

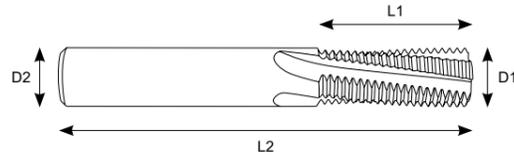
**BUY 3 GET 1 FREE ON VARDEX THREAD MILLS**

**NPT NATIONAL PIPE TAPER B2.1:1965 - HELICAL FLUTES**

Thread Milling of Steel, Stainless Steel, HRSA's, Aluminium & Cast Iron up to HRC45

- TiAlN coated carbide thread mills
- Helical flute for tapered threads

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**VARDEX**

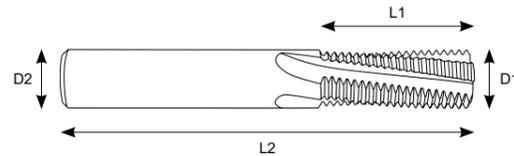
Thread Size	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
<b>Internal / External 2xD Max Depth (Solid)</b>								
1/16"	27	5.3	6	9.4	57	3	101-00075	£137.68
1/8"	27	7.5	8	9.4	63	4	101-00076	£160.39
1/4"	18	9.4	10	14.1	73	4	101-00077	£168.50
3/8"	18	11.9	12	14.1	83	4	101-00078	£229.19
1/2"	14	15.5	16	25.4	92	5	101-00079	£318.47
1"	11.5	19.9	20	33.1	104	5	101-00080	£347.62
2 1/2"	8	19.9	20	38.1	104	4	101-00081	£347.62

**NPTF NATIONAL PIPE TAPER FUEL ANSI 1.20.3-1 - HELICAL FLUTES**

Thread Milling of Steel, Stainless Steel, HRSA's, Aluminium & Cast Iron up to HRC45

- TiAlN coated carbide thread mills
- Helical flute for tapered threads

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**VARDEX**

Thread Size	TPI	D1	D2	L1	L2	No. of Flutes	Order Code	Price
<b>Internal / External 2xD Max Depth (Solid)</b>								
1/16"	27	5.3	6	9.4	57	3	101-00082	£137.68
1/8"	27	7.5	8	9.4	63	4	101-00083	£160.39
1/4"	18	9.4	10	14.1	73	4	101-00084	£168.50
3/8"	18	11.9	12	14.1	83	4	101-00085	£229.19
1/2"	14	15.5	16	25.4	92	5	101-00086	£318.47
1"	11.5	19.9	20	33.1	104	5	101-00087	£347.62
2 1/2"	8	19.9	20	38.1	104	4	101-00088	£347.62



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**BUY 3 GET 1 FREE ON VARDEX THREAD MILLS**

