



**GW*i***  
SERIES 3000

**GW**  
SERIES 3000

EN-ID-1017

 SWISS MADE

 **DC**® **THREADING  
TECHNOLOGY**

# BEST SOLUTION IN STAINLESS STEELS AND SUPER ALLOYS

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**Chip evacuation**



**Double performance**



**Process security**



**No sticking**

**Ø 0.8 - 6.5 mm**

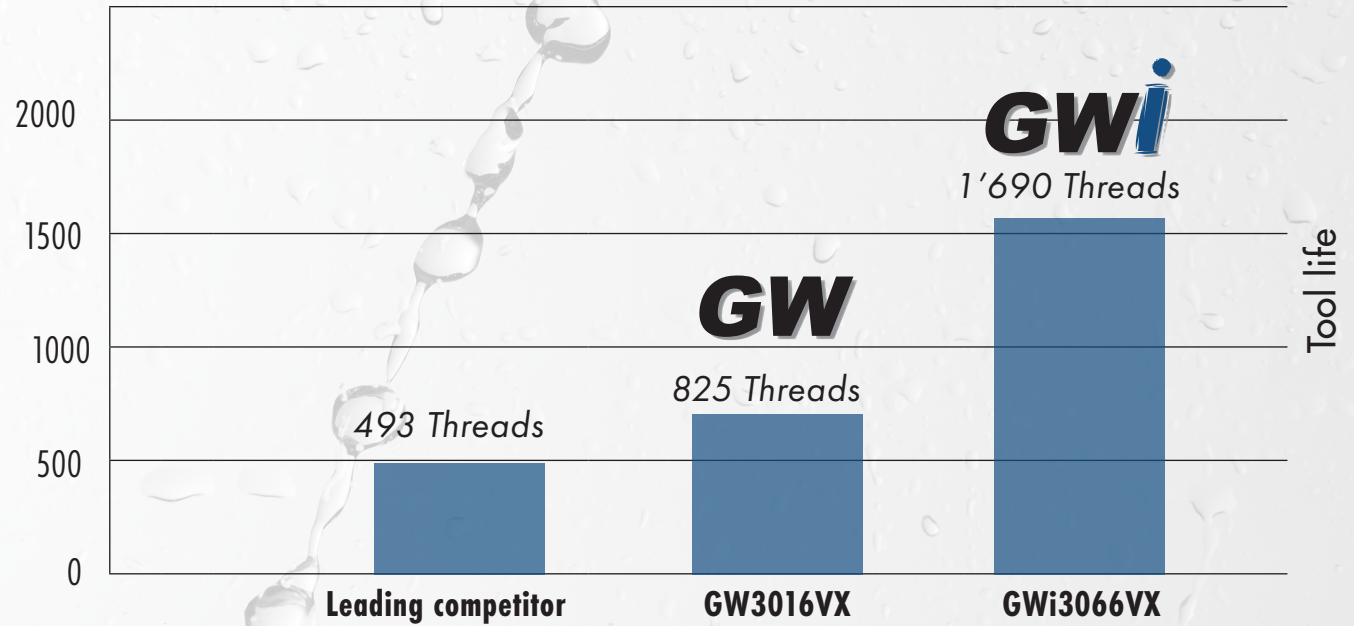
**GW*i***  
SERIES 3000



**Ø 6.5 - 20 mm**

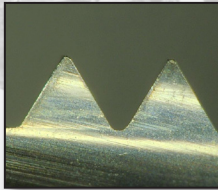
# PERFORMANCE

**Material:** Stainless steel, 1.4301  
**Machine:** DMC 650V  
**Kind of hole:** Blind hole  
**Thread size:** M3 6H  
**Thread length:** 2 x D<sub>1</sub>  
**Lubricant:** Emulsion 8%  
**Vc & Feed:** 50 m/min & 0.02 mm/tooth

