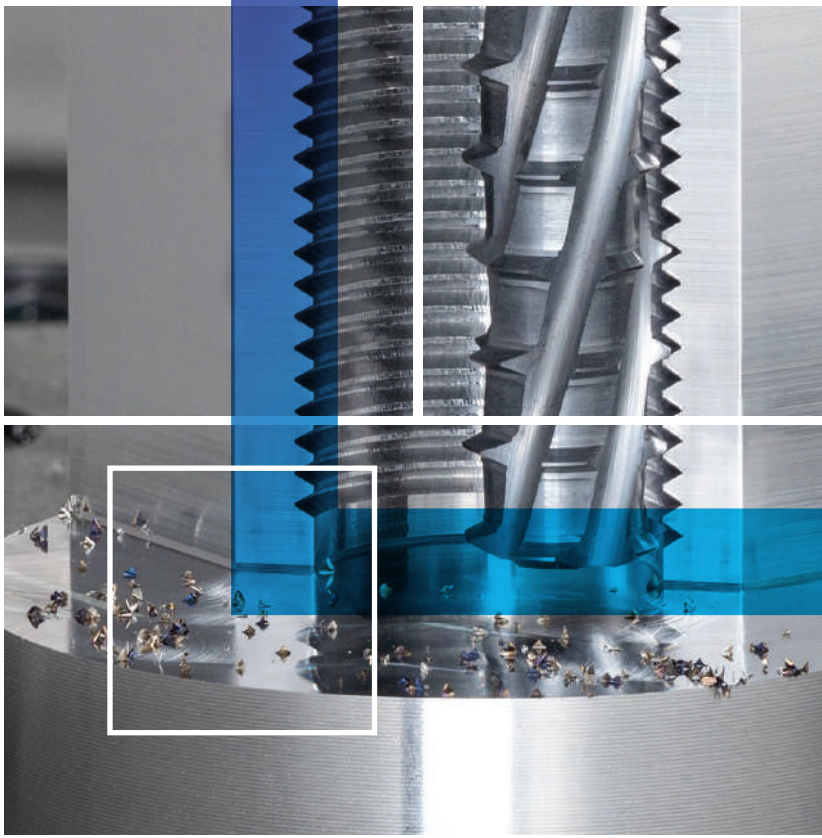
THREAD MAKING



THREAD MAKING

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Guide to Icons



› TS-THREAD Holder Page



› Insert Page



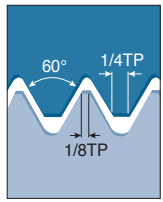
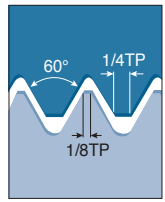
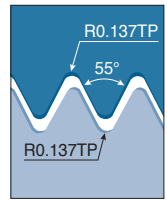
› Cutting Condition Page



T-TAP (Tapping)	
T-TAP Designation System	C76
Straight Flute with Spiral Point	C77
Right-hand Spiral Flute (40°)	C80
Recommended Cutting Conditions	C83

Tool Selection Guide

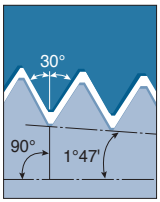
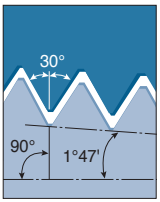
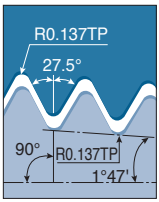
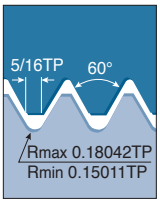
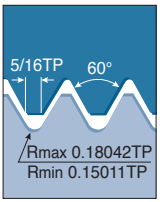
Solid carbide threading end mills

Thread	TS-THREAD		
	Metric ISO	**American UN**	**Whitworth**
			
Application	General usage for all industries	General usage for all industries	General industies. Pipe fittings and couplings
MTEC  General	● C13, C14	● C28, C29	● C41
MTECB  Internal coolant	● C15	● C30	● C41
MTECBF  Internal coolant more flutes	● C16	● C31	● C42
MTECQ  Reduced neck diameter for deep threading	● C17	● C32	
MTECZ  Internal coolant in the flutes	● C18	● C33	● C41
MTECH  Chamfering ability hard material	● C19	● C34	
MTECM  Triple lead for low cutting load	● C20	● C35	
MTECK  Double lead for low cutting load	● C21	● C38	
MTECS  Short flute	● C22	● C36	● C42
MTECSH  Short flute for hard material	● C24	● C39	
MTECD  Short flute drilling ability	● C25	● C40	
MTECI  Single point edge	● C26, C27		

▸ For correct tool choice and CNC programming, use the 'TS-thread guide' software (Available at www.taegutec.com)

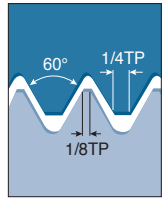
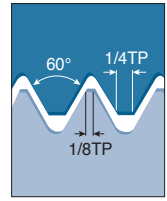
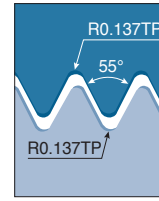
Tool Selection Guide

Solid carbide threading end mills

TS-THREAD				
NPT	**NPTF**	**BSPT**	**UNJ**	**MJ**
				
Steam, gas and water pipes	Steam, gas and water pipes. Dry seal	55° form for steam, gas and water pipes	Aviation and aerospace industry	Aviation and aerospace industry
● C43	● C44	● C45		
● C43		● C45		
● C43	● C44	● C45		
			● C46	● C46

Tool Selection Guide

Indexable insert type

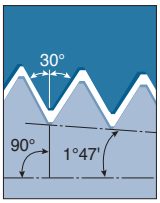
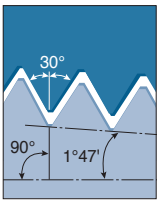
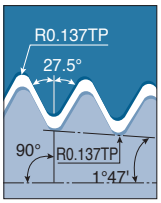
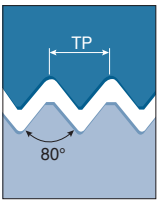
Thread	TS-THREAD		
	Metric ISO	**American UN**	**Whitworth**
			
Insert page	C56, C64	C57-C58, C65	C59, C66
Application	General usage for all industries	General usage for all industries	General industies. Pipe fittings and couplings
MTE D-1 C48  Single insert	●	●	●
MTE D-1-C C49  Solid carbide shank	●	●	●
MTE D-2 C50  Twin insert	●	●	●
TMTSRH C51  Helical end mill	●	●	●
MTF D C52  Large diameter thread	●	●	●
MTFLE D C53  Multi tooth-external threading	●	●	●
TMTSRH C54  Helical shell mill	●	●	●

▸ For correct tool choice and CNC programming, use the 'TS-thread guide' software (Available at www.taegutec.com)

ADVANCE CUTTING TaeguTec

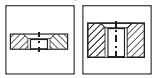
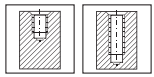
Tool Selection Guide

Indexable insert type

TS-THREAD			
NPT	**NPTF**	**BSPT**	**PG**
			
C60, C66	C61	C62, C67	C63
Steam, gas and water pipes	Steam, gas and water pipes (Dry seal)	55° form for steam, gas and water pipes	Electrical connector
●	●	●	●
●	●	●	●
●	●	●	●
●		●	
●	●	●	●
●	●	●	●
●		●	

Tool Selection Guide

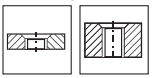
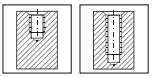
Straight flute with spiral point tap

Series		T-TAP Straight flute with spiral point tap		
		TPH...52B 	**TPH...52B05** 	**TPH...52B10** 
Pages		C77	C78	C79
Coating type		Uncoated	Steam tempered	TiN coated
Chamfer form		Form B 4-5 threads chamfer	Form B 4-5 threads chamfer	Form B 4-5 threads chamfer
Range (ISO metric)	Coarse threads	M2 - M20	M2 - M20	M2 - M20
	Fine threads	M8 - M16	M8 - M16	M8 - M16
Tolerance		ISO 2-6H	ISO 2-6H	ISO 2-6H
Material	P	○	●	●
	M		●	●
	K	○	○	○
	N	●	○	○
	S			○
Application	Through hole  (2xTDZ) (3xTDZ)	●	●	●
	Blind hole  (2xTDZ) (3xTDZ)			

● Recommended, ○ Suitable

Tool Selection Guide

40˚ Right-hand spiral flute tap

Series		T-TAP 40˚ Right-hand spiral flute tap		
		TPH...54C 	TPH...54C05 	TPH...54C10 
Pages		C80	C81	C82
Coating type		Uncoated	Steam tempered	TiN coated
Chamfer form		Form C 2-3 threads chamfer	Form C 2-3 threads chamfer	Form C 2-3 threads chamfer
Range (ISO metric)	Coarse threads	M2 - M20	M2 - M20	M2 - M20
	Fine threads	M8 - M16	M8 - M16	M8 - M16
Tolerance		ISO 2-6H	ISO 2-6H	ISO 2-6H
Material	P	○	●	●
	M		●	●
	K	○	○	○
	N	●	○	○
	S			○
Application	Through hole  (2xTDZ) (3xTDZ)			
	Blind hole  (2xTDZ) (3xTDZ)	●	●	●

● Recommended, ○ Suitable

TaeguTec Member IMC Group

Grades

Thread making grades

Grades	ISO	Characteristics & applications
TT9030 PVD coated	P20 – P40 M20 – M40 S20 – S40	• General machining of steel • General machining of stainless steel • General machining of heat-resistant alloy
TT5515	P10 – P30 M10 – M30 K10 – K30 S10 – S30 H10 – H30	• High speed machining of steel and hardened steel • General machining of stainless steel, cast iron and heat-resistant alloy
TT1040	P10 – P30 M10 – M30 K10 – K30 S10 – S30 H10 – H30	• High speed machining of steel and hardened steel Excellent wear and heat resistance • General machining of stainless steel, cast iron and heat-resistant alloy

TS-THREAD

Thread Milling



Designation System

TS-THREAD

Solid carbide end mill

MTEC	□	06	04	C	14	1.0	ISO	TT9030
1	2	3	4	5	6	7	8	9

1 TaeguTec mill thread

MT - Mill thread
E - End mill
C - Carbide

2 End mill type

□ - General
B - Internal coolant hole
BF - More flutes number
Q - Reduced neck diameter
Z - Coolant hole in the flutes
H - Chamfering ability
M - Triple lead
K - Double lead
S - Short flute
SH - Short flute for hard material
D - Drilling ability
I - Single point edge

3 Shank diameter

06 6.0 mm
10 10.0 mm

4 Cutting diameter

031 3.1 mm
04 4.0 mm

5 No. of flutes

C - 3 flutes
D - 4 flutes
E - 5 flutes
F - 6 flutes
G - 7 flutes
H - 8 flutes

6 Length of thread (APMX)

10 10.0 mm

7 Thread pitch

0.25-4.0 **mm** (Thread pitch)
72-7 **TPI** (Threads per inch)

8 Thread standard

ISO
UN
W
NPT
NPTF
BSPT
UNJ
MJ
UNJ

9 Grades

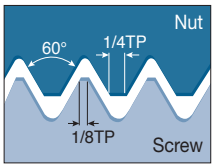
Coated
TT5515
TT9030
TT1040

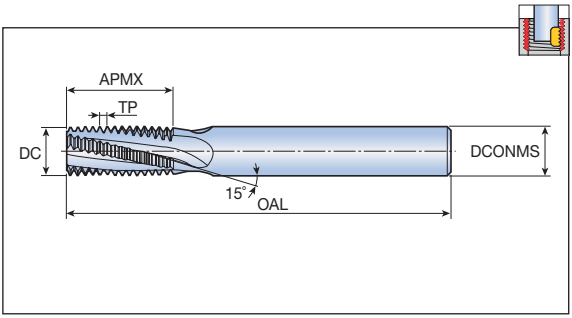
MTEC-ISO

TS-THREAD

Solid carbide threading end mills







Designation				TP (mm)	M coarse	M fine	Dimension (mm)				NOF	Grade
							DCONMS	DC	APMX	OAL		TT9030
MTEC	06022C5	0.5	ISO	0.5	M3	Ø ≥ 4	6	2.2	5.3	58	3	●
	06038C10	0.5	ISO	0.5	-	Ø ≥ 5	6	3.8	10.3	58	3	●
	06031C7	0.7	ISO	0.7	M4	Ø ≥ 5	6	3.1	7.4	58	3	●
	06045C10	0.75	ISO	0.75	-	Ø ≥ 6	6	4.5	10.0	58	3	●
	06036C9	0.8	ISO	0.8	M5	Ø ≥ 6	6	3.6	9.2	58	3	●
	0604C10	1.0	ISO	1.0	M6	Ø ≥ 7	6	4.0	10.5	58	3	●
	0604C14	1.0	ISO	1.0	M6	Ø ≥ 7	6	4.0	14.5	58	3	●
	0606C12	1.0	ISO	1.0	-	Ø ≥ 9	6	6.0	12.5	58	3	●
	0808D16	1.0	ISO	1.0	-	Ø ≥ 10	8	8.0	16.5	64	4	●
	0605C14	1.25	ISO	1.25	M8	Ø ≥ 10	6	5.0	14.4	58	3	●
	0605C19	1.25	ISO	1.25	M8	Ø ≥ 10	6	5.0	19.4	58	3	●
	0807C17	1.5	ISO	1.5	M10	Ø ≥ 12	8	7.0	17.3	64	3	●
	0807C24	1.5	ISO	1.5	M10	Ø ≥ 12	8	7.0	24.8	76	3	●
	1010D21	1.5	ISO	1.5	-	Ø ≥ 14	10	10.0	21.8	73	4	●
	1616F33	1.5	ISO	1.5	-	Ø ≥ 20	16	16.0	33.8	100	6	●
	0808C20	1.75	ISO	1.75	M12	Ø ≥ 14	8	8.0	20.1	64	3	●
	0808C28	1.75	ISO	1.75	M12	Ø ≥ 14	8	8.0	28.9	76	3	●
	1010C27	2.0	ISO	2.0	M14	Ø ≥ 15	10	10.0	27.0	73	3	●
	1010C39	2.0	ISO	2.0	M14	Ø ≥ 15	10	10.0	39.0	100	3	●
	1212D27	2.0	ISO	2.0	-	Ø ≥ 18	12	12.0	27.0	84	4	●
	2020F41	2.0	ISO	2.0	-	Ø ≥ 26	20	20.0	41.0	105	6	●
	1414D33	2.5	ISO	2.5	M20	Ø ≥ 22	14	14.0	33.8	84	4	●
	1414D48	2.5	ISO	2.5	M20	Ø ≥ 22	14	14.0	48.8	107	4	●
	1616C40	3.0	ISO	3.0	M24	Ø ≥ 25	16	16.0	40.5	100	3	●
	1616C58	3.0	ISO	3.0	M24	Ø ≥ 25	16	16.0	58.5	120	3	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

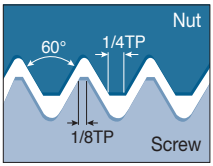
TaeguTec

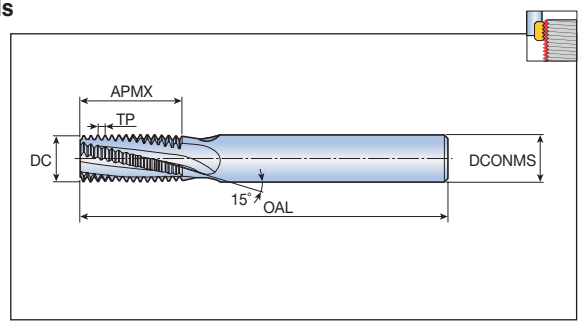
MTEC E-ISO

TS-THREAD

Solid carbide external threading end mills







Designation	TP (mm)	Dimension (mm)				NOF	Grade
		DCONMS	DC	APMX	OAL		TT9030
MTEC E 1010D16 1.0 ISO	1.0	10	10.0	16.5	73	4	●
1212E20 1.0 ISO	1.0	12	12.0	20.5	84	5	●
1010D16 1.25 ISO	1.25	10	10.0	16.9	73	4	●
1010D15 1.5 ISO	1.5	10	10.0	15.8	73	4	●
1212D20 1.5 ISO	1.5	12	12.0	20.3	84	4	●
1212D20 1.75 ISO	1.75	12	12.0	20.1	84	4	●
1010C17 2.0 ISO	2.0	10	10.0	17.0	73	3	●
1212D21 2.0 ISO	2.0	12	12.0	21.0	84	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

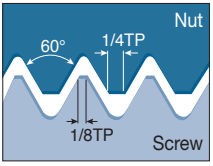
ADVANCE CUTTING TaeguTec

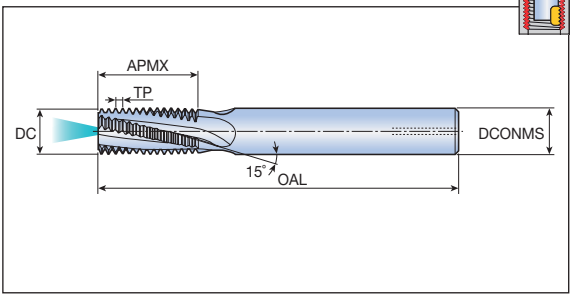
MTECB-ISO

TS-THREAD

Solid carbide threading end mills with a central coolant hole







Designation				TP (mm)	M coarse	M fine	Dimension (mm) DCONMS	DC	APMX	OAL	NOF	Grade TT9030
MTECB	06038C10	0.5	ISO	0.5	-	Ø ≥ 5	6	3.8	10.3	58	3	●
	06031C7	0.7	ISO	0.7	M4	Ø ≥ 5	6	3.1	7.4	58	3	●
	06045C10	0.75	ISO	0.75	-	Ø ≥ 6	6	4.5	10.1	58	3	●
	1010D24	0.75	ISO	0.75	-	Ø ≥ 12	10	10.0	24.4	73	4	●
	06038C9	0.8	ISO	0.8	M5	Ø ≥ 6	6	3.8	9.2	58	3	●
	06046C10	1.0	ISO	1.0	M6	Ø ≥ 7	6	4.6	10.5	58	3	●
	06046C14	1.0	ISO	1.0	M6	Ø ≥ 7	6	4.6	14.5	58	3	●
	0606C12	1.0	ISO	1.0	-	Ø ≥ 9	6	6.0	12.5	58	3	●
	0808D16	1.0	ISO	1.0	-	Ø ≥ 10	8	8.0	16.5	64	4	●
	1010D24	1.0	ISO	1.0	-	Ø ≥ 12	10	10.0	24.5	73	4	●
	0606C14	1.25	ISO	1.25	M8	Ø ≥ 10	6	6.0	14.4	58	3	●
	0606C19	1.25	ISO	1.25	M8	Ø ≥ 10	6	6.0	19.4	58	3	●
	08078C17	1.5	ISO	1.5	M10	Ø ≥ 12	8	7.8	17.0	64	3	●
	08078C24	1.5	ISO	1.5	M10	Ø ≥ 12	8	7.8	24.8	76	3	●
	1010D21	1.5	ISO	1.5	-	Ø ≥ 14	10	10.0	21.8	73	4	●
	1212D26	1.5	ISO	1.5	-	Ø ≥ 16	12	12.0	26.3	84	4	●
	1616F33	1.5	ISO	1.5	-	Ø ≥ 20	16	16.0	33.8	105	6	●
	1009C20	1.75	ISO	1.75	M12	Ø ≥ 12	10	9.0	20.1	73	3	●
	1009C28	1.75	ISO	1.75	M12	Ø ≥ 12	10	9.0	28.9	73	3	●
	1010C27	2.0	ISO	2.0	M14	Ø ≥ 15	10	10.0	27.0	73	3	●
	12118D27	2.0	ISO	2.0	M16	Ø ≥ 17	12	11.8	27.0	84	4	●
	12118D39	2.0	ISO	2.0	M16	Ø ≥ 17	12	11.8	39.0	105	4	●
	1615E33	2.5	ISO	2.5	M20	Ø ≥ 22	16	15.0	33.8	105	5	●
	1615E48	2.5	ISO	2.5	M20	Ø ≥ 22	16	15.0	48.8	105	5	●
	2018D58	3.0	ISO	3.0	M24	Ø ≥ 25	20	18.0	58.5	120	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

