SECO NEWS 2022.2

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MULTIPLE MILLING HEADS ARE BETTER THAN ONE

SECO X-HEADS

YOUR CHALLENGE
Need to purchase many different end mills and holders to machine different features on a workpiece which adds higher cost to a project.

OUR SOLUTION
Quick-change exchangeable milling head system adapts to various machining needs with a range of cutting profiles and materials without additional holders.

YOUR CHALLENGE
Tool changes require time consuming remeasuring and resetting of tool heights.

OUR SOLUTION
Quick-change milling heads or modular end mills eliminate the need to remove, remeasure and reset tools.

YOUR CHALLENGE
Deep part features require an inventory of various expensive long-reach holders or tools.

OUR SOLUTION
Broad range of quick-change end mills that are adaptable to long-reach shanks.

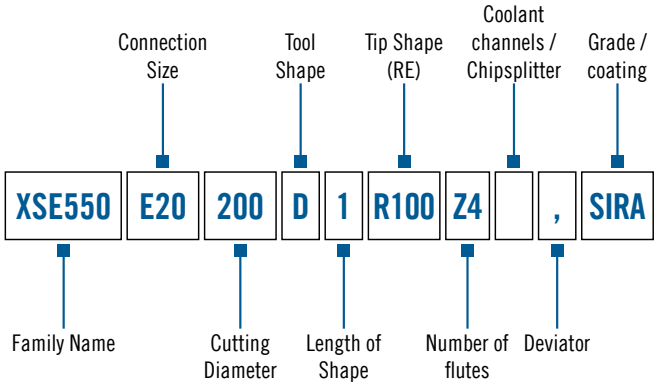
Visit **SECOTOOLS.COM** or scan the QR code and find out more information.

CUSTOMER BENEFITS

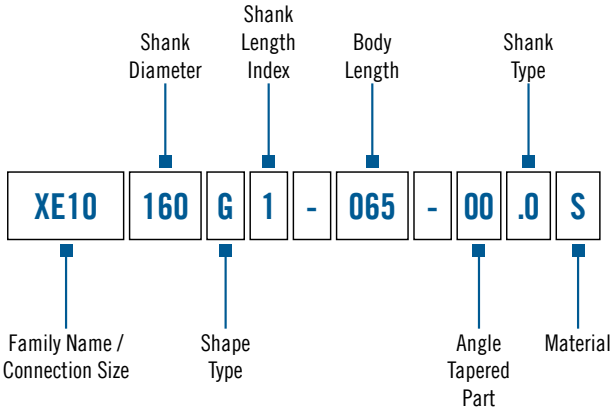
- Tooling speed and simplicity
- Greater machining flexibility
- Shorter tool changeout times
- Better tool setting precision
- Cost-effective tooling
- Increased milling versatility

SECO X-HEADS

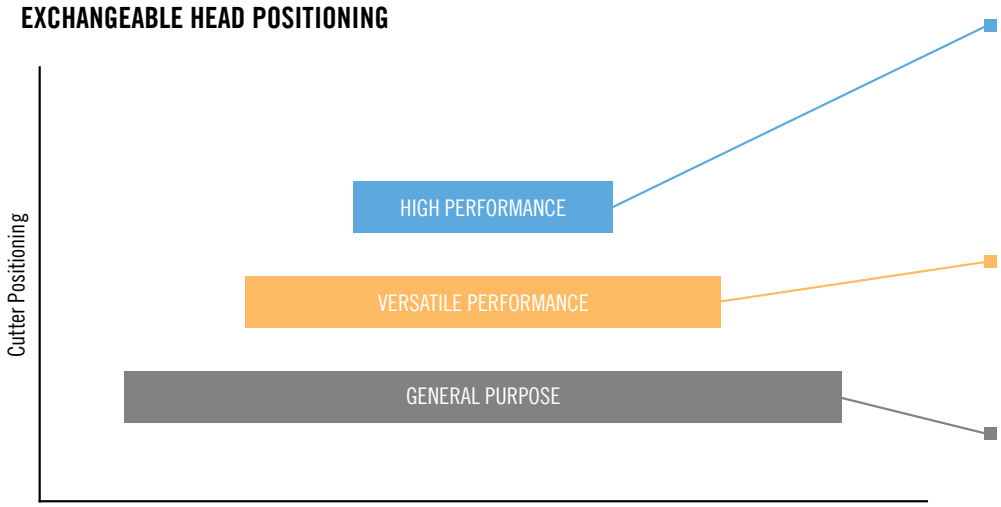
CODE KEY HEADS



CODE KEY SHANKS



EXCHANGEABLE HEAD POSITIONING



HIGH PERFORMANCE	
XSE720 (HXT)	Performance multi-flute
XSB720 (HXT)	Performance ballnose multi-flute
XHF780 (HXT)	Performance HighFeed
XHF580 (SIRA)	Performance HighFeed + ICC
XSE450 (AXT)	Performance Alu dedicated 3 flute
XHT740 (SIRA)	Barrel tools for finishing

VERSATILE PERFORMANCE	
XSE550 (SIRA)	Performance 3 flute
XSE550 (SIRA)	Performance 4 flute
XSE550 (SIRA)	Performance 5 flute
XSB540 (SIRA)	Performance 4 flute ball with ICC

GENERAL PURPOSE	
XVC512 (SIRA)	Chamfer SIG30
XVC506 (SIRA)	Chamfer SIG60
XVC509 (SIRA)	Chamfer SIG90
XVK310 (SIRA)	Concave
XVE540 (SIRA)	Basic 3 &4 flute
XVE510 (SIRA)	Basic 2 flute (spade)
XVB510 (SIRA)	Basic Ball

Please note that the data shown is just an extract and more products are available.
For more information please visit www.secotools.com.

INDUSTRY TARGETS

- General Engineering: Versatile for High Mix & Low Volume.
- Aerospace: Structural Parts and Pylons, Blisks, Casings, Discs.
- Automotive: Transmission parts, Turbo Housings, Steering Knuckles.
- Medical: Implants.
- Energy: Impellers and Turbine Wheels, Turbine Blades.

SECO X-HEADS

X-HEAD HIGH PERFORMANCE CUTTER OVERVIEW

GEOMETRY	XSE720	XSB720	XHF780	XHF580	XSE450	XHT740
TYPE	MULTIFLUTE	BALLNOSE MULTIFLUTE	HIGH FEED	HIGH FEED WITH ICC	DEDICATED ALUMINUM	BARREL FOR FINISHING
DIA RANGE	10-25mm *(0.375-1.0")*	10-20mm *(0.375-1.0")*	10-16mm *(0.375-0.625")*	10-16mm *(0.375-0.625")*	10-20mm *(0.375-1.0")*	10-16mm
NUMBER OF FLUTES	6	6	3	4	3	4 & 6
LENGTH AVAILABILITY	D3	D3	D1	D1	D2	T2 & T3
OPERATION						

X-HEAD VERSATILE PERFORMANCE CUTTER OVERVIEW

GEOMETRY	XSE550	XSE550	XSE550	XSB540
TYPE	SQUARE SHOULDER	SQUARE SHOULDER	SQUARE SHOULDER	BALL ENDMILL WITH ICC
DIA RANGE	10-20mm *(0.375-0.75")*	10-20mm *(0.375-0.75")*	10-20mm *(0.375-1.0")*	10-16mm
NUMBER OF FLUTES	3	4	5	4
LENGTH AVAILABILITY	D1*-D2	D1*-D2	D2	D1
OPERATION				

*D1 (0,55 x DIAMETER) VERSION WITH STABILIZING LAND FOR LONG REACH APPLICATIONS

X-HEAD GENERAL PURPOSE CUTTER OVERVIEW

GEOMETRY	XVC512	XVC506	XVC509	XVK310	XVE540	XVE510	XVB510
TYPE	CHAMFER SIG 120	CHAMFER SIG 60	CHAMFER SIG 90	CONCAVE	SQUARE SHOULDER WITH ICC	SPADE	BALLNOSE
DIA RANGE	12mm	10-12mm	10-16mm	12-20mm	10-20mm *(0.375-0.75")*	10-12mm	10-16mm *(0.375-0.625")*
NUMBER OF FLUTES	2	2	2	4	3 & 4	2	2
LENGTH AVAILABILITY	N1	N1	N1	D1	D1	D1	D1
OPERATION	60° Chamfer	30° Chamfer	45° Chamfer	Chamfering			

Please note that the data shown is just an extract and more products are available.
For more information please visit www.secotools.com.

SECO X-HEADS

REDUCE YOUR INVENTORY

- With this system one cutter head can be used on various shanks to meet different reach requirements.
- Shanks that can accept multiple types of cutting heads.
- Many tool length options with the shank selection.

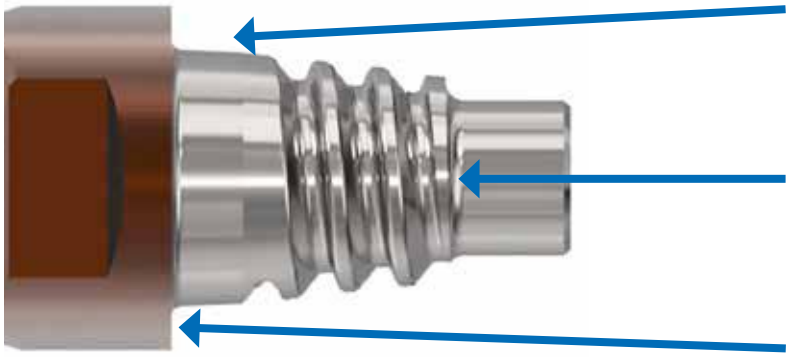
EXCHANGEABLE HEAD SHANKS

Metric/ *Inch* DCONWS	STEEL SHANKS ITEMS	CARBIDE/ HEAVY METAL ITEMS
10	9	3
12	9	3
16	7	3
20	4	4
25	3	2
3/8"	7	1
½"	9	1
5/8"	8	1
¾"	2	1
1"	2	1

Cylindrical Shanks

- 80 total items
- 60 Steel Shanks
- 20 Carbide / Heavy Metal

X-HEAD CONNECTION FEATURES



Ground Taper for secure seating in the shank and optimal axial/radial runout precision.

External Thread on Heads provides easy changeability and adds density for improved performance and strength.

Contact Face with shank for secure mounting and setting height repeatability.

SECO X-HEADS

The new Seco Tools Exchangeable Head range is a comprehensive offering to meet most customer demands. Utilizing our proven solid carbide geometries, we offer various types to machine most materials and complete various machining operations. The connection is a proven exchangeable head design to give high process security and reliability. The shanks offer many types for short reach up to long reach applications. Straight necking and tapered necks to give the best combination of stability depending on the needs for your machining operation.

- XSE550, XSE720, XSE450, XHF580, XHF780 XVE540 and XVE510 for chamfer or radius type.
- XSB540, XSB720 and XVB510 for ball-nose type.
- XVC506, XVC509 and XVC512 for conical type.
- XHT740 for barrel type.

Tool selection X-Heads

Name		XSE550	XSB540	XSE720	XSB720	XSE450	XHT740
Page(s)		483-490	499	501-502	507	513-514	289
Family name		X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS HSM/TORNADO
Type of mill							
Number of Flutes		3,4,5	4	6	6	3	4,6
ICC			■				
Diameter range	Metric	10-20	10-16	10-25	10-20	10-20	10-16
	Inch	3/8-1		3/8-1	3/8-1	3/8-1	
Length availability		1,2	1	3	3	2	2,3
Operation							
SMG							
P1-8		●	●	○	○		○
P11-12		●	○	●	●		●
M1-3		●	●	●	●		●
M4-5		●	●	●	●		
K1-7		●	●				
S1-3		●	○	●	●		○
S11-13		●	●	●	●		●
H3 H5 H7 H8 H11 H12 H21 H31		●	○				
N1		●	●			●	
N2-3		●	●			●	
N11		●	●			●	
TS1		●	●			●	
TP1		●	●			●	
GR		○	○				

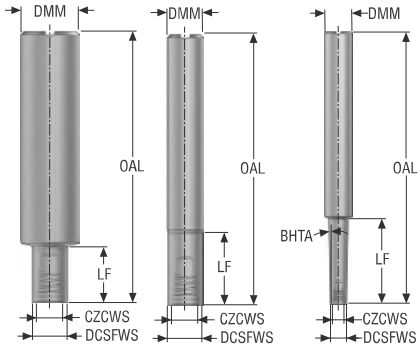
■ Stocked standard.
● Preferred choice, ○ Alternative choice

Tool selection X-Heads

Name		XHF580	XHF780	XVE540	XVE510	XVB510	XVC506/509/512	XVK310
Page(s)		520	525	538	543	546-547	550	554
Family name		X-HEADS HFM	X-HEADS HFM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM
Type of mill								
Number of Flutes		4	3	3,4	2	2	2	4
ICC		■		■				
Diameter range	Metric	10-16	10-16	10-20	10-12	10-16	10-16	12-20
	Inch	3/8-5/8	3/8-5/8	3/8-3/4		3/8-5/8		
Length availability		1	1	1	1	1	1	1
Operation								
SMG								
P1-8		●	○	●	●	●	●	●
P11-12		●	○	●	●	●	●	●
M1-3		●	●	●	●	●	●	●
M4-5		●	●	●	●	●	●	●
K1-7		●		●	●	●	●	●
S1-3		○	●	○	○	○	○	○
S11-13		○	●	○	○	○	○	○
H3 H5 H7 H8 H11 H12 H21 H31		○	○	○				○
N1				●	○	○	○	●
N2-3				●	○	○	○	●
N11				●	○	○	○	●
TS1				●	●	●	●	●
TP1				●	●	●	●	●
GR				○	○	○	○	○

■ Stocked standard.
● Preferred choice, ○ Alternative choice

Steel - Metric



- Tolerances:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					mm	mm	mm	mm		
XE10160G1-065-00.0S	10138083	1	G	E10	9,6	16,0	5,0	65,0	0,0	■
XE10100E2-055-00.0S	10138092	2	E	E10	9,6	10,0	10,0	55,0	0,0	■
XE10100E2-075-00.0S	10138093	2	E	E10	9,6	10,0	20,0	75,0	0,0	■
XE10160G2-075-00.0S	10138088	2	G	E10	9,6	16,0	15,0	75,0	0,0	■
XE10160J3-120-01.0S	10138099	3	J	E10	9,6	16,0	35,0	120,0	1,0	■
XE10160J5-160-01.0S	10138100	5	J	E10	9,6	16,0	50,0	160,0	1,0	■
XE10160J3-140-05.0S	10138106	3	J	E10	9,6	16,0	36,6	140,0	5,0	■
XE10200J5-140-05.0S	10138108	5	J	E10	9,6	20,0	59,4	140,0	5,0	■
XE10320J6-250-10.0S	10138113	6	J	E10	9,6	32,0	63,5	250,0	10,0	■
XE12160G1-065-00.0S	10138084	1	G	E12	11,6	16,0	5,0	65,0	0,0	■
XE12120E2-065-00.0S	10138094	2	E	E12	11,6	12,0	12,0	65,0	0,0	■
XE12120E2-100-00.0S	10138095	2	E	E12	11,6	12,0	22,0	100,0	0,0	■
XE12160G2-080-00.0S	10138089	2	G	E12	11,6	16,0	18,0	80,0	0,0	■
XE12160J3-155-01.0S	10138101	3	J	E12	11,6	16,0	42,0	155,0	1,0	■
XE12160J5-170-01.0S	10138102	5	J	E12	11,6	16,0	60,0	170,0	1,0	■
XE12160J2-140-05.0S	10138107	2	J	E12	11,6	16,0	25,1	140,0	5,0	■
XE12200J4-155-05.0S	10138109	4	J	E12	11,6	20,0	48,0	155,0	5,0	■
XE12320J4-250-10.0S	10138114	4	J	E12	11,6	32,0	57,8	250,0	10,0	■
XE16200G1-070-00.0S	10138085	1	G	E16	15,4	20,0	5,0	70,0	0,0	■
XE16160E2-070-00.0S	10138096	2	E	E16	15,4	16,0	16,0	70,0	0,0	■
XE16200G2-090-00.0S	10138090	2	G	E16	15,4	20,0	24,0	90,0	0,0	■
XE16200G2-110-00.0S	10138091	2	G	E16	15,4	20,0	25,0	110,0	0,0	■
XE16200J3-190-01.0S	10138103	3	J	E16	15,4	20,0	56,0	190,0	1,0	■
XE16200J4-190-01.0S	10138104	4	J	E16	15,4	20,0	75,0	190,0	1,0	■
XE16250J3-170-05.0S	10138110	3	J	E16	15,4	25,0	54,9	170,0	5,0	■
XE20250G1-080-00.0S	10138086	1	G	E20	19,2	25,0	5,0	80,0	0,0	■
XE20200E2-120-00.0S	10138097	2	E	E20	19,2	20,0	30,0	120,0	0,0	■
XE20250J4-200-01.0S	10138105	4	J	E20	19,2	25,0	80,0	200,0	1,0	■
XE20320J3-180-05.0S	10138111	3	J	E20	19,2	32,0	73,2	180,0	5,0	■
XE25320G1-080-00.0S	10138087	1	G	E25	24,1	32,0	5,0	80,0	0,0	■
XE25250E2-140-00.0S	10138098	2	E	E25	24,1	25,0	40,0	140,0	0,0	■
XE25320J2-200-05.0S	10138112	2	J	E25	24,1	32,0	45,1	200,0	5,0	■

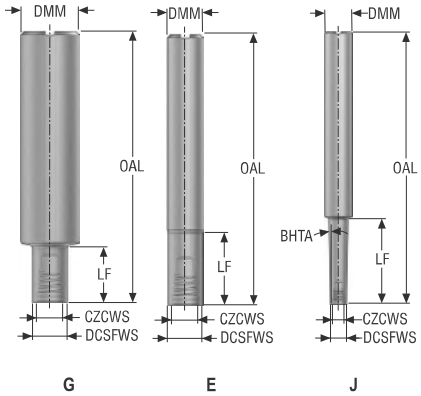
Spare Parts

Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Steel - Inch



- Tolerances:
- DMM= h6
- DCSFWS= ±.002 inch
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					inch	inch	inch	inch		
XE10.500G1-2.50-00.0S	10138050	1	G	E10	0.360	0.500	0.250	2.500	0,0	■
XE10.375E2-2.50-00.0S	10138053	2	E	E10	0.360	0.375	0.402	2.500	0,0	■
XE10.500G2-3.00-00.0S	10138051	2	G	E10	0.360	0.500	1.000	3.000	0,0	■
XE10.625J3-4.50-01.0S	10138063	3	J	E10	0.360	0.625	1.402	4.500	1,0	■
XE10.625J5-6.50-01.0S	10138064	5	J	E10	0.360	0.625	2.000	6.500	1,0	■
XE10.625J4-4.00-03.0S	10138071	4	J	E10	0.360	0.625	1.799	4.000	3,0	■
XE10.750J9-6.00-03.0S	10138072	9	J	E10	0.360	0.750	3.720	6.000	3,0	■
XE12.500E1-3.00-00.0S	10138054	1	E	E12	0.480	0.500	0.250	3.000	0,0	■
XE12.500E2-2.50-00.0S	10138055	2	E	E12	0.480	0.500	0.500	2.500	0,0	■
XE12.500E2-4.50-00.0S	10138056	2	E	E12	0.480	0.500	1.000	4.500	0,0	■
XE12.625J3-6.00-01.0S	10138065	3	J	E12	0.480	0.625	1.650	6.000	1,0	■
XE12.625J4-7.50-01.0S	10138066	4	J	E12	0.480	0.625	2.400	7.500	1,0	■
XE12.750J5-6.50-01.0S	10138067	5	J	E12	0.480	0.750	2.850	6.500	1,0	■
XE12.750J4-4.50-03.0S	10138073	4	J	E12	0.480	0.750	2.201	4.500	3,0	■
XE12.750J5-6.00-03.0S	10138074	5	J	E12	0.480	0.750	2.575	6.000	3,0	■
XE12.625J2-6.50-05.0S	10138075	2	J	E12	0.480	0.625	0.827	6.500	5,0	■
XE16.625E1-3.00-00.0S	10138057	1	E	E16	0.606	0.625	0.250	3.000	0,0	■
XE16.625E2-3.00-00.0S	10138058	2	E	E16	0.606	0.625	0.650	3.000	0,0	■
XE16.625E2-4.50-00.0S	10138059	2	E	E16	0.606	0.625	1.000	4.500	0,0	■
XE16.750J3-7.50-01.0S	10138068	3	J	E16	0.606	0.750	2.252	7.500	1,0	■
XE16.750J4-7.50-01.0S	10138070	4	J	E16	0.606	0.750	3.000	7.500	1,0	■
XE16.750J6-7.50-01.0S	10138069	6	J	E16	0.606	0.750	3.748	7.500	1,0	■
XE16.750J2-6.50-05.0S	10138076	2	J	E16	0.606	0.750	0.821	6.500	5,0	■
XE161.00J3-7.00-05.0S	10138077	3	J	E16	0.606	1.000	2.250	7.000	5,0	■
XE20.750E1-3.00-00.0S	10138060	1	E	E20	0.724	0.750	0.250	3.000	0,0	■
XE20.750E2-4.50-00.0S	10138061	2	E	E20	0.724	0.750	1.000	4.500	0,0	■
XE251.00E1-3.50-00.0S	10138062	1	E	E25	0.961	1.000	0.250	3.500	0,0	■
XE251.25G2-6.50-00.0S	10138052	2	G	E25	0.961	1.250	2.500	6.500	0,0	■

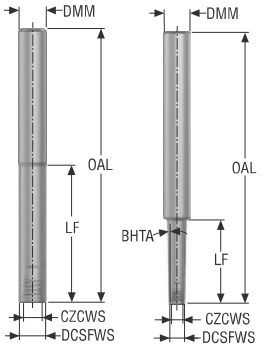
Spare Parts

Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Solid carbide - Metric



E J

- Tolerances:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					mm	mm	mm	mm		
XE10100E5-100-00.0E	10138120	5	E	E10	9,6	10,0	50,0	100,0	0,0	■
XE10160J9-155-01.0E	10138126	9	J	E10	9,6	16,0	100,0	155,0	1,0	■
XE12120E4-100-00.0E	10138121	4	E	E12	11,6	12,0	48,0	100,0	0,0	■
XE12160J7-150-01.0E	10138127	7	J	E12	11,6	16,0	90,0	150,0	1,0	■
XE16160E5-135-00.0E	10138122	5	E	E16	15,4	16,0	80,0	135,0	0,0	■
XE16200J7-175-01.0E	10138128	7	J	E16	15,4	20,0	118,0	175,0	1,0	■
XE20200E2-095-00.0E	10138123	2	E	E20	19,2	20,0	38,0	95,0	0,0	■
XE20200E5-180-00.0E	10138124	5	E	E20	19,2	20,0	110,0	180,0	0,0	■
XE20250J4-200-02.0E	10138129	4	J	E20	19,2	25,0	83,0	200,0	2,0	■
XE25250E4-200-00.0E	10138125	4	E	E25	24,1	25,0	120,0	200,0	0,0	■

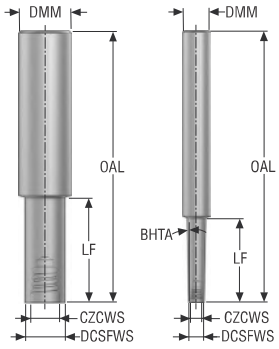
Spare Parts

Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Solid carbide - inch



- Tolerances:
- DMM= h6
- DCSFWS= ±.002 inch
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					inch	inch	inch	inch		
XE10.625J5-6.50-01.0E	10138079	5	J	E10	0.360	0.625	2.000	6.500	1,0	■
XE12.625J4-7.50-01.0E	10138080	4	J	E12	0.480	0.625	2.400	7.500	1,0	■
XE16.750J4-7.50-01.0E	10138081	4	J	E16	0.606	0.750	3.000	7.500	1,0	■
XE201.00J4-8.00-01.0E	10138082	4	J	E20	0.724	1.000	3.150	8.000	1,0	■
XE251.25G2-6.50-00.0E	10138078	2	G	E25	0.961	1.250	2.500	6.500	0,0	■

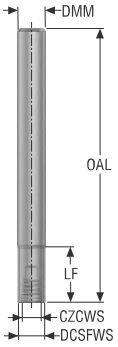
Spare Parts

Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Densimet - Metric



E

- Tolerances:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					mm	mm	mm	mm		
XE10100E2-100-00.0DM	10138115	2	E	E10	9,6	10,0	20,0	100,0	0,0	■
XE12120E2-110-00.0DM	10138116	2	E	E12	11,6	12,0	25,0	110,0	0,0	■
XE16160E2-130-00.0DM	10138117	2	E	E16	15,4	16,0	35,0	130,0	0,0	■
XE20200E2-160-00.0DM	10138118	2	E	E20	19,2	20,0	45,0	160,0	0,0	■
XE25250E2-185-00.0DM	10138119	2	E	E25	24,1	25,0	65,0	185,0	0,0	■

Spare Parts

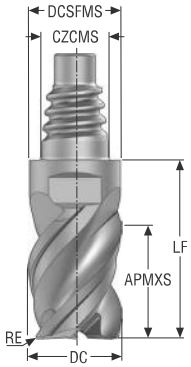
Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

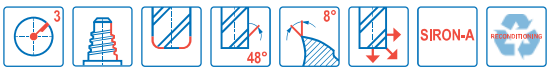
■ Stocked standard.