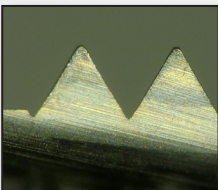


# WEAR OUT

**GWi VX**  
 1'690 Threads

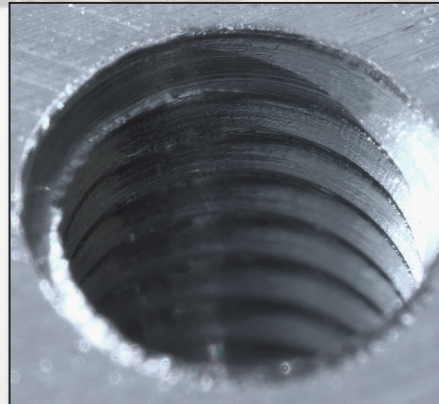


**GW VX**  
 825 Threads



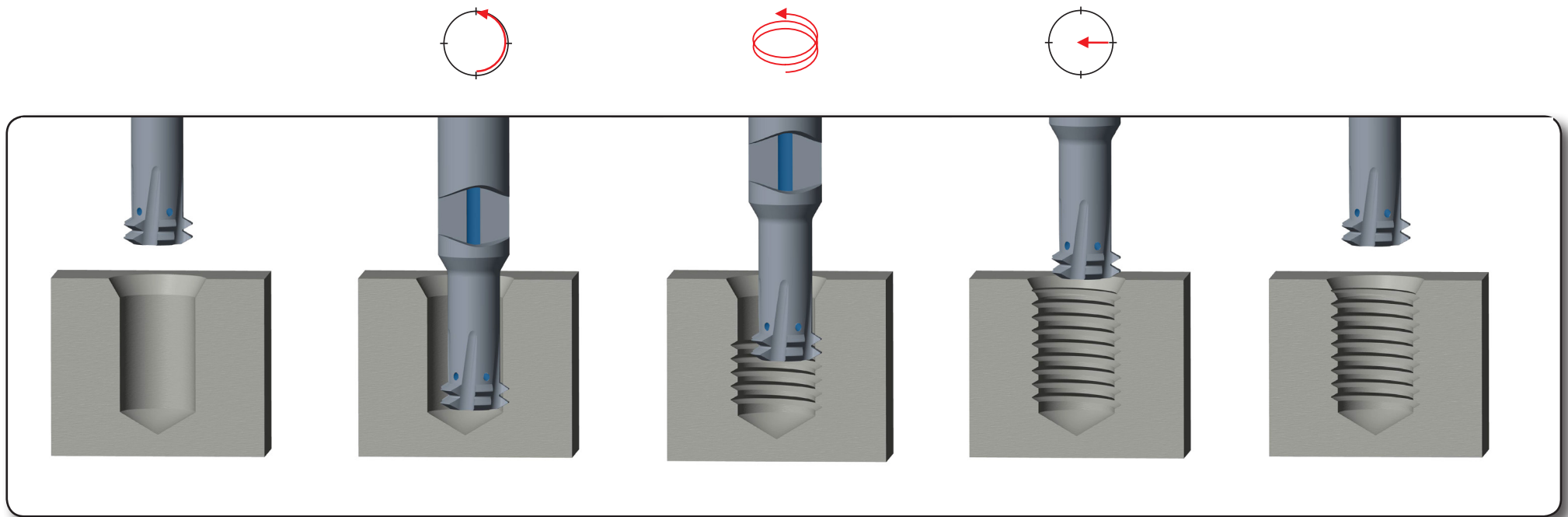
# SURFACE QUALITY

1'690 Threads



1'690 Threads in 1.4301  
**Numbers of NC-corrections: 2**  
 (Competitor 5)

# THREAD MILLING CYCLE



## PICTOGRAPHS



Thread length  $2.5 \times D_1$



Thread length  $3 \times D_1$



Thread length  $4 \times D_1$



Wear-protective coating



Wear-protective coating



Solid carbide



Internal thread



Tolerance class



High speed cutting



Internal coolant GWi



GW profil



In Stock



Delivery in 3 weeks

# APPLICATION




























## USE

 Optimal

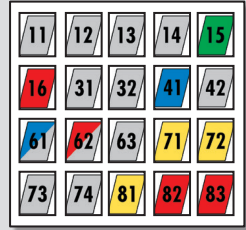
 Suitable

## MATERIAL CLASSIFICATION

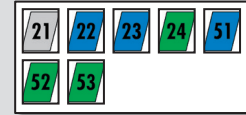
Material groups		Material designation	Hardness (HB)	Tensile strength Rm (N/mm <sup>2</sup> )	Elongation A (%)
Steels	11	Free-cutting steels	< 200	< 700	< 10
	12	Structural / cementation steels	< 200	< 700	< 30
	13	Carbon steels	< 300	< 1000	< 20
	14	Alloy steels <850 N/mm <sup>2</sup>	< 250	< 850	< 30
	15	Alloy steels hard. / temp. >850 - <1150 N/mm <sup>2</sup>	> 250	> 850	< 30
	16	High tensile alloy steels	> 250	> 850	< 12
Stainless Steels	21	Free machining stainless steels	< 250	< 850	< 25
	22	Austenitic stainless steels	< 250	< 850	> 20
	23	Ferritic and martensitic <850 N/mm <sup>2</sup>	< 250	< 850	> 20
	24	Ferritic and martens. >850 - <1150 N/mm <sup>2</sup>	> 250	> 850	> 15
Cast iron	31	Cast iron	< 250	< 850	< 10
	32	Spheroidal graphite + malleable cast iron	< 250	< 850	> 10
Titanium	41	Pure titanium	< 250	< 850	> 20
	42	Titanium alloys	> 250	> 850	< 20
Nickel	51	Nickel alloys 1 <850 N/mm <sup>2</sup>	< 250	< 850	> 25
	52	Nickel alloys 2 >850 - <1150 N/mm <sup>2</sup>	> 250	> 850	< 25
	53	Nickel alloys 3 >1150 - ≤1600 N/mm <sup>2</sup>	> 340	> 1150	< 20
Copper	61	Pure copper (electrolytic copper)	< 120	< 400	> 12
	62	Short chip brass, phosphor bronze, gun metal	< 200	< 700	< 12
	63	Long chip brass	< 200	< 700	> 12
Aluminium Magnesium	71	Al unalloyed	< 100	< 350	> 15
	72	Al alloyed Si < 1.5 %	< 150	< 500	> 15
	73	Al alloyed Si > 1.5 % - < 10 %	< 120	< 400	< 15
	74	Al alloyed Si > 10 %, Mg-Alloys	< 120	< 400	< 10
Plastic compounds	81	Thermoplastics	-	-	-
	82	Duroplastics	-	-	-
	83	Glass fibre reinforced plastics	-	-	-

GWi GW		Vc (m/min)		Milling fz (mm/tooth)			
VS	VX	VS	VX	Ø 0.3 - 1.0	Ø 1.01 - 3.0	Ø 3.01 - 6.0	Ø 6.01 - 20.0
				80 - 100	0.004 - 0.01	0.01 - 0.05	0.04 - 0.10
				80 - 100	0.004 - 0.01	0.01 - 0.05	0.04 - 0.10
				70 - 90	0.004 - 0.01	0.01 - 0.05	0.02 - 0.10
				70 - 90	0.004 - 0.01	0.01 - 0.05	0.02 - 0.10
				30 - 50	0.004 - 0.01	0.01 - 0.05	0.02 - 0.08
				15 - 40	0.003 - 0.01	0.006 - 0.03	0.008 - 0.05
				40 - 60	0.004 - 0.01	0.01 - 0.05	0.02 - 0.10
				30 - 50	0.004 - 0.01	0.01 - 0.03	0.02 - 0.05
				30 - 50	0.004 - 0.01	0.01 - 0.03	0.02 - 0.05
				30 - 50	0.004 - 0.01	0.01 - 0.03	0.02 - 0.05
				90 - 120	0.004 - 0.01	0.01 - 0.05	0.04 - 0.10
				70 - 90	0.004 - 0.01	0.01 - 0.05	0.02 - 0.10
				20 - 40	0.004 - 0.01	0.01 - 0.03	0.02 - 0.05
				15 - 35	0.004 - 0.01	0.01 - 0.03	0.02 - 0.05
				20 - 40	0.004 - 0.01	0.01 - 0.03	0.02 - 0.05
				20 - 40	0.004 - 0.01	0.01 - 0.03	0.02 - 0.05
				20 - 30	0.003 - 0.01	0.006 - 0.03	0.008 - 0.05
				200 - 250	0.004 - 0.01	0.01 - 0.05	0.02 - 0.10
				150 - 200	0.004 - 0.01	0.01 - 0.05	0.04 - 0.10
				150 - 200	0.004 - 0.01	0.01 - 0.05	0.02 - 0.10
				200 - 300	0.004 - 0.01	0.01 - 0.05	0.05 - 0.10
				200 - 300	0.004 - 0.01	0.01 - 0.05	0.05 - 0.10
				200 - 300	0.004 - 0.01	0.01 - 0.05	0.05 - 0.10
				200 - 300	0.004 - 0.01	0.01 - 0.05	0.04 - 0.10
				200 - 300	0.004 - 0.01	0.01 - 0.05	0.05 - 0.10
				100 - 200	0.004 - 0.01	0.01 - 0.05	0.04 - 0.10
				80 - 100	0.004 - 0.01	0.01 - 0.05	0.04 - 0.10

