



GW*i*
SERIES 3000

GW
SERIES 3000

EN-ID-1017



BEST SOLUTION IN STAINLESS STEELS AND SUPER ALLOYS

Ø 0.8 - 6.5 mm

GW*i*
SERIES 3000



Ø 6.5 - 20 mm



Chip evacuation



Double performance



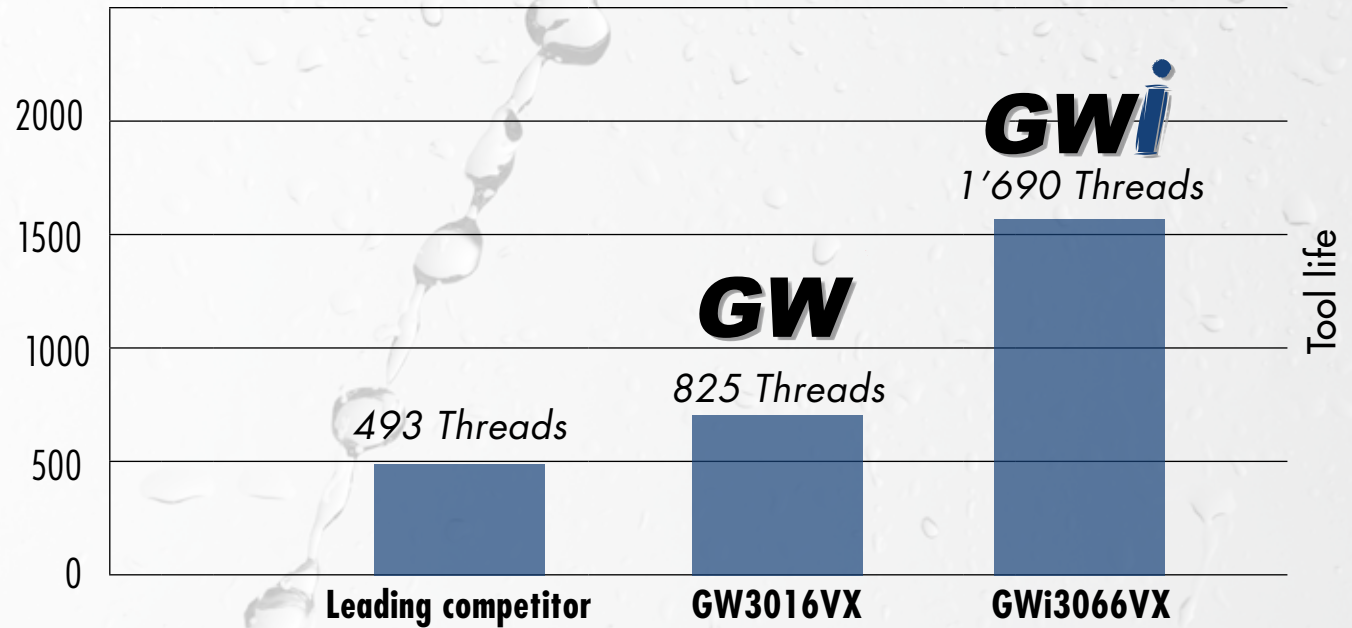
Process security



No sticking

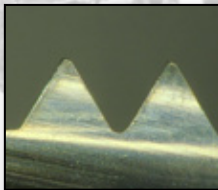
PERFORMANCE

Material: Stainless steel, 1.4301
Machine: DMC 650V
Kind of hole: Blind hole
Thread size: M3 6H
Thread length: 2 x D₁
Lubricant: Emulsion 8%
Vc & Feed: 50 m/min & 0.02 mm/tooth

