

THREADMILLING

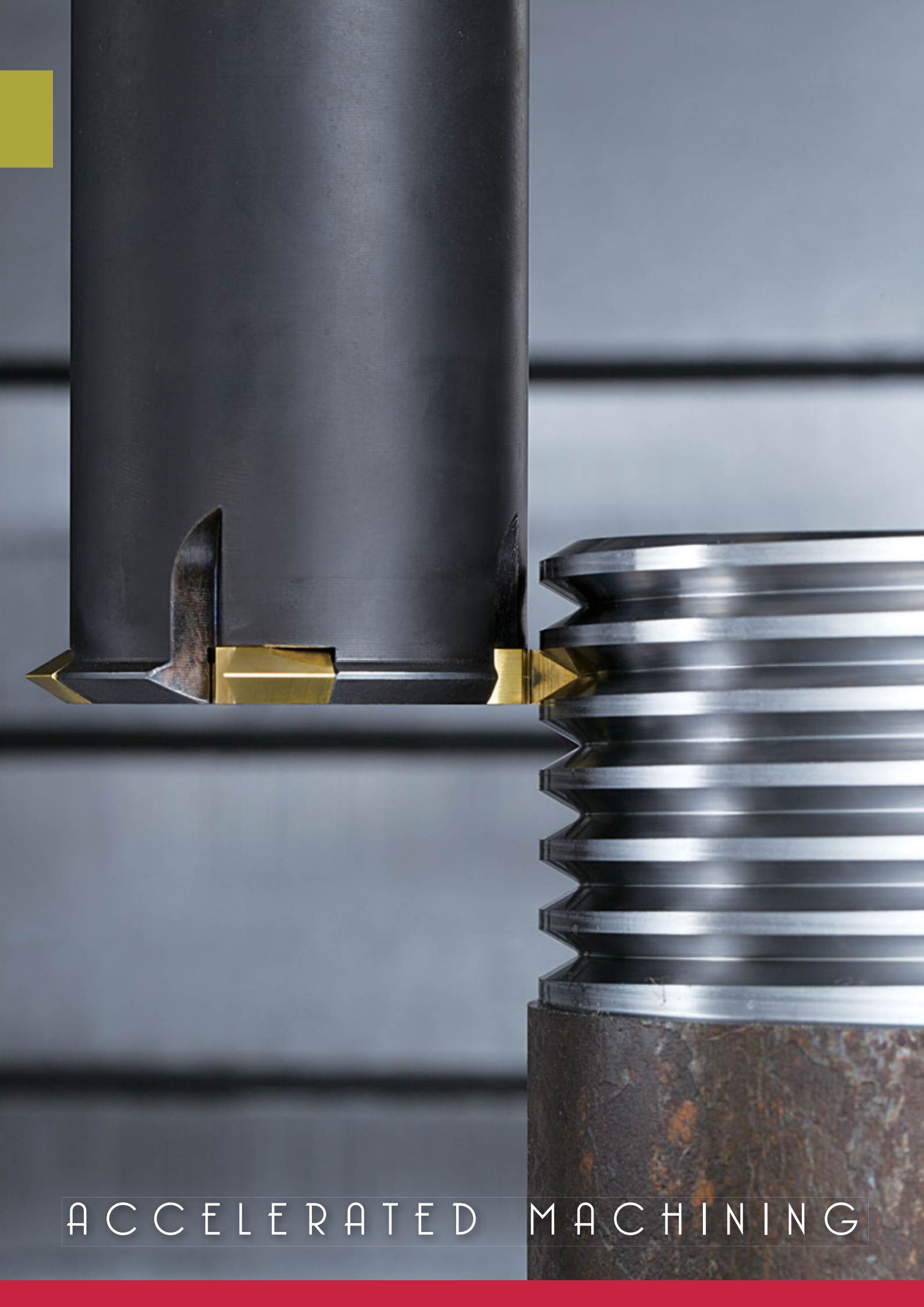
www.tungaloy.com

Tungaloy Report No. 514-G

Now offers indexable ThreadMilling solution



INDUSTRY 4.0
FEED the SPEED!



ACCELERATED MACHINING



Exchangeable inserts cover a wide range of standard taper threads, including R(BSPT external), Rc (BSPT internal), NPT, and NPTF

Thread milling tools

New



Indexable threading mills

p.5

Able to incorporate multiple inserts for various threading diameters and pitches, allowing tool integration and reduced tool cost.



SOLIDTHREAD

p.13

Solid threading tool series for machining small diameters, such as M1x0.25 and 0-80UNF.

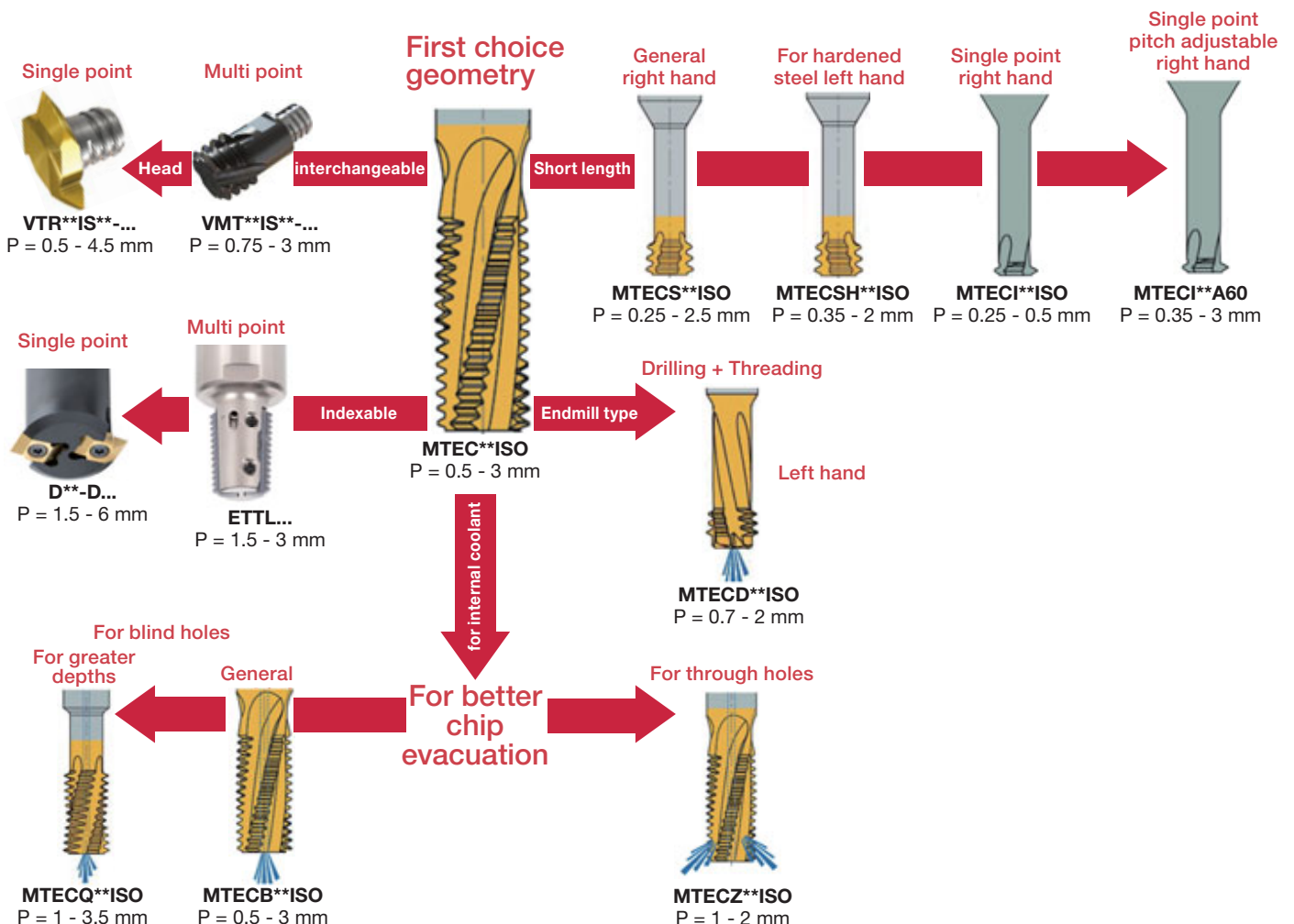


TUNGMEISTER

p.30

Head-changeable milling tool for less down-time than a solid tapping tool.

Tool selection guide for internal ISO metric threads



Indexable threading mills

- Various types of threads can be machined with simple insert changes
- Efficient deep hole threading is possible up to 25 mm deep

For parallel threads

ISO metric

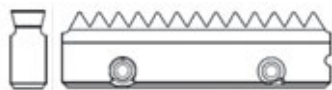
M

Unified

UN,UNC, UNF,UNEF, UNS

Whitworth (parallel pipe threads)

G, BSP, BSF, PF



Double sided insert



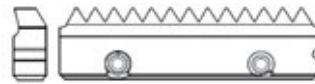
Tapered threads

BSPT

R, Rc, BSPT, PF

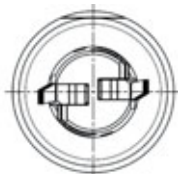
NPT

NPTF

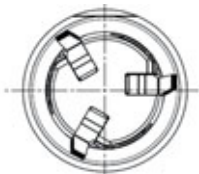


Single sided insert

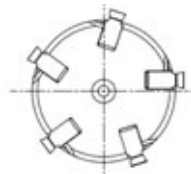
- Multiple-flute tools for increased productivity



2 teeth,
Cutter diameters:
ø17 mm and ø19 mm



3 teeth,
Cutter diameters:
ø20.5 mm and ø22.0 mm



5 teeth,
Cutter diameter:
ø30 mm

- The same inserts can be used for both internal and external threads when machining Whitworth, BSPT, NPT, or NPTF threads as they have an identical internal and external thread profiles.

Internal threads



External threads



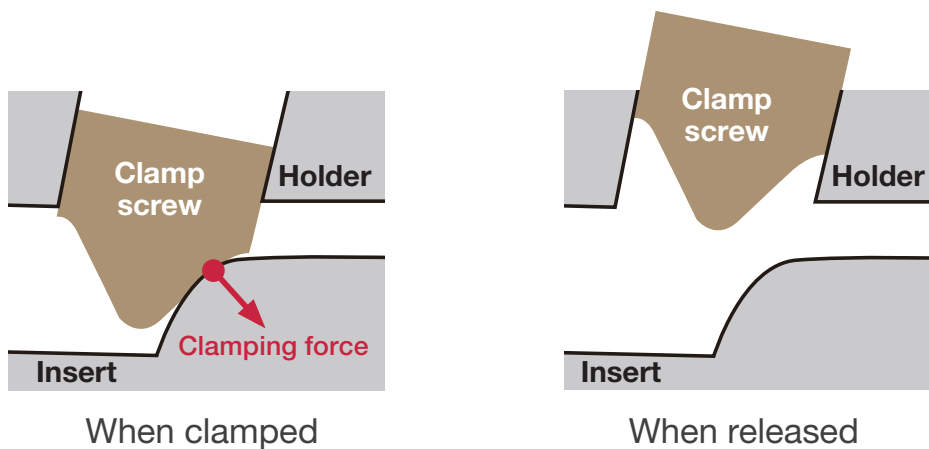
The inserts need to be exchanged for machining internal and external threads of ISO metric or Unified threads due to the thread profiles deviations at the thread bottom.

- Optimized coolant port locations for effective chip evacuation in through holes



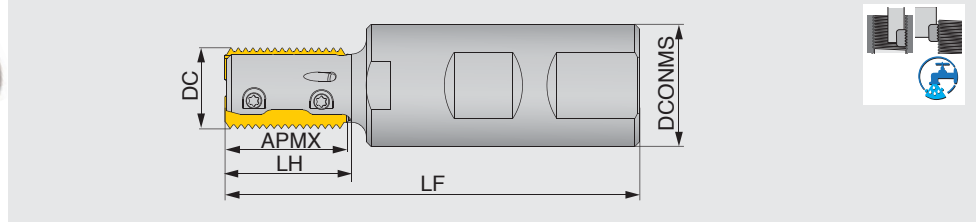
- Chip pocket design is optimized for threading at high feed rates

- Embedded clamping screw design allows for easy and swift insert exchanges



New**Thread milling cutter**

Indexable thread milling cutter, long edge



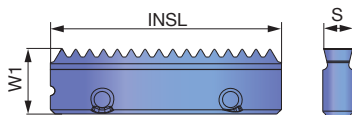
Designation	DC	APMX	CICT	DCONMS	LH	LF	Oil hole	Insert
ETTL25M017W25.0F026R02 ⁽¹⁾	17	25	2	25	26	85	with	TL25D...
ETTL25M017W25.0F036R02 ⁽¹⁾	17	25	2	25	36	95	with	TL25D...
ETTL25M019W25.0F032R02	19	25	2	25	32	92	with	TL25D...
ETTL25M019W25.0F044R02	19	25	2	25	44	104	with	TL25D...
ETTL25M021W25.0F037R03	20.5	25	3	25	37	96	with	TL25D...
ETTL25M021W25.0F044R03	20.5	25	3	25	44	103	with	TL25D...
ETTL25M022W25.0F043R03	22	25	3	25	43	102	with	TL25D...
ETTL25M022W25.0F055R03	22	25	3	25	55	114	with	TL25D...
ETTL25M030W25.0F055R05	30	25	5	25	55	115	with	TL25D...

SPARE PARTS

Designation	Clamping screw	Wrench
ETLN25...	SSTM4-3.6P	T-8D

(1) Inserts with a thread pitch of ≥ 3 mm or ≥ 8 TPI are not mountable**New****INSERTS**

TL25D...



