

TECHNO THREAD
HPT®



DTH Ni₃

Velocità di taglio e avanzamenti

Cutting speed and feed advance

Materiale	Gruppo materiale				
		Non rivestita - Uncoated			
		Vc	Fb	Fz	
1	1.1 Acciaio Dolce Magnetico - Magnetic Soft Iron				
	1.2 Acciaio da Costruzione - Structural Case Hardened Steel				
	1.3 Acciaio al Carbonio - Carbon Steel				
	1.4 Acciaio Legato - Alloy Steel				
	1.5 Acciaio Legato Temprato - Alloy Heat Treated Steel				
	1.6 Acciaio Legato Temprato - Alloy Heat Treated Steel				
	1.7 Acciaio Legato 45 HRC - Hardened Steel to 45 HRC				
	1.8 Acciaio Legato 58 HRC - Hardened Steel to 58 HRC				
2	2.1 Acciaio Inossidabile - Stainless steel				
	2.2 Austenico - Austenitic				
	2.3 Ferrico + Austenico - Ferritic Austenitic				
3	3.1 Ghisa lamellare - Grey Cast Iron	80-140	0,08	0,25	0,04
	3.2 Ghisa lamellare trattata - Grey Cast Iron heat treated	70-120	0,08	0,25	0,03
	3.3 Ghisa sferoidale - Spher Cast Iron	80-140	0,08	0,25	0,04
	3.4 Ghisa sferoidale trattata - Sphere Cast Iron heat treated	60-90	0,08	0,20	0,03
	3.5 Ghisa sfereidale trattata - Sphere Cast Iron heat treated	60-90	0,08	0,20	0,03
	3.6 Ghisa malleabile - Malleable Iron	80-140	0,08	0,25	0,04
	3.7 Ghisa Malleabile trattata - Malleable Iron treated	70-120	0,08	0,20	0,03
4	4.1 Titanio Non Legato - Pure Titanium				
	4.2 Titanio Legato - Titanium Alloys				
	4.3 Titanio Legato - Titanium Alloys				
5	5.1 Nichel non legato - Pure Nickel				
	5.2 Nichel legato - Nickel alloys heat resistant				
	5.3 Nichel legato - Nickel alloys high heat resistant				
6	6.1 Rame non legato - Non-alloy copper				
	6.2 Ottone, Bronzo - Short chip brass, bronze, red brass	80-160	0,10	0,25	0,05
	6.3 Ottone a truciolo lungo - long chip brass				
	6.4 Bronzo alta resistenza - Cu-Al-Ti alloy (Amico)	60-120	0,10	0,20	0,04
7	7.1 Alluminio MG non legato - Alu MG Non Alloy				
	7.2 Alluminio Legato ≤ 5% Si - Alu Cast Alloy Si ≤ 5%	100-200	0,10	0,30	0,03
	7.3 Alluminio Legato ≥ 5% ≤ 10% Si - Alu Cast Alloy Si ≥ 5% ≤ 10%	100-200	0,10	0,30	0,03
	7.4 Alluminio Legato ≥ 10% Si - Alu Cast Alloy Si ≥ 10%	80-180	0,10	0,30	0,03
8	6.1 Termoplastici - Thermoplastics				
	6.2 Plastiche termoindurenti - Thermosettings plastics	60-120	0,15	0,40	0,04
	6.3 Plastiche rinforzate - Fibre reinforced plastics	40-80	0,10	0,25	0,04

VC=Velocità di taglio in mm. Fz=Avanzamento al dente in mm.

VC=Cutting speed in mm. Fz=Milin feed in mm/tooth.

