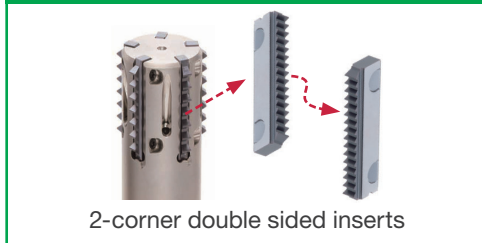


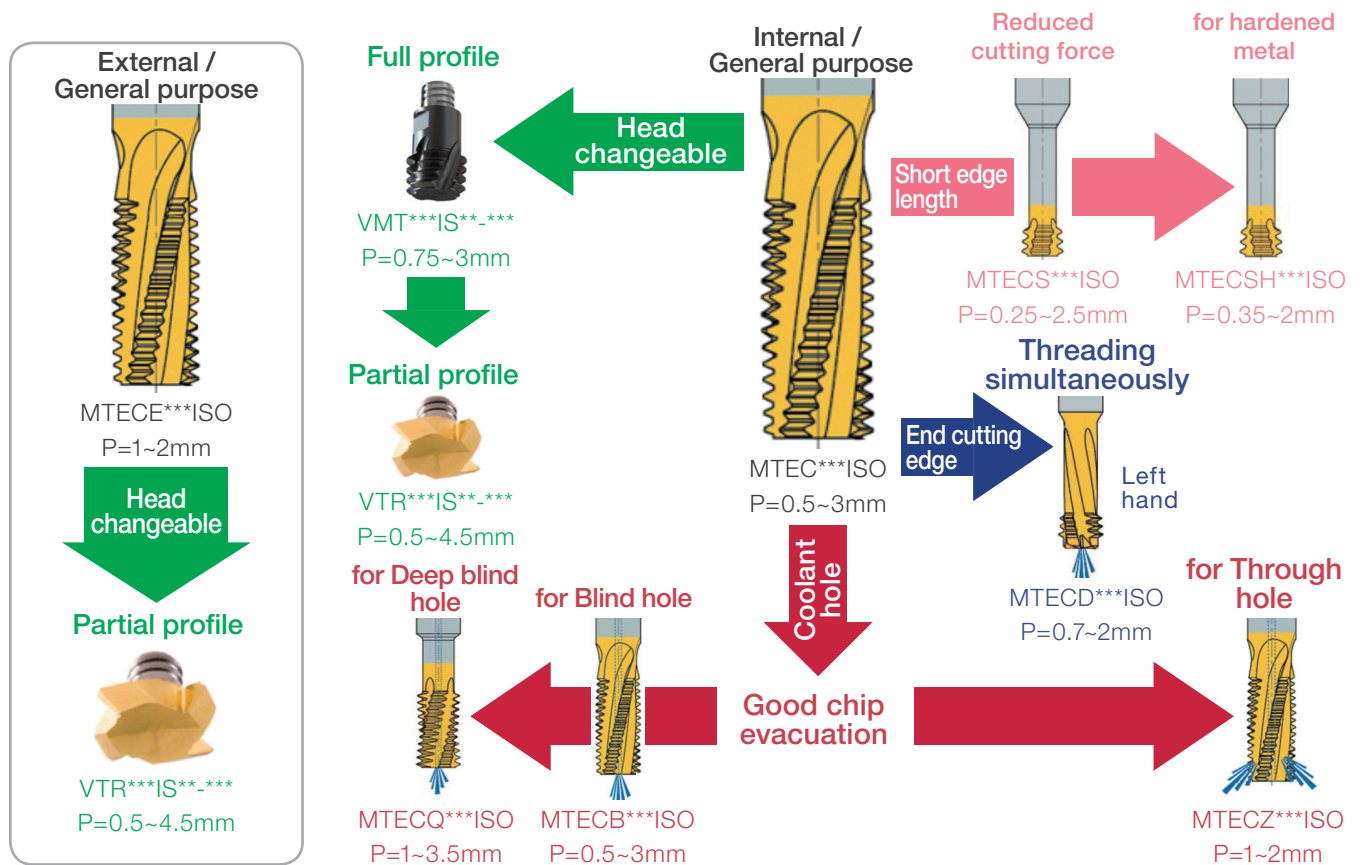
THREADMILLING

Highly economical tool design

Cost reduction

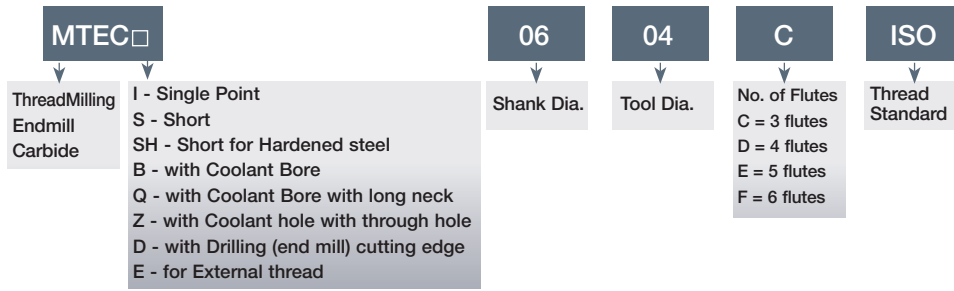


SOLIDTHREAD Selection Guide (for ISO metric)



Reference pages: I103 - I115, L058

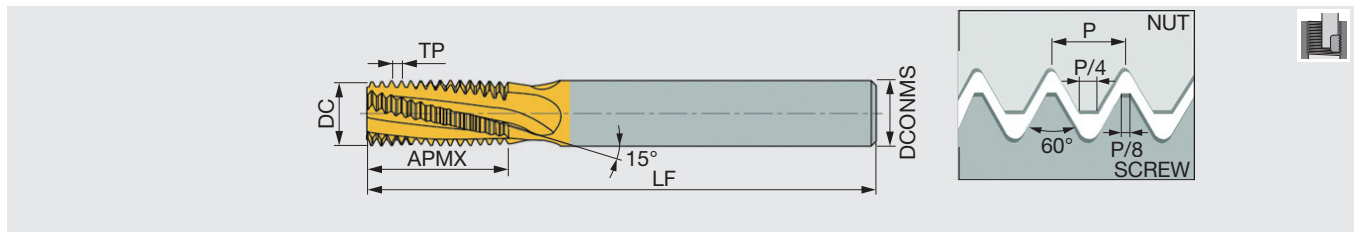
Designation System for Solid Carbide Endmills