P	Steel	★
M	Stainless	☆
K	Cast iron	☆
N	Non-ferrous	☆
S	Superalloys	★
H	Hard materials	★

★ : First choice
☆ : Second choice

Thread type	Application	Designation	Pitch	Threads per inch	Number of threads per edge	Coated			INSL	W1	S
						AH725					
ISO Metric	Internal	TL25DIR1.5ISO	1.5	-	16	●			25	7	3.1
		TL25DIR2.0ISO	2	-	12	●			25	7	3.1
		TL25DIR3.0ISO ⁽²⁾	3	-	8	●			25	7	3.1
Unified	Internal	TL25DIR20UN	-	20	19	●			25	7	3.1
		TL25DIR12UN	-	12	11	●			25	7	3.1
		TL25DIR9UN	-	9	8	●			25	7	3.1
		TL25DIR8UN ⁽²⁾	-	8	7	●			25	7	3.1
Whitworth	Internal and external	TL25DEIR14W	-	14	13	●			25	7	3.1
		TL25DEIR11W	-	11	10	●			25	7	3.1

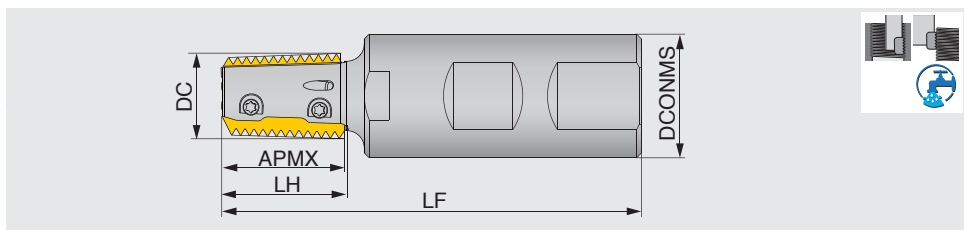
(2) Does not fit the $\phi Dc17$ holder

● : New product

New

Thread milling cutter

Indexable thread milling cutter, long edge



Designation	DC	APMX	CICT	DCONMS	LH	LF	Oil hole	Insert
ETTL25M017W25.0F026R02-PT	17.47	25	2	25	25.5	85	with	TL25SEIR...
ETTL25M022W25.0F043R03-PT	22.2	25	3	25	43	102	with	TL25SEIR...

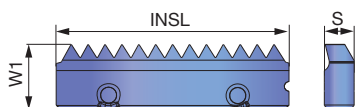
SPARE PARTS

Designation	Clamping screw	Wrench
ETTL...-PT	SSTM4-3.6P	T-8D

New

INSERTS

TL25SEIR...



P	Steel	★
M	Stainless	☆
K	Cast iron	☆
N	Non-ferrous	☆
S	Superalloys	★
H	Hard materials	★

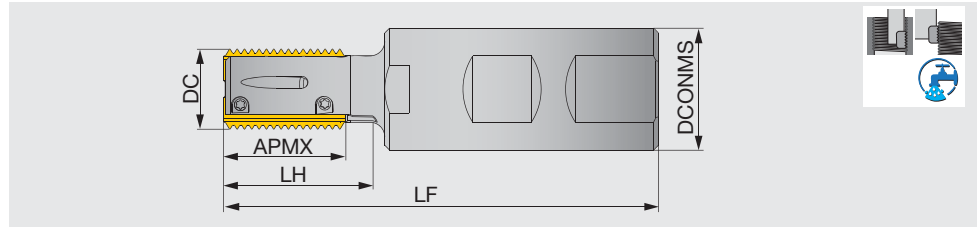
★ : First choice
☆ : Second choice

Thread type	Application	Designation	Pitch	Threads per inch	Number of threads per edge	Coated			INSL	W1	S
						AH725					
BSPT	Internal and external	TL25SEIR14BSPT	-	14	13	●			25	7	3.1
		TL25SEIR11BSPT	-	11	10	●			25	7	3.1
NPT	Internal and external	TL25SEIR14NPT	-	14	13	●			25	7	3.1
		TL25SEIR11.5NPT	-	11.5	11	●			25	7	3.1
NPTF	Internal and external	TL25SEIR14NPTF	-	14	13	●			25	7	3.1

● : New product

Thread milling cutter

Indexable thread milling cutter, long edge



Designation	DC	APMX	CICT	DCONMS	LH	LF	Oil hole	Insert
ETLN25M017W25.0F026R02 ⁽¹⁾	17	25	2	25	26	85	with	LN25....
ETLN25M017W25.0F036R02 ⁽¹⁾	17	25	2	25	36	95	with	LN25....
ETLN25M019W25.0F032R02	19	25	2	25	32	92	with	LN25....
ETLN25M019W25.0F044R02	19	25	2	25	44	104	with	LN25....
ETLN25M021W25.0F037R03	20.5	25	3	25	37	96	with	LN25....
ETLN25M021W25.0F044R03	20.5	25	3	25	44	103	with	LN25....
ETLN25M022W25.0F043R03	22	25	3	25	43	102	with	LN25....
ETLN25M022W25.0F055R03	22	25	3	25	55	114	with	LN25....
ETLN25M030W25.0F055R05	30	25	5	25	55	115	with	LN25....

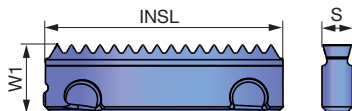
SPARE PARTS

Designation	Clamping screw	Wrench
ETLN25...	SSTM-3-3	T-6F

(1) Inserts with a thread pitch of ≥ 3 mm or ≥ 8 TPI are not moutable

INSERTS

LN25...



P	Steel	★
M	Stainless	☆
K	Cast iron	☆
N	Non-ferrous	☆
S	Superalloys	★
H	Hard materials	★

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Thread type	Application	Designation	Pitch	Threads per inch	Coated			INSL	W1	S
					AH725					
ISO Metric	Internal	LN25DIR1.5ISO	1.5	-	●			25	7	3.1
		LN25DIR2.0ISO	2	-	●			25	7	3.1
		LN25DIR3.0ISO ⁽²⁾	3	-	●			25	7	3.1
Unified	Internal	LN25DIR20UN	-	20	●			25	7	3.1
		LN25DIR12UN	-	12	●			25	7	3.1
		LN25DIR8UN ⁽²⁾	-	8	●			25	7	3.1
whitworth	Internal and external	LN25DEIR14W	-	14	●			25	7	3.1
		LN25DEIR11W	-	11	●			25	7	3.1

(2) Does not fit the $\phi Dc17$ holder

● : Line-up

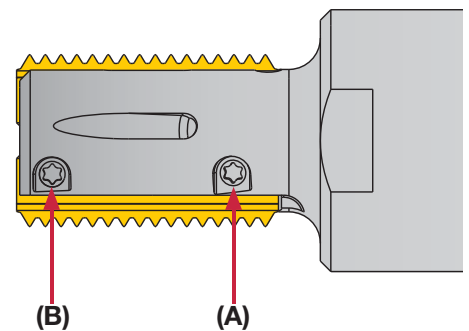
STANDARD CUTTING CONDITIONS

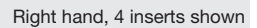
ISO	Workpiece material	Grade	Cutting speed V_c (m/min)	Feed per tooth f_z (mm/t)
P	Low carbon steel	AH725	100 - 200	0.1 - 0.3
	High carbon steel	AH725	70 - 150	0.1 - 0.3
	High carbon steels	AH725	70 - 170	0.1 - 0.3
	Cast steel	AH725	70 - 170	0.1 - 0.3
M	Stainless steel	AH725	90 - 140	0.1 - 0.3
K	Cast iron	AH725	60 - 130	0.05 - 0.3
N	Aluminium alloys	AH725	80 - 400	0.1 - 0.4
S	Heat-resistant alloys	AH725	10 - 30	0.02 - 0.1
	Titanium alloy	AH725	20 - 90	0.02 - 0.1

• Climb milling is recommended.

Insert installation

1. Use airgun or rag to thoroughly clean all the insert pockets free from dust or chips.
2. Lightly tighten Screw "A" first, then Screw "B" until the insert becomes stationary.
3. Lightly tighten the screws for other insert(s) in the same matter as mentioned in #2 above.
4. Firmly tighten Screw "A", then Screw "B".
Use the recommended torque strengths when tightening the screws.
5. Firmly tighten the screws for other insert(s) in the same manner as mentioned in #4 above.
6. Inspect to make sure there is no gap between the insert and the insert seat. Measure the radial runout before use.





STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grade	Cutting speed V _c (m/min)	Feed per tooth f _z (mm/t)
P	Mild steels / Unhardened steels < 200HB	GH330	150 ~ 200	0.3 ~ 0.4
	Carbon steels / Alloy steels < 300HB	GH330	150 ~ 200	0.17 ~ 0.26
	Die steels < 50HRC	GH330	30 ~ 50	0.14 ~ 0.2
M	Stainless steels < 300HB	GH330	150 - 200	0.05 - 0.12

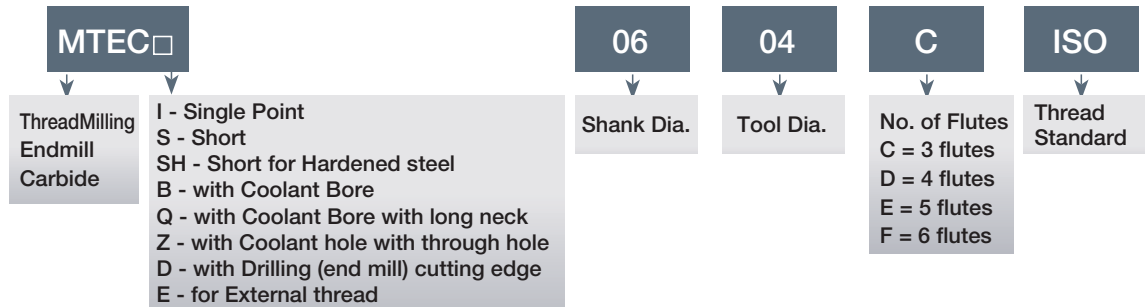
- Climb milling is recommended.
- When threading a blind hole, use a right hand cutter in right-hand rotation. Cut up from the bottom to prevent chip recutting.
- When machining internal threads from the mouth, use the left-hand cutter in left-hand rotation.

THREADING MILLS AND APPLICABLE THREADS

Cutter dia.	Applicable Thread							Minor diameter of max. pitch thread	
	Thread type	Coarse screw thread	Fine screw thread					Coarse screw thread	Fine screw thread
D23 X 1 tooth T1-type of inserts	M28				2	1.5			25.835
	M30	3.5			3	2	1.5	26.211	
D25 X 1 tooth T1-type of inserts	M32				2	1.5			29.835
	M33	3.5			3	2	1.5	29.211	
	M35					1.5			33.376
	M36	4			3	2	1.5	31.670	
	M38					1.5			36.376
	M39	4			3	2	1.5	34.670	
	M40				3	2	1.5		36.752
D38 X 2 teeth T1-type of inserts	M42	4.5		4	3	2	1.5	37.129	
	M45				3	2	1.5		40.152
	M48			4	3	2	1.5		43.670
	M50				3	2	1.5		46.752
	M52			4	3	2	1.5		47.670
	M55			4	3	2	1.5		50.670
	M56			4	3	2	1.5		51.670
D50 X 4 teeth T1-type of inserts	M58			4	3	2	1.5		53.670
	M60			4	3	2	1.5		55.670
	M62			4	3	2	1.5		57.670
	M64			4	3	2	1.5		59.670
	M65			4	3	2	1.5		60.670
	M68			4	3	2	1.5		63.670
D55 X 4 teeth T2-type of inserts	M64			4	3	2	1.5		59.670
	M65			4	3	2	1.5		60.670
	M68	6		4	3	2	1.5	61.505	
D60 X 4 teeth T2-type of inserts	M70			4	3	2	1.5		63.505
	M72		6	4	3	2	1.5		65.505
	M75			4	3	2	1.5		70.670
	M76		6	4	3	2	1.5		69.505
	M78					2			75.835
	M80		6	4	3	2	1.5		73.505
	M82					2			79.835
	M85		6	4	3	2			78.505
D80 X 6 teeth T2-type of inserts	M90		6	4	3	2			83.505
	M95		6	4	3	2			88.505

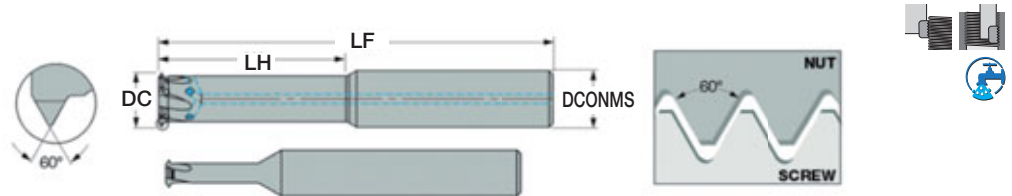
SOLIDTHREAD

Designation System for Solid Carbide Endmills



MTECI-60 (Partical profile)

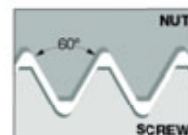
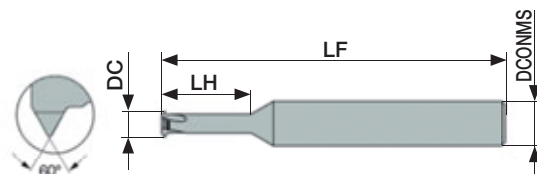
MTECI-A60



