

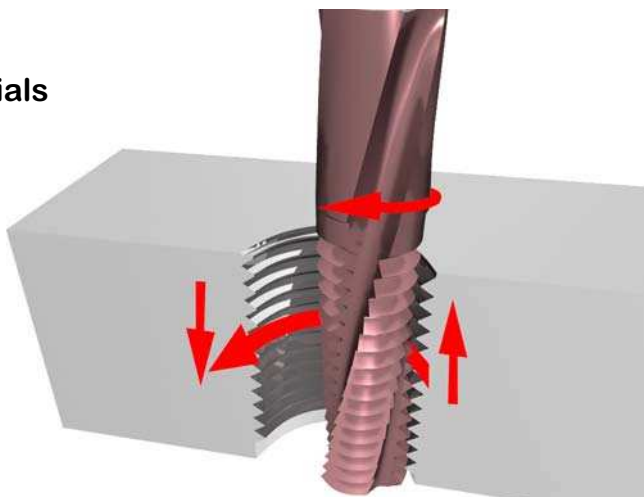
WhizCut[®]

Smart Solutions on the Cutting Edge

WhizThril
Solid Carbide Thread Mills
By WhizCut

Why one should choose Thread Milling versus Thread Tapping

- Smoother cutting with short chips
- Improves surface finish in many materials
- Better chipflow
- Increased tool life
- Straighter thread
- Less Toolbreakage



Why WhizThrill

- Micrograin Carbide
- Special TiAlCN PVD coating for best surface finish and maximum tool life
- Close tolerances on thread profile

Thread Milling is not a difficult operation to do when one has the right support. For this reason WhizCut offers a program, free of charge to all customers, that will help you program the machine. The WhizThrill aid is a very user friendly excel based program that recommends the programming for your CNC machine. It is available in 18 different languages. The program is updated regularly, so make sure you have the latest version. Get the latest version free of charge from your local distributor.

WhizThrill

Internal Thread Milling in Machining Center

Fanuc

M - Metric

Steel, Low Carbon, < 0,25% C, < 400 N/mm2

D = thread diameter (mm) **24**

P = pitch (mm) **3**

L = thread length (mm) **36**

S = safety distance (mm) **2**

NOS35C40 3.050 AC

d = cutter diameter (mm) **16**

l = length of cutting edge (mm) **40,5**

z = number of flutes **3**

V = cutting speed (m/min) **158**

Fz = feed/tooth (mm/tooth) **0,050**

Number of passes, radial (max 3) **1**

Number of passes, axial **1**

N = spindle speed (rpm) **3143**

FD = feed at thread diameter (mm/min) **467**

Fd = feed in center of mill (mm/min) **156**

T = time to mill the thread (seconds) **14**

[Please read before use!](#)











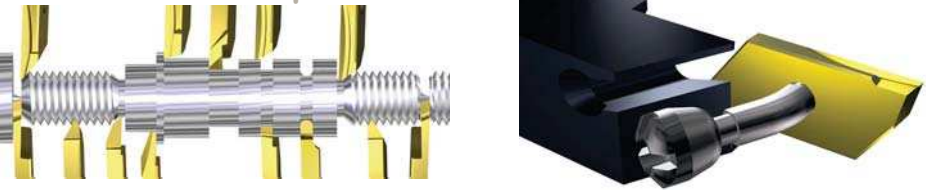
CNC program for Fanuc

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S3143 M3
G00 G91 Z-38.
G01 G41 X3. Y-2. F156
G03 X2. Y2. Z0.375 I0. J2.
G03 X0. Y0. Z3. I-4. J0.
G03 X-2. Y2. Z0.375 I-2. J0.
G01 G40 X-2. Y-2.
G00 Z34.25
                    
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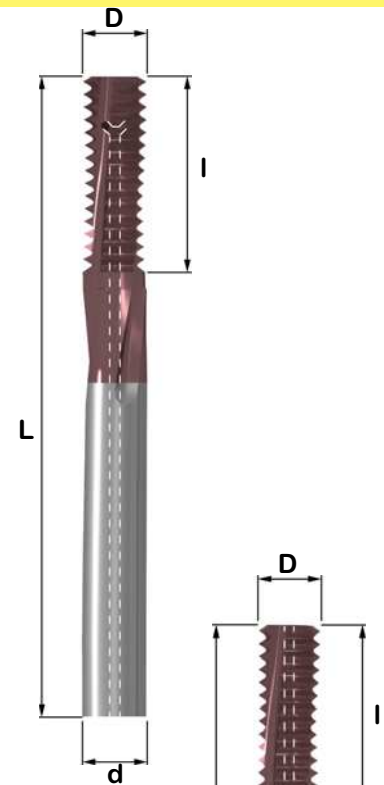
info@whizcut.se
www.whizcut.se
Tel +46 42 322 500
Fax +46 42 130 880

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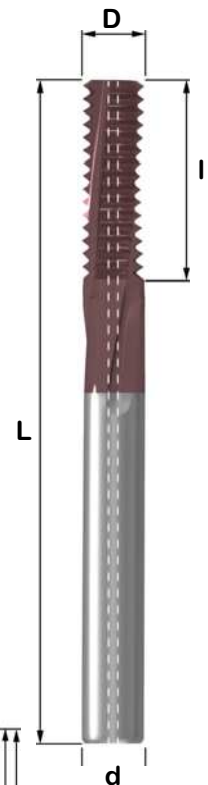
Metric with Internal coolant