XSE550

High performance – Universal – Square – 3 Flutes – Corner radius



D



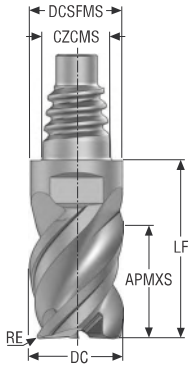
- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D1R050Z3	10138138	1	D	E10	10,0	9,7	5,5	12,3	0,5	3	8	■
XSE550E12120D1R050Z3	10138139	1	D	E12	12,0	11,7	6,6	14,4	0,5	3	10	■
XSE550E16160D1R050Z3	10138140	1	D	E16	16,0	15,5	8,8	18,6	0,5	3	12	■
XSE550E20200D1R050Z3	10138141	1	D	E20	20,0	19,3	11,0	21,2	0,5	3	16	■
XSE550E10100D2R050Z3	10138142	2	D	E10	10,0	9,7	12,0	18,7	0,5	3	8	■
XSE550E12120D2R050Z3	10138143	2	D	E12	12,0	11,7	14,4	22,1	0,5	3	10	■
XSE550E16160D2R050Z3	10138144	2	D	E16	16,0	15,5	19,2	29,2	0,5	3	12	■
XSE550E20200D2R050Z3	10138145	2	D	E20	20,0	19,3	24,0	34,3	0,5	3	16	■

■ Stocked standard.

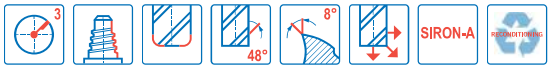
XSE550 – Inch

High performance – Universal – Square – 3 Flutes – Corner radius – *Inch*



D

- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D1R030Z3	10138146	1	D	E10	0.375	0.364	0.206	0.484	0.030	3	8	■
XSE550E12.500D1R030Z3	10138147	1	D	E12	0.500	0.484	0.275	0.567	0.030	3	10	■
XSE550E20.750D1R030Z3	10138148	1	D	E20	0.750	0.728	0.413	0.835	0.030	3	16	■
XSE550E10.375D2R030Z3	10138149	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8	■
XSE550E12.500D2R030Z3	10138150	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10	■
XSE550E20.750D2R030Z3	10138151	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16	■

■ Stocked standard.

Cutting data – XSE550 – Side milling PCEDC 3

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	215 (190 — 240) *710 (630 — 780)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	160 (140 — 180) *520 (460 — 590)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	105 (93 — 110) *345 (310 — 360)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (60 — 75) *215 (200 — 240)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 130) *395 (370 — 420)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	100 (88 — 110) *330 (290 — 360)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (50 — 74) *195 (170 — 240)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	48 (39 — 57) *155 (130 — 180)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	40 (32 — 47) *130 (110 — 150)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (160 — 200) *560 (530 — 650)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	150 (150 — 180) *490 (500 — 590)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	125 (120 — 150) *410 (400 — 490)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	120 (120 — 140) *395 (400 — 450)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	200 (180 — 220) *660 (600 — 720)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 500) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*

Cutting data – XSE550 – Slot milling PCEDC 3

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	50 (46 — 58) *165 (160 — 190)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	80 (70 — 89) *260 (230 — 290)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	50 (41 — 60) *165 (140 — 190)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (140 — 180) *490 (460 — 590)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*

Cutting data – XSE550 – Side milling PCEDC 3 – inch

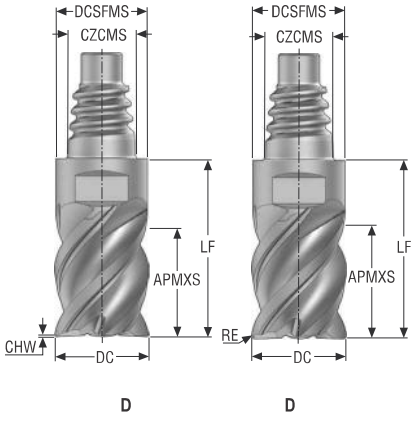
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	215 (190 — 240) *710 (630 — 780)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	160 (140 — 180) *520 (460 — 590)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	105 (93 — 110) *345 (310 — 360)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (60 — 75) *215 (200 — 240)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 130) *395 (370 — 420)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	100 (88 — 110) *330 (290 — 360)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (50 — 74) *195 (170 — 240)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	48 (39 — 57) *155 (130 — 180)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	40 (32 — 47) *130 (110 — 150)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (160 — 200) *560 (530 — 650)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	150 (150 — 180) *490 (500 — 590)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	125 (120 — 150) *410 (400 — 490)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	120 (120 — 140) *395 (400 — 450)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	200 (180 — 220) *660 (600 — 720)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 500) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*

Cutting data – XSE550 – Slot milling PCEDC 3 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	50 (46 — 58) *165 (160 — 190)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	80 (70 — 89) *260 (230 — 290)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	50 (41 — 60) *165 (140 — 190)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (140 — 180) *490 (460 — 590)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*

XSE550

High performance – Universal – Square – 4 Flutes – Corner radius or chamfer



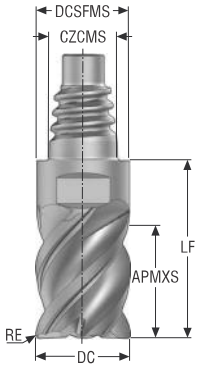
- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E10100D2CZ4	10138152	2	D	E10	10,0	9,7	12,0	18,7	0,125	–	4	8	■
XSE550E12120D2CZ4	10138153	2	D	E12	12,0	11,7	14,4	22,1	0,15	–	4	10	■
XSE550E16160D2CZ4	10138154	2	D	E16	16,0	15,5	19,2	29,2	0,2	–	4	12	■
XSE550E20200D2CZ4	10138155	2	D	E20	20,0	19,3	24,0	34,3	0,25	–	4	16	■
XSE550E10100D1R050Z4	10138156	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	4	8	■
XSE550E12120D1R050Z4	10138157	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	4	10	■
XSE550E16160D1R050Z4	10138158	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	4	12	■
XSE550E20200D1R100Z4	10138159	1	D	E20	20,0	19,3	11,0	21,2	–	1,0	4	16	■
XSE550E10100D2R100Z4	10138161	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	4	8	■
XSE550E12120D2R100Z4	10138165	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	4	10	■
XSE550E16160D2R100Z4	10138169	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	4	12	■
XSE550E20200D2R100Z4	10138172	2	D	E20	20,0	19,3	24,0	34,3	–	1,0	4	16	■
XSE550E10100D2R050Z4	10138160	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	4	8	■
XSE550E10100D2R200Z4	10138162	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	4	8	■
XSE550E10100D2R250Z4	10138163	2	D	E10	10,0	9,7	12,0	18,7	–	2,5	4	8	■
XSE550E12120D2R050Z4	10138164	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	4	10	■
XSE550E12120D2R200Z4	10138166	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	4	10	■
XSE550E12120D2R300Z4	10138167	2	D	E12	12,0	11,7	14,4	22,1	–	3,0	4	10	■
XSE550E16160D2R050Z4	10138168	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	4	12	■
XSE550E16160D2R200Z4	10138170	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	4	12	■
XSE550E16160D2R300Z4	10138171	2	D	E16	16,0	15,5	19,2	29,2	–	3,0	4	12	■
XSE550E20200D2R200Z4	10138173	2	D	E20	20,0	19,3	24,0	34,3	–	2,0	4	16	■
XSE550E20200D2R300Z4	10138174	2	D	E20	20,0	19,3	24,0	34,3	–	3,0	4	16	■
XSE550E20200D2R400Z4	10138175	2	D	E20	20,0	19,3	24,0	34,3	–	4,0	4	16	■

■ Stocked standard.

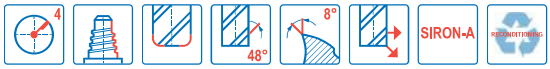
XSE550 – Inch

High performance – Universal – Square – 4 Flutes – Corner radius – *Inch*



D

- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D1R030Z4	10138176	1	D	E10	0.375	0.364	0.206	0.484	0.030	4	8	■
XSE550E12.500D1R030Z4	10138177	1	D	E12	0.500	0.484	0.275	0.567	0.030	4	10	■
XSE550E20.750D1R030Z4	10138178	1	D	E20	0.750	0.728	0.413	0.835	0.030	4	16	■
XSE550E10.375D2R030Z4	10138179	2	D	E10	0.375	0.364	0.450	0.720	0.030	4	8	■
XSE550E12.500D2R030Z4	10138180	2	D	E12	0.500	0.484	0.600	0.906	0.030	4	10	■
XSE550E20.750D2R030Z4	10138181	2	D	E20	0.750	0.728	0.900	1.295	0.030	4	16	■

■ Stocked standard.

Cutting data – XSE550 – Side milling PCEDC 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	150 (140 — 170) *490 (460 — 550)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	95 (84 — 100) *310 (280 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	60 (54 — 68) *195 (180 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	110 (97 — 120) *360 (320 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	90 (80 — 100) *295 (270 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (47 — 70) *195 (160 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (37 — 54) *150 (130 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	38 (31 — 45) *125 (110 — 140)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	160 (160 — 190) *520 (530 — 620)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	140 (140 — 170) *460 (460 — 550)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	120 (120 — 140) *395 (400 — 450)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	115 (110 — 130) *375 (370 — 420)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 490) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*

Cutting data – XSE550 – Slot milling PCEDC 4

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (44 — 55) *165 (150 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	80 (70 — 90) *260 (230 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (40 — 60) *165 (140 — 190)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (150 — 180) *490 (500 — 590)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 350) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*

Cutting data – XSE550 – Side milling PCEDC 4 inch

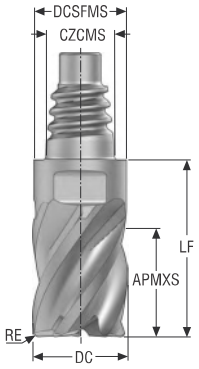
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	150 (140 — 170) *490 (460 — 550)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	95 (84 — 100) *310 (280 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	60 (54 — 68) *195 (180 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	110 (97 — 120) *360 (320 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	90 (80 — 100) *295 (270 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (47 — 70) *195 (160 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (37 — 54) *150 (130 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	38 (31 — 45) *125 (110 — 140)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	160 (160 — 190) *520 (530 — 620)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	140 (140 — 170) *460 (460 — 550)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	120 (120 — 140) *395 (400 — 450)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	115 (110 — 130) *375 (370 — 420)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 490) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*

Cutting data – XSE550 – Slot milling PCEDC 4 inch

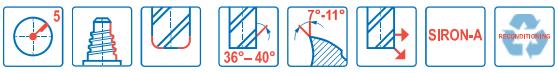
SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (44 — 55) *165 (150 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	80 (70 — 90) *260 (230 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (40 — 60) *165 (140 — 190)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (150 — 180) *490 (500 — 590)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 350) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*

XSE550

High performance – Universal – Square – 5 Flutes – Corner radius



D



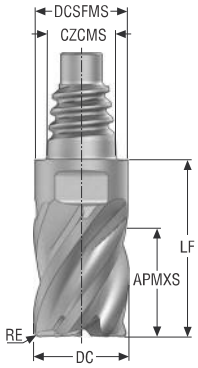
- Tolerances:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D2R050Z5	10138337	2	D	E10	10,0	9,7	12,0	18,7	0,5	5	8	■
XSE550E10100D2R100Z5	10138338	2	D	E10	10,0	9,7	12,0	18,7	1,0	5	8	■
XSE550E12120D2R050Z5	10138339	2	D	E12	12,0	11,7	14,4	22,1	0,5	5	10	■
XSE550E12120D2R100Z5	10138340	2	D	E12	12,0	11,7	14,4	22,1	1,0	5	10	■
XSE550E16160D2R050Z5	10138341	2	D	E16	16,0	15,5	19,2	29,2	0,5	5	12	■
XSE550E16160D2R100Z5	10138342	2	D	E16	16,0	15,5	19,2	29,2	1,0	5	12	■
XSE550E20200D2R050Z5	10138343	2	D	E20	20,0	19,3	24,0	34,3	0,5	5	16	■
XSE550E20200D2R100Z5	10138344	2	D	E20	20,0	19,3	24,0	34,3	1,0	5	16	■

■ Stocked standard.

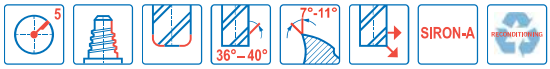
XSE550

High performance – Universal – Square – 5 Flutes – Corner radius – *Inch*



D

- Tolerances:
- DC= 0/-.002 Inch
- RE= ±.001 Inch
- Regrind possible if DC is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D2R015Z5	10138345	2	D	E10	0.375	0.364	0.450	0.720	0.015	5	8	■
XSE550E10.375D2R030Z5	10138346	2	D	E10	0.375	0.364	0.450	0.720	0.030	5	8	■
XSE550E10.375D2R045Z5	10138347	2	D	E10	0.375	0.364	0.450	0.720	0.044	5	8	■
XSE550E12.500D2R030Z5	10138348	2	D	E12	0.500	0.484	0.600	0.906	0.030	5	10	■
XSE550E12.500D2R060Z5	10138349	2	D	E12	0.500	0.484	0.600	0.906	0.060	5	10	■
XSE550E12.500D2R120Z5	10138350	2	D	E12	0.500	0.484	0.600	0.906	0.120	5	10	■
XSE550E16.625D2R030Z5	10138351	2	D	E16	0.625	0.610	0.750	1.150	0.030	5	12	■
XSE550E16.625D2R060Z5	10138352	2	D	E16	0.625	0.610	0.750	1.150	0.060	5	12	■
XSE550E16.625D2R120Z5	10138353	2	D	E16	0.625	0.610	0.750	1.150	0.120	5	12	■
XSE550E20.750D2R030Z5	10138354	2	D	E20	0.750	0.728	0.900	1.295	0.030	5	16	■
XSE550E20.750D2R060Z5	10138355	2	D	E20	0.750	0.728	0.900	1.295	0.060	5	16	■
XSE550E20.750D2R120Z5	10138356	2	D	E20	0.750	0.728	0.900	1.295	0.120	5	16	■
XSE550E251.00D2R030Z5	10138357	2	D	E25	1.000	0.965	1.200	1.673	0.030	5	20	■
XSE550E251.00D2R060Z5	10138358	2	D	E25	1.000	0.965	1.200	1.673	0.060	5	20	■
XSE550E251.00D2R120Z5	10138359	2	D	E25	1.000	0.965	1.200	1.673	0.120	5	20	■

■ Stocked standard.

Cutting data – XSE550 – Side milling PCEDC 5

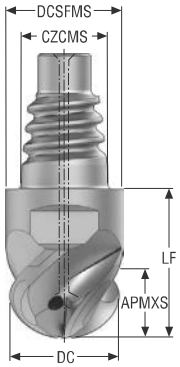
SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20		
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	165 (160 — 190) *540 (530 — 620)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (140 — 170) *475 (460 — 550)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	125 (120 — 140) *410 (400 — 450)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	120 (110 — 140) *395 (370 — 450)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	200 (170 — 220) *660 (560 — 720)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	44 (27 — 61) *145 (89 — 200)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	35 (22 — 49) *115 (73 — 160)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	31 (19 — 43) *100 (63 — 140)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	105 (75 — 130) *345 (250 — 420)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (58 — 100) *260 (200 — 320)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	65 (46 — 81) *215 (160 — 260)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
GR1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*

Cutting data – XSE550 – Side milling PCEDC 5 inch

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	165 (160 — 190) *540 (530 — 620)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (140 — 170) *475 (460 — 550)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	125 (120 — 140) *410 (400 — 450)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	120 (110 — 140) *395 (370 — 450)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	200 (170 — 220) *660 (560 — 720)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	44 (27 — 61) *145 (89 — 200)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	35 (22 — 49) *115 (73 — 160)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	31 (19 — 43) *100 (63 — 140)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	105 (75 — 130) *345 (250 — 420)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (58 — 100) *260 (200 — 320)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	65 (46 — 81) *215 (160 — 260)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
GR1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*

XSB540

High performance – Universal – Ball nose – 4 Flutes – ICC



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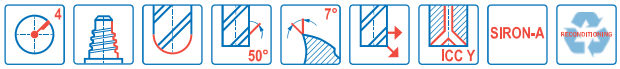


- Tolerances:
- DC= e8
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CSP	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
						mm	mm	mm	mm			SIRA
XSB540E10100D1BZ4A	10138334	1	D	■	E10	10,0	9,7	5,5	12,3	4	8	■
XSB540E12120D1BZ4A	10138335	1	D	■	E12	12,0	11,7	6,6	14,4	4	10	■
XSB540E16160D1BZ4A	10138336	1	D	■	E16	16,0	15,5	8,8	18,6	4	12	■

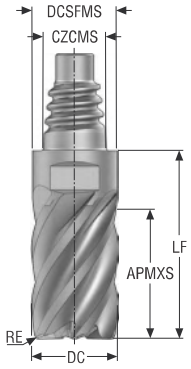
■ Stocked standard.

Cutting data – XSB540 Copy milling roughing

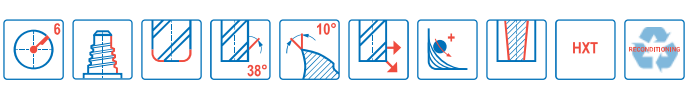
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	190 (160 — 220) *620 (530 — 720)*
P12	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M1	E/M/A	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	145 (120 — 170) *475 (400 — 550)*
M2	E/M/A	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M3	E/M/A	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	95 (75 — 110) *310 (250 — 360)*
M4	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	75 (57 — 88) *245 (190 — 280)*
M5	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	60 (48 — 74) *195 (160 — 240)*
K1	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	205 (190 — 220) *670 (630 — 720)*
K2	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	180 (160 — 190) *590 (530 — 620)*
K3	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	150 (140 — 160) *490 (460 — 520)*
K4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	170 (150 — 190) *560 (500 — 620)*
K5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	105 (90 — 110) *345 (300 — 360)*
K6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	150 (140 — 160) *490 (460 — 520)*
K7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	130 (120 — 140) *425 (400 — 450)*
N1	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	640 (540 — 740) *2100 (1800 — 2400)*
N2	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	275 (230 — 320) *900 (760 — 1000)*
N11	E/M/A	0,15 *0.15*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	430 (380 — 480) *1400 (1300 — 1500)*
S1	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (54 — 74) *215 (180 — 240)*
S2	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (59 — 75) *215 (200 — 240)*
S3	E	0,10 *0.10*	0,50 *0.50*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	32 (22 — 42) *105 (73 — 130)*
S11	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	110 (98 — 120) *360 (330 — 390)*
S12	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 96) *280 (250 — 310)*
S13	E	0,15 *0.15*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	65 (59 — 75) *215 (200 — 240)*
H5	M/A	0,030 *0.030*	0,44 *0.44*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
H8	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H21	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H31	M/A	0,030 *0.030*	0,44 *0.44*	0,034 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	100 (86 — 110) *330 (290 — 360)*
TS1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
TP1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
GR1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	640 (540 — 740) *2100 (1800 — 2400)*

XSE720

High performance – Superalloy – Square – 6 Flutes – Corner radius



D



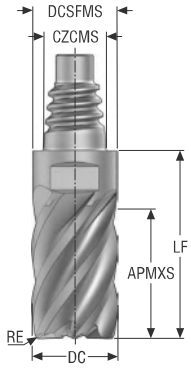
- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			HXT
XSE720E10100D3R050Z6	10138187	3	D	E10	10,0	9,7	15,0	21,8	0,5	6	8	■
XSE720E10100D3R100Z6	10138188	3	D	E10	10,0	9,7	15,0	21,8	1,0	6	8	■
XSE720E12120D3R050Z6	10138189	3	D	E12	12,0	11,7	18,0	25,9	0,5	6	10	■
XSE720E12120D3R100Z6	10138190	3	D	E12	12,0	11,7	18,0	25,9	1,0	6	10	■
XSE720E12120D3R200Z6	10138191	3	D	E12	12,0	11,7	18,0	25,9	2,0	6	10	■
XSE720E12120D3R300Z6	10138192	3	D	E12	12,0	11,7	18,0	25,9	3,0	6	10	■
XSE720E16160D3R050Z6	10138193	3	D	E16	16,0	15,5	24,0	34,1	0,5	6	12	■
XSE720E16160D3R100Z6	10138194	3	D	E16	16,0	15,5	24,0	34,1	1,0	6	12	■
XSE720E16160D3R200Z6	10138195	3	D	E16	16,0	15,5	24,0	34,1	2,0	6	12	■
XSE720E16160D3R300Z6	10138196	3	D	E16	16,0	15,5	24,0	34,1	3,0	6	12	■
XSE720E20200D3R050Z6	10138197	3	D	E20	20,0	19,3	30,0	40,2	0,5	6	16	■
XSE720E20200D3R100Z6	10138198	3	D	E20	20,0	19,3	30,0	40,2	1,0	6	16	■
XSE720E20200D3R200Z6	10138199	3	D	E20	20,0	19,3	30,0	40,2	2,0	6	16	■
XSE720E20200D3R300Z6	10138200	3	D	E20	20,0	19,3	30,0	40,2	3,0	6	16	■
XSE720E25250D3R200Z6	10138201	3	D	E25	25,0	24,2	37,5	49,5	2,0	6	20	■
XSE720E25250D3R300Z6	10138202	3	D	E25	25,0	24,2	37,5	49,5	3,0	6	20	■
XSE720E25250D3R400Z6	10138203	3	D	E25	25,0	24,2	37,5	49,5	4,0	6	20	■

■ Stocked standard.

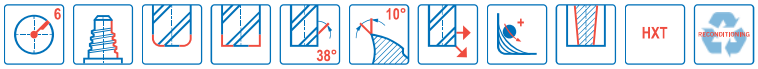
XSE720

High performance – Superalloy – Square – 6 Flutes – Corner radius or sharp – *Inch*



D

- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			HXT
XSE720E10.375D3SZ6	10138204	3	D	E10	0.375	0.364	0.563	0.827	–	6	8	■
XSE720E12.500D3SZ6	10138205	3	D	E12	0.500	0.484	0.750	1.055	–	6	10	■
XSE720E16.625D3SZ6	10138206	3	D	E16	0.625	0.610	0.938	1.343	–	6	12	■
XSE720E20.750D3SZ6	10138207	3	D	E20	0.750	0.728	1.125	1.524	–	6	16	■
XSE720E251.00D3SZ6	10138208	3	D	E25	1.000	0.965	1.500	1.980	–	6	20	■
XSE720E10.375D3R030Z6	10138209	3	D	E10	0.375	0.364	0.563	0.827	0.030	6	8	■
XSE720E12.500D3R030Z6	10138210	3	D	E12	0.500	0.484	0.750	1.055	0.030	6	10	■
XSE720E12.500D3R060Z6	10138211	3	D	E12	0.500	0.484	0.750	1.055	0.060	6	10	■
XSE720E12.500D3R120Z6	10138212	3	D	E12	0.500	0.484	0.750	1.055	0.125	6	10	■
XSE720E16.625D3R030Z6	10138213	3	D	E16	0.625	0.610	0.938	1.343	0.030	6	12	■
XSE720E16.625D3R060Z6	10138214	3	D	E16	0.625	0.610	0.938	1.343	0.060	6	12	■
XSE720E16.625D3R120Z6	10138215	3	D	E16	0.625	0.610	0.938	1.343	0.125	6	12	■
XSE720E20.750D3R030Z6	10138216	3	D	E20	0.750	0.728	1.125	1.524	0.030	6	16	■
XSE720E20.750D3R060Z6	10138217	3	D	E20	0.750	0.728	1.125	1.524	0.060	6	16	■
XSE720E20.750D3R120Z6	10138218	3	D	E20	0.750	0.728	1.125	1.524	0.125	6	16	■
XSE720E251.00D3R030Z6	10138219	3	D	E25	1.000	0.965	1.500	1.980	0.030	6	20	■
XSE720E251.00D3R060Z6	10138220	3	D	E25	1.000	0.965	1.500	1.980	0.060	6	20	■
XSE720E251.00D3R120Z6	10138221	3	D	E25	1.000	0.965	1.500	1.980	0.125	6	20	■

■ Stocked standard.