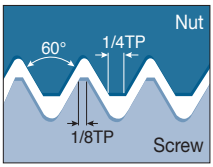
TaeguTec

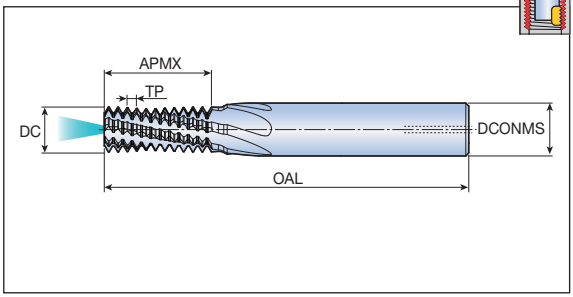
MTECBF-ISO

TS-THREAD

Solid carbide threading end mills with large number of flutes







Designation	TP (mm)	M Coarse	M Fine	Dimension (mm)				NOF	Grade
				DCONMS	DC	APMX	OAL		TT9030
MTECBF 06048F10 1.0 ISO	1.0	M6	Ø ≥ 7	6	4.8	10.2	58	6	●
08064G14 1.25 ISO	1.25	M8	Ø ≥ 10	8	6.4	14.0	64	7	●
1008G16 1.5 ISO	1.5	M10	Ø ≥ 12	10	8.0	16.7	73	7	●
12095G20 1.75 ISO	1.75	M12	Ø ≥ 12	12	9.5	20.0	84	7	●

Cutting Condition C72

▸ NOF: Number of flutes

●: Standard items

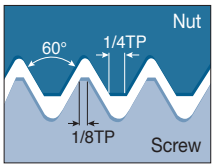
ADVANCE CUTTING TaeguTec

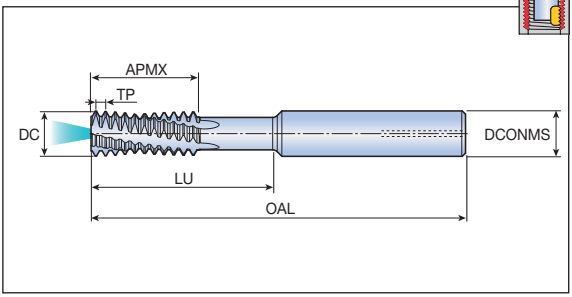
MTECQ-ISO

TS-THREAD

Solid carbide threading end mills with reduced neck diameter for deep holes







Designation		TP (mm)	TDZ	Dimension (mm)					NOF	Grade
				DCONMS	DC	APMX	LU	OAL		TT9030
MTECQ	**1010D32 1.0 ISO**	1.0	Ø ≥ 12	10	10.0	18.0	32.0	73	4	●
	1212D38 1.0 ISO	1.0	Ø ≥ 14	12	12.0	21.0	38.0	84	4	●
	1010D30 1.5 ISO	1.5	Ø ≥ 13	10	10.0	18.0	30.0	73	4	●
	2020F60 1.5 ISO	1.5	Ø ≥ 24	20	20.0	36.0	60.0	105	6	●
	1212D42 2.0 ISO	2.0	Ø ≥ 16	12	12.0	24.0	42.0	84	4	●
	2020F56 2.0 ISO	2.0	Ø ≥ 24	20	20.0	34.0	56.0	105	6	●
	2020D45 3.5 ISO	3.5	Ø ≥ 26	20	20.0	28.0	45.5	105	4	●

Cutting Condition C70

- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

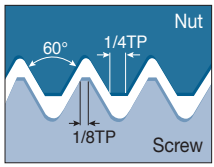
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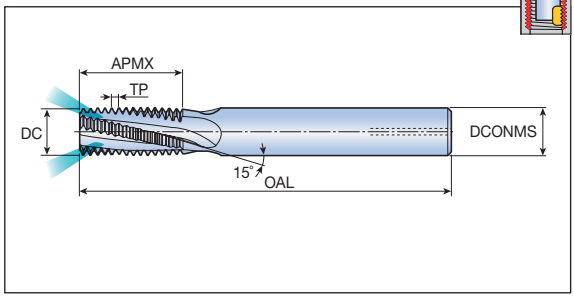
MTECZ-ISO

TS-THREAD

Solid carbide threading end mills with internal coolant holes directed to the cutting edges







Designation				TP (mm)	M coarse	M fine	Dimension (mm)				NOF	Grade TT9030
							DCONMS	DC	APMX	OAL		
MTECZ	**06048C10**	**1.0**	**ISO**	1.0	M6	Ø ≥ 7	6	4.8	10.5	58	3	●
	0606C12	**1.0**	**ISO**	1.0	-	Ø ≥ 9	6	6.0	12.5	58	3	●
	0808D16	**1.0**	**ISO**	1.0	-	Ø ≥ 10	8	8.0	16.5	64	4	●
	0606C14	**1.25**	**ISO**	1.25	M8	Ø ≥ 10	6	6.0	14.4	58	3	●
	0606C19	**1.25**	**ISO**	1.25	M8	Ø ≥ 10	6	6.0	19.4	58	3	●
	08078C17	**1.5**	**ISO**	1.5	M10	Ø ≥ 12	8	7.8	17.0	64	3	●
	1010D21	**1.5**	**ISO**	1.5	-	Ø ≥ 14	10	10.0	21.8	73	4	●
	1212D26	**1.5**	**ISO**	1.5	-	Ø ≥ 16	12	12.0	26.3	84	4	●
	1616E33	**1.5**	**ISO**	1.5	-	Ø ≥ 20	16	16.0	33.8	101	5	●
	1009C20	**1.75**	**ISO**	1.75	M12	Ø ≥ 12	10	9.0	20.1	73	3	●
	1009C28	**1.75**	**ISO**	1.75	M12	Ø ≥ 12	10	9.0	28.9	73	3	●
	1010C27	**2.0**	**ISO**	2.0	M14	Ø ≥ 15	10	10.0	27.0	73	3	●
	12118D27	**2.0**	**ISO**	2.0	M16	Ø ≥ 17	12	11.8	27.0	84	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

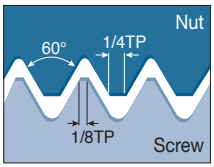
ADVANCE CUTTING TaeguTec

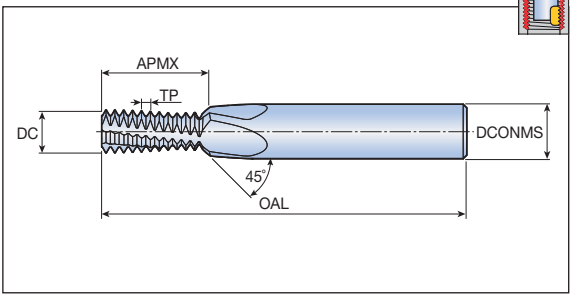
MTECH-ISO

TS-THREAD

Solid carbide threading end mills for threading and chamfering on hardened steel







Designation				TP (mm)	M Coarse	M Fine	Dimension (mm)				NOF	Grade
							DCONMS	DC	APMX	OAL		TT5515
MTECH	**0604C9**	**0.8**	**ISO**	0.8	M5	Ø ≥ 5.9	6	4.0	9.2	58	3	●
	08048D10	**1.0**	**ISO**	1.0	M6	Ø ≥ 6.9	8	4.8	10.5	64	4	●
	0806D14	**1.25**	**ISO**	1.25	M8	Ø ≥ 9.9	8	6.0	13.7	64	4	●
	12095D20	**1.75**	**ISO**	1.75	M12	-	12	9.5	20.1	84	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

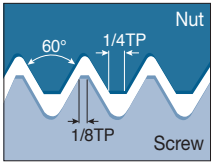
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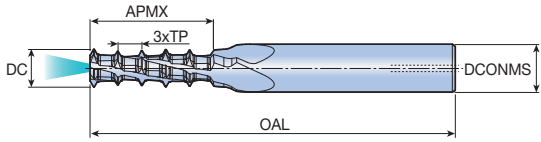
MTECM-ISO

TS-THREAD

Triple lead solid carbide threading end mills for low cutting loads







• Lead: 3 x pitch

Designation	TP (mm)	M Coarse	M Fine	Dimension (mm)				NOF	Grade
				DCONMS	DC	APMX	OAL		TT9030
MTECM 06031C11 0.7 ISO	0.7	M4	-	6	3.1	10.8	58	3	●
06039C12 0.8 ISO	0.8	M5	-	6	3.9	13.2	58	3	●
06047D14 1.0 ISO	1.0	M6	-	6	4.7	15.4	58	4	●
08079E21 1.0 ISO	1.0	-	M10	8	7.9	21.4	64	5	●
10096D32 1.75 ISO	1.75	M12	-	10	9.6	32.3	81	4	●
16131E42 2.0 ISO	2.0	M16	-	16	13.1	42.9	105	5	●

Cutting Condition C72

▸ NOF: Number of flutes

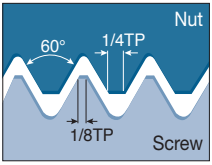
●: Standard items

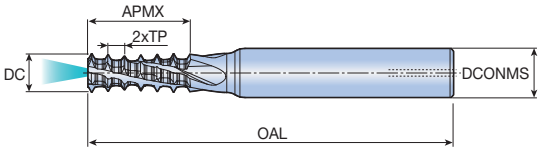
MTECK-ISO

TS-THREAD

Double lead solid carbide threading end mills for low cutting loads







• Lead: 2 x pitch

Designation	TP (mm)	M Coarse	M Fine	Dimension (mm) DCONMS	DC	APMX	OAL	NOF	Grade TT9030
MTECK 06032D8 0.5 ISO	0.5	-	M4	6	3.2	8.2	58	4	●
06031C9 0.7 ISO	0.7	M4	-	6	3.1	8.7	58	3	●
06039C10 0.8 ISO	0.8	M5	-	6	3.9	10.8	58	3	●
06047D12 1.0 ISO	1.0	M6	-	6	4.7	12.5	58	4	●
08063D16 1.25 ISO	1.25	M8	-	8	6.3	16.9	64	4	●
08079D21 1.5 ISO	1.5	M10	-	8	7.9	21.7	64	4	●
10098E24 1.5 ISO	1.5	-	M13	10	9.8	24.8	73	5	●
120117E28 1.5 ISO	1.5	-	M16	12	11.7	29.3	94	5	●
160125F33 1.5 ISO	1.5	-	M16	16	12.5	33.7	93	6	●
10096D24 1.75 ISO	1.75	M12	-	10	9.6	25.3	73	4	●
12112D28 2.0 ISO	2.0	M16	-	12	11.2	28.9	84	4	●
16131E32 2.0 ISO	2.0	M16	-	16	13.1	32.9	93	5	●

Cutting Condition C72

▸ NOF: Number of flutes

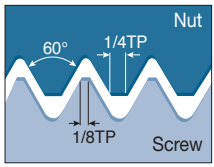
●: Standard items

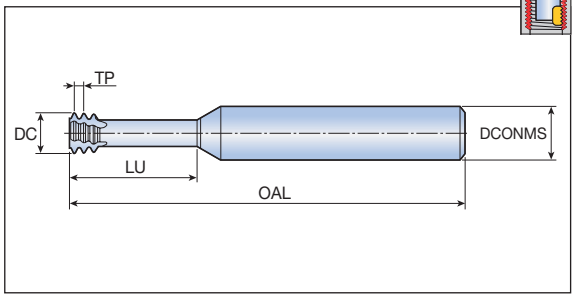
MTECS-ISO

TS-THREAD

Solid carbide threading end mills with short cutting flutes for low cutting loads







Designation				TP (mm)	TDZ	Dimension (mm)				NOF	Grade
						DCONMS	DC	LU	OAL		TT9030
MTECS	**03007C2**	**0.25**	**ISO**	0.25	M1	3	0.72	2.5	39	3	●
	03009C3	**0.25**	**ISO**	0.25	M1.2	3	0.9	3.0	39	3	●
	03011C4	**0.3**	**ISO**	0.3	M1.4	3	1.05	4.0	39	3	●
	03012C5	**0.35**	**ISO**	0.35	M1.6	3	1.20	5.0	39	3	●
	06016C4	**0.4**	**ISO**	0.4	M2	6	1.53	4.5	58	3	●
	03016C6	**0.4**	**ISO**	0.4	M2	3	1.53	6.0	39	3	●
	03017C7	**0.45**	**ISO**	0.45	M2.2	3	1.65	7.0	39	3	●
	06017C5	**0.45**	**ISO**	0.45	M2.2	6	1.65	5.0	58	3	●
	0602C5	**0.45**	**ISO**	0.45	M2.5	6	1.95	5.5	58	3	●
	0602C5	**0.45**	**ISO-L**	0.45	M2.5	6	1.95	5.5	100	3	●
	0602C7	**0.45**	**ISO**	0.45	M2.5	6	1.95	7.5	58	3	●
	06024C6	**0.5**	**ISO**	0.5	M3	6	2.37	6.5	58	3	●
	06024C9	**0.5**	**ISO**	0.5	M3	6	2.37	9.5	58	3	●
	06024C9	**0.5**	**ISO-L**	0.5	M3	6	2.37	9.5	100	3	●
	03024C12	**0.5**	**ISO**	0.5	M3	3	2.4	12.5	39	3	●
	03024C15	**0.5**	**ISO**	0.5	M3	3	2.4	15.5	39	3	●
	06054D20	**0.5**	**ISO**	0.5	M6	6	5.35	20.0	58	4	●
	06028C7	**0.6**	**ISO**	0.6	M3.5	6	2.75	7.5	58	3	●
	06028C10	**0.6**	**ISO**	0.6	M3.5	6	2.75	10.5	58	3	●
	06031C9	**0.7**	**ISO**	0.7	M4	6	3.1	9.0	58	3	●
	06031C12	**0.7**	**ISO**	0.7	M4	6	3.1	12.5	58	3	●
	06031C12	**0.7**	**ISO-L**	0.7	M4	6	3.1	12.5	100	3	●
	06031C16	**0.7**	**ISO**	0.7	M4	6	3.1	16.7	58	3	●
	0808D25	**0.75**	**ISO**	0.75	M10	8	8.0	25.0	64	4	●
	06038C12	**0.8**	**ISO**	0.8	M5	6	3.8	12.5	58	3	●
	06038C16	**0.8**	**ISO**	0.8	M5	6	3.8	16.0	58	3	●
	06038C16	**0.8**	**ISO-L**	0.8	M5	6	3.8	16.0	100	3	●
	0604C20	**0.8**	**ISO**	0.8	M5	6	4.0	20.8	58	3	●
	06047C14	**1.0**	**ISO**	1.0	M6	6	4.65	14.0	58	3	●
	06047C20	**1.0**	**ISO**	1.0	M6	6	4.65	20.0	58	3	●
	06047C20	**1.0**	**ISO-L**	1.0	M6	6	4.65	20.0	100	3	●
	06048C25	**1.0**	**ISO**	1.0	M6	6	4.8	25.0	58	3	●
	0606C18	**1.25**	**ISO**	1.25	M8	6	6.0	18.0	58	3	●
	0606C24	**1.25**	**ISO**	1.25	M8	6	6.0	24.0	58	3	●
	0606C24	**1.25**	**ISO-L**	1.25	M8	6	6.0	24.6	100	3	●

Cutting Condition C74

- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

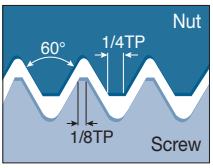
ADVANCE CUTTING TaeguTec

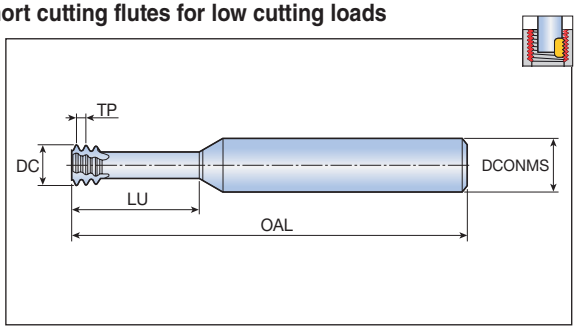
MTECS-ISO

TS-THREAD

Solid carbide threading end mills with short cutting flutes for low cutting loads







Designation	TP (mm)	TDZ	Dimension (mm)				NOF	Grade
			DCONMS	DC	LU	OAL		TT9030
MTECS 08078C23 1.5 ISO	1.5	M10	8	7.8	23.0	64	3	●
08078C31 1.5 ISO	1.5	M10	8	7.8	31.5	64	3	●
1009C26 1.75 ISO	1.75	M12	10	9.0	26.0	73	3	●
1009C37 1.75 ISO	1.75	M12	10	9.0	37.8	73	3	●
12118D35 2.0 ISO	2.0	M16	12	11.8	35.0	84	4	●
12118D50 2.0 ISO	2.0	M16	12	11.8	50.0	100	4	●
1615E43 2.5 ISO	2.5	M20	16	15.0	43.0	100	5	●

Cutting Condition C74

- TDZ: Thread diameter size
- NOF: Number of flutes

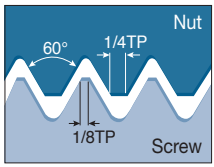
●: Standard items

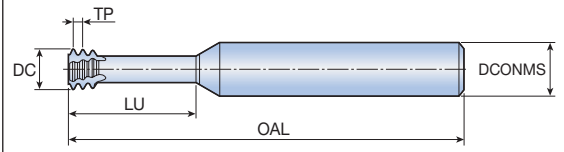
MTECSH-ISO

TS-THREAD

Left-handed solid carbide threading end mills with short cutting flutes for hardened steel







• Left-hand tools (CNC code M04)

Designation				TP (mm)	TDZ	Dimension (mm)				NOF	Grade
						DCONMS	DC	LU	OAL		TT1040
MTECSH	**03011C4**	**0.3**	**ISO**	0.3	M1.4	3	1.05	4.0	39	3	●
	03012C5	**0.35**	**ISO**	0.35	M1.6	3	1.20	4.8	39	3	●
	03016C6	**0.4**	**ISO**	0.4	M2	3	1.55	6.0	39	3	●
	06016C4	**0.4**	**ISO**	0.4	M2	6	1.55	4.5	58	3	●
	06017C5	**0.45**	**ISO**	0.45	M2.2	6	1.65	5.0	58	3	●
	0602C5	**0.45**	**ISO**	0.45	M2.5	6	1.95	5.5	58	3	●
	0602C7	**0.45**	**ISO**	0.45	M2.5	6	1.95	7.5	58	3	●
	06024C6	**0.5**	**ISO**	0.5	M3	6	2.35	6.5	58	3	●
	06024C9	**0.5**	**ISO**	0.5	M3	6	2.35	9.5	58	3	●
	06028C7	**0.6**	**ISO**	0.6	M3.5	6	2.75	7.5	58	3	●
	06028C10	**0.6**	**ISO**	0.6	M3.5	6	2.75	10.0	58	3	●
	06031C9	**0.7**	**ISO**	0.7	M4	6	3.1	9.0	58	3	●
	06031C12	**0.7**	**ISO**	0.7	M4	6	3.1	12.5	58	3	●
	06038C12	**0.8**	**ISO**	0.8	M5	6	3.8	12.5	58	3	●
	06038C16	**0.8**	**ISO**	0.8	M5	6	3.8	16.0	58	3	●
	06047C14	**1.0**	**ISO**	1.0	M6	6	4.65	14.0	58	3	●
	06047C20	**1.0**	**ISO**	1.0	M6	6	4.65	20.0	58	3	●
	0606C18	**1.25**	**ISO**	1.25	M8	6	5.95	18.0	58	3	●
	0606C24	**1.25**	**ISO**	1.25	M8	6	5.95	24.0	58	3	●
	08078C23	**1.5**	**ISO**	1.5	M10	8	7.8	23.0	64	3	●
	1009C26	**1.75**	**ISO**	1.75	M12	10	9.0	26.0	73	3	●
	12118D35	**2.0**	**ISO**	2.0	M16	12	11.8	35.0	84	4	●