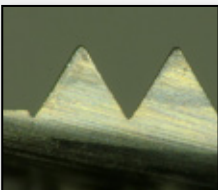


WEAR OUT

GWi VX
1'690 Threads

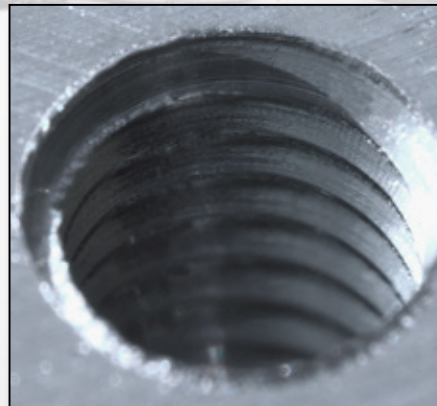


GW VX
825 Threads



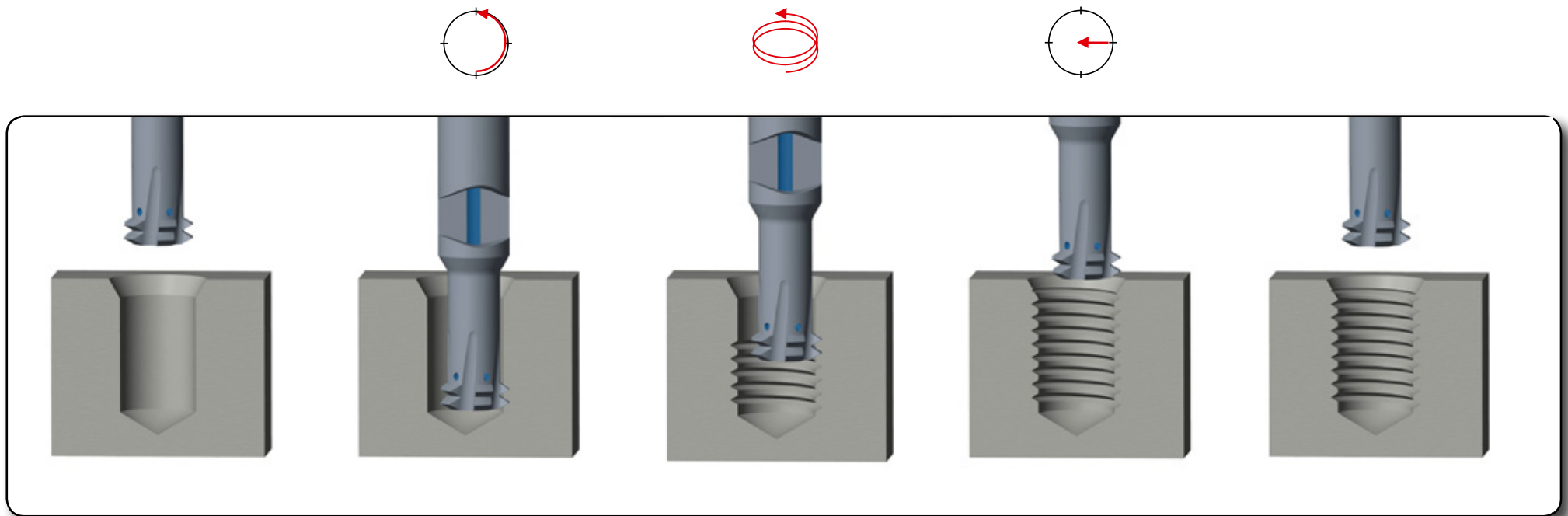
SURFACE QUALITY

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

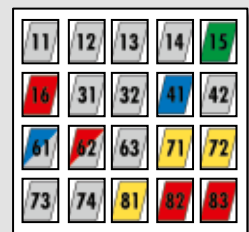
 Suitable

MATERIAL CLASSIFICATION

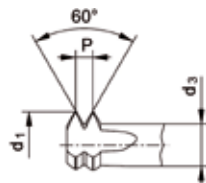
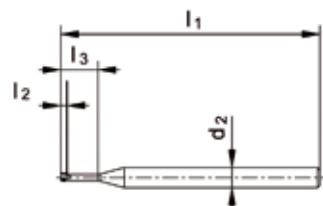
Material groups		Material designation	Hardness (HB)	Tensile strength Rm (N/mm ²)	Elongation A (%)
Steels	11	Free-cutting steels	<200	<700	<10
	12	Structural / cementation steels	<200	<700	<30
	13	Carbon steels	<300	<1000	<20
	14	Alloy steels <850 N/mm ²	<250	<850	<30
	15	Alloy steels hard. / temp. >850 - <1150 N/mm ²	>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 ²	<250	<850	>20
	24	Ferritic and martens. >850 - <1150 N/mm ²	>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 ²	<250	<850	>25
	52	Nickel alloys 2 >850 - <1150 N/mm ²	>250	>850	<25
	53	Nickel alloys 3 >1150 - ≤1600 N/mm ²	>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	0.08 – 0.15
		80 – 100		0.004 – 0.01	0.01 – 0.05	0.04 – 0.10	0.08 – 0.15
		70 – 90		0.004 – 0.01	0.01 – 0.05	0.02 – 0.10	0.05 – 0.15
		70 – 90		0.004 – 0.01	0.01 – 0.05	0.02 – 0.10	0.05 – 0.15
		30 – 50		0.004 – 0.01	0.01 – 0.05	0.02 – 0.08	0.04 – 0.15
		15 – 40		0.003 – 0.01	0.006 – 0.03	0.008 – 0.05	0.01 – 0.08
		40 – 60		0.004 – 0.01	0.01 – 0.05	0.02 – 0.10	0.05 – 0.15
		30 – 50		0.004 – 0.01	0.01 – 0.03	0.02 – 0.05	0.03 – 0.08
		30 – 50		0.004 – 0.01	0.01 – 0.03	0.02 – 0.05	0.03 – 0.08
		30 – 50		0.004 – 0.01	0.01 – 0.03	0.02 – 0.05	0.03 – 0.08
		90 – 120		0.004 – 0.01	0.01 – 0.05	0.04 – 0.10	0.08 – 0.15