GWi3066VS  
GWi3067VS  
GWi3069VS



GWi3066VX  
GWi3067VX



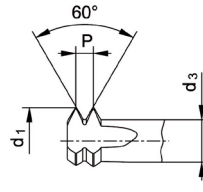
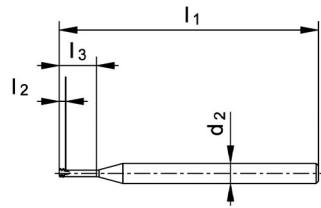
GWi3066VS

GWi3067VS

GWi3069VS

GWi3066VX

GWi3067VX



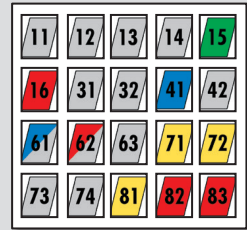
D <sub>1</sub>	P	d <sub>1</sub>	l <sub>1</sub>		l <sub>3</sub>		l <sub>3</sub>		d <sub>2</sub> h6		d <sub>3</sub>		
			2.5 · 3 x D <sub>1</sub>	2.5 x D <sub>1</sub>	3 x D <sub>1</sub>	4 x D <sub>1</sub>	4 x D <sub>1</sub>						
M 0.8	0.2	0.57	40	2.3	2.7	40	3.5	3	0.29	3	0.65		
0.9	0.225	0.64	40	2.6	3.0	40	3.9	3	0.33	3	0.70		
1	0.25	0.71	40	2.9	3.4	40	4.4	3	0.36	3	0.75		
1.2	0.25	0.91	40	3.4	4.0	40	5.2	3	0.56	3	0.95		
1.4	0.3	1.06	40	3.9	4.6	40	6.0	4	0.64	3	1.10		
1.6	0.35	1.20	40	4.5	5.3	40	6.9	4	0.71	3	1.25		
1.8	0.35	1.40	40	5.0	5.9	40	7.7	4	0.91	3	1.45		
2	0.4	1.54	40	5.6	6.6	40	8.6	4	0.98	3	1.60		
2.5	0.45	1.98	40	6.9	8.1	40	10.6	4	1.35	3	2.05		
3	0.5	2.43	51	8.4	9.9	51	12.9	5	1.73	4	2.50		
3.5	0.6	2.81	51	9.9	11.6	51	15.1	6	1.97	4	2.90		
4	0.7	3.20	51	11.3	13.3	51	17.3	6	2.22	4	3.30		
5	0.8	4.08	51	14.0	16.5	51	21.5	8	2.96	4	4.20		
6	1	4.85	51	16.8	19.8	51	25.8	8	3.45	4	5.00		
8	1.25	5.95	75	23.0	27.0	75	35.0	6	4.20	5	6.80		
10	1.5	7.95	83	28.0	33.0	83	43.0	8	5.85	5	8.50		
12	1.75	9.95	95	34.0	40.0	95	52.0	10	7.50	5	10.25		
14	2	10.95	120	44.0	52.0	120	68.0	12	8.15	5	12.00		
16	2	10.95	120	44.0	52.0	120	68.0	12	8.15	5	14.00		
18	2.5	13.95	135	55.0	65.0	135	85.0	14	10.45	6	15.50		
20	2.5	13.95	135	55.0	65.0	135	85.0	14	10.45	6	17.50		

ID

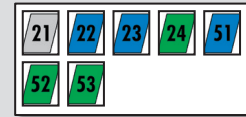


186029			187325		
186030			187326		
186031			187327		
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186034	186444		187330	187454	
186035	186445		187331	187455	
186036	186446		187332	187456	
186037	186447		187333	187457	
186038	186448	186610	187334	187458	
186039	186449	186611	187335	187459	
186040	186450	186612	187336	187460	
186041	186451	186613	187337	187461	
186042	186452	186614	187338	187462	
186043	186453	186615	187339	187463	
186044	186454	186616	187340	187464	
186045	186455	186617	187341	187465	
186046	186456	186618	187342	187466	
186817	186825	186833	187343	187467	
186047	186457	186619	187344	187468	
186818	186826	186834	187345	187469	

