



Solid Carbide Thread Milling

2 in 1 HeliCool-C

Thread Mill & Chamfering Tool

- Lets you thread mill and chamfer with 1 tool!
- Reduces tool changeovers and saves machining time.
- Saves space in tool magazine.

NEW!



HeliCool-R

Thread Mill with Radial Cooling

- Flushes chips out of through holes effectively.
- Radial exit holes for delivering coolant directly to the cutting edge.
- Great solution when external cooling is not available!

NEW!



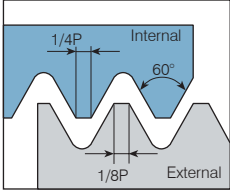
Metric

HeliCool-C

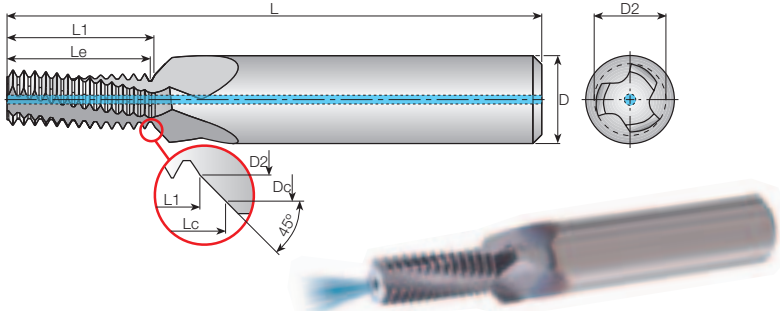
Helical Fluted Thread Mill +Chamfer with Thru-Hole Cooling

ISO Metric

Internal



Defined by: R262 (DIN 13)
Tolerance class: 6g/6H



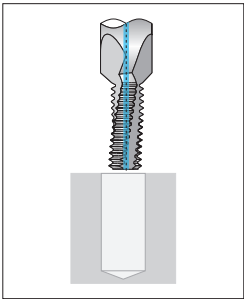
Dc = Minimum recommended chamfer diameter

2 x Do (L1 ≤ 2 x Thread Diameter)

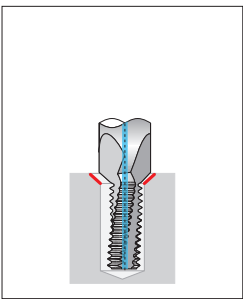
Thread		Pitch	Ordering Code	Dimensions [mm]							No. of Flutes	Teeth	Recommended *Drill Size +0.05
M Coarse	M Fine	mm	Internal	D	D2	Dc	L	Le	L1	Lc	Z	Zt	mm
M6x1.0	M8-M40x1.0	1.0	HCC08048L12-I1.00ISO TM...	8	4.8	6.3	61	12.0	12.5	13.3	3	12	5
	M10x1.0	1.0	HCC12087L20-I1.00ISO TM...	12	8.7	10.3	73	20.0	20.5	21.3	3	20	9
	M12x1.0	1.0	HCC14107L24-I1.00ISO TM...	14	10.7	12.3	80	24.0	24.5	25.3	4	24	11
M8x1.25		1.25	HCC10065L16-I1.25ISO TM...	10	6.5	8.3	73	16.3	16.9	17.8	3	13	6.8
M10x1.5	M12-M48x1.5	1.5	HCC12082L20-I1.50ISO TM...	12	8.2	10.3	80	19.5	20.3	21.3	3	13	8.5
	M12x1.5	1.5	HCC14099L24-I1.50ISO TM...	14	9.9	12.3	80	24.0	24.8	26.0	4	16	10.5
	M14x1.5	1.5	HCC16119L29-I1.50ISO TM...	16	11.9	14.3	92	28.5	29.3	30.5	4	19	12.5
	M16x1.5	1.5	HCC18139L32-I1.50ISO TM...	18	13.9	16.3	92	31.5	32.3	33.5	4	21	14.5
M12x1.75		1.75	HCC14099L25-I1.75ISO TM...	14	9.9	12.3	80	24.5	25.4	26.6	4	14	10.3