		70 – 90		0.004 – 0.01	0.01 – 0.05	0.02 – 0.10	0.05 – 0.15
		20 – 40		0.004 – 0.01	0.01 – 0.03	0.02 – 0.05	0.03 – 0.08
		15 – 35		0.004 – 0.01	0.01 – 0.03	0.02 – 0.05	0.03 – 0.08
		20 – 40		0.004 – 0.01	0.01 – 0.03	0.02 – 0.05	0.03 – 0.08
		20 – 40		0.004 – 0.01	0.01 – 0.03	0.02 – 0.05	0.03 – 0.08
		20 – 30		0.003 – 0.01	0.006 – 0.03	0.008 – 0.05	0.01 – 0.08
		200 – 250		0.004 – 0.01	0.01 – 0.05	0.02 – 0.10	0.05 – 0.15
		150 – 200		0.004 – 0.01	0.01 – 0.05	0.04 – 0.10	0.08 – 0.15
		150 – 200		0.004 – 0.01	0.01 – 0.05	0.02 – 0.10	0.05 – 0.15
		200 – 300		0.004 – 0.01	0.01 – 0.05	0.05 – 0.10	0.10 – 0.20
		200 – 300		0.004 – 0.01	0.01 – 0.05	0.05 – 0.10	0.10 – 0.20
		200 – 300		0.004 – 0.01	0.01 – 0.05	0.05 – 0.10	0.10 – 0.20
		200 – 300		0.004 – 0.01	0.01 – 0.05	0.04 – 0.10	0.08 – 0.15
		200 – 300		0.004 – 0.01	0.01 – 0.05	0.05 – 0.10	0.10 – 0.20
		100 – 200		0.004 – 0.01	0.01 – 0.05	0.04 – 0.10	0.08 – 0.15
		80 – 100		0.004 – 0.01	0.01 – 0.05	0.04 – 0.10	0.08 – 0.15

GWi3066VS
GWi3067VS
GWi3069VS



GWi3066VX
GWi3067VX



GWi3066VS

GWi3067VS

GWi3069VS

GWi3066VX

GWi3067VX



D ₁	P	d ₁	l ₁ 2.5 - 3 x D ₁	l ₃ 2.5 x D ₁	l ₃ 3 x D ₁	l ₁ 4 x D ₁	l ₃ 4 x D ₁	d ₂ h6	d ₃		
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

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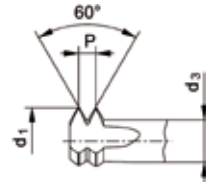
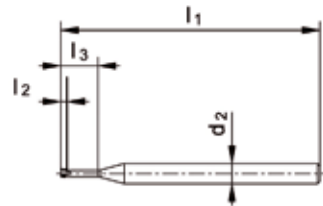
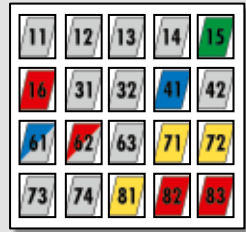
187345

187469

GW3066VS
GW3067VS
GW3069VS



GW3066VX
GW3067VX



GW3066VS

GW3067VS

GW3069VS

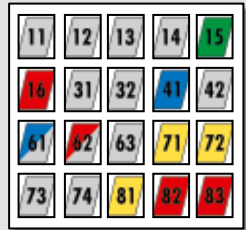
GW3066VX

GW3067VX

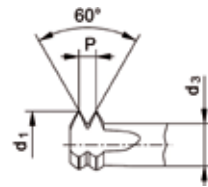
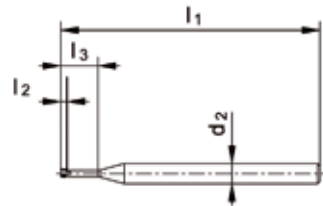