Cutting data – XSE720 Side milling

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	265 (200 — 320) *870 (660 — 1000)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	255 (200 — 320) *840 (660 — 1000)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (170 — 270) *740 (560 — 880)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	195 (150 — 240) *640 (500 — 780)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	160 (120 — 190) *520 (400 — 620)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	180 (140 — 220) *590 (460 — 720)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	170 (130 — 210) *560 (430 — 680)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	160 (120 — 190) *520 (400 — 620)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	160 (130 — 200) *520 (430 — 650)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 110) *395 (330 — 360)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 91) *295 (260 — 290)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 76) *245 (210 — 240)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSE720 advanced roughing

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	285 (220 — 350) *940 (730 — 1100)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	275 (210 — 340) *900 (690 — 1100)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	240 (180 — 290) *790 (600 — 950)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	210 (160 — 260) *690 (530 — 850)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	175 (130 — 210) *570 (430 — 680)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 240) *640 (500 — 780)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	185 (140 — 220) *610 (460 — 720)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	170 (130 — 210) *560 (430 — 680)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 120) *410 (370 — 390)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 95) *310 (270 — 310)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 79) *260 (220 — 250)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSE720 Side milling inch

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	265 (200 — 320) *870 (660 — 1000)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	255 (200 — 320) *840 (660 — 1000)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (170 — 270) *740 (560 — 880)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	195 (150 — 240) *640 (500 — 780)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	160 (120 — 190) *520 (400 — 620)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	180 (140 — 220) *590 (460 — 720)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	170 (130 — 210) *560 (430 — 680)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	160 (120 — 190) *520 (400 — 620)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	160 (130 — 200) *520 (430 — 650)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 110) *395 (330 — 360)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 91) *295 (260 — 290)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 76) *245 (210 — 240)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

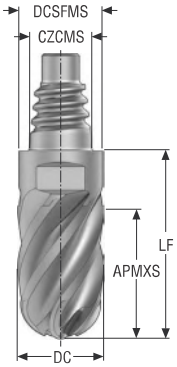
Cutting data – XSE720 advanced roughing inch

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	285 (220 — 350) *940 (730 — 1100)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	275 (210 — 340) *900 (690 — 1100)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	240 (180 — 290) *790 (600 — 950)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	210 (160 — 260) *690 (530 — 850)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	175 (130 — 210) *570 (430 — 680)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 240) *640 (500 — 780)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	185 (140 — 220) *610 (460 — 720)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	170 (130 — 210) *560 (430 — 680)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 120) *410 (370 — 390)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 95) *310 (270 — 310)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 79) *260 (220 — 250)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

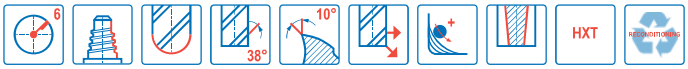
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XSB720

High performance – Superalloy – Ball nose – 6 Flutes



D



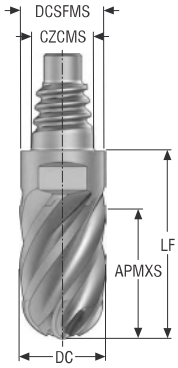
- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					mm	mm	mm	mm			HXT
XSB720E10100D3BZ6	10138222	3	D	E10	10,0	9,7	15,0	21,8	6	8	■
XSB720E12120D3BZ6	10138223	3	D	E12	12,0	11,7	18,0	25,9	6	10	■
XSB720E16160D3BZ6	10138224	3	D	E16	16,0	15,5	24,0	34,1	6	12	■
XSB720E20200D3BZ6	10138225	3	D	E20	20,0	19,3	30,0	40,2	6	16	■

■ Stocked standard.

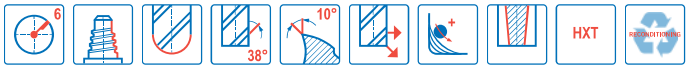
XSB720

High performance – Superalloy – Ball nose – 6 Flutes – *Inch*



D

- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*			HXT
XSB720E10.375D3BZ6	10138226	3	D	E10	0.375	0.364	0.563	0.827	6	8	■
XSB720E12.500D3BZ6	10138227	3	D	E12	0.500	0.484	0.750	1.055	6	10	■
XSB720E16.625D3BZ6	10138228	3	D	E16	0.625	0.610	0.938	1.343	6	12	■
XSB720E20.750D3BZ6	10138229	3	D	E20	0.750	0.728	1.125	1.524	6	16	■
XSB720E251.00D3BZ6	10138230	3	D	E25	1.000	0.965	1.500	1.980	6	20	■

■ Stocked standard.

Cutting data – XSB720 Side milling

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	95 (81 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	180 (140 — 220) *590 (460 — 720)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	160 (120 — 200) *520 (400 — 650)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	125 (93 — 150) *410 (310 — 490)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	105 (77 — 120) *345 (260 — 390)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSB720 Side milling advanced roughing a_e/DC=0,07

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	235 (190 — 280) *770 (630 — 910)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (160 — 230) *640 (530 — 750)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	170 (130 — 200) *560 (430 — 650)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	105 (81 — 130) *345 (270 — 420)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSB720 Side milling inch

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	95 (81 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	180 (140 — 220) *590 (460 — 720)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	160 (120 — 200) *520 (400 — 650)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	125 (93 — 150) *410 (310 — 490)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	105 (77 — 120) *345 (260 — 390)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

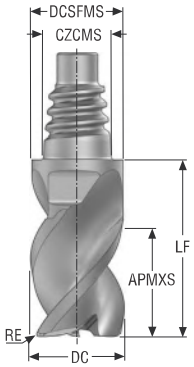
Cutting data – XSB720 Side milling advanced roughing a_e/DC=0,07 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	235 (190 — 280) *770 (630 — 910)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (160 — 230) *640 (530 — 750)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	170 (130 — 200) *560 (430 — 650)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	105 (81 — 130) *345 (270 — 420)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XSE450

High performance – Aluminium – Square – 3 Flutes – Corner radius



D

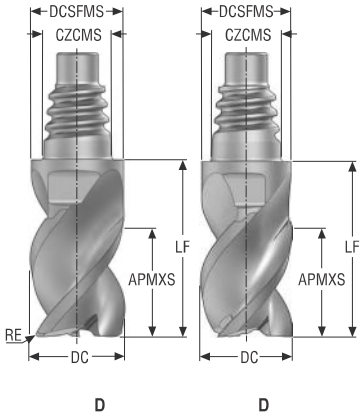
- Tolerances:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			AXT
XSE450E10100D2R050Z3	10138362	2	D	E10	10,0	9,7	12,0	18,7	0,5	3	8	■
XSE450E12120D2R050Z3	10138363	2	D	E12	12,0	11,7	14,4	22,1	0,5	3	10	■
XSE450E12120D2R100Z3	10138364	2	D	E12	12,0	11,7	14,4	22,1	1,0	3	10	■
XSE450E16160D2R050Z3	10138365	2	D	E16	16,0	15,5	19,2	29,2	0,5	3	12	■
XSE450E16160D2R100Z3	10138366	2	D	E16	16,0	15,5	19,2	29,2	1,0	3	12	■
XSE450E20200D2R050Z3	10138367	2	D	E20	20,0	19,3	24,0	34,3	0,5	3	16	■
XSE450E20200D2R100Z3	10138369	2	D	E20	20,0	19,3	24,0	34,3	1,0	3	16	■

■ Stocked standard.

XSE450

High performance – Aluminium – Square – 3 Flutes – Corner radius – *Inch*



- Tolerances:
- DC= 0/-.002 Inch
- RE= ±.001 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			AXT
XSE450E10.375D2SZ3	10138370	2	D	E10	0.375	0.364	0.450	0.720	–	3	8	■
XSE450E12.500D2SZ3	10138371	2	D	E12	0.500	0.484	0.600	0.906	–	3	10	■
XSE450E16.625D2SZ3	10138372	2	D	E16	0.625	0.610	0.750	1.150	–	3	12	■
XSE450E20.750D2SZ3	10138373	2	D	E20	0.750	0.728	0.900	1.295	–	3	16	■
XSE450E251.00D2SZ3	10138374	2	D	E25	1.000	0.965	1.200	1.673	–	3	20	■
XSE450E10.375D2R030Z3	10138375	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8	■
XSE450E12.500D2R030Z3	10138376	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10	■
XSE450E12.500D2R060Z3	10138377	2	D	E12	0.500	0.484	0.600	0.906	0.060	3	10	■
XSE450E16.625D2R030Z3	10138378	2	D	E16	0.625	0.610	0.750	1.150	0.030	3	12	■
XSE450E16.625D2R060Z3	10138379	2	D	E16	0.625	0.610	0.750	1.150	0.060	3	12	■
XSE450E16.625D2R120Z3	10138380	2	D	E16	0.625	0.610	0.750	1.150	0.120	3	12	■
XSE450E20.750D2R030Z3	10138381	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16	■
XSE450E20.750D2R060Z3	10138382	2	D	E20	0.750	0.728	0.900	1.295	0.060	3	16	■
XSE450E20.750D2R120Z3	10138383	2	D	E20	0.750	0.728	0.900	1.295	0.120	3	16	■
XSE450E251.00D2R030Z3	10138384	2	D	E25	1.000	0.965	1.200	1.673	0.030	3	20	■
XSE450E251.00D2R060Z3	10138385	2	D	E25	1.000	0.965	1.200	1.673	0.060	3	20	■
XSE450E251.00D2R120Z3	10138386	2	D	E25	1.000	0.965	1.200	1.673	0.120	3	20	■

■ Stocked standard.

Cutting data – XSE450 Side milling

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20		
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	295 (230 — 360) *970 (760 — 1100)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	395 (300 — 490) *1300 (990 — 1600)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

Cutting data – XSE450 Slot milling

SMG		a_p/DC	f_z					v_c
			10	12	16	20		
N1	E/M/A	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	500 (400 — 590) *1650 (1400 — 1900)*
N2	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	400 (300 — 490) *1300 (990 — 1600)*
N3	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	265 (200 — 330) *870 (660 — 1000)*
N11	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	355 (270 — 440) *1175 (890 — 1400)*
TS1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSE450 Side milling inch

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	295 (230 — 360) *970 (760 — 1100)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	395 (300 — 490) *1300 (990 — 1600)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

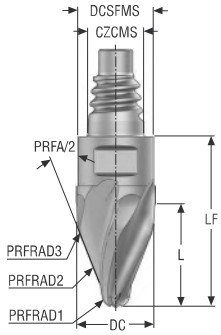
Cutting data – XSE450 Slot milling inch

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
N1	E/M/A	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	500 (400 — 590) *1650 (1400 — 1900)*
N2	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	400 (300 — 490) *1300 (990 — 1600)*
N3	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	265 (200 — 330) *870 (660 — 1000)*
N11	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	355 (270 — 440) *1175 (890 — 1400)*
TS1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XHT740

High speed – ISO– M and ISO– S - Taper Shape – 4-6 Flutes



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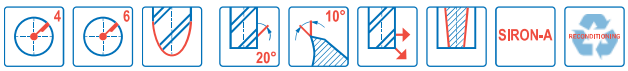


- Tolerances:
- PRFRAD1= ±0,03 mm
- Form tolerance PRFRAD2= 0,02 mm
- Regrind possible if DC is ≥Ø12 mm is ≥Ø12 mm and PRFRAD1 is ≥1,5 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	L	LF	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm	mm				SIRA
XHT740E10100T2R1.5R250Z4	10138388	2	T	E10	10,0	9,7	5,4	18,7	1,5	250,0	2,0	65,0	4	8	■
XHT740E12120T2R3R250Z4	10138389	2	T	E12	12,0	11,7	10,5	22,1	3,0	250,0	6,0	32,5	4	10	■
XHT740E16160T2R4R500Z4	10138390	2	T	E16	16,0	15,5	14,6	29,2	4,0	500,0	8,0	27,5	4	12	■
XHT740E10100T3R2R250Z4	10138391	3	T	E10	10,0	9,7	12,7	21,8	2,0	250,0	5,0	20,0	4	8	■
XHT740E12120T3R3R250Z4	10138392	3	T	E12	12,0	11,7	13,7	25,9	3,0	250,0	6,0	20,0	4	10	■
XHT740E16160T3R4R1000Z4	10138394	3	T	E16	16,0	15,5	24,0	34,1	4,0	1000,0	5,0	20,0	4	12	■
XHT740E16160T3R4R500Z4	10138393	3	T	E16	16,0	15,5	17,6	34,1	4,0	500,0	8,0	20,0	4	12	■
XHT740E10100T3R2R250Z6	10138395	3	T	E10	10,0	9,7	12,7	21,8	2,0	250,0	5,0	20,0	6	8	■
XHT740E12120T3R3R250Z6	10138396	3	T	E12	12,0	11,7	13,7	25,9	3,0	250,0	6,0	20,0	6	10	■
XHT740E16160T3R4R500Z6	10138397	3	T	E16	16,0	15,5	17,6	34,1	4,0	500,0	8,0	20,0	6	12	■

■ Stocked standard.

Cutting data – XHT740 – Copy milling PCEDC 4

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

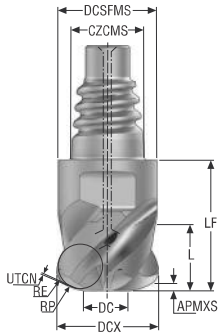
Cutting data – XHT740 – Copy milling PCEDC 6

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

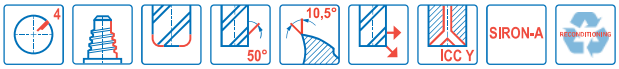
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XHF580

High feed – Universal – 4 Flutes – Corner radius – ICC



D



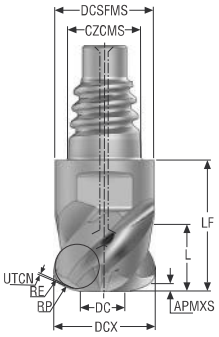
- Tolerances:
- DCX= h9
- RE= ±0,03 mm
- Regrind possible if DCX is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Grades
						mm	mm	mm	mm	mm	mm	mm	mm	mm			SIRA
XHF580E10100D1HZ4A	10137971	1	D	■	E10	10,0	3,4	9,7	0,7	6,0	12,4	1,5	1,99	0,27	4	8	■
XHF580E12120D1HZ4A	10137972	1	D	■	E12	12,0	4,5	11,7	0,8	7,5	14,5	1,5	2,1	0,323	4	10	■
XHF580E16160D1HZ4A	10137973	1	D	■	E16	16,0	6,2	15,5	1,0	10,0	18,7	2,0	2,747	0,426	4	12	■

■ Stocked standard.

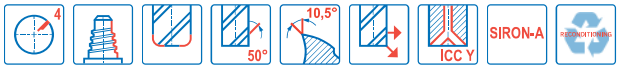
XHF580

High feed – Universal – 4 Flutes – Corner radius – ICC – *Inch*



D

- Tolerances:
- DCX= h9
- RE= ±.0012 Inch
- Regrind possible if DCX is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Grades
						Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XHF580E10.375D1HZ4A	10137974	1	D	■	E10	0.375	0.134	0.364	0.024	0.236	0.488	0.060	0.076	0.008	4	8	■
XHF580E12.500D1HZ4A	10137975	1	D	■	E12	0.500	0.197	0.484	0.033	0.315	0.571	0.060	0.086	0.014	4	10	■
XHF580E16.625D1HZ4A	10137976	1	D	■	E16	0.614	0.236	0.610	0.039	0.394	0.736	0.080	0.110	0.016	4	12	■

■ Stocked standard.

Cutting data – XHF580 Side milling

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	485 (440 — 530) *1600 (1500 — 1700)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	405 (370 — 450) *1325 (1300 — 1400)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P5	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P6	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
P7	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	280 (250 — 300) *920 (830 — 980)*
P8	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P11	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (140 — 170) *520 (460 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	185 (170 — 200) *610 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 99) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 82) *230 (210 — 260)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	415 (370 — 450) *1350 (1300 — 1400)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (320 — 380) *1150 (1100 — 1200)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	335 (300 — 370) *1100 (990 — 1200)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	200 (180 — 220) *660 (600 — 720)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	255 (230 — 280) *840 (760 — 910)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	170 (150 — 190) *560 (500 — 620)*
S12	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	130 (120 — 140) *425 (400 — 450)*
S13	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	100 (89 — 110) *330 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (74 — 100) *295 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XHF580 Slot milling

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	440 (400 — 480) *1450 (1400 — 1500)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 470) *1400 (1300 — 1500)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	370 (330 — 400) *1225 (1100 — 1300)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 360) *1075 (960 — 1100)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	275 (250 — 300) *900 (830 — 980)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (240 — 280) *850 (790 — 910)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P11	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	85 (75 — 94) *280 (250 — 300)*
M1	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	170 (150 — 180) *560 (500 — 590)*
M2	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	135 (120 — 150) *445 (400 — 490)*
M3	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 110) *345 (290 — 360)*
M4	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (66 — 89) *260 (220 — 290)*
M5	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (55 — 74) *215 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 480) *1400 (1300 — 1500)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	375 (340 — 410) *1225 (1200 — 1300)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	305 (270 — 330) *1000 (890 — 1000)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	180 (170 — 200) *590 (560 — 650)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (240 — 290) *870 (790 — 950)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (210 — 250) *750 (690 — 820)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	47 (32 — 62) *155 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (26 — 50) *125 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	32 (22 — 43) *105 (73 — 140)*
S11	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	160 (150 — 180) *520 (500 — 590)*
S12	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	125 (110 — 140) *410 (370 — 450)*
S13	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (84 — 100) *310 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (67 — 91) *260 (220 — 290)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XHF580 Side milling inch

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	485 (440 — 530) *1600 (1500 — 1700)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	405 (370 — 450) *1325 (1300 — 1400)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P5	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P6	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
P7	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	280 (250 — 300) *920 (830 — 980)*
P8	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P11	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (140 — 170) *520 (460 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	185 (170 — 200) *610 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 99) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 82) *230 (210 — 260)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	415 (370 — 450) *1350 (1300 — 1400)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (320 — 380) *1150 (1100 — 1200)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	335 (300 — 370) *1100 (990 — 1200)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	200 (180 — 220) *660 (600 — 720)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	255 (230 — 280) *840 (760 — 910)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	170 (150 — 190) *560 (500 — 620)*
S12	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	130 (120 — 140) *425 (400 — 450)*
S13	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	100 (89 — 110) *330 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (74 — 100) *295 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

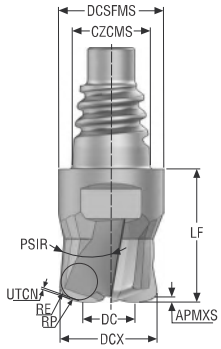
Cutting data – XHF580 Slot milling inch

SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	440 (400 — 480) *1450 (1400 — 1500)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 470) *1400 (1300 — 1500)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	370 (330 — 400) *1225 (1100 — 1300)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 360) *1075 (960 — 1100)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	275 (250 — 300) *900 (830 — 980)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (240 — 280) *850 (790 — 910)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P11	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	85 (75 — 94) *280 (250 — 300)*
M1	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	170 (150 — 180) *560 (500 — 590)*
M2	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	135 (120 — 150) *445 (400 — 490)*
M3	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 110) *345 (290 — 360)*
M4	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (66 — 89) *260 (220 — 290)*
M5	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (55 — 74) *215 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 480) *1400 (1300 — 1500)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	375 (340 — 410) *1225 (1200 — 1300)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	305 (270 — 330) *1000 (890 — 1000)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	180 (170 — 200) *590 (560 — 650)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (240 — 290) *870 (790 — 950)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (210 — 250) *750 (690 — 820)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	47 (32 — 62) *155 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (26 — 50) *125 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	32 (22 — 43) *105 (73 — 140)*
S11	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	160 (150 — 180) *520 (500 — 590)*
S12	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	125 (110 — 140) *410 (370 — 450)*
S13	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (84 — 100) *310 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (67 — 91) *260 (220 — 290)*

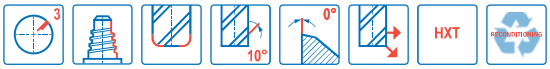
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XHF780

High feed – ISO– M and ISO– S – 3 Flutes – Corner radius



D



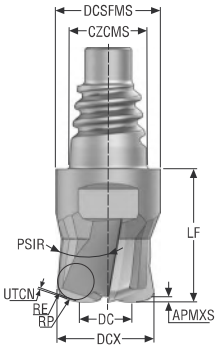
- Tolerances:
- DCX= -0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DCX is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	RP	UTCN	PSIR°	PCEDC	SW	Grades
					mm	mm	mm	mm	mm	mm	mm	mm				HXT
XHF780E10100D1HZ3	10137957	1	D	E10	10,0	5,0	9,7	0,45	12,3	0,8	1,175	0,232	-5,0	3	8	■
XHF780E12120D1HZ3	10137958	1	D	E12	12,0	6,0	11,7	0,5	14,4	1,0	1,416	0,262	-5,0	3	10	■
XHF780E16160D1HZ3	10137959	1	D	E16	16,0	8,0	15,5	0,6	18,6	1,5	1,989	0,32	-5,0	3	12	■

■ Stocked standard.

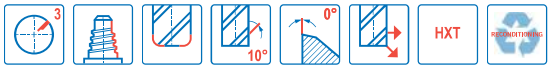
XHF780

High feed – ISO– M and ISO– S – 3 Flutes – Corner radius – *Inch*



D

- Tolerances:
- DCX= -.0008/-0.0016 Inch
- RE= ±.002 Inch
- Regrind possible if DCX is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	RP	UTCN	PSIR°	PCEDC	SW	Grades
					Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*				HXT
XHF780E10.375D1HZ3	10137960	1	D	E10	0.375	0.188	0.364	0.018	0.484	0.028	0.043	0.009	-5,0	3	8	■
XHF780E12.500D1HZ3	10137961	1	D	E12	0.461	0.250	0.484	0.020	0.567	0.045	0.061	0.010	-5,0	3	10	■
XHF780E16.625D1HZ3	10137962	1	D	E16	0.625	0.313	0.610	0.024	0.732	0.061	0.080	0.012	-5,0	3	12	■

■ Stocked standard.

Cutting data – XHF780 Side milling

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	370 (330 — 410) *1225 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	310 (280 — 340) *1025 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	305 (280 — 330) *1000 (920 — 1000)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	290 (260 — 320) *950 (860 — 1000)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P11	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (150 — 170) *520 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 83) *230 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	175 (160 — 190) *570 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	135 (120 — 150) *445 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	105 (90 — 110) *345 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (130 — 170) *490 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (75 — 100) *295 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XHF780 Slot milling

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 350) *1075 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (250 — 300) *890 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (240 — 290) *890 (790 — 950)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	255 (230 — 280) *840 (760 — 910)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P11	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	140 (130 — 150) *460 (430 — 490)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (73 — 92) *260 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (53 — 72) *215 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	45 (31 — 60) *150 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	36 (25 — 48) *120 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (21 — 41) *100 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	155 (140 — 170) *510 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	120 (110 — 130) *395 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (82 — 100) *310 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (110 — 140) *425 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (65 — 88) *245 (220 — 280)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XHF780 Side milling inch

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	370 (330 — 410) *1225 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	310 (280 — 340) *1025 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	305 (280 — 330) *1000 (920 — 1000)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	290 (260 — 320) *950 (860 — 1000)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P11	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (150 — 170) *520 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 83) *230 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	175 (160 — 190) *570 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	135 (120 — 150) *445 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	105 (90 — 110) *345 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (130 — 170) *490 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (75 — 100) *295 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

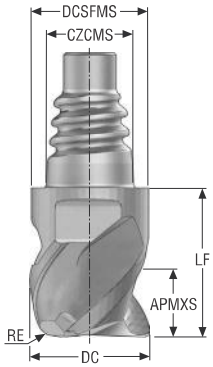
Cutting data – XHF780 Slot milling inch

SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 350) *1075 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (250 — 300) *890 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (240 — 290) *890 (790 — 950)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	255 (230 — 280) *840 (760 — 910)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P11	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	140 (130 — 150) *460 (430 — 490)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (73 — 92) *260 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (53 — 72) *215 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	45 (31 — 60) *150 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	36 (25 — 48) *120 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (21 — 41) *100 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	155 (140 — 170) *510 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	120 (110 — 130) *395 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (82 — 100) *310 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (110 — 140) *425 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (65 — 88) *245 (220 — 280)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XVE540

General purpose – Universal – Square – 3 Flutes – Corner radius



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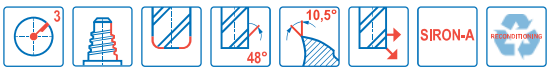


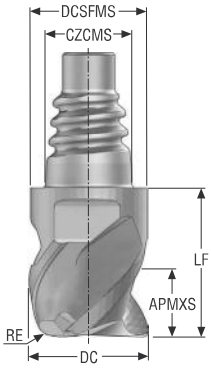
- Tolerances:
- DC= h9
- RE= ±0,015 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z3	10137981	1	D	E10	10,0	9,7	5,5	12,4	0,5	3	8	■
XVE540E12120D1R050Z3	10137982	1	D	E12	12,0	11,7	6,5	14,5	0,5	3	10	■
XVE540E16160D1R050Z3	10137983	1	D	E16	16,0	15,5	8,5	18,7	0,5	3	12	■
XVE540E20200D1R050Z3	10137984	1	D	E20	20,0	19,3	11,0	21,3	0,5	3	16	■

■ Stocked standard.

XVE540

General purpose – Universal – Square – 3 Flutes – Corner radius – *Inch*



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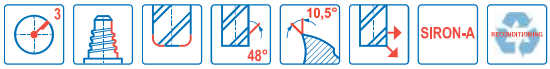


- Tolerances:
- DC= h9
- RE= .015 Inch= ±.0006 Inch
- RE= .031 Inch= ±.0012 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XVE540E10.375D1R015Z3	10137985	1	D	E10	0.375	0.364	0.209	0.488	0.015	3	8	■
XVE540E12.500D1R015Z3	10137986	1	D	E12	0.500	0.484	0.276	0.575	0.015	3	10	■
XVE540E16.625D1R015Z3	10137987	1	D	E16	0.625	0.610	0.335	0.736	0.015	3	12	■
XVE540E20.750D1R031Z3	10137988	1	D	E20	0.750	0.728	0.413	0.839	0.031	3	16	■

■ Stocked standard.

