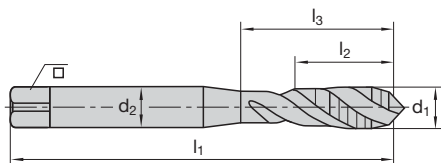




DIN 371

DIN 376



| Katalog-Nr. Cat.-No.                                          |                                                                                 |                |                |                |                |                              |   |                                                                                     | 6511C                               |                              |           | 6512C                               |                              |  |
|---------------------------------------------------------------|---------------------------------------------------------------------------------|----------------|----------------|----------------|----------------|------------------------------|---|-------------------------------------------------------------------------------------|-------------------------------------|------------------------------|-----------|-------------------------------------|------------------------------|--|
| P1                                                            | Stahl Steel < 500 N/mm²                                                         |                |                |                |                |                              |   |                                                                                     | <input type="checkbox"/>            | v <sub>c</sub> = 15–20 m/min |           | <input type="checkbox"/>            | v <sub>c</sub> = 15–20 m/min |  |
| P2                                                            | Stahl Steel 500–1000 N/mm²                                                      |                |                |                |                |                              |   |                                                                                     | <input checked="" type="checkbox"/> | v <sub>c</sub> = 15–20 m/min |           | <input checked="" type="checkbox"/> | v <sub>c</sub> = 15–20 m/min |  |
| P3                                                            | Stahl Steel > 1000 N/mm²                                                        |                |                |                |                |                              |   |                                                                                     | <input type="checkbox"/>            | v <sub>c</sub> = 10–15 m/min |           | <input type="checkbox"/>            | v <sub>c</sub> = 10–15 m/min |  |
| M1                                                            | Rostfreie austenitische Stähle Stainless steel austenitic                       |                |                |                |                |                              |   |                                                                                     | <input type="checkbox"/>            | v <sub>c</sub> = 5–10 m/min  |           | <input type="checkbox"/>            | v <sub>c</sub> = 5–10 m/min  |  |
| M2                                                            | Rostfreie martensitische Stähle Stainless steel martensitic                     |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| K1                                                            | Grauguss Grey cast iron                                                         |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| K2                                                            | Sphäroguss Nodular cast iron                                                    |                |                |                |                |                              |   |                                                                                     | <input type="checkbox"/>            | v <sub>c</sub> = 15–20 m/min |           | <input type="checkbox"/>            | v <sub>c</sub> = 15–20 m/min |  |
| N1                                                            | Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si   |                |                |                |                |                              |   |                                                                                     | <input type="checkbox"/>            | v <sub>c</sub> = 20–25 m/min |           | <input type="checkbox"/>            | v <sub>c</sub> = 20–25 m/min |  |
| N2                                                            | Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si  |                |                |                |                |                              |   |                                                                                     | <input checked="" type="checkbox"/> | v <sub>c</sub> = 15–20 m/min |           | <input checked="" type="checkbox"/> | v <sub>c</sub> = 15–20 m/min |  |
| N3                                                            | Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si |                |                |                |                |                              |   |                                                                                     | <input checked="" type="checkbox"/> | v <sub>c</sub> = 15–20 m/min |           | <input type="checkbox"/>            | v <sub>c</sub> = 15–20 m/min |  |
| N4                                                            | Graphit Graphite                                                                |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| S1                                                            | Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm²         |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| S2                                                            | Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm²            |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| H1                                                            | Hartguss und Harte Stähle Chilled steel and Hardened steel 45–55 HRC            |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| d <sub>1</sub>                                                | P                                                                               | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | d <sub>2</sub> | <input type="checkbox"/> h12 | z |  | Ident No.                           | LMT-Code                     | Ident No. | LMT-Code                            |                              |  |
| mit verstärktem Zylinderschaft with reinforced straight shank |                                                                                 |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| M 3                                                           | 0,5                                                                             | 56             | 5              | 18             | 3,5            | 2,7                          | 3 | 2,5                                                                                 | 1400408                             | TC-CM 03x0.50-6H-V40-1       | –         | –                                   |                              |  |
| M 3,5                                                         | 0,6                                                                             | 56             | 6              | 20             | 4              | 3                            | 3 | 2,9                                                                                 | 1400409                             | TC-CM 3.5x0.60-6H-V40-1      | –         | –                                   |                              |  |
| M 4                                                           | 0,7                                                                             | 63             | 7              | 21             | 4,5            | 3,4                          | 3 | 3,3                                                                                 | 1400417                             | TC-CM 04x0.70-6H-V40-1       | –         | –                                   |                              |  |
| M 5                                                           | 0,8                                                                             | 70             | 8              | 25             | 6              | 4,9                          | 3 | 4,2                                                                                 | 1400426                             | TC-CM 05x0.80-6H-V40-1       | –         | –                                   |                              |  |
| M 6                                                           | 1                                                                               | 80             | 10             | 30             | 6              | 4,9                          | 3 | 5                                                                                   | 1400435                             | TC-CM 06x1.00-6H-V40-1       | –         | –                                   |                              |  |
