



**THREADING
TECHNOLOGY**



DC Swiss stands for High Quality Tools made in Switzerland. For over 75 years the company designs, produces and markets top of the range thread cutting tools intended for all companies and all materials. As one of the leading Tap Manufacturers in Europe and with over 6'000 standard articles, **DC Swiss** offers a reliable solution to any threading application.

For more information, visit www.dcswiss.com or contact your local dealer



Why pay more? Thanks to the DC Swiss FiT Line you get a high performance tool to an affordable price. Manufactured under the latest production standards in Europe, the FiT program offers an All-rounder solution with the best price-performance ratio on the market. Available as thread taps, thread mills and carbide end mills from 3 up to 48 mm.

Test it and be part of numerous satisfied customers

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www.dcswiss.com

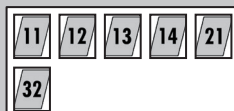


FiT

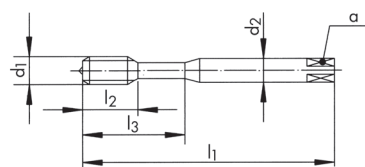
Best Value Tools

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FTN320V-4

FTN420V-4

FTN320TN-4

FTN420TN-4

FTN320V-4
FTN420V-4
FTN320TN-4
FTN420TN-4


$\varnothing d_1$ M	P mm	l_1 mm	l_2 mm	l_3 mm	d_2 mm	a mm		
3	0.50	56	12.0	18	3.5	2.7	3	2.50
4	0.70	63	14.0	21	4.5	3.4	3	3.30
5	0.80	70	15.0	25	6.0	4.9	3	4.20
6	1.00	80	17.0	30	6.0	4.9	3	5.00
8	1.25	90	20.0	35	8.0	6.2	3	6.80
10	1.50	100	22.0	39	10.0	8.0	3	8.50
12	1.75	110	24.0		9.0	7.0	3	10.20
14	2.00	110	28.0		11.0	9.0	3	12.00
16	2.00	110	30.0		12.0	9.0	3	14.00
20	2.50	140	36.0		16.0	12.0	3	17.50
22	2.50	140	36.0		18.0	14.5	3	19.50
24	3.00	160	39.0		18.0	14.5	4	21.00
27	3.00	160	42.0		20.0	16.0	4	24.00
30	3.50	180	45.0		22.0	18.0	4	26.50
33	3.50	180	48.0		25.0	20.0	4	29.50
36	4.00	200	51.0		28.0	22.0	4	32.00
39	4.00	200	55.0		32.0	24.0	4	35.00
42	4.50	200	55.0		32.0	24.0	4	37.50
45	4.50	220	59.0		36.0	29.0	4	40.50
48	5.00	250	63.0		36.0	29.0	4	43.00

GBP / ID
GBP / ID

10.90 / 174878

10.90 / 174879

10.90 / 174880

10.90 / 174881

12.90 / 174882

15.90 / 174883

20.90 / 174884

26.90 / 174885

29.90 / 174886

46.00 / 178977

65.00 / 178978

66.00 / 178979

96.00 / 178980

104.00 / 178981

125.00 / 178982

145.00 / 178983

193.00 / 178984

217.00 / 178985

278.00 / 178986

330.00 / 178987

$\varnothing d_1$ M	P mm	l_1 mm	l_2 mm	l_3 mm	d_2 mm	a mm		
3	0.50	56	12.0	18	3.5	2.7	3	2.50
4	0.70	63	14.0	21	4.5	3.4	3	3.30
5	0.80	70	15.0	25	6.0	4.9	3	4.20
6	1.00	80	17.0	30	6.0	4.9	3	5.00
8	1.25	90	20.0	35	8.0	6.2	3	6.80
10	1.50	100	22.0	39	10.0	8.0	3	8.50
12	1.75	110	24.0		9.0	7.0	3	10.20
14	2.00	110	28.0		11.0	9.0	3	12.00
16	2.00	110	30.0		12.0	9.0	3	14.00

GBP / ID
GBP / ID

15.90 / 174887

15.90 / 174888

15.90 / 174889

15.90 / 174890

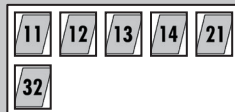
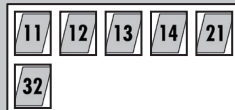
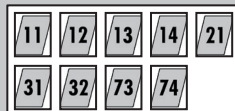
19.90 / 174891