Pitch mm	M coarse	M fine	Part Number	d mm	D mm	Cutting edges	l mm	L mm	Price Group
1,25	M8 (1,5xD)	≥ M10	UC0606C14 1.25ISO A9	6	6	3	14,38	64	T8
1,25	M8 (2,25xD)	≥ M10	UC0606C19 1.25ISO A9	6	6	3	19,38	64	T10
1,25	M8 (3xD)	≥ M10	UC0606C25 1.25ISO A9	6	6	3	25,62	76	T12
1,5	M10 (1,5xD)	≥ M12	UC08075C17 1.5ISO A9	8	7,5	3	17,25	76	T12
1,5	M10 (2,25xD)	≥ M12	UC08075C24 1.5ISO A9	8	7,5	3	24,75	76	T15
1,5	M10 (3xD)	≥ M12	UC08075C32 1.5ISO A9	8	7,5	3	32,25	76	T17
1,75	M12 (1,5xD)		UC0808C20 1.75ISO A9	8	8	3	20,13	76	T12
1,75	M12 (2,25xD)		UC0808C28 1.75ISO A9	8	8	3	28,88	76	T15
1,75	M12 (1,5xD)		UC1009C20 1.75ISO A9	10	9	3	20,13	100	T16
1,75	M12 (2,25xD)		UC1009C28 1.75ISO A9	10	9	3	28,88	100	T19
1,75	M12 (3xD)		UC1009C37 1.75ISO A9	10	9	3	37,62	100	T20
2	M14 (1,5xD)	≥ M18	UC1010C27 2.0ISO A9	10	10	3	27	100	T16
2	M14 (2,25xD)	≥ M18	UC1010C39 2.0ISO A9	10	10	3	39	100	T19
2	M16 (1,5xD)	≥ M18	UC1212D27 2.0ISO A9	12	12	4	27	100	T19
2	M16 (2,25xD)	≥ M18	UC1212D39 2.0ISO A9	12	12	4	39	100	T22
2	M16 (3xD)	≥ M18	UC1212C51 2.0ISO A9	12	12	3	51	100	T21
2,5	M20 (2,25xD)		UC1414D48 2.5ISO A9	14	14	4	48,75	100	T24
3	M24 (2,25xD)	≥ M30	UC1616C58 3.0ISO A9	16	16	3	58,5	120	T26
3,5	M30 (2,25xD)		UC2020C71 3.5ISO A9	20	20	3	71,75	150	T29



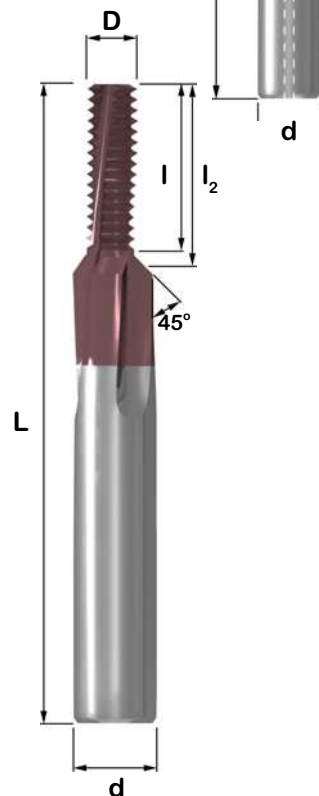
Metric with Radial coolant

Pitch mm	M coarse	M fine	Part Number	d mm	D mm	Cutting edges	l mm	L mm	Price Group
1,25	M8 (2,25xD)	≥ M10	UT0606C19 1.25ISO A9	6	6	3	19,38	64	T12
1,5	M10 (2,25xD)	≥ M12	UT08075C24 1.5ISO A9	8	7,5	3	24,75	76	T16
1,75	M12 (2,25xD)		UT0808C28 1.75ISO A9	8	8	3	28,88	76	T16
1,75	M12 (2,25xD)		UT1009C28 1.75ISO A9	10	9	3	28,88	100	T20
2	M14 (2,25xD)	≥ M18	UT1010C39 2.0ISO A9	10	10	3	39	100	T20
2	M16 (2,25xD)	≥ M18	UT1212D39 2.0ISO A9	12	12	4	39	100	T21