Velocità di taglio e avanzamenti

Cutting speed and feed advance

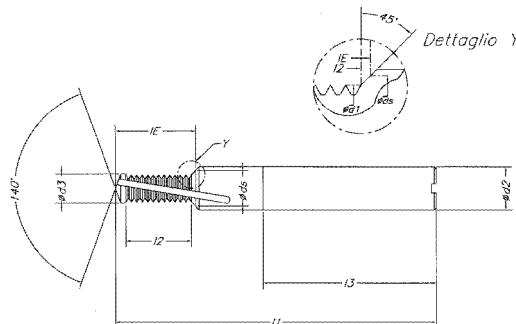
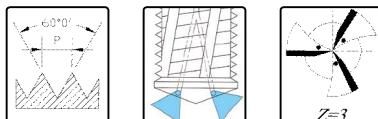
Materiale	Gruppo materiale				
		Rivestita X-TOP - Coated X-TOP			
		Vc	Fb	Fz	
1	1.1 Acciaio Dolce Magnetico - Magnetic Soft Iron				
	1.2 Acciaio da Costruzione - Structural Case Hardened Steel				
	1.3 Acciaio al Carbonio - Carbon Steel				
	1.4 Acciaio Legato - Alloy Steel				
	1.5 Acciaio Legato Temprato - Alloy Heat Treated Steel				
	1.6 Acciaio Legato Temprato - Alloy Heat Treated Steel				
	1.7 Acciaio Legato 45 HRC - Hardened Steel to 45 HRC				
	1.8 Acciaio Legato 58 HRC - Hardened Steel to 58 HRC				
2	2.1 Acciaio Inossidabile - Stainless steel				
	2.2 Austenico - Austenitic				
	2.3 Ferrico + Austenico - Ferritic Austenitic				
3	3.1 Ghisa lamellare - Grey Cast Iron	100-200	0,08	0,25	0,04
	3.2 Ghisa lamellare trattata - Grey Cast Iron heat treated	80-160	0,08	0,25	0,03
	3.3 Ghisa sferoidale - Spher Cast Iron	100-200	0,08	0,25	0,04
	3.4 Ghisa sferoidale trattata - Sphere Cast Iron heat treated	70-140	0,08	0,20	0,03
	3.5 Ghisa sfenoidale trattata - Sphere Cast Iron heat treated	70-140	0,08	0,20	0,03
	3.6 Ghisa malleabile - Malleable Iron	100-200	0,08	0,25	0,04
	3.7 Ghisa Malleabile trattata - Malleable Iron treated	80-160	0,08	0,20	0,03
4	4.1 Titanio Non Legato - Pure Titanium				
	4.2 Titanio Legato - Titanium Alloys				
	4.3 Titanio Legato - Titanium Alloys				
5	5.1 Nichel non legato - Pure Nickel				
	5.2 Nichel legato - Nickel alloys heat resistant				
	5.3 Nichel legato - Nickel alloys high heat resistant				
6	6.1 Rame non legato - Non-alloy copper				
	6.2 Ottone, Bronzo - Short chip brass, bronze, red brass	100-200	0,10	0,25	0,05
	6.3 Ottone a truciolo lungo - long chip brass				
	6.4 Bronzo alta resistenza - Cu-Al-Fe alloy (Ampco)	80-160	0,10	0,20	0,04
7	7.1 Alluminio MG non legato - Alu MG Non Alloy				
	7.2 Alluminio Legato ≤ 5% Si - Alu Cast Alloy Si ≤ 5%	100-350	0,10	0,30	0,03
	7.3 Alluminio Legato ≥ 5% ≤ 10% Si - Alu Cast Alloy Si ≥ 5% ≤ 10%	100-350	0,10	0,30	0,03
	7.4 Alluminio Legato ≥ 10% Si - Alu Cast Alloy Si ≥ 10%	80-280	0,10	0,30	0,03
8	6.1 Termoplastici - Thermoplastics				
	6.2 Plastiche termoindurenti - Thermosettings plastics	60-200	0,15	0,40	0,04
	6.3 Plastiche rinforzate - Fibre reinforced plastics	40-120	0,10	0,25	0,04

VC=Velocità di taglio in mm. Fz=Avanzamento al dente in mm.

VC=Cutting speed in mm. Fz=Milin feed in mm/tooth.



- Frese foro, filetta, smussa in metallo duro integrale,
con fori di lubrificazione.
 Solid carbide thrillers, with coolant holes.



MA 1.5 x Ø

M	P	I1	I2	I3	d1	d2	d3	ds	IE	Codice	Non rivestita Prezzo €	Rivestita X-TOP Codice	Prezzo €
6	1.00	62	9.05	36	4.90	8	5.00	6.3	11.66	TTDTH06100030	210,00	TTDTH06100033	225,00
8	1.25	74	11.32	40	6.50	10	6.75	8.3	14.64	TTDTH08125030	258,00	TTDTH08125033	275,00
10	1.5	85	15.08	45	8.20	12	8.50	10.3	19.11	TTDTH10150030	310,00	TTDTH10150033	340,00
12	1.75	89	17.6	45	9.90	14	10.25	12.3	22.33	TTDTH12175030	386,00	TTDTH12175033	408,00
14	2.00	102	20.11	48	11.6	16	12.00	14.3	25.54	TTDTH14200030	465,00	TTDTH14200033	493,00
16	2.00	102	24.11	48	13.6	18	14.00	16.3	29.91	TTDTH16200030	550,00	TTDTH16200033	585,00