ISO metric

MTEC-ISO

Solid carbide internal threading endmill, for ISO metric profile



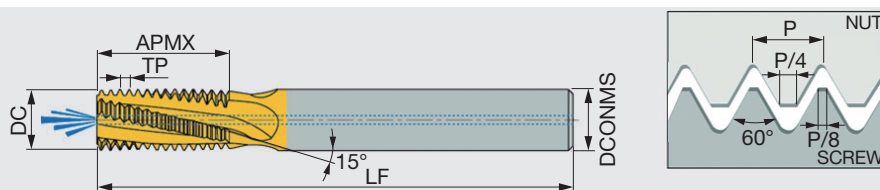
Designation	TP	Application range		DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
		Fine	Coarse							
MTEC06038C100.5ISO	0.5	-	≥M5	6	3.8	3	10.3	58	Without	AH725
MTEC06022C50.5ISO	0.5	M3	≥M4	6	2.2	3	5.3	58	Without	AH725
MTEC06031C70.7ISO	0.7	M4	≥M5	6	3.1	3	7.4	58	Without	AH725
MTEC06045C100.75ISO	0.75	-	≥M6	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	M16	≥M17	10	10	3	27	73	Without	AH725
MTEC1010C392.0ISO	2	M16	≥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

Reference pages: Standard cutting conditions → I118 - I120



ISO metric**MTECB-ISO**

Solid carbide internal threading endmill, with coolant hole, for ISO metric profile



Designation	TP	Application range		DCONMS	DC	NOF	APMX	LF	Coolant 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

2

3

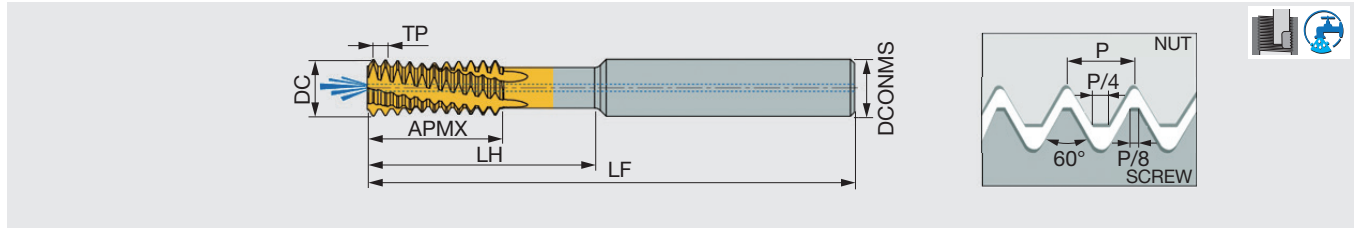
4

5

6
or more

MTECQ-ISO

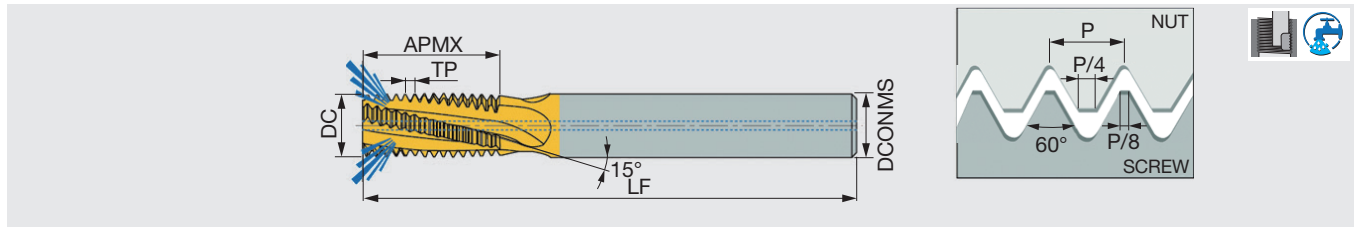
Solid carbide deep internal threading endmill, with internal coolant hole, for ISO metric profile



Designation	TP	Application range	DCONMS	DC	NOF	APMX	LH	LF	Coolant 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 endmill, with coolant hole in the flute, for ISO metric profile

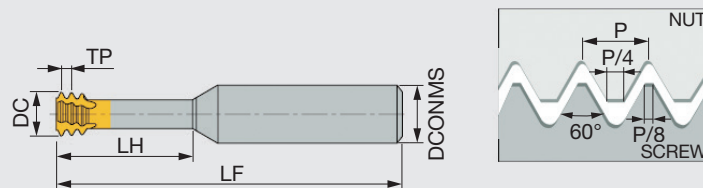


Designation	TP	Application range		DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
		Fine	Coarse							
MTECZ0808D161.0ISO	1	-	≥M10	8	8	4	16.5	64	With	AH725
MTECZ06048C101.0ISO	1	M6	≥M7	6	4.8	3	10.5	58	With	AH725
MTECZ0606C141.25ISO	1.25	M8	≥M10	6	6	3	14.4	58	With	AH725
MTECZ0606C191.25ISO	1.25	M8	≥M10	6	6	3	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

Reference pages: Standard cutting conditions → I118 - I120

ISO metric**MTECS-ISO**

Small diameter solid carbide internal threading endmill, short edge type, for ISO metric profile

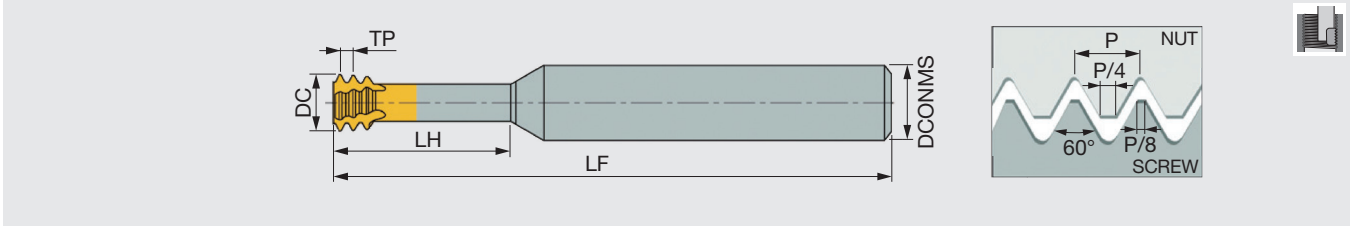


Designation	TP	Application range	DCONMS	DC	NOF	LH	LF	Coolant hole	Grade
MTECS03007C20.25ISO	0.25	≥M1	3	0.72	3	2.5	39	Without	AH725
MTECS03009C30.25ISO	0.25	≥M1.2	3	0.9	3	3	39	Without	AH725
MTECS03011C40.3ISO	0.3	≥M1.4	3	1.05	3	4	39	Without	AH725
MTECS03012C50.35ISO	0.35	≥M1.6	3	1.2	3	4.8	39	Without	AH725
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