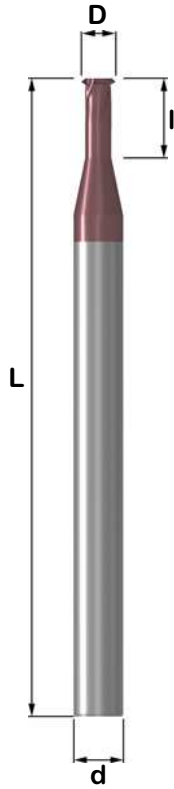


Metric with chamfer

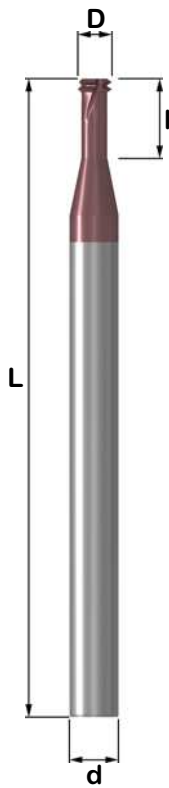
Pitch mm	M Coarse	Part Number	d mm	D mm	Cutting Edges	l mm	l ₂ mm	L mm	Price group
0,5	M3 (1,5xD)	UF06023C5 0.5ISO A9	6	2,3	3	5,25	5,9	64	T7
0,5	M3 (2,25xD)	UF06023C7 0.5ISO A9	6	2,3	3	7,25	7,9	64	T9
0,5	M3 (3xD)	UF06023C9 0.5ISO A9	6	2,3	3	9,75	10,4	64	T11
0,7	M4 (1,5xD)	UF0603C7 0.7ISO A9	6	3	3	7,35	8,3	64	T7
0,7	M4 (2,25xD)	UF0603C10 0.7ISO A9	6	3	3	10,15	11,1	64	T9
0,7	M4 (3xD)	UF0603C12 0.7ISO A9	6	3	3	12,95	13,9	64	T11
0,8	M5 (1,5xD)	UF06038C9 0.8ISO A9	6	3,8	3	9,2	10,3	64	T7
0,8	M5 (2,25xD)	UF06038C12 0.8ISO A9	6	3,8	3	12,4	13,5	64	T9
0,8	M5 (3xD)	UF06038C16 0.8ISO A9	6	3,8	3	16,4	17,5	64	T11
1	M6 (1,5xD)	UF08045C10 1.0ISO A9	8	4,5	3	10,5	12	64	T9
1	M6 (2,25xD)	UF08045C14 1.0ISO A9	8	4,5	3	14,5	16	64	T12
1,25	M8 (1,5xD)	UF1006C14 1.25ISO A9	10	6	3	14,38	16,51	76	T12
1,25	M8 (2,25xD)	UF1006C19 1.25ISO A9	10	6	3	19,38	21,51	76	T15
1,5	M10 (1,5xD)	UF12075C17 1.5ISO A9	12	7,5	3	17,25	19,5	83	T14
1,5	M10 (2,25xD)	UF12075C24 1.5ISO A9	12	7,5	3	24,75	27	83	T17
1,75	M12 (1,5xD)	UF1409C20 1.75ISO A9	14	9	3	20,13	23,01	89	T18
1,75	M12 (2,25xD)	UF1409C28 1.75ISO A9	14	9	3	28,88	31,76	89	T20



Micro Partial Profile 60°

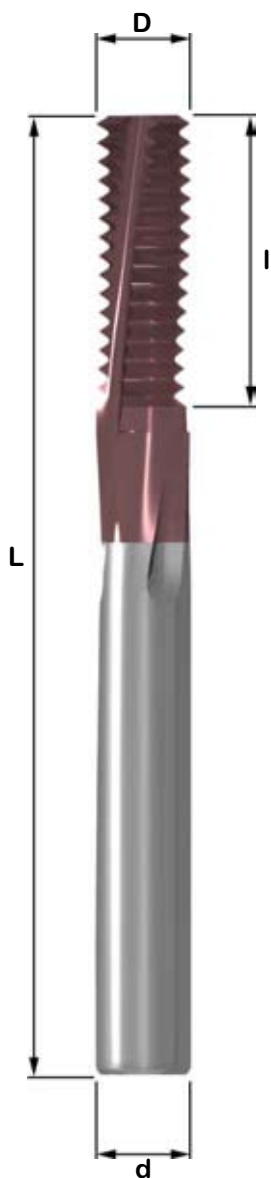


M coarse	M fine	UNC UNF	Part Number	d mm	D mm	Cutting edges	l mm	L mm	Price Group
M2-M2,2	M1,8-M2	No.2 (1,5xD)	US03015C3.8 P60 A9	3	1,5	3	3,8	39	T1
M2-M2,2	M1,8-M2	No.2 (2,25xD)	US03015C5.4 P60 A9	3	1,5	3	5,4	39	T1
M2,5	M2,2	No.3 (1,5xD)	US03019C4.3 P60 A9	3	1,9	3	4,3	39	T1
M2,5	M2,2	No.3 (2,25xD)	US03019C6.2 P60 A9	3	1,9	3	6,2	39	T1
	M2,5	No.4 (1,5xD)	US03021C4.9 P60 A9	3	2,1	3	4,9	39	T1
	M2,5	No.4 (2,25xD)	US03021C7.1 P60 A9	3	2,1	3	7,1	39	T1
M3		No.5 (1,5xD)	US03023C5.4 P60 A9	3	2,3	3	5,4	39	T1
M3		No.5 (2,25xD)	US03023C7.8 P60 A9	3	2,3	3	7,8	39	T1
M3,5	M3	No.6 (1,5xD)	US03026C6.1 P60 A9	3	2,6	3	6,1	39	T1
M3,5	M3	No.6 (2,25xD)	US03026C8.7 P60 A9	3	2,6	3	8,7	39	T1
M4	M3,5-M4	No.8 (1,5xD)	US0303C7.1 P60 AC9	3	3	3	7,1	39	T1
M4	M3,5-M4	No.8 (2,25xD)	US0303C10.2 P60 A9	3	3	3	10,2	39	T1
M4,5	M4,5	No.10 (1,5xD)	US04036C8.3 P60 A9	4	3,6	3	8,3	51	T2
M4,5	M4,5	No.10 (2,25xD)	US04036C12.0 P60 A9	4	3,6	3	12	51	T2
M5-M6	M5-M6	No.12 (1,5xD)	US0404C10.0 P60 A9	4	4	3	10	51	T2
M5-M6	M5-M6	No.12 (2,25xD)	US0404C14.5 P60 A9	4	4	3	14,5	51	T2