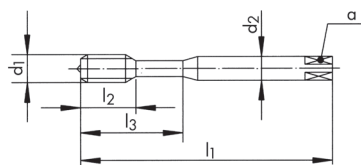
22.90 / 174892

28.90 / 174893

36.90 / 174894

39.90 / 174895


FTN360V-3

FTN460V-3

FTN360TN-3

FTN460TN-3

FTN360V-3
FTN460V-3
FTN360TN-3
FTN460TN-3


Ø d ₁ M	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm		
3	0.50	56	5.5	18	3.5	2.7	3	2.50
4	0.70	63	7.5	21	4.5	3.4	3	3.30
5	0.80	70	9.0	25	6.0	4.9	3	4.20
6	1.00	80	11.0	30	6.0	4.9	3	5.00
8	1.25	90	12.5	35	8.0	6.2	3	6.80
10	1.50	100	14.0	39	10.0	8.0	3	8.50
12	1.75	110	14.0		9.0	7.0	3	10.20
14	2.00	110	14.0		11.0	9.0	3	12.00
16	2.00	110	18.0		12.0	9.0	3	14.00
20	2.50	140	24.0		16.0	12.0	4	17.50
22	2.50	140	24.0		18.0	14.5	4	19.50
24	3.00	160	27.0		18.0	14.5	4	21.00
27	3.00	160	27.0		20.0	16.0	4	24.00
30	3.50	180	30.0		22.0	18.0	4	26.50
33	3.50	180	33.0		25.0	20.0	4	29.50
36	4.00	200	36.0		28.0	22.0	5	32.00
39	4.00	200	40.0		32.0	24.0	5	35.00
42	4.50	200	40.0		32.0	24.0	5	37.50
45	4.50	220	44.0		36.0	29.0	5	40.50
48	5.00	250	48.0		36.0	29.0	5	43.00

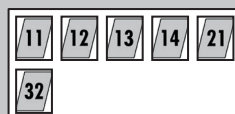
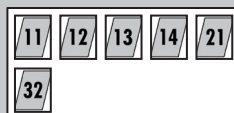
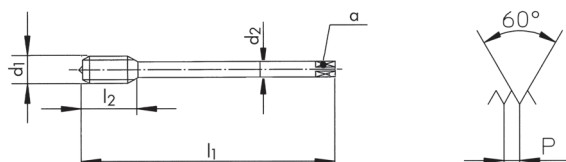
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GBP /ID

11.90 / 174896	
11.90 / 174897	
11.90 / 174898	
11.90 / 174899	
13.90 / 174900	
17.90 / 174901	
	21.90 / 174902
	28.90 / 174903
	33.90 / 174904
	53.00 / 179003
	74.00 / 179004
	75.00 / 179005
	108.00 / 179006
	117.00 / 179007
	146.00 / 179008
	163.00 / 179009
	217.00 / 179010
	246.00 / 179011
	263.00 / 179012
	303.00 / 179013

Ø d ₁ M	P mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm		
3	0.50	56	5.5	18	3.5	2.7	3	2.50
4	0.70	63	7.5	21	4.5	3.4	3	3.30
5	0.80	70	9.0	25	6.0	4.9	3	4.20
6	1.00	80	11.0	30	6.0	4.9	3	5.00
8	1.25	90	12.5	35	8.0	6.2	3	6.80
10	1.50	100	14.0	39	10.0	8.0	3	8.50
12	1.75	110	14.0		9.0	7.0	3	10.20
14	2.00	110	14.0		11.0	9.0	3	12.00
16	2.00	110	18.0		12.0	9.0	3	14.00

GBP /ID
GBP /ID

17.90 / 174905	
17.90 / 174906	
17.90 / 174907	
17.90 / 174908	
21.90 / 174909	
25.90 / 174910	
	30.90 / 174911
	40.90 / 174912
	43.90 / 174913


FTN420V-4

FTN460V-3

FTN420V-4
FTN460V-3


Ø d ₁ MF	P mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm		
20	1.50	125	28.0	16.0	12.0	4	18.50
22	1.50	125	28.0	18.0	14.5	4	20.50
24	1.50	140	30.0	18.0	14.5	4	22.50
24	2.00	140	34.0	18.0	14.5	4	22.00
25	1.50	140	30.0	18.0	14.5	4	23.50
27	2.00	140	34.0	20.0	16.0	4	25.00
30	1.50	150	32.0	22.0	18.0	4	28.50
30	2.00	150	32.0	22.0	18.0	4	28.00
32	1.50	150	32.0	22.0	18.0	4	30.50
33	2.00	160	32.0	25.0	20.0	4	31.00
36	2.00	170	34.0	28.0	22.0	4	34.00
39	3.00	200	45.0	32.0	24.0	4	36.00
42	3.00	200	45.0	32.0	24.0	4	39.00
48	2.00	190	36.0	36.0	29.0	5	46.00
48	3.00	220	48.0	36.0	29.0	5	45.00

GBP / ID

52.00/178988
57.00/178989
68.00/178990
68.00/178991
98.00/178992
101.00/178993
106.00/178994
106.00/178995
129.00/178996
145.00/178997
170.00/178998
225.00/178999
282.00/179000
333.00/179001
333.00/179002

Ø d ₁ MF	P mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm		
20	1.50	125	20.0	16.0	12.0	4	18.50
22	1.50	125	20.0	18.0	14.5	4	20.50
24	1.50	140	22.0	18.0	14.5	4	22.50
24	2.00	140	22.0	18.0	14.5	4	22.00
25	1.50	140	22.0	18.0	14.5	4	23.50
27	2.00	140	22.0	20.0	16.0	4	25.00
30	1.50	150	24.0	22.0	18.0	4	28.50
30	2.00	150	24.0	22.0	18.0	4	28.00
32	1.50	150	24.0	22.0	18.0	4	30.50
33	2.00	160	26.0	25.0	20.0	4	31.00
36	2.00	170	28.0	28.0	22.0	5	34.00
39	3.00	200	40.0	32.0	24.0	5	36.00
42	3.00	200	40.0	32.0	24.0	5	39.00
48	2.00	190	36.0	36.0	29.0	5	46.00
48	3.00	220	48.0	36.0	29.0	5	45.00