Cutting Condition C74

▸ TDZ: Thread diameter size
▸ NOF: Number of flutes

●: Standard items

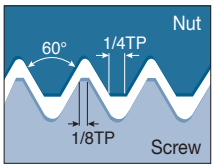
ADVANCE CUTTING TaeguTec

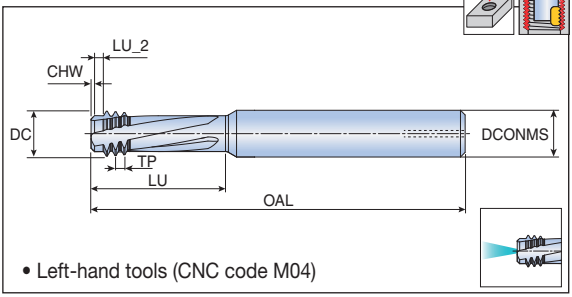
MTECD-ISO

TS-THREAD

Left-handed solid carbide threading end mills for hole-making, threading and chamfering







• Left-hand tools (CNC code M04)

Designation	TP (mm)	TDZ	Dimension (mm)						NOF	Coolant hole	Grade TT9030
			DCONMS	DC	LU	OAL	CHW	LU_2			
MTECD 06032C11 0.7 ISO	0.7	M4	6	3.15	11.6	58	0.2	0.7	3	x	●
0604C14 0.8 ISO	0.8	M5	6	4.0	14.4	58	0.3	0.8	3	x	●
08047C14 1.0 ISO	1.0	M6-M9	8	4.7	14.0	64	0.4	1.0	3	●	●
08061D18 1.25 ISO	1.25	M8-M12	8	6.1	18.0	64	0.5	1.3	4	●	●
08078D23 1.5 ISO	1.5	M10-M15	8	7.8	23.0	64	0.6	1.5	4	●	●
1009D26 1.75 ISO	1.75	M12	10	9.0	26.0	73	0.6	1.8	4	●	●
12118D35 2.0 ISO	2.0	M16-M23	12	11.8	35.0	84	0.6	2.0	4	●	●

Cutting Condition C74

- Thread hole, thread and chamfer by circular interpolation
- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

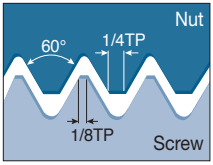
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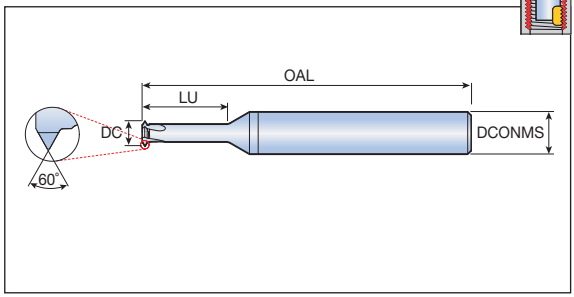
MTECI-ISO

TS-THREAD

Solid carbide threading end mills with single point cutting edges for small holes







Designation	TP (mm)	M Coarse	M Fine	Dimension (mm)				NOF	Grade
				DCONMS	DC	LU	OAL		TT5515
MTECI 03007C3 0.25 ISO	0.25	M1	-	3	0.72	3.6	39	3	●
03009C4 0.25 ISO	0.25	M1.2	M1.4, M1.6	3	0.9	4.3	39	3	●
03011C5 0.3 ISO	0.3	M1.4	-	3	1.05	5.0	39	3	●
03012C6 0.35 ISO	0.35	M1.6	M2, M2.2	3	1.2	5.7	39	3	●
03016C7 0.4 ISO	0.4	M2	-	3	1.55	7.1	39	3	●
03024C10 0.5 ISO	0.5	M3	M3.5, M4	3	2.37	10.6	39	3	●

Cutting Condition C70

▸ NOF: Number of flutes

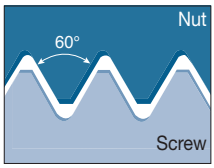
●: Standard items

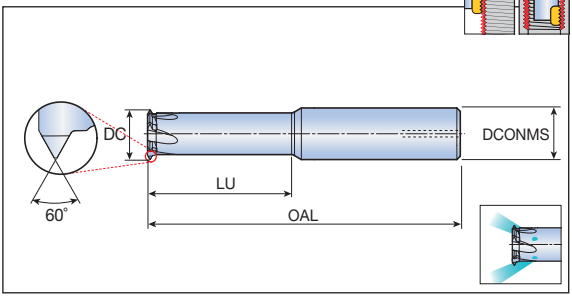
MTECI-60

TS-THREAD

Solid carbide threading end mills with single point cutting edges for 60° partial profiles







Designation		TP (mm)	TPI	TDZ	Dimension (mm)				NOF	Coolant hole	Grade	
					DCONMS	DC	LU	OAL			TT5515	TT9030
MTECI	**03019C5 A60**	0.35-0.6	72-40	Ø ≥ 2	3	1.9	5.2	39	3	x	●	
	03024C7 A60	0.5-0.8	48-32	Ø ≥ 2.5	3	2.4	7.1	38	3	x	●	
	06032C9 A60	0.5-1.0	48-24	Ø ≥ 3	6	3.2	9.5	57	3	x	●	
	0604C12 A60	0.5-1.0	48-24	Ø ≥ 4	6	4.0	12.5	58	3	x	●	
	0605D20 A60	Int. 0.5-0.8	56-28	Ø ≥ 6	6	5.0	20.0	58	4	●		●
	0808D28 A60	Ext. 0.4-0.8	64-32	Ø ≥ 9	8	8.0	28.0	64	4	●		●
	0808D30 A60	Int. 1.0-1.75 Ext. 0.8-1.5	28-14 32-16	Ø ≥ 10	8	8.0	30.0	64	4	●		●
	1010D35 A60			Ø ≥ 12	10	10.0	35.0	73	4	●		●
	1212E39 A60			Ø ≥ 14	12	12.0	39.0	84	5	●		●
	1212E40 A60	Int. 2.0-3.0 Ext. 1.75-2.5	13-8 15-10	Ø ≥ 16	12	12.0	40.0	84	5	●		●
	1614E45 A60			Ø ≥ 18	16	14.0	45.0	101	5	●		●
	1616E50 A60			Ø ≥ 20	16	16.0	50.0	101	5	●		●

Cutting Condition C70

- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

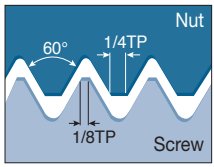
TaeguTec

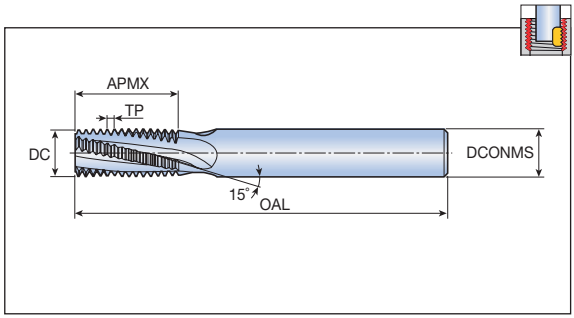
MTEC-UN

TS-THREAD

Solid carbide threading end mills







Designation			TPI	UNC	UNF	UNEF	Dimension (mm)				NOF	Grade
							DCONMS	DC	APMX	OAL		TT9030
MTEC	06025C6	40 UN	40	#5	-	-	6	2.5	6.0	58	3	●
	06032C6	32 UN	32	#8	#10	#12	6	3.2	6.8	58	3	●
	0604C11	28 UN	28	-	1/4	-	6	4.0	11.3	58	3	●
	0606C14	28 UN	28	-	-	7/16-1/2	6	6.0	14.5	58	3	●
	0605C14	24 UN	24	-	5/16	-	6	5.0	14.3	58	3	●
	0807C21	24 UN	24	-	3/8	9/16-5/8	8	7.0	20.0	64	3	●
	06045C12	20 UN	20	1/4	-	-	6	4.5	12.1	58	3	●
	0807C21	20 UN	20	-	7/16-1/2	-	8	7.0	20.0	64	3	●
	1212E27	20 UN	20	-	-	3/4-1	12	12.0	27.3	84	5	●
	0605C14	18 UN	18	5/16	-	-	6	5.0	14.8	58	3	●
	1010D26	18 UN	18	-	9/16-5/8	1 1/8-1 5/8	10	10.0	26.1	73	4	●
	0606C16	16 UN	16	3/8	-	-	6	6.0	16.7	57	3	●
	1212D31	16 UN	16	-	3/4	-	12	12.0	30.0	83	4	●
	1615E37	14 UN	14	-	7/8	-	16	15.0	37.2	100	5	●
	0808C22	13 UN	13	1/2	-	-	8	8.0	22.5	63	3	●
	1010C26	12 UN	12	9/16	-	-	10	10.0	26.5	72	3	●
	1616E41	12 UN	12	-	1-1 1/2	-	16	16.0	41.3	100	5	●
	1010C28	11 UN	11	5/8	-	-	10	10.0	28.9	72	3	●
	1212C34	10 UN	10	3/4	-	-	12	12.0	34.3	83	3	●
	1615C38	9 UN	9	7/8	-	-	16	15.0	38.1	101	3	●
	1616C42	8 UN	8	1	-	-	16	16.0	42.9	100	3	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

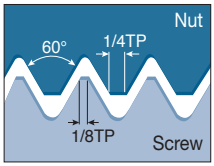
ADVANCE CUTTING TaeguTec

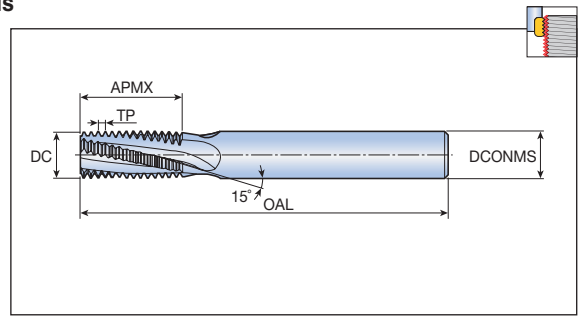
MTEC E-UN

TS-THREAD

Solid carbide external threading end mills







Designation		TPI	Dimension (mm)				NOF	Grade
			DCONMS	DC	APMX	OAL		TT9030
MTEC E	**1010D16 24 UN**	24	10	10.0	16.4	73	4	●
	1212E21 20 UN	20	12	12.0	21.0	84	5	●
	1212D20 12 UN	12	12	12.0	20.1	84	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

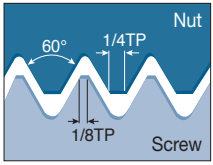
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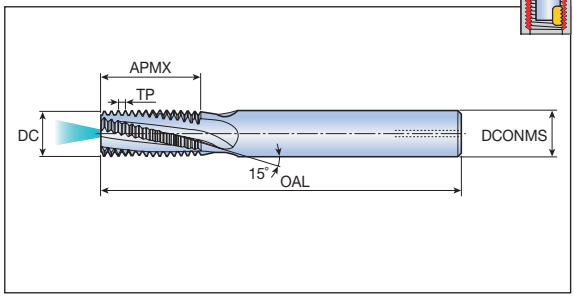
MTECB-UN

TS-THREAD

Solid carbide threading end mills with a central coolant hole







	Designation	TPI	UNC	UNF	UNEF	Dimension (mm)				NOF	Grade
						DCONMS	DC	APMX	OAL		TT9030
MTECB	06032C6 32 UN	32	#8	#10	#12	6	3.2	6.8	58	3	●
	0606C14 32 UN	32	-	-	7/16-1/2	6	6.0	16.0	58	3	●
	0808D18 32 UN	32	-	-	3/8	8	8.0	18.7	64	4	●
	0605C11 28 UN	28	-	1/4	-	6	5.0	11.3	58	3	●
	08066C14 24 UN	24	-	5/16	-	8	6.6	14.3	64	3	●
	0808D21 24 UN	24	-	-	9/16-5/8	8	8.0	20.6	64	4	●
	0808C21 20 UN	20	-	7/16	-	8	8.0	21.0	64	3	●
	1010D22 20 UN	20	-	1/2	-	10	10.0	22.3	73	4	●
	06056C14 18 UN	18	5/16	-	-	6	5.6	14.8	58	3	●
	12113D26 18 UN	18	-	9/16-5/8	11/8-15/8	12	11.3	26.1	84	4	●
	08067C16 16 UN	16	3/8	-	-	8	6.7	16.7	64	3	●
	1212D31 16 UN	16	-	3/4	-	12	12.0	31.0	84	4	●
	08077C20 14 UN	14	7/16	-	-	8	7.7	20.9	64	3	●
	1616E37 14 UN	14	-	7/8	-	16	16.0	37.2	105	5	●
	10092C22 13 UN	13	1/2	-	-	10	9.2	22.5	73	3	●
	12114C28 11 UN	11	5/8	-	-	12	11.4	28.9	84	3	●
	16144D34 10 UN	10	3/4	-	-	16	14.4	34.3	105	4	●
	20195D42 8 UN	8	1	-	-	20	19.5	42.9	105	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

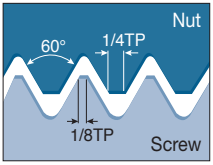
ADVANCE CUTTING TaeguTec

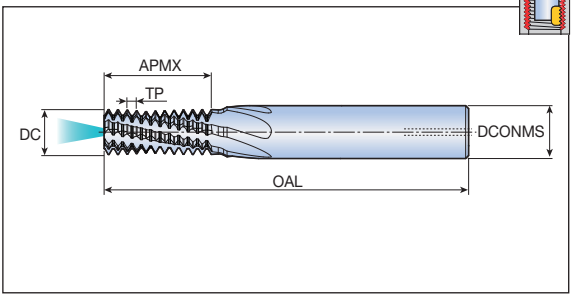
MTECBF-UN

TS-THREAD

Solid carbide threading end mills with large number of flutes







Designation	TPI	UNC	UNF	UNEF	Dimension (mm)				NOF	Grade
					DCONMS	DC	APMX	OAL		TT9030
MTECBF 08066G14 24 UN	24	-	5/16	-	8	6.6	14.2	64	7	●
10066G14 24 UN	24	-	5/16	-	10	6.6	14.2	73	7	●
06048E12 20 UN	20	1/4	-	-	6	4.8	12.0	58	5	●
10092H21 20 UN	20	-	7/16	-	10	9.2	20.9	73	8	●
12092H21 20 UN	20	-	7/16	-	12	9.2	20.9	84	8	●
0806F14 18 UN	18	5/16	-	-	8	6.0	14.7	64	6	●
16125H26 18 UN	18	-	9/16-5/8	11/16	16	12.5	26.0	105	8	●
10074F16 16 UN	16	3/8	-	-	10	7.4	16.6	73	6	●
10085F20 14 UN	14	7/16	-	-	10	8.5	20.8	73	6	●
12098F24 13 UN	13	1/2	-	-	12	9.8	24.3	84	6	●
16116F26 12 UN	12	5/8	1-1 1/2	-	16	11.6	26.4	105	6	●

Cutting Condition C72

▸ NOF: Number of flutes

●: Standard items

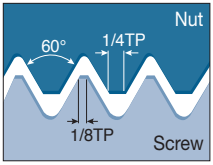
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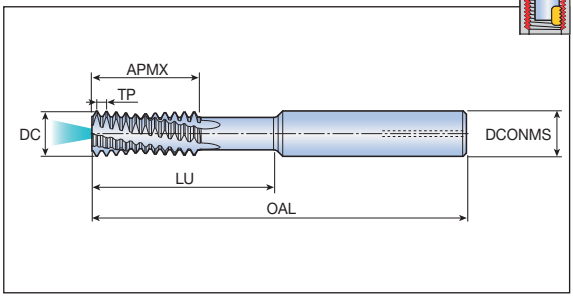
MTECQ-UN

TS-THREAD

Solid carbide threading end mills with reduced neck diameter for deep holes







Designation		TPI	TDZ	Dimension (mm)					NOF	Grade
				DCONMS	DC	APMX	LU	OAL		TT9030
MTECQ	**1010D30 20 UN**	20	Ø ≥ 12	10	10.0	17.8	30.5	73	4	●
	1616F43 20 UN	20	Ø ≥ 18	16	16.0	25.4	43.2	105	6	●
	1616E42 16 UN	16	Ø ≥ 19	16	16.0	25.4	42.9	105	5	●
	1212D42 12 UN	12	Ø ≥ 16	12	12.0	25.4	42.3	84	4	●

Cutting Condition C70

- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

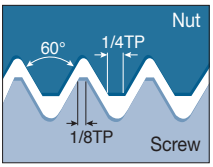
ADVANCE CUTTING TaeguTec

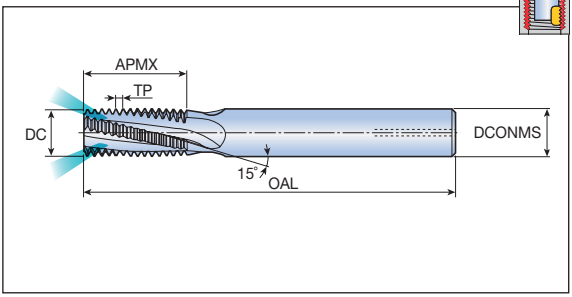
MTECZ-UN

TS-THREAD

Solid carbide threading end mills with internal coolant holes directed to the cutting edges







Designation		TPI	UNC	UNF	UNEF	Dimension (mm)				NOF	Grade
						DCONMS	DC	APMX	OAL		TT9030
MTECZ	1010D22 20 UN	20	-	1/2	-	10	10.0	22.3	73	4	●
	1212E27 20 UN	20	-	-	3/4-1	12	12.0	27.3	84	5	●
	12113D26 18 UN	18	-	9/16-5/8	1 1/8-1 5/8	12	11.3	26.1	84	4	●
	08067C16 16 UN	16	3/8	-	-	8	6.7	16.7	64	3	●
	1212D31 16 UN	16	-	3/4	-	12	12.0	31.0	84	4	●
	12114C28 11 UN	11	5/8	-	-	12	11.4	28.9	84	3	●
	16144D34 10 UN	10	3/4	-	-	16	14.4	34.3	101	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

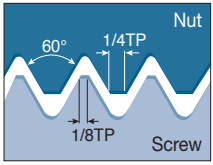
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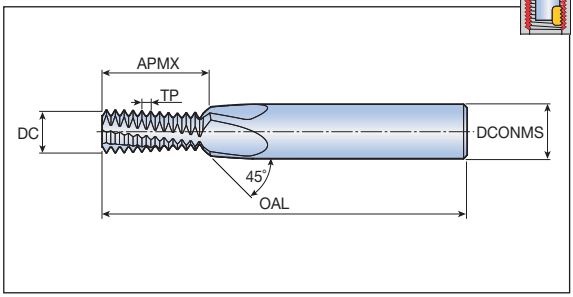
MTECH-UN