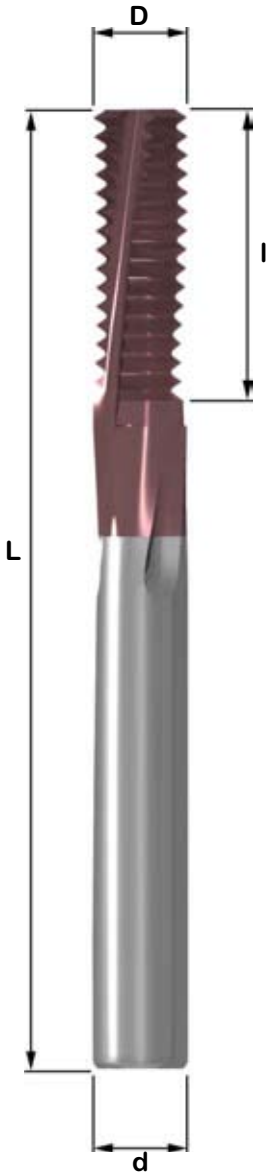
Micro Metrical

Pitch mm	M Coarse	Part Number	d mm	D mm	Cutting Edges	l mm	L mm	Price group
0,4	M2 (1,5xD)	UM03015C3 0.4ISO A9	3	1,5	3	3,4	39	T1
0,4	M2 (2,25xD)	UM03015C5 0.4ISO A9	3	1,5	3	5	39	T1
0,45	M2.2 (1,5xD)	UM03016C3 0.45ISO A9	3	1,6	3	3,8	39	T1
0,45	M2.2 (2,25xD)	UM03016C5 0.45ISO A9	3	1,6	3	5,4	39	T1
0,45	M2.5 (1,5xD)	UM03019C4 0.45ISO A9	3	1,9	3	4,2	39	T1
0,45	M2.5 (2,25xD)	UM03019C6 0.45ISO A9	3	1,9	3	6,1	39	T1
0,5	M3 (1,5xD)	UM03023C5 0.5ISO A9	3	2,3	3	5	39	T1
0,5	M3 (2,25xD)	UM03023C7 0.5ISO A9	3	2,3	3	7,3	39	T1
0,6	M3.5 (1,5xD)	UM03026C6 0.6ISO A9	3	2,6	3	6	39	T1
0,6	M3.5 (2,25xD)	UM03026C8 0.6ISO A9	3	2,6	3	8,5	39	T1
0,7	M4 (1,5xD)	UM0303C7 0.7ISO A9	3	3	3	7	39	T1
0,7	M4 (2,25xD)	UM0303C10 0.7ISO A9	3	3	3	10	39	T1
0,8	M5 (1,5xD)	UM04038C9 0.8ISO A9	4	3,8	3	9	51	T2
0,8	M5 (2,25xD)	UM04038C12 0.8ISO A9	4	3,8	3	12,1	51	T2
1	M6 (1,5xD)	UM06045C10 1.0ISO A9	6	4,5	3	10	64	T3
1	M6 (2,25xD)	UM06045C14 1.0ISO A9	6	4,5	3	14,5	64	T3
1,25	M8 (1,5xD)	UM0606C14 1.25ISO A9	6	6	3	14	64	T3
1,25	M8 (2,25xD)	UM0606C19 1.25ISO A9	6	6	3	19,3	64	T3