D ₁	P	d ₁	l ₁ 2.5 - 3 x D ₁	l ₃ 2.5 x D ₁	l ₃ 3 x D ₁	l ₁ 4 x D ₁	l ₃ 4 x D ₁	d ₂ h6	d ₃			ID					
MF2	0.2	1.77	40	5.3	6.3		40	8.3	4	1.49	3	1.80	186086	186488	187346	187470	
2	0.25	1.71	40	5.4	6.4		40	8.4	4	1.36	3	1.75	186087	186489	187347	187471	
2.5	0.2	2.27	40	6.6	7.8		40	10.3	4	1.99	3	2.30	186088	186490	187348	187472	
2.5	0.25	2.21	40	6.6	7.9		40	10.4	4	1.86	3	2.25	186089	186491	187349	187473	
3	0.35	2.60	51	8.2	9.7		51	12.7	5	2.11	4	2.65	186090	186492	186620	187350	187474
4	0.5	3.43	51	10.9	12.9		51	16.9	6	2.73	4	3.50	186091	186493	186621	187351	187475
5	0.5	4.43	51	13.4	15.9		51	20.9	8	3.73	4	4.50	186092	186494	186622	187352	187476
6	0.75	4.95	51	16.4	19.4		51	25.4	8	3.90	4	5.25	186093	186495	186623	187353	187477
8	1	5.95	75	22.0	26.0		75	34.0	6	4.55	5	7.00	186094	186496	186624	187354	187478
10	1	7.95	83	27.0	32.0		83	42.0	8	6.55	5	9.00	186095	186497	186625	187355	187479
10	1.25	7.95	83	28.0	33.0		83	43.0	8	6.20	5	8.75	186096	186498	186626	187356	187480
12	1.5	9.95	95	33.0	39.0		95	51.0	10	7.85	5	10.50	186097	186499	186627	187357	187481
14	1.5	10.95	120	43.0	51.0		120	67.0	12	8.85	5	12.50	186098	186500	186628	187358	187482
16	1.5	10.95	120	43.0	51.0		120	67.0	12	8.85	5	14.50	186819	186827	186835	187359	187483
18	1.5	13.95	135	53.0	63.0		135	83.0	14	11.85	6	16.50	186099	186501	186629	187360	187484
20	1.5	13.95	135	53.0	63.0		135	83.0	14	11.85	6	18.50	186820	186828	186836	187361	187485

GW3016VS
GW3017VS
GW3019VS



GW3016VX
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D ₁	P	d ₁	l ₁ 2.5 - 3 x D ₁	l ₃ 2.5 x D ₁	l ₃ 3 x D ₁	l ₁ 4 x D ₁	l ₃ 4 x D ₁	d ₂ h5	d ₃		
MF2	0.2	1.77	39	5.3	6.3	39	8.3	3	1.49	3	1.80
2	0.25	1.71	39	5.4	6.4	39	8.4	3	1.36	3	1.75
2.5	0.2	2.27	39	6.6	7.8	39	10.3	3	1.99	3	2.30
2.5	0.25	2.21	39	6.6	7.9	39	10.4	3	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	5	2.73	4	3.50
5	0.5	4.43	51	13.4	15.9	51	20.9	5	3.73	4	4.50
6	0.75	4.95	51	16.4	19.4	51	25.4	5	3.90	4	5.25
8	1	5.95	63	22.0	26.0	75	34.0	6*	4.55	5	7.00
10	1	7.95	67	27.0	32.0	83	42.0	8*	6.55	5	9.00
10	1.25	7.95	67	28.0	33.0	83	43.0	8*	6.20	5	8.75
12	1.5	9.95	76	33.0	39.0	95	51.0	10*	7.85	5	10.50
14	1.5	10.95	95	43.0	51.0	120	67.0	12*	8.85	5	12.50
16	1.5	10.95	95	43.0	51.0	120	67.0	12*	8.85	5	14.50
18	1.5	13.95	105	53.0	63.0	135	83.0	14*	11.85	6	16.50
20	1.5	13.95	105	53.0	63.0	135	83.0	14*	11.85	6	18.50

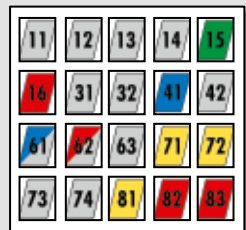
* tol. h6

ID

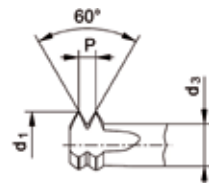
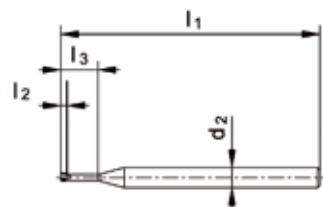