TS-THREAD

Solid carbide threading end mills for threading and chamfering on hardened steel







Designation		TPI	UNC	UNF	UNEF	Dimension (mm)				NOF	Grade
						DCONMS	DC	APMX	OAL		TT5515
MTECH	**06026C5 32 UN**	32	#6	-	-	6	2.6	6.7	58	3	●
	06048C12 20 UN	20	1/4	-	-	6	4.8	12.1	58	3	●
	08057C14 18 UN	18	5/16	9/16-5/8	11/16	8	5.7	14.8	64	3	●
	10074C16 16 UN	16	3/8	3/4	-	10	7.4	16.7	73	3	●
	12094D22 13 UN	13	1/2	-	-	12	9.4	22.5	84	4	●

Cutting Condition C70

▸ NOF: Number of flutes

●: Standard items

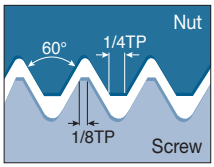
ADVANCE CUTTING TaeguTec

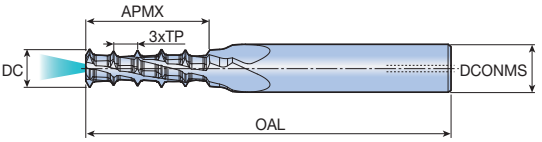
MTECM-UN

TS-THREAD

Triple lead solid carbide threading end mills for low cutting loads







• Lead: 3 x pitch

Designation		TPI	UNC	Dimension (mm)				NOF	Grade
				DCONMS	DC	APMX	OAL		TT9030
MTECM	**0250C28 32 UN**	32	#8	6.35	3.1	7.5	63.5	3	●
	0250C50 24 UN	24	#10	6.35	3.5	13.2	63.5	3	●
	06047C16 20 UN	20	1/4	6	4.7	17.1	58	3	●
	0250C65 20 UN	20	1/4	6.35	4.7	17.1	63.5	3	●
	0312D09 16 UN	16	3/8	7.94	7.4	24.5	63.5	4	●

Cutting Condition C72

▸ NOF: Number of flutes

●: Standard items

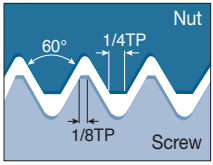
TaeguTec

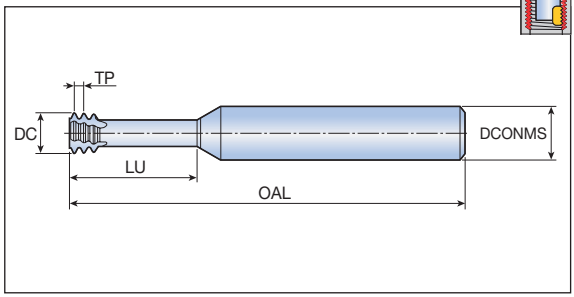
MTECS-UN

TS-THREAD

Solid carbide threading end mills with short cutting flutes for low cutting loads







Designation		TPI	UNC	UNF	Dimension (mm)				NOF	Grade
					DCONMS	DC	LU	OAL		TT9030
MTECS	03012C8 80 UN	80	-	#0	3	1.15	8.0	39	3	●
	03015C6 72 UN	72	-	#1	3	1.45	6.0	39	3	●
	03016C6 56 UN	56	#2	#3	3	1.65	6.6	39	3	●
	03016C9 56 UN	56	#2	#3	3	1.65	9.2	39	3	●
	03016C11 56 UN	56	#2	#3	3	1.65	11.4	39	3	●
	06016C4 56 UN	56	#2	#3	6	1.65	4.4	58	3	●
	06016C6 56 UN	56	#2	#3	6	1.65	6.6	58	3	●
	06016C6 56 UN-L	56	#2	#3	6	1.65	6.6	100	3	●
	06019C5 48 UN	48	#3	#4	6	1.9	5.2	58	3	●
	03021C8 40 UN	40	#4	-	3	2.1	8.0	39	3	●
	03021C12 40 UN	40	#4	-	3	2.1	12.0	39	3	●
	06021C6 40 UN	40	#4	-	6	2.1	6.3	58	3	●
	06021C6 40 UN-L	40	#4	-	6	2.1	6.3	100	3	●
	06021C8 40 UN	40	#4	-	6	2.1	8.0	58	3	●
	06021C8 40 UN-L	40	#4	-	6	2.1	8.0	100	3	●
	06024C9 40 UN	40	#5	#6	6	2.45	9.6	58	3	●
	06033C9 36 UN	36	-	#8	6	3.3	9.0	58	3	●
	03025C14 32 UN	32	#6	-	3	2.55	14.8	39	3	●
	06025C7 32 UN	32	#6	-	6	2.55	7.1	58	3	●
	06025C10 32 UN	32	#6	-	6	2.55	10.5	58	3	●
	06025C10 32UN-L	32	#6	-	6	2.55	10.5	100	3	●
	06032C9 32 UN	32	#8	#10	6	3.2	9.5	58	3	●
	06032C12 32 UN	32	#8	#10	6	3.2	12.5	58	3	●
	06037C10 32 UN	32	-	#10	6	3.7	10.5	58	3	●
	06037C15 32 UN	32	-	#10	6	3.7	15.0	58	3	●
	06037C15 32 UN-L	32	-	#10	6	3.7	15.0	101	3	●
	06042C11 28 UN	28	-	#12	6	4.2	11.0	58	3	●
	0605C14 28 UN	28	-	1/4	6	5.0	14.5	58	3	●
	0605C19 28 UN	28	-	1/4	6	5.0	19.0	58	3	●
	06035C10 24 UN	24	#10,#12	-	6	3.5	10.6	58	3	●
	06035C15 24 UN	24	#10,#12	-	6	3.5	15.5	58	3	●
	08066C17 24 UN	24	-	5/16	8	6.6	17.0	64	3	●
	08066C24 24 UN	24	-	5/16	8	6.6	24.0	64	3	●

Cutting Condition C74

▸ NOF: Number of flutes

●: Standard items

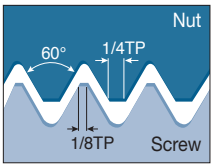
ADVANCE CUTTING TaeguTec

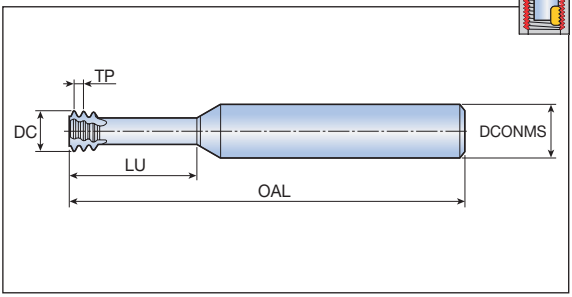
MTECS-UN

TS-THREAD

Solid carbide threading end mills with short cutting flutes for low cutting loads







Designation	TPI	UNC	UNF	Dimension (mm)				NOF	Grade
				DCONMS	DC	LU	OAL		TT9030
MTECS 06047C14 20 UN	20	1/4	-	6	4.75	14.0	58	3	●
06047C19 20 UN	20	1/4	-	6	4.75	19.0	58	3	●
06047C19 20 UN-L	20	1/4	-	6	4.75	19.0	100	3	●
0808C25 20 UN	20	-	7/16	8	8.0	25.0	64	3	●
0808C34 20 UN	20	-	7/16	8	8.0	34.6	64	3	●
0606C17 18 UN	18	5/16	-	6	6.0	17.0	58	3	●
0606C23 18 UN	18	5/16	-	6	6.0	23.0	58	3	●
1212D35 18 UN	18	-	5/8	12	12.0	35.0	84	4	●
08067C22 16 UN	16	3/8	-	8	6.7	22.0	64	3	●
08067C30 16 UN	16	3/8	-	8	6.7	30.2	64	3	●
08077C25 14 UN	14	7/16	-	8	7.7	25.0	64	3	●
08077C35 14 UN	14	7/16	-	8	7.7	35.2	64	3	●
10092C27 13 UN	13	1/2	-	10	9.2	27.5	73	3	●
12114C34 11 UN	11	5/8	-	12	11.4	34.5	84	3	●
12114C50 11 UN	11	5/8	-	12	11.4	50.0	101	3	●
16144D41 10 UN	10	3/4	-	16	14.4	41.5	105	4	●

Cutting Condition C74

▸ NOF: Number of flutes

●: Standard items

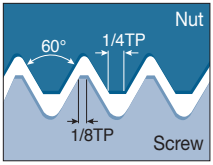
TaeguTec

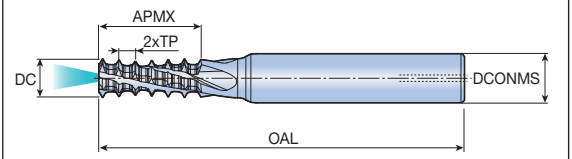
MTECK-UN

TS-THREAD

Double lead solid carbide threading end mills for low cutting loads







• Lead: 2 x pitch

	Designation	TPI	UNC	UNF	Dimension (mm)				NOF	Grade
					DCONMS	DC	APMX	OAL		TT9030
MTECK	**0250C34 32 UN**	32	#8	-	6.35	3.1	9.1	63.5	3	●
	0250D50 28 UN	28	-	1/4	6.35	5.0	13.1	63.5	4	●
	06035C10 24 UN	24	#10	-	6	3.5	11.0	58	3	●
	0250C50 20 UN	20	1/4	-	6.35	4.7	13.3	63.5	3	●
	0250D67 18 UN	18	5/16	-	6.35	6.1	17.6	63.5	4	●
	08061D17 18 UN	18	5/16	-	8	6.1	17.6	64	4	●
	08061D22 18 UN	18	5/16	-	8	6.1	23.2	76	4	●
	12011E29 18 UN	18	-	9/16	12	11.0	30.4	84	5	●
	08074D19 16 UN	16	3/8	-	8	7.4	19.8	64	4	●
	1298D25 13 UN	13	1/2	-	12	9.8	26.3	84	4	●

Cutting Condition C72

▸ NOF: Number of flutes

●: Standard items

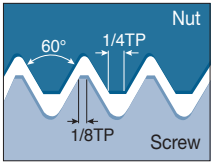
ADVANCE CUTTING TaeguTec

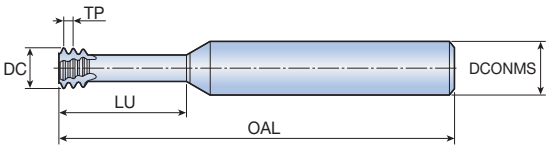
MTECSH-UN

TS-THREAD

Left-handed solid carbide threading end mills with short cutting flutes for hardened steel







• Left-hand tools (CNC code M04)

Designation	TPI	UNC	UNF	Dimension (mm)				NOF	Grade
				DCONMS	DC	LU	OAL		TT1040
MTECSH 06012C4 80 UN	80	-	#0	6	1.15	4.0	58	3	●
03015C6 72 UN	72	-	#1	3	1.45	6.0	39	3	●
06016C6 56 UN	56	#2	#3	6	1.65	6.6	58	3	●
06019C5 48 UN	48	#3	#4	6	1.9	5.2	58	3	●
06021C6 40 UN	40	#4	-	6	2.1	6.3	58	3	●
06021C8 40 UN	40	#4	-	6	2.1	8.0	58	3	●
06024C7 40 UN	40	#5	#6	6	2.45	7.0	58	3	●
06024C9 40 UN	40	#5	#6	6	2.45	9.6	58	3	●
06025C7 32 UN	32	#6	-	6	2.55	7.1	58	3	●
06025C10 32 UN	32	#6	-	6	2.55	10.5	58	3	●
06032C9 32 UN	32	#8	-	6	3.2	9.5	58	3	●
06032C12 32 UN	32	#8	-	6	3.2	12.5	58	3	●
06037C10 32 UN	32	-	#10	6	3.7	10.5	58	3	●
06037C15 32 UN	32	-	#10	6	3.7	15.0	58	3	●
06042C11 28 UN	28	-	#12	6	4.2	11.0	58	3	●
0605C14 28 UN	28	-	1/4	6	5.0	14.5	58	3	●
0605C19 28 UN	28	-	1/4	6	5.0	19.0	58	3	●
06035C10 24 UN	24	#10,#12	-	6	3.5	10.6	58	3	●
08066C17 24 UN	24	-	5/16	8	6.6	17.0	64	3	●
08066C24 24 UN	24	-	5/16	8	6.6	24.0	64	3	●
06047C14 20 UN	20	1/4	-	6	4.75	14.0	58	3	●
06047C19 20 UN	20	1/4	-	6	4.75	19.0	58	3	●
0808C25 20 UN	20	-	7/16	8	8.0	25.0	64	3	●
0606C17 18 UN	18	5/16	-	6	6.0	17.0	58	3	●
0606C23 18 UN	18	5/16	-	6	6.0	23.0	58	3	●
08067C22 16 UN	16	3/8	-	8	6.7	22.0	64	3	●
08077C25 14 UN	14	7/16	-	8	7.7	25.0	64	3	●
10092C27 13 UN	13	1/2	-	10	9.2	27.5	73	3	●
12114C34 11 UN	11	5/8	-	12	11.4	34.5	84	3	●

Cutting Condition C74

▸ NOF: Number of flutes

●: Standard items

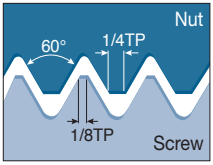
TaeguTec

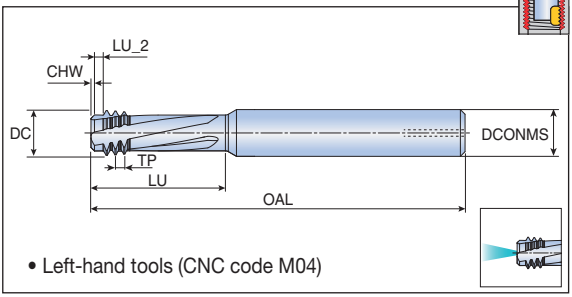
MTECD-UN

TS-THREAD

Left-handed solid carbide threading end mills for hole-making, threading and chamfering







• Left-hand tools (CNC code M04)

	Designation	TPI	CNT	Dimension (mm)						NOF	Coolant hole	Grade
				DCONMS	DC	LU	OAL	CHW	LU_2			TT9030
MTECD	**06033C12 36 UN**	36	#8	6	3.3	12.0	58	0.2	0.7	3	x	●
	06032C12 32 UN	32	#8	6	3.2	12.3	58	0.3	0.8	3	x	●
	06038C14 32 UN	32	#10	6	3.8	14.0	58	0.3	0.8	3	x	●
	0805C14 28 UN	28	1/4-3/8	8	5.0	14.5	64	0.4	0.9	3	●	●
	08065D17 24 UN	24	5/16-1/2	8	6.5	17.0	64	0.5	1.1	4	●	●
	08048C14 20 UN	20	1/4-3/8	8	4.8	14.0	64	0.4	1.3	3	●	●
	0806D17 18 UN	18	5/16-7/16	8	6.0	17.0	64	0.5	1.4	4	●	●
	08067C22 16 UN	16	3/8-1/2	8	6.7	22.0	64	0.5	1.6	3	●	●

Cutting Condition C74

- Thread hole, thread and chamfer by circular interpolation
- NOF: Number of flutes

●: Standard items

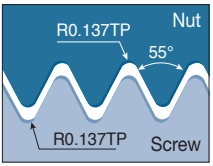
ADVANCE CUTTING TaeguTec

MTEC-W / MTECB-W / MTECZ-W

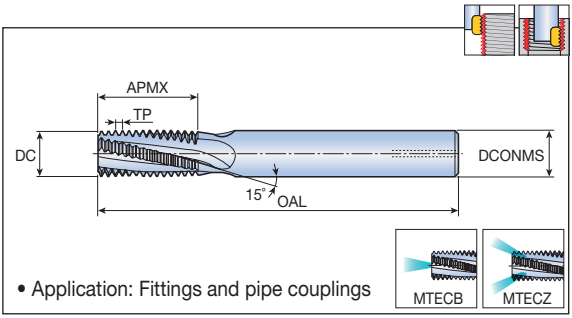
TS-THREAD

Solid carbide threading end mills





BSF
BSP
BSW



• Application: Fittings and pipe couplings

	Designation			TPI	TDZ	Designation				NOF	Grade
						DCONMS	DC	APMX	OAL		TT9030
MTEC	**0606C9**	**28**	**W**	28	G1/8	6	6.0	9.5	58	3	●
	0808C14	**19**	**W**	19	G1/4-3/8	8	8.0	14.0	64	3	●
	1212D19	**14**	**W**	14	G1/2-7/8	12	12.0	19.3	84	4	●
	1212D26	**14**	**W**	14	G1/2-7/8	12	12.0	26.3	84	4	●
	1212C24	**11**	**W**	11	G1-1 1/2	12	12.0	24.2	84	3	●
	1616D38	**11**	**W**	11	G1-3	16	16.0	38.1	101	4	●
MTECB	**08078C14**	**28**	**W**	28	G1/8	8	7.8	14.1	64	3	●
	1010D16	**19**	**W**	19	G1/4-3/8	10	10.0	16.7	73	4	●
	1616E26	**14**	**W**	14	G1/2-7/8	16	16.0	26.3	105	5	●
	1616D38	**11**	**W**	11	G ≥ 1	16	16.0	38.1	105	4	●
	2020E47	**11**	**W**	11	G ≥ 1	20	20.0	47.3	105	5	●
MTECZ	**08078C14**	**28**	**W**	28	G1/8	8	7.8	14.1	64	3	●
	1010D16	**19**	**W**	19	G1/4-3/8	10	10.0	16.7	73	4	●
	10092D24	**16**	**W**	16	G1/2	10	9.2	24.6	73	4	●
	1616E26	**14**	**W**	14	G1/2-7/8	16	16.0	26.3	101	5	●
	10086D24	**12**	**W**	12	G1/2	10	8.6	24.4	73	4	●
	12109D28	**11**	**W**	11	G5/8	12	10.9	28.9	84	4	●
	1616D38	**11**	**W**	11	G ≥ 1	16	16.0	38.1	101	4	●

Cutting Condition C70

- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

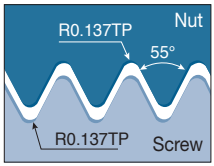
TaeguTec

MTECBF-W

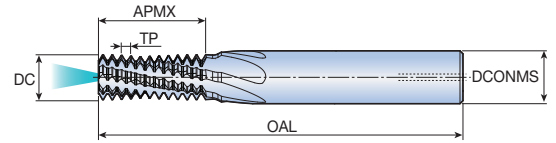
TS-THREAD

Solid carbide threading end mills with large number of flutes





BSF
BSP
BSW



• Application: Fitting and pipe couplings

Designation		TPI	TDZ	Dimension (mm)				NOF	Grade
				DCONMS	DC	LU	OAL		TT9030
MTECBF	**08078H14 28 W**	28	G1/8	8	7.8	14.0	64	8	●
	1010G16 19 W	19	G1/4-3/8	10	10.0	16.0	73	7	●
	1614H26 14 W	14	G1/2-7/8	16	14.0	26.2	105	8	●
	1616H38 11 W	11	G7/18	16	16.0	37.9	105	8	●

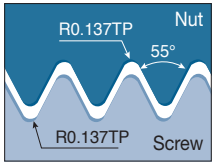
Cutting Condition C72

●: Standard items

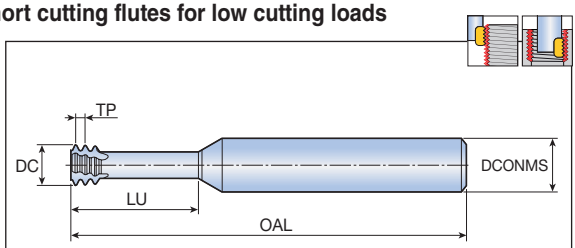
MTECS-W

Solid carbide threading end mills with short cutting flutes for low cutting loads