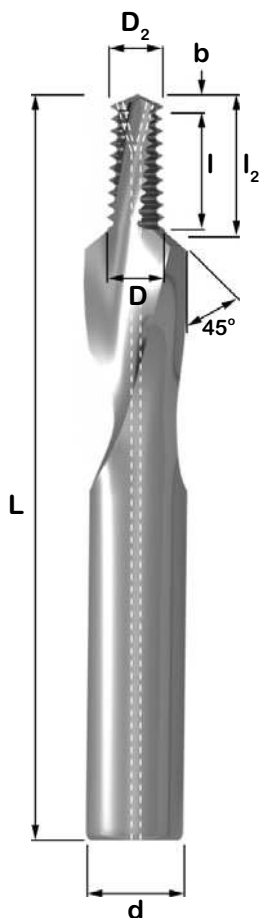
Pitch TPI	UNC	UNF	Part Number	d mm	D mm	Cutting Edges	l mm	L mm	Price group
44		No.5 (1,5xD)	U03024C5 44UN A9	3	2,4	3	5,48	39	T4
40	No.5 (2,25xD)	No.6 (1,5xD)	U03023C7 40UN A9	3	2,3	3	7,94	39	T6
36		No.8 (1,5xD)	U04031C7 36UN A9	4	3,1	3	7,41	51	T5
32	No.6 (2,25xD)		U03025C9 32UN A9	3	2,5	3	9,13	39	T6
32	No.8 (2,25xD)	No.10 (1,5xD)	U0303C10 32UN A9	3	3	3	10,72	39	T6
28		No.12 (1,5xD)	U0604C11 28UN A9	6	4	3	11,34	64	T7
28		1/4 (1,5xD)	U0605C11 28UN A9	6	5	3	11,34	64	T7
24	No.10-12 (2,25xD)		U04038C14 24UN A9	4	3,8	3	14,29	51	T7
24		5/16 (1,5xD)	U0606C14 24UN A9	6	6	3	14,29	64	T7
24		3/8 (1,5xD)	U08076C21 24UN A9	8	7,6	3	20,96	64	T10
20	1/4 (1,5xD)		U06045C12 20UN A9	6	4,5	3	12,07	64	T7
20	1/4 (2,25xD)		U06045C15 20UN A9	6	4,5	3	15,88	64	T9
20		7/16 (1,5xD)	U0808C21 20UN A9	8	8	3	20,96	76	T10
20		1/2 (1,5xD)	U1010D21 20UN A9	10	10	4	20,96	76	T14
20			U1212E27 20UN A9	12	12	5	27,31	83	T17
18	5/16 (1,5xD)		U06058C14 18UN A9	6	5,8	3	14,82	64	T7
18	5/16 (2,25xD)		U06058C20 18UN A9	6	5,8	3	20,46	64	T9
18		9/16 (1,5xD)	U1010D26 18UN A9	10	10	4	26,11	76	T14
18		5/8 (1,5xD)	U1212D26 18UN A9	12	12	4	26,11	83	T17
16	3/8 (1,5xD)		U0606C16 16UN A9	6	6	3	16,67	64	T7
16	3/8 (2,25xD)		U0606C23 16UN A9	6	6	3	23,02	76	T9
16	3/8 (1,5xD)		U0807C16 16UN A9	8	7	3	16,67	64	T10
16	3/8 (2,25xD)		U0807C23 16UN A9	8	7	3	23,02	76	T13
16		3/4 (1,5xD)	U1212D31 16UN A9	12	12	4	30,95	100	T17
16			U1616E34 16UN A9	16	16	5	34,13	100	T22
14	7/16 (1,5xD)		U808C20 14UN A9	8	8	3	20,87	76	T10
14	7/16 (2,25xD)		U0808C28 14UN A9	8	8	3	28,12	76	T13
14		7/8 (1,5xD)	U1616E37 14UN A9	16	16	5	37,2	100	T22
13	1/2 (1,5xD)		U0808C22 13UN A9	8	8	3	22,47	76	T10
13	1/2 (2,25xD)		U0808C32 13UN A9	8	8	3	32,24	76	T13
13	1/2 (1,5xD)		U10093C22 13UN A9	10	9,3	3	22,47	100	T14
13	1/2 (2,25xD)		U10093C32 13UN A9	10	9,3	3	32,24	100	T17
12	9/16 (1,5xD)		U1010C26 12UN A9	10	10	3	26,46	76	T14
12	9/16 (2,25xD)		U1010C34 12UN A9	10	10	3	34,94	100	T17
12		1-1,5	U1616E41 12UN A9	16	16	5	41,28	100	T22
11	5/8 (1,5xD)		U1010C28 11UN A9	10	10	3	28,86	76	T14
11	5/8 (2,25xD)		U1010C40 11UN A9	10	10	3	40,41	100	T17
11	5/8 (1,5xD)		U12115C28 11UN A9	12	11,5	3	28,86	83	T17
11	5/8 (2,25xD)		U12115C40 11UN A9	12	11,5	3	40,41	100	T20
10	3/4 (1,5xD)		U1212C34 10UN A9	12	12	3	34,29	100	T17
10	3/4 (2,25xD)		U1212C47 10UN A9	12	12	3	46,99	100	T20
10	3/4 (1,5xD)		U1414D34 10UN A9	14	14	4	34,29	89	T21
10	3/4 (2,25xD)		U1414D47 10UN A9	14	14	4	46,99	100	T22
9	7/8 (1,5xD)		U1616C38 9UN A9	16	16	3	38,1	100	T22
9	7/8 (2,25xD)		U1616C55 9UN A9	16	16	3	55,03	120	T23
8	1 (1,5xD)		U1616C42 8UN A9	16	16	3	42,87	100	T22
8	1 (2,25xD)		U1616C61 8UN A9	16	16	3	61,92	120	T23
8			U2020D46 8UN A9	20	20	4	46,04	120	T24
7	11/8-11/4 (1,5xD)		U2020C52 7UN A9	20	20	3	52,61	120	T25
6	13/8-11/2 (1,5xD)		U2525C61 6UN A9	25	25	3	61,38	130	T28