GW3016VS  
GW3017VS  
GW3019VS



GW3016VX  
GW3017VX



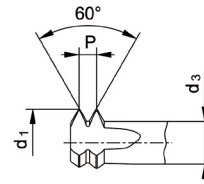
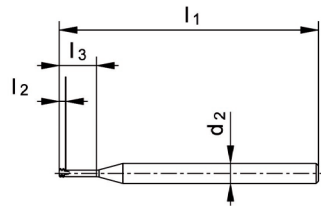
GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D <sub>1</sub>	P	d <sub>1</sub>	l <sub>1</sub> 2.5 · 3 x D <sub>1</sub>	l <sub>3</sub> 2.5 x D <sub>1</sub>	l <sub>3</sub> 3 x D <sub>1</sub>	l <sub>1</sub> 4 x D <sub>1</sub>	l <sub>3</sub> 4 x D <sub>1</sub>	d <sub>2</sub> h5	d <sub>3</sub>	3	4	5
M 0.8	0.2	0.57	39	2.3	2.7	39	3.5	3	0.29	3	0.65	
0.9	0.225	0.64	39	2.6	3.0	39	3.9	3	0.33	3	0.70	
1	0.25	0.71	39	2.9	3.4	39	4.4	3	0.36	3	0.75	
1.2	0.25	0.91	39	3.4	4.0	39	5.2	3	0.56	3	0.95	
1.4	0.3	1.06	39	3.9	4.6	39	6.0	3	0.64	3	1.10	
1.6	0.35	1.20	39	4.5	5.3	39	6.9	3	0.71	3	1.25	
1.8	0.35	1.40	39	5.0	5.9	39	7.7	3	0.91	3	1.45	
2	0.4	1.54	39	5.6	6.6	39	8.6	3	0.98	3	1.60	
2.5	0.45	1.98	39	6.9	8.1	39	10.6	3	1.35	3	2.05	
3	0.5	2.43	51	8.4	9.9	51	12.9	5	1.73	4	2.50	
3.5	0.6	2.81	51	9.9	11.6	51	15.1	5	1.97	4	2.90	
4	0.7	3.20	51	11.3	13.3	51	17.3	5	2.22	4	3.30	
5	0.8	4.08	51	14.0	16.5	51	21.5	5	2.96	4	4.20	
6	1	4.85	51	16.8	19.8	51	25.8	5	3.45	4	5.00	
8	1.25	5.95	63	23.0	27.0	75	35.0	6*	4.20	5	6.80	
10	1.5	7.95	67	28.0	33.0	83	43.0	8*	5.85	5	8.50	
12	1.75	9.95	76	34.0	40.0	95	52.0	10*	7.50	5	10.25	
14	2	10.95	95	44.0	52.0	120	68.0	12*	8.15	5	12.00	
16	2	10.95	95	44.0	52.0	120	68.0	12*	8.15	5	14.00	
18	2.5	13.95	105	55.0	65.0	135	85.0	14*	10.45	6	15.50	
20	2.5	13.95	105	55.0	65.0	135	85.0	14*	10.45	6	17.50	

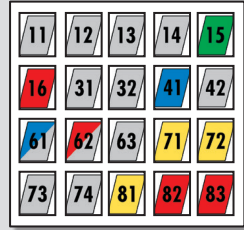
\* tol. h6

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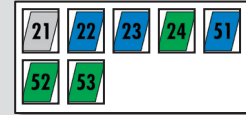


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167036	186267	167078	187262	187390
167037	186268	167079	187263	187391
167038	186269	167080	187264	187392
167039	186270	167081	187265	187393
167040	186271	167082	187266	187394
167041	186272	167083	187267	187395
167042	186273	167084	187268	187396
167043	186274	167085	187269	187397
167044	186275	167086	187270	187398
167045	186276	167087	187271	187399
167046	186277	167088	187272	187400
167047	186278	167089	187273	187401
167048	186279	167090	187274	187402
175243	186280	175274	187275	187403
175244	186281	175275	187276	187404
175245	186282	175276	187277	187405
184748	186283	184751	187278	187406
186813	186821	186829	187279	187407
184503	186284	184754	187280	187408
186814	186822	186830	187281	187409

GWi3066VS  
GWi3067VS  
GWi3069VS



GWi3066VX  
GWi3067VX



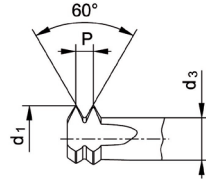
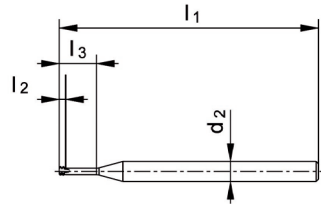
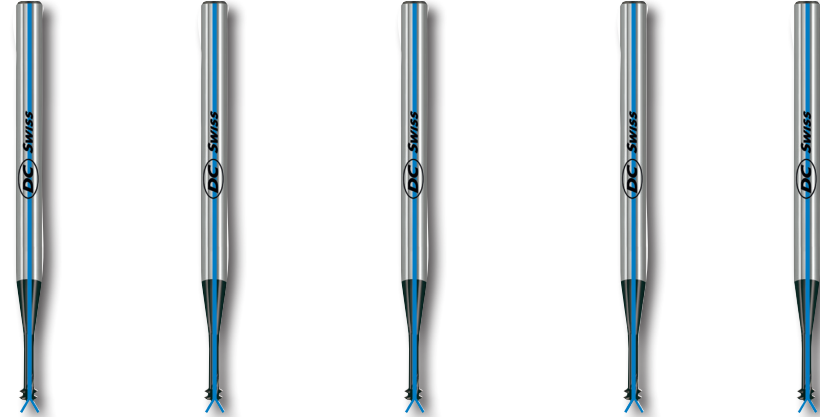
GWi3066VS

GWi3067VS

GWi3069VS

GWi3066VX

GWi3067VX



D <sub>1</sub>	P	d <sub>1</sub>	l <sub>1</sub> 2.5 · 3 x D <sub>1</sub>	l <sub>3</sub> 2.5 x D <sub>1</sub>	l <sub>3</sub> 3 x D <sub>1</sub>	l <sub>1</sub> 4 x D <sub>1</sub>	l <sub>3</sub> 4 x D <sub>1</sub>	d <sub>2</sub> h6	d <sub>3</sub>		
MF 2	0.2	1.77	40	5.3	6.3	40	8.3	4	1.49	3	1.80
2	0.25	1.71	40	5.4	6.4	40	8.4	4	1.36	3	1.75
2.5	0.2	2.27	40	6.6	7.8	40	10.3	4	1.99	3	2.30
2.5	0.25	2.21	40	6.6	7.9	40	10.4	4	1.86	3	2.25
3	0.35	2.60	51	8.2	9.7	51	12.7	5	2.11	4	2.65
4	0.5	3.43	51	10.9	12.9	51	16.9	6	2.73	4	3.50
5	0.5	4.43	51	13.4	15.9	51	20.9	8	3.73	4	4.50
6	0.75	4.95	51	16.4	19.4	51	25.4	8	3.90	4	5.25
8	1	5.95	75	22.0	26.0	75	34.0	6	4.55	5	7.00
10	1	7.95	83	27.0	32.0	83	42.0	8	6.55	5	9.00
10	1.25	7.95	83	28.0	33.0	83	43.0	8	6.20	5	8.75
12	1.5	9.95	95	33.0	39.0	95	51.0	10	7.85	5	10.50
14	1.5	10.95	120	43.0	51.0	120	67.0	12	8.85	5	12.50
16	1.5	10.95	120	43.0	51.0	120	67.0	12	8.85	5	14.50
18	1.5	13.95	135	53.0	63.0	135	83.0	14	11.85	6	16.50
20	1.5	13.95	135	53.0	63.0	135	83.0	14	11.85	6	18.50