GBP / ID

64.00/179014
74.00/179015
86.00/179016
86.00/179017
124.00/179018
129.00/179019
134.00/179020
134.00/179021
145.00/179022
159.00/179023
176.00/179024
235.00/179025
299.00/179026
333.00/179027
333.00/179028



SixPack



GBP/ID

FTN5892 SIXPACK M3 – M10

69.00 / 180511

- 1x FTN320V-4 M3 6H
- 1x FTN320V-4 M4 6H
- 1x FTN320V-4 M5 6H
- 1x FTN320V-4 M6 6H
- 1x FTN320V-4 M8 6H
- 1x FTN320V-4 M10 6H



**ISO 2
6H**



SixPack



GBP/ID

FTN5896 SIXPACK M3 – M10

79.00 / 180512

- 1x FTN360V-3 M3 6H
- 1x FTN360V-3 M4 6H
- 1x FTN360V-3 M5 6H
- 1x FTN360V-3 M6 6H
- 1x FTN360V-3 M8 6H
- 1x FTN360V-3 M10 6H

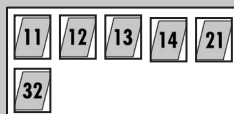


**ISO 2
6H**

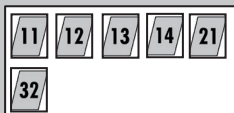




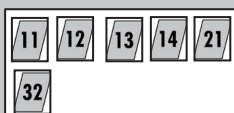
FTN320V-4



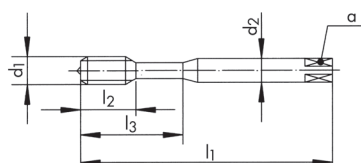
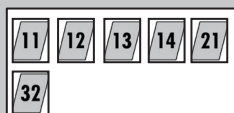
FTN420V-3



FTN360V-4



FTN460V-3



FTN320V-4

FTN420V-4

FTN360V-4

FTN460V-4



2B

2B

2B

2B

Ø" d ₁ UNC	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm		
*2	56	2.18	45	9.0		2.8	2.1	2	1.75
4	40	2.84	56	12.0	18	3.5	2.7	3	2.25
6	32	3.50	56	13.0	20	4.0	3.0	3	2.75
8	32	4.16	63	14.0	21	4.5	3.4	3	3.40
10	24	4.82	70	15.0	25	6.0	4.9	3	3.80
1/4	20	6.35	80	17.0	30	7.0	5.5	3	5.10

GBP / ID

17.50 / 181269
14.00 / 181270
13.00 / 181271
14.00 / 181272
14.50 / 181273
14.50 / 181274

Ø" d ₁ UNC	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm		
5/16	18	7.93	90	20.0	6.0	4.9	3	6.50
3/8	16	9.52	100	22.0	7.0	5.5	3	8.00
7/16	14	11.11	100	19.0	8.0	6.2	3	9.30
1/2	13	12.70	110	24.0	9.0	7.0	3	10.80
5/8	11	15.87	110	30.0	12.0	9.0	3	13.60
3/4	10	19.05	125	33.0	14.0	11.0	3	16.60

GBP / ID

16.00 / 181275
19.50 / 181276
23.00 / 181277
24.90 / 181278
35.00 / 181279
47.00 / 181280

Ø" d ₁ UNC	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm		
2	56	2.18	45	8.0		2.8	2.1	2	1.75
4	40	2.84	56	5.5	18	3.5	2.7	3	2.25
6	32	3.50	56	6.5	20	4.0	3.0	3	2.75
8	32	4.16	63	7.5	21	4.5	3.4	3	3.40
10	24	4.82	70	9.0	25	6.0	4.9	3	3.80
1/4	20	6.35	80	11.0	30	7.0	5.5	3	5.10
5/16	18	7.93	90	12.5	35	8.0	6.2	3	6.50
3/8	16	9.52	100	14.0	39	10.0	8.0	3	8.00

GBP / ID

20.90 / 181281
18.50 / 181282
17.50 / 181283
17.50 / 181284
16.00 / 181285
16.50 / 181286
17.90 / 181287
19.90 / 181288

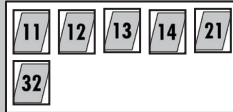
Ø" d ₁ UNC	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm		
7/16	14	11.11	100	14.0	8.0	6.2	3	9.30
1/2	13	12.70	110	14.0	9.0	7.0	3	10.80
5/8	11	15.87	110	18.0	12.0	9.0	3	13.60
3/4	10	19.05	125	21.0	14.0	11.0	3	16.60

GBP / ID

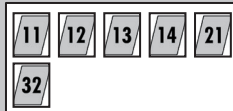
24.90 / 181289
27.00 / 181290
39.90 / 181291
50.50 / 181292