Pitch TPI	UNC	UNF	Part Number	d mm	D mm	Cutting Edges	l mm	L mm	Price group
44		No.5 (1,5xD)	U03024C5 44UN A9	3	2,4	3	5,48	39	T4
40	No.5 (2,25xD)	No.6 (1,5xD)	U03023C7 40UN A9	3	2,3	3	7,94	39	T6
36		No.8 (1,5xD)	U04031C7 36UN A9	4	3,1	3	7,41	51	T5
32	No.6 (2,25xD)		U03025C9 32UN A9	3	2,5	3	9,13	39	T6
32	No.8 (2,25xD)	No.10 (1,5xD)	U0303C10 32UN A9	3	3	3	10,72	39	T6
28		No.12 (1,5xD)	U0604C11 28UN A9	6	4	3	11,34	64	T7
28		1/4 (1,5xD)	U0605C11 28UN A9	6	5	3	11,34	64	T7
24	No.10-12 (2,25xD)		U04038C14 24UN A9	4	3,8	3	14,29	51	T7
24		5/16 (1,5xD)	U0606C14 24UN A9	6	6	3	14,29	64	T7
24		3/8 (1,5xD)	U08076C21 24UN A9	8	7,6	3	20,96	64	T10
20	1/4 (1,5xD)		U06045C12 20UN A9	6	4,5	3	12,07	64	T7
20	1/4 (2,25xD)		U06045C15 20UN A9	6	4,5	3	15,88	64	T9
20		7/16 (1,5xD)	U0808C21 20UN A9	8	8	3	20,96	76	T10
20		1/2 (1,5xD)	U1010D21 20UN A9	10	10	4	20,96	76	T14
20			U1212E27 20UN A9	12	12	5	27,31	83	T17
18	5/16 (1,5xD)		U06058C14 18UN A9	6	5,8	3	14,82	64	T7
18	5/16 (2,25xD)		U06058C20 18UN A9	6	5,8	3	20,46	64	T9
18		9/16 (1,5xD)	U1010D26 18UN A9	10	10	4	26,11	76	T14
18		5/8 (1,5xD)	U1212D26 18UN A9	12	12	4	26,11	83	T17
16	3/8 (1,5xD)		U0606C16 16UN A9	6	6	3	16,67	64	T7
16	3/8 (2,25xD)		U0606C23 16UN A9	6	6	3	23,02	76	T9
16	3/8 (1,5xD)		U0807C16 16UN A9	8	7	3	16,67	64	T10
16	3/8 (2,25xD)		U0807C23 16UN A9	8	7	3	23,02	76	T13
16		3/4 (1,5xD)	U1212D31 16UN A9	12	12	4	30,95	100	T17
16			U1616E34 16UN A9	16	16	5	34,13	100	T22
14	7/16 (1,5xD)		U808C20 14UN A9	8	8	3	20,87	76	T10
14	7/16 (2,25xD)		U0808C28 14UN A9	8	8	3	28,12	76	T13
14		7/8 (1,5xD)	U1616E37 14UN A9	16	16	5	37,2	100	T22
13	1/2 (1,5xD)		U0808C22 13UN A9	8	8	3	22,47	76	T10
13	1/2 (2,25xD)		U0808C32 13UN A9	8	8	3	32,24	76	T13
13	1/2 (1,5xD)		U10093C22 13UN A9	10	9,3	3	22,47	100	T14
13	1/2 (2,25xD)		U10093C32 13UN A9	10	9,3	3	32,24	100	T17
12	9/16 (1,5xD)		U1010C26 12UN A9	10	10	3	26,46	76	T14
12	9/16 (2,25xD)		U1010C34 12UN A9	10	10	3	34,94	100	T17
12		1-1,5	U1616E41 12UN A9	16	16	5	41,28	100	T22
11	5/8 (1,5xD)		U1010C28 11UN A9	10	10	3	28,86	76	T14
11	5/8 (2,25xD)		U1010C40 11UN A9	10	10	3	40,41	100	T17
11	5/8 (1,5xD)		U12115C28 11UN A9	12	11,5	3	28,86	83	T17
11	5/8 (2,25xD)		U12115C40 11UN A9	12	11,5	3	40,41	100	T20
10	3/4 (1,5xD)		U1212C34 10UN A9	12	12	3	34,29	100	T17
10	3/4 (2,25xD)		U1212C47 10UN A9	12	12	3	46,99	100	T20
10	3/4 (1,5xD)		U1414D34 10UN A9	14	14	4	34,29	89	T21
10	3/4 (2,25xD)		U1414D47 10UN A9	14	14	4	46,99	100	T22
9	7/8 (1,5xD)		U1616C38 9UN A9	16	16	3	38,1	100	T22
9	7/8 (2,25xD)		U1616C55 9UN A9	16	16	3	55,03	120	T23
8	1 (1,5xD)		U1616C42 8UN A9	16	16	3	42,87	100	T22
8	1 (2,25xD)		U1616C61 8UN A9	16	16	3	61,92	120	T23
8			U2020D46 8UN A9	20	20	4	46,04	120	T24
7	11/8-11/4 (1,5xD)		U2020C52 7UN A9	20	20	3	52,61	120	T25
6	13/8-11/2 (1,5xD)		U2525C61 6UN A9	25	25	3	61,38	130	T28



All New Drill, Thread and Chamfer in one!

Do you work in aluminium and have been tired of using many different tools? WhizCut now offers the UD line, which drills, threads and chamfers in one operation. This exceptional tool gives a superb result and saves both tool cost and time.



Pitch mm	M coarse	Part Number	d mm	D mm	D ₂ mm	b mm	Cutting edges	l mm	l ₂ mm	L mm	Price Group
1	M6(1,5xD)	UD08047B10 1.0ISO MG	8	4,7	5	1,9	2	10,5	13,6	64	T20
1,25	M8(1,5xD)	UD10065B14 1.25ISO MG	10	6,5	6,8	2,5	2	14,38	18,3	76	T21
1,5	M10(1,5xD)	UD12082B17 1.5ISO MG	12	8,2	8,5	3,2	2	17,25	22,1	83	T22

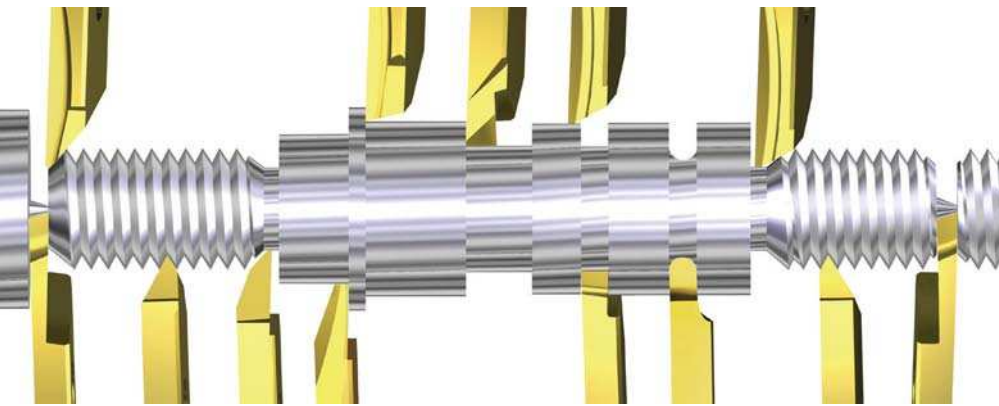
Smart Solutions on the Cutting Edge

Demand on production for small parts around the world is continuously increasing. Higher expectations and more pressure are put on the producers of these parts. This is where WhizCut comes in.

