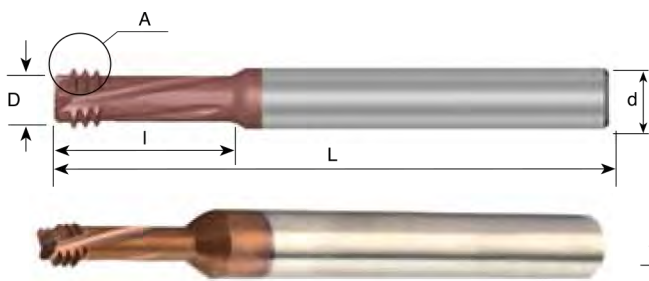
Left hand cutting  
For CNC code use M04

### For thread depth up to 2 x D1

Pitch mm	D1	Ordering Code	d	D	No. of Flutes	I	W	V	L
1.0	M6 - M9	<b>DMT 08047C14 1.0 ISO</b>	8	4.70	3	14.0	0.4	1.0	64
1.25	M8 - M12	<b>DMT 08061D18 1.25 ISO</b>	8	6.10	4	18.0	0.5	1.25	64
1.5	M10 - M15	<b>DMT 08078D23 1.5 ISO</b>	8	7.80	4	23.0	0.6	1.5	64
1.75	M12	<b>DMT 1009D26 1.75 ISO</b>	10	9.00	4	26.0	0.6	1.75	73
2.0	M16 - M23	<b>DMT 12118D35 2.0 ISO</b>	12	11.80	4	35.0	0.6	2.0	84

Order example: DMT 08047C14 1.0 ISO MT7

## ISO without internal coolant



Left hand cutting  
For CNC code use M04

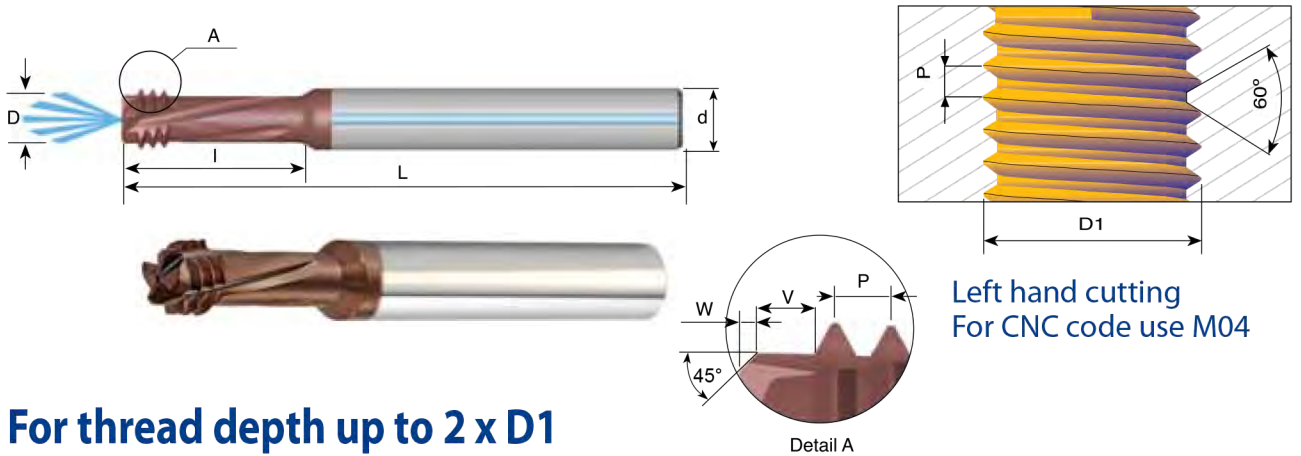
### For thread depth up to 2.5 x D1

Pitch mm	D1	Ordering Code	d	D	No. of Flutes	I	W	V	L
0.7	M4	<b>DMT 06032C11 0.7 ISO-D</b>	6	3.15	3	11.6	0.2	0.7	58
0.8	M5	<b>DMT 0604C14 0.8 ISO-D</b>	6	4.00	3	14.4	0.3	0.8	58