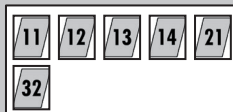
FTN320V-4



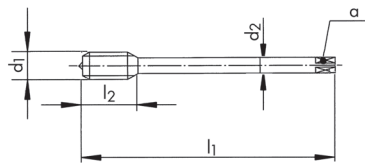
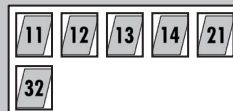
FTN420V-4



FTN360V-4



FTN460V-3



FTN320V-4

FTN420V-4

FTN360V-4

FTN460V-4



Ø" d ₁ UNF	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm		
10	32	4.82	70	15.0	25	6.0	4.9	3	4.05
1/4	28	6.35	80	17.0	30	7.0	5.5	3	5.50

GBP/ID

14.50/181293

16.50/181294

Ø" d ₁ UNF	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm		
5/16	24	7.93	90	20.0	6.0	4.9	3	6.90
3/8	24	9.52	100	22.0	7.0	5.5	3	8.50
7/16	20	11.11	100	19.0	8.0	6.2	3	9.80
1/2	20	12.70	100	24.0	9.0	7.0	3	11.40
5/8	18	15.87	100	26.0	12.0	9.0	3	14.50
3/4	16	19.05	125	33.0	14.0	11.0	4	17.50

GBP/ID

18.50/181295

20.50/181296

25.50/181297

26.90/181298

37.50/181299

52.00/181300

Ø" d ₁ UNF	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	l ₃ mm	d ₂ mm	a mm		
10	32	4.82	70	9.0	25	6.0	4.9	3	4.05
1/4	28	6.35	80	11.0	30	7.0	5.5	3	5.50
5/16	24	7.93	90	12.5	35	8.0	6.2	3	6.90
3/8	24	9.52	100	14.0	39	10.0	8.0	3	8.50

GBP/ID

16.50/181301

18.00/181302

19.90/181303

21.50/181304

Ø" d ₁ UNF	P TPI	d ₁ mm	l ₁ mm	l ₂ mm	d ₂ mm	a mm		
7/16	20	11.11	100	14.0	8.0	6.2	3	9.80
1/2	20	12.70	100	14.0	9.0	7.0	3	11.40
5/8	18	15.87	100	14.0	12.0	9.0	3	14.50
3/4	16	19.05	125	18.0	14.0	11.0	4	17.50

GBP/ID

27.00/181305

29.00/181306

41.00/181307

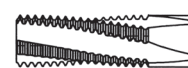
54.50/181308

CUTTING SPEEDS AND FEED RATES

Material groups		Material designation	Hardness (HB)	Tensile strength Rm (N/mm ²)
Steels	11	Free-cutting steels	< 200	< 700
	12	Structural / cementation steels	< 200	< 700
	13	Carbon steels	< 300	< 1000
	14	Alloy steels <850 N/mm ²	< 250	< 850
	15	Alloy steels hard. / temp. >850 - <1150 N/mm ²	> 250	> 850
	16	High tensile alloy steels	> 250	> 850
Stainless Steels	21	Free machining stainless steels	< 250	< 850
	22	Austenitic stainless steels	< 250	< 850
	23	Ferritic and martensitic <850 N/mm ²	< 250	< 850
	24	Ferritic and martens. >850 - <1150 N/mm ²	> 250	> 850
Cast iron	31	Cast iron	< 250	< 850
	32	Spheroidal graphite + malleable cast iron	< 250	< 850
Titanium	41	Pure titanium	< 250	< 850
	42	Titanium alloys	> 250	> 850
Nickel	51	Nickel alloys 1 <850 N/mm ²	< 250	< 850
	52	Nickel alloys 2 >850 - <1150 N/mm ²	> 250	> 850
	53	Nickel alloys 3 >1150 - ≤1600 N/mm ²	> 340	> 1150
Copper		Pure copper (electrolytic copper)	< 120	< 400
		Short chip brass, phosphor bronze, gun metal	< 200	< 700
	63	Long chip brass	< 200	< 700
Aluminium Magnesium	71	Al unalloyed	< 100	< 350
	72	Al alloyed Si < 1.5 %	< 150	< 500
	73	Al alloyed Si > 1.5 % - < 10 %	< 120	< 400
	74	Al alloyed Si > 10 %, Mg-Alloys	< 120	< 400
Plastic compounds	81	Thermoplastics	-	-
	82	Duroplastics	-	-
	83	Glass fibre reinforced plastics	-	-