Designation	ISO Metric						Unified						DCONMS	DC	NOF	LH	LF	Oil hole	Grade	
	Pitch				Application range		TPI				Application range									
	Internal		External		Fine	Coarse	Internal		External		UNC	UNF								UNS
	min.	max.	min.	max.			min.	max.	min.	max.										
MTECI03019C5A60	0.35	0.6	0.35	0.6	M2.5X0.45	M2.5X0.35, M3X0.35	40	72	40	72	#3-48 #4-40	#3-56 #4-48	-	3	1.9	3	5.2	39	Without AH710	
MTECI06032C9A60	0.5	1.0	0.5	1.0	M4X0.7 M4.5X0.75	M4X0.5	24	48	24	48	#8-32 #10-24	#8-36 #10-32	#10-28	6	3.2	3	9.5	57	Without AH710	
MTECI0604C12A60	0.5	1.0	0.5	1.0	M5X0.8, M6X1.0	M5X0.5, M5.5X0.5 M5X0.75	24	48	24	48	#12-24	#12-28	#10-36 #10-40 #10-48	6	4	3	12.5	58	Without AH710	
MTECI0605D20A60	0.5	0.8	0.4	0.8	≥M6		32	56	32	64	≥M1/4			6	5	4	20	58	With AH725	
MTECI0808D28A60	0.5	0.8	0.4	0.8	≥M9		32	56	32	64	≥M3/8			8	8	4	28	64	With AH725	
MTECI0808D30A60	1.0	1.75	0.8	1.5	≥M10		14	28	16	32	≥M7/16			8	8	4	30	64	With AH725	
MTECI1010D35A60	1.0	1.75	0.8	1.5	≥M12		14	28	16	32	≥M1/2			10	10	4	35	73	With AH725	
MTECI1212E40A60	2.0	3.0	1.75	2.5	≥M16		8	13	10	15	≥M11/16			12	12	5	40	84	With AH725	
MTECI1616E50A60	2.0	3.0	1.75	2.5	≥M20		8	13	10	15	≥M13/16			16	16	5	50	101	With AH725	

ISO metric

MTECI-ISO



Designation	Pitch	Application range	DCONMS	DC	NOF	LH	LF	Oil hole	Grade
MTECI03007C30.25ISO	0.25	≥M1	6	0.72	3	3.6	39	Without	AH710
MTECI03009C40.25ISO	0.25	≥M1.2	6	0.9	3	4.3	39	Without	AH710
MTECI03011C50.3ISO	0.3	≥M1.4	6	1.05	3	5.0	39	Without	AH710
MTECI03012C60.35ISO	0.35	≥M1.6	6	1.2	3	5.7	39	Without	AH710
MTECI03016C70.4ISO	0.4	≥M2	6	1.55	3	7.1	39	Without	AH710
MTECI03024C100.5ISO	0.5	≥M3	6	2.37	3	10.6	39	Without	AH710

ISO metric

MTEC-ISO

Solid Carbide Internal Threading
Endmills for ISO metric Thread Profile

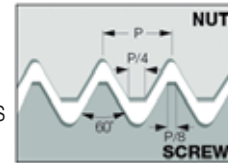
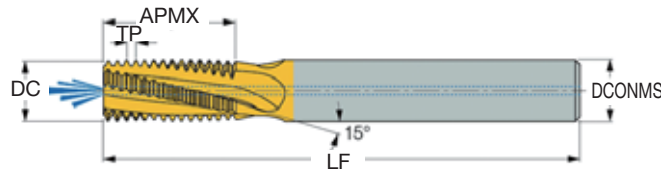


Designation	Pitch	Application range		DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		Fine	Coarse							
MTEC06022C50.5ISO	0.5	M3	≥M4	6	2.2	3	5.3	58	Without	AH725
MTEC06038C100.5ISO	0.5	-	≥M5	6	3.8	3	10.3	58	Without	AH725
MTEC06031C70.7ISO	0.7	M4	≥M5	6	3.1	3	7.4	58	Without	AH725
MTEC06045C100.75ISO	0.75	-	≥M6	6	4.5	3	10	58	Without	AH725
MTEC06036C90.8ISO	0.8	M5	≥M6	6	3.6	3	9.2	58	Without	AH725
MTEC0606C121.0ISO	1	-	≥M9	6	6	3	12.5	58	Without	AH725
MTEC0808D161.0ISO	1	-	≥M10	8	8	4	16.5	64	Without	AH725
MTEC0604C101.0ISO	1	M6	≥M7	6	4	3	10.5	58	Without	AH725
MTEC0604C141.0ISO	1	M6	≥M7	6	4	3	14.5	58	Without	AH725
MTEC0605C141.25ISO	1.25	M8	≥M10	6	5	3	14.4	58	Without	AH725
MTEC0605C191.25ISO	1.25	M8	≥M10	6	5	3	19.4	58	Without	AH725
MTEC1010D211.5ISO	1.5	-	≥M14	10	10	4	21.8	73	Without	AH725
MTEC1616F331.5ISO	1.5	-	≥M20	16	16	6	33.8	105	Without	AH725
MTEC0807C171.5ISO	1.5	M10	≥M12	8	7	3	17.3	64	Without	AH725
MTEC0807C241.5ISO	1.5	M10	≥M12	8	7	3	24.8	76	Without	AH725
MTEC0808C201.75ISO	1.75	M12	≥M14	8	8	3	20.1	64	Without	AH725
MTEC0808C281.75ISO	1.75	M12	≥M14	8	8	3	28.9	76	Without	AH725
MTEC1212D272.0ISO	2	-	≥M18	12	12	4	27	84	Without	AH725
MTEC2020F412.0ISO	2	-	≥M26	20	20	6	41	105	Without	AH725
MTEC1010C272.0ISO	2	M14	≥M17	10	10	3	27	73	Without	AH725
MTEC1010C392.0ISO	2	M14	≥M17	10	10	3	39	105	Without	AH725
MTEC1414D332.5ISO	2.5	M20	≥M22	14	14	4	33.8	84	Without	AH725
MTEC1414D482.5ISO	2.5	M20	≥M22	14	14	4	48.8	105	Without	AH725
MTEC1616C403.0ISO	3	M24	≥M25	16	16	3	40.5	105	Without	AH725
MTEC1616C583.0ISO	3	M24	≥M25	16	16	3	58.5	120	Without	AH725

ISO metric

MTECB-ISO

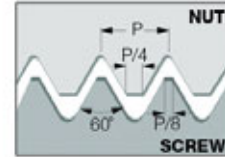
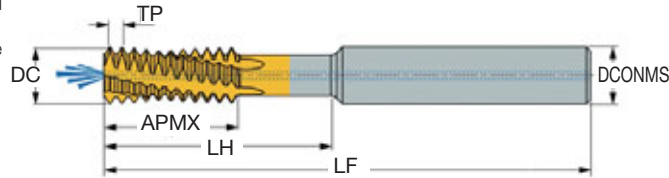
Solid Carbide Internal Threading
Endmills with Coolant Holes
for ISO metric Thread Profile



Designation	Pitch	Application range		DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		Fine	Coarse							
MTECB06038C100.5ISO	0.5	-	≥M5	6	3.8	3	10.3	58	With	AH725
MTECB06031C70.7ISO	0.7	M4	≥M5	6	3.1	3	7.4	58	With	AH725
MTECB06045C100.75ISO	0.75	-	≥M6	6	4.5	3	10.1	58	With	AH725
MTECB1010D240.75ISO	0.75	-	≥M12	10	10	4	24.4	73	With	AH725
MTECB06038C90.8ISO	0.8	M5	≥M6	6	3.8	3	9.2	58	With	AH725
MTECB0606C121.0ISO	1	-	≥M9	6	6	3	12.5	58	With	AH725
MTECB0808D161.0ISO	1	-	≥M10	8	8	4	16.5	64	With	AH725
MTECB1010D241.0ISO	1	-	≥M12	10	10	4	24.5	73	With	AH725
MTECB06046C101.0ISO	1	M6	≥M7	6	4.6	3	10.5	58	With	AH725
MTECB06046C141.0ISO	1	M6	≥M6	6	4.6	3	14.5	58	With	AH725
MTECB0606C141.25ISO	1.25	M8	≥M10	6	6	3	14.4	58	With	AH725
MTECB0606C191.25ISO	1.25	M8	≥M10	6	6	3	19.4	58	With	AH725
MTECB1010D211.5ISO	1.5	-	≥M14	10	10	4	21.8	73	With	AH725
MTECB1616F331.5ISO	1.5	-	≥M20	16	16	6	33.8	105	With	AH725
MTECB1212D261.5ISO	1.5		≥M16	12	12	4	26.3	84	With	AH725
MTECB08078C171.5ISO	1.5	M10	≥M12	8	7.8	3	17	64	With	AH725
MTECB08078C241.5ISO	1.5	M10	≥M12	8	7.8	3	24.8	76	With	AH725
MTECB1009C201.75ISO	1.75	M12	≥M12	10	9	3	20.1	73	With	AH725
MTECB1009C281.75ISO	1.75	M12	≥M12	10	9	3	28.9	73	With	AH725
MTECB1010C272.0ISO	2	M14	≥M15	10	10	3	27	73	With	AH725
MTECB12118D272.0ISO	2	M16	≥M17	12	11.8	4	27	84	With	AH725
MTECB12118D392.0ISO	2	M16	≥M17	12	11.8	4	39	105	With	AH725
MTECB1615E332.5ISO	2.5	M20	≥M22	16	15	5	33.8	105	With	AH725
MTECB1615E482.5ISO	2.5	M20	≥M22	16	15	5	48.8	105	With	AH725
MTECB2018D583.0ISO	3	M24	≥M25	20	18	4	58.5	120	With	AH725

MTECQ-ISO

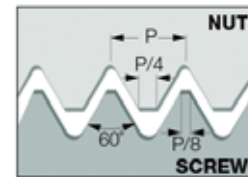
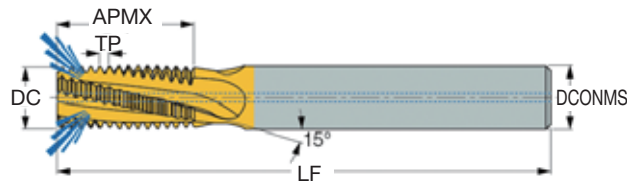
Solid Carbide Threading Endmills with Internal Coolant Holes and a Reduced Diameter Neck for Deep Internal ISO metric Profile



Designation	Pitch	Application range	DCONMS	DC	NOF	APMX	LH	LF	Oil hole	Grade
MTECQ1212D381.0ISO	1	≥M14	12	12	4	21	38	84	With	AH725
MTECQ1010D301.5ISO	1.5	≥M13	10	10	4	18	30	73	With	AH725
MTECQ2020F562.0ISO	2	≥M24	20	20	6	34	56	105	With	AH725
MTECQ2020D453.5ISO	3.5	≥M26	20	20	4	28	45.5	105	With	AH725

MTECZ-ISO

Solid Carbide Internal Threading Endmills with Coolant Holes Located in the Flutes

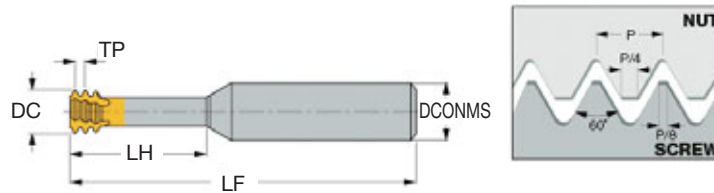


Designation	Pitch	Application range		DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		Fine	Coarse							
MTECZ0808D161.0ISO	1	-	≥M10	8	8	4	16.5	64	With	AH725
MTECZ06048C101.0ISO	1	M6	≥M7	6	4.8	3	10.5	58	With	AH725
MTECZ0606C141.25ISO	1.25	M8	≥M10	6	6	3	14.4	58	With	AH725
MTECZ0606C191.25ISO	1.25	M8	≥M10	6	6	3	19.4	58	With	AH725
MTECZ1010D211.5ISO	1.5	-	≥M14	10	10	4	21.8	73	With	AH725
MTECZ1212D261.5ISO	1.5	-	≥M16	12	12	4	26.3	84	With	AH725
MTECZ1616E331.5ISO	1.5	-	≥M20	16	16	5	33.8	101	With	AH725
MTECZ08078C171.5ISO	1.5	M10	≥M12	8	7.8	3	17	64	With	AH725
MTECZ1009C281.75ISO	1.75	M12	≥M12	10	9	3	28.9	73	With	AH725
MTECZ1010C272.0ISO	2	M14	≥M15	10	10	3	27	73	With	AH725
MTECZ12118D272.0ISO	2	M16	≥M17	12	11.8	4	27	84	With	AH725

ISO metric

MTECS-ISO

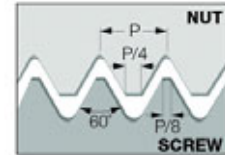
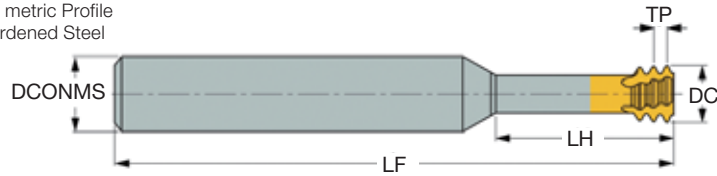
Small Diameter Solid Carbide
Threading Endmills for
Internal ISO metric Profile