Material	Group	Detail	Hardness Brinell HB	Vc [m/min]		Feed fz [mm/tooth]		
				Helical Flute Deep Threading	Miniature	Helical	Deep Threading	Miniature
P Steel	Unalloyed Steel	Low Carbon (C=0.1-0.25%)	125	80-250	60-120	0.03-0.15	0.03-0.23	0.03-0.12
		Medium Carbon (C=0.25-0.55%)	150	80-230	60-120	0.03-0.1	0.03-0.15	0.03-0.12
		High Carbon (C=0.55-0.85%)	170	80-200	60-90	0.03-0.08	0.03-0.12	0.03-0.12
	Low Alloy Steel (Alloying Elements <5%)	Non Hardened	180	60-180	60-90	0.03-0.1	0.03-0.15	0.03-0.1
		Hardened	275	60-170	50-80	0.03-0.07	0.03-0.11	0.03-0.07
		Hardened	350	60-160	50-80	0.01-0.03	0.01-0.05	0.03
	High Alloy Steel (Alloying Elements >5%)	Annealed	200	40-100	50-80	0.03-0.05	0.03-0.08	0.03-0.05
		Hardened	325	30-80	50-80	0.01-0.03	0.01-0.05	0.03
	Cast Steel	Low Alloy (Alloying Elements <5%)	200	80-250	70-90	0.03-0.1	0.03-0.15	0.03-0.1
		High Alloy (Alloying Elements >5%)	225	60-170	60-80	0.01-0.03	0.01-0.05	0.03
M Stainless Steel	Stainless Steel Ferritic	Non Hardened	200	60-150	60-90	0.04-0.1	0.04-0.15	0.03-0.1
		Hardened	330	60-120	50-80	0.01-0.05	0.01-0.08	0.03
	Stainless Steel Austenitic	Austenitic	180	60-140	60-90	0.04-0.1	0.04-0.15	0.03-0.1
		Super Austenitic	200	60-130	50-80	0.04-0.1	0.04-0.15	0.03-0.1
	Stainless Steel Cast Ferritic	Non Hardened	200	60-160	60-90	0.04-0.1	0.04-0.15	0.03-0.1
		Hardened	330	60-110	50-80	0.03-0.05	0.03-0.08	0.03
Stainless Steel Cast Austenitic	Austenitic	200	60-150	60-90	0.04-0.1	0.04-0.15	0.03-0.1	
	Hardened	330	60-100	50-80	0.03-0.05	0.03-0.08	0.03	
K Cast Iron	Malleable	Ferritic (Short Chips)	130	60-70	50-80	0.01-0.03	0.01-0.05	0.03
	Cast Iron	Pearlitic (Long Chips)	230	60-150	60-90	0.03-0.05	0.03-0.08	0.05
		Low Tensile Strength	180	70-160	70-100	0.025-0.1	0.05-0.15	0.04-0.1
	Grey Cast Iron	High Tensile Strength	260	40-120	60-90	0.03-0.05	0.03-0.08	0.05
Nodular Sg Iron		Ferritic	160	40-110	70-100	0.05-0.1	0.05-0.15	0.04-0.1
	Pearlitic	260	40-100	60-90	0.03-0.05	0.03-0.08	0.05	
N Non-Ferrous Metals	Aluminium Alloys Wrought	Non Aging	60	200-300	60-250	0.1-0.25	0.10-0.38	0.05-0.15
		Aged	100	150-250	60-150	0.1-0.2	0.10-0.30	0.04-0.12
	Aluminium Alloys	Cast	75	100-200	60-250	0.1-0.2	0.10-0.30	0.04-0.12
		Cast & Aged	90	120-220	60-150	0.1-0.15	0.10-0.23	0.03-0.1
	Aluminium Alloys	Cast Si 13-22%	130	200-300	250	0.1-0.2	0.10-0.30	0.05-0.1
		Copper & Copper Alloys	Brass	90	200-300	60-250	0.1-0.25	0.10-0.38
Bronze & Non Leaded Copper	100		150-250	60-150	0.1-0.2	0.10-0.30	0.05-0.1	
S Heat Resistant Material	High Temperature Alloys	Annealed (Iron Based)	200	30-60	60	0.04-0.1	0.04-0.15	0.03-0.1
		Aged (Iron Based)	280	20-50	50	0.01-0.03	0.01-0.05	0.03
		Annealed (Nickel or Cobalt Based)	250	15-35	20-40	0.01-0.03	0.01-0.05	0.03
	Aged (Nickel or Cobalt Based)	350	15-30	15-30	0.01-0.03	0.01-0.05	0.03	
Titanium Alloys	Pure 99.5 Ti	400Rm	40-80	30-50	0.03-0.05	0.03-0.08	0.03-0.06	
	A+B Alloys	1050Rm	20-50	25-35	0.03-0.05	0.03-0.08	0.03-0.07	
H Hardened Steel	Extra Hard Steel	Hardened & Tempered	45-50HRC	15-45	30-45	0.005-0.01	0.005-0.02	0.01
		Hardened & Tempered	51-55HRC	15-40	15-30	0.005-0.01	0.005-0.02	0.01
		Hardened & Tempered	55-60HRC	40-60	-	0.005-0.025	-	-
		Hardened & Tempered	60-63HRC	30-40	-	0.005-0.015	-	-
		Hardened & Tempered	63-66HRC	30-40	-	0.005-0.015	-	-