MA 2 x Ø

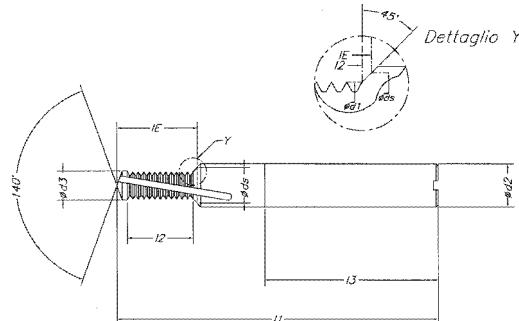
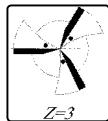
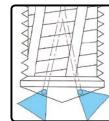
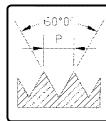
M	P	I1	I2	I3	d1	d2	d3	ds	IE	Codice	Non rivestita Prezzo €	Rivestita X-TOP Codice	Prezzo €
6	1.00	62	12.05	36	4.90	8	5.00	6.3	14.66	TTDTH06100031	215,00	TTDTH06100034	232,00
8	1.25	74	15.07	40	6.50	10	6.75	8.3	18.39	TTDTH08125031	268,00	TTDTH08125034	285,00
10	1.5	85	19.58	45	8.20	12	8.50	10.3	23.61	TTDTH10150031	330,00	TTDTH10150034	353,00
12	1.75	89	22.85	45	9.90	14	10.25	12.3	27.58	TTDTH12175031	396,00	TTDTH12175034	420,00
14	2.00	102	28.11	48	11.6	16	12.00	14.3	33.54	TTDTH14200031	480,00	TTDTH14200034	506,00
16	2.00	102	32.11	48	13.6	18	14.00	16.3	37.91	TTDTH16200031	570,00	TTDTH16200034	602,00

MA 2.5 x Ø

M	P	I1	I2	I3	d1	d2	d3	ds	IE	Codice	Non rivestita Prezzo €	Rivestita X-TOP Codice	Prezzo €
6	1.00	65	14.9	36	4.90	8	5.00	6.3	17.65	TTDTH06100032	222,00	TTDTH06100035	240,00
8	1.25	80	19.9	40	6.50	10	6.75	8.3	23.40	TTDTH08125032	275,00	TTDTH08125035	286,00
10	1.5	85	23.9	45	8.20	12	8.50	10.3	28.10	TTDTH10150032	344,00	TTDTH10150035	368,00
12	1.75	95	29.6	45	9.90	14	10.25	12.3	34.60	TTDTH12175032	414,00	TTDTH12175035	430,00
14	2.00	110	35.85	48	11.6	16	12.00	14.3	41.55	TTDTH14200032	510,00	TTDTH14200035	540,00
16	2.00	110	39.85	48	13.6	18	14.00	16.3	45.95	TTDTH16200032	599,00	TTDTH16200035	634,00

Altri diametri e misure a richiesta • Other size are available on request

Frese foro, filetta, smussa in metallo duro integrale,
con fori di lubrificazione.
 Solid carbide thrillers, with coolant holes.



MF 1.5 x Ø

M	P	I1	I2	I3	d1	d2	d3	ds	IE	Codice	Non rivestita Prezzo €	Rivestita X-TOP Codice	Prezzo €
6	0.75	62	8.95	36	5.05	8	5.25	6.3	11.30	TTDTH06075036	220,00	TTDTH06075038	238,00
8	1.00	74	11.9	40	6.75	10	7.00	8.3	15.05	TTDTH08100036	260,00	TTDTH08100038	282,00
10	1.00	79	15.1	45	8.70	12	9.00	10.3	18.47	TTDTH10100036	340,00	TTDTH10100038	364,00
10	1.25	79	15.1	45	8.40	12	8.75	10.3	18.90	TTDTH10125036	340,00	TTDTH10125038	364,00
12	1.00	89	17.9	45	10.65	14	11.00	12.3	21.08	TTDTH12100036	398,00	TTDTH12100038	430,00
12	1.25	89	19.9	45	10.40	14	10.75	12.3	23.00	TTDTH12125036	398,00	TTDTH12125038	430,00
12	1.50	89	18.1	45	10.15	14	10.50	12.3	22.50	TTDTH12150036	398,00	TTDTH12150038	430,00
14	1.50	102	21.12	48	12.10	16	12.50	14.3	25.90	TTDTH14150036	469,00	TTDTH14150038	499,00
16	1.50	102	24.15	48	14.10	18	14.50	16.3	29.30	TTDTH16150036	565,00	TTDTH16150038	565,00