Designation	Pitch	Application range		DCONMS	DC	NOF	LH	LF	Oil hole	Grade
		Fine	Coarse							
MTECS03007C20.25ISO	0.25	≥M1		3	0.72	3	2.5	39	Without	AH725
MTECS03009C30.25ISO	0.25	≥M1.2		3	0.9	3	3	39	Without	AH725
MTECS03011C40.3ISO	0.3	≥M1.4		3	1.05	3	4	39	Without	AH725
MTECS03012C50.35ISO	0.35	≥M1.6		3	1.2	3	4.8	39	Without	AH725
MTECS03016C60.4ISO	0.4	≥M2		3	1.53	3	6	39	Without	AH725
MTECS06016C40.4ISO	0.4	≥M2		6	1.53	3	4.5	58	Without	AH725
MTECS03017C70.45ISO	0.45	≥M2.2		3	1.65	3	7	39	Without	AH725
MTECS06017C50.45ISO	0.45	≥M2.2		6	1.65	3	5	58	Without	AH725
MTECS0602C50.45ISO	0.45	≥M2.5		6	1.95	3	5.5	58	Without	AH725
MTECS0602C70.45ISO	0.45	≥M2.5		6	1.95	3	7.5	58	Without	AH725
MTECS06024C60.5ISO	0.5	≥M3		6	2.37	3	6.5	58	Without	AH725
MTECS06024C90.5ISO	0.5	≥M3		6	2.37	3	9.5	58	Without	AH725
MTECS06024C90.5ISOL	0.5	≥M3		6	2.37	3	9.5	105	Without	AH725
MTECS03024C120.5ISO	0.5	≥M3		3	2.4	3	12.5	39	Without	AH725
MTECS03024C150.5ISO	0.5	≥M3		3	2.4	3	15.5	39	Without	AH725
MTECS06054D200.5ISO	0.5	≥M6		6	5.35	4	20	58	Without	AH725
MTECS06028C100.6ISO	0.6	≥M3.5		6	2.75	3	10.5	58	Without	AH725
MTECS06028C70.6ISO	0.6	≥M3.5		6	2.75	3	7.5	58	Without	AH725
MTECS06031C120.7ISO	0.7	≥M4		6	3.1	3	12.5	58	Without	AH725
MTECS06031C120.7ISOL	0.7	≥M4		6	3.1	3	12.5	105	Without	AH725
MTECS06031C160.7ISO	0.7	≥M4		6	3.1	3	16.7	58	Without	AH725
MTECS06031C90.7ISO	0.7	≥M4		6	3.1	3	9	58	Without	AH725
MTECS0808D250.75ISO	0.75	≥M10		8	8	4	25	64	Without	AH725
MTECS06038C120.8ISO	0.8	≥M5		6	3.8	3	12.5	58	Without	AH725
MTECS06038C160.8ISO	0.8	≥M5		6	3.8	3	16	58	Without	AH725
MTECS06038C160.8ISOL	0.8	≥M5		6	3.8	3	16	105	Without	AH725
MTECS06047C141.0ISO	1	≥M6		6	4.65	3	14	58	Without	AH725
MTECS06047C201.0ISO	1	≥M6		6	4.65	3	20	58	Without	AH725
MTECS06047C201.0ISOL	1	≥M6		6	4.65	3	20	105	Without	AH725
MTECS0606C181.25ISO	1.25	≥M8		6	6	3	18	58	Without	AH725
MTECS0606C241.25ISO	1.25	≥M8		6	6	3	24	58	Without	AH725
MTECS08078C231.5ISO	1.5	≥M10		8	7.8	3	23	64	Without	AH725
MTECS08078C311.5ISO	1.5	≥M10		8	7.8	3	31.5	64	Without	AH725
MTECS1009C261.75ISO	1.75	≥M12		10	9	3	26	73	Without	AH725
MTECS12118D352.0ISO	2	≥M16		12	11.8	4	35	84	Without	AH725
MTECS12118D502.0ISO	2	≥M16		12	11.8	4	50	105	Without	AH725
MTECS1615E432.5ISO	2.5	≥M20		16	15	5	43	100	Without	AH725

MTECSH-ISO

Small Diameter Short Left-Hand Cutting
Solid Carbide Internal ISO metric Profile
Threading Endmills for Hardened Steel

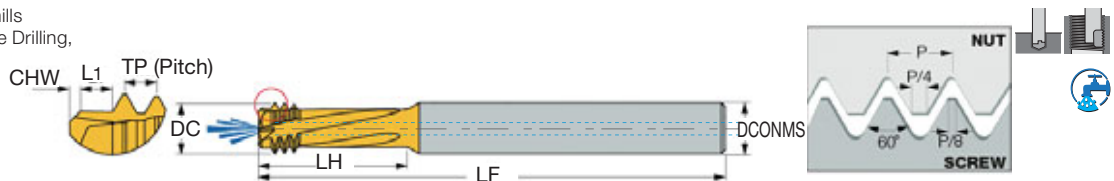


Designation	Pitch	Application range		DCONMS	DC	NOF	LH	LF	Oil hole	Grade
		Fine	Coarse							
MTECSH03012C50.35ISO	0.35	≥M1.6		3	1.2	3	4.8	39	Without	AH750
MTECSH03016C60.4ISO	0.4	≥M2		3	1.55	3	6	39	Without	AH750
MTECSH06016C40.4ISO	0.4	≥M2		6	1.55	3	4.5	58	Without	AH750
MTECSH06017C50.45ISO	0.45	≥M2.2		6	1.65	3	5	58	Without	AH750
MTECSH0602C50.45ISO	0.45	≥M2.5		6	1.95	3	5.5	58	Without	AH750
MTECSH0602C70.45ISO	0.45	≥M2.5		6	1.95	3	7.5	58	Without	AH750
MTECSH06024C60.5ISO	0.5	≥M3		6	2.35	3	6.5	58	Without	AH750
MTECSH06024C90.5ISO	0.5	≥M3		6	2.35	3	9.5	58	Without	AH750
MTECSH06028C70.6ISO	0.6	≥M3.5		6	2.75	3	7.5	58	Without	AH750
MTECSH06031C120.7ISO	0.7	≥M4		6	3.1	3	12.5	58	Without	AH750
MTECSH06038C120.8ISO	0.8	≥M5		6	3.8	3	12.5	58	Without	AH750
MTECSH06047C141.0ISO	1	≥M6		6	4.65	3	14	58	Without	AH750
MTECSH06047C201.0ISO	1	≥M6		6	4.65	3	20	58	Without	AH750
MTECSH0606C181.25ISO	1.25	≥M8		6	5.95	3	18	58	Without	AH750
MTECSH0606C241.25ISO	1.25	≥M8		6	5.95	3	24	58	Without	AH750
MTECSH08078C231.5ISO	1.5	≥M10		8	7.8	3	23	64	Without	AH750
MTECSH1009C261.75ISO	1.75	≥M12		10	9	3	26	73	Without	AH750
MTECSH12118D352.0ISO	2	≥M16		12	11.8	4	35	84	Without	AH750

ISO metric

MTECD-ISO

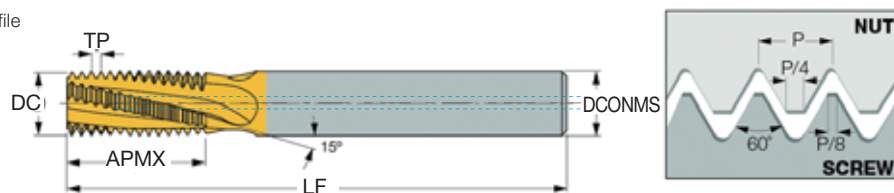
Small Diameter Short Left-Hand
Cutting Solid Carbide Endmills
for Internal ISO metric Profile Drilling,
Threading and Chamfering



Designation	Pitch	Application range	DCONMS	DC	NOF	LH	LF	Ch	L1	Oil hole	Grade
MTECD06032C110.7ISO	0.7	M4	6	3.15	3	11.6	58	0.2	0.7	Without	AH725
MTECD0604C140.8ISO	0.8	M5	6	4	3	14.4	58	0.3	0.8	Without	AH725
MTECD08047C141.0ISO	1	M6-M9	8	4.7	3	14	64	0.4	1	With	AH725
MTECD08061D181.25ISO	1.25	M8-M12	8	6.1	4	18	64	0.5	1.3	With	AH725
MTECD08078D231.5ISO	1.5	M10-M15	8	7.8	4	23	64	0.6	1.5	With	AH725
MTECD1009D261.75ISO	1.75	M12	10	9	4	26	73	0.6	1.8	With	AH725
MTECD12118D352.0ISO	2	M16-M23	12	11.8	4	35	84	0.6	2	With	AH725

MTEC E-ISO

Solid Carbide External Threading
Endmills for ISO metric Thread Profile

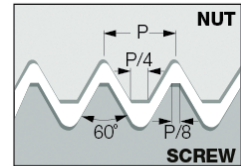
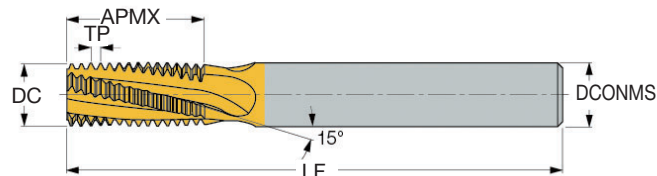


Designation	Pitch	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECE1010D161.0ISO	1	10	10	4	16.5	73	Without	AH725
MTECE1010D161.25ISO	1.25	10	10	4	16.9	73	Without	AH725
MTECE1010D151.5ISO	1.5	10	10	4	15.8	73	Without	AH725
MTECE1212D201.5ISO	1.5	12	12	4	20.3	84	Without	AH725
MTECE1212D201.75ISO	1.75	12	12	4	20.1	84	Without	AH725
MTECE1212D212.0ISO	2	12	12	4	21	84	Without	AH725

Unified

MTEC-UN

Solid Carbide Threading Endmills
for Internal UN Thread Profile

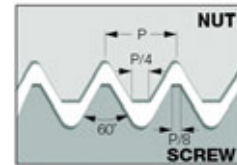
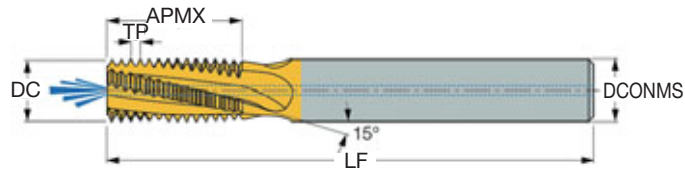


Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		UNC	UNF	UNEF							
MTEC06032C632UN	32	#8	#10	#12	6	3.2	3	6.8	58	Without	AH725
MTEC0604C1128UN	28	-	1/4	-	6	4	3	11.3	58	Without	AH725
MTEC0606C1428UN	28	-	-	7/16-1/2	6	6	3	14.5	58	Without	AH725
MTEC0605C1424UN	24	-	5/16	-	6	5	3	14.3	58	Without	AH725
MTEC0807C2124UN	24	-	3/8	9/16-5/8	8	7	3	20	64	Without	AH725
MTEC06045C1220UN	20	1/4	-	-	6	4.5	3	12.1	58	Without	AH725
MTEC0807C2120UN	20	-	7/16-1/2	-	8	7	3	20	64	Without	AH725
MTEC1212E2720UN	20	-	-	3/4-1	12	12	5	27.3	84	Without	AH725
MTEC0605C1418UN	18	5/16	-	-	6	5	3	14.8	58	Without	AH725
MTEC1010D2618UN	18	-	9/16-5/8	1 1/8-1 5/8	10	10	4	26.1	73	Without	AH725
MTEC0606C1616UN	16	3/8	-	-	6	6	3	16.7	58	Without	AH725
MTEC1212D3116UN	16	-	3/4	-	12	12	4	30	84	Without	AH725
MTEC1615E3714UN	14	-	7/8	-	16	15	5	37.2	105	Without	AH725
MTEC0808C2213UN	13	1/2	-	-	8	8	3	22.5	64	Without	AH725
MTEC1010C2612UN	12	9/16	-	-	10	10	3	26.5	73	Without	AH725
MTEC1616E4112UN	12	-	1-1 1/2	-	16	16	5	41.3	105	Without	AH725
MTEC1010C2811UN	11	5/8	-	-	10	10	3	28.9	73	Without	AH725
MTEC1212C3410UN	10	3/4	-	-	12	12	3	34.3	84	Without	AH725
MTEC1615C389UN	9	7/8	-	-	16	15	3	38.1	105	Without	AH725
MTEC1616C428UN	8	1	-	-	16	16	3	42.9	105	Without	AH725

Unified

MTECB-UN

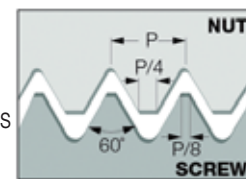
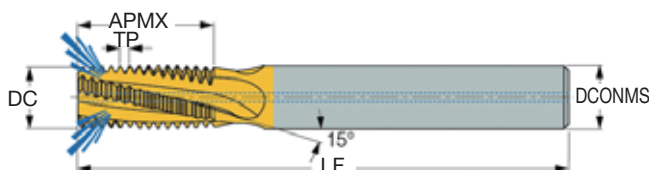
Solid Carbide Threading
Endmills with Coolant Holes for
Internal UN Thread Profile



Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		UNC	UNF	UNEF							
MTECB06032C632UN	32	#8	#10	#12	6	3.2	3	6.8	58	With	AH725
MTECB0606C1432UN	32	-	-	7/16-1/2	6	6	3	16	58	With	AH725
MTECB0605C1128UN	28	-	1/4	-	6	5	3	11.3	58	With	AH725
MTECB08066C1424UN	24	-	5/16	-	8	6.6	3	14.3	64	With	AH725
MTECB0808D2124UN	24	-	-	9/16-5/8	8	8	4	20.6	64	With	AH725
MTECB0808C2120UN	20	-	7/16	-	8	8	3	21	64	With	AH725
MTECB1010D2220UN	20	-	1/2	-	10	10	4	22.3	73	With	AH725
MTECB06056C1418UN	18	5/16	-	-	6	5.6	3	14.8	58	With	AH725
MTECB12113D2618UN	18	-	9/16-5/8	1 1/8-1 5/8	12	11.3	4	26.1	84	With	AH725
MTECB08067C1616UN	16	3/8	-	-	8	6.7	3	16.7	64	With	AH725
MTECB1212D3116UN	16	-	3/4	-	12	12	4	31	84	With	AH725
MTECB1616E3714UN	14	-	7/8	-	16	16	5	37.2	105	With	AH725
MTECB10092C2213UN	13	1/2	-	-	10	9.2	3	22.5	73	With	AH725
MTECB12114C2811UN	11	5/8	-	-	12	11.4	3	28.9	84	With	AH725
MTECB16144D3410UN	10	3/4	-	-	16	14.4	4	34.3	105	With	AH725
MTECB20195D428UN	8	1	-	-	20	19.5	4	42.9	105	With	AH725