Cutting data – XVE540 – Side milling PCEDC 3

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 200) *590 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (100 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (94 — 140) *375 (310 — 450)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (89 — 130) *360 (300 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (70 — 110) *310 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (45 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (81 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 76) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	50 (36 — 63) *165 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 140) *395 (370 — 450)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	105 (87 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 80) *215 (180 — 260)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (69 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	300 (250 — 340) *1025 (860 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (32 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (26 — 37) *100 (86 — 120)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	28 (23 — 33) *90 (76 — 100)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (87 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Cutting data – XVE540 – Slot milling PCEDC 3

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 190) *540 (460 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (64 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (38 — 62) *165 (130 — 200)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (75 — 120) *330 (250 — 390)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 67) *165 (130 — 210)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	44 (32 — 56) *145 (110 — 180)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (92 — 120) *360 (310 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (78 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 71) *195 (160 — 230)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (71 — 100) *295 (240 — 320)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 91) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 43) *120 (96 — 140)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (24 — 34) *95 (79 — 110)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 30) *80 (66 — 98)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 77) *195 (160 — 250)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

Cutting data – XVE540 – Side milling PCEDC 3 inch

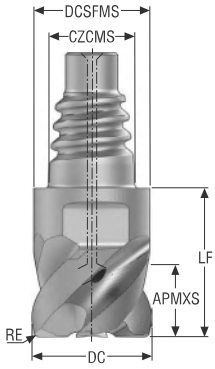
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 200) *590 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (100 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (94 — 140) *375 (310 — 450)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (89 — 130) *360 (300 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (70 — 110) *310 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (45 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (81 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 76) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	50 (36 — 63) *165 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 140) *395 (370 — 450)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	105 (87 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 80) *215 (180 — 260)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (69 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	300 (250 — 340) *1025 (860 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (32 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (26 — 37) *100 (86 — 120)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	28 (23 — 33) *90 (76 — 100)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (87 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Cutting data – XVE540 – Slot milling PCEDC 3 inch

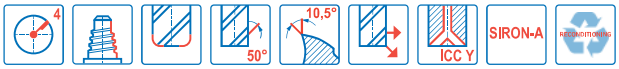
SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 190) *540 (460 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (64 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (38 — 62) *165 (130 — 200)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (75 — 120) *330 (250 — 390)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 67) *165 (130 — 210)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	44 (32 — 56) *145 (110 — 180)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (92 — 120) *360 (310 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (78 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 71) *195 (160 — 230)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (71 — 100) *295 (240 — 320)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 91) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 43) *120 (96 — 140)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (24 — 34) *95 (79 — 110)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 30) *80 (66 — 98)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 77) *195 (160 — 250)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

XVE540

General purpose – Universal – Square – 4 Flutes – Corner radius – ICC



D



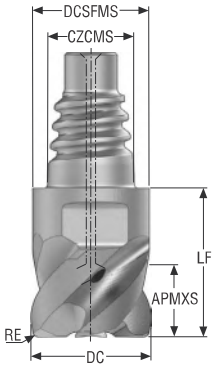
- Tolerances:
- DC= h9
- RE= ±0,015 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
						mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z4A	10137989	1	D	■	E10	10,0	9,7	6,0	12,4	0,5	4	8	■
XVE540E12120D1R050Z4A	10137990	1	D	■	E12	12,0	11,7	7,5	14,5	0,5	4	10	■
XVE540E16160D1R050Z4A	10137991	1	D	■	E16	16,0	15,5	10,0	18,7	0,5	4	12	■
XVE540E20200D1R050Z4A	10137992	1	D	■	E20	20,0	19,3	12,0	21,3	0,5	4	16	■

■ Stocked standard.

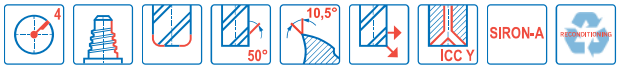
XVE540

General purpose – Universal – Square – 4 Flutes – Corner radius – ICC – *Inch*



D

- Tolerances:
- DC= h9
- RE= .015 Inch= ±.0006 Inch
- RE= .031 Inch= ±.0012 Inch
- Regrind possible if DC is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
						Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XVE540E10.375D1R015Z4A	10137993	1	D	■	E10	0.375	0.364	0.236	0.488	0.015	4	8	■
XVE540E12.500D1R031Z4A	10137994	1	D	■	E12	0.500	0.484	0.315	0.571	0.031	4	12	■
XVE540E16.625D1R031Z4A	10137995	1	D	■	E16	0.625	0.610	0.394	0.736	0.031	4	16	■
XVE540E20.750D1R031Z4A	10137996	1	D	■	E20	0.750	0.728	0.453	0.839	0.031	4	18	■

■ Stocked standard.

Cutting data – XVE540 – Side milling PCEDC 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 210) *590 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (150 — 200) *570 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (99 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (93 — 130) *375 (310 — 420)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (88 — 130) *360 (290 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (70 — 110) *295 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (44 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (80 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 75) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	49 (36 — 63) *160 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (120 — 150) *445 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	100 (86 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 79) *215 (180 — 250)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (68 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	295 (250 — 340) *1000 (860 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (31 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (25 — 37) *100 (83 — 120)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	27 (22 — 32) *90 (73 — 100)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (86 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Cutting data – XVE540 – Slot milling PCEDC 4

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 180) *540 (460 — 590)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (89 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (84 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (63 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	49 (37 — 61) *160 (130 — 200)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (74 — 120) *330 (250 — 390)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 66) *165 (130 — 210)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	43 (31 — 55) *140 (110 — 180)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (91 — 120) *345 (300 — 390)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (77 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 70) *195 (160 — 220)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (70 — 100) *280 (230 — 320)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 90) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	380 (320 — 440) *1250 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 42) *120 (96 — 130)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (23 — 34) *95 (76 — 110)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 29) *80 (66 — 95)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 76) *195 (160 — 240)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

Cutting data – XVE540 – Side milling PCEDC 4 inch

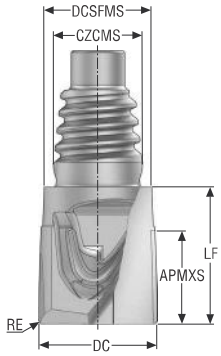
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 210) *590 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (150 — 200) *570 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (99 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (93 — 130) *375 (310 — 420)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (88 — 130) *360 (290 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (70 — 110) *295 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (44 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (80 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 75) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	49 (36 — 63) *160 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (120 — 150) *445 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	100 (86 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 79) *215 (180 — 250)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (68 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	295 (250 — 340) *1000 (860 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (31 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (25 — 37) *100 (83 — 120)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	27 (22 — 32) *90 (73 — 100)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (86 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Cutting data – XVE540 – Slot milling PCEDC 4 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 180) *540 (460 — 590)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (89 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (84 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (63 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	49 (37 — 61) *160 (130 — 200)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (74 — 120) *330 (250 — 390)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 66) *165 (130 — 210)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	43 (31 — 55) *140 (110 — 180)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (91 — 120) *345 (300 — 390)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (77 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 70) *195 (160 — 220)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (70 — 100) *280 (230 — 320)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 90) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	380 (320 — 440) *1250 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 42) *120 (96 — 130)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (23 — 34) *95 (76 — 110)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 29) *80 (66 — 95)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 76) *195 (160 — 240)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

XVE510

General purpose – Universal – Square – 2 Flutes – Corner radius



D

- Tolerances:
- DC= h10
- RE= ±0,015 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			SIRA
XVE510E10100D1R050Z2	10138003	1	D	E10	10,0	9,7	8,0	11,8	0,5	2	6	■
XVE510E12120D1R050Z2	10138004	1	D	E12	12,0	11,7	10,0	14,0	0,5	2	8	■

■ Stocked standard.

Cutting data – XVE510 Side milling

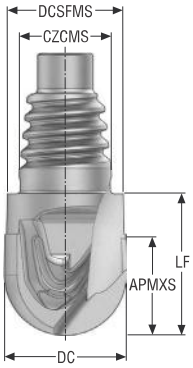
SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	255 (220 — 290) *840 (730 — 950)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	245 (210 — 280) *800 (690 — 910)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	210 (180 — 240) *690 (600 — 780)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	185 (160 — 210) *610 (530 — 680)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (140 — 200) *570 (460 — 650)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	165 (140 — 190) *540 (460 — 620)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	130 (99 — 160) *425 (330 — 520)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,080 *0.0032*	80 (60 — 98) *260 (200 — 320)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (120 — 190) *510 (400 — 620)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	125 (94 — 150) *410 (310 — 490)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	110 (78 — 130) *360 (260 — 420)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	80 (59 — 100) *260 (200 — 320)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (49 — 87) *230 (170 — 280)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	130 (110 — 150) *425 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	230 (190 — 270) *750 (630 — 880)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	100 (83 — 110) *330 (280 — 360)*
N1	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	810 (680 — 940) *2650 (2300 — 3000)*
N2	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	520 (440 — 600) *1700 (1500 — 1900)*
N3	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	345 (290 — 400) *1125 (960 — 1300)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
S1	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	60 (39 — 85) *195 (130 — 270)*
S2	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	55 (32 — 77) *180 (110 — 250)*
S3	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	39 (24 — 54) *130 (79 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	160 (130 — 200) *520 (430 — 650)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	125 (94 — 150) *410 (310 — 490)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	95 (73 — 120) *310 (240 — 390)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	390 (240 — 540) *1275 (790 — 1700)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	390 (240 — 540) *1275 (790 — 1700)*
GR1	A/D	0,20 *0.20*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	760 (640 — 880) *2500 (2100 — 2800)*

Cutting data – XVE510 Slot milling

SMG		a_p/DC	f_z		v_c
			10	12	
P1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	165 (140 — 180) *540 (460 — 590)*
P2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	160 (140 — 180) *520 (460 — 590)*
P3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	120 (100 — 130) *395 (330 — 420)*
P5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (64 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	50 (39 — 64) *165 (130 — 200)*
M1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (75 — 120) *330 (250 — 390)*
M2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	80 (60 — 99) *260 (200 — 320)*
M3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	50 (38 — 67) *165 (130 — 210)*
M5	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	44 (32 — 56) *145 (110 — 180)*
K1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (70 — 97) *280 (230 — 310)*
K5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 120) *330 (270 — 390)*
K6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	65 (54 — 74) *215 (180 — 240)*
N1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	40 (25 — 54) *130 (83 — 170)*
S2	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	35 (20 — 49) *115 (66 — 160)*
S3	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	60 (47 — 77) *195 (160 — 250)*
TS1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	600 (500 — 690) *1975 (1700 — 2200)*

XVB510

General purpose – Universal – Ball nose – 2 Flutes



D

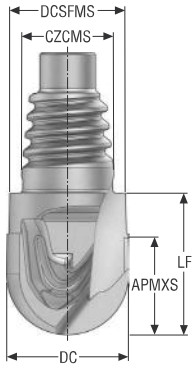
- Tolerances:
- DC= h9
- RE= ±0,01 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					mm	mm	mm	mm			SIRA
XVB510E10100D1BZ2	10138005	1	D	E10	10,0	9,7	8,0	11,8	2	6	■
XVB510E12120D1BZ2	10138006	1	D	E12	12,0	11,7	10,0	14,0	2	8	■
XVB510E16160D1BZ2	10138007	1	D	E16	16,0	15,5	13,0	18,1	2	10	■

■ Stocked standard.

XVB510

General purpose – Universal – Ball nose – 2 Flutes – *Inch*



D

- Tolerances:
- DC= h9
- RE= ±.0004 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*			SIRA
XVB510E10.375D1BZ2	10138008	1	D	E10	0.375	0.364	0.315	0.465	2	6	■
XVB510E12.500D1BZ2	10138009	1	D	E12	0.500	0.484	0.413	0.551	2	8	■
XVB510E16.625D1BZ2	10138010	1	D	E16	0.624	0.610	0.512	0.713	2	10	■

■ Stocked standard.

Cutting data – XVB510 Copy milling roughing

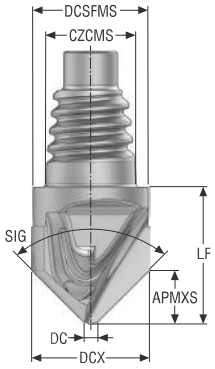
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	365 (320 — 420) *1200 (1100 — 1300)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	355 (310 — 400) *1175 (1100 — 1300)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	305 (270 — 350) *1000 (890 — 1100)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	270 (230 — 310) *890 (760 — 1000)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	195 (160 — 240) *640 (530 — 780)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 220) *610 (500 — 720)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	95 (78 — 110) *310 (260 — 360)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (160 — 210) *610 (530 — 680)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	120 (95 — 140) *395 (320 — 450)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	90 (71 — 110) *295 (240 — 360)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 92) *245 (200 — 300)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	360 (310 — 410) *1175 (1100 — 1300)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	310 (270 — 350) *1025 (890 — 1100)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	265 (230 — 300) *870 (760 — 980)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	250 (220 — 280) *820 (730 — 910)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (79 — 120) *330 (260 — 390)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (120 — 180) *490 (400 — 590)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	510 (390 — 630) *1675 (1300 — 2000)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	330 (250 — 400) *1075 (830 — 1300)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	405 (270 — 530) *1325 (890 — 1700)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	110 (66 — 150) *360 (220 — 490)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	90 (53 — 120) *295 (180 — 390)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	75 (46 — 100) *245 (160 — 320)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (130 — 220) *570 (430 — 720)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (95 — 170) *445 (320 — 550)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (74 — 130) *345 (250 — 420)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	850 (710 — 980) *2800 (2400 — 3200)*

Cutting data – XVB510 Copy milling roughing inch

SMG		a_e/DC	a_p/DC	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	365 (320 — 420) *1200 (1100 — 1300)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	355 (310 — 400) *1175 (1100 — 1300)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	305 (270 — 350) *1000 (890 — 1100)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	270 (230 — 310) *890 (760 — 1000)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	195 (160 — 240) *640 (530 — 780)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 220) *610 (500 — 720)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	95 (78 — 110) *310 (260 — 360)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (160 — 210) *610 (530 — 680)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	120 (95 — 140) *395 (320 — 450)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	90 (71 — 110) *295 (240 — 360)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 92) *245 (200 — 300)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	360 (310 — 410) *1175 (1100 — 1300)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	310 (270 — 350) *1025 (890 — 1100)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	265 (230 — 300) *870 (760 — 980)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	250 (220 — 280) *820 (730 — 910)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (79 — 120) *330 (260 — 390)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (120 — 180) *490 (400 — 590)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	510 (390 — 630) *1675 (1300 — 2000)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	330 (250 — 400) *1075 (830 — 1300)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	405 (270 — 530) *1325 (890 — 1700)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	110 (66 — 150) *360 (220 — 490)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	90 (53 — 120) *295 (180 — 390)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	75 (46 — 100) *245 (160 — 320)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (130 — 220) *570 (430 — 720)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (95 — 170) *445 (320 — 550)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (74 — 130) *345 (250 — 420)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	850 (710 — 980) *2800 (2400 — 3200)*

XVC506/509/512

General purpose – Universal – Chamfer – 2 Flutes



N

- Tolerances:
- SIG= ±1°

Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	SIG°	PCEDC	SW	Grade
					mm	mm	mm	mm	mm				SIRA
XVC506E10100N1SZ2	10138012	1	N	E10	10,0	1,5	9,7	7,23	11,8	60,0	2	6	■
XVC506E12120N1SZ2	10138013	1	N	E12	12,0	1,5	11,7	7,73	14,0	60,0	2	8	■
XVC509E10100N1SZ2	10138014	1	N	E10	10,0	1,5	9,7	4,23	11,8	90,0	2	6	■
XVC509E12120N1SZ2	10138015	1	N	E12	12,0	1,5	11,7	5,23	14,0	90,0	2	8	■
XVC509E16160N1SZ2	10138016	1	N	E16	16,0	1,5	15,5	7,23	18,1	90,0	2	10	■
XVC512E12120N1SZ2	10138017	1	N	E12	12,0	1,5	11,7	3,03	14,0	120,0	2	8	■

■ Stocked standard.

Cutting data – XVC506 Chamfering

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	105 (86 — 120) *345 (290 — 390)*
P12	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,16 *0.0065*	0,17 *0.0065*	65 (53 — 78) *215 (180 — 250)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,26 *0.010*	0,28 *0.011*	125 (99 — 140) *410 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	50 (35 — 65) *165 (120 — 210)*
M5	E/M/A	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	42 (29 — 54) *140 (96 — 170)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	150 (130 — 160) *490 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	30 (10 — 49) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	95 (72 — 120) *310 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	60 (44 — 75) *195 (150 — 240)*
H5	M/A	0,050 *0.050*	2,0 *2.0*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,050 *0.050*	2,0 *2.0*	0,085 *0.0034*	0,090 *0.0036*	120 (110 — 140) *395 (370 — 450)*
H21	M/A	0,050 *0.050*	2,0 *2.0*	0,085 *0.0034*	0,090 *0.0036*	120 (110 — 140) *395 (370 — 450)*
H31	M/A	0,050 *0.050*	2,0 *2.0*	0,075 *0.0030*	0,080 *0.0032*	95 (78 — 100) *310 (260 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
GR1	A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*

Cutting data – XVC509 Chamfering

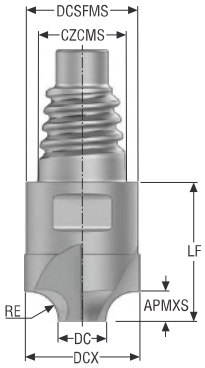
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	150 (130 — 160) *490 (430 — 520)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	105 (85 — 120) *345 (280 — 390)*
P12	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,15 *0.0060*	0,16 *0.0065*	0,18 *0.0070*	65 (52 — 77) *215 (180 — 250)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	120 (98 — 140) *395 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*	49 (35 — 64) *160 (120 — 200)*
M5	E/M/A	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*	41 (29 — 53) *135 (96 — 170)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	125 (110 — 130) *410 (370 — 420)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	30 (10 — 50) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	60 (44 — 74) *195 (150 — 240)*
H5	M/A	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,10 *0.10*	2,0 *2.0*	0,090 *0.0036*	0,095 *0.0038*	0,10 *0.0040*	120 (110 — 140) *395 (370 — 450)*
H21	M/A	0,10 *0.10*	2,0 *2.0*	0,090 *0.0036*	0,095 *0.0038*	0,10 *0.0040*	120 (110 — 140) *395 (370 — 450)*
H31	M/A	0,10 *0.10*	2,0 *2.0*	0,075 *0.0030*	0,080 *0.0032*	0,090 *0.0036*	90 (77 — 100) *295 (260 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*

Cutting data – XVC512 Chamfering

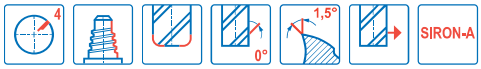
SMG		a_e/DC	a_p/DC	f_z	v_c
				12	
P1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	165 (150 — 180) *540 (500 — 590)*
P2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 170) *520 (460 — 550)*
P3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	135 (120 — 150) *445 (400 — 490)*
P7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	125 (120 — 140) *410 (400 — 450)*
P8	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P11	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	85 (68 — 100) *280 (230 — 320)*
P12	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,22 *0.0085*	50 (41 — 61) *165 (140 — 200)*
M1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	100 (80 — 110) *330 (270 — 360)*
M2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (65 — 96) *260 (220 — 310)*
M3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	50 (37 — 68) *165 (130 — 220)*
M4	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	39 (28 — 51) *130 (92 — 160)*
M5	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	33 (23 — 42) *110 (76 — 130)*
K1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	140 (130 — 150) *460 (430 — 490)*
K3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	115 (110 — 130) *375 (370 — 420)*
K4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	110 (98 — 120) *360 (330 — 390)*
K5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	65 (58 — 75) *215 (200 — 240)*
K6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	85 (74 — 96) *280 (250 — 310)*
N1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*
N2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	310 (260 — 360) *1025 (860 — 1100)*
N3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	205 (180 — 240) *670 (600 — 780)*
N11	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	320 (290 — 360) *1050 (960 — 1100)*
S1	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	35 (12 — 58) *115 (40 — 190)*
S2	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	29 (9,6 — 47) *95 (32 — 150)*
S3	E	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	25 (8,3 — 41) *80 (28 — 130)*
S11	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (58 — 98) *260 (200 — 320)*
S12	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	60 (45 — 76) *195 (150 — 240)*
S13	E	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	47 (35 — 59) *155 (120 — 190)*
H5	M/A	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	100 (83 — 110) *330 (280 — 360)*
H8	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H21	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H31	M/A	0,10 *0.10*	1,3 *1.3*	0,11 *0.0044*	75 (64 — 88) *245 (210 — 280)*
TS1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
TP1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
GR1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*

XVK310

General purpose – Universal – Concave – 4 Flutes



- Tolerances:
- RE= ≤5= ±0,05 mm
- RE= >5= ±0,01 mm



Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm			SIRA
XVK310E12120D1K300Z4	10137998	1	D	E12	12,0	5,0	11,7	3,0	14,5	3,0	4	10	■
XVK310E12120D1K400Z4	10137999	1	D	E12	12,0	4,0	11,7	4,0	14,5	4,0	4	10	■
XVK310E16160D1K500Z4	10138000	1	D	E16	16,0	6,0	15,5	5,0	18,7	5,0	4	12	■
XVK310E20200D1K600Z4	10138001	1	D	E20	20,0	8,0	19,3	6,0	21,3	6,0	4	16	■

■ Stocked standard.