Reference pages: Standard cutting conditions → **I118 - I120**

MTECSH-ISO

Small diameter solid carbide internal threading endmill, short edge type, left hand cutting, for ISO metric profile



Designation	TP	Application range	DCONMS	DC	NOF	LH	LF	Coolant hole	Grade
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

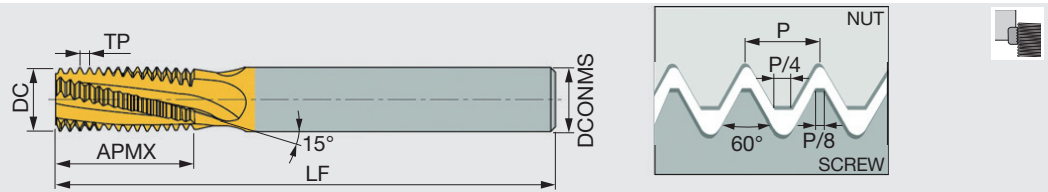
Small diameter solid carbide endmill for internal threading, drilling, and chamfering, short edge type, left hand cutting, for ISO metric profile



Designation	TP	Application range	DCONMS	DC	NOF	LH	LF	CHW	L1	Coolant 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 endmill, for ISO metric profile

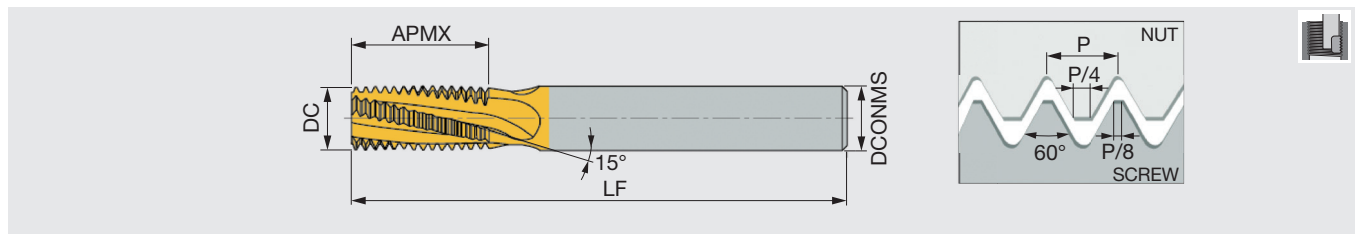


Designation	TP	DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
MTECE1010D161.0ISO	1	10	10	4	16.5	73	Without	AH725
MTECE1010D161.25ISO	1.25	10	10	4	16.9	73	Without	AH725
MTECE1010D151.5ISO	1.5	10	10	4	15.8	73	Without	AH725
MTECE1212D201.5ISO	1.5	12	12	4	20.3	84	Without	AH725
MTECE1212D201.75ISO	1.75	12	12	4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

Unified

MTEC-UN

Solid carbide internal threading endmill, for UN profile



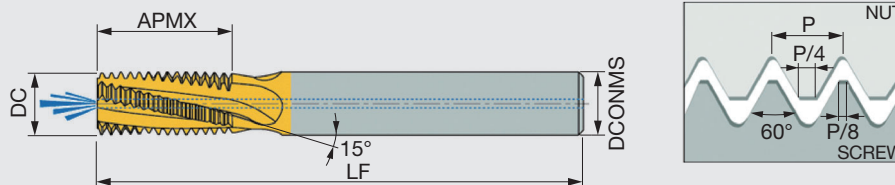
Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
		UNC	UNF	UNEF							
MTEC06032C632UN	32	#8	#10	#12	6	3.2	3	6.8	58	Without	AH725
MTEC0604C1128UN	28	-	1/4	-	6	4	3	11.3	58	Without	AH725
MTEC0606C1428UN	28	-	-	7/16-1/2	6	6	3	14.5	58	Without	AH725
MTEC0605C1424UN	24	-	5/16	-	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

Reference pages: Standard cutting conditions → I118 - I120



Unified**MTECB-UN**

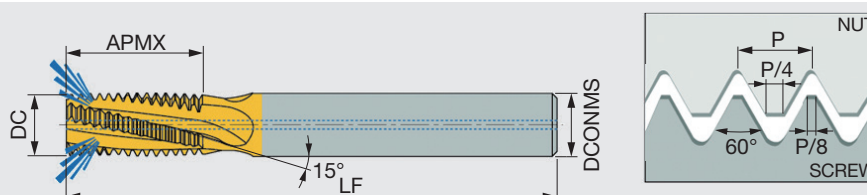
Solid carbide internal threading endmill, with coolant hole, for UN profile



Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Coolant 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 internal threading endmill, with coolant hole in the flute, for UN profile



Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Coolant 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 internal threading endmill, short edge type, for UN profile



Designation	TPI	Application range		DCONMS	DC	NOF	LH	LF	Coolant 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

Reference pages: Standard cutting conditions → I118 - I120



Unified**MTECSH-UN**

Small diameter solid carbide internal threading endmill, short edge type, left hand cutting, for UN profile



Designation	TPI	Application range		DCONMS	DC	NOF	LH	LF	Coolant 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

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6
or more**MTEC E-UN**

Solid carbide external threading endmill, for UN profile



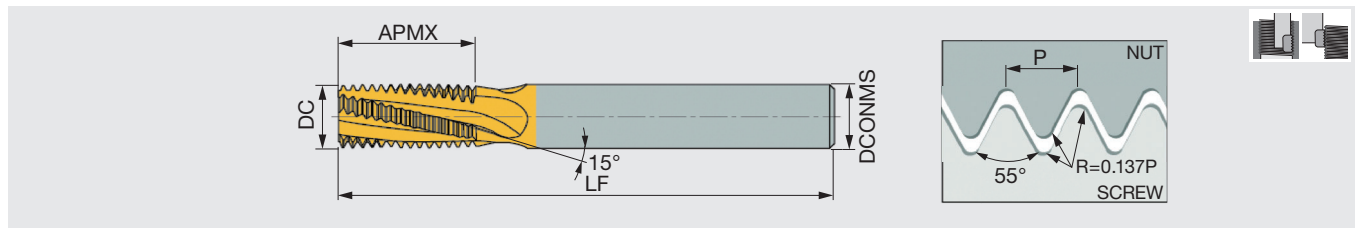
Designation	TPI	DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
MTECE1010D1624UN	24	10	10	4	16.4	73	Without	AH725
MTECE1212E2120UN	20	12	12	5	21	84	Without	AH725