At WhizCut we understand the day to day challenges the users of automatic lathes are up against. To assist these users WhizCut has developed many very useful products for all automatic lathes around the globe.

We try; to put it simple, to find new solutions for existing problems within the world of small part machining. Our company is based on these new products that will make your production faster, more precise and effective. No matter if your work is in external or internal cutting, we have the solutions to boost your production.

WhizCut is determined to continuing being one of the leading manufacturers for small part machining in the world.

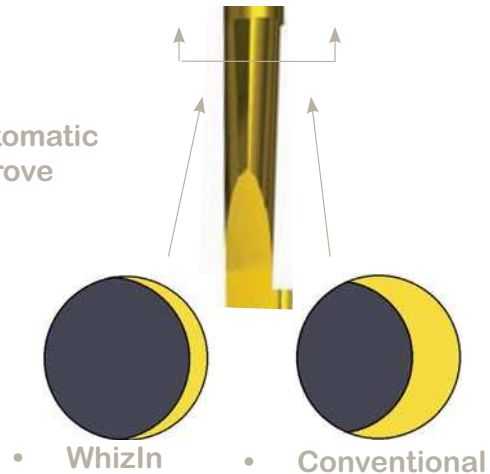


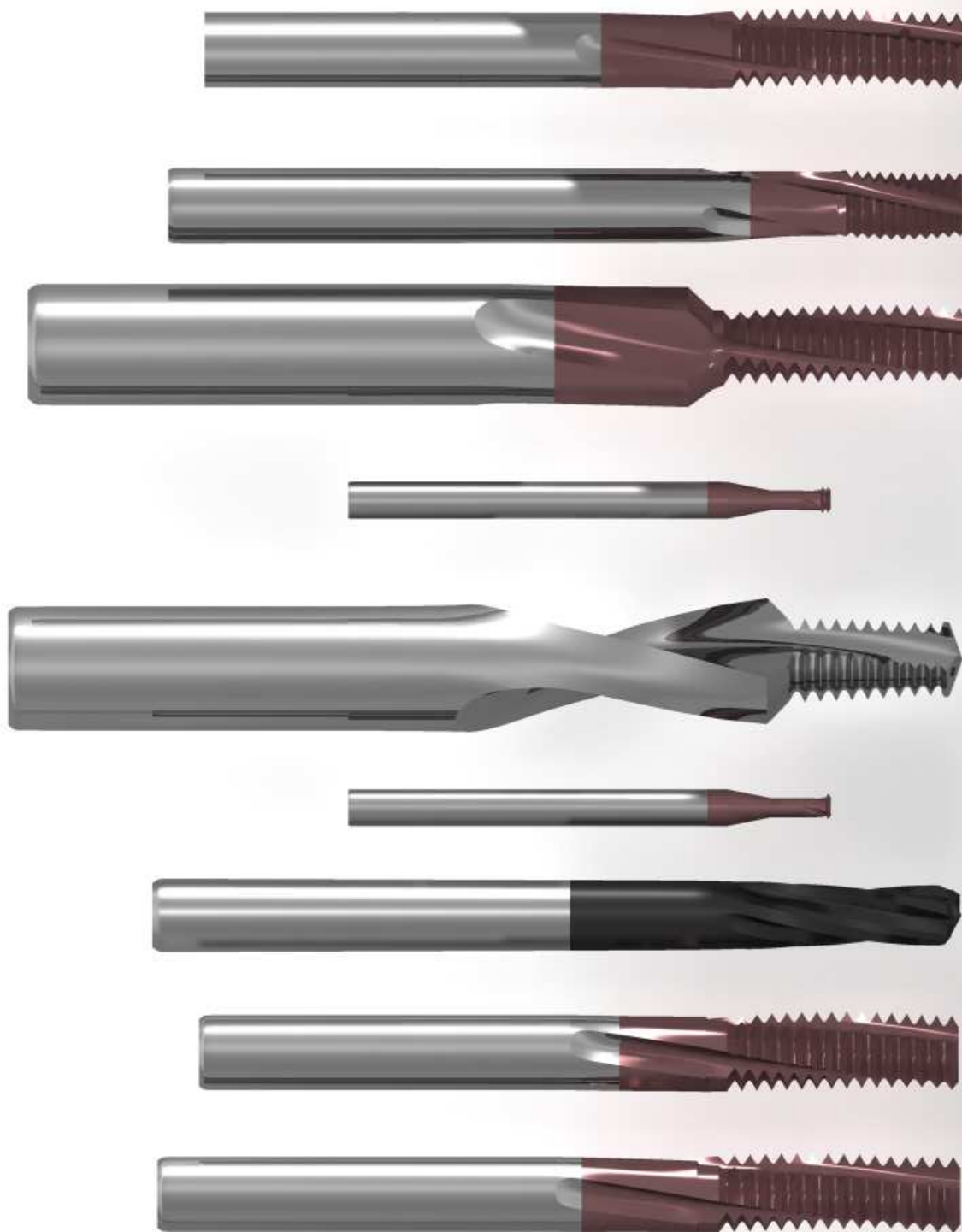
The Products

WhizCut offers a complete external and internal range of toolholders and carbide inserts specially developed for automatic lathes. With this new technology WhizCut will help You improve productivity and reduce interruptions in production.