BSF
BSP
BSW



• Application: Fittings and pipe couplings

Designation		TPI	TDZ	Dimension (mm)				NOF	Grade
				DCONMS	DC	LU	OAL		TT9030
MTECS	**08078C19 28 W**	28	G1/8	8	7.8	19.5	64	3	●
	1010D30 19 W	19	G1/4-3/8	10	10.0	30.0	73	4	●
	1212D37 14 W	14	G1/2-7/8	12	12.0	37.0	84	4	●
	1616D44 11 W	11	G ≥ 1	16	16.0	44.0	105	4	●

Cutting Condition C74

- TDZ: Thread diameter size
- NOF: Number of flutes

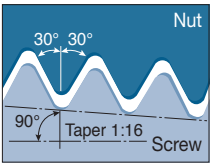
●: Standard items

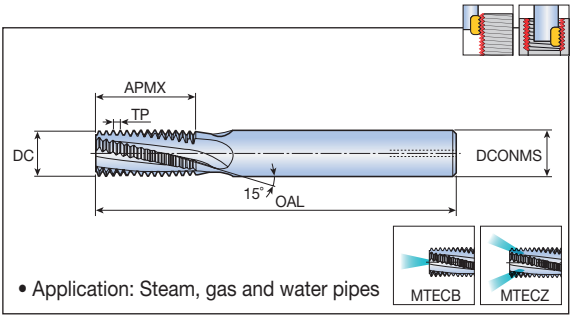
MTEC-NPT / MTECB-NPT / MTECZ-NPT

TS-THREAD

Solid carbide threading end mills







• Application: Steam, gas and water pipes

Designation				TPI	TDZ	Dimension (mm)				NOF	Grade
						DCONMS	DC	APMX	OAL		TT9030
MTEC	**0606C9**	**27**	**NPT**	27	1/16-1/8	6	5.36	9.9	58	3	●
	0808C14	**18**	**NPT**	18	1/4-3/8	8	7.12	14.8	64	3	●
	1212D20	**14**	**NPT**	14	1/2-3/4	12	10.77	20.9	84	4	●
	1616D27	**11.5**	**NPT**	11.5	1-2	16	14.24	27.6	101	4	●
	2020D39	**8**	**NPT**	8	2 1/2	20	20.0	39.7	105	4	●
MTECB	**08076C10**	**27**	**NPT**	27	1/8	8	7.6	10.8	64	3	●
	1010D16	**18**	**NPT**	18	1/4-3/8	10	10.0	16.2	73	4	●
	16155D22	**14**	**NPT**	14	1/2-3/4	16	15.5	22.7	105	4	●
MTECZ	**08076C10**	**27**	**NPT**	27	1/8	8	7.6	10.8	64	3	●
	1010D16	**18**	**NPT**	18	1/4-3/8	10	10.0	16.2	73	4	●
	16155D22	**14**	**NPT**	14	1/2-3/4	16	15.5	22.7	101	4	●

Cutting Condition C70

▸ TDZ: Thread diameter size
▸ NOF: Number of flutes

●: Standard items

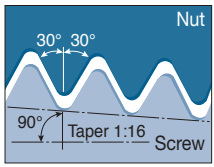
TaeguTec

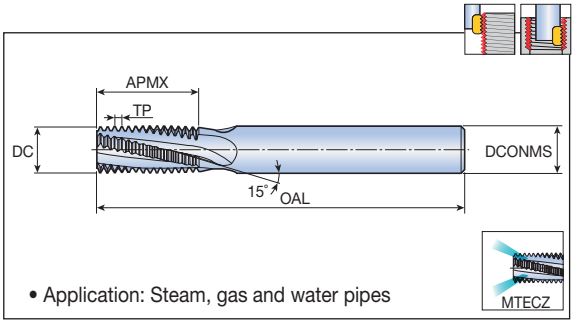
MTEC-NPTF / MTECZ-NPTF

TS-THREAD

Solid carbide threading end mills







• Application: Steam, gas and water pipes

Designation				TPI	TDZ	Dimension (mm)				NOF	Grade
						DCONMS	DC	APMX	OAL		TT9030
MTEC	**0606C9**	**27**	**NPTF**	27	1/16-1/8	6	6.0	9.9	58	3	●
	0808C14	**18**	**NPTF**	18	1/4-3/8	8	8.0	14.8	64	3	●
	1212D20	**14**	**NPTF**	14	1/2-3/4	12	12.0	20.9	84	4	●
MTECZ	**08076C10**	**27**	**NPTF**	27	1/8	8	7.6	10.8	64	3	●
	1010D16	**18**	**NPTF**	18	1/4-3/8	10	10.0	16.2	73	4	●

Cutting Condition C70

- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

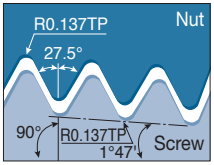
ADVANCE CUTTING TaeguTec

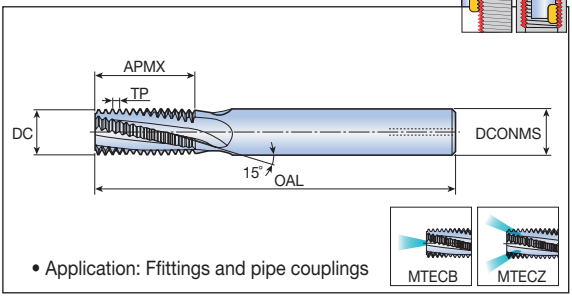
MTEC-BSPT / MTECB-BSPT / MTECZ-BSPT

TS-THREAD

Solid carbide threading end mills







• Application: Ffittings and pipe couplings

Designation			TPI	TDZ	Dimension (mm)				NOF	Grade
					DCONMS	DC	APMX	OAL		TT9030
MTEC	**0606C9**	**28 BSPT**	28	RC1/8	6	5.4	8.1	58	3	●
	0808C14	**19 BSPT**	19	RC1/4-3/8	8	7.16	12.0	64	3	●
	1212D19	**14 BSPT**	14	RC1/2-7/8	12	10.88	16.3	84	4	●
	1616D28	**11 BSPT**	11	RC1-2	16	14.17	25.4	101	4	●
MTECB	**08078C14**	**28 BSPT**	28	RC1/8	8	7.8	14.1	64	3	●
	1010D16	**19 BSPT**	19	RC1/4-3/8	10	10.0	16.7	73	4	●
	1616E26	**14 BSPT**	14	RC1/2-7/8	16	16.0	26.3	105	5	●
MTECZ	**08078C14**	**28 BSPT**	28	RC1/8	8	7.8	14.1	64	3	●
	1010D16	**19 BSPT**	19	RC1/4-3/8	10	10.0	16.7	73	4	●

Cutting Condition C70

- TDZ: Thread diameter size
- NOF: Number of flutes

●: Standard items

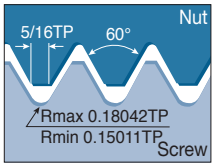
TaeguTec

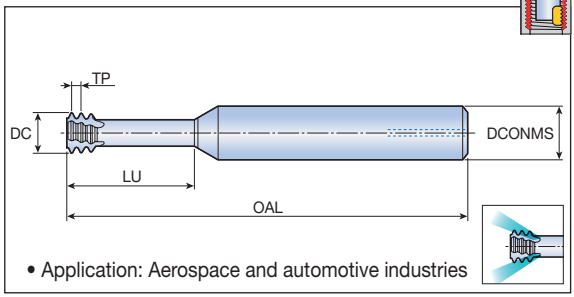
MTECS-MJ/UNJ

TS-THREAD

Solid carbide threading end mills with short cutting flutes for low cutting loads







• Application: Aerospace and automotive industries

Designation	TP (mm)	TPI	MJ size	UNJC	UNJF	Dimension (mm)				NOF	Coolant hole	Grade TT9030
						DCONMS	DC	LU	OAL			
MTECS 06032C10 0.7 MJ	0.7	-	MJ4	-	-	6	3.2	10.0	58	3	x	●
06039C12 0.8 MJ	0.8	-	MJ5	-	-	6	3.9	12.5	58	3	x	●
06048C15 1.0 MJ	1.0	-	MJ6	-	-	6	4.8	15.0	58	3	x	●
08061C20 1.25 MJ	1.25	-	MJ8	-	-	8	6.1	20.0	64	3	●	●
0808C25 1.5 MJ	1.5	-	MJ10	-	-	8	8.0	25.0	64	3	●	●
10092C30 1.75 MJ	1.75	-	MJ12	-	-	10	9.2	30.0	73	3	●	●
1010C35 2.0 MJ	2.0	-	MJ16	-	-	10	10.0	35.0	73	3	●	●
MTECS 06033C10 32 UNJ	-	32	-	#8	#10	6	3.3	10.5	58	3	x	●
08051C16 28 UNJ	-	28	-	-	1/4	8	5.1	16.0	64	3	●	●
08067C20 24 UNJ	-	24	-	-	5/16	8	6.7	20.0	64	3	●	●
06049C16 20 UNJ	-	20	-	1/4	-	6	4.9	16.0	58	3	x	●
0808C28 20 UNJ	-	20	-	-	7/16	8	8.0	28.0	64	3	●	●
08061C20 18 UNJ	-	18	-	5/16	9/16	8	6.15	20.0	64	3	●	●
08069C24 16 UNJ	-	16	-	3/8	-	8	6.9	24.0	64	3	●	●
10094C27 13 UNJ	-	13	-	1/2	-	10	9.4	27.5	73	3	●	●

Cutting Condition C74

▸ NOF: Number of flutes

●: Standard items

ADVANCE CUTTING TaeguTec

Tool Designation System

T-THREAD

End mills

MT	E	D25	-	1	-	W	20	(C)	-	21
1	2	3		4		5	6	7		8

1 Mill thread

M - Mill
T - Thread

2 Tool type

E - End mills type

3 Cutting diameter

D25 - 25.0mm

4 Number of insert

1 1 insert
2 2 inserts

5 Shank type

W - Weldon shank
C - Cylindrical type

6 Shank diameter

20 - 20.0mm

7 Shank material

C Carbide shank

8 Insert size (APMX)

12 12.0 mm
14 14.0 mm
21 21.0 mm
30 30.0 mm
40 40.0 mm

Cutters

MT	F	D063	-	5	-	22	-	21
1	2	3		4		5		6

1 Mill thread

M - Mill
T - Thread

2 Tool type

F - Facemill type

3 Cutting diameter

D063 - 63.0mm

4 Number of insert

4 4 inserts
5 5 inserts

5 Bore diameter

22 22.0 mm
27 27.0 mm
32 32.0 mm

6 Insert size (APMX)

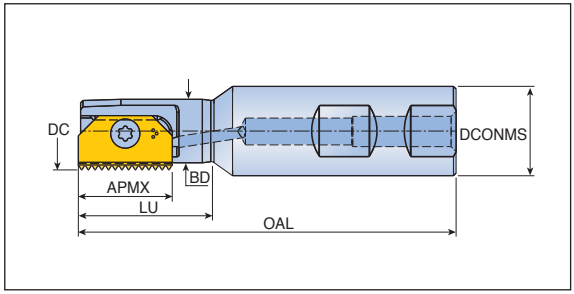
21 21.0 mm
30 30.0 mm
40 40.0 mm

MTE D-1

TS-THREAD

Indexable threading end mills - Weldon shank





Designation			Dimension (mm)						Shank	Coolant hole	Kg	Insert
			APMX	DC	DCONMS	BD	LU	OAL				
MTE	D09.5-1-W20-12 (1)	1	12	9.5	20	7.5	15.5	85	W	●	0.16	TTMT12
	D09.9-1-W20-12	1	12	9.9	20	7.5	16.0	85	W	●	0.16	TTMT12
	D12.2-1-W20-14	1	14	12.2	20	8.8	20.0	75	W	●	0.15	TTMT14
	D14.5-1-W20-14	1	14	14.5	20	10.8	27.1	85	W	●	0.16	TTMT14
	D17.0-1-W20-14	1	14	17.0	20	12.8	30.0	85	W	●	0.23	TTMT14
	D18-1-W20-21 (2)	1	21	18.5	20	14.2	30.0	85	W	●	0.20	TTMT21
	D21-1-W20-21	1	21	21.0	20	15.9	40.0	94	W	●	0.23	TTMT21
	D25-1-W20-21	1	21	25.0	20	20.0	61.0	115	W	●	0.24	TTMT21
	D29-1-W25-30	1	30	29.0	25	22.2	50.0	110	W	●	0.32	TTMT30
	D31-1-W25-30	1	30	31.0	25	25.0	90.0	150	W	●	0.60	TTMT30
	D38-1-W32-30	1	30	38.0	32	32.0	86.0	150	W	●	0.90	TTMT30
	D48-1-W40-40	1	40	48.0	40	35.0	78.0	153	W	●	1.30	TTMT40
	D48-1-W40-40-B	1	40	48.0	40	36.5	138.0	210	W	●	1.50	TTMT40

- Minimum bore should be one-third larger than DC (diameter)
- All end mills are equipped with a bore for internal coolant
- (1) Not suitable for inserts: TTMT12 18 NPT, TTMT12 18 NPTF, TTMT12 19 BSPT
- (2) Not suitable for inserts: TTMT21 I 3.50 ISO, TTMT21 I 7 UN, TTMT21 11.5 NPT, TTMT21 11.5 NPTF

Spare parts

Designation	Screw	Wrench	Wrench handle	
				
MTE D...12	SR M2.5-T8-MT	BLD T08/M7	SW4-SD	-
MTE D...14	SR M2.6-L6.7-S11	BLD T08/M7	SW4-SD	-
MTE D...21	SR M4-IP15-MT	BLD IP15/S7	SW6-SD	-
MTE D...30/40(-B)	SR M5-IP25-MT	BLD IP25/S7	-	SW6-T



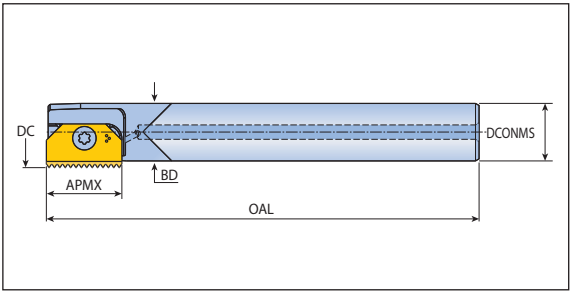
ADVANCE CUTTING
TaeguTec

MTE D-1-C

TS-THREAD

Indexable threading end mills - Cylindrical carbide shank





Designation			Dimension (mm)					Shank	Coolant hole	Kg	Insert
			APMX	DC	DCONMS	BD	OAL				
MTE	**D09.9-1-C08C-12**	1	12	9.9	8	8	127.0	C	●	0.10	TTMT12
	D13.7-1-C10C-14	1	14	13.7	10	10	110.0	C	●	0.12	TTMT14
	D13.7-1-C10C-14-B	1	14	13.7	10	10	153.5	C	●	0.17	TTMT14
	D15.2-1-C12C-14	1	14	15.2	12	12	182.3	C	●	0.30	TTMT14
	D21-1-C16C-21	1	21	21.0	16	16	130.0	C	●	0.35	TTMT21
	D21-1-C16C-21-B	1	21	21.0	16	16	206.3	C	●	0.50	TTMT21
	D27-1-C20C-30	1	30	27.0	20	20	263.0	C	●	1.20	TTMT30

- For holders with long overhang, reduce the cutting speed and feed rate, between 20 to 40% (depending on workpiece, material, pitch and overhang)
- All end mills are equipped with a bore for internal coolant

Spare parts

Designation	Screw	Wrench	Wrench handle	
MTE D...C...12	SR M2.5-T8-MT	BLD T08/M7	SW4-SD	-
MTE D...C...14(-B)	SR M2.6-L6.7-S11	BLD T08/M7	SW4-SD	-
MTE D...C...21(-B)	SR M4-IP15-MT	BLD IP15/S7	SW6-SD	-
MTE D...C...30	SR M5-IP25-MT-S	BLD IP25/S7	-	SW6-T

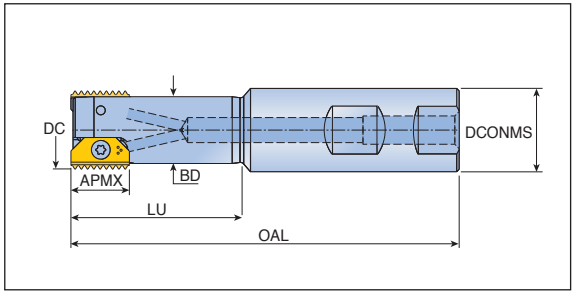
C56-C63 | Cutting Condition C69

MTE D-2

TS-THREAD

Double insert thread milling end mills - Weldon shank





Designation			Dimension (mm)						Shank	Coolant hole	Kg	Insert
			APMX	DC	DCONMS	BD	LU	OAL				
MTE	**D20.0-2-W20-14**	2	14	20	20	16	41	93	W	●	0.20	TTMT14
	D30-2-W25-21	2	21	30	25	24	52	108	W	●	0.40	TTMT21
	D40-2-W32-30	2	30	40	32	30	70	130	W	●	0.70	TTMT30
	D50-2-W40-40	2	40	50	40	38	78	153	W	●	0.80	TTMT40

- Minimum bore should be one-third larger than DC (diameter)
- All end mills are equipped with a bore for internal coolant

Spare parts

Designation	Screw	Wrench	Wrench handle	
MTE D...W...14	SR M2.6-L6.7-S11	BLD T08/M7	SW4-SD	-
MTE D...W...21	SR M4-IP15-MT	BLD IP15/S7	SW6-SD	-
MTE D...W...30/40	SR M5-IP25-MT	BLD IP25/S7	-	SW6-T

Cutting Condition

C56-C63 | C69

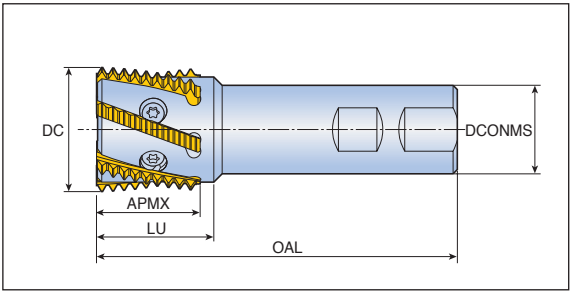
ADVANCE CUTTING TaeguTec

TMTSRH

TS-THREAD

End mills with coolant holes for helical threading inserts - Weldon shank





Designation			Dimension (mm)					Shank	Coolant hole	Kg	Insert
			APMX	DC	DCONMS	LU	OAL				
TMTSRH	**23-2-N**	2	27	23	25	50	110	W	●	0.26	TMTH 23
	32-5-N	5	32	32	32	60	130	W	●	0.60	TMTH 32
	45-6-N	6	37	45	32	-	130	W	●	0.70	TMTH 45