Cutting data – XVK310 Side milling roughing

SMG		a_p/D_c	f_z			v_c
			12	16	20	
P1	E/M/A/D	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A/D	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	105 (70 — 115) *345 (220 — 375)*
N1	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S1	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S2	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S3	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S11	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	265 (180 — 285) *870 (590 — 940)*
S12	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S13	E	0,24 *0,24*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	155 (105 — 165) *510 (345 — 540)*
TS1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 30° *						
JS412																
LV2	100	100	100	100	100	140	3	40	120	80	100	50	10	130	50	100
										≤ 10° *						
JS413																
LV2	100	100	100	100	100	150	3	40	120	70	50	50	10	130	X	X
LV3	X	X	25	60	240	120	3	40	230	70	50	50	10	130	X	X
										≤ 30° *						
JS452																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 10° *						
JS453																
LV2	100	100	100	100	100	140	3	35	120	70	50	50	10	130	20	10
LV3	X	X	25	60	240	120	3	40	230	70	70	50	10	130	20	10
										≤ 30° *						
JSE512																
LV2	100	100	100	100	100	110	3	65	125	40	40	100	5	130	40	40
										≤ 5° *						
JSE513																
LV2	100	100	100	100	100	110	3	85	150	100	100	100	5	130	50	40
LV3	30	100	30	50	200	110	3	85	250	X	X	X	X	X	X	X
										≤ 5° *						
JSE514																
LV2	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV3	X	X	25	50	200	110	3	60	250	X	X	X	X	X	X	X
										≤ 45° *						
JS553																
LV1	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV2	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV3	40	60	40	105	200	110	3	55	250	50	15	35	3	130	35	50
										≤ 5° *						
JS554																
LV1	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV2	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	53	250	50	50	60	3	130	X	X
JS564																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X
JS565																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X

*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 45° *						
J28																
LV2	100	100	100	100	100	140	3	100	135	40	25	100	10	130	25	60
										≤ X° *						
J36																
LV2	X	X	100	100	100	120	3	85	150	X	X	X	X	X	X	X
										≤ 20° *						
J93F																
LV2	100	100	100	100	100	133	3	40	100	100	100	100	3	130	25	30
										≤ 1°						
JH120																
LV2	100	100	100	100	100	120	3	120	80	17	100	100	2	130	X	X
										≤ X° *						
JH130																
LV2	X	X	100	100	100	120	3	120	80	X	X	X	X	X	X	X
										≤ X° *						
JH142																
LV2	X	X	100	100	100	110	3	80	70	X	X	30	2	130	X	X
LV3	X	X	100	100	100	110	3	80	70	X	X	20	1	130	X	X
LV6	X	X	100	100	100	110	3	80	70	X	X	10	1	130	X	X
										≤ 45° *						
JH830																
LV2	100	100	100	100	100	110	3	110	80	9	135	135	3	130	X	X
										≤ X° *						
JH910																
LV2	100	100	100	100	100	125	4	100	80	15	140	140	3	130	X	X
LV3	80	80	100	80	80	125	4	80	65	10	110	110	3	130	X	X
										≤ X° *						
JH930																
LV2	X	X	100	100	100	125	2	30	100	X	X	X	X	X	X	X

*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 5° *						
JH40																
LV2	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
LV3	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
										≤ 45° *						
JH410																
LV2	100	100	100	100	100	125	2	25	100	100	67	67	40	130	67	80
LV2 (ML)	75	60	80	60	100	125	2	25	100	60	40	40	40	130	40	50
LV2 (TL)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV2 (RS)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV3 (RS)	95	95	80	100	100	100	2	100	100	50	50	50	40	130	75	40
										≤ 45° *						
JH421																
LV2	100	100	100	100	100	100	4	35	100	100	100	100	25	130	45	80
										≤ 30° *						
JH440																
LV2	100	100	100	100	100	125	3	40	100	100	100	100	5	130	X	X
										≤ 5° *						
JHP750																
LV1	115	120	115	115	100	100	2	145	100	100	120	120	3	130	10	70
LV2	100	100	100	100	100	100	2	145	100	100	100	100	3	130	10	60
										≤ 5° *						
JHP951																
LV2	100	100	100	100	100	158	2	50	113	20	100	125	3	130	6	20
										≤ 10° *						
JHP993																
LV2	100	100	100	100	100	X	X	X	X	30	100	100	3	130	4	40
LV3	80	80	80	80	80	X	X	X	X	20	80	80	3	130	3	30
										≤ X° *						
JS520																
LV2	X	X	100	100	100	133	2	65	100	X	X	X	X	X	X	X
LV3	X	X	X	X	X	133	2	65	175	X	X	X	X	X	X	X
										≤ X° *						
JS522																
LV4	X	X	100	100	100	129	2	140	100	X	X	X	X	X	X	X
JS720																
LV2	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
LV3	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
JS754																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	55	250	50	50	60	3	130		
JS755																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	100	110	3	55	250	50	50	60	3	130		

*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version side milling cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ X°						
JME542-JME562-JME564																
LV1	100	100	100	100	100	125	2	150	5	X	X	X	X	X	X	X
LV2	63	100	100	100	65	125	2	150	3	X	X	X	X	X	X	X
LV3	25	100	100	100	25	125	2	150	1	X	X	X	X	X	X	X
LV4 (TL)	18	100	100	100	20	125	2	150	1	X	X	X	X	X	X	X
LV4 (XL)	12	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV5	10	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV6	4	100	100	100	5	125	2	150	1	X	X	X	X	X	X	X
LV7	2	100	100	100	2	125	2	150	1	X	X	X	X	X	X	X
										≤ X°						
JME142-JME144																
LV1	100	100	100	100	100	100	2	150	5	X	X	X	X	X	X	X
LV2	85	85	100	100	63	100	2	150	3	X	X	X	X	X	X	X
LV3	75	75	100	100	25	100	2	150	1	X	X	X	X	X	X	X
LV4	60	60	100	100	20	100	2	150	1	X	X	X	X	X	X	X
LV5	50	50	100	100	10	100	2	150	1	X	X	X	X	X	X	X
LV6	40	40	100	100	5	100	2	150	1	X	X	X	X	X	X	X
										≤ X° *						
JM403-JM404-JM406																
LV1	100	100	100	100	100	X	X	X	X	X	X	X	X	X	X	X
LV2	100	75	100	75	100	X	X	X	X	X	X	X	X	X	X	X
LV3 (L)	100	75	100	75	90	X	X	X	X	X	X	X	X	X	X	X
LV3 (TL)	90	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (XL)	75	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (SL)	75	75	100	75	45	X	X	X	X	X	X	X	X	X	X	X
LV5	50	50	100	50	30	X	X	X	X	X	X	X	X	X	X	X
JME642																
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
										≤2						
JC898																
LV3	X	X	100	100	100	X	X	X	X	X	50	80	3	130-160	X	X
										≤5°						
JC899																
LV3	X	X	100	100	100	100	3	50	100	X	X	X	X	X	X	X

*Max ramping angle

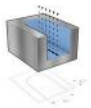
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 1°						
JHP170																
LV2	100	100	100	100	100	130	3	175	80	100	100	100	2	130	X	X
										≤ 30°						
JHP490																
LV2	100	100	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV2 (E-Shape)	100	75	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV3	100	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
LV4	150	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
										≤ 5°						
JHP760																
LV2	100	100	100	100	100	140	2	125	15	30	100	100	3	130	10	50
LV3	50	50	100	50	50	140	2	125	15	15	50	50	3	130	5	25
										≤ 15°						
JHP770																
LV2	100	100	100	100	100	170	3	125	100	100	40	40	3	130	X	X
										≤ 5°						
JHP780																
LV1	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
LV2	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
JD620																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	20	100	60	100	60	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD630																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD640																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X

*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!								
	Slotting		Side rough			Side finish				Ramping		Helical			Plunging			
Straight																		
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	v_c	a_e (% of DC)	f_z	a_e-sd (% of DC)
JHF181																		
LV1	100	100	100	100	100	X	X	X	X	X	X	100	3,4	130	X	X	X	X
LV2	80	85	100	85	80	X	X	X	X	X	X	85	3,0	130	X	X	X	X
LV3	60	70	100	70	60	X	X	X	X	X	X	70	2,5	130	X	X	X	X
										≤ 1,5° *								
JHF980																		
LV1	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV2	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV3	80	85	80	85	80	X	X	X	X	80	85	85	3	130	70	30	33	200
LV4	50	70	50	70	60	X	X	X	X	60	70	70	3	130	70	30	33	200

*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!									
	Slotting		Side rough			Side finish				Copy milling roughing			Copy milling finishing				Helical		
BALL																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)
JSB512																			
LV2	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	100	5	130
JS532																			
LV1	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV2	X	X	70	100	70	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV3	X	X	X	X	X	125	3	125	10	X	X	X	X	X	X	X	X	X	X
JS533																			
LV1	X	X	100	100	100	125	3	125	15	X	X	X	X	X	X	X	75	5	130
LV2	X	X	75	75	75	125	3	125	15	X	X	X	X	X	X	X	75	5	130
JS534																			
LV1	X	X	100	100	100	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV2	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV3	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
JHB970																			
LV1	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV2	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV3	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
JHB720																			
LV2	X	X	100	100	100	125	2	90	75	X	X	X	X	X	X	X	40	3	130
JH112																			
LV1	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV2	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV3	X	X	100	100	100	110	1,6	55	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	130	1,4	55	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	130	1,4	50	100	X	X	X	X	X	X	X	X	X	X
LV6	X	X	100	100	100	130	1	35	100	X	X	X	X	X	X	X	X	X	X
JH150																			
LV2	X	X	100	100	100	165	1	90	35	X	X	X	X	X	X	X	30	2	130

*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!									
	Slotting		Side rough			Side finish				Copy milling roughing			Copy milling finishing				Helical		
BALL																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)
JH160																			
Standard (2)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
JH450																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	45	5	130
JH460																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	X	X	X
JMB542-JMB562-JMB563																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	125	2	150	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	100	100	63	125	2	150	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	100	100	25	125	2	150	1	X	X	X
LV4 (TL)	20	100	X	X	X	X	X	X	X	100	100	19	125	2	150	1	X	X	X
LV4 (XL)	12	100	X	X	X	X	X	X	X	100	100	12	125	2	150	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	100	100	10	125	2	150	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	100	100	4	125	2	150	1	X	X	X
LV7	2	100	X	X	X	X	X	X	X	100	100	2	125	2	150	1	X	X	X
JMB112																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	118	2	120	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	64	85	85	118	2	120	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	56	75	75	118	2	120	1	X	X	X
LV4	20	100	X	X	X	X	X	X	X	45	60	60	118	2	120	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	38	50	50	118	2	120	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	30	40	40	118	2	120	1	X	X	X
JM413-JM416																			
LV1	X	X	100	100	100	100	5	40	35	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	60	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	80	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	60	75	100	5	40	10	X	X	X	X	X	X	X	X	X	X
JMB642																			
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
										≤2									
JD660																			
LV1	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X

*Max ramping angle
All values are percentages of original (100%) cutting data.

Nomenclature and formulae

RPM

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_c} \quad \text{(rev/min)}$$

Cutting speed

$$v_c = \frac{n \cdot \pi \cdot D_c}{1000} \quad \text{(m/min)}$$

Feed speed

$$v_f = n \cdot z_n \cdot f_z \quad \text{(mm/min)}$$

Feed per revolution

$$f = z_n \cdot f_z \quad \text{(mm/rev)}$$

Metal removal rate

$$Q = \frac{a_e \cdot a_p \cdot v_f}{1000} \quad (cm^3/min)$$

Cutting speed and RPM for copying

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000} \quad \text{(m/min)}$$

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w} \quad \text{(RPM)}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$

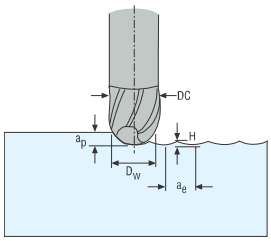
Calculation of a_p vs. overhang length:
If the overhang length (XS) is longer than 4 x DC and Cylindrical shanks are used it is important to adopt another depth of cut (a_p) value than that indicated in the table.
Use the following formula to calculate the new a_p value

$a_p new = a_p \times (4 \times DC/XS)^2$

Profile heigth

$$H = \frac{D_c}{2} - \frac{\sqrt{D_c^2 - a_e^2}}{2}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$



Profile heigth H (um)

DC	Pitch a_e (µm)						
	0,06	0,08	0,11	0,15	0,20	0,3	0,45
1	0,90	1,60	3,00	5,70	10,0	23,0	53,0
2	0,45	0,80	1,50	2,80	5,0	11,0	26,0
4	0,23	0,40	0,76	1,40	2,5	5,60	13,0
6	0,15	0,27	0,50	0,94	1,7	3,80	8,40
8	0,11	0,20	0,38	0,70	1,3	2,80	6,30
10	0,09	0,16	0,30	0,56	1,0	2,30	5,10
12	0,08	0,13	0,25	0,47	0,83	1,90	4,20

a_p = Depth of cut mm/axial depth of cut (mm)
a_e = Width of cut mm/radial depth of cut (mm)
DC = Cutter diameter
f = Feed per revolution (mm/rev)
f_z = Feed per tooth (mm/tooth)
z_n = No. of teeth
n = RPM (rev/min)
Q = Material removal rate (cm^3/min)
v_c = Cutting speed (m/min)
v_f = Feed speed (mm/min)
D_w = Working diameter

Operation recommendations

Ramping method

The table below shows the feed rate percentage to use at certain ramping angles

Recommended diameter of hole for helical interpolation ramping

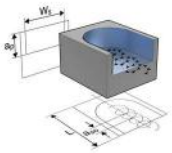
Diameter of end mill DC	Diameter of hole
1-2,5	1,4 x DC
3-6	1,3 x DC
8-12	1,2 x DC
16-32	1,15 x DC

Trochoidal method

The figure below shows a method often called the trochoidal method for milling slots

Recommendation of width of slot

Diameter of end mill DC	Slot width
1-2,5	1,8 x DC
3-6	1,6 x DC
8-12	1,4 x DC
16-32	1,2 x DC



ONE SECO TAP – A MULTITUDE OF APPLICATIONS

SECO THREADING TAPS

YOUR CHALLENGE
High-mix/low production involves various part materials and types that require extensive inventories of thread cutting and forming taps.

OUR SOLUTION
For versatility and cost savings, the Seco Tools line of thread cutting and forming taps handles a wide range of materials.

YOUR CHALLENGE
Spending too much time selecting proper tap for the application at hand.

OUR SOLUTION
The Seco range of thread cutting and forming taps offers various performance levels that encompass versatile and cost-effective general-purpose tools.

YOUR CHALLENGE
Chips can cause tool breakage when threading stainless steel and other long chip materials.

OUR SOLUTION
Seco thread cutting and forming taps efficiently control chips at hole depths up to 3 x diameter.

Visit **SECOTOOLS.COM** or scan the QR code and find out more information.

CUSTOMER BENEFITS

- Do more with less tooling and reduce tooling inventory and costs
- Get jobs up and running faster
- Improve process stability and consistency
- Process a wider range of part materials with single universal-type tools
- Uninterrupted machining operations
- Process security

SECO THREADING TAPS

THREAD WITH SECO VERSATILITY

To help shops accomplish more work with less tooling, Seco Taps provide versatile and cost-effective thread cutting taps and forming taps for a wide range of materials and part types. The product line encompasses three available performance levels that give manufacturers the perfectly matched taps for their applications. With the combination of superior base materials, advanced coatings and special edge preparations, Seco Taps generate precision threads while they also maximize chip evacuation, shorten setup times and extend tool life.

T34 - NEW HIGH PERFORMANCE VERSATILE TAPS

THREADS RANGE
M 1 ÷ 36; MF 3x0,35 ÷ 24x1,5
UNC #4-40 ÷ 5/8-11; UNF #4-48 ÷ 5/8-18
G 1/8 ÷ 1
EG (M, UNC, UNF)
APPLICATION (Rm UP TO 1200 MPa):
P, M, K, N
MATERIAL & COATING:
HSSE-PM & TiAlN+WC/C
TYPE OF FLUTES & CHAMFERS:
Spiral point & chamfer B – through holes / available also with internal radial cooling
Helix flutes 45° & & chamfer C or E - blind holes / available also with internal axial cooling
ACC. TO STANDARDS:
DIN 371
DIN 376/374
DIN 5156
TOLERANCE:
6HX (4H for <M1,4) – for Metric threads
2BX – for UN threads
Normal-X – for G threads

T32 - REPLACEMENT OF –V TAPS

THREADS RANGE
M 1 ÷ 52, MF 8x1 ÷ 30x2
UNC #4-40 ÷ 1 ½ -6; UNF #12-28 ÷ 1 ½ -12
G ½" – 1"
APPLICATION (Rm UP TO 1000 MPa):
P, M, K, N
MATERIAL & COATING:
HSSE & TiAlN+TiN
TYPE OF FLUTES & CHAMFERS:
Straight & chamfer C – both types of holes
Spiral point & chamfer B – through holes
Helix flutes 40° & chamfer C - blind holes
ACC. TO STANDARDS:
DIN 371 + Extra long version (EL)
DIN 376/374 + Extra long version (EL)
DIN 5156
TOLERANCE:
6H (4H for <M1,4), 6G – for M threads
2B – for UN threads
Normal – for G threads

T33 - REPLACEMENT OF –MF FORMING TAPS

THREADS RANGE
M 2 ÷ 20; MF 4x0,5 ÷ 20x1,5
UNC #5-40 ÷ 5/8-11; UNF #5-44 ÷ 5/8-18
G 1/8" ÷ ¾"
APPLICATION:
P, M, N
MATERIAL & COATING:
HSSE-PM & TiAlN+TiN
HSSE-PM & TiCN
CHAMFER:
C for both types of holes
E recommended mainly for blind holes / also available with radial or axial internal cooling
ACC. TO STANDARDS:
DIN 371
DIN 376/374
DIN 5156
TOLERANCE:
6HX, 6GX – M threads
2BX – UN threads
Normal-X – G threads

Please note that the data shown is just an extract and more products are available.
For more information please visit www.secotools.com.

Code key – Taps T34, T33 and T32

T34	A	-	R	45	H	01	C	03	-	6	X	1	-	65	R
1	2		3	4	5	6	7	8		9		10		11	12

No. 3, 4

R40/R45
Blind holes
ULDR = 2,5

P
Through holes
ULDR = 3

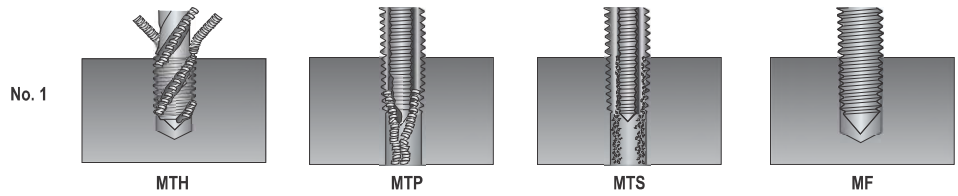
S
Blind and through holes
ULDR = 1,5

F/FS - forming taps
Blind and through holes
ULDR = 3

	Description			
1	**Family**	T34 – High performance versatile cutting taps T33 – Forming taps T32 – Versatile cutting taps		
2	**Internal coolant**	[Blank] – Without coolant A – Axial B – Radial		
3	**Design**	P – Helix Point S – Straight Flutes R – Right hand spiral flutes	L – Left hand flute F – Forming tap FS – Forming tap with oil grooves	
4	**Flute angle**	40 45	Used for Design R and L	
5	**Coating**	C – TiN + TiCN H – TiAlN + WC/C N – TiAlN + TiN		
6	**Thread Type**	01 – M 02 – MF 04 – EGM 08 – UNC	09 – UNF 16 – EGUNC 17 – EGUNF 21 – G	
7	**Type of chamfer**	B C E		
8	**Standard**	03 – DIN371 04 – DIN371/EL 05 – DIN374	06 – DIN376 07 – DIN376/EL 09 – DIN5156	
9	**Thread size**			
10	**Pitch**			
11	**Tolerance**	M threads: 41 – 4H 61 – 6G 62 – 6GX 63 – 6H 64 – 6H mod (for EG M) 65 – 6HX	For UNC and UNF threads 21 – 2B 22 – 2BX	For G threads: 11 – Normal 12 – Normal X
12	**Hand**	R - Right L - Left		

Code key – Taps MTH, MTS, MF and MTP

MTS	-	M10	X	1.5ISO	6H	-	B	C	-	V	0	01	-	A
1		2		3	4		5	6		7	8	9		10

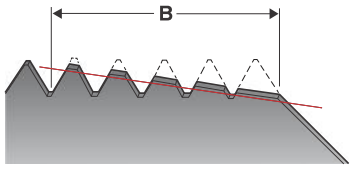


	Description
1	MTH = Threadmaster™ Tap Helix flute MTP = Threadmaster™ Tap Helix point MTS = Threadmaster™ Tap Straight flute tap MF = Threadmaster™ FormTap
2	Thread type and size
3	Pitch and thread form
4	Tolerance (tctr) 4H, 6H, 6HX, 6G, 6GX metric and 2B, 2BX, 3B, 3BX, Normal, NormalX inch
5	Operation B = Blind hole T = Through hole X = Blind and Through hole
6	Entering Chamfer(THCHT) B = Entering chamfer 3,5 - 5 threads C = Entering chamfer 2 - 3 threads E = Entering chamfer 1,5 - 2 threads
7	V = Versatile P = Steel M = Stainless Steel K = Cast Iron N = Non ferrous metals S = Superalloys and titanium
8	Release No. = 0 (2014)
9	Tool type No. = 01, 02, 03, 04 etc
10	A = Through coolant

Taps – Entering chamfer THCHT

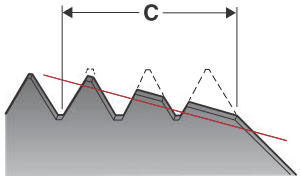
B-type

Length 3.5 – 5 threads
High torque
Best surface finish
Thin chip thickness
Low pressure at the chamfer
Long tool life
Most common for through holes (Helix point)



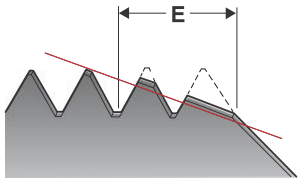
C-type

Length 2 - 3 threads
Medium torque
Good surface finish
Normal chip thickness
Normal pressure at the chamfer
Normal tool life
Most common design
Standard for blind holes
Most common for blind holes (Helix flute)

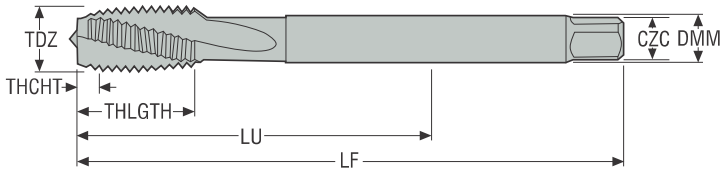


E-type

Length 1.5 – 2 threads
Low torque
Good surface finish
Thick chip thickness
High pressure at the chamfer
Shorter tool life
When limited space in the bottom of a hole

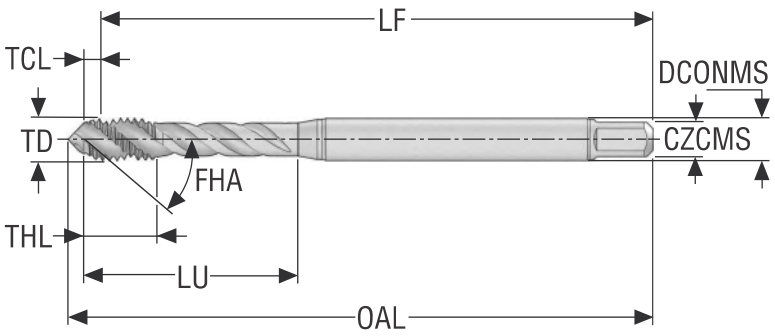


Definitions for -P, -M, -K, -N, -S, -V and MF



Definitions Seco Threadmaster™	
BSG	= Basic standard group
CZC	= Connection size code
DMM	= Shank diameter
FHA	= Flute helix angle
LF	= Functional length
LU	= Usable length
NOF	= Number of flutes
PHDR	= Recommended premachined hole diameter
PHDX	= Maximum premachined hole diameter
TCTR	= Thread tolerance class
TD	= Thread diameter
TDZ	= Thread diameter size
THCHT	= Thread chamfer type
THFT	= Thread form type ISO, Withworth, UN...
THLGTH	= Thread length
TPIX	= Threads per inch maximum
TTP	= Thread type internal/external/both
TPX	= Thread pitch maximum
ULDR	= Usable length diameter ratio

Definitions for T32, T33 and T34



Definitions Seco Threadmaster™	
BSG	= Basic standard group
TD	= Thread diameter
TDZ	= Thread diameter size
THCHT	= Threading chamfer type
TCL	= Thread chamfer length
THL	= Thread length
LU	= Usable length
LF	= Functional length
OAL	= Overall length
FHA	= Flute Helix angle
DCONS	= Connection diameter machine side
CZCMS	= Connection size code machine side
NOF	= Flute count
PHDR	= Recommended premachined hole diameter
PHDX	= Maximum premachined hole diameter
TCTR	= Thread tolerance class
TPI	= Threads per inch
ULDR	= Usable length diameter ratio

Taps - Choice of toolholder

The tool holder choice is made according to the machine spindle, with or without synchronization.

Modern CNC machine with synchronization:

The modern CNC machines can synchronize the spindle feed rate and rotation in order to make a rigid tapping operation. The TCER – tapping chucks with micro-compensation is the most suitable for synchronized tapping.

TCER Tapping chucks with micro-compensation, for synchronized tapping:

TCER for synchronized tapping has a micro-compensation system to avoid the small discrepancies and axial forces during rigid tapping machining. The taps are mounted in specific ER collets with square drive.

Note: These ER collets with square drive can also be mounted in ER collet chucks, but then without micro-compensation.

TCER

Troubleshooting

Oversized thread

Wrong tap for application
- Refer to application charts

Incorrect axial feed
- Ensure feed rate is controlled
- If possible, use tool holder for syncronized tapping

Wrong cutting speed
- Refer to recommendations

Wrong tolerance
- Choose tap with lower tolerance

Undersized thread

Tap worn out
- Replace tap

Tap drill hole too small
- Check drilling recommendations

Material closing after tapping
- Increase drill diameter

Wrong tolerance on tap
- Choose tap with higher tolerance

Chipping

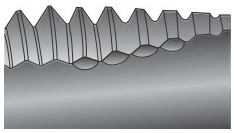
Wrong tap for the application
- Check for tool selection

Incorrect or lack of lubricant
- Use appropriate emulsion or oil

Tap hitting bottom of hole
- Increase drill depth or reduce thread depth

Trapped chip
- Check tool selection

Surface hardening in drilled hole
- Check drilling recommendations



Breakage

Too high torque
- Use tap holder with torque settings

Tap worn out
- Replace tap

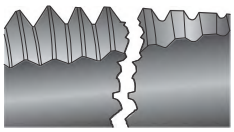
Incorrect or lack of lubricant
- Use appropriate emulsion or oil

Tap hitting bottom of hole
- Increase drill depth or reduce thread depth

Wrong cutting speed
- Refer to recommendations

Birdnest around tool
- Check tool selection

Tap drill hole too small
- Check drilling recommendations



Rapid wear

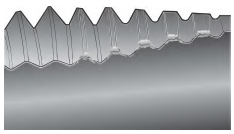
Wrong type of tap for application
- Refer to tap choice

Incorrect or lack of lubricant
- Use appropriate emulsion or oil

Too high cutting speed
- Refer to recommendations

Work (surface) hardening in drilled hole
- Check drilling recommendations
- Drill worn out

Tap drill hole too small
- Check drilling recommendations



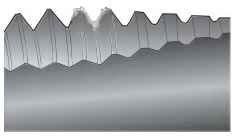
Built-up edge

Incorrect or lack of lubricant
- Use appropriate emulsion or oil

Tap worn out
- Replace tap

Wrong cutting speed
- Refer to recommendations

Wrong type of tap for application
- Refer to tap choice



Taps Selection T32

Type of tap		T32-SNC-micro	T32-SNC	T32-PNB-micro	T32-PNB	T32-PNB	T32-R40NC-micro	T32-R40NC	T32-R40NC
Type of hole		Blind and through holes	Blind and through holes	Through holes	Through holes	Through holes	Blind holes	Blind holes	Blind holes
Chamfer form		C	C	B	B	B	C	C	C
Coolant		External	External	External	External	External	External	External	External
Substrate:		HSS-PM	HSSE	HSS-PM	HSSE	HSSE	HSS-PM	HSSE	HSSE
Page(s)	M	293, 294	295, 296, 297	304, 305	306, 307, 308	309, 310	323, 324	325, 326, 327	328, 329
	M 6G				311, 312			330, 331	
	M LH		298, 299		313, 314			332, 333	
	MF		300, 301, 302		315, 316, 317			334, 335, 336	
	UNC				318, 319			337, 338	
	UNF				320, 321			339, 340	
	G		303		322			341	
	EG M								
	EG UNC								
	EG UNF								

For cutting data see page(s) 260

Cutting data T32

SMG	v_c					
	T32-SNC-micro	T32-SNC	T32-PNB-micro	T32-PNB	T32-R40NC-micro	T32-R40NC
P1	20 *65*	20 *65*	20 *65*	20 *65*	20 *65*	20 *65*
P2	20 *65*	20 *65*	20 *65*	20 *65*	20 *65*	20 *65*
P3	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*
P4	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*
P5	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*
P6	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*
P7	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*
P8	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*
P11	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*
P12	8,7 *29*	8,7 *29*	8,7 *29*	8,7 *29*	8,7 *29*	8,7 *29*
M1	12 *39*	12 *39*	12 *39*	12 *39*	12 *39*	12 *39*
M2	10 *33*	10 *33*	10 *33*	10 *33*	10 *33*	10 *33*
M3	7,6 *25*	7,6 *25*	7,6 *25*	7,6 *25*	7,6 *25*	7,6 *25*
M4	5,7 *19*	5,7 *19*	5,7 *19*	5,7 *19*	5,7 *19*	5,7 *19*
M5	4,8 *16*	4,8 *16*	4,8 *16*	4,8 *16*	4,8 *16*	4,8 *16*
K1	17 *55*	17 *55*	17 *55*	17 *55*	— —	— —
K2	15 *49*	15 *49*	15 *49*	15 *49*	— —	— —
K3	13 *43*	13 *43*	13 *43*	13 *43*	13 *43*	13 *43*
K4	12 *39*	12 *39*	12 *39*	12 *39*	12 *39*	12 *39*
K5	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —
N1	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*
N2	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*
N3	10 *33*	10 *33*	10 *33*	10 *33*	10 *33*	10 *33*
N11	13 *43*	13 *43*	13 *43*	13 *43*	13 *43*	13 *43*
S1	— —	— —	— —	— —	— —	— —
S2	— —	— —	— —	— —	— —	— —
S3	— —	— —	— —	— —	— —	— —
S11	— —	— —	— —	— —	— —	— —
S12	— —	— —	— —	— —	— —	— —
S13	— —	— —	— —	— —	— —	— —

SMG = Seco material group
Cutting speeds, (v_c = m/min, (sf/min), in the table are recommendations for a start value.