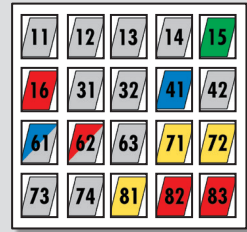
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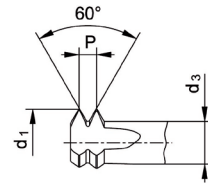
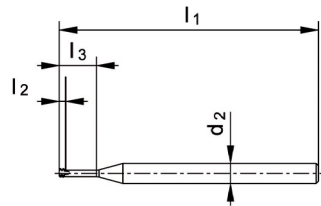
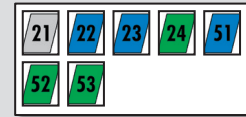
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186088	186490	187348	187472
186089	186491	187349	187473
186090	186492	186620	187350
186091	186493	186621	187351
186092	186494	186622	187352
186093	186495	186623	187353
186094	186496	186624	187354
186095	186497	186625	187355
186096	186498	186626	187356
186097	186499	186627	187357
186098	186500	186628	187358
186819	186827	186835	187359
186099	186501	186629	187360
186820	186828	186836	187361



GW3016VS  
GW3017VS  
GW3019VS



GW3016VX  
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

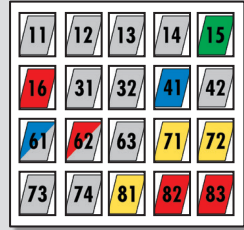
GW3017VX



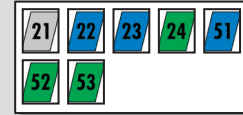
D <sub>1</sub>	P	d <sub>1</sub>	l <sub>1</sub>			l <sub>2</sub>		d <sub>2</sub> h5		d <sub>3</sub>	ID					
			2.5 · 3 x D <sub>1</sub>	2.5 x D <sub>1</sub>	3 x D <sub>1</sub>	4 x D <sub>1</sub>	4 x D <sub>1</sub>									
MF 2	0.2	1.77	39	5.3	6.3	39	8.3	3	1.49	3	1.80	171442	186325	175270	187282	187410
2	0.25	1.71	39	5.4	6.4	39	8.4	3	1.36	3	1.75	186209	186326	186592	187283	187411
2.5	0.2	2.27	39	6.6	7.8	39	10.3	3	1.99	3	2.30	175241	186327	175271	187284	187412
2.5	0.25	2.21	39	6.6	7.9	39	10.4	3	1.86	3	2.25	167299	186328	175272	187285	187413
3	0.35	2.60	51	8.2	9.7	51	12.7	5	2.11	4	2.65	175242	186329	175273	187286	187414
4	0.5	3.43	51	10.9	12.9	51	16.9	5	2.73	4	3.50	184572	186330	186593	187287	187415
5	0.5	4.43	51	13.4	15.9	51	20.9	5	3.73	4	4.50	186210	175199	171033	187288	187416
6	0.75	4.95	51	16.4	19.4	51	25.4	5	3.90	4	5.25	186211	186331	186594	187289	187417
8	1	5.95	63	22.0	26.0	75	34.0	6*	4.55	5	7.00	186212	181233	186595	187290	187418
10	1	7.95	67	27.0	32.0	83	42.0	8*	6.55	5	9.00	186213	186332	186596	187291	187419
10	1.25	7.95	67	28.0	33.0	83	43.0	8*	6.20	5	8.75	186214	186333	186597	187292	187420
12	1.5	9.95	76	33.0	39.0	95	51.0	10*	7.85	5	10.50	186215	186334	186598	187293	187421
14	1.5	10.95	95	43.0	51.0	120	67.0	12*	8.85	5	12.50	186216	186335	186599	187294	187422
16	1.5	10.95	95	43.0	51.0	120	67.0	12*	8.85	5	14.50	186815	186823	186831	187295	187423
18	1.5	13.95	105	53.0	63.0	135	83.0	14*	11.85	6	16.50	186217	186336	186600	187296	187424
20	1.5	13.95	105	53.0	63.0	135	83.0	14*	11.85	6	18.50	186816	186824	186832	187297	187425

\* tol. h6

GWi3066VS  
GWi3067VS  
GWi3069VS



GWi3066VX  
GWi3067VX



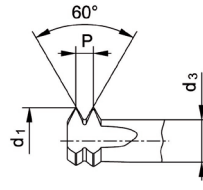
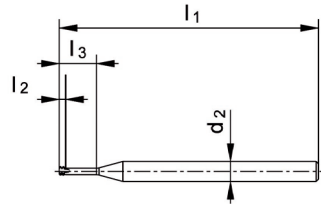
GWi3066VS

GWi3067VS

GWi3069VS

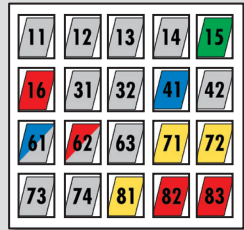
GWi3066VX

GWi3067VX

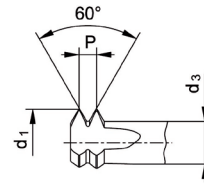
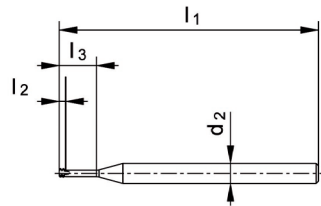
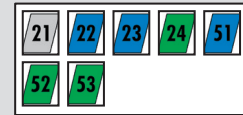