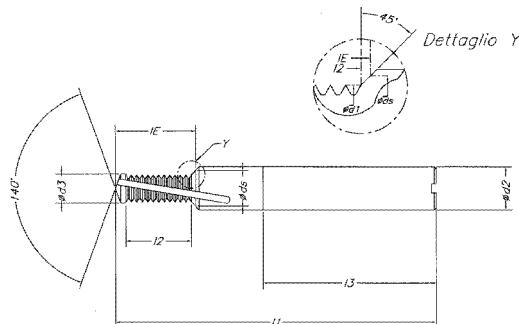
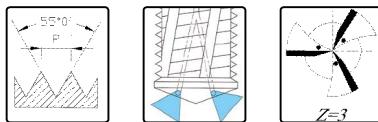
MF 2 x Ø

M	P	I1	I2	I3	d1	d2	d3	ds	IE	Codice	Non rivestita Prezzo €	Rivestita X-TOP Codice	Prezzo €
6	0.75	62	11.95	36	5.05	8	5.25	6.3	14.3	TTDTH06075037	229,00	TTDTH06075039	246,00
8	1.00	74	15.9	40	6.75	10	7.00	8.3	19.10	TTDTH08100037	270,00	TTDTH08100039	289,00
10	1.00	79	20.1	45	8.70	12	9.00	10.3	23.47	TTDTH10100037	352,00	TTDTH10100039	380,00
10	1.25	79	20.1	45	8.40	12	8.75	10.3	23.90	TTDTH10125037	352,00	TTDTH10125039	380,00
12	1.00	89	23.9	45	10.65	14	11.00	12.3	27.80	TTDTH12100037	408,00	TTDTH12100039	440,00
12	1.25	89	23.9	45	10.40	14	10.75	12.3	28.00	TTDTH12125037	408,00	TTDTH12125039	440,00
12	1.50	89	24.1	45	10.15	14	10.50	12.3	28.50	TTDTH12150037	408,00	TTDTH12150039	440,00
14	1.50	102	27.12	48	12.10	16	12.50	14.3	31.90	TTDTH14150037	499,00	TTDTH14150039	485,00
16	1.50	102	31.65	48	14.10	18	14.50	16.3	36.80	TTDTH16150037	599,00	TTDTH16150039	646,00

Altri diametri e misure a richiesta • Other size are available on request



- Frese foro, filetta, smussa in metallo duro integrale,
con fori di lubrificazione.
Solid carbide thrills, with coolant holes.



GAS 1.5 x Ø

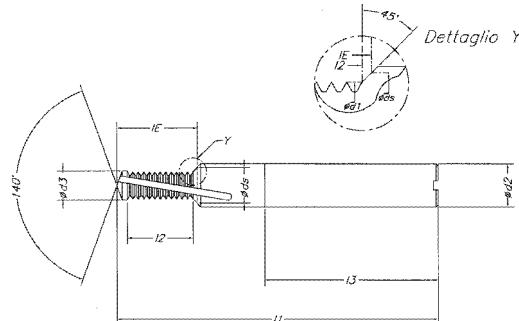
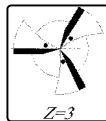
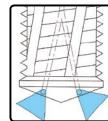
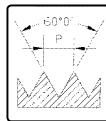
ØDmin filx1"	I1	I2	I3	d1	d2	d3	ds	IE	Non rivestita	Prezzo	Rivestita X-TOP	Prezzo
									Codice	€	Codice	€
1/8	28	79	14.44	45	8.5	12	8.8	10	TTDTH1/8GAS40	318,00	TTDTH1/8GAS42	338,00
1/4	19	102	18.61	48	11.40	16	11.80	13.5	TTDTH1/4GAS40	456,00	TTDTH1/4GAS42	486,00
3/8	19	102	30.75	48	14.85	18	15.25	17	TTDTH3/8GAS40	548,00	TTDTH3/8GAS42	586,00

GAS 2 x Ø

ØDmin filx1"	I1	I2	I3	d1	d2	d3	ds	IE	Non rivestita	Prezzo	Rivestita X-TOP	Prezzo
									Codice	€	Codice	€
1/8	28	79	18.98	45	8.5	12	8.8	10	TTDTH1/8GAS41	329,00	TTDTH1/8GAS43	349,00
1/4	19	102	25.3	48	11.40	16	11.80	13.5	TTDTH1/4GAS41	480,00	TTDTH1/4GAS43	508,00
3/8	19	102	37.4	48	14.85	18	15.25	17	TTDTH3/8GAS41	570,00	TTDTH3/8GAS43	614,00

Altri diametri e misure a richiesta • Other size are available on request

Frese foro, filetta, smussa in metallo duro integrale,
con fori di lubrificazione.
 Solid carbide thrillers, with coolant holes.