| M 7                                                           | 1                                                                               | 80             | 10             | 30             | 7              | 5,5                          | 3 | 6                                                                                   | 1400436                             | TC-CM 07x1.00-6H-V40-1       | –         | –                                   |                              |  |
| M 8                                                           | 1,25                                                                            | 90             | 10             | 35             | 8              | 6,2                          | 3 | 6,8                                                                                 | 1400444                             | TC-CM 08x1.25-6H-V40-1       | –         | –                                   |                              |  |
| M 10                                                          | 1,5                                                                             | 100            | 12             | 39             | 10             | 8                            | 3 | 8,5                                                                                 | 1400453                             | TC-CM 10x1.50-6H-V40-1       | –         | –                                   |                              |  |
| mit Überlaufschaft with standard straight shank               |                                                                                 |                |                |                |                |                              |   |                                                                                     |                                     |                              |           |                                     |                              |  |
| M 3                                                           | 0,5                                                                             | 56             | 4              | –              | 2,2            | 1,2                          | 3 | 2,5                                                                                 | –                                   | –                            | 1400251   | TC-CM 03x0.50-6H-V40-1              |                              |  |
| M 4                                                           | 0,7                                                                             | 63             | 5              | –              | 2,8            | 2,1                          | 3 | 3,3                                                                                 | –                                   | –                            | 1400252   | TC-CM 04x0.70-6H-V40-1              |                              |  |
| M 5                                                           | 0,8                                                                             | 70             | 7              | –              | 3,5            | 2,7                          | 3 | 4,2                                                                                 | –                                   | –                            | 1400253   | TC-CM 05x0.80-6H-V40-1              |                              |  |
| M 6                                                           | 1                                                                               | 80             | 8              | –              | 4,5            | 3,4                          | 3 | 5                                                                                   | –                                   | –                            | 1400254   | TC-CM 06x1.00-6H-V40-1              |                              |  |
| M 8                                                           | 1,25                                                                            | 90             | 10             | –              | 6              | 4,9                          | 3 | 6,8                                                                                 | –                                   | –                            | 1400255   | TC-CM 08x1.25-6H-V40-1              |                              |  |
| M 10                                                          | 1,5                                                                             | 100            | 12             | –              | 7              | 5,5                          | 3 | 8,5                                                                                 | –                                   | –                            | 1400256   | TC-CM 10x1.50-6H-V40-1              |                              |  |
| M 12                                                          | 1,75                                                                            | 110            | 14             | –              | 9              | 7                            | 3 | 10,2                                                                                | –                                   | –                            | 1400462   | TC-CM 12x1.75-6H-V40-1              |                              |  |
| M 14                                                          | 2                                                                               | 110            | 16             | –              | 11             | 9                            | 3 | 12                                                                                  | –                                   | –                            | 1400464   | TC-CM 14x2.00-6H-V40-1              |                              |  |
| M 16                                                          | 2                                                                               | 110            | 18             | –              | 12             | 9                            | 3 | 14                                                                                  | –                                   | –                            | 1400471   | TC-CM 16x2.00-6H-V40-1              |                              |  |
| M 18                                                          | 2,5                                                                             | 125            | 20             | –              | 14             | 11                           | 4 | 15,5                                                                                | –                                   | –                            | 1400473   | TC-CM 18x2.50-6H-V40-1              |                              |  |
| M 20                                                          | 2,5                                                                             | 140            | 25             | –              | 16             | 12                           | 4 | 17,5                                                                                | –                                   | –                            | 1400480   | TC-CM 20x2.50-6H-V40-1              |                              |  |
| M 22                                                          | 2,5                                                                             | 140            | 25             | –              | 18             | 14,5                         | 4 | 19,5                                                                                | –                                   | –                            | 1400482   | TC-CM 22x2.50-6H-V40-1              |                              |  |
| M 24                                                          | 3                                                                               | 160            | 25             | –              | 18             | 14,5                         | 4 | 21                                                                                  | –                                   | –                            | 1400329   | TC-CM 24x3.00-6H-V40-1              |                              |  |
| M 27                                                          | 3                                                                               | 160            | 30             | –              | 20             | 16                           | 4 | 24                                                                                  | –                                   | –                            | 1384615   | TC-CM 27x3.00-6H-V40-1              |                              |  |