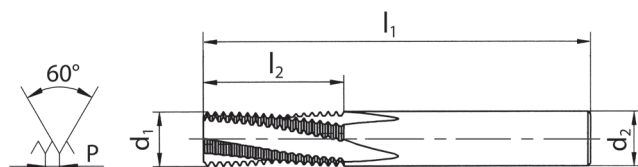
THREAD MILLING

Vc (m/min)		Feed rate fz (mm/tooth)	SFM (Surface feet/min)		Feed rate fz (inch/tooth)
Uncoated	Coated		Uncoated	Coated	
50 – 90	80 – 140	0.005 – 0.070	164 – 295	262 – 459	0.0002 – 0.0027
40 – 70	60 – 110	0.005 – 0.070	131 – 230	197 – 361	0.0002 – 0.0027
40 – 70	60 – 110	0.005 – 0.050	131 – 230	197 – 361	0.0002 – 0.0019
40 – 70	60 – 110	0.005 – 0.050	131 – 230	197 – 361	0.0002 – 0.0019
30 – 60	50 – 90	0.005 – 0.050	98 – 197	164 – 295	0.0002 – 0.0019
20 – 40	30 – 60	0.005 – 0.050	66 – 131	98 – 197	0.0002 – 0.0019
30 – 60	50 – 90	0.005 – 0.020	98 – 197	164 – 295	0.0002 – 0.0007
20 – 40	50 – 90	0.005 – 0.020	66 – 131	164 – 295	0.0002 – 0.0007
30 – 60	50 – 90	0.005 – 0.020	98 – 197	164 – 295	0.0002 – 0.0007
20 – 40	30 – 60	0.005 – 0.020	66 – 131	98 – 197	0.0002 – 0.0007
30 – 90	50 – 100	0.030 – 0.100	98 – 295	164 – 328	0.0011 – 0.0039
30 – 80	50 – 100	0.030 – 0.100	98 – 262	164 – 328	0.0011 – 0.0039
40 – 70	60 – 90	0.003 – 0.040	131 – 230	197 – 295	0.0001 – 0.0015
20 – 40	30 – 60	0.002 – 0.030	66 – 131	98 – 197	0.0001 – 0.0011
20 – 40	30 – 60	0.003 – 0.050	66 – 131	98 – 197	0.0001 – 0.0019
20 – 40	30 – 60	0.003 – 0.050	66 – 131	98 – 197	0.0001 – 0.0019
10 – 20	20 – 30	0.002 – 0.010	33 – 66	66 – 98	0.0001 – 0.0004
150 – 200	200 – 250	0.008 – 0.100	492 – 656	656 – 820	0.0003 – 0.0039
150 – 200	200 – 250	0.008 – 0.100	492 – 656	656 – 820	0.0003 – 0.0039
150 – 200	200 – 250	0.008 – 0.100	492 – 656	656 – 820	0.0003 – 0.0039
80 – 200	80 – 200	0.010 – 0.150	262 – 656	262 – 656	0.0004 – 0.0059
80 – 200	80 – 200	0.010 – 0.150	262 – 656	262 – 656	0.0004 – 0.0059
80 – 200	80 – 200	0.010 – 0.150	262 – 656	262 – 656	0.0004 – 0.0059
80 – 200	80 – 200	0.010 – 0.100	262 – 656	262 – 656	0.0004 – 0.0039
100 – 200	150 – 300	0.010 – 0.015	328 – 656	492 – 984	0.0004 – 0.0006
50 – 100	80 – 150	0.010 – 0.015	164 – 328	262 – 492	0.0004 – 0.0006
60 – 80	80 – 150	0.010 – 0.015	197 – 262	262 – 492	0.0004 – 0.0006


FMILL6215

FMILL6215VS

FMILL6265

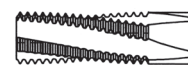
FMILL6265VS

FMILL6215
FMILL6215VS
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FMILL6265VS


$\varnothing D_1$ M	P mm	d_1 mm	l_1 mm	l_2 mm	d_2 mm		
------------------------	---------	-------------	-------------	-------------	-------------	--	--

4	0.70	3.00	48	8.8	6	3	3.30
5	0.80	3.80	48	10.8	6	3	4.20
6	1.00	4.50	54	13.5	6	3	5.00
8	1.25	5.95	54	18.1	6	3	6.80
10	1.50	7.95	64	21.8	8	4	8.50
12	1.75	9.95	72	25.4	10	4	10.20
14	2.00	9.95	74	31.0	10	4	12.00
16	2.00	11.95	80	35.0	12	4	14.00
18	2.50	13.95	90	41.3	14	4	15.50
20							17.50

GBP/ID
GBP/ID
GBP/ID
GBP/ID

99.00/181333	115.00/181309		
99.00/181334	115.00/181310		
105.00/181335	124.00/181311	109.00/181338	129.00/181314
115.00/181336	139.00/181312	119.00/181339	145.00/181315
120.00/181337	149.00/181313	129.00/181340	155.00/181316
		159.00/181341	169.00/181317
		189.00/181342	219.00/181318
		219.00/181343	245.00/181319
		255.00/181344	285.00/181320



FMILL6265

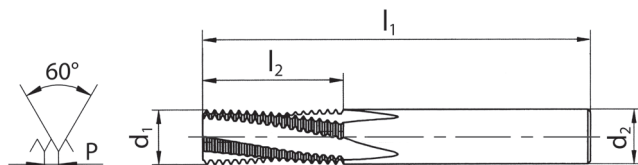
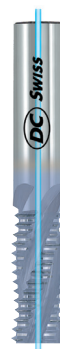


FMILL6265VS



FMILL6265

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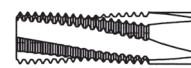


$\varnothing D_1$	P	d_1	l_1	l_2	d_2		
MF	mm	mm	mm	mm	mm		
10	1.00	7.95	64	21.5	8	4	9.00
10	1.25	7.95	64	21.9	8	4	8.80
12	1.00	9.95	72	25.5	10	4	11.00
12	1.50	9.95	72	26.3	10	4	10.50