UNC 1.5 x Ø

ØDmin filx1"	I1	I2	I3	d1	d2	d3	ds	IE	Non rivestita	Prezzo	Rivestita X-TOP	Prezzo
									Codice	€	Codice	€
1/4 20	62	8.95	36	4.85	8	5.20	6.65	12.00	TTDTH1/4UNC44	210,00	TTDTH1/4UNC47	228,00
5/16 18	74	11.35	40	6.25	10	6.60	8.25	14.98	TTDTH516UNC44	246,00	TTDTH516UNC47	264,00
3/8 16	80	14.35	45	7.65	12	8.00	9.83	18.45	TTDTH3/8UNC44	322,00	TTDTH3/8UNC47	346,00
7/16 14	80	16.4	45	9.0	12	9.40	11.43	21.05	TTDTH716UNC44	322,00	TTDTH716UNC47	346,00
1/2 13	89	17.7	45	10.35	14	10.75	13	22.85	TTDTH1/2UNC44	388,00	TTDTH1/2UNC47	418,00
9/16 12	102	21.3	48	11.8	16	12.25	14.61	26.95	TTDTH916UNC44	464,00	TTDTH916UNC47	499,00
5/8 11	102	23.2	48	13.10	18	13.50	16.18	29.40	TTDTH5/8UNC44	550,00	TTDTH5/8UNC47	592,00
3/4 10	115	28.05	50	16.00	20	16.50	19.35	35.20	TTDTH3/4UNC44	698,00	TTDTH3/4UNC47	752,00

UNC 2 x Ø

ØDmin filx1"	I1	I2	I3	d1	d2	d3	ds	IE	Non rivestita	Prezzo	Rivestita X-TOP	Prezzo
									Codice	€	Codice	€
1/4 20	62	12.75	36	4.85	8	5.20	6.65	15.8	TTDTH1/4UNC45	220,00	TTDTH1/4UNC48	234,00
5/16 18	74	15.6	40	6.25	10	6.60	8.25	19.10	TTDTH516UNC45	268,00	TTDTH516UNC48	286,00
3/8 16	80	19.15	45	7.65	12	8.00	9.83	23.20	TTDTH3/8UNC45	328,00	TTDTH3/8UNC48	352,00
7/16 14	80	21.85	45	9.0	12	9.40	11.43	26.50	TTDTH716UNC45	328,00	TTDTH716UNC48	352,00
1/2 13	89	25.5	45	10.35	14	10.75	13	30.65	TTDTH1/2UNC45	396,00	TTDTH1/2UNC48	424,00
9/16 12	102	27.65	48	11.8	16	12.25	14.61	33.30	TTDTH916UNC45	484,00	TTDTH916UNC48	520,00
5/8 11	102	30.15	48	13.10	18	13.50	16.18	36.35	TTDTH5/8UNC45	570,00	TTDTH5/8UNC48	610,00
3/4 10	115	38.25	50	16.00	20	16.50	19.35	45.35	TTDTH3/4UNC45	780,00	TTDTH3/4UNC48	809,00

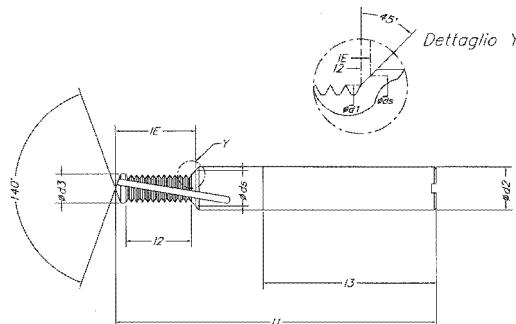
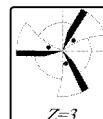
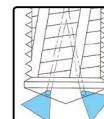
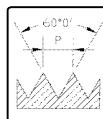
UNC 2.5 x Ø