▸ All end mills are equipped with a bore for internal coolant

Spare parts

Designation	Screw	Wrench		
				
TMTSRH 23	SR M4X0.7-MTH23	T-15/5		
TMTSRH 32	SR 8-32UNC-MTH32	T-20/5		
TMTSRH 45	SR M5X0.8-MTH45	TK40		

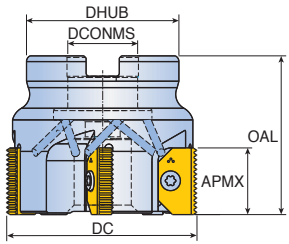


MTF D

TS-THREAD

Multi-insert shell mills for large diameter threading





Designation			Dimension (mm)					Coolant hole	Arbor style	Kg	Mounting bolt	Insert
			APMX	DC	DHUB	DCONMS	OAL					
MTF	**D063-5-22-21**	5	21	63	40	22	50	●	A	0.70	SR M10X25 DIN912	TTMT21
	D063-4-22-30	4	30	63	48	22	50	●	A	0.56	SR M10X25 DIN912	TTMT30
	D080-4-27-30	4	30	80	60	27	50	●	A	1.18	SR M12X25	TTMT30
	D080-4-27-40	4	40	80	60	27	65	●	A	1.04	SR M12X25	TTMT30
	D100-4-32-30	4	30	100	78	32	50	●	A	1.89	SR M16X30 DIN912	TTMT40
	D100-4-32-40	4	40	100	78	32	65	●	A	0.20	SR M16X30 DIN912	TTMT40

▸ All shell mills are equipped with a bore for internal coolant

Spare parts

Designation	Screw	Wrench	Wrench handle		
MTF D063...21	SR M4-IP15-MT	BLD IP15/S7	SW6-SD	-	
MTF D063...30	SR M5-IP25-MT	BLD IP25/S7	-	SW6-T	
MTF D080...30/40	SR M5-IP25-MT	BLD IP25/S7	-	SW6-T	
MTF D100...30/40	SR M5-IP25-MT	BLD IP25/S7	-	SW6-T	

Cutting Condition

C56-C63 C69

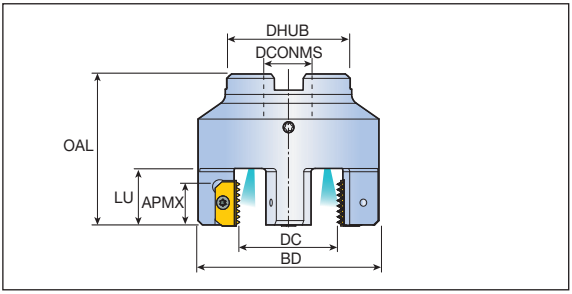
ADVANCE CUTTING TaeguTec

MTFLE D

TS-THREAD

External multi-tooth threading shell mills





Designation		Dimension (mm)							Coolant hole	Arbor style	Kg	Mounting bolt	Insert
		APMX	DC	BD	DHUB	DCONMS	LU	OAL					
MTFLE D20-3-22-21	3	21	20	58.2	48	22	27	63	●	A	0.70	SR M10X25 DIN912	TTMT21 E
D30-3-22-21	3	21	30	68.2	48	22	27	63	●	A	0.90	SR M10X25 DIN912	TTMT21 E
D45-4-27-21	4	21	45	83.2	60	27	27	67	●	A	1.40	SR M12X25 DIN 912	TTMT21 E

▸ All shell mills are equipped with a bore for internal coolant

Spare parts

Designation	Screw	Wrench	Wrench handle	
MTFLE D...21	SR M4-IP15-MT	BLD IP15/S7	SW6-SD	

Cutting Condition
C69

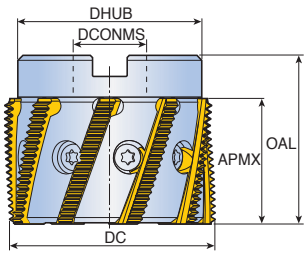
TaeguTec

TMTSRH

TS-THREAD

Helical shell mill for large thread diameters





Designation			Dimension (mm)					Coolant hole	Arbor style	Kg	Insert
			APMX	DC	DHUB	DCONMS	OAL				
TMTSRH	**32-5M-N**	5	32	32	26.0	16	52	●	A	0.12	TMTH 32
	45-6M-N	6	37	45	38.0	22	60	●	A	0.43	TMTH 45
	63-9-N	9	38	63	51.7	22	50	●	A	0.71	TMTH 63

▸ All shell mills are equipped with a bore for internal coolant

Spare parts

Designation	Screw	Wrench		
				
TMTSRH 32	SR 8-32UNC-MTH32S	T-20/5		
TMTSRH 45	SR M5X0.8-MTH45	TK40		
TMTSRH 63	SR M5X0.8-MTH63	TK40		



ADVANCE CUTTING TaeguTec

Insert Designation System

T-THREAD

Thread milling inserts

TTMT(H)	30	E	1.5	ISO	TT9030
1	2	3	4	5	6

1 TaeguTec mill thread

TT - TaeguTec
M - Mill
T - Thread
H - Helical insert

2 Insert size (INSL)

12 12.0 mm
14 14.0 mm
21 21.0 mm
30 30.0 mm
40 40.0 mm



3 Application

E - External
I - Internal
☐ - External + internal

4 Thread pitch

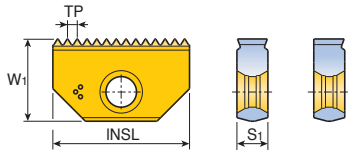
0.5 - 6.0 **mm** (Thread pitch)
32 - 4 **TPI** (Threads per inch)

5 Thread standard

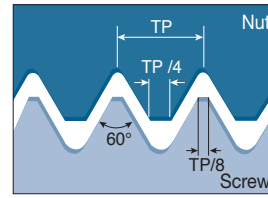
ISO
UN
WHIT
NPT
NPTF
BSPT

6 Grades

Coated
TT9030



TTMT12 I [1]



Insert	Designation	TP (mm)	Dimension (mm)			Grade
			INSL	W1	S1	TT9030
	**TTMT12 I 0.5 ISO[1]**	0.50	12	6.5	2.9	●
	TTMT12 I 0.75 ISO[1]	0.75	12	6.5	2.9	●
	TTMT12 I 1.0 ISO[1]	1.00	12	6.5	2.9	●
	TTMT12 I 1.25 ISO[1]	1.25	12	6.5	2.9	●
	TTMT12 I 1.5 ISO[1]	1.50	12	6.5	2.9	●
	TTMT14 I 0.5 ISO	0.50	14	7.9	3.2	●
	TTMT14 E/I 0.75 ISO	0.75	14	7.9	3.2	●
	TTMT14 E/I 1.0 ISO	1.00	14	7.9	3.2	●
	TTMT14 E/I 1.25 ISO	1.25	14	7.9	3.2	●
	TTMT14 E/I 1.5 ISO	1.50	14	7.9	3.2	●
	TTMT14 E/I 1.75 ISO	1.75	14	7.9	3.2	●
	TTMT14 E/I 2.0 ISO	2.00	14	7.9	3.2	●
	TTMT14 E/I 2.5 ISO	2.50	14	7.9	3.2	●
	TTMT21 E/I 1.0 ISO	1.00	21	12.6	4.8	●
	TTMT21 E/I 1.5 ISO	1.50	21	12.6	4.8	●
	TTMT21 I 1.75 ISO	1.75	21	12.6	4.8	●
	TTMT21 E/I 2.0 ISO	2.00	21	12.6	4.8	●
	TTMT21 E/I 2.5 ISO	2.50	21	12.6	4.8	●
	TTMT21 E/I 3.0 ISO	3.00	21	12.6	4.8	●
	TTMT21 I 3.5 ISO	3.50	21	12.6	4.8	●
	TTMT30 E/I 1.5 ISO	1.50	30	16.7	5.6	●
	TTMT30 E/I 2.0 ISO	2.00	30	16.7	5.6	●
	TTMT30 E/I 3.0 ISO	3.00	30	16.7	5.6	●
	TTMT30 E/I 3.5 ISO	3.50	30	16.7	5.6	●
	TTMT30 E/I 4.0 ISO	4.00	30	16.7	5.6	●
	TTMT30 I 4.5 ISO	4.50	30	16.7	5.6	●
	TTMT30 I 5.0 ISO	5.00	30	16.7	5.6	●
	TTMT40 E/I 1.5 ISO	1.50	40	20.8	6.4	●
	TTMT40 E/I 2.0 ISO	2.00	40	20.8	6.4	●
	TTMT40 E/I 3.0 ISO	3.00	40	20.8	6.4	●
	TTMT40 I 3.5 ISO	3.50	40	20.8	6.4	●
	TTMT40 E/I 4.0 ISO	4.00	40	20.8	6.4	●
	TTMT40 I 4.5 ISO	4.50	40	20.8	6.4	●
	TTMT40 E/I 5.0 ISO	5.00	40	20.8	6.4	●
	TTMT40 I 5.5 ISO	5.50	40	20.8	6.4	●
	TTMT40 E/I 6.0 ISO	6.00	40	20.8	6.4	●

▸ [1] TTMT12 insert is only available with a single cutting edge

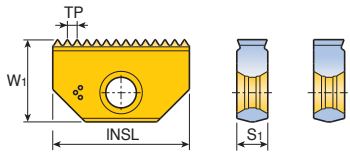
●: Standard items

MTE/F
C48-C53

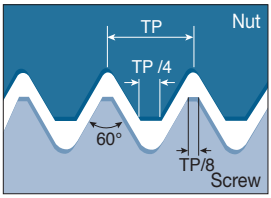
TTMT-UN

TS-THREAD

UN, UNC, UNF, UNEF, UNS



TTMT12 I (1)



Insert	Designation	TPI	Dimension (mm)			Grade
			INSL	W1	S1	TT9030
	**TTMT12 I 32 UN** (1)	32	12	6.5	2.9	●
	TTMT12 I 28 UN (1)	28	12	6.5	2.9	●
	TTMT12 I 24 UN (1)	24	12	6.5	2.9	●
	TTMT12 I 20 UN (1)	20	12	6.5	2.9	●
	TTMT12 I 18 UN (1)	18	12	6.5	2.9	●
	TTMT12 I 16 UN (1)	16	12	6.5	2.9	●
	TTMT14 E/I 32 UN	32	14	7.9	3.2	●
	TTMT14 E/I 28 UN	28	14	7.9	3.2	●
	TTMT14 I 27 UN	27	14	7.9	3.2	●
	TTMT14 E/I 24 UN	24	14	7.9	3.2	●
	TTMT14 E/I 20 UN	20	14	7.9	3.2	●
	TTMT14 E/I 18 UN	18	14	7.9	3.2	●
	TTMT14 E/I 16 UN	16	14	7.9	3.2	●
	TTMT14 E/I 14 UN	14	14	7.9	3.2	●
	TTMT14 E/I 12 UN	12	14	7.9	3.2	●
	TTMT14 I 11 UN	11	14	7.9	3.2	●
	TTMT14 I 10 UN	10	14	7.9	3.2	●
	TTMT21 E/I 24 UN	24	21	12.6	4.8	●
	TTMT21 E/I 20 UN	20	21	12.6	4.8	●
	TTMT21 E/I 18 UN	18	21	12.6	4.8	●
	TTMT21 E/I 16 UN	16	21	12.6	4.8	●
	TTMT21 E/I 14 UN	14	21	12.6	4.8	●
	TTMT21 E/I 12 UN	12	21	12.6	4.8	●
	TTMT21 E/I 10 UN	10	21	12.6	4.8	●
	TTMT21 I 8 UN	8	21	12.6	4.8	●
	TTMT21 I 7 UN	7	21	12.6	4.8	●
	TTMT30 E/I 20 UN	20	30	16.7	5.6	●
	TTMT30 E/I 18 UN	18	30	16.7	5.6	●
	TTMT30 E/I 16 UN	16	30	16.7	5.6	●
	TTMT30 E/I 14 UN	14	30	16.7	5.6	●
	TTMT30 E/I 12 UN	12	30	16.7	5.6	●
	TTMT30 E/I 10 UN	10	30	16.7	5.6	●
	TTMT30 E/I 8 UN	8	30	16.7	5.6	●
	TTMT30 E/I 6 UN	6	30	16.7	5.6	●
	TTMT30 I 5 UN	5	30	16.7	5.6	●

MTE/F
C48-C53

▸ (1) TTMT12 insert is only available with a single cutting edge

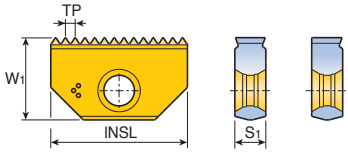
●: Standard items

TaeguTec

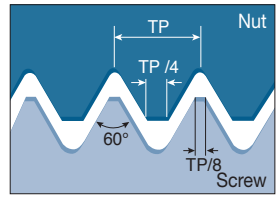
TTMT-UN

TS-THREAD

UN, UNC, UNF, UNEF, UNS



TTMT12 I [1]



Insert	Designation	TPI	Dimension (mm)			Grade
			INSL	W1	S1	TT9030
	**TTMT40 E/I 16 UN**	16	40	20.8	6.4	●
	TTMT40 E/I 14 UN	14	40	20.8	6.4	●
	TTMT40 E/I 12 UN	12	40	20.8	6.4	●
	TTMT40 E/I 10 UN	10	40	20.8	6.4	●
	TTMT40 E/I 8 UN	8	40	20.8	6.4	●
	TTMT40 E/I 6 UN	6	40	20.8	6.4	●
	TTMT40 I 4.5 UN	4.5	40	20.8	6.4	●
	TTMT40 I 4 UN	4	40	20.8	6.4	●

MTE/F

C48-C53

▸ [1] TTMT12 insert is only available with a single cutting edge

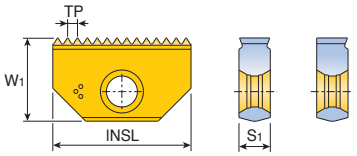
●: Standard items

ADVANCE CUTTING TaeguTec

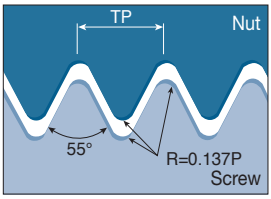
TTMT-W

TS-THREAD

Whitworth (BSW, BSF, BSP)



TTMT12 (1)



Insert	Designation	TPI	Dimension (mm)			Grade
			INSL	W1	S1	TT9030
	**TTMT12 19 W(1)**	19	12	6.5	2.9	●
	TTMT14 24 W	24	14	7.9	3.2	●
	TTMT14 20 W	20	14	7.9	3.2	●
	TTMT14 19 W	19	14	7.9	3.2	●
	TTMT14 16 W	16	14	7.9	3.2	●
	TTMT14 14 W	14	14	7.9	3.2	●
	TTMT21 20 W	20	21	12.6	4.8	●
	TTMT21 19 W	19	21	12.6	4.8	●
	TTMT21 16 W	16	21	12.6	4.8	●
	TTMT21 14 W	14	21	12.6	4.8	●
	TTMT21 11 W	11	21	12.6	4.8	●
	TTMT30 16 W	16	30	16.7	5.6	●
	TTMT30 14 W	14	30	16.7	5.6	●
	TTMT30 11 W	11	30	16.7	5.6	●
	TTMT40 11 W	11	40	20.8	6.4	●
	TTMT40 8 W	8	40	20.8	6.4	●

MTE/F



C48-C53

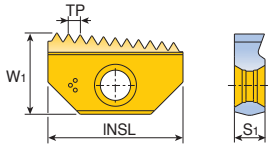
- The same insert for external and internal threading
- (1) TTMT12 insert is only available with a single cutting edge

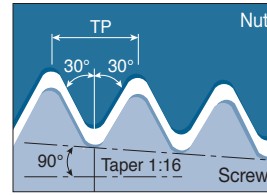
●: Standard items

TTMT-NPT

TS-THREAD

NPT - National pipe taper thread





Insert	Designation	TPI	Dimension (mm)			Grade
			INSL	W1	S1	TT9030
	**TTMT12 18 NPT**	18	12	6.5	2.9	●
	TTMT14 18 NPT	18	14	7.9	3.2	●
	TTMT14 14 NPT	14	14	7.9	3.2	●
	TTMT21 14 NPT	14	21	12.6	4.8	●
	TTMT21 11.5 NPT	11.5	21	12.6	4.8	●
	TTMT30 11.5 NPT	11.5	30	16.7	5.6	●
	TTMT30 8 NPT	8	30	16.7	5.6	●
	TTMT40 11.5 NPT	11.5	40	20.8	6.4	●
	TTMT40 8 NPT	8	40	20.8	6.4	●

MTE/F

C48-C53

- The same insert for external and internal threading
- Conical pipe thread inserts are single-sided

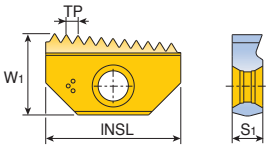
●: Standard items

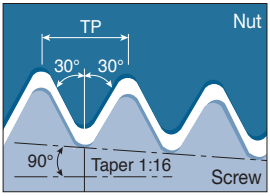
ADVANCE CUTTING TaeguTec

TTMT-NPTF

TS-THREAD

NPTF - National pipe thread tapered (Dryseal)





Insert	Designation	TPI	Dimension (mm)			Grade
			INSL	W1	S1	TT9030
	**TTMT12 18 NPTF**	18	12	6.5	2.9	●
	TTMT14 18 NPTF	18	14	7.9	3.2	●
	TTMT14 14 NPTF	14	14	7.9	3.2	●
	TTMT21 14 NPTF	14	21	12.6	4.8	●
	TTMT21 11.5 NPTF	11.5	21	12.6	4.8	●
	TTMT30 11.5 NPTF	11.5	30	16.7	5.6	●
	TTMT30 8 NPTF	8	30	16.7	5.6	●
	TTMT40 11.5 NPTF	11.5	40	20.8	6.4	●
	TTMT40 8 NPTF	8	40	20.8	6.4	●

MTE/F

C48-C53

- The same insert for external and internal threading
- Conical pipe thread Inserts are single-sided

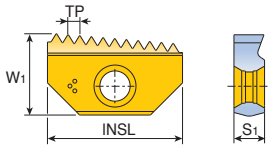
●: Standard items

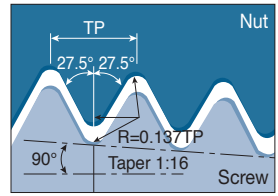
TaeguTec

TTMT-BSPT

TS-THREAD

BSPT - British standard pipe tapered





Insert	Designation	TPI	Dimension (mm)			Grade
			INSL	W1	S1	TT9030
	**TTMT12 19 BSPT**	19	12	6.5	2.9	●
	TTMT14 19 BSPT	19	14	7.9	3.2	●
	TTMT14 14 BSPT	14	14	7.9	3.2	●
	TTMT21 14 BSPT	14	21	12.6	4.8	●
	TTMT21 11 BSPT	11	21	12.6	4.8	●
	TTMT30 11 BSPT	11	30	16.7	5.6	●
	TTMT40 11 BSPT	11	40	20.8	6.4	●

MTE/F

C48-C53

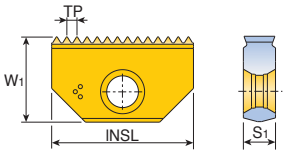
- The same insert for external and internal threading
- Conical pipe thread inserts are single-sided

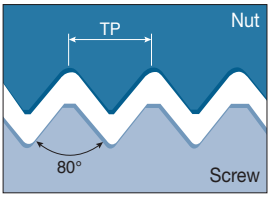
●: Standard items

ADVANCE CUTTING TaeguTec

TTMT-PG

Electrical connectors (DIN 40430)





Insert	Designation	TPI	Thread size	Dimension (mm)			Grade
				INSL	W1	S1	TT9030
	**TTMT14 18 PG**	18	PG9, 11, 13.5, 16	14	7.9	3.2	●
	TTMT21 18 PG	18	PG16	21	12.6	4.8	●
	TTMT21 16 PG	16	PG21, 29, 36, 42, 48	21	12.6	4.8	●
	TTMT30 16 PG	16	PG36, 42, 48	30	16.7	5.6	●