GBP/ID

GBP/ID

149.00/181345	169.00/181321
149.00/181346	169.00/181322
185.00/181347	209.00/181323
185.00/181348	209.00/181324



FMILL6265

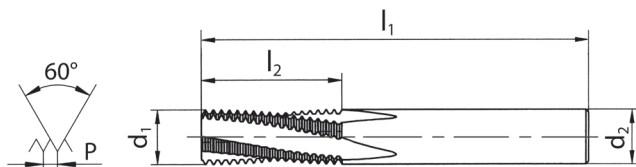


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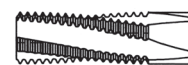


Ø" D ₁	P	d ₁	l ₁	l ₂	d ₂		
UNC	TPI	mm	mm	mm	mm		
1/4	20	4.80	54	14.6	6.0	3	5.10
5/16	18	5.95	54	17.6	6.0	3	6.50
3/8	16	7.10	64	21.4	8.0	4	8.00
1/2	13	9.95	72	28.3	10.0	4	10.80

GBP/ID

GBP/ID

109.00/181349	139.00/181325
109.00/181350	139.00/181326
135.00/181351	155.00/181327
175.00/181352	195.00/181328



FMILL6265

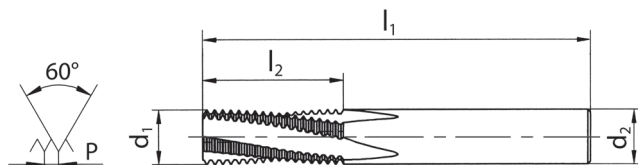
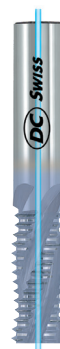


FMILL6265VS



FMILL6265

FMILL6265VS



Ø" D ₁	P	d ₁	l ₁	l ₂	d ₂		
UNF	TPI	mm	mm	mm	mm		
1/4	28	4.80	54	14.1	6.0	3	5.50
5/16	24	5.95	54	17.5	6.0	3	6.90
3/8	24	7.10	64	20.6	8.0	4	8.50
1/2	20	9.95	72	27.3	10.0	4	11.40

GBP/ID

GBP/ID

115.00/181353	145.00/181329
115.00/181354	145.00/181330
149.00/181355	169.00/181331
185.00/181356	205.00/181332

CUTTING SPEEDS AND FEED RATES **MILLING**

Cutting Speeds FEM1579VS & FEM1589VS*



Material groups		Ø 4 - 6	Ø 7 - 8	Ø 9 - 10	Ø 11 - 12	Ø 13 - 14	Ø 16	Ø 18	Ø 20
Alu	v_c [m/min]	350	350	350	350	350	350	350	350
	f_z [mm]	0,080	0,110	0,140	0,180	0,220	0,260	0,300	0,250
	v_f [mm/min]	5900	6100	6240	6700	7000	7200	7400	7800
	n [1/min]	18500	14000	11140	9300	8000	7000	6200	5600
Alu > 9% Si	v_c [m/min]	300	300	300	300	300	300	300	300
	f_z [mm]	0,068	0,094	0,119	0,153	0,190	0,220	0,250	0,306
	v_f [mm/min]	4300	4500	4500	4900	5200	5200	5300	5800
	n [1/min]	16000	12000	9600	8000	6800	6000	5300	4800
Steel < 800 N/mm ²	v_c [m/min]	150	150	150	150	150	150	150	150
	f_z [mm]	0,044	0,060	0,077	0,100	0,120	0,143	0,170	0,200
	v_f [mm/min]	1400	1430	1470	1600	1600	1700	1800	1900
	n [1/min]	8000	6000	4800	4000	3400	3000	2650	2400
Steel < 1200 N/mm ²	v_c [m/min]	140	140	140	140	140	140	140	140
	f_z [mm]	0,040	0,055	0,070	0,090	0,110	0,130	0,150	0,180
	v_f [mm/min]	1200	1220	1250	1340	1400	1500	1500	1600
	n [1/min]	7400	5600	4500	3720	3200	2800	2500	2200
Steel < 1600 N/mm ²	v_c [m/min]	110	110	110	110	110	110	110	110
	f_z [mm]	0,034	0,047	0,060	0,077	0,095	0,110	0,130	0,155
	v_f [mm/min]	800	820	840	900	950	960	1000	1080
	n [1/min]	5800	4400	3500	3000	2500	2200	2000	1750
Stainless Steel INOX < 800 N/mm ²	v_c [m/min]	85	85	85	85	85	85	85	85
	f_z [mm]	0,032	0,044	0,056	0,070	0,090	0,105	0,120	0,145
	v_f [mm/min]	580	600	610	630	700	710	720	780
	n [1/min]	4500	3400	2700	2200	1950	1700	1500	1350
Stainless Steel INOX > 800 N/mm ²	v_c [m/min]	75	75	75	75	75	75	75	75
	f_z [mm]	0,027	0,037	0,047	0,060	0,075	0,090	0,100	0,120
	v_f [mm/min]	430	440	450	480	510	540	530	580
	n [1/min]	4000	3000	2400	2000	1700	1500	1300	1200
GG	v_c [m/min]	150	150	150	150	150	150	150	150
	f_z [mm]	0,044	0,060	0,077	0,100	0,120	0,145	0,165	0,200
	v_f [mm/min]	1400	1430	1470	1600	1640	1730	1750	1900
	n [1/min]	8000	6000	4800	4000	3400	3000	2650	2400
GGG	v_c [m/min]	140	140	140	140	140	140	140	140
	f_z [mm]	0,040	0,055	0,070	0,090	0,110	0,130	0,150	0,180
	v_f [mm/min]	1200	1200	1250	1340	1400	1450	1500	1600
	n [1/min]	7400	5600	4500	3700	3200	2800	2500	2250
Special Alloys	v_c [m/min]	40	40	40	40	40	40	40	40
	f_z [mm]	0,026	0,036	0,046	0,060	0,070	0,085	0,100	0,120
	v_f [mm/min]	220	230	230	250	250	270	280	300
	n [1/min]	2100	1600	1300	1080	900	800	700	640
Titanium	v_c [m/min]	70	70	70	70	70	70	70	70
	f_z [mm]	0,027	0,037	0,047	0,060	0,070	0,085	0,100	0,120
	v_f [mm/min]	400	410	420	450	450	480	500	530
	n [1/min]	3700	2800	2200	1850	1600	1400	1200	1120
Non ferrous materials	v_c [m/min]	260	260	260	260	260	260	260	260
	f_z [mm]	0,080	0,110	0,140	0,180	0,220	0,260	0,300	0,360
	v_f [mm/min]	4400	4550	4600	5000	5200	5400	5500	6000
	n [1/min]	13800	10400	8300	6900	5900	5200	4600	1150