Reference pages: Standard cutting conditions → **I118 - I120**

Whitworth

MTEC-W

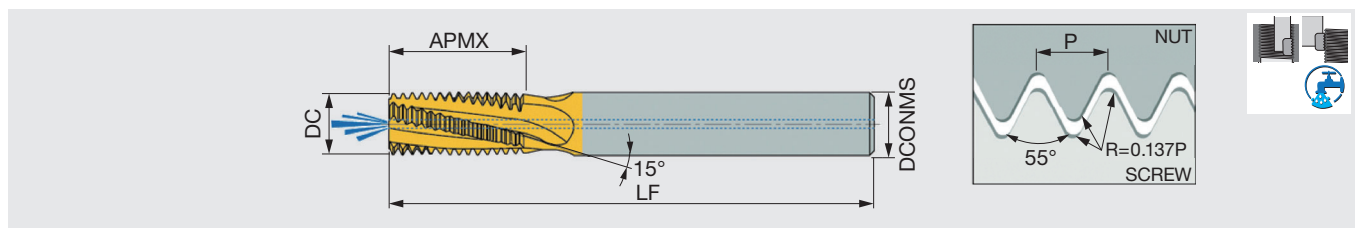
Solid carbide internal and external threading endmill, for BSP profile



Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Coolant 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

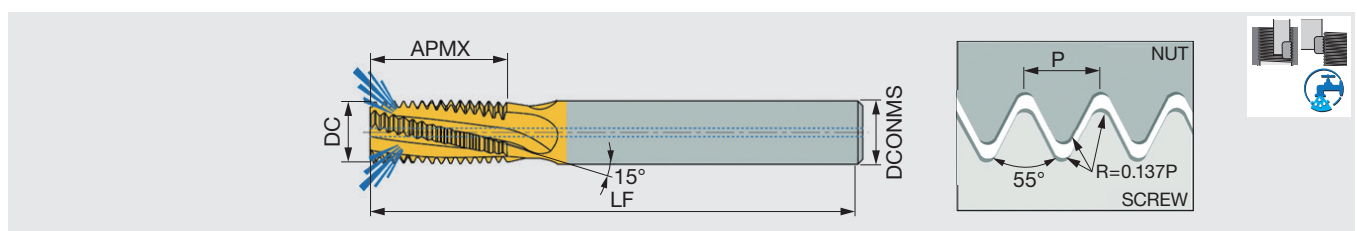
Solid carbide internal and external threading endmill, with coolant hole, for BSP profile



Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
MTECB08078C1428W	28	1/8	8	7.8	3	14.1	64	Without	AH725
MTECB1010D1619W	19	1/4-3/8	10	10	4	16.7	73	Without	AH725
MTECB1616E2614W	14	1/2-7/8	16	16	5	26.3	105	Without	AH725
MTECB1616D3811W	11	≥1	16	16	4	38.1	105	Without	AH725
MTECB2020E4711W	11	≥1	20	20	5	47.3	105	Without	AH725

MTECZ-W

Solid carbide internal and external threading endmill, with coolant hole, for BSP profile



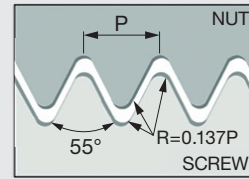
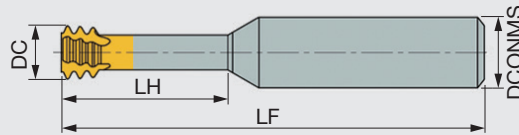
Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
MTECZ08078C1428W	28	1/8	8	7.8	3	14.1	64	With	AH725
MTECZ1010D1619W	19	1/4-3/8	10	10	4	16.7	73	With	AH725
MTECZ1616E2614W	14	1/2-7/8	16	16	5	26.3	101	With	AH725

Reference pages: Standard cutting conditions → [I118](#) - [I120](#)

SOLIDTHREAD

MTECS-W

Solid carbide internal and external threading endmill, short edge type, for BSP/BSF profile

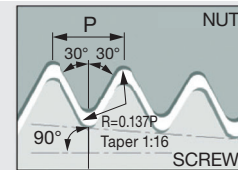
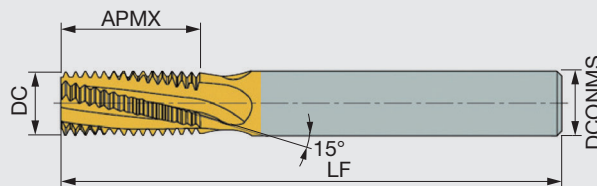


Designation	TPI	Application range	DCONMS	DC	NOF	LH	LF	Coolant hole	Grade
MTECS08078C1928W	28	1/8	8	7.8	3	19.5	64	Without	AH725
MTECS1010D3019W	19	1/4-3/8	10	10	4	30	73	Without	AH725
MTECS1212D3714W	14	1/2-7/8	12	12	4	37	84	Without	AH725

BSPT

MTEC-BSPT

Solid carbide internal and external threading endmill. for BSPT profile

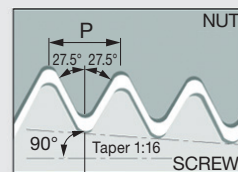
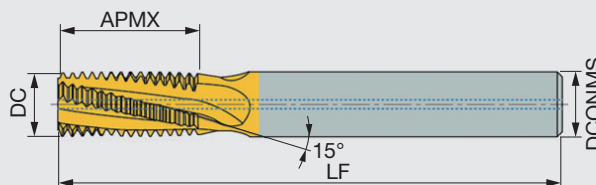


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
MTEC0606C928BSPT	28	1/8	6	6	3	9.5	58	Without	AH725
MTEC0808C1419BSPT	19	1/4-3/8	8	8	3	14	64	Without	AH725
MTEC1212D1914BSPT	14	1/2-7/8	12	12	4	19.1	84	Without	AH725
MTEC1616D2811BSPT	11	1-2	16	16	4	28.9	105	Without	AH725

NPT

MTEC-NPT

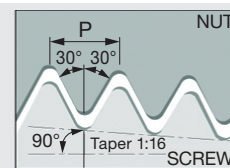
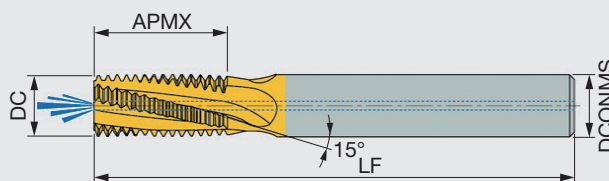
Solid carbide internal and external threading endmill. for NPT profile



Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Coolant 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 internal and external threading endmill, with coolant hole, for NPT profile