For more detailed information on cutting data, please visit MyPages or Seco Suggest on secotools.com

Taps Selection T34

Type of tap		T34-PHB-micro	T34-PHB	T34B-PHB	T34-R45HC-micro	T34-R45HC	T34A-R45HC	T34-R45HE	T34A-R45HE
Type of hole		Through holes	Through holes	Through holes	Blind holes	Blind holes	Blind holes	Blind holes	Blind holes
Chamfer form		B	B	B	C	C	C	E	E
Coolant		External	External	Internal	External	External	Internal	External	Internal
Substrate:		HSS-PM	HSSE-PM	HSSE-PM	HSS-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM
Page(s)	M	342, 343	344, 345	346, 347	363, 364	365, 366	369, 370	367, 368	
	M 6G								
	M LH								
	MF		348, 349	350, 351		371, 372	375, 376	373, 374	377
	UNC		352, 353			378, 379			
	UNF		354, 355			380, 381			
	G		356			382			
	EG M		357, 358					383, 384	
	EG UNC		359, 360					385, 386	
	EG UNF		361, 362					387, 388	

For cutting data, see next page

Cutting data T34

SMG	v_c							
	T34-PHB-micro	T34-PHB	T34B-PHB	T34-R45HC-micro	T34-R45HC	T34A-R45HC	T34-R45HE	T34A-R45HE
P1	28 *90*	28 *90*	43 *140*	28 *90*	28 *90*	43 *140*	28 *90*	43 *140*
P2	28 *90*	28 *90*	41 *135*	28 *90*	28 *90*	41 *135*	28 *90*	41 *135*
P3	24 *80*	24 *80*	36 *120*	24 *80*	24 *80*	36 *120*	24 *80*	36 *120*
P4	21 *70*	21 *70*	31 *100*	21 *70*	21 *70*	31 *100*	21 *70*	31 *100*
P5	20 *65*	20 *65*	30 *100*	20 *65*	20 *65*	30 *100*	20 *65*	30 *100*
P6	22 *70*	22 *70*	34 *110*	22 *70*	22 *70*	34 *110*	22 *70*	34 *110*
P7	21 *70*	21 *70*	32 *105*	21 *70*	21 *70*	32 *105*	21 *70*	32 *105*
P8	20 *65*	20 *65*	30 *100*	20 *65*	20 *65*	30 *100*	20 *65*	30 *100*
P11	21 *70*	21 *70*	31 *100*	21 *70*	21 *70*	31 *100*	21 *70*	31 *100*
P12	12 *39*	12 *39*	18 *60*	12 *39*	12 *39*	18 *60*	12 *39*	18 *60*
M1	15 *49*	15 *49*	21 *70*	15 *49*	15 *49*	21 *70*	15 *49*	21 *70*
M2	12 *39*	12 *39*	17 *55*	12 *39*	12 *39*	17 *55*	12 *39*	17 *55*
M3	9,1 *30*	9,1 *30*	13 *43*	9,1 *30*	9,1 *30*	13 *43*	9,1 *30*	13 *43*
M4	6,9 *23*	6,9 *23*	9,7 *32*	6,9 *23*	6,9 *23*	9,7 *32*	6,9 *23*	9,7 *32*
M5	5,7 *19*	5,7 *19*	8,1 *27*	5,7 *19*	5,7 *19*	8,1 *27*	5,7 *19*	8,1 *27*
K1	24 *80*	24 *80*	36 *120*	24 *80*	24 *80*	36 *120*	24 *80*	36 *120*
K2	21 *70*	21 *70*	31 *100*	21 *70*	21 *70*	31 *100*	21 *70*	31 *100*
K3	18 *60*	18 *60*	26 *85*	18 *60*	18 *60*	26 *85*	18 *60*	26 *85*
K4	17 *55*	17 *55*	25 *80*	17 *55*	17 *55*	25 *80*	17 *55*	25 *80*
K5	— —	10 *33*	15 *49*	— —	10 *33*	15 *49*	10 *33*	15 *49*
K6	15 *49*	15 *49*	22 *70*	15 *49*	15 *49*	22 *70*	15 *49*	22 *70*
K7	13 *43*	13 *43*	19 *60*	13 *43*	13 *43*	19 *60*	13 *43*	19 *60*
N1	26 *85*	26 *85*	39 *130*	26 *85*	26 *85*	39 *130*	26 *85*	39 *130*
N2	17 *55*	17 *55*	25 *80*	17 *55*	17 *55*	25 *80*	17 *55*	25 *80*
N3	11 *36*	11 *36*	17 *55*	11 *36*	11 *36*	17 *55*	11 *36*	17 *55*
N11	15 *49*	15 *49*	22 *70*	15 *49*	15 *49*	22 *70*	15 *49*	22 *70*
S1	— —	4,0 *13*	4,0 *13*	— —	4,0 *13*	4,0 *13*	4,0 *13*	4,0 *13*
S2	— —	— —	— —	— —	— —	— —	— —	— —
S3	— —	— —	— —	— —	— —	— —	— —	— —
S11	— —	4,0 *13*	4,0 *13*	— —	4,0 *13*	4,0 *13*	4,0 *13*	4,0 *13*
S12	— —	— —	— —	— —	— —	— —	— —	— —
S13	— —	— —	— —	— —	— —	— —	— —	— —

SMG = Seco material group
Cutting speeds, (v_c = m/min, (sf/min), in the table are recommendations for a start value.

For more detailed information on cutting data, please visit MyPages or Seco Suggest on secotools.com

Taps Selection T33

Type of tap		T33-FNC	T33-FSNC	T33-FSCC	T33-FSCE	T33B-FSCE	T33A-FSCE
Type of hole		Blind and through holes	Blind and through holes	Blind and through holes	Blind and through holes	Through holes	Blind holes
Chamfer form		C	C	C	E	E	E
Coolant		External	External	External	External	Internal	Internal
Substrate:		HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM	HSSE-PM
Page(s)	M	389, 390	391, 392	402	403	405	404
	M 6G		393, 394				
	M LH						
	MF		395, 396	406, 407			
	UNC		397, 398				
	UNF		399, 400				
	G		401				
	EG M						
	EG UNC						
	EG UNF						

For cutting data, see next page

Cutting data T33

SMG	v_c					
	T33-FNC	T33-FSNC	T33-FSCC	T33-FSCE	T33A-FSCE	T33B-FSCE
P1	21 *70*	21 *70*	21 *70*	21 *70*	28 *90*	28 *90*
P2	21 *70*	21 *70*	21 *70*	21 *70*	28 *90*	28 *90*
P3	18 *60*	18 *60*	18 *60*	18 *60*	24 *80*	24 *80*
P4	16 *50*	16 *50*	16 *50*	16 *50*	21 *70*	21 *70*
P5	15 *49*	15 *49*	15 *49*	15 *49*	20 *65*	20 *65*
P6	17 *55*	17 *55*	17 *55*	17 *55*	22 *70*	22 *70*
P7	16 *50*	16 *50*	16 *50*	16 *50*	21 *70*	21 *70*
P8	— —	— —	— —	— —	— —	— —
P11	— —	— —	— —	— —	— —	— —
P12	— —	— —	— —	— —	— —	— —
M1	19 *60*	19 *60*	19 *60*	19 *60*	19 *60*	19 *60*
M2	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*	15 *49*
M3	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*
M4	— —	— —	8,6 *28*	8,6 *28*	8,6 *28*	8,6 *28*
M5	— —	— —	— —	— —	— —	— —
K1	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —
N1	31 *100*	31 *100*	47 *155*	47 *155*	47 *155*	47 *155*
N2	20 *65*	20 *65*	30 *100*	30 *100*	30 *100*	30 *100*
N3	— —	— —	20 *65*	20 *65*	20 *65*	20 *65*
N11	— —	— —	27 *90*	27 *90*	27 *90*	27 *90*
S1	— —	— —	— —	— —	— —	— —
S2	— —	— —	— —	— —	— —	— —
S3	— —	— —	— —	— —	— —	— —
S11	— —	— —	— —	— —	— —	— —
S12	— —	— —	— —	— —	— —	— —
S13	— —	— —	— —	— —	— —	— —

SMG = Seco material group
Cutting speeds, (v_c = m/min, (sf/min), in the table are recommendations for a start value.

For more detailed information on cutting data, please visit MyPages or Seco Suggest on secotools.com

Taps Selection MTH-P001 (-A) – MTH-P011

Tool type	MTH-P001 30-48 HRC	MTH-P001-A 30-48 HRC	MTH-P002 30-48 HRC	MTH-P002-A 30-48 HRC	MTH-P003	MTH-P003-A	MTH-P004	MTH-P004-A	MTH-P011
Thread type	M	M	M	M	M	M	M	M	MF
TCTR	6H	6H	6H	6H	6HX	6HX	6HX	6HX	6HX
ULDR	1.5	1.5	1.5	1.5	3	3	3	3	3
THCHT	C	C	C	C	C	C	C	C	C
BSG	SECO-DIN	SECO-DIN	DIN376	DIN376	DIN371	DIN371	DIN376	DIN376	DIN374
Thread size	M3 - M10	M4 - M10	M12 - M20	M12 - M20	M1.6 - M10	M4 - M10	M5 - M30	M12 - M30	MF 4X0.5 - MF 30X2.0
FHA	15°	15°	15°	15°	48°	48°	48°	48°	48°
Coolant	No	Yes	No	Yes	No	Yes	No	Yes	No
Page(s)	437	438	439	440	441	442	443	444	445, 446

For cutting data, see next page

Cutting data MTH-P001 (-A) – P011

SMG	v_c								
	MTH- P001	MTH- P001-A	MTH- P002	MTH- P002-A	MTH- P003	MTH- P003-A	MTH- P004	MTH- P004-A	MTH- P011
P1	—	—	—	—	55	55	55	55	55
	—	—	—	—	*180*	*180*	*180*	*180*	*180*
P2	—	—	—	—	55	55	55	55	55
	—	—	—	—	*180*	*180*	*180*	*180*	*180*
P3	—	—	—	—	45	45	45	45	45
	—	—	—	—	*150*	*150*	*150*	*150*	*150*
P4	—	—	—	—	40	40	40	40	40
	—	—	—	—	*130*	*130*	*130*	*130*	*130*
P5	—	—	—	—	38	38	38	38	38
	—	—	—	—	*125*	*125*	*125*	*125*	*125*
P6	—	—	—	—	43	43	43	43	43
	—	—	—	—	*140*	*140*	*140*	*140*	*140*
P7	—	—	—	—	40	40	40	40	40
	—	—	—	—	*130*	*130*	*130*	*130*	*130*
P8	—	—	—	—	38	38	38	38	38
	—	—	—	—	*125*	*125*	*125*	*125*	*125*
P11	—	—	—	—	39	39	39	39	39
	—	—	—	—	*130*	*130*	*130*	*130*	*130*
P12	—	—	—	—	23	23	23	23	23
	—	—	—	—	*75*	*75*	*75*	*75*	*75*
M1	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
M2	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
M3	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
M4	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
M5	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K1	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
H5	17	17	17	17	—	—	—	—	—
	55	*55*	*55*	*55*	—	—	—	—	—
H8	17	17	17	17	—	—	—	—	—
	55	*55*	*55*	*55*	—	—	—	—	—

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTP-P001 – MTP-P011

Tool type	MTP-P001 30-48 HRC	MTP-P002 30-48 HRC	MTP-P003	MTP-P003-A	MTP-P004	MTP-P004-A	MTP-P011
Thread type	M	M	M	M	M	M	MF
TCTR	6H	6H	5HX/6HX	6HX	6HX	6HX	6HX
ULDR	2.5	2.5	3	3	3	3	3
THCHT	B	B	B	B	B	B	B
BSG	SECO-DIN	DIN376	DIN371	DIN371	DIN376	DIN376	DIN374
Thread size	M3 - M10	M12 - M20	M1 - M10	M4 - M10	M4 - M30	M12 - M30	MF 4X0.5 - MF 30X2.0
Coolant	No	No	No	Yes	No	Yes	No
Page(s)	408	409	410	411	412	413	414, 415

For cutting data, see next page

Cutting data MTP-P001 – P011

SMG	v_c						
	MTP- P001	MTP- P002	MTP- P003	MTP- P003-A	MTP- P004	MTP- P004-A	MTP- P011
P1	—	—	60	60	60	60	60
	—	—	*195*	*195*	*195*	*195*	*195*
P2	—	—	60	60	60	60	60
	—	—	*195*	*195*	*195*	*195*	*195*
P3	—	—	50	50	50	50	50
	—	—	*165*	*165*	*165*	*165*	*165*
P4	—	—	45	45	45	45	45
	—	—	*150*	*150*	*150*	*150*	*150*
P5	—	—	43	43	43	43	43
	—	—	*140*	*140*	*140*	*140*	*140*
P6	—	—	48	48	48	48	48
	—	—	*155*	*155*	*155*	*155*	*155*
P7	—	—	46	46	46	46	46
	—	—	*150*	*150*	*150*	*150*	*150*
P8	—	—	43	43	43	43	43
	—	—	*140*	*140*	*140*	*140*	*140*
P11	—	—	44	44	44	44	44
	—	—	*145*	*145*	*145*	*145*	*145*
P12	—	—	26	26	26	26	26
	—	—	*85*	*85*	*85*	*85*	*85*
M1	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
M2	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
M3	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
M4	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
M5	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K1	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
H5	17	17	—	—	—	—	—
	55	*55*	—	—	—	—	—
H8	17	17	—	—	—	—	—
	55	*55*	—	—	—	—	—

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTH-M003 (-A) – MTP-M004 (-A)

Tool type	MTH-M003	MTH-M003-A	MTH-M004	MTH-M004-A	MTP-M003-A	MTP-M004	MTP-M004-A
Thread type	M	M	M	M	M	M	M
TCTR	6H	6H	6H	6H	6H	6H	6H
ULDR	2.5	2.5	2.5	2.5	2.5	2.5	2.5
THCHT	C	C	C	C	B	B	B
BSG	DIN371	DIN371	DIN376	DIN376	DIN371	DIN376	DIN376
Thread size	M1.6 - M10	M4 - M10	M12 - M20	M12 - M20	M4 - M10	M12 - M20	M12 - M24
FHA	48°	48°	48°	48°	–	–	–
Coolant	No	Yes	No	Yes	Yes	No	Yes
Page(s)	447	448	449	450	416	417	418

For cutting data, see next page

Cutting data MTH-M003 (-A) – M004 (-A)

SMG	v_c						
	MTH- M003	MTH- M003-A	MTH- M004	MTH- M004-A	MTP- M003-A	MTP- M004	MTP- M004-A
P1	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P2	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P3	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P4	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P5	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P6	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P7	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P8	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P11	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
P12	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
M1	12	12	12	12	12	12	12
	39	*39*	*39*	*39*	*39*	*39*	*39*
M2	10	10	10	10	10	10	10
	33	*33*	*33*	*33*	*33*	*33*	*33*
M3	8	8	8	8	8	8	8
	26	*26*	*26*	*26*	*26*	*26*	*26*
M4	6	6	6	6	6	6	6
	20	*20*	*20*	*20*	*20*	*20*	*20*
M5	5	5	5	5	5	5	5
	16	*16*	*16*	*16*	*16*	*16*	*16*
K1	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
H5	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—
	—	—	—	—	—	—	—

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTH-N001 – MTP-N002 (-A)

Tool type	MTH-N001	MTH-N002	MTP-N001	MTP-N001-A	MTP-N002	MTP-N002-A
Thread type	M	M	M	M	M	M
TCTR	6H	6H	6H	6H	6H	6H
ULDR	1.5	1.5	3	3	3	3
THCHT	C	C	B	B	B	B
BSG	DIN371	DIN376	DIN371	DIN371	DIN376	DIN376
Thread size	M3 - M10	M12 - M16	M3 - M10	M4 - M10	M12 - M16	M12 - M16
FHA	15°	15°	–	–	–	–
Coolant	No	No	No	Yes	No	Yes
Page(s)	451	452	419	420	421	422

For cutting data, see next page

Cutting data MTH-N001 – N002 (-A)

SMG	v_c					
	MTH- N001	MTH- N002	MTP- N001	MTP- N001-A	MTP- N002	MTP- N002-A
P1	— —	— —	— —	— —	— —	— —
P2	— —	— —	— —	— —	— —	— —
P3	— —	— —	— —	— —	— —	— —
P4	— —	— —	— —	— —	— —	— —
P5	— —	— —	— —	— —	— —	— —
P6	— —	— —	— —	— —	— —	— —
P7	— —	— —	— —	— —	— —	— —
P8	— —	— —	— —	— —	— —	— —
P11	— —	— —	— —	— —	— —	— —
P12	— —	— —	— —	— —	— —	— —
M1	— —	— —	— —	— —	— —	— —
M2	— —	— —	— —	— —	— —	— —
M3	— —	— —	— —	— —	— —	— —
M4	— —	— —	— —	— —	— —	— —
M5	— —	— —	— —	— —	— —	— —
K1	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —
N1	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
N2	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*
N3	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*
N11	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*
H5	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
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Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTH-S001 – MTH-S032

Tool type	MTH-S001	MTH-S002	MTH-S003	MTH-S004	MTH-S011	MTH-S012	MTH-S031	MTH-S032
Thread type	M	M	M	M	MF	MJ	UNC	UNJC
TCTR	6HX	6HX	6HX	6HX	6HX	4H	2B	3B
ULDR	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
THCHT	C	C	C	C	C	C	C	C
BSG	DIN371	DIN371	DIN371	DIN371	DIN371	DIN371	DIN2184-1	DIN2184-1
Thread size	M3-M10	M12-M16	M3-M10	M12-M16	MF8X1-MF12X1,5	MJ3-MJ6	UNC2-56-UNC3/8-16	UNJC4-40-UNJC3/8-16
FHA	10°	10°	10°	10°	10°	10°	25°	10°
Coolant	No	No	No	No	No	No	No	No
Page(s)	453	454	455	456	457	458	459	460

For cutting data, see next page

Cutting data MTH-S001 – S032

SMG	v_c							
	MTH-S001	MTH-S002	MTH-S003	MTH-S004	MTH-S011	MTH-S012	MTH-S031	MTH-S032
P1	— —	— —	— —	— —	— —	— —	— —	— —
P2	— —	— —	— —	— —	— —	— —	— —	— —
P3	— —	— —	— —	— —	— —	— —	— —	— —
P4	— —	— —	— —	— —	— —	— —	— —	— —
P5	— —	— —	— —	— —	— —	— —	— —	— —
P6	3 *10*	3 *10*	7 *23*	7 *23*	3 *10*	3 *10*	3 *10*	3 *10*
P7	3 *10*	3 *10*	7 *23*	7 *23*	3 *10*	3 *10*	3 *10*	3 *10*
P8	— —	— —	— —	— —	— —	— —	— —	— —
P11	3 *10*	3 *10*	6 *20*	6 *20*	3 *10*	3 *10*	3 *10*	3 *10*
P12	2 *7*	2 *7*	4 *13*	4 *13*	2 *7*	2 *7*	2 *7*	2 *7*
M1	— —	— —	— —	— —	— —	— —	— —	— —
M2	— —	— —	— —	— —	— —	— —	— —	— —
M3	— —	— —	— —	— —	— —	— —	— —	— —
M4	— —	— —	— —	— —	— —	— —	2 *7*	— —
M5	— —	— —	— —	— —	— —	— —	2 *7*	— —
K1	— —	— —	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —
N3	16 *50*	16 *50*	25 *80*	25 *80*	16 *50*	16 *50*	— —	16 *50*
N11	— —	— —	— —	— —	— —	— —	— —	— —
S1	2 *7*	2 *7*	4 *13*	4 *13*	2 *7*	2 *7*	2 *7*	2 *7*
S2	2 *7*	2 *7*	3 *10*	3 *10*	2 *7*	2 *7*	2 *7*	2 *7*
S3	2 *7*	2 *7*	3 *10*	3 *10*	2 *7*	2 *7*	2 *7*	2 *7*
S11	— —	— —	— —	— —	— —	— —	— —	— —
S12	— —	— —	— —	— —	— —	— —	— —	— —
S13	— —	— —	— —	— —	— —	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —

Taps Selection MTH-S041 – MTH-S142

Tool type	MTH-S041	MTH-S042	MTH-S043	MTH-S044	MTH-S101	MTH-S102	MTH-S111	MTH-S112	MTH-S142
Thread type	UNF	UNJF	EGUNF	EGUNF	M	M	MF	MJ	UNJF
TCTR	3B	3B	3B	3B	6HX	6HX	6HX	4H	3B
ULDR	1.5	1.5	2.0	1.5	2.0	2.0	2.0	2.0	2.0
THCHT	C	C	C	C	C	C	C	C	C
BSG	DIN2184-1	DIN2184-1	DIN2184-1	DIN2184-1	DIN371	DIN376	DIN376	DIN371	DIN2184-1
Thread size	UNF6-40-UNF3/8-24	UNJF6-40-UN-JF3/8-24	EGUNF6-40-EGUNF3/8-24	EGUNF6-40-EGUNF3/8-24	M2-M10	M12-M20	MF6X0,75-MF14X1,5	MJ3-MJ10	UNJF10-32-UNJF3/8-24
FHA	25°	10°	15°	10°	15°	15°	15°	15°	15°
Coolant	No	No	No	No	No	No	No	No	No
Page(s)	461	462	463	464	465	466	467	468	469

For cutting data, see next page

Cutting data MTH-S041 – S142

SMG	v_c								
	MTH-S041	MTH-S042	MTH-S043	MTH-S044	MTH-S101	MTH-S102	MTH-S111	MTH-S112	MTH-S142
P1	— —	— —	— —	— —	— —	— —	— —	— —	— —
P2	— —	— —	— —	— —	— —	— —	— —	— —	— —
P3	— —	— —	— —	— —	— —	— —	— —	— —	— —
P4	— —	— —	— —	— —	— —	— —	— —	— —	— —
P5	— —	— —	— —	— —	— —	— —	— —	— —	— —
P6	3 *10*	3 *10*	7 *23*	3 *10*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*
P7	3 *10*	3 *10*	7 *23*	3 *10*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*
P8	— —	— —	— —	— —	— —	— —	— —	— —	— —
P11	3 *10*	3 *10*	6 *20*	3 *10*	6 *20*	6 *20*	6 *20*	6 *20*	6 *20*
P12	2 *7*	2 *7*	4 *13*	2 *7*	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*
M1	— —	— —	— —	— —	— —	— —	— —	— —	— —
M2	— —	— —	— —	— —	— —	— —	— —	— —	— —
M3	— —	— —	— —	— —	— —	— —	— —	— —	— —
M4	2 *7*	— —	6 *20*	— —	6 *20*	6 *20*	6 *20*	6 *20*	6 *20*
M5	2 *7*	— —	5 *16*	— —	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*
K1	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	16 *50*	25 *80*	16 *50*	25 *80*	25 *80*	25 *80*	25 *80*	25 *80*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	2 *7*	2 *7*	— —	2 *7*	— —	— —	— —	— —	— —
S2	2 *7*	2 *7*	— —	2 *7*	— —	— —	— —	— —	— —
S3	2 *7*	2 *7*	— —	2 *7*	— —	— —	— —	— —	— —
S11	— —	— —	5 *16*	— —	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*
S12	— —	— —	4 *13*	— —	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*
S13	— —	— —	3 *10*	— —	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —

Taps Selection MTP-S001 – MTP-S043

Tool type	MTP-S001	MTP-S002	MTP-S011	MTP-S012	MTP-S013	MTP-S042	MTP-S043
Thread type	M	M	MF	MJ	EGM	UNFJ	EGUNF
TCTR	6HX	6HX	6HX	4H	4H	3B	3B
ULDR	2.0	2.0	2.0	2.0	2.0	2.0	2.0
THCHT	B	B	B	B	B	B	B
BSG	DIN371	DIN376	DIN371	DIN371	DIN40435	DIN2184-1	DIN2184-1
Thread size	M2-M10	M12-M20	MF6X0,75-MF14X1,5	MJ4-MJ8	EGM4-EGM8	UNJF10-32-UNJF3/8-24	EGUNF10-32-EGUNF3/8-24
FHA	–	–	–	–	–	–	–
Coolant	No	No	No	No	No	No	No
Page(s)	423	424	425	426	427	428	429

For cutting data, see next page

Cutting data MTP-S001 – S043

SMG	v_c						
	MTP-S001	MTP-S002	MTP-S011	MTP-S012	MTP-S013	MTP-S042	MTP-S043
P1	— —	— —	— —	— —	— —	— —	— —
P2	— —	— —	— —	— —	— —	— —	— —
P3	— —	— —	— —	— —	— —	— —	— —
P4	— —	— —	— —	— —	— —	— —	— —
P5	— —	— —	— —	— —	— —	— —	— —
P6	— —	— —	— —	— —	— —	— —	— —
P7	— —	— —	— —	— —	— —	— —	— —
P8	— —	— —	— —	— —	— —	— —	— —
P11	— —	— —	— —	— —	— —	— —	— —
P12	— —	— —	— —	— —	— —	— —	— —
M1	— —	— —	— —	— —	— —	— —	— —
M2	— —	— —	— —	— —	— —	— —	— —
M3	— —	— —	— —	— —	— —	— —	— —
M4	6 *20*	6 *20*	6 *20*	6 *20*	2 *7*	6 *20*	2 *7*
M5	5 *16*	5 *16*	5 *16*	5 *16*	2 *7*	5 *16*	2 *7*
K1	— —	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —
N3	25 *80*	25 *80*	25 *80*	25 *80*	16 *50*	25 *80*	16 *50*
N11	— —	— —	— —	— —	— —	— —	— —
S1	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*
S2	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*
S3	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*
S11	5 *16*	5 *16*	5 *16*	5 *16*	4 *13*	5 *16*	4 *13*
S12	4 *13*	4 *13*	4 *13*	4 *13*	3 *10*	4 *13*	3 *10*
S13	3 *10*	3 *10*	3 *10*	3 *10*	2 *7*	3 *10*	2 *7*
H5	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —

Taps Selection MTS-K101 (-A) – MTS-K141

Tool type	MTS-K101	MTS-K101-A	MTS-K002	MTS-K002-A	MTS-K102	MTS-K102-A	MTS-K111	MTS-K121	MTS-K131	MTS-K141
Thread type	M	M	M	M	M	M	MF	G	UNC	UNF
TCTR	6HX	6HX	6HX	6HX	6HX	6HX	6HX	NORMAL-X	2BX	2BX
ULDR	2.5	2.5	2	2.5	2.5	2.5	2.5	2.5	2.5	2.5
THCHT	C	C/E	C	C/E	C	C/E	C	C	C	C
BSG	DIN371	DIN371	DIN376	DIN376	DIN376	DIN376	DIN374	DIN5156	DIN2184-1	DIN2184-1
Thread size	M3 - M10	M4 - M10	M27 - M42	M27 - M42	M8 - M24	M12 - M24	MF 10X1 - MF 20X1.5	G1/8-28 - G1-11	UNC 1/4-20 - UNC 7/8-9	UNF 1/4-28 - UNF 7/8-14
FHA	–	–	–	–	–	–	–	–	–	–
Coolant	No	Yes	No	Yes	No	Yes	No	No	No	No
Page(s)	487	488	489	490	491	492	493	494	495	496

For cutting data, see next page

Cutting data MTS-K101 – MTS-K141

SMG	v_c							
	MTS- K101	MTS- K101-A	MTS- K102	MTS- K102-A	MTS- K111	MTS- K121	MTS- K131	MTS- K141
P1	— —	— —	— —	— —	— —	— —	— —	— —
P2	— —	— —	— —	— —	— —	— —	— —	— —
P3	— —	— —	— —	— —	— —	— —	— —	— —
P4	— —	— —	— —	— —	— —	— —	— —	— —
P5	— —	— —	— —	— —	— —	— —	— —	— —
P6	— —	— —	— —	— —	— —	— —	— —	— —
P7	— —	— —	— —	— —	— —	— —	— —	— —
P8	— —	— —	— —	— —	— —	— —	— —	— —
P11	— —	— —	— —	— —	— —	— —	— —	— —
P12	— —	— —	— —	— —	— —	— —	— —	— —
M1	— —	— —	— —	— —	— —	— —	— —	— —
M2	— —	— —	— —	— —	— —	— —	— —	— —
M3	— —	— —	— —	— —	— —	— —	— —	— —
M4	— —	— —	— —	— —	— —	— —	— —	— —
M5	— —	— —	— —	— —	— —	— —	— —	— —
K1	85 *280*	85 *280*	85 *280*	85 *280*	85 *280*	85 *280*	85 *280*	85 *280*
K2	75 *245*	75 *245*	75 *245*	75 *245*	75 *245*	75 *245*	75 *245*	75 *245*
K3	65 *215*	65 *215*	65 *215*	65 *215*	65 *215*	65 *215*	65 *215*	65 *215*
K4	60 *195*	60 *195*	60 *195*	60 *195*	60 *195*	60 *195*	60 *195*	60 *195*
K5	36 *120*	36 *120*	36 *120*	36 *120*	36 *120*	36 *120*	36 *120*	36 *120*
K6	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
K7	46 *150*	46 *150*	46 *150*	46 *150*	46 *150*	46 *150*	46 *150*	46 *150*
N1	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTH-V011 – MTH-V030 (-A)

Tool type	MTH-V011	MTH-V015	MTH-V016	MTH-V025	MTH-V026	MTH-V029	MTH-V030	MTH-V030-A
Thread type	MF	M	M	M	M	M	M	M
TCTR	6HX	6H	6H	6H	6H	6G	6H	6H
ULDR	2	2	2	3	3	3	2.5	2.5
THCHT	C	C	C	C	C	C	C	C
BSG	DIN374	DIN371	DIN376	DIN371	DIN376	DIN376	DIN371	DIN371
Thread size	MF 8X0.75 - MF 24X2.0	M3 - M10	M12 - M36	M3 - M10	M12 - M20	M12 - M20	M2 - M10	M4 - M10
FHA	15°	15°	15°	45°	45°	45°	45°	45°
Coolant	No	No	No	No	No	No	No	Yes
Page(s)	470	471	472	473	474	475	476	477

For cutting data, see next page

Cutting data MTH-V011 – MTH-V030 (-A)

SMG	v_c							
	MTH- V011	MTH- V015	MTH- V016	MTH- V025	MTH- V026	MTH- V029	MTH- V030	MTH- V030-A
P1	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*
P2	39 *130*	39 *130*	39 *130*	39 *130*	39 *130*	39 *130*	39 *130*	39 *130*
P3	33 *110*	33 *110*	33 *110*	33 *110*	33 *110*	33 *110*	33 *110*	33 *110*
P4	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*
P5	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*
P6	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*
P7	30 *100*	30 *100*	30 *100*	30 *100*	30 *100*	30 *100*	30 *100*	30 *100*
P8	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*
P11	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*
P12	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*
M1	9 *30*	9 *30*	9 *30*	9 *30*	9 *30*	9 *30*	9 *30*	9 *30*
M2	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*
M3	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*
M4	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*
M5	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*
K1	— —	— —	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	— —	— —
N1	37 *120*	37 *120*	37 *120*	37 *120*	37 *120*	37 *120*	37 *120*	37 *120*
N2	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*
N3	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*
N11	21 *70*	21 *70*	21 *70*	21 *70*	21 *70*	21 *70*	21 *70*	21 *70*
H5	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTH-V033 (-A) – MTH-V045

Tool type	MTH-V033	MTH-V033-A	MTH-V038	MTH-V038-A	MTH-V043	MTH-V045
Thread type	M	M	MF	MF	UNF	G
TCTR	6H	6H	6H	6H	2B	NORMAL
ULDR	2.5	2.5	2.5	2.5	2.5	2.5
THCHT	C	C	C	C	C	C
BSG	DIN376	DIN376	DIN374	DIN374	DIN2184-1	DIN5156
Thread size	M6 - M64	M12 - M64	MF 4X0.5 - MF 30X2.0	MF 6X0.75 - MF 30X2.0	UNF 8-36 - UNF 1-12	G 1/8-28 - G11/2-11
FHA	45°	45°	45°	45°	45°	45°
Coolant	No	No	No	No	No	Yes
Page(s)	478	479	480	481, 482	483	484

For cutting data, see next page

Cutting data MTH-V033 (-A) – MTH-V045

SMG	v_c					
	MTH- V033	MTH- V033-A	MTH- V038	MTH- V038-A	MTH- V043	MTH- V045
P1	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*
P2	39 *130*	39 *130*	39 *130*	39 *130*	39 *130*	39 *130*
P3	33 *110*	33 *110*	33 *110*	33 *110*	33 *110*	33 *110*
P4	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*
P5	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*
P6	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*
P7	30 *100*	30 *100*	30 *100*	30 *100*	30 *100*	30 *100*
P8	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*
P11	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*
P12	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*
M1	9 *30*	9 *30*	9 *30*	9 *30*	9 *30*	9 *30*
M2	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*
M3	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*
M4	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*
M5	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*
K1	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —
N1	37 *120*	37 *120*	37 *120*	37 *120*	37 *120*	37 *120*
N2	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*
N3	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*
N11	21 *70*	21 *70*	21 *70*	21 *70*	21 *70*	21 *70*
H5	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTP-V002 – MTP-V008 (-A)

Tool type	MTP-V002	MTP-V007	MTP-V007-A	MTP-V008	MTP-V008-A
Thread type	M	M	M	M	M
TCTR	6H	6H	6H	6H	6H
ULDR	3	2.5	2.5	2.5	2.5
THCHT	B	B	B	B	B
BSG	DIN376	DIN371	DIN371	DIN376	DIN376
Thread size	M12 - M20	M2 - M10	M4 - M10	M3 - M36	M12 - M36
FHA	–	–	–	–	–
Coolant	No	No	Yes	No	Yes
Page(s)	430	431	432	433	434

For cutting data, see next page

Cutting data MTP-V002 – MTP-V008 (-A)

SMG	v_c				
	MTP- V002	MTP- V005	MTP- V007-A	MTP- V008	MTP- V008-A
P1	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*
P2	39 *130*	39 *130*	39 *130*	39 *130*	39 *130*
P3	33 *110*	33 *110*	33 *110*	33 *110*	33 *110*
P4	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*
P5	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*
P6	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*
P7	30 *100*	30 *100*	30 *100*	30 *100*	30 *100*
P8	28 *90*	28 *90*	28 *90*	28 *90*	28 *90*
P11	29 *95*	29 *95*	29 *95*	29 *95*	29 *95*
P12	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*
M1	9 *30*	9 *30*	9 *30*	9 *30*	9 *30*
M2	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*
M3	5 *16*	5 *16*	5 *16*	5 *16*	5 *16*
M4	4 *13*	4 *13*	4 *13*	4 *13*	4 *13*
M5	3 *10*	3 *10*	3 *10*	3 *10*	3 *10*
K1	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —
N1	37 *120*	37 *120*	37 *120*	37 *120*	37 *120*
N2	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*
N3	16 *50*	16 *50*	16 *50*	16 *50*	16 *50*
N11	21 *70*	21 *70*	21 *70*	21 *70*	21 *70*
H5	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

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Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTP-V014 (-A) – MTP-V023

Tool type	MTP-V014	MTP-V014-A
Thread type	MF	MF
TCTR	6H	6H
ULDR	2.5	2.5
THCHT	B	B
BSG	DIN374	DIN374
Thread size	MF 4X0.5 - MF 30X2.0	MF 6X0.75 - MF 24X2.0
FHA	–	–
Coolant	No	Yes
Page(s)	435	436

For cutting data, see next page

Cutting data MTP-V014 (-A) – MTP-V023

SMG	v_c	
	MTP- V014	MTP- V014-A
P1	40 *130*	40 *130*
P2	39 *130*	39 *130*
P3	33 *110*	33 *110*
P4	29 *95*	29 *95*
P5	28 *90*	28 *90*
P6	31 *100*	31 *100*
P7	30 *100*	30 *100*
P8	28 *90*	28 *90*
P11	29 *95*	29 *95*
P12	17 *55*	17 *55*
M1	9 *30*	9 *30*
M2	7 *23*	7 *23*
M3	5 *16*	5 *16*
M4	4 *13*	4 *13*
M5	3 *10*	3 *10*
K1	— —	— —
K2	— —	— —
K3	— —	— —
K4	— —	— —
K5	— —	— —
K6	— —	— —
K7	— —	— —
N1	37 *120*	37 *120*
N2	24 *80*	24 *80*
N3	16 *50*	16 *50*
N11	21 *70*	21 *70*
H5	— —	— —
H8	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTH-V048 – MTH-V050

Tool type	MTH-V048	MTH-V050
Thread type	NPT	NPTF
TCTR	NORMAL	NORMAL
ULDR	1.5	1.5
THCHT	C	C
BSG	DIN/ANSI	DIN/ANSI
Thread size	NPT 1/16-27 NPT 1-11.5	NPTF 1/16-27 NPTF 3/4-14
FHA	15°	15°
Coolant	No	No
Page(s)	485	486

For cutting data, see next page

Cutting data MTH-V048 – V050

SMG	v_c	
	MTH- V048	MTH- V050
P1	11 *36*	11 *36*
P2	11 *36*	11 *36*
P3	10 *33*	10 *33*
P4	8 *26*	8 *26*
P5	8 *26*	8 *26*
P6	9 *30*	9 *30*
P7	8 *26*	8 *26*
P8	8 *26*	8 *26*
P11	8 *26*	8 *26*
P12	5 *16*	5 *16*
M1	9 *30*	9 *30*
M2	7 *23*	7 *23*
M3	5 *16*	5 *16*
M4	4 *13*	4 *13*
M5	3 *10*	3 *10*
K1	14 *46*	14 *46*
K2	12 *39*	12 *39*
K3	10 *33*	10 *33*
K4	10 *33*	10 *33*
K5	6 *20*	6 *20*
K6	9 *30*	9 *30*
K7	8 *26*	8 *26*
N1	23 *75*	23 *75*
N2	15 *49*	15 *49*
N3	10 *33*	10 *33*
N11	13 *43*	13 *43*
H5	— —	— —
H8	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
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Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MF-V053 – MF-V063 (-A)

Tool type	MF-V054	MF-V055	MF-V056	MF-V057	MF-V058	MF-V060-A	MF-V063	MF-V063-A
Thread type	M	M	UNC	UNF	M	M	MF	MF
TCTR	5HX/6HX	6HX	2BX	2BX	6GX	6HX	6HX	6HX
ULDR	3	3	3	3	3	3	3	3
THCHT	C	C	C	C	C	C	C	C
BSG	DIN2174	DIN2174	DIN2184-1	DIN2184-1	DIN2174	DIN2174	DIN2174	DIN2174
Thread size	M1 - M2.6	M3 - M48	UNC 4-40 - UNC 1-8	UNF 10-32 - UNF 1-12	M3 - M12	M5 - M48	MF 5X0.5 - MF 16X1.5	MF 5X0.5 - MF 16X1.5
FHA	–	–	–	–	–	–	–	–
Coolant	No	No	No	No	No	Yes	No	Yes
Page(s)	497	498	499	500	501	502	503	504

For cutting data, see next page

Cutting data MF-V053 – MF-V063 (-A)

SMG	v_c							
	MF- V054	MF- V055	MF- V056	MF- V057	MF- V058	MF- V060	MF- V063	MF- V063-A
P1	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
P2	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
P3	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*
P4	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*
P5	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*
P6	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*
P7	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*
P8	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*
P11	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*
P12	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*
M1	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*
M2	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*
M3	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*
M4	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*
M5	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*
K1	— —	— —	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	— —	— —
N1	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
N2	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*
N3	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*
N11	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*
H5	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —

SMG = Seco material group
v_c = m/min (sf/min)

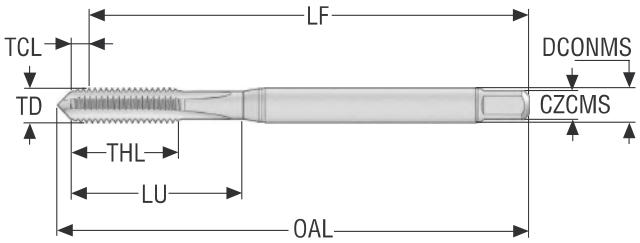
Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

When running in 1,5xD increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

T32-SNC-micro

Blind and through holes – Metric coarse threads

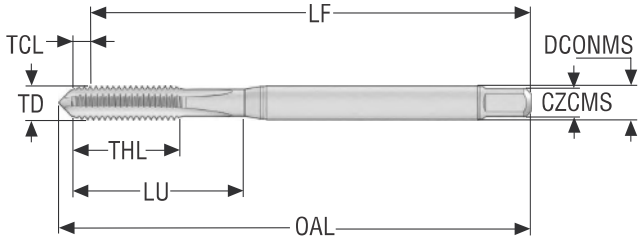


- Substrate: HSS-PM
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 4H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN01C03-1X0.25-41R	10139661	M1	0,25	0,68 *0.027*	6,0 *0.236*	13 *0.512*	39,32 *1.548*	40,9 *1.610*	2,5 *0.098*	2.50X2.10	0,75 *0.030*	2	C
T32-SN01C03-1.1X0.25-41R	10139662	M1.1	0,25	0,68 *0.027*	6,0 *0.236*	13 *0.512*	39,32 *1.548*	41,0 *1.614*	2,5 *0.098*	2.50X2.10	0,85 *0.033*	2	C
T32-SN01C03-1.2X0.25-41R	10139663	M1.2	0,25	0,68 *0.027*	6,0 *0.236*	13 *0.512*	39,32 *1.548*	41,1 *1.618*	2,5 *0.098*	2.50X2.10	0,95 *0.037*	2	C
T32-SN01C03-1.4X0.3-41R	10139664	M1.4	0,3	0,79 *0.031*	7,0 *0.276*	13 *0.512*	39,21 *1.544*	41,3 *1.626*	2,5 *0.098*	2.50X2.10	1,1 *0.043*	2	C

T32-SNC-micro

Blind and through holes – Metric coarse threads

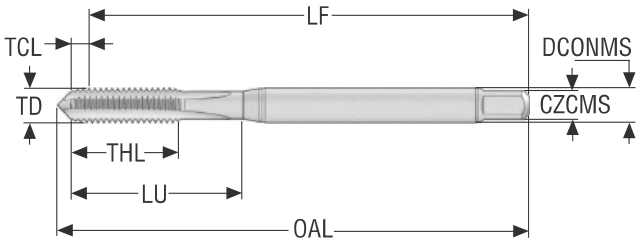


- Substrate: HSS-PM
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN01C03-1.6X0.35-63R	10139665	M1.6	0,35	0,92 *0.036*	8,0 *0.315*	13 *0.512*	39,08 *1.539*	41,4 *1.630*	2,5 *0.098*	2.50X2.10	1,25 *0.049*	2	C
T32-SN01C03-1.7X0.35-63R	10139666	M1.7	0,35	0,92 *0.036*	8,0 *0.315*	13 *0.512*	39,08 *1.539*	41,5 *1.634*	2,5 *0.098*	2.50X2.10	1,35 *0.053*	2	C
T32-SN01C03-1.8X0.35-63R	10139667	M1.8	0,35	0,92 *0.036*	8,0 *0.315*	13 *0.512*	39,08 *1.539*	41,6 *1.638*	2,5 *0.098*	2.50X2.10	1,45 *0.057*	2	C
T32-SN01C03-2X0.4-63R	10139668	M2	0,4	1,13 *0.044*	10,0 *0.394*	13 *0.512*	43,87 *1.727*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,6 *0.063*	2	C
T32-SN01C03-2.2X0.45-63R	10139669	M2.2	0,45	1,24 *0.049*	10,0 *0.394*	13 *0.512*	43,76 *1.723*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,75 *0.069*	2	C
T32-SN01C03-2.3X0.4-63R	10139670	M2.3	0,4	1,13 *0.044*	10,0 *0.394*	13 *0.512*	43,87 *1.727*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,9 *0.075*	2	C
T32-SN01C03-2.5X0.45-63R	10139672	M2.5	0,45	1,24 *0.049*	9,0 *0.354*	14 *0.551*	48,76 *1.920*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,05 *0.081*	2	C
T32-SN01C03-2.6X0.45-63R	10139673	M2.6	0,45	1,24 *0.049*	9,0 *0.354*	14 *0.551*	48,76 *1.920*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,15 *0.085*	2	C

T32-SNC

Blind and through holes – Metric coarse threads

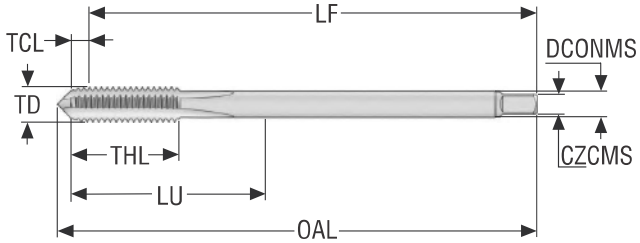


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN01C03-3X0.5-63R	10139674	M3	0,5	1,1 *0.043*	10,0 *0.394*	18 *0.709*	54,9 *2.161*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	C
T32-SN01C03-3.5X0.6-63R	10139675	M3.5	0,6	1,28 *0.050*	12,0 *0.472*	20 *0.787*	54,72 *2.154*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,9 *0.114*	3	C
T32-SN01C03-4X0.7-63R	10139676	M4	0,7	1,61 *0.063*	12,0 *0.472*	21 *0.827*	61,39 *2.417*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	C
T32-SN01C03-4.5X0.75-63R	10139677	M4.5	0,75	1,61 *0.063*	14,0 *0.551*	25 *0.984*	68,39 *2.693*	71,8 *2.827*	6,0 *0.236*	6.00X4.90	3,8 *0.150*	3	C
T32-SN01C03-5X0.8-63R	10139678	M5	0,8	1,78 *0.070*	14,0 *0.551*	25 *0.984*	68,22 *2.686*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T32-SN01C03-6X1-63R	10139679	M6	1,0	2,14 *0.084*	18,0 *0.709*	30 *1.181*	77,86 *3.065*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C
T32-SN01C03-7X1-63R	10139680	M7	1,0	2,14 *0.084*	18,0 *0.709*	30 *1.181*	77,86 *3.065*	82,9 *3.264*	7,0 *0.276*	7.00X5.50	6,0 *0.236*	3	C
T32-SN01C03-8X1.25-63R	10139681	M8	1,25	2,94 *0.116*	20,0 *0.787*	35 *1.378*	87,06 *3.428*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	C
T32-SN01C03-9X1.25-63R	10139682	M9	1,25	2,94 *0.116*	20,0 *0.787*	35 *1.378*	87,06 *3.428*	91,7 *3.610*	9,0 *0.354*	9.00X7.00	7,8 *0.307*	3	C
T32-SN01C03-10X1.5-63R	10139683	M10	1,5	3,55 *0.140*	20,0 *0.787*	39 *1.535*	96,45 *3.797*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T32-SNC