MTE/F

C48-C53

▸ The same insert for external and internal threading

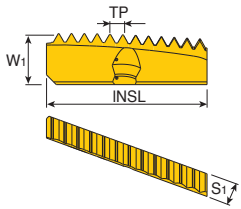
●: Standard items

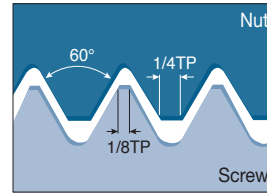
TaeguTec

TMTH-ISO

TS-THREAD

Helical inserts for ISO metric threads (Internal)





Insert	Designation	TP (mm)	THID	Dimension (mm)			Tool	Grade
				INSL	W1	S1		TT9030
	**TMTH 23 I 1.0 ISO**	1.0	≥M26	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 1.5 ISO	1.5	≥M27	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 2.0 ISO	2.0	≥M28	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 3.0 ISO	3.0	≥M30	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 32 I 1.0 ISO	1.0	≥M34	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 1.5 ISO	1.5	≥M35	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 2.0 ISO	2.0	≥M36	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 3.0 ISO	3.0	≥M38	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 4.0 ISO	4.0	≥M40	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 45 I 1.5 ISO	1.5	≥M50	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 45 I 2.0 ISO	2.0	≥M50	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 45 I 3.0 ISO	3.0	≥M56	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 45 I 4.0 ISO	4.0	≥M56	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 63 I 1.5 ISO	1.5	≥M70	38	11.9	5.0	TMTSRH 63-9	●
	TMTH 63 I 2.0 ISO	2.0	≥M70	38	11.9	5.0	TMTSRH 63-9	●
	TMTH 63 I 3.0 ISO	3.0	≥M75	38	11.9	5.0	TMTSRH 63-9	●
	TMTH 63 I 4.0 ISO	4.0	≥M75	38	11.9	5.0	TMTSRH 63-9	●
	TMTH 63 I 6.0 ISO	6.0	≥M78	38	11.9	5.0	TMTSRH 63-9	●

TMTSRH
C51,C54

▸ THID: Thread designation inside

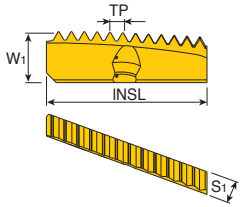
●: Standard items

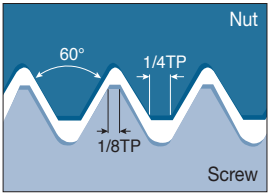
ADVANCE CUTTING
TaeguTec

TMTH-UN

TS-THREAD

Helical inserts for UN, UNC, UNF, UNEF, UNS threads (Internal)





Insert	Designation	TPI	THID	Dimension (mm)			Tool	Grade
				INSL	W1	S1		TT9030
	**TMTH 23 I 24 UN**	24	≥1”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 20 UN	20	≥1”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 18 UN	18	≥1 1/16”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 16 UN	16	≥1 1/16”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 14 UN	14	≥1 1/8”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 12 UN	12	≥1 1/8”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 8 UN	8	≥1 3/16”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 23 I 7 UN	7	≥1 1/4”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 32 I 20 UN	20	≥1 3/8”	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 18 UN	18	≥1 3/8”	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 16 UN	16	≥1 3/8”	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 12 UN	12	≥1 7/16”	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 8 UN	8	≥1 1/2”	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 32 I 6 UN	6	≥1 9/16”	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 45 I 16 UN	16	≥2”	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 45 I 12 UN	12	≥2”	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 45 I 8 UN	8	≥2 1/4”	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 45 I 6 UN	6	≥2 1/4”	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 63 I 16 UN	16	≥2 3/4”	38	11.9	5.0	TMTSRH 63-9	●
	TMTH 63 I 12 UN	12	≥2 3/4”	38	11.9	5.0	TMTSRH 63-9	●
	TMTH 63 I 8 UN	8	≥3”	38	11.9	5.0	TMTSRH 63-9	●
	TMTH 63 I 6 UN	6	≥3”	38	11.9	5.0	TMTSRH 63-9	●

TMTSRH

C51,C54

▸ THID: Thread designation inside

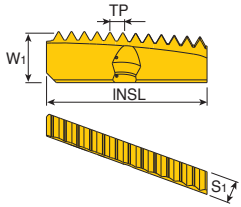
●: Standard items

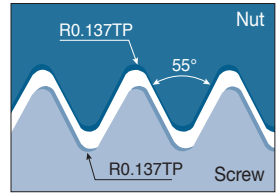
TaeguTec

TMTH-W

TS-THREAD

Helical inserts for whitworth threads, BSW, BSF, BSP (Internal and external)





Insert	Designation	TPI	THID	THOD	Dimension (mm)			Tool	Grade
					INSL	W1	S1		TT9030
	**TMTH 23 11 W**	11	≥G 1”	≥G 1”	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 32 11 W	11	≥G 1 1/8”	≥G 1”	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 45 11 W	11	≥G 1 3/4”	≥G 1”	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 63 11 W	11	≥G 2 1/2”	≥G 1”	38	11.9	5.0	TMTSRH 63-9	●

TMTSRH C51,C54

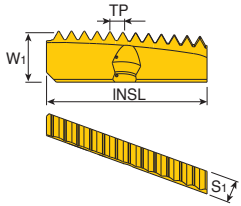
- THID: Thread designation inside
- THOD: Thread designation outside

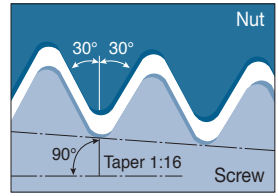
●: Standard item

TMTH-NPT

TS-THREAD

Helical inserts for NPT threads (Internal and external)





Insert	Designation	TPI	THID	THOD	Dimension (mm)			Tool	Grade
					INSL	W1	S1		TT9030
	**TMTH 23 11.5 NPT**	11.5	1”-2” NPT	1”-2” NPT	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 32 11.5 NPT	11.5	11/14”-2” NPT	1”-2” NPT	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 45 11.5 NPT	11.5	2” NPT	1”-2” NPT	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 63 11.5 NPT	11.5	-	≥1” NPT	38	11.9	5.0	TMTSRH 63-9	●

TMTSRH C51,C54

- THID: Thread designation inside
- THOD: Thread designation outside

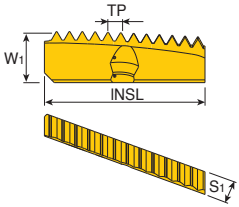
●: Standard items

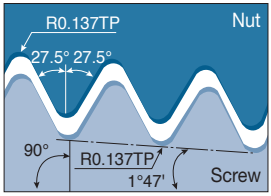
ADVANCE CUTTING TaeguTec

TMTH-BSPT

TS-THREAD

Helical inserts for BSPT threads (Internal and external)





Insert	Designation	TPI	THID	THOD	Dimension (mm)			Tool	Grade
					INSL	W1	S1		TT9030
	**TMTH 23 11 BSPT**	11	≥1" BSPT	≥1" BSPT	27	8.0	3.5	TMTSRH 23-2	●
	TMTH 32 11 BSPT	11	≥1 1/8" BSPT	≥1" BSPT	32	9.0	4.0	TMTSRH 32-5	●
	TMTH 45 11 BSPT	11	≥1 3/4" BSPT	≥1" BSPT	37	11.9	5.0	TMTSRH 45-6	●
	TMTH 63 11 BSPT	11	≥2 1/2" BSPT	≥1" BSPT	38	11.9	5.0	TMTSRH 63-9	●

TMTSRH
C51,C54

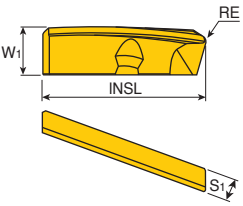
- THID: Thread designation inside
- THOD: Thread designation outside

●: Standard Item

TMTH-F

TS-THREAD

Helical long edge finishing inserts



Insert	Designation	Dimension (mm)				Tool	Grade
		INSL	W1	S1	RE		TT9030
	**TMTH 23F R0.2**	27	8.0	3.5	0.2	TMTSRH 23-2	●
	TMTH 23F R0.5	27	8.0	3.5	0.5	TMTSRH 23-2	●
	TMTH 23F R1.0	27	8.0	3.5	1.0	TMTSRH 23-2	●
	TMTH 32F R0.2	32	9.0	4.0	0.2	TMTSRH 32-5	●
	TMTH 32F R0.5	32	9.0	4.0	0.5	TMTSRH 32-5	●
	TMTH 32F R1.0	32	9.0	4.0	1.0	TMTSRH 32-5	●
	TMTH 45F R0.2	37	11.9	5.0	0.2	TMTSRH 45-6	●

TMTSRH
C51,C54

●: Standard items

Recommended Cutting Conditions

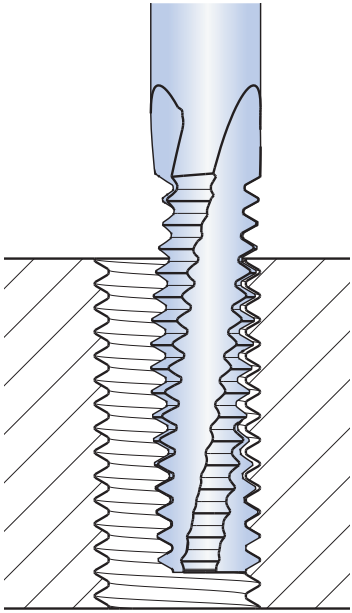
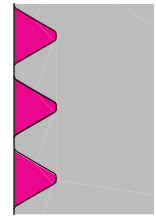
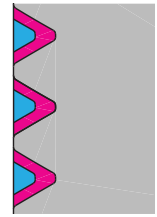
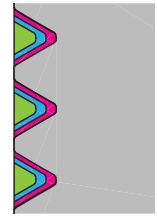
TS-THREAD

Radial depth per pass

Recommended number of passes

ISO	Material	Material No.	Number of passes by pitch			
			0.25-1.0	1.25-1.5	1.75-2.0	2.5-6.0
P	Steels	1-11	1	1	2	3
M	Stainless steels	12-14	1	1	2	3
K	Cast iron	15-20	1	1	2	3
N	Aluminum	21-24	1	1	1	1
	High temp. cast alloys	25	1	1	2	3
	Copper alloys, non metallic	26-30	1	1	1	1
S	High temperature alloys	31-37	2	2	2	3
H	Chilled cast iron	40	3	3	3	3
	Hardened cast iron nodular	41	2	2	2	3

Recommended depths per pass

Number of passes		Radial depths	
	1 pass		1st: 100%
	2 passes		1st: 75% 2nd: 100%
	3 passes		1st: 65% 2nd: 75% 3rd: 100%

Recommended Cutting Conditions

TS-THREAD

Machining data for indexable insert of threading cutters

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc(m/min) TT9030
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	100-200
		>=0.25%C	Annealed	650	190	2	95-190
		<0.55%C	Quenched and tempered	850	250	3	90-180
		>=0.55%C	Annealed	750	220	4	90-170
			Quenched and tempered	1000	300	5	80-150
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	120-170
			Quenched and tempered	930	275	7	115-160
				1000	300	8	105-150
				1200	350	9	140
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	90-170
			Quenched and tempered	1100	325	11	75-145
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	110-170
			Martensitic	820	240	13	100-160
			Austenitic	600	180	14	90-145
K	Gray cast iron (GG)		Ferritic		160	15	65-135
			Pearlitic		250	16	65-110
	Cast iron nodular (GGG)		Ferritic		180	17	65-135
			Pearlitic		260	18	60-100
	Malleable cast iron		Ferritic		130	19	65-135
			Pearlitic		230	20	60-120
N	Aluminum - Wrought alloy		Not cureable		60	21	110-260
			Cured		100	22	110-200
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	145-350
			Cured		90	24	145-275
		>12% Si	High temp.		130	25	95-225
	Copper alloys	>1% Pb	Free cutting		110	26	145-350
			Brass		90	27	145-350
			Electrolitic copper		100	28	145-350
	Non-metallic		Duroplastics, fiber plastics			29	90-370
			Hard rubber			30	80-330
S	High temp. alloys	Fe based	Annealed		200	31	20-60
			Cured		280	32	20-50
		Ni or Co based	Annealed		250	33	20-30
			Cured		350	34	10-20
			Cast		320	35	15-25
	Titanium, Ti alloys		Pure	Rm 400	190	36	30-90
			Alpha+beta alloys cured	Rm 1050	310	37	20-70
H	Hardened steel		Hardened		55HRC	38	25-60
			Hardened		60HRC	39	20-40
	Chilled cast iron		Cast		400	40	25-60
	Cast iron nodular		Hardened		55HRC	41	20-50

▸ For more information of material groups, see the materials & grades "material conversion table"

Steel Stainless steel Cast iron Nonferrous High temp. alloys Hardened steel

▸ Feed rate: 0.05 - 0.15 mm/tooth

Recommended Cutting Conditions

TS-THREAD

Machining data for MTEC, MTECB, MTECQ, MTECZ, MTECH, MTECI

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc(m/min)	
							TT9030	TT5515
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	100-250	100-250
		>=0.25%C	Annealed	650	190	2	80-210	80-210
		<0.55%C	Quenched and tempered	850	250	3	65-170	65-170
		>=0.55%C	Annealed	750	220	4	110-180	110-180
			Quenched and tempered	1000	300	5	95-160	95-160
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	90-160	90-160
			Quenched and tempered	930	275	7	65-200	65-200
				1000	300	8	70-210	70-210
				1200	350	9	95-160	95-160
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	130-170	130-170
			Quenched and tempered	1100	325	11	75-100	75-100
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	110-170	110-170
			Martensitic	820	240	13	70-155	70-155
			Austenitic	600	180	14	85-100	85-100
K	Gray cast iron (GG)		Ferritic		160	15	70-150	70-150
			Pearlitic		250	16	110-140	110-140
	Cast iron nodular (GGG)		Ferritic		180	17	120-160	120-160
			Pearlitic		260	18	75-160	75-160
	Malleable cast iron		Ferritic		130	19	120-160	120-160
			Pearlitic		230	20	110-140	110-140
N	Aluminum - Wrought alloy		Not cureable		60	21	160-300	160-300
			Cured		100	22		
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	150-350	150-350
			Cured		90	24		
		>12% Si	High temp.		130	25	100-250	100-250
	Copper alloys	>1% Pb	Free cutting		110	26		
			Brass		90	27		
			Electrolitic copper		100	28		
	Non-metallic		Duroplastics, fiber plastics			29	100-400	100-400
			Hard rubber			30		
S	High temp. alloys	Fe based	Annealed		200	31		
			Cured		280	32		
		Ni or Co based	Annealed		250	33	20-80	20-80
			Cured		350	34		
			Cast		320	35		
	Titanium, Ti alloys		Pure	Rm 400		36		
			Alpha+beta alloys cured	Rm 1050		37	20-80	30-100
H	Hardened steel		Hardened		55HRC	38	55-65	60-80
			Hardened		60HRC	39	45-55	50-70
	Chilled cast iron		Cast		400	40	90-105	100-120
	Cast iron nodular		Hardened		55HRC	41	55-65	60-80

▸ For more information of material groups, see the materials & grades "material conversion table"

Steel Stainless steel Cast iron Nonferrous High temp. alloys Hardened steel

Recommended Cutting Conditions

TS-THREAD

Machining data for MTEC, MTECB, MTECQ, MTECZ, MTECH, MTECI

Feed (mm/tooth) for diameter (mm)											
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
0.03	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	0.21	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	0.1	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

Recommended Cutting Conditions

TS-THREAD

Machining data for MTECBF, MTECM, MTECK

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc(m/min) TT9030
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	70-120
		>=0.25%C	Annealed	650	190	2	65-115
		<0.55%C	Quenched and tempered	850	250	3	60-110
		>=0.55%C	Annealed	750	220	4	70-90
			Quenched and tempered	1000	300	5	60-85
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	60-80
			Quenched and tempered	930	275	7	60-75
				1000	300	8	55-75
				1200	350	9	55-70
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-65
			Quenched and tempered	1100	325	11	50-63
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	50-60
			Martensitic	820	240	13	50-70
			Austenitic	600	180	14	60-90
K	Gray cast iron (GG)		Ferritic		160	15	60-80
			Pearlitic		250	16	60-75
	Cast iron nodular (GGG)		Ferritic		180	17	50-70
			Pearlitic		260	18	40-65
	Malleable cast iron		Ferritic		130	19	50-70
			Pearlitic		230	20	40-65
N	Aluminum - Wrought alloy		Not cureable		60	21	150
			Cured		100	22	110-
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	120-
			Cured		90	24	120-
		>12% Si	High temp.		130	25	80-110
	Copper alloys	>1% Pb	Free cutting		110	26	85-120
			Brass		90	27	85-120
			Electrolitic copper		100	28	70-100
	Non-metallic		Duroplastics, fiber plastics			29	120-
			Hard rubber			30	120-
S	High temp. alloys	Fe based	Annealed		200	31	40-60
			Cured		280	32	30-50
		Ni or Co based	Annealed		250	33	25-40
			Cured		350	34	20-35
			Cast		320	35	20-40
	Titanium, Ti alloys		Pure	Rm 400		36	30-45
			Alpha+beta alloys cured	Rm 1050		37	30-40
H	Hardened steel		Hardened		55HRC	38	
			Hardened		60HRC	39	
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

▸ For more information of material groups, see the materials & grades "material conversion table"

Steel Stainless steel Cast iron Nonferrous High temp. alloys Hardened steel

Recommended Cutting Conditions

TS-THREAD

Machining data for MTECBF, MTECM, MTECK

Feed (mm/tooth) for diameter (mm)												
Ø1.5	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø12	Ø14	Ø15
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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

Recommended Cutting Conditions

TS-THREAD

Machining data for MTECS, MTECSH, MTECD

ISO	Material		Cutting speed Vc (m/min)		Feed (mm/tooth) for diameter (mm)												
			TT9030	TT1040	Ø1.5	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø12	Ø14	Ø15
P	Low & medium carbon steels		60-120	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	60-90	0.04	0.05	0.06	0.08	0.09	0.10	0.12	0.13	0.14	0.14	0.16	0.17	0.18
	Alloy steels, treated steels		50-80	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	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	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
K	Cast Iron		40-80	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	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	50-200	0.10	0.11	0.12	0.14	0.16	0.18	0.19	0.19	0.19	0.19	0.19	0.20	0.20
S	Nickel alloys, titanium alloys.		20-40	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
H	Hardened steel	HrC 45-50	35-50	60-70	0.04	0.04	0.05	0.05	0.06	0.06	0.07	0.07	0.08				
		HrC 51-55	25-40	50-60	0.03	0.03	0.04	0.04	0.05	0.05	0.06	0.06	0.07				
		HrC 56-62	15-30	40-50	0.02	0.02	0.03	0.03	0.04	0.04	0.05	0.05	0.06				

Steel | Stainless steel | Cast iron | Nonferrous | High temp. alloys | Hardened steel