filx1" filx1"	I1	I2	I3	d1	d2	d3	ds	IE	Non rivestita	Prezzo	Rivestita X-TOP	Prezzo
									Codice	€	Codice	€
3/8 16	85	23.9	45	7.65	12	8.00	9.83	27.95	TTDTH3/8UNC46	344,00	TTDTH3/8UNC49	368,00
7/16 14	85	27.3	45	9.0	12	9.40	11.43	31.95	TTDTH716UNC46	344,00	TTDTH716UNC49	368,00
1/2 13	95	31.35	45	10.35	14	10.75	13	36.50	TTDTH1/2UNC46	416,00	TTDTH1/2UNC49	446,00
9/16 12	110	34	48	11.8	16	12.25	14.61	39.65	TTDTH916UNC46	510,00	TTDTH916UNC49	548,00
5/8 11	110	39.35	48	13.10	18	13.50	16.18	45.60	TTDTH5/8UNC46	598,00	TTDTH5/8UNC49	642,00
3/4 10	125	45.85	50	16.00	20	16.50	19.35	53.00	TTDTH3/4UNC46	799,00	TTDTH3/4UNC49	858,00

Altri diametri e misure a richiesta • Other size are available on request



- Frese foro, filetta, smussa in metallo duro integrale,
con fori di lubrificazione.
 Solid carbide thrillers, with coolant holes.



UNF 1.5 x Ø

ØDmin filx1"	I1	I2	I3	d1	d2	d3	ds	IE	Non rivestita	Prezzo	Rivestita X-TOP	Prezzo	
									Codice	€	Codice	€	
1/4	28	62	9.15	36	5.26	8	5.50	6.65	11.70	TTDTH1/4UNF50	210,00	TTDTH1/4UNF52	228,00
5/16	24	74	11.75	40	6.60	10	6.90	8.25	14.80	TTDTH516UNF50	246,00	TTDTH516UNF52	264,00
3/8	24	80	13.85	45	8.20	12	8.50	9.85	17.20	TTDTH3/8UNF50	322,00	TTDTH3/8UNF52	346,00
7/16	20	80	17.9	45	9.55	12	9.90	11.4	21.85	TTDTH716UNF50	322,00	TTDTH716UNF52	346,00
1/2	20	89	19.2	45	11.10	14	11.50	13	23.45	TTDTH1/2UNF50	388,00	TTDTH1/2UNF52	418,00
9/16	18	102	21.3	48	12.50	16	12.90	14.6	26.05	TTDTH916UNF50	464,00	TTDTH916UNF52	499,00
5/8	18	102	22.75	48	14.10	18	14.50	16.2	27.75	TTDTH5/8UNF50	550,00	TTDTH5/8UNF52	592,00
3/4	16	115	28.75	50	16.95	20	17.50	19.4	234.65	TTDTH3/4UNF50	698,00	TTDTH3/4UNF52	752,00

UNF 2 x Ø

ØDmin filx1"	I1	I2	I3	d1	d2	d3	ds	IE	Non rivestita	Prezzo	Rivestita X-TOP	Prezzo	
									Codice	€	Codice	€	
1/4	28	62	12.75	36	5.26	8	5.50	6.65	15.35	TTDTH1/4UNF51	220,00	TTDTH1/4UNF53	234,00
5/16	24	74	15.95	40	6.60	10	6.90	8.25	19.00	TTDTH516UNF51	268,00	TTDTH516UNF53	286,00
3/8	24	80	19.15	45	8.20	12	8.50	9.85	22.50	TTDTH3/8UNF51	328,00	TTDTH3/8UNF53	352,00
7/16	20	80	21.7	45	9.55	12	9.90	11.4	25.65	TTDTH716UNF51	328,00	TTDTH716UNF53	352,00
1/2	20	89	25.55	45	11.10	14	11.50	13	29.80	TTDTH1/2UNF51	396,00	TTDTH1/2UNF53	424,00
9/16	18	102	28.35	48	12.50	16	12.90	14.6	33.10	TTDTH916UNF51	484,00	TTDTH916UNF53	520,00
5/8	18	102	31.2	48	14.10	18	14.50	16.2	36.25	TTDTH5/8UNF51	570,00	TTDTH5/8UNF53	610,00
3/4	16	115	38.3	50	16.95	20	17.50	19.4	44.15	TTDTH3/4UNF51	780,00	TTDTH3/4UNF53	809,00

Altri diametri e misure a richiesta • Other size are available on request