171442	186325	175270	187282	187410
186209	186326	186592	187283	187411
175241	186327	175271	187284	187412
167299	186328	175272	187285	187413
175242	186329	175273	187286	187414
184572	186330	186593	187287	187415
186210	175199	171033	187288	187416
186211	186331	186594	187289	187417
186212	181233	186595	187290	187418
186213	186332	186596	187291	187419
186214	186333	186597	187292	187420
186215	186334	186598	187293	187421
186216	186335	186599	187294	187422
186815	186823	186831	187295	187423
186217	186336	186600	187296	187424
186816	186824	186832	187297	187425

GW3066VS
GW3067VS
GW3069VS



GW3066VX
GW3067VX



GW3066VS

GW3067VS

GW3069VS

GW3066VX

GW3067VX



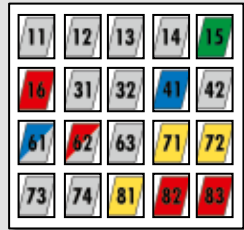
D ₁	P	D ₁	d ₁	l ₁	l ₃	l ₃	l ₁	l ₃	d ₂ h6	d ₃		
TPI		mm		2.5 - 3 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁				
UNC 2	56	2.18	1.66	40	6.1	7.2	40	9.4	4	1.02	3	1.80
3	48	2.51	1.90	40	7.0	8.3	40	10.8	4	1.16	3	2.00
4	40	2.84	2.11	40	8.0	9.4	40	12.2	5	1.22	3	2.30
5	40	3.17	2.44	51	9.1	10.7	51	13.9	5	1.55	4	2.60
6	32	3.50	2.59	51	10.2	12.0	51	15.5	6	1.48	4	2.80
8	32	4.16	3.25	51	11.9	14.0	51	18.1	6	2.14	4	3.40
10	24	4.82	3.60	51	14.0	16.4	51	21.2	8	2.12	4	3.80
12	24	5.48	4.26	51	15.7	18.4	51	23.9	8	2.78	4	4.50
1/4	20	6.35	4.89	51	18.2	21.4	51	27.7	8	3.11	4	5.10
5/16	18	7.93	5.95	75	23.0	27.0	75	35.0	6	3.97	5	6.60
3/8	16	9.52	7.10	83	27.0	32.0	83	41.0	8	4.87	5	8.00
7/16	14	11.11	7.95	83	32.0	37.0	83	48.0	8	5.41	5	9.30
1/2	13	12.70	9.95	95	36.0	42.0	95	55.0	10	7.21	5	10.80

ID

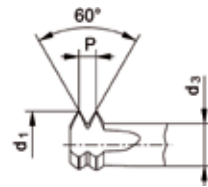
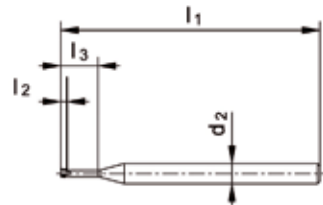


186128		187362	
186129		187363	
186130	186526	187364	187486
186131	186527	187365	187487
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186135	186531	186633	187369
186136	186532	186634	187370
186137	186533	186635	187371
186138	186534	186636	187372
186139	186535	186637	187373
186140	186536	186638	187374

GW3016VS
GW3017VS
GW3019VS



GW3016VX
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D ₁	P	D ₁	d ₁	I ₁	I ₃	I ₃	I ₁	I ₃	d ₂ h5	d ₃		
TPI		mm		2.5 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁				
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

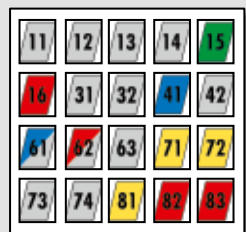
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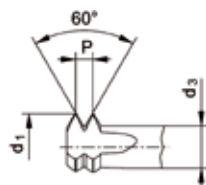
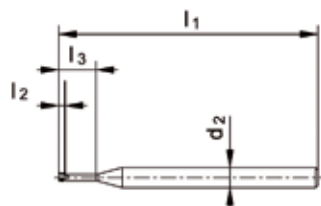