MTECZ-UN

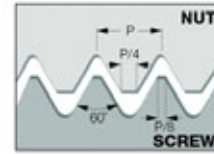
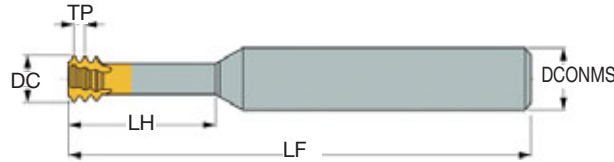
Solid Carbide Threading Endmills
with Coolant Holes Located in the
Flutes for Internal UN Thread Profile



Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		UNC	UNF	UNEF							
MTECZ1010D2220UN	20	-	1/2	-	10	10	4	22.3	73	With	AH725
MTECZ12113D2618UN	18	-	9/16-5/8	1 1/8-1 5/8	12	11.3	4	26.1	84	With	AH725
MTECZ08067C1616UN	16	3/8	-	-	8	6.7	3	16.7	64	With	AH725
MTECZ16144D3410UN	10	3/4	-	-	16	14.4	4	34.3	101	With	AH725

MTECS-UN

Small Diameter Solid Carbide UN
Profile Threading Endmills for Steel

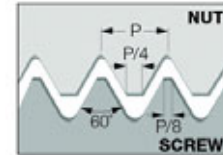
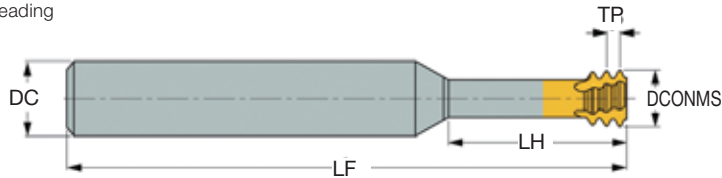


Designation	TPI	Application range		DCONMS	DC	NOF	LH	LF	Oil hole	Grade
		UNC	UNF							
MTECS03012C880UN	80	-	#0	3	1.15	3	8	39	Without	AH725
MTECS03015C672UN	72	-	#1	3	1.45	3	6	39	Without	AH725
MTECS06016C656UN	56	#2	#3	6	1.65	3	6.6	58	Without	AH725
MTECS06016C456UN	56	#2	#3	6	1.65	3	4.4	58	Without	AH725
MTECS06019C548UN	48	#3	#4	6	1.9	3	5.2	58	Without	AH725
MTECS03021C1240UN	40	#4	-	3	2.1	3	12	39	Without	AH725
MTECS06021C840UN	40	#4	-	6	2.1	3	8	58	Without	AH725
MTECS06024C940UN	40	#5	#6	6	2.45	3	9.6	58	Without	AH725
MTECS06021C640UN	40	#4	-	6	2.1	3	6.3	58	Without	AH725
MTECS06033C936UN	36	-	#8	6	3.3	3	9	58	Without	AH725
MTECS06025C732UN	32	#6	-	6	2.55	3	7.1	58	Without	AH725
MTECS06025C1032UN	32	#6	-	6	2.55	3	10.5	58	Without	AH725
MTECS06032C932UN	32	#8	#10	6	3.2	3	9.5	58	Without	AH725
MTECS06032C1232UN	32	#8	#10	6	3.2	3	12.5	58	Without	AH725
MTECS06037C1032UN	32	-	#10	6	3.7	3	10.5	58	Without	AH725
MTECS06037C1532UN	32	-	#10	6	3.7	3	15	58	Without	AH725
MTECS0605C1428UN	28	-	1/4	6	5	3	14.5	58	Without	AH725
MTECS0605C1928UN	28	-	1/4	6	5	3	19	58	Without	AH725
MTECS08066C1724UN	24	-	5/16	8	6.6	3	17	64	Without	AH725
MTECS08066C2424UN	24	-	5/16	8	6.6	3	24	64	Without	AH725
MTECS06047C1420UN	20	1/4	-	6	4.75	3	14	58	Without	AH725
MTECS06047C1920UN	20	1/4	-	6	4.75	3	19	58	Without	AH725
MTECS06047C1920UN-L	20	1/4	-	6	4.75	3	19	105	Without	AH725
MTECS0808C2520UN	20	-	7/16	8	8	3	25	64	Without	AH725
MTECS0606C1718UN	18	5/16	-	6	6	3	17	58	Without	AH725
MTECS0606C2318UN	18	5/16	-	6	6	3	23	58	Without	AH725
MTECS1212D3518UN	18	-	5/8	12	12	4	35	84	Without	AH725
MTECS08067C2216UN	16	3/8	-	8	6.7	3	22	64	Without	AH725
MTECS08067C3016UN	16	3/8	-	8	6.7	3	30.2	64	Without	AH725
MTECS08077C2514UN	14	7/16	-	8	7.7	3	25	64	Without	AH725
MTECS10092C2713UN	13	1/2	-	10	9.2	3	27.5	73	Without	AH725
MTECS12114C3411UN	11	5/8	-	12	11.4	3	34.5	84	Without	AH725
MTECS12114C5011UN	11	5/8	-	12	11.4	3	50	105	Without	AH725

Unified

MTECSH-UN

Small Diameter Short Left-Hand Cutting
Solid Carbide UN Profile Threading
Endmills for Hardened Steel



Designation	TPI	Application range		DCONMS	DC	NOF	LH	LF	Oil hole	Grade
		UNC	UNF							
MTECSH06012C480UN	80	-	#0	6	1.15	3	4	58	Without	AH725
MTECSH06016C656UN	56	#2	#3	6	1.65	3	6.6	58	Without	AH725
MTECSH06019C548UN	48	#3	#4	6	1.9	3	5.2	58	Without	AH725
MTECSH06021C640UN	40	#4	-	6	2.1	3	6.3	58	Without	AH725
MTECSH06024C740UN	40	#5	#6	6	2.45	3	7	58	Without	AH725
MTECSH06021C840UN	40	#4	-	6	2.1	3	8	58	Without	AH725
MTECSH06024C940UN	40	#5	#6	6	2.45	3	9.6	58	Without	AH725
MTECSH06025C1032UN	32	#6	-	6	2.55	3	10.5	58	Without	AH725
MTECSH06032C932UN	32	#8	-	6	3.2	3	9.5	58	Without	AH725
MTECSH06037C1032UN	32	-	#10	6	3.7	3	10.5	58	Without	AH725
MTECSH06037C1532UN	32	-	#10	6	3.7	3	15	58	Without	AH725
MTECSH06042C1128UN	28	-	#12	6	4.2	3	11	58	Without	AH725
MTECSH0605C1428UN	28	-	1/4	6	5	3	14.5	58	Without	AH725
MTECSH06035C1024UN	24	#10-#12	-	6	3.5	3	10.6	58	Without	AH725
MTECSH08066C1724UN	24	-	5/16	8	6.6	3	17	64	Without	AH725
MTECSH08066C2424UN	24	-	5/16	8	6.6	3	24	64	Without	AH725
MTECSH06047C1920UN	20	1/4	-	6	4.75	3	19	58	Without	AH725
MTECSH0808C2520UN	20	-	7/16	8	8	3	25	64	Without	AH725
MTECSH0606C1718UN	18	5/16	-	6	6	3	17	58	Without	AH725
MTECSH0606C2318UN	18	5/16	-	6	6	3	23	58	Without	AH725
MTECSH08067C2216UN	16	3/8	-	8	6.7	3	22	64	Without	AH725
MTECSH08077C2514UN	14	7/16	-	8	7.7	3	25	64	Without	AH725
MTECSH10092C2713UN	13	1/2	-	10	9.2	3	27.5	73	Without	AH725
MTECSH12114C3411UN	11	5/8	-	12	11.4	3	34.5	84	Without	AH725

MTEC E-UN

Solid Carbide Threading Endmills with
UN Form for External Threading

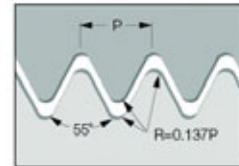
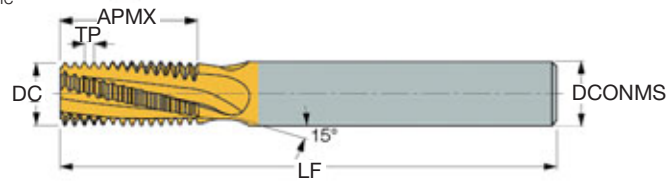


Designation	TPI	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECE1010D1624UN	24	10	10	4	16.4	73	Without	AH725
MTECE1212E2120UN	20	12	12	5	21	84	Without	AH725

Whitworth

MTEC-W

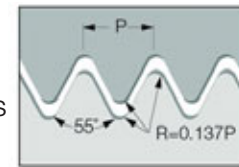
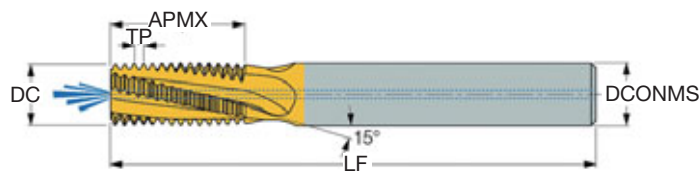
Solid Carbide Threading Endmills for Internal or External BSP Thread Profile



Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTEC0606C928W	28	1/8	6	6	3	9.5	58	Without	AH725
MTEC0808C1419W	19	1/4-3/8	8	8	3	14	64	Without	AH725
MTEC1212D1914W	14	1/2-7/8	12	12	4	19.3	84	Without	AH725
MTEC1212D2614W	14	1/2-7/8	12	12	4	26.3	84	Without	AH725
MTEC1212C2411W	11	1-1 1/2	12	12	3	24.2	84	Without	AH725
MTEC1616D3811W	11	1-3	16	16	4	38.1	105	Without	AH725

MTECB-W

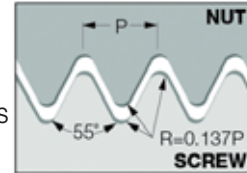
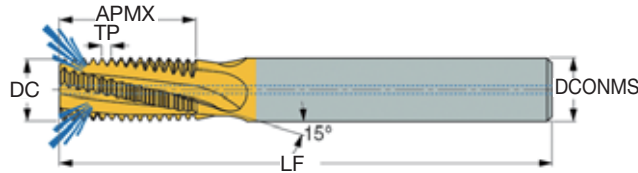
Solid Carbide Internal or External Threading Endmills with Coolant Holes for BSP Thread Profile



Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECB08078C1428W	28	1/8	8	7.8	3	14.1	64	With	AH725
MTECB1010D1619W	19	1/4-3/8	10	10	4	16.7	73	With	AH725
MTECB1616E2614W	14	1/2-7/8	16	16	5	26.3	105	With	AH725
MTECB1616D3811W	11	≥1	16	16	4	38.1	105	With	AH725
MTECB2020E4711W	11	≥1	20	20	5	47.3	105	With	AH725

MTECZ-W

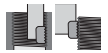
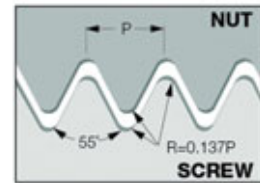
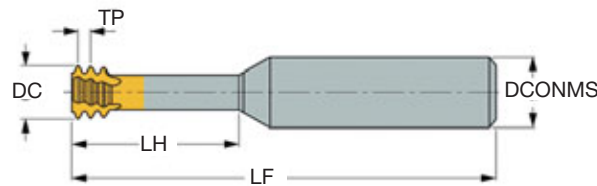
Solid Carbide Threading Endmills with Coolant Holes Located in the Flutes for Internal or External BSF/BSP Thread



Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECZ08078C1428W	28	1/8	8	7.8	3	14.1	64	With	AH725
MTECZ1010D1619W	19	1/4-3/8	10	10	4	16.7	73	With	AH725
MTECZ1616E2614W	14	1/2-7/8	16	16	5	26.3	101	With	AH725

MTECS-W

Short Solid Carbide Threading Endmills for Internal or External BSP and BSF Thread Profiles

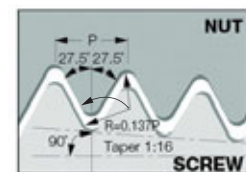
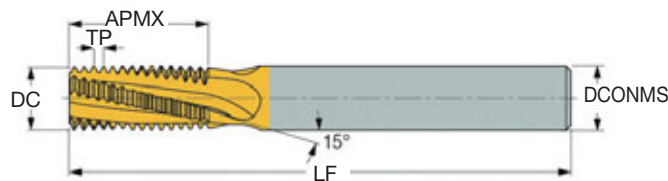


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECS08078C1928W	28	1/8	8	7.8	3	19.5	64	Without	AH725
MTECS1010D3019W	19	1/4-3/8	10	10	4	30	73	Without	AH725
MTECS1212D3714W	14	1/2-7/8	12	12	4	37	84	Without	AH725

BSPT

MTEC-BSPT

Solid Carbide Threading Endmills for External or Internal BSPT Thread Profile

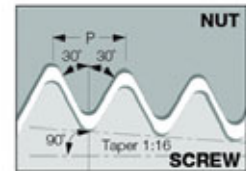
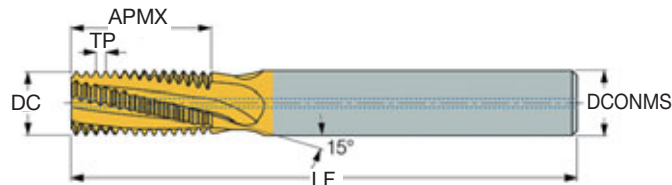


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTEC0606C928BSPT	28	1/8	6	6	3	9.5	58	Without	AH725
MTEC0808C1419BSPT	19	1/4-3/8	8	8	3	14	64	Without	AH725
MTEC1212D1914BSPT	14	1/2-7/8	12	12	4	19.1	84	Without	AH725
MTEC1616D2811BSPT	11	1-2	16	16	4	28.9	105	Without	AH725