D <sub>1</sub>	P	D <sub>1</sub>	d <sub>1</sub>	l <sub>1</sub>	l <sub>3</sub>	l <sub>3</sub>	l <sub>1</sub>	l <sub>3</sub>	d <sub>2</sub> h6	d <sub>3</sub>			ID		
TPI		mm		2.5 · 3 x D <sub>1</sub>	2.5 x D <sub>1</sub>	3 x D <sub>1</sub>	4 x D <sub>1</sub>	4 x D <sub>1</sub>							
UNC 2	56	2.18	1.66	40	6.1	7.2	40	9.4	4	1.02	3	1.80	186128		187362
3	48	2.51	1.90	40	7.0	8.3	40	10.8	4	1.16	3	2.00	186129		187363
4	40	2.84	2.11	40	8.0	9.4	40	12.2	5	1.22	3	2.30	186130	186526	187364
5	40	3.17	2.44	51	9.1	10.7	51	13.9	5	1.55	4	2.60	186131	186527	187365
6	32	3.50	2.59	51	10.2	12.0	51	15.5	6	1.48	4	2.80	186132	186528	187366
8	32	4.16	3.25	51	11.9	14.0	51	18.1	6	2.14	4	3.40	186133	186529	187367
10	24	4.82	3.60	51	14.0	16.4	51	21.2	8	2.12	4	3.80	186134	186530	187368
12	24	5.48	4.26	51	15.7	18.4	51	23.9	8	2.78	4	4.50	186135	186531	187369
1/4	20	6.35	4.89	51	18.2	21.4	51	27.7	8	3.11	4	5.10	186136	186532	187370
5/16	18	7.93	5.95	75	23.0	27.0	75	35.0	6	3.97	5	6.60	186137	186533	187371
3/8	16	9.52	7.10	83	27.0	32.0	83	41.0	8	4.87	5	8.00	186138	186534	187372
7/16	14	11.11	7.95	83	32.0	37.0	83	48.0	8	5.41	5	9.30	186139	186535	187373
1/2	13	12.70	9.95	95	36.0	42.0	95	55.0	10	7.21	5	10.80	186140	186536	187374

GW3016VS  
GW3017VS  
GW3019VS



GW3016VX  
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D <sub>1</sub>	P	D <sub>1</sub>	d <sub>1</sub>	l <sub>1</sub>	l <sub>3</sub>	l <sub>3</sub>	l <sub>1</sub>	l <sub>3</sub>	d <sub>2</sub> h5	d <sub>3</sub>		
TPI		mm		2.5 · 3 x D <sub>1</sub>	2.5 x D <sub>1</sub>	3 x D <sub>1</sub>	4 x D <sub>1</sub>	4 x D <sub>1</sub>				
UNC 2	56	2.18	1.66	39	6.1	7.2	39	9.4	3	1.02	3	1.80
3	48	2.51	1.90	39	7.0	8.3	39	10.8	3	1.16	3	2.00
4	40	2.84	2.11	39	8.0	9.4	39	12.2	3	1.22	3	2.30
5	40	3.17	2.44	51	9.1	10.7	51	13.9	5	1.55	4	2.60
6	32	3.50	2.59	51	10.2	12.0	51	15.5	5	1.48	4	2.80
8	32	4.16	3.25	51	11.9	14.0	51	18.1	5	2.14	4	3.40
10	24	4.82	3.60	51	14.0	16.4	51	21.2	5	2.12	4	3.80
12	24	5.48	4.26	51	15.7	18.4	51	23.9	5	2.78	4	4.50
1/4	20	6.35	4.89	51	18.2	21.4	51	27.7	5	3.11	4	5.10
5/16	18	7.93	5.95	63	23.0	27.0	75	35.0	6*	3.97	5	6.60
3/8	16	9.52	7.10	67	27.0	32.0	83	41.0	8*	4.87	5	8.00
7/16	14	11.11	7.95	67	32.0	37.0	83	48.0	8*	5.41	5	9.30
1/2	13	12.70	9.95	76	36.0	42.0	95	55.0	10*	7.21	5	10.80

ID



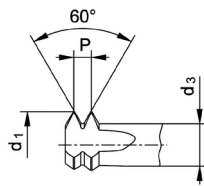
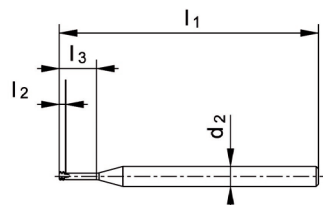
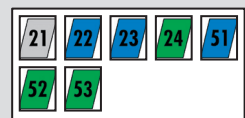
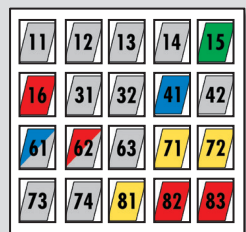
167500	186365	167507	187298	187426
186236	186366	186601	187299	187427
167501	186367	167508	187300	187428
186237	186368	186602	187301	187429
167502	186369	167509	187302	187430
167503	186370	167510	187303	187431
173986	186371	173979	187304	187432
186238	186372	186603	187305	187433
167504	186373	167511	187306	187434
175246	186374	175277	187307	187435
173546	186375	175278	187308	187436
186239	186376	186604	187309	187437
175247	186377	175279	187310	187438