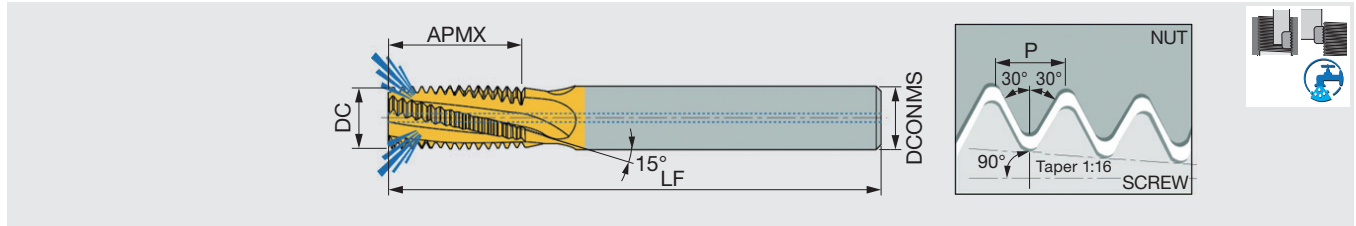


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
MTECB08076C1027NPT	27	1/8	8	7.6	3	10.8	64	With	AH725
MTECB1010D1618NPT	18	1/4-3/8	10	10	4	16.2	73	With	AH725
MTECB16155D2214NPT	14	1/2-3/4	16	15.5	4	22.7	105	With	AH725

NPTF

MTECZ-NPTF

Solid carbide internal and external threading endmill, with coolant hole in the flute, for NPTF profile

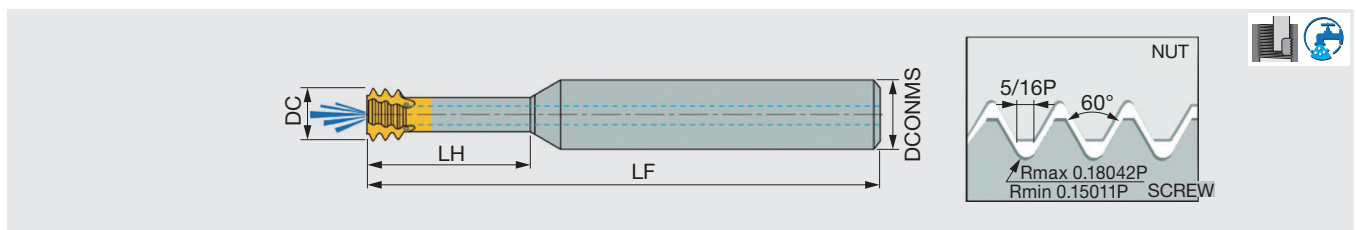


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Coolant hole	Grade
MTECZ08076C1027NPTF	27	1/8	8	7.6	3	10.8	64	With	AH725
MTECZ1010D1618NPTF	18	1/4-3/8	10	10	4	16.2	73	With	AH725

MJ

MTECS-MJ

Small diameter solid carbide internal threading endmill, short edge type, with coolant hole, for MJ profile

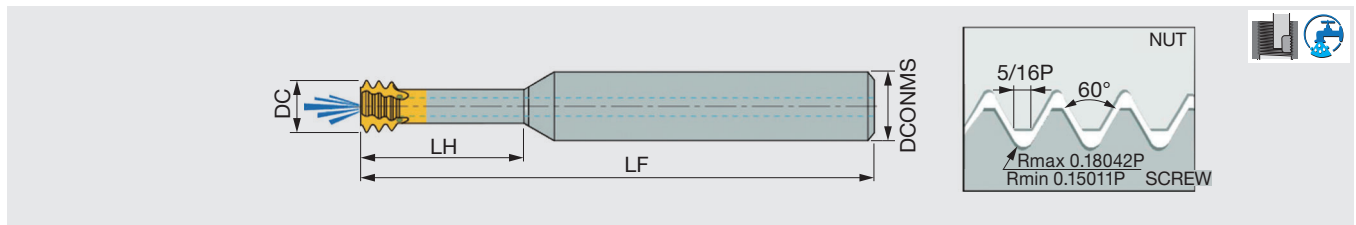


Designation	TP	Application range	DCONMS	DC	NOF	LH	LF	Coolant hole	Grade
MTECS06039C120.8MJ	0.8	5	6	3.9	3	12.5	58	Without	AH725
MTECS08061C201.25MJ	1.25	8	8	6.1	3	20	64	With	AH725
MTECS10092C301.75MJ	1.75	12	10	9.2	3	30	73	With	AH725

UNJ

MTECS-UNJ

Small diameter solid carbide internal threading endmill, short edge type, with coolant hole, for UNJ profile

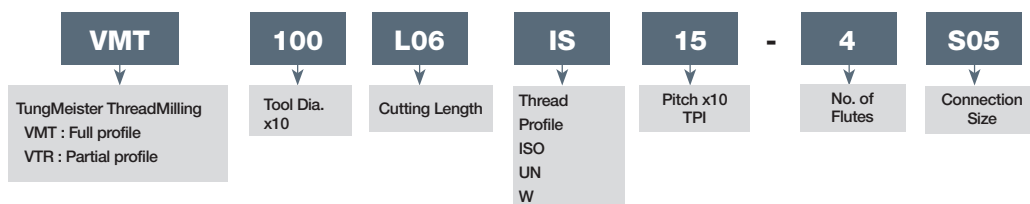


Designation	TPI	Application range		DCONMS	DC	NOF	LH	LF	Coolant hole	Grade
		UNJC	UNJF							
MTECS08051C1628UNJ	28	-	1/4	8	5.1	3	16	64	With	AH725
MTECS08067C2024UNJ	24	-	5/16-3/8	8	6.7	3	20	64	With	AH725
MTECS06049C1620UNJ	20	1/4	-	6	4.9	3	16	58	Without	AH725
MTECS0808C2820UNJ	20	-	7/16	8	8	3	28	64	With	AH725
MTECS08061C2018UNJ	18	5/16	-	8	6.15	3	20	64	With	AH725



TUNGMEISTER

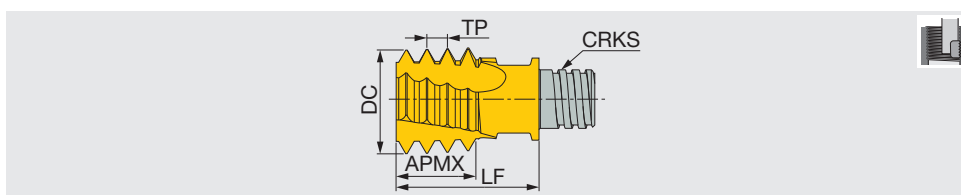
Designation System for TungMeister



ISO metric

VMT***IS

Internal threading head, for ISO metric profile (TungMeister)