NPT

MTEC-NPT

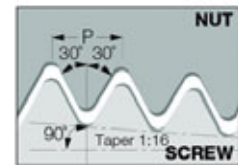
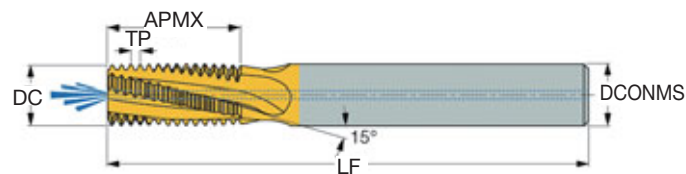
Solid Carbide Threading Endmill without Coolant Holes for Internal or External NPT Threads



Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTEC0606C927NPT	27	1/16-1/8	6	6	3	9.9	58	Without	AH725
MTEC0808C1418NPT	18	1/4-3/8	8	8	3	14.8	64	Without	AH725
MTEC1212D2014NPT	14	1/2-3/4	12	12	4	20.9	84	Without	AH725
MTEC1616D2711.5NPT	11.5	1-2	16	16	4	27.6	105	Without	AH725
MTEC2020D398NPT	8	≥2 1/2	20	20	4	39.7	105	Without	AH725

MTECB-NPT

Solid Carbide Threading Endmill with a Coolant Hole Internal or External NPT Threads

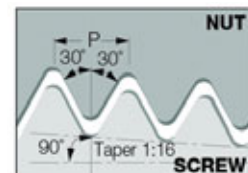
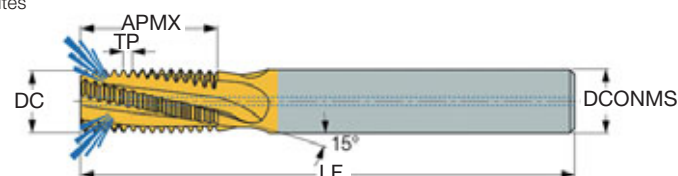


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECB08076C1027NPT	27	1/8	8	7.6	3	10.8	64	With	AH725
MTECB1010D1618NPT	18	1/4-3/8	10	10	4	16.2	73	With	AH725
MTECB16155D2214NPT	14	1/2-3/4	16	15.5	4	22.7	105	With	AH725

NPTF

MTECZ-NPTF

Solid Carbide Threading Endmill with Coolant Holes located in the Flutes Internal or External NPTF Threads

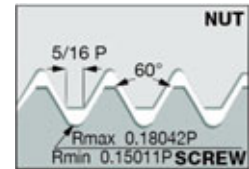
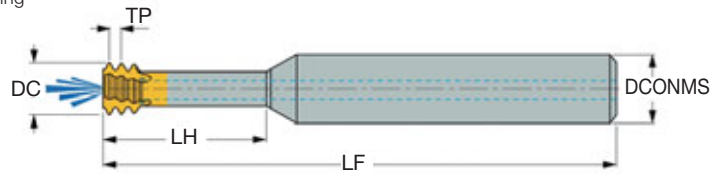


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECZ08076C1027NPTF	27	1/8	8	7.6	3	10.8	64	With	AH725
MTECZ1010D1618NPTF	18	1/4-3/8	10	10	4	16.2	73	With	AH725

MJ

MTECS-MJ

Small Diameter Short Solid Carbide
Internal MJ-Type Profile Threading
Endmills

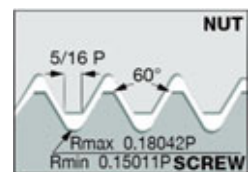
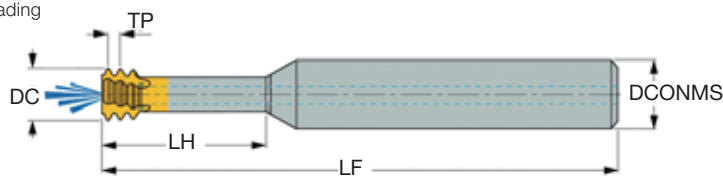


Designation	Pitch	Application range	DCONMS	DC	NOF	LH	LF	Oil hole	Grade
MTECS06032C100.7MJ	0.7	4	6	3.2	3	10	58	Without	AH725
MTECS06039C120.8MJ	0.8	5	6	3.9	3	12.5	58	Without	AH725
MTECS06048C151.0MJ	1	6	6	4.8	3	15	58	Without	AH725
MTECS08061C201.25MJ	1.25	8	8	6.1	3	20	64	With	AH725
MTECS0808C251.5MJ	1.5	10	8	8	3	25	64	With	AH725
MTECS10092C301.75MJ	1.75	12	10	9.2	3	30	73	With	AH725
MTECS1010C352.0MJ	2	14, 16	10	10	3	35	73	With	AH725

UNJ

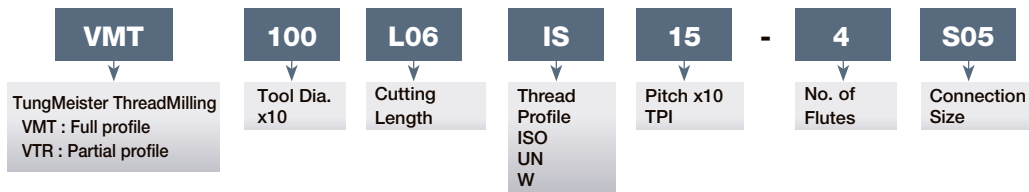
MTECS-UNJ

Small Diameter Short Solid Carbide
Internal UNJ-Type Profile Threading
Endmills



Designation	TPI	Application range		DCONMS	DC	NOF	LH	LF	Oil hole	Grade
		UNJC	UNJF							
MTECS06033C1032UNJ	32	8	10	6	3.3	3	10.5	58	Without	AH725
MTECS08051C1628UNJ	28	-	1/4	8	5.1	3	16	64	With	AH725
MTECS08067C2024UNJ	24	-	5/16, 3/8	8	6.7	3	20	64	With	AH725
MTECS06049C1620UNJ	20	1/4	-	6	4.9	3	16	58	Without	AH725
MTECS0808C2820UNJ	20	-	7/16	8	8	3	28	64	With	AH725
MTECS08061C2018UNJ	18	5/16	9/16	8	6.15	3	20	64	With	AH725
MTECS08069C2416UNJ	16	3/8	-	8	6.9	3	24	64	With	AH725
MTECS10094C2713UNJ	13	1/2	-	10	9.4	3	27.5	73	With	AH725

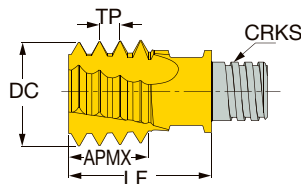
Designation System for TungMeister



ISO metric

VMT***IS

Carbide Milling Heads with a Threaded Connection for Internal ISO Metric Thread

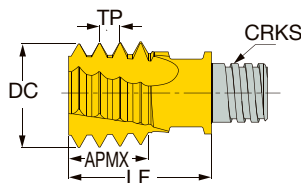


Designation	Pitch	Application range		DC	NOF	APMX	LF	CRKS	Grade	Wrench
		Fine	Coarse							
VMT100L06IS07-4S05	0.75	-	≥M12	10	4	6	12.8	S05	AH725	KEYV-S05
VMT100L06IS10-4S05	1	-	≥M12	10	4	6	12.8	S05	AH725	KEYV-S05
VMT100L06IS15-4S05	1.5	-	≥M14	10	4	6	12.8	S05	AH725	KEYV-S05
VMT120L08IS15-4S06	1.5	-	≥M16	12	4	7.6	14.3	S06	AH725	KEYV-S06
VMT120L08IS20-4S06	2	M16	≥M17	12	4	8	14.3	S06	AH725	KEYV-S06
VMT160L12IS15-6S08	1.5	-	≥M20	16	6	12	19	S08	AH725	KEYV-T30L
VMT160L12IS20-5S08	2	-	≥M19	16	5	12	19	S08	AH725	KEYV-T30L
VMT154L13IS25-5S08	2.5	M20	≥M22	15.4	5	12.7	20	S08	AH725	KEYV-S08
VMT160L12IS30-3S08	3	M24	≥M25	16	3	12	19	S08	AH725	KEYV-T30L

Unified

VMT***UN

Carbide Milling Heads with a Threaded Connection for Internal UN Thread Profile

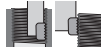
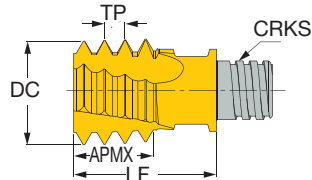


Designation	TPI	Application range			DC	NOF	APMX	LF	CRKS	Grade	Wrench
		UNC	UNF	UNFF							
VMT100L06UN24-4S05	24	-	-	9/16-5/8	10	4	5.3	12.8	S05	AH725	KEYV-S05
VMT100L06UN20-4S05	20	-	1/2	-	10	4	5.1	12.8	S05	AH725	KEYV-S05
VMT120L08UN16-4S06	16	-	3/4	-	12	4	8	14.3	S06	AH725	KEYV-S06
VMT120L10UN14-4S06	14	-	7/8	-	12	4	9	14.3	S06	AH725	KEYV-T25
VMT160L13UN12-5S08	12	-	1-1 1/2	-	16	5	12.7	19	S08	AH725	KEYV-T30L
VMT150L13UN10-4S08	10	3/4	-	-	15.4	4	12.7	19	S08	AH725	KEYV-T30L
VMT160L11UN09-3S08	9	7/8	-	-	16	3	11.3	19	S08	AH725	KEYV-T30L
VMT160L13UN08-3S08	8	1	-	-	16	3	12.7	20	S08	AH725	KEYV-S08

Whitworth

VMT***W

Carbide Milling Heads with a Threaded Connection for Internal and External 55° BSP Thread Profile

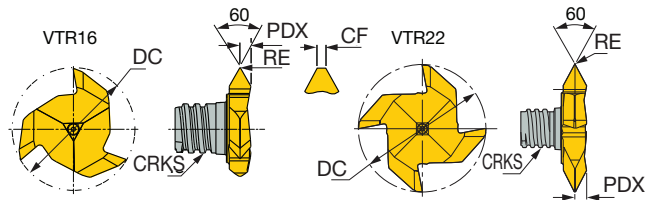


Designation	TPI	Application range	DC	NOF	APMX	LF	CRKS	Grade	Wrench
VMT100L06W19-4S05	19	1/4 - 3/8	10	4	5.3	12.8	S05	AH725	KEYV-S05
VMT160L13W14-4S08	14	1/2 - 7/8	16	4	12.7	20	S08	AH725	KEYV-S08
VMT160L11W11-4S08	11	≥1	16	4	11.6	19	S08	AH725	KEYV-T30L

60° partial profile

VTR***IS

Interchangeable Solid Carbide Milling Head with Threaded Connection for Internal or External 60° Partial Profile Thread Milling

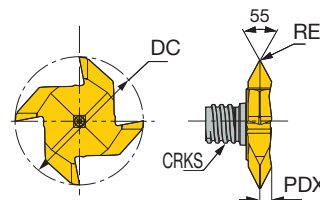


Designation	Pitch		Smallest Possible thread	DC	RE	CF	PDX	NOF	CRKS	Grade	Wrench
	P min	P max									
VTR160L12IS05-3S06	0.5	2	M20	15.7	-	0.05	1.4	3	S06	GH130	KEYV-177
VTR160L12IS15-3S06	1.5	2	M22	15.7	0.05	-	1.4	3	S06	GH130	KEYV-177
VTR220L28IS30-4S08	3	4.5	M36	21.7	0.2	-	2.8	4	S08	GH130	KEYV-217

55° partial profile

VTR***W

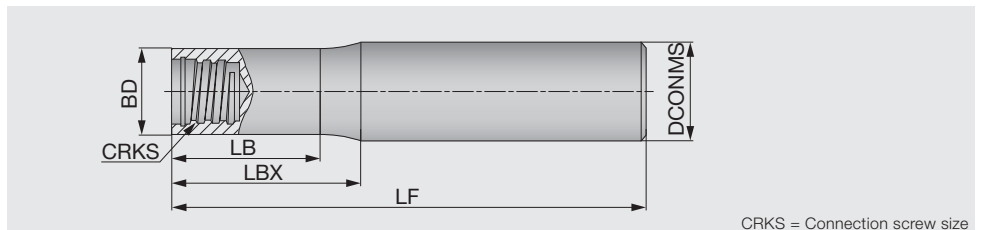
Interchangeable Solid Carbide Milling Head with Threaded Connection for Internal or External 55° Partial Profile Thread Milling



Designation	TPI		Smallest Possible thread	DC	RE	PDX	NOF	CRKS	Grade	Wrench
	TPI max	TPI min								
VTR220L24W14-4S08	14	11	3/4	21.7	0.2	2.4	4	S08	GH130	KEYV-217

VSSD...