\* tol. h6

GWi3066VS  
GWi3067VS  
GWi3069VS



GWi3066VX  
GWi3067VX



GWi3066VS

GWi3067VS

GWi3069VS

GWi3066VX

GWi3067VX



D <sub>1</sub>	P	D <sub>1</sub>	d <sub>1</sub>	l <sub>1</sub>	l <sub>3</sub>	l <sub>3</sub>	l <sub>1</sub>	l <sub>3</sub>	d <sub>2</sub> h6	d <sub>3</sub>		
TPI		mm		2.5 · 3 x D <sub>1</sub>	2.5 x D <sub>1</sub>	3 x D <sub>1</sub>	4 x D <sub>1</sub>	4 x D <sub>1</sub>				
UNF 0	80	1.52	1.15	40	4.3	5.0	40	6.6	4	0.71	3	1.20
1	72	1.85	1.44	40	5.1	6.1	40	7.9	4	0.95	3	1.50
2	64	2.18	1.72	40	6.0	7.1	40	9.3	4	1.16	3	1.80
4	48	2.84	2.23	40	7.9	9.3	40	12.1	5	1.49	3	2.40
5	44	3.17	2.51	51	9.0	10.6	51	13.8	5	1.70	4	2.60
6	40	3.50	2.77	51	10.0	11.7	51	15.2	6	1.88	4	2.90
8	36	4.16	3.35	51	11.7	13.8	51	18.0	6	2.36	4	3.50
10	32	4.82	3.91	51	13.5	15.9	51	20.8	8	2.80	4	4.10
12	28	5.48	4.44	51	15.4	18.1	51	23.6	8	3.17	4	4.60
1/4	28	6.35	4.95	51	17.6	20.7	51	27.1	8	3.68	4	5.50
5/16	24	7.93	5.95	75	22.0	26.0	75	34.0	6	4.47	5	6.90
3/8	24	9.52	7.10	83	26.0	31.0	83	40.0	8	5.62	5	8.50
7/16	20	11.11	7.95	83	31.0	36.0	83	47.0	8	6.17	5	9.90
1/2	20	12.70	9.95	95	35.0	41.0	95	54.0	10	8.17	5	11.50

ID



186167				187375	
186168				187376	
186169				187377	
186170	186559			187378	187497
186171	186560			187379	187498
186172	186561	186639		187380	187499
186173	186562	186640		187381	187500
186174	186563	186641		187382	187501
186175	186564	186642		187383	187502
186176	186565	186643		187384	187503
186177	186566	186644		187385	187504
186178	186567	186645		187386	187505
186179	186568	186646		187387	187506
186180	186569	186647		187388	187507

# UNF

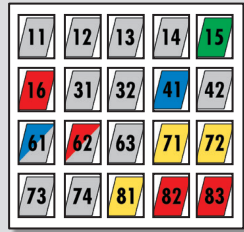
ANSI B1.1

# GW

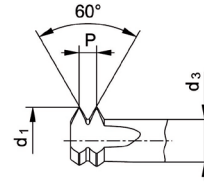
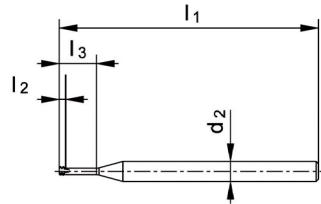
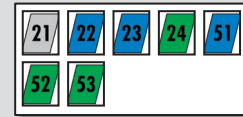


h5/h6

GW3016VS  
GW3017VS  
GW3019VS



GW3016VX  
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D <sub>1</sub>	P	D <sub>1</sub>	d <sub>1</sub>	l <sub>1</sub>	l <sub>3</sub>	l <sub>3</sub>	l <sub>1</sub>	l <sub>3</sub>	d <sub>2</sub> h5	d <sub>3</sub>		
TPI		mm		2.5 · 3 x D <sub>1</sub>	2.5 x D <sub>1</sub>	3 x D <sub>1</sub>	4 x D <sub>1</sub>	4 x D <sub>1</sub>				
UNF 0	80	1.52	1.15	39	4.3	5.0	39	6.6	3	0.71	3	1.20
1	72	1.85	1.44	39	5.1	6.1	39	7.9	3	0.95	3	1.50
2	64	2.18	1.72	39	6.0	7.1	39	9.3	3	1.16	3	1.80
4	48	2.84	2.23	39	7.9	9.3	39	12.1	3	1.49	3	2.40
5	44	3.17	2.51	51	9.0	10.6	51	13.8	5	1.70	4	2.60
6	40	3.50	2.77	51	10.0	11.7	51	15.2	5	1.88	4	2.90
8	36	4.16	3.35	51	11.7	13.8	51	18.0	5	2.36	4	3.50
10	32	4.82	3.91	51	13.5	15.9	51	20.8	5	2.80	4	4.10
12	28	5.48	4.44	51	15.4	18.1	51	23.6	5	3.17	4	4.60
1/4	28	6.35	4.95	51	17.6	20.7	51	27.1	5	3.68	4	5.50
5/16	24	7.93	5.95	63	22.0	26.0	75	34.0	6*	4.47	5	6.90
3/8	24	9.52	7.10	67	26.0	31.0	83	40.0	8*	5.62	5	8.50
7/16	20	11.11	7.95	67	31.0	36.0	83	47.0	8*	6.17	5	9.90
1/2	20	12.70	9.95	76	35.0	41.0	95	54.0	10*	8.17	5	11.50

\* tol. h6

ID

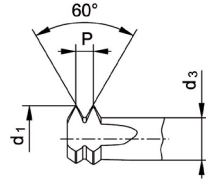
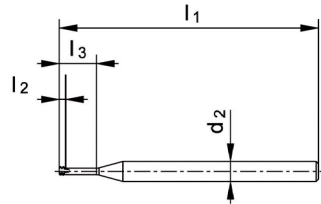
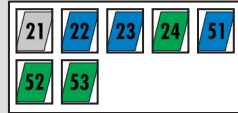
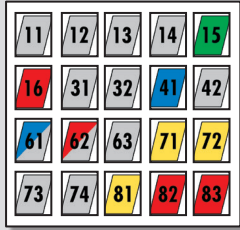


175248	186404	175280	187311	187439
175249	186405	175281	187312	187440
186248	186406	186605	187313	187441
175250	186407	172376	187314	187442
186249	186408	169815	187315	187443
186250	186409	186606	187316	187444
175251	186410	175282	187317	187445
167505	184633	167512	187318	187446
186251	186411	186607	187319	187447
167506	186412	167513	187320	187448
175252	186413	175283	187321	187449
175253	186414	175284	187322	187450
186252	186415	186608	187323	187451
186253	186416	186609	187324	187452