Designation	TP	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
VMT120L09IS15-4S06	1.5	-	≥M16	12	4	9	14.3	S06	AH725	KEYV-T25
VMT120L10IS20-4S06	2	M16	≥M17	12	4	10	14.3	S06	AH725	KEYV-T25
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
VMT150L13IS25-5S08	2.5	M20	≥M22	15.4	5	12.5	19	S08	AH725	KEYV-T30L
VMT160L12IS30-3S08	3	M24	≥M25	16	3	12	19	S08	AH725	KEYV-T30L

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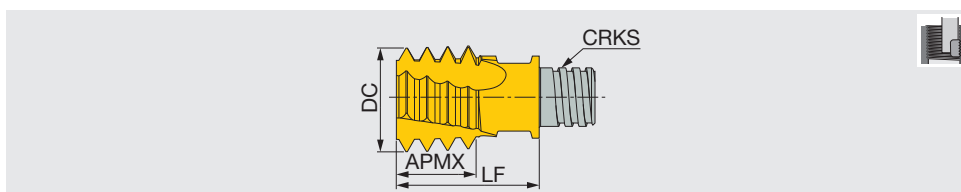
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6
or more

Unified

VMT***UN

Internal threading head, for UN profile (TungMeister)



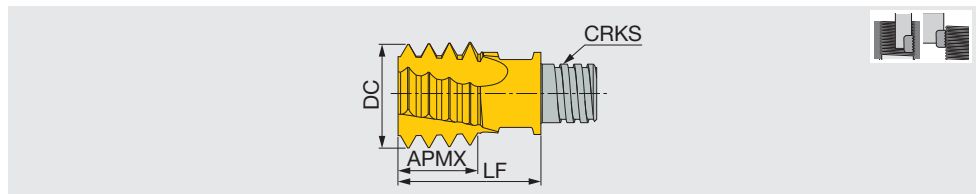
Designation	TPI	Application range			DC	NOF	APMX	LF	CRKS	Grade	Wrench
		UNC	UNF	UNEF							
VMT100L06UN24-4S05	24	-	-	9/16-5/8	10	4	5.3	12.8	S05	AH725	KEYV-S05
VMT100L06UN20-4S05	20	-	1/2	-	10	4	5.1	12.8	S05	AH725	KEYV-S05
VMT100L06UN18-4S05	18	-	9/16-5/8	1 1/8-1 5/8	10	4	5.6	12.8	S05	AH725	KEYV-S05
VMT120L10UN16-4S06	16	-	3/4	-	12	4	9	14.3	S06	AH725	KEYV-T25
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
VMT160L12UN08-3S08	8	1	-	-	16	3	12.7	19	S08	AH725	KEYV-T30L

Reference pages: ThreadMill → **I103 - I115**

Whitworth

VMT***W

Internal and external threading head, for 55° BSP profile (TungMeister)

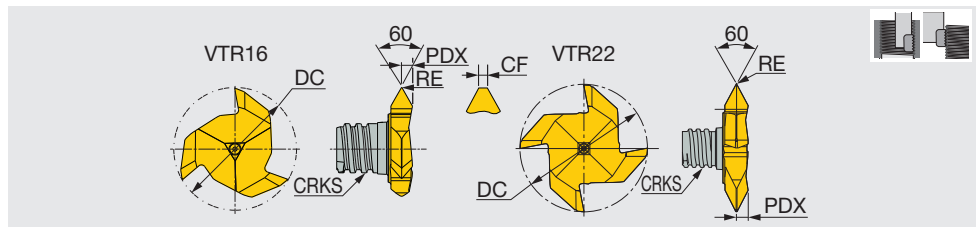


Designation	TPI	Application range	DC	NOF	APMX	LF	CRKS	Grade	Wrench
VMT100L06W19-4S05	19	1/4-3/8	10	4	5.3	12.8	S05	AH725	KEYV-S05
VMT160L12W14-4S08	14	1/2-7/8	16	4	12.7	19	S08	AH725	KEYV-T30L
VMT160L11W11-4S08	11	≥1	16	4	11.6	19	S08	AH725	KEYV-T30L

60° partial profile

VTR***IS

Internal and external threading head, for 60° partial profile (TungMeister)

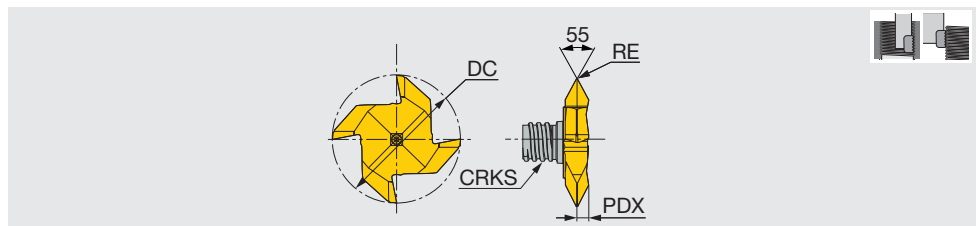


Designation	TP		Smallest Possible thread	DC	NOF	RE	CF	PDX	CRKS	Grade	Wrench
	TPN	TPX									
VTR160L12IS05-3S06	0.5	2	M20	15.7	3	-	0.05	1.4	S06	GH130	KEYV-177
VTR160L12IS15-3S06	1.5	2	M22	15.7	3	0.05	-	1.4	S06	GH130	KEYV-177
VTR220L28IS30-4S08	3	4.5	M36	21.7	4	0.2	-	2.8	S08	GH130	KEYV-217

55° partial profile

VTR***W

Internal and external threading head, for 55° partial profile



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

THREADMILLING

STANDARD CUTTING CONDITIONS

ISO	Material	Condition	Tensile strength [N/mm ²]	Hardness HB	Cutting speed (m/min)	
					AH725	
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	420	125	100-250
		≥ 0.25 %C	Annealed	650	190	80-210
		< 0.55 %C	Quenched and tempered	850	250	65-170
		≥ 0.55 %C	Annealed	750	220	110-180
	Low alloy steel and cast steel (less than 5% of alloying elements)	Quenched and tempered		1000	300	95-160
			Annealed	600	200	90-160
		Quenched and tempered		930	275	65-200
				1000	300	70-210
		High alloyed steel, cast steel, and tool steel	Annealed	680	200	130-170
			Quenched and tempered	1100	325	75-100
	Stainless steel and cast steel	Ferritic/martensitic	680	200	110-170	
		Martensitic	820	240	70-155	
M	Stainless steel	Annealed	600	180	85-100	
K	Cast iron nodular (GGG)	Ferritic/martensitic		180	120-160	
		Pearlitic		260	75-160	
	Grey cast iron (GG)	Ferritic		160	70-150	
		Pearlitic		250	110-140	
	Malleable cast iron	Ferritic		130	120-160	
		Pearlitic		230	110-140	
N	Aluminum- wrought alloy	Not cureable		60	160-300	
		Cured		100		
	Aluminum-cast, alloyed	≤12% Si	Not cureable		75	150-350
			Cured		90	
		>12% Si	High temperature		130	100-250
	Copper alloys	>1% Pb	Free cutting		110	
			Brass		90	
Non-metallic		Electrolitic copper		100		
		Duroplastics, fiber plastics			100-400	
S	High temp. alloys	Fe based	Annealed		200	
			Cured		280	
		Ni or Co based	Annealed		250	20-80
			Cured		350	
	Titanium Ti alloys		Cast		320	
				RM 400		
H	Hardened steel	Hardened			55 HRC	55-65
					60 HRC	45-55
	Chilled cast iron	Cast		400	90-105	
	Cast iron	Hardened		55 HRC	55-65	