TungMeister, straight neck and cylindrical shank

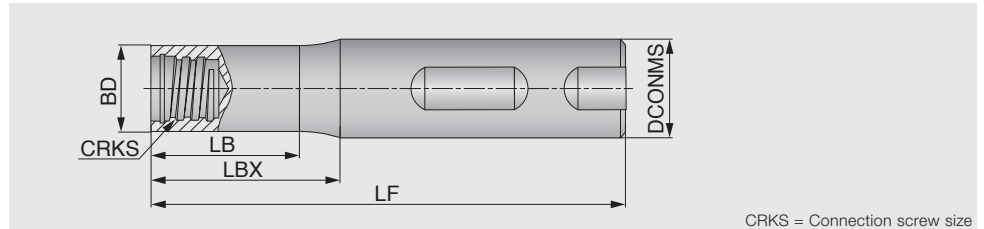


CRKS = Connection screw size

Designation	DCONMS	BD	LF	LBX	LB	CRKS	Type	Material
VSSD08L060S05-S	8	7.6	60	15	12.80	S05	CYLINDRICAL	STEEL
VSSD08L070S05-C	8	7.6	70	20	19	S05	CYLINDRICAL	CARBIDE
VSSD08L090S05-C	8	7.6	90	40	39	S05	CYLINDRICAL	CARBIDE
VSSD08L110S05-C	8	7.6	110	60	59	S05	CYLINDRICAL	CARBIDE
VSSD10L070S06-C	10	9.6	70	20	18.5	S06	CYLINDRICAL	CARBIDE
VSSD10L075S06-S	10	9.6	75	20	17.7	S06	CYLINDRICAL	STEEL
VSSD10L090S06-C	10	9.6	90	40	38.5	S06	CYLINDRICAL	CARBIDE
VSSD10L110S06-C	10	9.6	110	60	58.5	S06	CYLINDRICAL	CARBIDE
VSSD10L150S06-C	10	9.6	150	100	98.5	S06	CYLINDRICAL	CARBIDE
VSSD12L070S08-C	12	11.5	70	20	17	S08	CYLINDRICAL	CARBIDE
VSSD12L090S08-C	12	11.5	90	40	37	S08	CYLINDRICAL	CARBIDE
VSSD12L090S08-S	12	11.5	90	16	13.6	S08	CYLINDRICAL	STEEL
VSSD12L110S08-C	12	11.5	110	60	57	S08	CYLINDRICAL	CARBIDE
VSSD12L130S08-C	12	11.5	130	80	77	S08	CYLINDRICAL	CARBIDE
VSSD16L090S10-C	16	15.2	90	40	38	S10	CYLINDRICAL	CARBIDE
VSSD16L100S10-S	16	15.2	100	20	18	S10	CYLINDRICAL	STEEL
VSSD16L110S10-C	16	15.2	110	60	58	S10	CYLINDRICAL	CARBIDE
VSSD16L130S10-C	16	15.2	130	80	78	S10	CYLINDRICAL	CARBIDE
VSSD16L150S10-C	16	15.2	150	100	98	S10	CYLINDRICAL	CARBIDE
VSSD20L090S12-C	20	18.3	90	40	37	S12	CYLINDRICAL	CARBIDE
VSSD20L120S12-S	20	18.3	120	25	20.5	S12	CYLINDRICAL	STEEL
VSSD20L130S12-C	20	18.3	130	80	77	S12	CYLINDRICAL	CARBIDE
VSSD20L200S12-C	20	18.3	200	120	117	S12	CYLINDRICAL	CARBIDE
VSSD25L120S15-C	25	23.9	120	60	58	S15	CYLINDRICAL	CARBIDE
VSSD25L135S15-S	25	23.9	135	35	33	S15	CYLINDRICAL	STEEL
VSSD25L170S15-C	25	23.9	170	100	98	S15	CYLINDRICAL	CARBIDE
VSSD25L250S15-C	25	23.9	250	150	148	S15	CYLINDRICAL	CARBIDE

VSSD**W...

TungMeister, straight neck and weldon shank

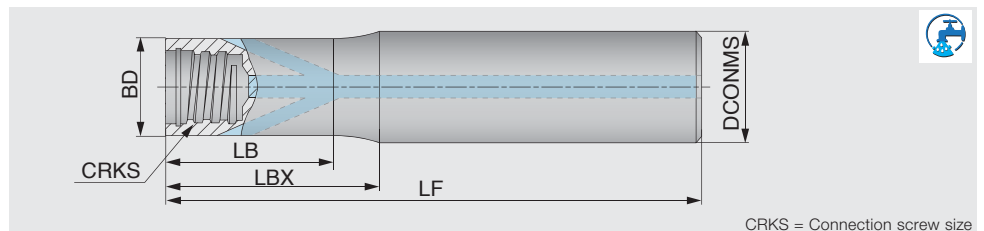


CRKS = Connection screw size

Designation	DCONMS	BD	LF	LBX	LB	CRKS	Shank	Material
VSSD12L055W05-S	12	7.6	55	3.8	-	S05	WELDON	STEEL
VSSD16L065W06-S	16	9.6	65	6	-	S06	WELDON	STEEL
VSSD16L065W08-S	16	11.5	65	4	-	S08	WELDON	STEEL
VSSD20L070W10-S	20	15.2	70	4	-	S10	WELDON	STEEL
VSSD25L075W12-S	25	18.3	75	6	-	S12	WELDON	STEEL

VSSD**-W-A

TungMeister, straight shank and neck with coolant hole

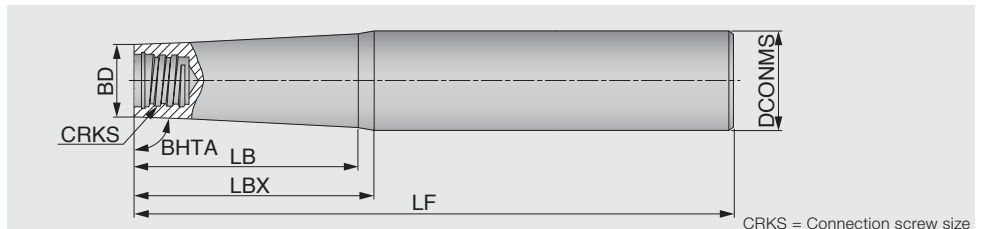


CRKS = Connection screw size

Designation	DCONMS	BD	LF	LBX	LB	CRKS	Material
VSSD10L070S06-W-A	10	9.6	70	20	19	S06	TUNGSTEN
VSSD10L090S06-W-A	10	9.6	90	40	39	S06	TUNGSTEN
VSSD10L110S06-W-A	10	9.6	110	60	59	S06	TUNGSTEN
VSSD12L070S08-W-A	12	11.5	70	20	19	S08	TUNGSTEN
VSSD12L090S08-W-A	12	11.5	90	40	39	S08	TUNGSTEN
VSSD12L110S08-W-A	12	11.5	110	60	59	S08	TUNGSTEN
VSSD12L130S08-W-A	12	11.5	130	80	79	S08	TUNGSTEN
VSSD16L070S10-W-A	16	15.2	70	20	18.5	S10	TUNGSTEN
VSSD16L090S10-W-A	16	15.2	90	40	36.5	S10	TUNGSTEN
VSSD16L110S10-W-A	16	15.2	110	60	58.5	S10	TUNGSTEN
VSSD16L130S10-W-A	16	15.2	130	80	78.5	S10	TUNGSTEN
VSSD20L090S12-W-A	20	18.3	90	40	37	S12	TUNGSTEN
VSSD20L130S12-W-A	20	18.3	130	80	77	S12	TUNGSTEN

VTSD...

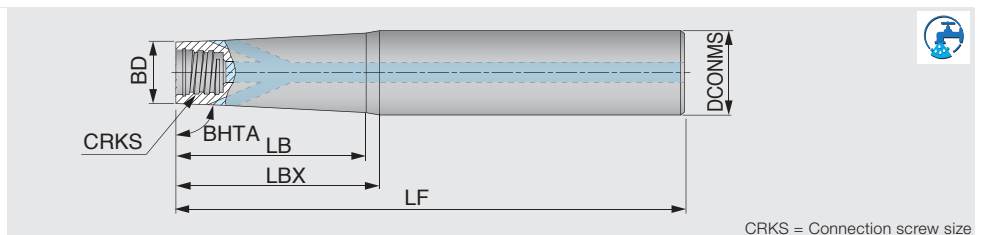
TungMeister, straight shank and taper neck



Designation	BHTA	DCONMS	BD	LF	LBX	LB	CRKS	Material
VTSD12L080S05-S	85	12	7.6	80	25	-	S05	STEEL
VTSD12L100S05-S	89	12	7.6	100	35	31	S05	STEEL
VTSD12L110S05-C	89	12	7.6	110	60	58	S05	CARBIDE
VTSD12L130S05-C	89	12	7.6	130	80	79	S05	CARBIDE
VTSD16L125S06-S	85	16	9.6	125	34	31.6	S06	STEEL
VTSD16L130S08-C	89	16	11.5	130	80	78.8	S08	CARBIDE
VTSD16L140S08-S	85	16	11.5	140	22	19.3	S08	STEEL
VTSD16L150S05-C	89	16	7.6	150	100	96	S05	CARBIDE
VTSD16L150S06-C	89	16	9.6	150	100	98	S06	CARBIDE
VTSD16L150S08-C	89	16	11.5	150	100	-	S08	CARBIDE
VTSD16L160S06-S	89	16	9.6	160	55	45.9	S06	STEEL
VTSD16L170S06-C	89	16	9.6	170	120	119	S06	CARBIDE
VTSD20L140S10-S	85	20	15.2	140	27.5	-	S10	STEEL
VTSD20L170S08-C	89	20	11.5	170	120	117	S08	CARBIDE
VTSD20L170S08-S	89	20	11.5	170	80	68.6	S08	STEEL
VTSD20L170S10-C	89	20	15.2	170	120	-	S10	CARBIDE
VTSD20L190S10-C	89	20	15.2	190	140	-	S10	CARBIDE
VTSD20L190S10-S	89	20	15.2	190	80	73	S10	STEEL
VTSD20L210S10-C	89	20	15.2	210	160	-	S10	CARBIDE
VTSD25L160S12-S	85	25	18.3	160	40	-	S12	STEEL
VTSD25L170S10-S	85	25	15.2	170	56	-	S10	STEEL
VTSD25L180S12-C	89	25	18.3	180	120	-	S12	CARBIDE
VTSD25L210S12-S	89	25	18.3	210	100	91	S12	STEEL
VTSD25L250S12-C	89	25	18.3	250	140	-	S12	CARBIDE
VTSD32L155S15-S	85	32	23.9	155	45	40	S15	STEEL
VTSD32L190S12-S	85	32	18.3	190	80	-	S12	STEEL
VTSD32L220S15-S	85	32	23.9	220	100	-	S15	STEEL
VTSD32L250S15-C	89	32	23.9	250	150	-	S15	CARBIDE
VTSD32L300S15-C	89	32	23.9	300	200	-	S15	CARBIDE

VTSD**-W-A

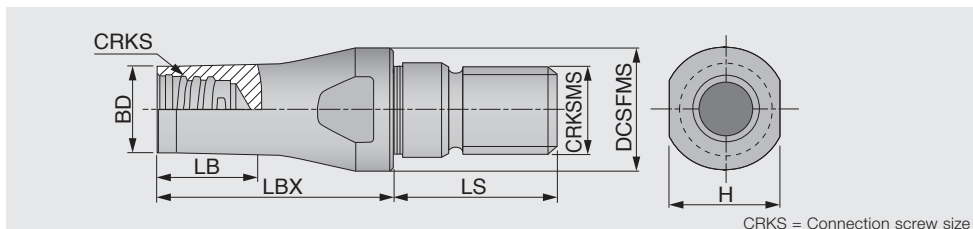
TungMeister, straight shank and taper neck with coolant hole



Designation	BHTA	DCONMS	BD	LF	LBX	LB	CRKS	Material
VTSD12L110S06-W-A	89	12	9.6	110	60	59	S06	TUNGSTEN
VTSD16L170S06-W-A	89	16	9.6	170	120	116	S06	TUNGSTEN

VAD-M...**

TungFlex conversion adaptor with TungMeister



Designation	BD	DCFSMS	LBX	LS	LB	CRKS	M	T
VAD130L016S08-S-M8	11.7	13	16	17.5	6	S08	M8	11
VAD130L025S08-S-M8	11.7	13	25	17.5	20	S08	M8	11
VAD180L020S08-S-M10	11.7	18	20	20	12	S08	M10	13
VAD180L025S08-S-M10	11.7	18	25	20	15	S08	M10	11
VAD210L020S08-S-M12	11.7	21	20	20	10	S08	M12	12.75
VAD210L025S08-S-M12	11.7	21	25	20	13	S08	M12	12.75

Wrench

Appearance	Cat. No.	Stock	Connection screw size	Torque (N-m)
	KEYV-S05	●	S05	7
	KEYV-S06	●	S06	10
	KEYV-S08	●	S08	15
	KEYV-S10	●	S10	28
	KEYV-S12	●	S12	28
	KEYV-W20	●	S15	40
	KEYV-177	●	S06	10
	KEYV-217	●	S08	15
	KEYV-T40L	●	S08 / S10	15
	KEYV-T20	●	S05	7
			S06	10
	KEYV-T25	●	S06	10
	KEYV-T30L	●	S08	15
	KEYV-T50L	●	S08	28
			S10	

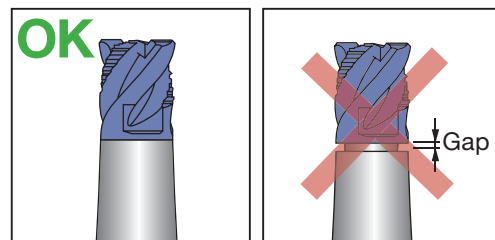
Note: Optional parts

Torque wrenches

Appearance	Description	Stock	Connection	TM Head description	Torque (N·m)
Handle 	TORQUEWRENCH5-50NM9x12	●	-	-	-
Open wrenches for cylindrical heads 	TM-WRENCH-6-05	●	S05	VMT...S05	7
	TM-WRENCH-8-06	●	S06	-	10
	TM-WRENCH-10-08	●	S08	-	15
	TM-WRENCH-13-10	●	S10	-	28
	TM-WRENCH-16-12	●	S12	-	28
	TM-WRENCH-20-15	●	S15	-	40
Open wrenches for 2 flute heads 	TM-WRENCH-4E-05	●	S05	-	7
	TM-WRENCH-5E-06	●	S06	-	10
	TM-WRENCH-7E-08	●	S08	-	15
	TM-WRENCH-8E-10	●	S10	-	28
	TM-WRENCH-9E-12	●	S12	-	28
90° adaptor for Torx bits 	INSERT-TOOL-9X12MM	●	-	-	-
Torx bits sockets 	BIT-SOCKET-T20-DRIVE	●	S05, S06	-	7, 10
	BIT-SOCKET-T25-DRIVE	●	S06	VMT...S06	10
	BIT-SOCKET-T30-DRIVE	●	S08	VMT...S08	15
	BIT-SOCKET-T40-DRIVE	●	S08, S10	-	15, 28
	BIT-SOCKET-T50-DRIVE	●	S08, S10	-	15, 28

CAUTIONARY POINTS IN USE

- The cutting heads specified by Tungaloy must be used. Avoid using alternate heads that are not Tungaloy products as this will damage the shank and can cause severe accident or injury.
- Before setting the head, clean the connection screw with an air blast or a cloth to remove chips and other foreign matter that may remain.
- Do not apply lubricant to the connection screw.
- Please use the correct "Wrench" with the correct cutting head. Tighten the head slowly until the face of the head contacts the shank. (Please refer to the picture shown on the right.) Re-tightening or over-tightening is not required. Excessive tightening may cause the cutting head to break.
- Do not apply excessive force or a hammer when tightening or exchanging the cutting heads.