GWi3067VS



GWi3067VX



GWi3067VS

GWi3067VX

GWi3067VS

GWi3067VX



$D_1$	$P$	$d_1$	$l_1$	$l_3$ <small>3 x <math>D_1</math></small>	$d_2$ h6	$d_3$		
MJ 3.0	0.5	2.17	51	9.9	5	1.47	4	2.60
4.0	0.7	2.84	51	13.3	6	1.86	4	3.40
5.0	0.8	3.67	51	16.5	8	2.55	4	4.30
6.0	1.0	4.34	51	19.8	8	2.94	4	5.10
8.0	1.25	5.95	75	27.0	6	4.20	5	6.90
10.0	1.5	7.95	83	33.0	8	5.85	5	8.70
12.0	1.75	9.95	95	40.0	10	7.50	5	10.40

ID



188820	188843
188821	188844
188822	188845
188823	188846
188824	188847
188825	188848
188826	188849

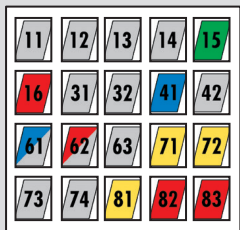
$D_1$	$P$	$d_1$	$l_1$	$l_3$ <small>3 x <math>D_1</math></small>	$d_2$ h6	$d_3$		
MJF 6.0	0.75	4.76	51	19.4	8	3.71	4	5.35
8.0	1.0	5.95	75	26.0	6	4.55	5	7.10
10.0	1.25	7.95	83	33.0	8	6.20	5	8.90
12.0	1.5	9.95	95	39.0	10	7.85	5	10.70

ID

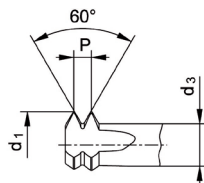
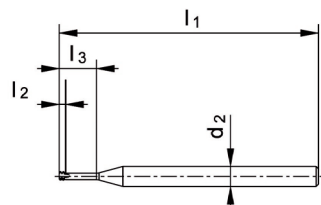


188827	188850
188828	188851
188829	188852
188830	188853

GW3067VS



GW3067VX



GW3067VS

GW3067VX

GW3067VS

GW3067VX



$D_1$	P	$d_1$	$l_1$	$l_3$	$d_2$ h6	$d_3$		
TPI		mm		3 x $D_1$				
UNJC 6	32	2.59	51	12.0	6	1.48	4	2.80
10	24	3.60	51	16.4	8	2.12	4	4.00
1/4	20	4.89	51	21.4	8	3.11	4	5.30
5/16	18	5.95	75	27.0	6	3.97	5	6.75
3/8	16	7.10	83	32.0	8	4.88	5	8.10
1/2	13	9.95	95	42.0	10	7.21	5	11.00

ID			
188831	•	188854	•
188832	•	188855	•
188833	•	188856	•
188834	•	188857	•
188835	•	188858	•
188836	•	188859	•

$D_1$	P	$d_1$	$l_1$	$l_3$	$d_2$ h6	$d_3$		
TPI		mm		3 x $D_1$				
UNJF 8	36	2.99	51	13.8	6	2.00	4	3.60
10	32	3.51	51	16.0	8	2.40	4	4.20
1/4	28	4.84	51	20.7	8	3.57	4	5.60
5/16	24	5.95	75	26.0	6	4.47	5	7.00
3/8	24	7.10	83	31.0	8	5.62	5	8.60
1/2	20	9.95	95	41.0	10	8.17	5	11.60

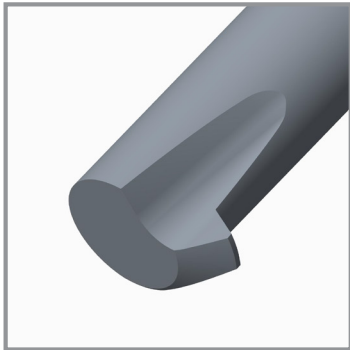
ID			
188837	•	188860	•
188838	•	188861	•
188839	•	188862	•
188840	•	188863	•
188841	•	188864	•
188842	•	188865	•

# LARGE PROGRAMME OF THREAD MILLING SOLUTIONS

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**GW**  
SERIES 1000

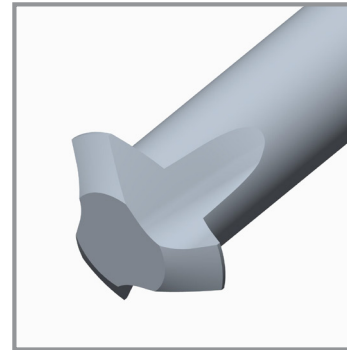
VS



GW1116 / GW1116VS  
S 0.3 – S 1.4

**GW**  
SERIES 2000

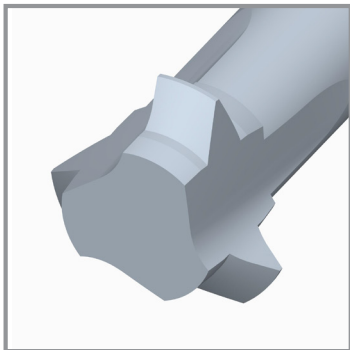
VS



GW2016 / GW2016VS  
M 0.8 – M 6  
S 0.8 – S 1.4

**GW**  
SERIES 4000

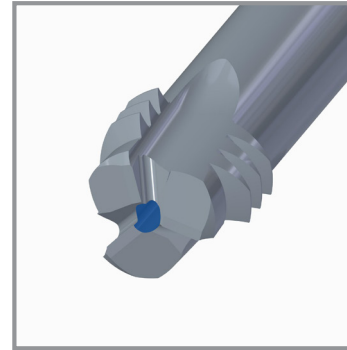
VS



GW4116 / GW4116VS  
GW4119 / GW4119VS  
M 0.8 – M 6  
UNC 2-56 – UNC 1/4-20  
UNF 10-32 – UNF 1/4-28

**ZBGF**

VS



ZBGF6065VS / ZBGF6067VS  
M 3 – M 16  
UNC 4-40 – UNC 5/8-11  
UNF 4-48 – UNF 5/8-18





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