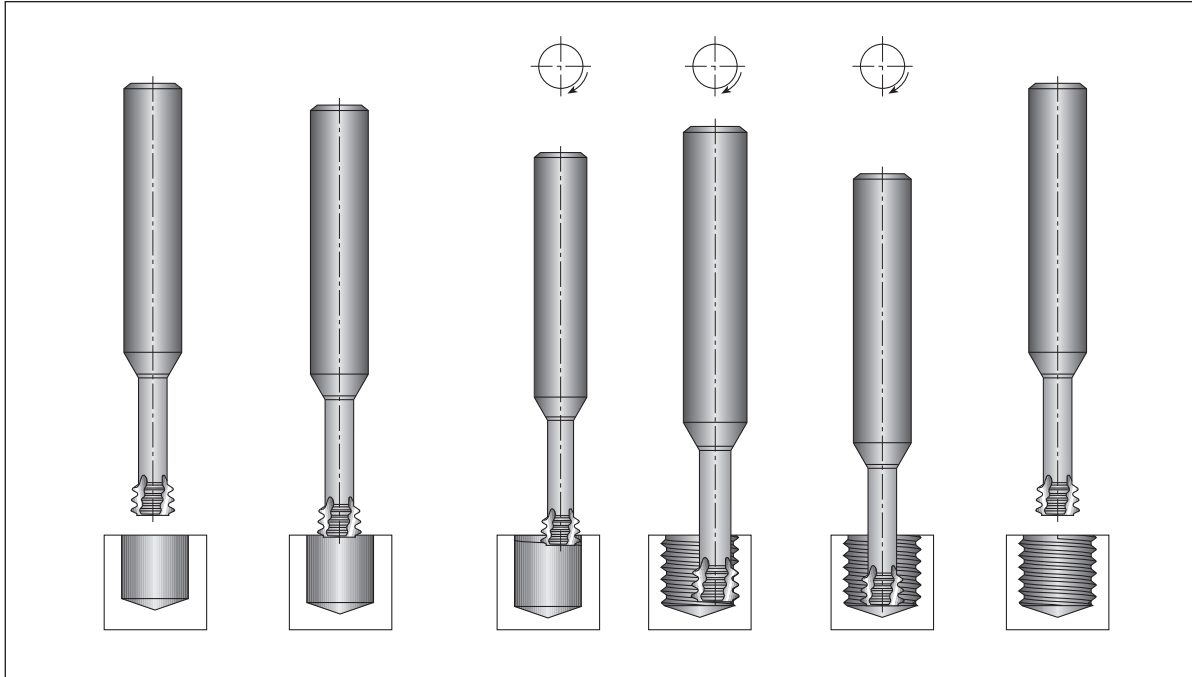
Tool dia. (mm)											
Feed (mm/t)											
ø2	ø3	ø4	ø6	ø8	ø10	ø12	ø14	ø16	ø20	ø25	ø30
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.02	0.03	0.03	0.05	0.06	0.07	0.08	0.09	0.1	0.12	0.15	0.18
0.02	0.03	0.03	0.05	0.06	0.07	0.08	0.09	0.1	0.12	0.15	0.18
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.1	0.11
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18	0.21
0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10	0.12
0.05	0.06	0.07	0.09	0.1	0.11	0.12	0.13	0.15	0.18	0.22	0.25
0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04	0.04	0.04	0.05	0.05
0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04	0.04	0.04	0.05	0.05

With long edge, reduce feed rate to 40%.

MTECS Small Diameter, Short type

Thread Milling - Recommended Procedure

Starting Point Center Location Tangential Arc Engagement Thread Milling Tangential Arc Exit End Point



STANDARD CUTTING CONDITIONS

ISO	Material	Cutting speed m/min	Feed (mm/t)												
			ø1.5	ø2	ø3	ø4	ø5	ø6	ø7	ø8	ø9	ø10	ø12	ø14	ø15
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

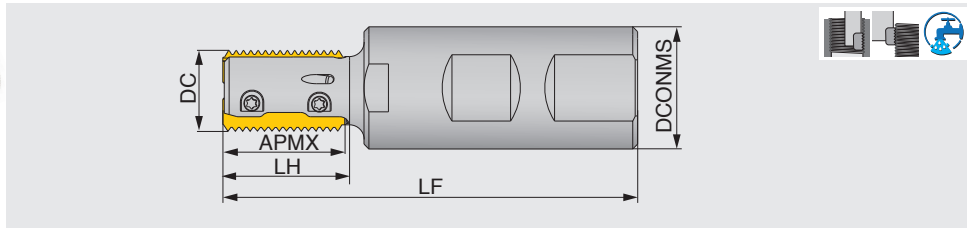
- Minimum thread size of MTECS: **M1x0.25** (0.75 mm pre hole diameter) up to M20x2.50
- 2xD and 3xD threading lengths
- High cutting speeds
- Short cycle time
- Low cutting forces due to the short contact profile resulting in accurate and parallel thread
- Prevents oval threads near thin walls
- No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



THREADMILLING

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...