MEMO

STANDARD CUTTING CONDITIONS

ISO	Material	Condition	Tensile strength [N/mm ²]	Hardness HB
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C Annealed	420	125
		≥ 0.25 %C Annealed	650	190
		< 0.55 %C Quenched and tempered	850	250
		≥ 0.55 %C Annealed	750	220
		Quenched and tempered	1000	300
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200
		Quenched and tempered	930	275
			1000	300
			1200	350
	High alloyed steel, cast steel, and tool steel	Annealed	680	200
		Quenched and tempered	1100	325
M	Stainless steel	Ferritic/martensitic	680	200
		Martensitic	820	240
K	Cast iron nodular (GGG)	Ferritic/martensitic		180
		Pearlitic		260
	Grey cast iron (GG)	Ferritic		160
		Pearlitic		250
	Malleable cast iron	Ferritic		130
		Pearlitic		230
N	Aluminum- wrought alloy	Not cureable		60
		Cured		100
	Aluminum-cast, alloyed	=<12% Si Not cureable		75
		Cured		90
		>12% Si High temperature		130
		>1% Pb Free cutting		110
	Copper alloys	Brass		90
		Electrolitic copper		100
S	High temp. alloys	Fe based Annealed		200
				280
		Ni or Co based Annealed		250
				350
				320
	Titanium Ti alloys		RM 400	
		Alpha+beta alloys cured	RM 1050	
H	Hardened steel	Hardened		55 HRC
		Hardened		60 HRC
	Chilled cast iron	Cast		400
	Cast iron	Hardened		55 HRC

Cutting speed (m/min)	Tool diameter											
	Feed (mm/t)											
AH725	ø2	ø3	ø4	ø6	ø8	ø10	ø12	ø14	ø16	ø20	ø25	ø30
100 - 250	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
80 - 210	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
65 - 170												
110 - 180	0.02	0.03	0.03	0.05	0.06	0.07	0.08	0.09	0.1	0.12	0.15	0.18
95 - 160	0.02	0.03	0.03	0.05	0.06	0.07	0.08	0.09	0.1	0.12	0.15	0.18
90 - 160	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
65 - 200	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
70 - 210	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
95 - 160	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
130 - 170	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
75 - 100	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
110 - 170	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
70 - 155	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
85 - 100	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
120 - 160	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
75 - 160	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
70 - 150	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
110 - 140	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
120 - 160	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
110 - 140	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.21	0.15	0.18	0.21
160 - 300	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
150 - 350	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
100 - 250	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12
100 - 400	0.05	0.06	0.07	0.09	0.1	0.11	0.12	0.13	0.15	0.18	0.22	0.25
20 - 80	0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04	0.04	0.04	0.05	0.05
20 - 80	0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04	0.04	0.04	0.05	0.05
55 - 65												
45 - 55												
90 - 105												
55 - 65												

h long cutting flute, reduce feed rate by 40%.

Thread Milling CNC Program for Internal Thread

Right-hand thread (climb milling) from bottom up.

Program is based on tool center.

This method of programming needs no tool radius compensation value, other than an offset for wear

$$A = \frac{Do - D}{2}$$

A = Radius of tool path
Do = Major thread diameter
D = Cutting diameter

General Program

```
G90 G00 G54 G43 H1X0 Y0 Z10 S (n : Number of revolutions)
G00 Z-(to thread depth)
G01 G91 G41 D1 X (A/2) Y-(A/2) Z0 F (Center of tool)
G03 X(A/2) Y(A/2) R (A/2) Z(1/8 pitch) F (Cutting edge)
G03 X0 Y0 I -(A) J0 Z (pitch)
G03 X-(A/2) Y(A/2) R (A/2) Z(1/8 pitch)
G01 G40 X -(A/2) Y-(A/2) Z0
G90 X0 Y0 Z0
```

Internal Thread

Example: M20x2.0 IN-RH (Thread depth 20 mm)

Tool : MTEC1010C27 2.0ISO

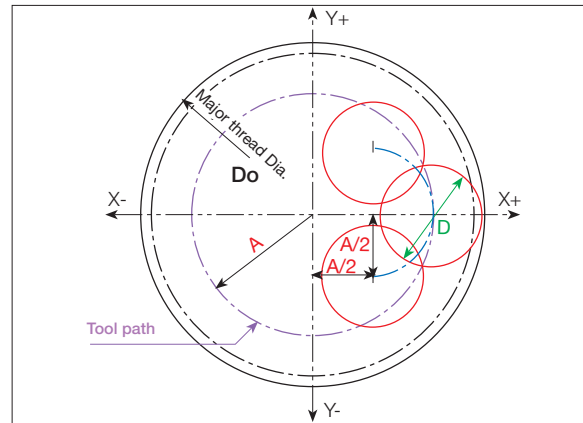
(Cutting dia. 10 mm)

$$A = (Do - D) / 2 = (20 - 10) / 2 = 5$$

$$A/2 = 2.5$$

(Tool compensation of radius=0)

```
G90 G0 G54 G43 G17 H1X0 Y0 Z10 S4000
G0 Z-20
G01 G91 G41 D1X 2.5 Y-2.5 Z0 F840
G03 X2.5 Y2.5 R2.5 Z0.25 F420
G03 X0 Y0 I-5.0 J0 Z2.0
G03 X-2.5 Y2.5 R2.5 Z0.25
G01 G40 X-2.5 Y-2.5 Z0
G90 G0 X0 Y0 Z0
M30
%
```



$$F \text{ (Center of tool)} = n \times f \times z$$

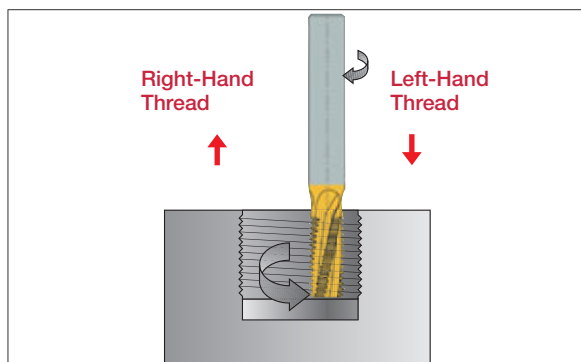
n : Number of revolutions

$$F \text{ (Cutting edge)} = \frac{Do - D}{Do} \times n \times f \times z$$

f : rev / tooth

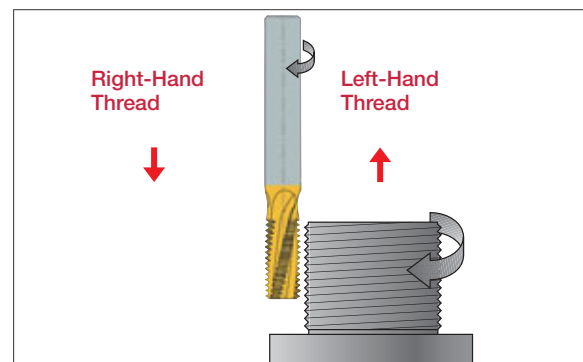
z : Number of edge

Internal Thread



A thread milling operation is applicable for thread cutting in non-symmetrical parts utilizing the advantage of helical interpolation programs on modern machining centers.

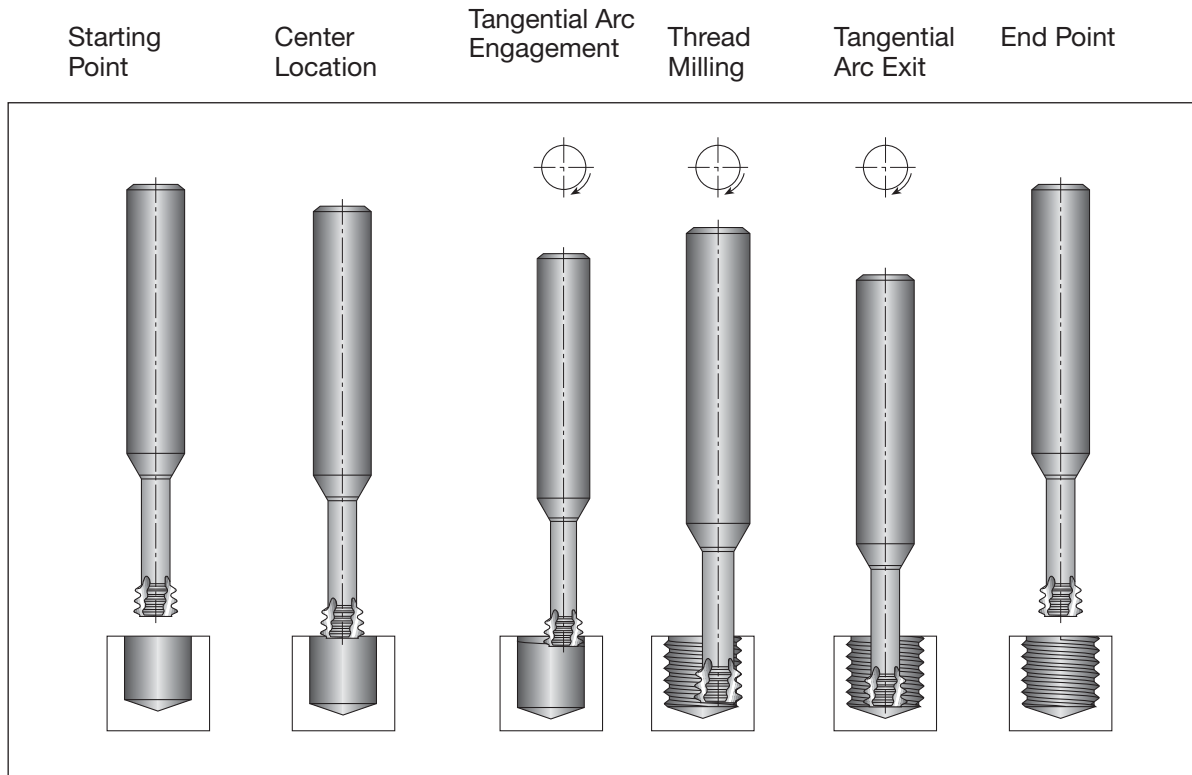
External Thread



MTECS

Small Diameter, Short type

Thread Milling - Recommended Procedure



STANDARD CUTTING CONDITIONS

ISO	Material	Cutting speed m/min	Ø1.5	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø12	Ø14	Ø1.5
P	Low & medium carbon steels	60 - 120	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
	High carbon steels	60 - 90	0.04	0.05	0.06	0.08	0.09	0.1	0.12	0.13	0.14	0.14	0.16	0.17	0.18
	Alloy steels, treated steels	50 - 80	0.04	0.04	0.05	0.05	0.06	0.07	0.07	0.08	0.09	0.1	0.12	0.13	0.14
	Cast steels	70 - 90	0.04	0.04	0.05	0.05	0.06	0.07	0.07	0.08	0.09	0.1	0.12	0.13	0.14
M	Stainless steels	60 - 90	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.1	0.11	0.12	0.13
S	Nickel alloys, titanium alloys	20 - 40	0.03	0.03	0.04	0.04	0.05	0.06	0.06	0.06	0.07	0.07	0.07	0.08	0.08
K	Cast iron	40 - 80	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
N	Aluminum	80 - 150	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
	Synthetics, duroplastics, thermoplastics	50 - 200	0.1	0.11	0.12	0.14	0.16	0.18	0.19	0.19	0.19	0.19	0.19	0.2	0.2

MTECS Small Diameter, Short type

SolidThread MTECS is used for the production of small internal threads. These thread mills feature a short 3-tooth cutting zone with 3 flutes and a released neck between the cutting zone and the shank.

This unique tool design offers very precise profiles and a high performance AH725 submicron carbide grade with PVD titanium aluminum nitride coating. The very short profile exerts a low force which minimizes tool bending. This facilitates parallel and high thread precision for the entire length.



Compared to taps, the **SOLIDTHREAD** is more accurate, thread machining is substantially faster and there is no danger of a broken tap being stuck in the hole.

SolidThread vs. Tap

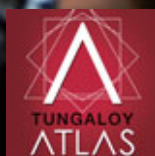
Criteria	Thread mill	Taps
Thread surface quality	High	Medium
Thread geometry	Very accurate	Medium
Thread tolerance	4H, 5H, 6H with std. cutter	6H with standard tap, 4H with special tap
Machining time	Shorter or same as tap	Short
Machining load	Very low	High
Range of thread diameters	Wide range of diameters	Specific tap for each thread size
Right-/Left-hand threading	Same cutter	Specific tap for right- and left-hand
Geometric shape	Full profile	Partial profile

Features

- Minimum thread size of MTECS: **M1x0.25** (0.75 mm pre hole diameter) up to M20x2.50
- 2xD and 3xD threading lengths
- High cutting speeds
- Short cycle time
- Low cutting forces due to the short contact profile resulting in accurate and parallel thread
- Prevents oval threads near thin walls
- No more dealing with broken taps
- Reliable threading in blind holes
- Excellent performance on hardened steel, high temperature alloys and titanium



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