T-TAP

Tapping



Designation System

TPH	4	5	2	B	05	M2 X 0.4
1	2	3	4	5	6	7

1 TaeguTec T-Tap

T	TaeguTec
P	PM
H	HSSE

2 Standard

4	DIN371
5	DIN374
6	DIN376

3 ISO grade

5	Multi

4 Flute

2	Straight flute-spiral point
4	Right-hand spiral 40°

5 Chamfer

B	4-5 threads
C	2-3 threads

6 Coating

None	Uncoated
05	S.T.
10	TiN

7 Tap X Pitch

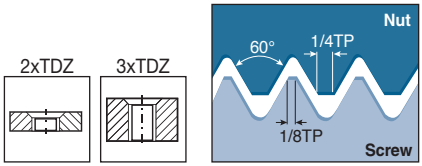
M2 X 0.4	M2 size
	0.4 pitch

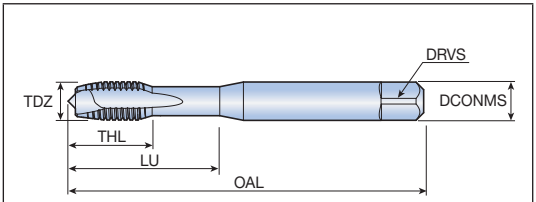
TPH...52B

T-TAP

Straight flute with spiral point - Uncoated







- For general purpose
- Form B: 4-5 threads chamfer

Metric ISO standard thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH452B M2x0.4	M2	0.4	DIN371	ISO 2-6H	45	8	-	2.8	2.1	1.6
TPH452B M2.5x0.45	M2.5	0.45			50	9	-	2.8	2.1	2.05
TPH452B M3x0.5	M3	0.5			56	10	18	3.5	2.7	2.5
TPH452B M4x0.7	M4	0.7			63	12	21	4.5	3.4	3.3
TPH452B M5x0.8	M5	0.8			70	14	25	6	4.9	4.2
TPH452B M6x1.0	M6	1			80	16	30	6	4.9	5
TPH452B M8x1.25	M8	1.25			90	18	35	8	6.2	6.8
TPH452B M10x1.5	M10	1.5			100	20	39	10	8	8.5
TPH652B M12x1.75	M12	1.75	DIN376	ISO 2-6H	110	22	-	9	7	10.2
TPH652B M14x2.0	M14	2			110	24	-	11	9	12
TPH652B M16x2.0	M16	2			110	26	-	12	9	14
TPH652B M20x2.5	M20	2.5			140	30	-	16	12	17.5

Metric ISO fine thread DIN 13 standard

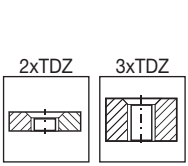
Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH552B MF8x1.0	M8	1	DIN374	ISO 2-6H	90	15	-	6	4.9	7
TPH552B MF10x1.25	M10	1.25			100	18	-	7	5.5	8.8
TPH552B MF12x1.5	M12	1.5			100	18	-	9	7	10.5
TPH552B MF14x1.5	M14	1.5			100	18	-	11	9	12.5
TPH552B MF16x1.5	M16	1.5			100	18	-	12	9	14.5

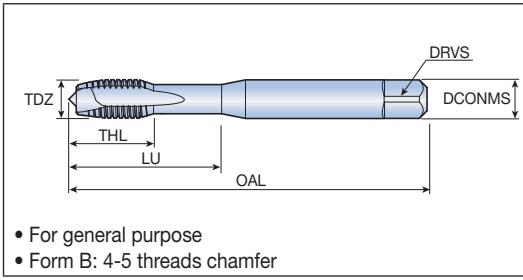
Cutting Condition
C83

TPH...52B05

Straight flute with spiral point - Steam tempered







- For general purpose
- Form B: 4-5 threads chamfer

Metric ISO standard thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH452B05 M2x0.4	M2	0.4	DIN371	ISO 2-6H	45	8	-	2.8	2.1	1.6
TPH452B05 M2.5x0.45	M2.5	0.45			50	9	-	2.8	2.1	2.05
TPH452B05 M3x0.5	M3	0.5			56	10	18	3.5	2.7	2.5
TPH452B05 M4x0.7	M4	0.7			63	12	21	4.5	3.4	3.3
TPH452B05 M5x0.8	M5	0.8			70	14	25	6	4.9	4.2
TPH452B05 M6x1.0	M6	1			80	16	30	6	4.9	5
TPH452B05 M8x1.25	M8	1.25			90	18	35	8	6.2	6.8
TPH452B05 M10x1.5	M10	1.5			100	20	39	10	8	8.5
TPH652B05 M12x1.75	M12	1.75	DIN376	ISO 2-6H	110	22	-	9	7	10.2
TPH652B05 M14x2.0	M14	2			110	24	-	11	9	12
TPH652B05 M16x2.0	M16	2			110	26	-	12	9	14
TPH652B05 M20x2.5	M20	2.5			140	30	-	16	12	17.5

Metric ISO fine thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH552B05 MF8x1.0	M8	1	DIN374	ISO 2-6H	90	15	-	6	4.9	7
TPH552B05 MF10x1.25	M10	1.25			100	18	-	7	5.5	8.8
TPH552B05 MF12x1.5	M12	1.5			100	18	-	9	7	10.5
TPH552B05 MF14x1.5	M14	1.5			100	18	-	11	9	12.5
TPH552B05 MF16x1.5	M16	1.5			100	18	-	12	9	14.5

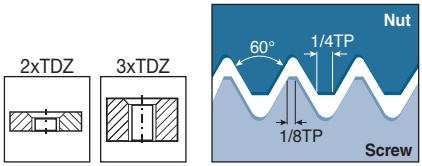
Cutting Condition C83

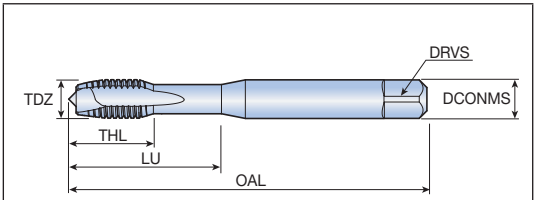
TPH...52B10

T-TAP

Straight flute with spiral point - TiN coated







- For general purpose
- Form B: 4-5 threads chamfer

Metric ISO standard thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH452B10 M2x0.4	M2	0.4	DIN371	ISO 2-6H	45	8	-	2.8	2.1	1.6
TPH452B10 M2.5x0.45	M2.5	0.45			50	9	-	2.8	2.1	2.05
TPH452B10 M3x0.5	M3	0.5			56	10	18	3.5	2.7	2.5
TPH452B10 M4x0.7	M4	0.7			63	12	21	4.5	3.4	3.3
TPH452B10 M5x0.8	M5	0.8			70	14	25	6	4.9	4.2
TPH452B10 M6x1.0	M6	1			80	16	30	6	4.9	5
TPH452B10 M8x1.25	M8	1.25			90	18	35	8	6.2	6.8
TPH452B10 M10x1.5	M10	1.5			100	20	39	10	8	8.5
TPH652B10 M12x1.75	M12	1.75	DIN376	ISO 2-6H	110	22	-	9	7	10.2
TPH652B10 M14x2.0	M14	2			110	24	-	11	9	12
TPH652B10 M16x2.0	M16	2			110	26	-	12	9	14
TPH652B10 M20x2.5	M20	2.5			140	30	-	16	12	17.5

Metric ISO fine thread DIN 13 standard

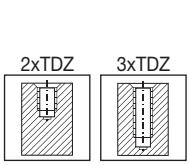
Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH552B10 MF8x1.0	M8	1	DIN374	ISO 2-6H	90	15	-	6	4.9	7
TPH552B10 MF10x1.25	M10	1.25			100	18	-	7	5.5	8.8
TPH552B10 MF12x1.5	M12	1.5			100	18	-	9	7	10.5
TPH552B10 MF14x1.5	M14	1.5			100	18	-	11	9	12.5
TPH552B10 MF16x1.5	M16	1.5			100	18	-	12	9	14.5

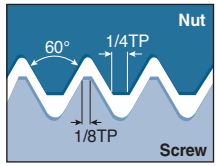
Cutting Condition
CB3

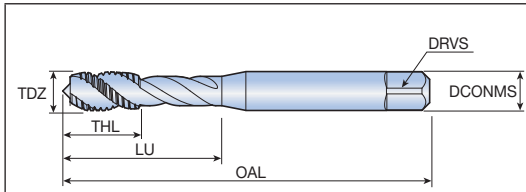
TPH...54C

Right-hand spiral flute (40˚) - Uncoated









- For general purpose
- Form C: 2-3 threads chamfer

Metric ISO standard thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH454C M2x0.4	M2	0.4	DIN371	ISO 2-6H	45	6	10	2.8	2.1	1.6
TPH454C M2.5x0.45	M2.5	0.45			50	6	12	2.8	2.1	2.05
TPH454C M3x0.5	M3	0.5			56	7	18	3.5	2.7	2.5
TPH454C M4x0.7	M4	0.7			63	8	21	4.5	3.4	3.3
TPH454C M5x0.8	M5	0.8			70	10	25	6	4.9	4.2
TPH454C M6x1.0	M6	1			80	12	30	6	4.9	5
TPH454C M8x1.25	M8	1.25			90	15	35	8	6.2	6.8
TPH454C M10x1.5	M10	1.5			100	18	39	10	8	8.5
TPH654C M12x1.75	M12	1.75	DIN376	ISO 2-6H	110	18	-	9	7	10.2
TPH654C M14x2.0	M14	2			110	20	-	11	9	12
TPH654C M16x2.0	M16	2			110	20	-	12	9	14
TPH654C M20x2.5	M20	2.5			140	25	-	16	12	17.5

Metric ISO fine thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH554C MF8x1.0	M8	1	DIN374	ISO 2-6H	90	15	-	6	4.9	7
TPH554C MF10x1.25	M10	1.25			100	18	-	7	5.5	8.8
TPH554C MF12x1.5	M12	1.5			100	18	-	9	7	10.5
TPH554C MF14x1.5	M14	1.5			100	18	-	11	9	12.5
TPH554C MF16x1.5	M16	1.5			100	18	-	12	9	14.5

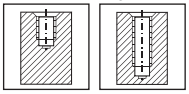
Cutting Condition C84

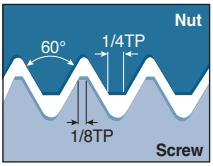
TPH...54C05

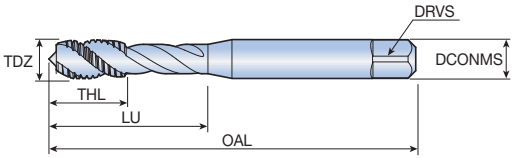
T-TAP

Right-hand spiral flute (40˚) - Steam tempered









- For general purpose
- Form C: 2-3 threads chamfer

Metric ISO standard thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH454C05 M2x0.4	M2	0.4	DIN371	ISO 2-6H	45	6	10	2.8	2.1	1.6
TPH454C05 M2.5x0.45	M2.5	0.45			50	6	12	2.8	2.1	2.05
TPH454C05 M3x0.5	M3	0.5			56	7	18	3.5	2.7	2.5
TPH454C05 M4x0.7	M4	0.7			63	8	21	4.5	3.4	3.3
TPH454C05 M5x0.8	M5	0.8			70	10	25	6	4.9	4.2
TPH454C05 M6x1.0	M6	1			80	12	30	6	4.9	5
TPH454C05 M8x1.25	M8	1.25			90	15	35	8	6.2	6.8
TPH454C05 M10x1.5	M10	1.5			100	18	39	10	8	8.5
TPH654C05 M12x1.75	M12	1.75	DIN376	ISO 2-6H	110	18	-	9	7	10.2
TPH654C05 M14x2.0	M14	2			110	20	-	11	9	12
TPH654C05 M16x2.0	M16	2			110	20	-	12	9	14
TPH654C05 M20x2.5	M20	2.5			140	25	-	16	12	17.5

Metric ISO fine thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH554C05 MF8x1.0	M8	1	DIN374	ISO 2-6H	90	15	-	6	4.9	7
TPH554C05 MF10x1.25	M10	1.25			100	18	-	7	5.5	8.8
TPH554C05 MF12x1.5	M12	1.5			100	18	-	9	7	10.5
TPH554C05 MF14x1.5	M14	1.5			100	18	-	11	9	12.5
TPH554C05 MF16x1.5	M16	1.5			100	18	-	12	9	14.5

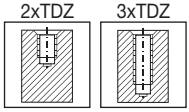
Cutting Condition C84

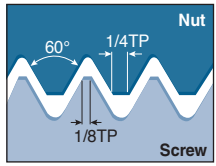
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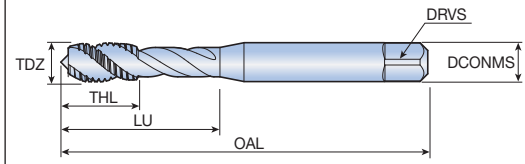
T-TAP

Right-hand spiral flute (40˚) - TiN coated









- For general purpose
- Form C: 2-3 threads chamfer

Metric ISO standard thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH454C10 M2x0.4	M2	0.4	DIN371	ISO 2-6H	45	6	10	2.8	2.1	1.6
TPH454C10 M2.5x0.45	M2.5	0.45			50	6	12	2.8	2.1	2.05
TPH454C10 M3x0.5	M3	0.5			56	7	18	3.5	2.7	2.5
TPH454C10 M4x0.7	M4	0.7			63	8	21	4.5	3.4	3.3
TPH454C10 M5x0.8	M5	0.8			70	10	25	6	4.9	4.2
TPH454C10 M6x1.0	M6	1			80	12	30	6	4.9	5
TPH454C10 M8x1.25	M8	1.25			90	15	35	8	6.2	6.8
TPH454C10 M10x1.5	M10	1.5			100	18	39	10	8	8.5
TPH654C10 M12x1.75	M12	1.75	DIN376	ISO 2-6H	110	18	-	9	7	10.2
TPH654C10 M14x2.0	M14	2			110	20	-	11	9	12
TPH654C10 M16x2.0	M16	2			110	20	-	12	9	14
TPH654C10 M20x2.5	M20	2.5			140	25	-	16	12	17.5

Metric ISO fine thread DIN 13 standard

Designation	TDZ	TP (mm)	Standard (DIN)	Tolerance	Dimension (mm)					
					OAL	THL	LU	DCONMS	DRVS	Core hole
TPH554C10 MF8x1.0	M8	1	DIN374	ISO 2-6H	90	15	-	6	4.9	7
TPH554C10 MF10x1.25	M10	1.25			100	18	-	7	5.5	8.8
TPH554C10 MF12x1.5	M12	1.5			100	18	-	9	7	10.5
TPH554C10 MF14x1.5	M14	1.5			100	18	-	11	9	12.5
TPH554C10 MF16x1.5	M16	1.5			100	18	-	12	9	14.5

Cutting Condition C84

Recommended Cutting Conditions

T-TAP

Machining data for straight flute with spiral point tap

Cutting speed Vc(m/min)

ISO	Material		Condition	Straight flute with spiral point tap			Lubrication
				Uncoated	Steam tempered	TiN coated	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	5-25	5-25 *	15-45 *	E/O
		>=0.25%C	Annealed	5-20	5-20 *	10-40 *	E/O
		<0.55%C	Quenched and tempered	-	2-15 *	5-25 *	E/O
		>=0.55%C	Annealed	5-20	5-20 *	10-40 *	E/O
			Quenched and tempered	-	2-15 *	5-25 *	E/O
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	5-25	5-25 *	15-45 *	E/O
			Quenched and tempered	-	2-15 *	5-20 *	E/O
	High alloy steel, cast steel and tool steel		Annealed	5-20	5-20	10-40 *	E/O
			Quenched and tempered	-	-	5-20	O/S
M	Stainless steel and cast steel		Ferritic / martensitic	-	2-10 *	5-20 *	E/O
			Martensitic	-	2-10 *	5-20 *	E/O
			Austenitic	-	2-10 *	5-20 *	E/O
K	Gray cast iron (GG)		Ferritic	10-15	10-25	15-45	E/D
			Pearlitic	10-15	10-25	10-40	E/D
	Cast iron nodular (GGG)		Ferritic	8-12	5-20	10-30	E/D
			Pearlitic	8-12	5-15	10-25	E/D
	Malleable cast iron		Ferritic	10-15	10-25	15-45	E/D
			Pearlitic	10-15	10-20	10-40	E/D
N	Aluminum - wrought alloy		Not cureable	15-25 *	15-25	15-25	E/O
			Cured	15-25 *	15-25	15-25	E/O
	Aluminum-cast, alloyed	<=12% Si	Not cureable	15-20 *	10-20	15-40 *	E/O
			Cured	15-20 *	10-20	15-40 *	E/O
		>12% Si	High temp.	15-20 *	15-20	10-30	E/O
	Copper alloys	>1% Pb	Free cutting	15-25 *	15-25	10-30	E/O
			Brass	10-40	10-40	20-60	E/O
			Electrolitic copper	10-15 *	2-10	5-25	E/O
	Non-metallic		Duroplastics, fiber plastics	-	10-20	10-20	D
			Hard rubber	-	10-20	10-20	D
S	High temp. alloys	Fe based	Annealed	-	-	3-5	S
			Cured	-	-	3-5	S
		Ni or Co based	Annealed	-	-	2-4	S
			Cured	-	-	2-4	S
			Cast	-	-	2-4	S
	Titanium, Ti alloys		Pure	-	-	4-6	S
			Alpha+beta alloys cured	-	-	4-6	S

* : Recommended

▸ For more information of material groups, see the materials & grades "material conversion table"

Steel Stainless steel Cast iron Nonferrous High temp. alloys Hardened steel

▸ **Lubrication** **E:** Emulsion **O:** Cutting oil **S:** Special cutting oil **D:**Dry/air

Recommended Cutting Conditions

T-TAP

Machining data for 40˚ Right-hand spiral flute tap

Cutting speed Vc(m/min)

ISO	Material		Condition	40˚ Right-hand spiral flute tap			Lubrication
				Uncoated	Steam tempered	TiN coated	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	5-25	5-25*	15-45 *	E/O
		>=0.25%C	Annealed	5-20	5-20*	10-40 *	E/O
		<0.55%C	Quenched and tempered	-	2-15*	5-25 *	E/O
		>=0.55%C	Annealed	5-20	5-20*	10-40 *	E/O
			Quenched and tempered	-	2-15*	5-25 *	E/O
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	5-25	5-25*	15-45 *	E/O
			Quenched and tempered	-	2-15*	5-20 *	E/O
	High alloy steel, cast steel and tool steel		Annealed	5-20	5-20	10-40 *	E/O
			Quenched and tempered	-	-	5-20	O/S
M	Stainless steel and cast steel		Ferritic / martensitic	-	2-10*	5-20*	E/O
			Martensitic	-	2-10*	5-20*	E/O
			Austenitic	-	2-10*	5-20*	E/O
K	Gray cast iron (GG)		Ferritic	10-15	10-25	15-45	E/D
			Pearlitic	10-15	10-20	10-40	E/D
	Cast iron nodular (GGG)		Ferritic	8-12	5-20	10-30	E/D
			Pearlitic	8-12	5-15	10-25	E/D
	Malleable cast iron		Ferritic	10-15	10-25	15-45	E/D
			Pearlitic	10-15	10-20	10-40	E/D
N	Aluminum - wrought alloy		Not cureable	15-25 *	15-25	15-25	E/O
			Cured	15-25 *	15-25	15-25	E/O
	Aluminum-cast, alloyed	<=12% Si	Not cureable	15-20 *	10-20	15-40*	E/O
			Cured	15-20 *	10-20	15-40*	E/O
		>12% Si	High temp.	15-20 *	15-20	10-30	E/O
	Copper alloys	>1% Pb	Free cutting	15-25 *	15-25	10-30	E/O
			Brass	10-40	10-40	50-60	E/O
			Electrolitic copper	10-15 *	2-10	5-25	E/O
	Non-metallic		Duroplastics, fiber plastics	-	10-20	10-20	D
			Hard rubber	-	10-20	10-20	D
S	High temp. alloys	Fe based	Annealed	-	-	3-5	S
			Cured	-	-	3-5	S
		Ni or Co based	Annealed	-	-	2-4	S
			Cured	-	-	2-4	S
			Cast	-	-	2-4	S
	Titanium, Ti alloys		Pure	-	-	4-6	S
			Alpha+beta alloys cured	-	-	4-6	S

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