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■ = Hauptanwendung First choice  
□ = Nebenanwendung Second choice



|   |   |    |       |     |   |           |          |           |         |         |
|---|---|----|-------|-----|---|-----------|----------|-----------|---------|---------|
| M | V | h9 | 2,5xD | 40° | C | ISO2 (6H) | HSS E-PM | TiCN Plus | DIN 371 | DIN 376 |
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| Katalog-Nr. Cat.-No. |                                                                                 | 6511C                                                            | 6512C                                                            |
|----------------------|---------------------------------------------------------------------------------|------------------------------------------------------------------|------------------------------------------------------------------|
| P1                   | Stahl Steel < 500 N/mm²                                                         | <input type="checkbox"/> v <sub>c</sub> = 15–20 m/min            | <input type="checkbox"/> v <sub>c</sub> = 15–20 m/min            |
| P2                   | Stahl Steel 500–1000 N/mm²                                                      | <input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min | <input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min |
| P3                   | Stahl Steel > 1000 N/mm²                                                        | <input type="checkbox"/> v <sub>c</sub> = 10–15 m/min            | <input type="checkbox"/> v <sub>c</sub> = 10–15 m/min            |
| M1                   | Rostfreie austenitische Stähle Stainless steel austenitic                       | <input type="checkbox"/> v <sub>c</sub> = 5–10 m/min             | <input type="checkbox"/> v <sub>c</sub> = 5–10 m/min             |
| M2                   | Rostfreie martensitische Stähle Stainless steel martensitic                     |                                                                  |                                                                  |
| K1                   | Grauguss Grey cast iron                                                         |                                                                  |                                                                  |
| K2                   | Sphäroguss Nodular cast iron                                                    | <input type="checkbox"/> v <sub>c</sub> = 15–20 m/min            | <input type="checkbox"/> v <sub>c</sub> = 15–20 m/min            |
| N1                   | Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping < 5 % Si   | <input type="checkbox"/> v <sub>c</sub> = 20–25 m/min            | <input type="checkbox"/> v <sub>c</sub> = 20–25 m/min            |
| N2                   | Alu- & Cu-Legierungen langspanend Alu- & Copper alloys long chipping 5–10 % Si  | <input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min | <input checked="" type="checkbox"/> v <sub>c</sub> = 15–20 m/min |
| N3                   | Alu- & Cu-Legierungen kurzspanend Alu- & Copper alloys short chipping > 10 % Si | <input type="checkbox"/> v <sub>c</sub> = 15–20 m/min            | <input type="checkbox"/> v <sub>c</sub> = 15–20 m/min            |
| N4                   | Graphit Graphite                                                                |                                                                  |                                                                  |
| S1                   | Titanlegierungen mittelfest Titanium alloys medium strength < 900 N/mm²         |                                                                  |                                                                  |
| S2                   | Titanlegierungen hochfest Titanium alloys high strength < 1300 N/mm²            |                                                                  |                                                                  |
| H1                   | Hartguss und Harte Stähle Chilled steel and Hardened steel 45–55 HRC            |                                                                  |                                                                  |

| d <sub>1</sub>                                  | P   | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | d <sub>2</sub> | <input type="checkbox"/> h12 | z |      | Ident No. | LMT-Code | Ident No. | LMT-Code               |
|-------------------------------------------------|-----|----------------|----------------|----------------|----------------|------------------------------|---|------|-----------|----------|-----------|------------------------|
| mit Überlaufschaft with standard straight shank |     |                |                |                |                |                              |   |      |           |          |           |                        |
| M 30                                            | 3,5 | 180            | 35             | –              | 22             | 18                           | 4 | 26,5 | –         | –        | 1384617   | TC-CM 30x3.50-6H-V40-1 |
| M 36                                            | 4   | 200            | 40             | –              | 28             | 22                           | 4 | 32   | –         | –        | 1384619   | TC-CM 36x4.00-6H-V40-1 |
| M 42                                            | 4,5 | 200            | 45             | –              | 32             | 24                           | 4 | 37,5 | –         | –        | 1384620   | TC-CM 42x4.50-6H-V40-1 |
| M 45                                            | 4,5 | 220            | 45             | –              | 36             | 29                           | 4 | 40,5 | –         | –        | 9127742   | TC-CM 45x4.50-6H-V40-1 |
| M 48                                            | 5   | 250            | 50             | –              | 36             | 29                           | 4 | 43   | –         | –        | 9127745   | TC-CM 48x5.00-6H-V40-1 |
| M 52                                            | 5   | 250            | 50             | –              | 40             | 32                           | 4 | 47   | –         | –        | 9127747   | TC-CM 52x5.00-6H-V40-1 |
|                                                 |     |                |                |                |                |                              |   |      |           |          |           |                        |
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 ■ = Hauptanwendung First choice  
 □ = Nebenanwendung Second choice