WhizCut Special features

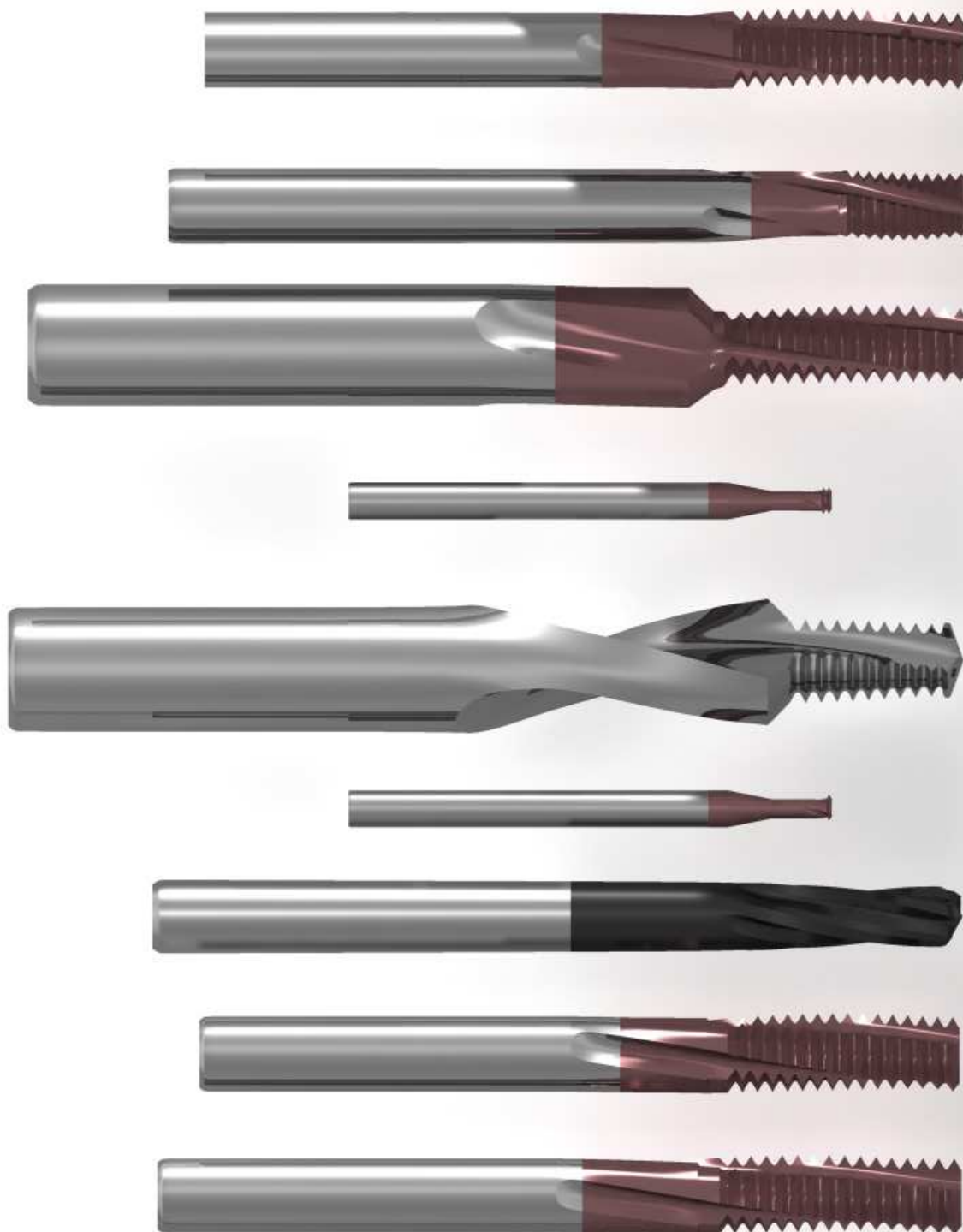
- Versatile with 2 clamping systems
- Inserts for all standard applications
- Up to 20° positive cutting rake
- Fully ground edge
- Micro grain Carbide
- PVD coated inserts
- Chip control
- Makes it possible to index the insert in the machine
- Unique back turning insert
- An internal tooling program with outstanding stability
- Wide range of internal boring bars
- Boring bar diameter starts at 1 mm
- Custom made external and internal inserts can be specially made to suit customer needs.
- Any type of stepdrill or special reamer can be ordered with fast turn around time.



**WhizCut®**

WhizCut of Sweden AB
Kungsgatan 2
S-25221 Helsingborg
Sweden

Ph. +46 42 322500
Fax. +46 42 130880
Web: www.whizcut.se
Email: info@whizcut.se

**WhizCut®**

WhizCut of Sweden AB
Kungsgatan 2
S-25221 Helsingborg
Sweden

WhizThrill -Solid Carbide
Thread Mills by WhizCut

Ph. +46 42 322500
Fax. +46 42 130880
Web: www.whizcut.se
Email: info@whizcut.se