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167502	186369	167509	187302	187430
167503	186370	167510	187303	187431
173986	186371	173979	187304	187432
186238	186372	186603	187305	187433
167504	186373	167511	187306	187434
175246	186374	175277	187307	187435
173546	186375	175278	187308	187436
186239	186376	186604	187309	187437
175247	186377	175279	187310	187438

GW3066VS
GW3067VS
GW3069VS



GW3066VX
GW3067VX



GW3066VS

GW3067VS

GW3069VS

GW3066VX

GW3067VX



ID



D ₁	P	D ₁	d ₁	l ₁	l ₃	l ₃	l ₁	l ₃	d ₂ h6	d ₃		
TPI		mm		2.5 - 3 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁				
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

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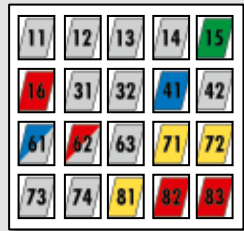
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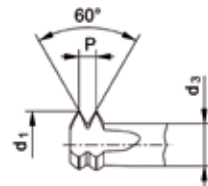
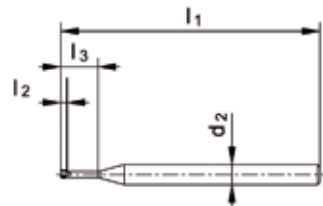
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GW3016VS
GW3017VS
GW3019VS



GW3016VX
GW3017VX



GW3016VS

GW3017VS

GW3019VS

GW3016VX

GW3017VX



D ₁	P	D ₁	d ₁	l ₁	l ₃	l ₃	l ₁	l ₃	d ₂ h5	d ₃		
TPI		mm		2.5 - 3 x D ₁	2.5 x D ₁	3 x D ₁	4 x D ₁	4 x D ₁				
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

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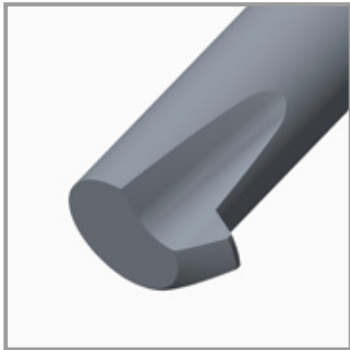
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LARGE PROGRAMME OF THREAD MILLING SOLUTIONS

GW
SERIES 1000

VS

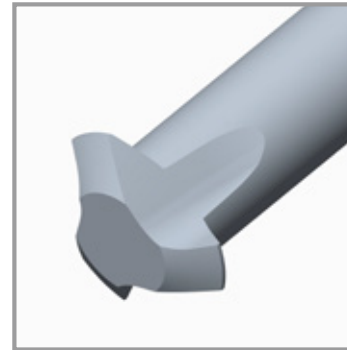


GW1116 / GW1116VS

S 0.3 – S 1.4

GW
SERIES 2000

VS



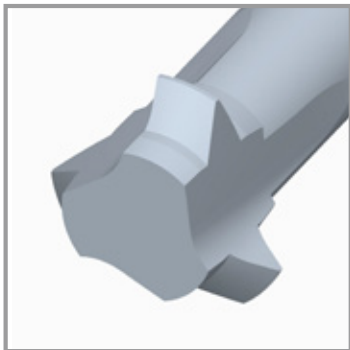
GW2016 / GW2016VS

M 0.8 – M 6

S 0.8 – S 1.4

GW
SERIES 4000

VS



GW4116 / GW4116VS

GW4119 / GW4119VS

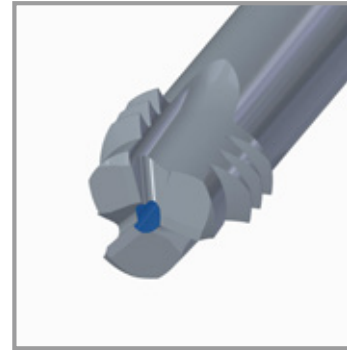
M 0.8 – M 6

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

► **THREAD GAUGES**



► **THREAD TAPPING**



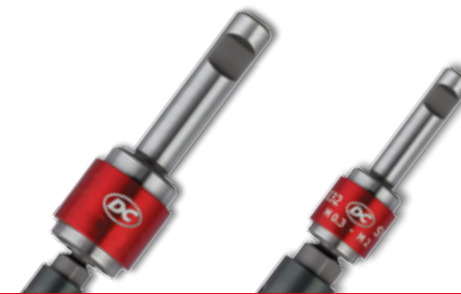
► **THREAD FORMING**



► **THREAD MILLING**



► **TAPPING CHUCKS**



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