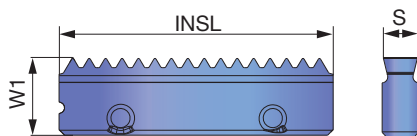
SPARE PARTS

Designation	Clamping screw	Wrench
ETTL25...	SSTM4-3.6P	T-8D

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

INSERT

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 DC 17 holder

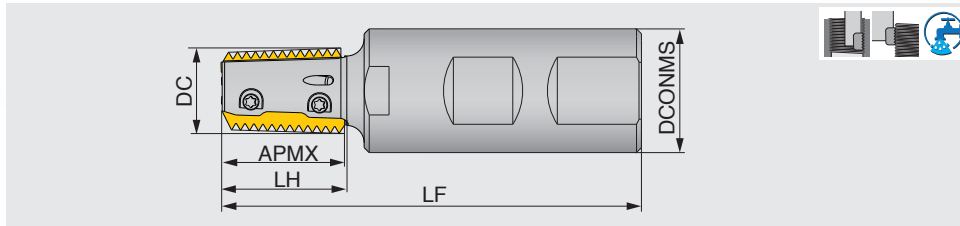
●: Line up

Reference pages: Standard cutting conditions → I125

THREADMILLING

Thread milling cutter

Indexable thread milling cutter, long edge



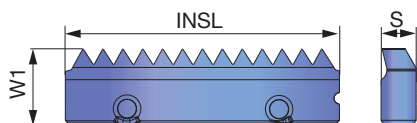
Designation	DC	APMX	CICT	DCONMS	LH	LF	Oil hole	Insert
ETTL25M017W25.0F026R02-PT	17.47	25	2	25	25.5	85	with	TL25SEIR...
ETTL25M022W25.0F043R03-PT	22.2	25	3	25	43	102	with	TL25SEIR...

SPARE PARTS

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

INSERT

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

●: Line up

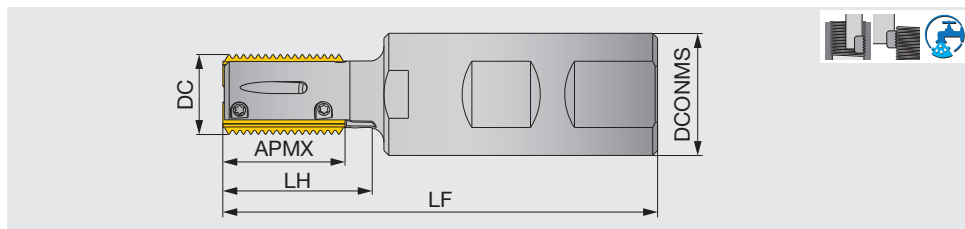
Reference pages: Standard cutting conditions → I125



THREADMILLING

Thread milling cutter

Indexable thread milling cutter, long edge type



Designation	DC	APMX	CICT	DCONMS	LH	LF	Coolant 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



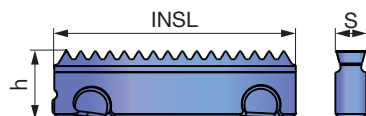
Designation	Clamping screw	Wrench
ETLN25...	SSTM3-3	T-6F

* Recommended clamping torque: SSTM3-3=1

(1) Inserts with a thread pitch of ≥ 3 mm or ≥ 8 TPI do not fit.

INSERT

LN25...



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	Coated			INSL	h	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 DC 17 holder

●: Line up

Reference pages: Standard cutting conditions → I125

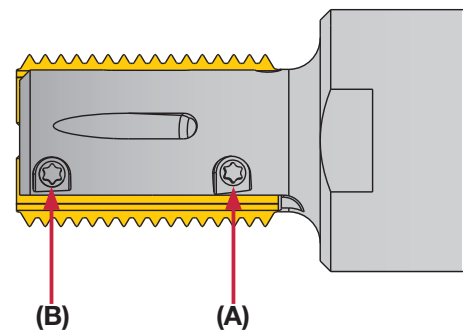
STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grades	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

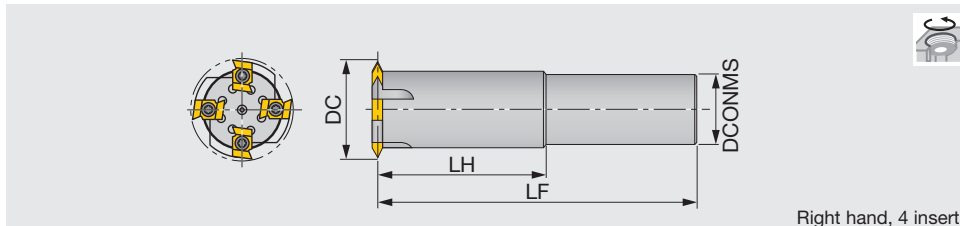
1. Use airgun or rag to thoroughly clean all the insert pockets free from dust or chips.
2. Lightly tighten Screw "A" first, then Screw "B" until the insert becomes stationary.
3. Lightly tighten the screws for other insert(s) in the same matter as mentioned in #2 above.
4. Firmly tighten Screw "A", 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.



THREADMILLING

Thread milling cutter

Indexable thread milling cutter, single tooth



Right hand, 4 inserts

Designation	DC	CICT	DCONMS	LH	LF	Range of internal thread	Insert
D23-D25-45R	23	1	25	45	115	M28 - M30	T1-R...
D25-D25-45R	25	1	25	45	115	M32 - M42	T1-R...
D38-D32-85R	38	2	32	85	165	M45 - M56	T1-R...
D50-D42-100R	50	4	42	100	190	M58 - M68	T1-R...
D55-D42-100R	55	4	42	100	190	M64 - M85	T2-R...
D60-D42-100R	60	4	42	100	190	M70 - M85	T2-R...
D80-D42-100R	80	6	42	100	190	M90 -	T2-R...

SPARE PARTS

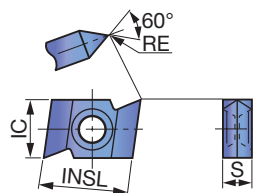


Designation	Clamping screw	Wrench
D23-D25... - D50-D42...	CSTB-4	T-15F
D55-D42... - D80-D42...	CSTB-5	T-20F

* Recommended clamping torque (N-m): CSTB-4=3.5, CSTB-5=5

INSERT

T*-R...



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

★ : First choice
☆ : Second choice

Designation	RE	Coated										INSL	IC	S	
		GH330													
T1-R14	0.14	●											14.4	9.525	4.76
T1-R28	0.28	●											14.4	9.525	4.76
T2-R14	0.14	●											17.8	12.7	6.35
T2-R28	0.28	●											17.8	12.7	6.35

● : Line up

Reference pages: Standard cutting conditions → I127

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grades	Cutting speed Vc (m/min)	Feed per tooth fz (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 the right hand cutter in right-hand rotation. Cut up from the bottom to prevent chip recutting.

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	26.211	
D25 X 1 tooth T1-type of inserts	M32				2	1.5		29.835
	M33	3.5			3	2	29.211	
	M35					1.5		33.376
	M36	4			3	2	31.670	
	M38					1.5		36.376
	M39	4			3	2	34.670	
	M40					3	2	
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
D50 X 4 teeth T1-type of inserts	M56		4	3	2	1.5		51.670
	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
D55 X 4 teeth T2-type of inserts	M68		4	3	2	1.5		63.670
	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