* Recommendations FEM1589VS

Processing	▽▽	▽	▽
a_p	1,50 x D	1,50 x D	1,00 x D
a_e	0,04 x D	0,50 x D	1,00 x D
v_c	x 1,00	x 0,90	x 0,85
f_z	x 1,00	x 0,85	x 0,50

L/D	v_c	f_z
< 3 x D	1.0	1.0
< 5 x D	0.8	0.8
> 5 x D	0.55	0.5



Solid Carbide End Mills With variable helix

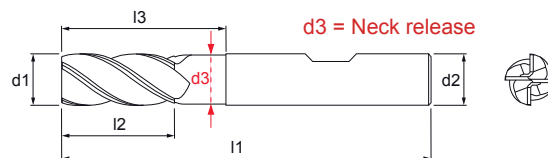
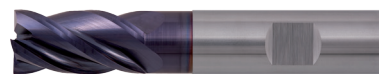
Catalogue-N°: FEM1579VS

Characteristics:

- Low deflections
- Vibration-free operation
- Neck release for deeper cuttings
- 45° protective chamfer

Application:

Slotting, side milling and pocketing
Especially for roughing and finishing
Excellent chip shape and evacuation
Improved surface quality



Material	Alu	Alu > 9% Si	Steel < 800 N/mm ²	Steel < 1200 N/mm ²	Steel < 1600 N/mm ²	Steel < 55 HRC	Steel < 60 HRC	Steel < 66 HRC	Stainless Steel (Inox) < 800 N/mm ²	Stainless Steel (Inox) > 800 N/mm ²	GG	GGG	Special Alloys	Titanium	Non ferrous materials	Plastic compounds	MMS	Max.	None	AIR
FEM1579VS	○	○	●	●	●				●	●	●	●	○	●	○		●	●	○	○

● Optimal ○ Suitable

d1 h10 mm		d2 h6 mm	d3 - 0,1 mm	I1 mm	I2 mm	I3 mm	Z	GBP / ID
4	0,06	6	3,8	57	11	15	4	18.50 / 182557
5	0,08	6	4,8	57	13	20	4	18.50 / 182558
6	0,09	6	5,8	57	13	21	4	18.50 / 182559
7	0,1	8	6,5	63	19	27	4	24.00 / 182560
8	0,12	8	7,5	63	19	27	4	24.00 / 182561
9	0,14	10	8,5	72	22	31	4	33.50 / 182562
10	0,15	10	9,5	72	22	32	4	33.50 / 182563
11	0,17	12	10,5	83	26	38	4	43.00 / 182564
12	0,18	12	11,5	83	26	38	4	43.00 / 182565
13	0,2	14	12,5	83	26	38	4	55.50 / 182566
14	0,21	14	13,5	83	26	38	4	55.50 / 182567
16	0,24	16	15,5	92	32	44	4	71.00 / 182568
18	0,27	18	17,5	92	32	44	4	122.00 / 182569
20	0,3	20	19,5	104	38	54	4	135.00 / 182570



Solid Carbide End Mills – Long Execution With variable helix

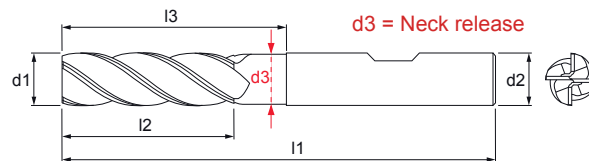
Catalogue-N°: FEM1589VS

Characteristics:

- Low deflections
- Vibration-free operation
- Neck release for deeper cuttings
- 45° protective chamfer

Application:

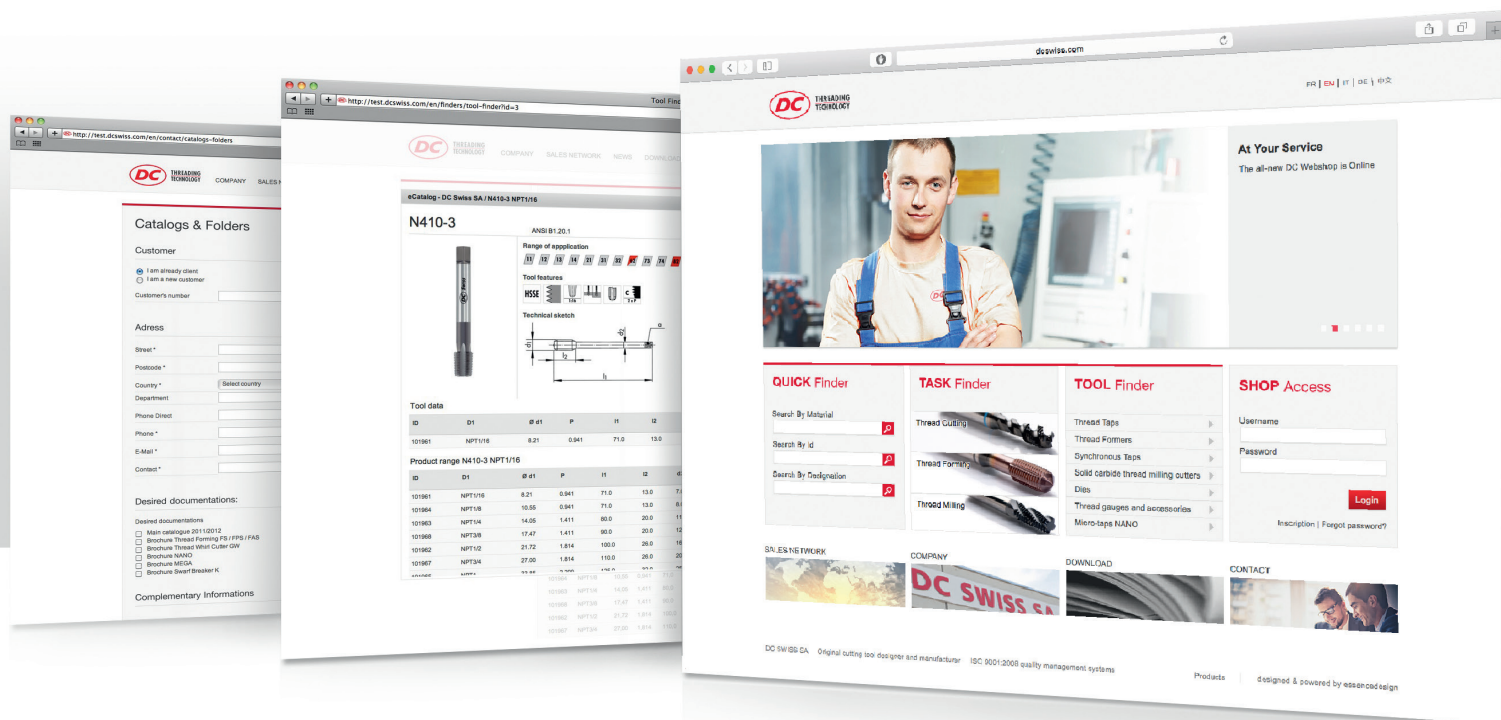
Slotting, side milling and pocketing
Especially for roughing and finishing
Excellent chip shape and evacuation
Improved surface quality



Material	Alu	Alu > 9% Si	Steel < 800 N/mm ²	Steel < 1200 N/mm ²	Steel < 1600 N/mm ²	Steel < 55 HRC	Steel < 60 HRC	Steel < 66 HRC	Stainless Steel (Inox) < 800 N/mm ²	Stainless Steel (Inox) > 800 N/mm ²	GG	GGG	Special Alloys	Titanium	Non ferrous materials	Plastic compounds	MMS	Max.	None	AIR
FEM1589VS	○	○	●	●	●				●	●	●	●	○	●	○		●	●	○	○

● Optimal ○ Suitable

d1 h10 mm		d2 h6 mm	d3 - 0,1 mm	I1 mm	I2 mm	I3 mm	Z	GBP / ID
6	0,09	6	5,8	63	20	27	4	34.00 / 182571
8	0,12	8	7,5	80	38	44	4	39.50 / 182572
10	0,15	10	9,5	95	45	55	4	56.50 / 182573
12	0,18	12	11,5	100	50	55	4	71.00 / 182574
16	0,24	16	15,5	123	63	75	4	122.00 / 182575
20	0,3	20	19,5	125	65	75	4	172.00 / 182576



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Warning

Tools can break or shatter either through technical failure or negligence, and can endanger the health of the operator. Always obey the safety and health regulations, also the wearing of safety glasses is compulsory.

The grinding of tools causes hazardous particles, and must be performed only under most rigorous safety standards.

.....

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