*Drill size applies to smallest thread diameter

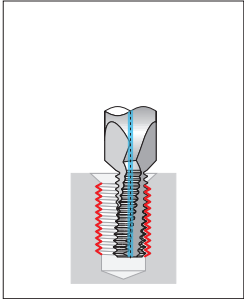
Maximum thread length = L1 – 1/4 Pitch



Positioning



Chamfering



Thread Milling



TM Gen Version 8.0.1

VARDEX TM Gen software – the fast and easy way to select the right tool and generate your CNC milling program

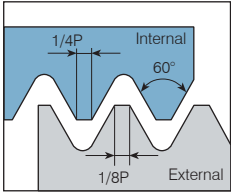


HeliCool-R

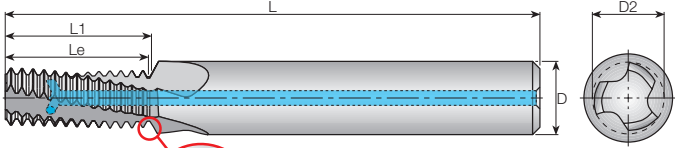
Helical Fluted Thread Mill with Radial Cooling

ISO Metric

Internal



Defined by: R262 (DIN 13)
Tolerance class: 6g/6H



2 x Do (L1 ≤ 2 x Thread Diameter)

Thread		Pitch	Ordering Code	Dimensions [mm]				No. of Flutes	Teeth	Recommended *Drill Size +0.05	
M Coarse	M Fine	mm	Internal	D	D2	L	Le	L1	Z	Zt	mm
M6x1.0	M8-M40x1.0	1.0	HCR06048L12-I1.00ISO TM...	6	4.8	57	12.0	12.5	3	12	5
	M10x1.0	1.0	HCR10087L20-I1.00ISO TM...	10	8.7	73	20.0	20.5	3	20	9
	M12x1.0	1.0	HCR12107L24-I1.00ISO TM...	12	10.7	73	24.0	24.5	4	24	11
M8x1.25		1.25	HCR08065L16-I1.25ISO TM...	8	6.5	64	16.3	16.9	3	13	6.8
M10x1.5	M12-M48x1.5	1.5	HCR10082L20-I1.50ISO TM...	10	8.2	73	19.5	20.3	3	13	8.5
	M12x1.5	1.5	HCR10099L24-I1.50ISO TM...	10	9.9	73	24.0	24.8	4	16	10.5
	M14x1.5	1.5	HCR12119L29-I1.50ISO TM...	12	11.9	84	28.5	29.3	4	19	12.5
	M16x1.5	1.5	HCR14139L32-I1.50ISO TM...	14	13.9	84	31.5	32.3	4	21	14.5
M12x1.75		1.75	HCR10099L25-I1.75ISO TM...	10	9.9	73	24.5	25.4	4	14	10.3

*Drill size applies to smallest thread diameter

Maximum thread length = L1 – 1/4 Pitch

HeliCool-C & HeliCool-R Technical Data

Recommended Cutting Speeds and Feed

Grade

Material			Hardness Brinell HB	VTH	
				Vc [m/min]	Feed f [mm/ tooth]
P	Unalloyed Steel	(C=0.25-0.55%)	150	80-230	0.021-0.82
	Low alloy steel	non hardened	180	60-180	0.018-0.069
M	Stainless Steel	austenitic	180	60-140	0.01-0.037
K	Alluminum alloys	non aging	60	200-300	0.035-0.114

Grade	Application
VTH	A general-purpose, heavy duty thread milling grade. TiCN coated for high resistance to wear.

* For the complete list of materials & cutting conditions, refer to VARDEX TM Gen software.

VARDEX Solid Carbide Thread Mills



HeliCool



HeliCool-C



HeliCool-R



MilliPro



TM Solid Straight Flutes



TM Solid Deep Thread

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