Order example: DMT 06032C11 0.7 ISO-D MT7

## UN with internal coolant bore

### Tools for Internal Thread

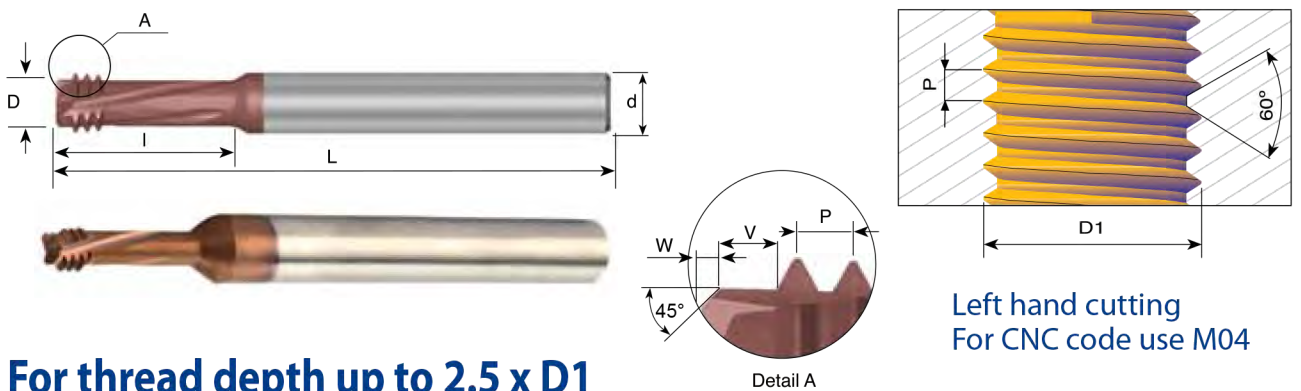


### For thread depth up to 2 x D1

Pitch TPI	UN, UNEF, UNF UNC, UNS	Ordering Code	d	D	No. of Flutes	I	W	V	L
28	1/4 - 3/8	DMT 0805C14 28 UN	8	5.00	3	14.5	0.4	0.9	64
24	5/16 - 1/2	DMT 08065D17 24 UN	8	6.50	4	17.0	0.5	1.05	64
20	1/4 - 3/8	DMT 08048C14 20 UN	8	4.80	3	14.0	0.4	1.25	64
18	5/16 - 7/16	DMT 0806D17 18 UN	8	6.00	4	17.0	0.5	1.4	64
16	3/8 - 1/2	DMT 08067C22 16 UN	8	6.70	3	22.0	0.5	1.6	64

Order example: DMT 08067C 22 16 UN MT7

## UN without internal coolant



### For thread depth up to 2.5 x D1

Pitch TPI	UNC	UNF	Ordering Code	d	D	No. of Flutes	I	W	V	L
36		8	DMT 06033C12 36 UN-D	6	3.30	3	12.0	0.2	0.7	58
32	8		DMT 06032C12 32 UN-D	6	3.20	3	12.3	0.3	0.8	58
32		10	DMT 06038C14 32 UN-D	6	3.80	3	14.0	0.3	0.8	58

Order example: DMT 06032C12 32UN-D MT7

## DMT type

**MT7** Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min	Feed mm/tooth Cutting Diameter = D							
			Ø3	Ø4	Ø5	Ø6	Ø8	Ø9	Ø10	Ø12
<b>P</b>	Low and Medium Carbon Steels < 0.55%C	60-120	0.02	0.03	0.03	0.04	0.05	0.05	0.05	0.05
	High Carbon Steels ≥ 0.55%C	60-90	0.015	0.02	0.03	0.03	0.04	0.04	0.04	0.05
	Alloy Steels, Treated Steels	50-80	0.015	0.02	0.02	0.02	0.02	0.03	0.03	0.04
<b>M</b>	Stainless Steels - Free Cutting	70-100	0.015	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Stainless Steels - Austenitic	60-90	0.015	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Cast Steels	70-90	0.015	0.02	0.02	0.02	0.02	0.03	0.03	0.04
<b>K</b>	Cast Iron	40-80	0.02	0.03	0.03	0.04	0.05	0.05	0.05	0.05
<b>N</b>	Aluminum ≤12%Si, Copper	100-200	0.02	0.03	0.03	0.04	0.05	0.05	0.05	0.05
	Aluminum >12% Si	60-140	0.015	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Synthetics, Duroplastics, Thermoplastics	50-200	0.03	0.04	0.05	0.05	0.06	0.06	0.06	0.06

## DMTH type

**MT11** Ultra-fine Sub-Micron grade with advanced PVD triple Blue coating

ISO	Materials	Cutting Speed m/min	Feed mm/tooth								
			Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø9	Ø10	Ø12
<b>P</b>	Low and Medium Carbon Steels < 0.55%C	60-120	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.05	0.05
	High Carbon Steels ≥ 0.55%C	60-90	0.02	0.02	0.02	0.03	0.03	0.04	0.04	0.04	0.05
	Alloy Steels, Treated Steels	50-80	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.04
<b>M</b>	Stainless Steels - Free Cutting	70-100	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Stainless Steels - Austenitic	60-90	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Cast Steels	70-90	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.04
<b>K</b>	Cast Iron	40-80	0.03	0.03	0.03	0.03	0.04	0.05	0.05	0.05	0.05
<b>N</b>	Aluminum ≤10%Si, Copper	100-200	0.03	0.03	0.03	0.03	0.04	0.05	0.05	0.05	0.05
	Aluminum >10% Si	60-140	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Synthetics, Duroplastics, Thermoplastics	50-200	0.04	0.05	0.05	0.05	0.05	0.06	0.06	0.06	0.06
<b>S</b>	Nickel Alloys, Titanium Alloys and High Temp. Alloys	20-40	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.06	0.06
<b>H</b>	Hardened Steels 45-50 HRc	60-70	0.02	0.02	0.02	0.03	0.04	0.04	0.05	0.05	0.05
	Hardened Steels 50-55 HRc	50-60	0.01	0.01	0.01	0.02	0.03	0.03	0.04	0.04	0.04