Blind and through holes – Metric coarse threads

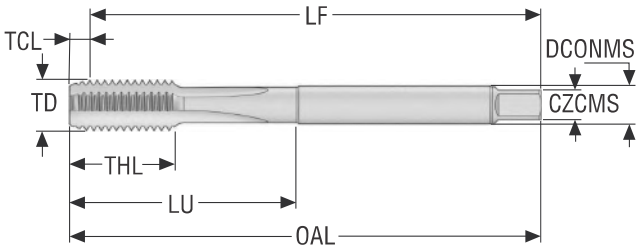


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN01C06-3X0.5-63R	10139694	M3	0,5	1,1 *0.043*	11,0 *0.433*	36 *1.417*	54,9 *2.161*	57,2 *2.252*	2,2 *0.087*	2.20X1.80	2,5 *0.098*	3	C
T32-SN01C06-4X0.7-63R	10139696	M4	0,7	1,61 *0.063*	12,0 *0.472*	43 *1.693*	61,39 *2.417*	64,6 *2.543*	2,8 *0.110*	2.80X2.10	3,3 *0.130*	3	C
T32-SN01C06-5X0.8-63R	10139697	M5	0,8	1,78 *0.070*	14,0 *0.551*	49 *1.929*	68,22 *2.686*	72,0 *2.835*	3,5 *0.138*	3.50X2.70	4,2 *0.165*	3	C
T32-SN01C06-6X1-63R	10139698	M6	1,0	2,14 *0.084*	18,0 *0.709*	59 *2.323*	77,86 *3.065*	82,4 *3.244*	4,5 *0.177*	4.50X3.40	5,0 *0.197*	3	C

T32-SNC

Blind and through holes – Metric coarse threads

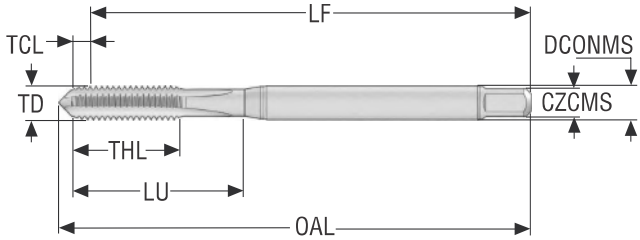


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN01C06-8X1.25-63R	10139700	M8	1,25	2,94 *0.116*	20,0 *0.787*	67 *2.638*	87,06 *3.428*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	6,8 *0.268*	3	C
T32-SN01C06-10X1.5-63R	10139702	M10	1,5	3,55 *0.140*	20,0 *0.787*	77 *3.031*	96,45 *3.797*	100,0 *3.937*	7,0 *0.276*	7.00X5.50	8,5 *0.335*	3	C
T32-SN01C06-12X1.75-63R	10139703	M12	1,75	4,17 *0.164*	24,0 *0.945*	83 *3.268*	105,83 *4.167*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T32-SN01C06-14X2-63R	10139704	M14	2,0	4,78 *0.188*	25,0 *0.984*	81 *3.189*	105,22 *4.143*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	4	C
T32-SN01C06-16X2-63R	10139705	M16	2,0	4,88 *0.192*	32,0 *1.260*	68 *2.677*	105,12 *4.139*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	C
T32-SN01C06-18X2.5-63R	10139706	M18	2,5	5,97 *0.235*	32,0 *1.260*	81 *3.189*	119,03 *4.686*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	15,5 *0.610*	4	C
T32-SN01C06-20X2.5-63R	10139707	M20	2,5	6,17 *0.243*	32,0 *1.260*	95 *3.740*	133,83 *5.269*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	C
T32-SN01C06-22X2.5-63R	10139708	M22	2,5	6,17 *0.243*	32,0 *1.260*	93 *3.661*	133,83 *5.269*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,5 *0.768*	4	C
T32-SN01C06-24X3-63R	10139709	M24	3,0	7,4 *0.291*	38,0 *1.496*	113 *4.449*	152,6 *6.008*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C
T32-SN01C06-27X3-63R	10139710	M27	3,0	7,4 *0.291*	38,0 *1.496*	97 *3.819*	152,6 *6.008*	160,0 *6.299*	20,0 *0.787*	20.00X16.00	24,0 *0.945*	4	C
T32-SN01C06-30X3.5-63R	10139711	M30	3,5	8,4 *0.331*	45,0 *1.772*	115 *4.528*	171,6 *6.756*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	26,5 *1.043*	4	C
T32-SN01C06-33X3.5-63R	10139712	M33	3,5	8,4 *0.331*	45,0 *1.772*	113 *4.449*	171,6 *6.756*	180,0 *7.087*	25,0 *0.984*	25.00X20.00	29,5 *1.161*	4	C
T32-SN01C06-36X4-63R	10139713	M36	4,0	9,4 *0.370*	50,0 *1.969*	131 *5.157*	190,6 *7.504*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	32,0 *1.260*	4	C
T32-SN01C06-39X4-63R	10139714	M39	4,0	9,4 *0.370*	50,0 *1.969*	102 *4.016*	190,6 *7.504*	200,0 *7.874*	32,0 *1.260*	32.00X24.00	35,0 *1.378*	4	C
T32-SN01C06-42X4.5-63R	10139715	M42	4,5	10,4 *0.409*	60,0 *2.362*	102 *4.016*	189,6 *7.465*	200,0 *7.874*	32,0 *1.260*	32.00X24.00	37,5 *1.476*	5	C
T32-SN01C06-45X4.5-63R	10139716	M45	4,5	10,42 *0.410*	60,0 *2.362*	117 *4.606*	209,58 *8.251*	220,0 *8.661*	36,0 *1.417*	36.00X29.00	40,5 *1.594*	5	C
T32-SN01C06-48X5-63R	10139717	M48	5,0	11,4 *0.449*	65,0 *2.559*	147 *5.787*	238,6 *9.394*	250,0 *9.843*	36,0 *1.417*	36.00X29.00	43,0 *1.693*	5	C
T32-SN01C06-52X5-63R	10139718	M52	5,0	11,4 *0.449*	65,0 *2.559*	120 *4.724*	238,6 *9.394*	250,0 *9.843*	40,0 *1.575*	40.00X32.00	47,0 *1.850*	5	C

T32-SNC

Blind and through holes – Metric coarse threads, left hand thread

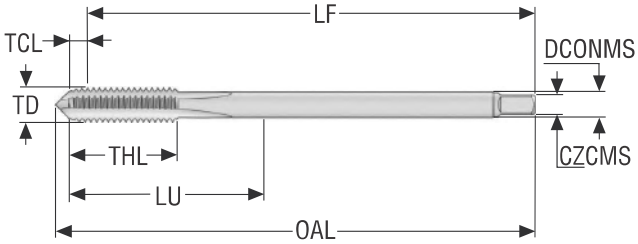


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN01C03-3X0.5-63L	10139686	M3	0,5	1,1 *0.043*	10,0 *0.394*	18 *0.709*	54,9 *2.161*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	C
T32-SN01C03-4X0.7-63L	10139687	M4	0,7	1,61 *0.063*	12,0 *0.472*	21 *0.827*	61,39 *2.417*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	C
T32-SN01C03-5X0.8-63L	10139688	M5	0,8	1,78 *0.070*	14,0 *0.551*	25 *0.984*	68,22 *2.686*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T32-SN01C03-6X1-63L	10139689	M6	1,0	2,14 *0.084*	18,0 *0.709*	30 *1.181*	77,86 *3.065*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C
T32-SN01C03-7X1-63L	10139690	M7	1,0	2,14 *0.084*	18,0 *0.709*	30 *1.181*	77,86 *3.065*	82,9 *3.264*	7,0 *0.276*	7.00X5.50	6,0 *0.236*	3	C
T32-SN01C03-8X1.25-63L	10139691	M8	1,25	2,94 *0.116*	20,0 *0.787*	35 *1.378*	87,06 *3.428*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	C
T32-SN01C03-9X1.25-63L	10139692	M9	1,25	2,94 *0.116*	20,0 *0.787*	35 *1.378*	87,06 *3.428*	91,7 *3.610*	9,0 *0.354*	9.00X7.00	7,8 *0.307*	3	C
T32-SN01C03-10X1.5-63L	10139693	M10	1,5	3,55 *0.140*	20,0 *0.787*	39 *1.535*	96,45 *3.797*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T32-SNC

Blind and through holes – Metric coarse threads, left hand thread

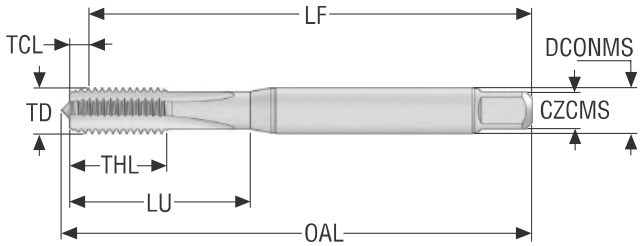


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN01C06-12X1.75-63L	10139751	M12	1,75	4,17 *0.164*	24,0 *0.945*	83 *3.268*	105,83 *4.167*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T32-SN01C06-16X2-63L	10139752	M16	2,0	4,88 *0.192*	32,0 *1.260*	68 *2.677*	105,12 *4.139*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	C
T32-SN01C06-20X2.5-63L	10139753	M20	2,5	6,17 *0.243*	32,0 *1.260*	95 *3.740*	133,83 *5.269*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	C
T32-SN01C06-24X3-63L	10139754	M24	3,0	7,4 *0.291*	38,0 *1.496*	113 *4.449*	152,6 *6.008*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C

T32-SNC

Blind and through holes – MF threads

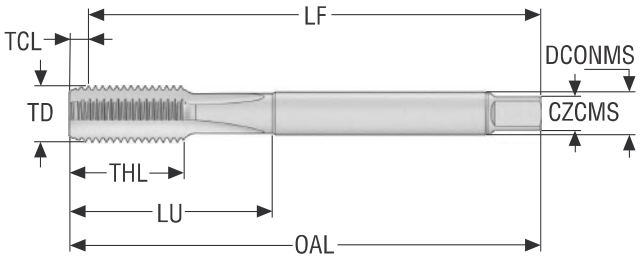


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN02C03-8X1-63R	10139684	MF8X1	1,0	2,44 *0.096*	20,0 *0.787*	35 *1.378*	87,56 *3.447*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	C
T32-SN02C03-10X1-63R	10139685	MF10X1	1,0	2,54 *0.100*	20,0 *0.787*	35 *1.378*	87,46 *3.443*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	C

T32-SNC

Blind and through holes – MF threads



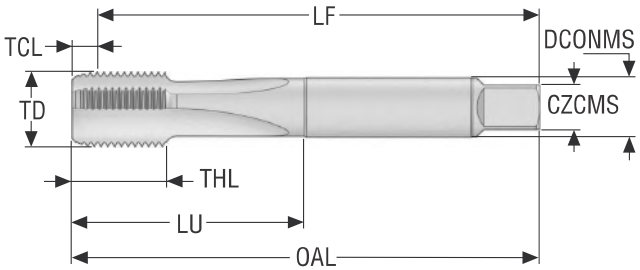
- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN374
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN02C05-8X1-63R	10139719	MF8X1	1,0	2,44 *0.096*	20,0 *0.787*	67 *2.638*	87,56 *3.447*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	C
T32-SN02C05-10X0.75-63R	10139720	MF10X0.75	0,75	3,43 *0.135*	18,0 *0.709*	67 *2.638*	86,57 *3.408*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,2 *0.362*	3	C
T32-SN02C05-10X1-63R	10139721	MF10X1	1,0	2,54 *0.100*	20,0 *0.787*	67 *2.638*	87,46 *3.443*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	C
T32-SN02C05-10X1.25-63R	10139722	MF10X1.25	1,25	3,04 *0.120*	20,0 *0.787*	77 *3.031*	96,96 *3.817*	100,0 *3.937*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	C
T32-SN02C05-12X1-63R	10139723	MF12X1	1,0	2,65 *0.104*	20,0 *0.787*	73 *2.874*	97,35 *3.833*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,0 *0.433*	3	C
T32-SN02C05-12X1.25-63R	10139724	MF12X1.25	1,25	3,16 *0.124*	20,0 *0.787*	73 *2.874*	96,84 *3.813*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,8 *0.425*	3	C
T32-SN02C05-12X1.5-63R	10139725	MF12X1.5	1,5	3,66 *0.144*	20,0 *0.787*	73 *2.874*	96,34 *3.793*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	C
T32-SN02C05-14X1-63R	10139726	MF14X1	1,0	2,75 *0.108*	20,0 *0.787*	71 *2.795*	97,25 *3.829*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,0 *0.512*	4	C
T32-SN02C05-14X1.25-63R	10139727	MF14X1.25	1,25	3,26 *0.128*	20,0 *0.787*	71 *2.795*	96,74 *3.809*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,8 *0.504*	4	C
T32-SN02C05-14X1.5-63R	10139728	MF14X1.5	1,5	3,76 *0.148*	20,0 *0.787*	71 *2.795*	96,24 *3.789*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	4	C
T32-SN02C05-16X1-63R	10139729	MF16X1	1,0	2,85 *0.112*	20,0 *0.787*	58 *2.283*	97,15 *3.825*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,0 *0.591*	4	C
T32-SN02C05-16X1.5-63R	10139730	MF16X1.5	1,5	3,86 *0.152*	20,0 *0.787*	58 *2.283*	96,14 *3.785*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	C
T32-SN02C05-18X1.5-63R	10139731	MF18X1.5	1,5	3,96 *0.156*	24,0 *0.945*	66 *2.598*	106,04 *4.175*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	C
T32-SN02C05-18X2-63R	10139732	MF18X2	2,0	4,98 *0.196*	27,0 *1.063*	81 *3.189*	120,02 *4.725*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,0 *0.630*	4	C
T32-SN02C05-20X1.5-63R	10139733	MF20X1.5	1,5	4,16 *0.164*	24,0 *0.945*	80 *3.150*	120,84 *4.757*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	18,5 *0.728*	4	C
T32-SN02C05-20X2-63R	10139734	MF20X2	2,0	5,18 *0.204*	27,0 *1.063*	95 *3.740*	134,82 *5.308*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	18,0 *0.709*	4	C
T32-SN02C05-22X1.5-63R	10139735	MF22X1.5	1,5	4,16 *0.164*	24,0 *0.945*	78 *3.071*	120,84 *4.757*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	20,5 *0.807*	4	C
T32-SN02C05-22X2-63R	10139736	MF22X2	2,0	5,18 *0.204*	27,0 *1.063*	93 *3.661*	134,82 *5.308*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	20,0 *0.787*	4	C
T32-SN02C05-24X1.5-63R	10139737	MF24X1.5	1,5	3,88 *0.153*	27,0 *1.063*	93 *3.661*	136,12 *5.359*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,5 *0.886*	4	C
T32-SN02C05-24X2-63R	10139738	MF24X2	2,0	4,89 *0.193*	27,0 *1.063*	93 *3.661*	135,11 *5.319*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,0 *0.866*	4	C
T32-SN02C05-27X1.5-63R	10139739	MF27X1.5	1,5	4,38 *0.172*	27,0 *1.063*	77 *3.031*	135,62 *5.339*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	25,5 *1.004*	4	C

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN02C05-27X2-63R	10139740	MF27X2	2,0	5,39 *0.212*	27,0 *1.063*	77 *3.031*	134,61 *5.300*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	25,0 *0.984*	4	C
T32-SN02C05-30X1.5-63R	10139741	MF30X1.5	1,5	4,38 *0.172*	27,0 *1.063*	85 *3.346*	145,62 *5.733*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,5 *1.122*	4	C
T32-SN02C05-30X2-63R	10139742	MF30X2	2,0	5,39 *0.212*	27,0 *1.063*	85 *3.346*	144,61 *5.693*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,0 *1.102*	4	C

T32-SNC

Blind and through holes – G threads

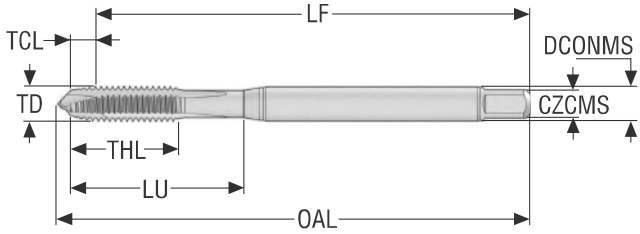


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN5156
- Thread tolerance class: NORMAL
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-SN21C09-1/8-28-11R	10139743	G1/8	9,728 *0.383*	*28.0*	2,43 *0.096*	18,0 *0.709*	67 *2.638*	87,57 *3.448*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	C
T32-SN21C09-1/4-19-11R	10139744	G1/4	13,157 *0.518*	*19.0*	3,52 *0.139*	22,0 *0.866*	71 *2.795*	96,48 *3.798*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	11,8 *0.465*	4	C
T32-SN21C09-3/8-19-11R	10139745	G3/8	16,662 *0.656*	*19.0*	3,72 *0.146*	22,0 *0.866*	58 *2.283*	96,28 *3.791*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,25 *0.600*	4	C
T32-SN21C09-1/2-14-11R	10139746	G1/2	20,955 *0.825*	*14.0*	5,02 *0.198*	25,0 *0.984*	80 *3.150*	119,98 *4.724*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,0 *0.748*	4	C
T32-SN21C09-5/8-14-11R	10139747	G5/8	22,911 *0.902*	*14.0*	4,94 *0.194*	25,0 *0.984*	78 *3.071*	120,06 *4.727*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C
T32-SN21C09-3/4-14-11R	10139748	G3/4	26,441 *1.041*	*14.0*	5,19 *0.204*	28,0 *1.102*	77 *3.031*	134,81 *5.307*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	24,5 *0.965*	4	C
T32-SN21C09-7/8-14-11R	10139749	G7/8	30,201 *1.189*	*14.0*	5,13 *0.202*	30,0 *1.181*	85 *3.346*	144,87 *5.704*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,25 *1.112*	4	C
T32-SN21C09-1-11-11R	10139750	G1	33,249 *1.309*	*11.0*	6,03 *0.237*	32,0 *1.260*	93 *3.661*	153,97 *6.062*	160,0 *6.299*	25,0 *0.984*	25.00X20.00	30,75 *1.211*	4	C

T32-PNB-micro

Through holes – Metric coarse threads

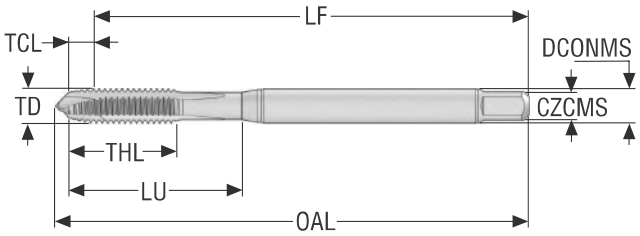


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 4H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B03-1X0.25-41R	10139427	M1	0,25	1,13 *0.044*	6,0 *0.236*	13 *0.512*	38,87 *1.530*	40,9 *1.610*	2,5 *0.098*	2.50X2.10	0,75 *0.030*	2	B
T32-PN01B03-1.1X0.25-41R	10139428	M1.1	0,25	1,13 *0.044*	6,0 *0.236*	13 *0.512*	38,87 *1.530*	41,0 *1.614*	2,5 *0.098*	2.50X2.10	0,85 *0.033*	2	B
T32-PN01B03-1.2X0.25-41R	10139429	M1.2	0,25	1,13 *0.044*	6,0 *0.236*	13 *0.512*	38,87 *1.530*	41,1 *1.618*	2,5 *0.098*	2.50X2.10	0,95 *0.037*	2	B
T32-PN01B03-1.4X0.3-41R	10139430	M1.4	0,3	1,32 *0.052*	7,0 *0.276*	13 *0.512*	38,68 *1.523*	41,3 *1.626*	2,5 *0.098*	2.50X2.10	1,1 *0.043*	2	B

T32-PNB-micro

Through holes – Metric coarse threads

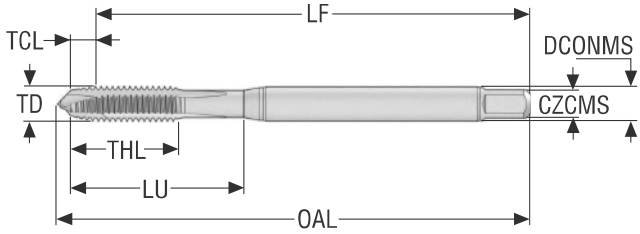


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B03-1.6X0.35-63R	10139431	M1.6	0,35	1,54 *0.061*	8,0 *0.315*	13 *0.512*	38,46 *1.514*	41,4 *1.630*	2,5 *0.098*	2.50X2.10	1,25 *0.049*	2	B
T32-PN01B03-1.7X0.35-63R	10139432	M1.7	0,35	1,54 *0.061*	8,0 *0.315*	13 *0.512*	38,46 *1.514*	41,5 *1.634*	2,5 *0.098*	2.50X2.10	1,35 *0.053*	2	B
T32-PN01B03-1.8X0.35-63R	10139433	M1.8	0,35	1,54 *0.061*	8,0 *0.315*	13 *0.512*	38,46 *1.514*	41,6 *1.638*	2,5 *0.098*	2.50X2.10	1,45 *0.057*	2	B
T32-PN01B03-2X0.4-63R	10139434	M2	0,4	1,89 *0.074*	10,0 *0.394*	13 *0.512*	43,11 *1.697*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,6 *0.063*	2	B
T32-PN01B03-2.2X0.45-63R	10139435	M2.2	0,45	2,07 *0.081*	10,0 *0.394*	13 *0.512*	42,93 *1.690*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,75 *0.069*	2	B
T32-PN01B03-2.3X0.4-63R	10139436	M2.3	0,4	1,89 *0.074*	10,0 *0.394*	13 *0.512*	43,11 *1.697*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,9 *0.075*	2	B
T32-PN01B03-2.5X0.45-63R	10139437	M2.5	0,45	2,07 *0.081*	9,0 *0.354*	14 *0.551*	47,93 *1.887*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,05 *0.081*	2	B
T32-PN01B03-2.6X0.45-63R	10139438	M2.6	0,45	2,07 *0.081*	9,0 *0.354*	14 *0.551*	47,93 *1.887*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,15 *0.085*	2	B

T32-PNB

Through holes – Metric coarse threads

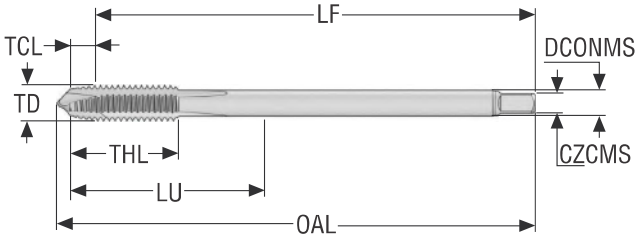


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B03-3X0.5-63R	10139439	M3	0,5	2,28 *0.090*	10,0 *0.394*	18 *0.709*	53,72 *2.115*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	B
T32-PN01B03-3.5X0.6-63R	10139440	M3.5	0,6	2,65 *0.104*	12,0 *0.472*	20 *0.787*	53,35 *2.100*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,9 *0.114*	3	B
T32-PN01B03-4X0.7-63R	10139441	M4	0,7	3,33 *0.131*	12,0 *0.472*	21 *0.827*	59,67 *2.349*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	B
T32-PN01B03-4.5X0.75-63R	10139442	M4.5	0,75	3,33 *0.131*	14,0 *0.551*	25 *0.984*	66,67 *2.625*	71,8 *2.827*	6,0 *0.236*	6.00X4.90	3,8 *0.150*	3	B
T32-PN01B03-5X0.8-63R	10139443	M5	0,8	3,68 *0.145*	14,0 *0.551*	25 *0.984*	66,32 *2.611*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	B
T32-PN01B03-6X1-63R	10139444	M6	1,0	4,41 *0.174*	18,0 *0.709*	30 *1.181*	75,59 *2.976*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	B
T32-PN01B03-7X1-63R	10139445	M7	1,0	4,41 *0.174*	18,0 *0.709*	30 *1.181*	75,59 *2.976*	82,9 *3.264*	7,0 *0.276*	7.00X5.50	6,0 *0.236*	3	B
T32-PN01B03-8X1.25-63R	10139446	M8	1,25	5,43 *0.214*	20,0 *0.787*	35 *1.378*	84,57 *3.330*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	B
T32-PN01B03-9X1.25-63R	10139447	M9	1,25	5,7 *0.224*	20,0 *0.787*	35 *1.378*	84,3 *3.319*	91,7 *3.610*	9,0 *0.354*	9.00X7.00	7,8 *0.307*	3	B
T32-PN01B03-10X1.5-63R	10139448	M10	1,5	6,84 *0.269*	20,0 *0.787*	39 *1.535*	93,16 *3.668*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	B

T32-PNB

Through holes – Metric coarse threads

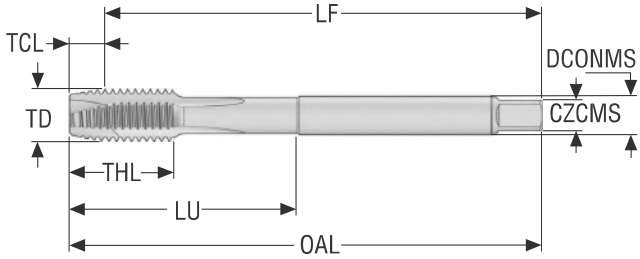


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B06-3X0.5-63R	10139482	M3	0,5	2,2 *0.087*	11,0 *0.433*	36 *1.417*	53,8 *2.118*	57,2 *2.252*	2,2 *0.087*	2.20X1.80	2,5 *0.098*	3	B
T32-PN01B06-4X0.7-63R	10139484	M4	0,7	3,3 *0.130*	12,0 *0.472*	43 *1.693*	59,7 *2.350*	64,6 *2.543*	2,8 *0.110*	2.80X2.10	3,3 *0.130*	3	B
T32-PN01B06-5X0.8-63R	10139485	M5	0,8	3,6 *0.142*	14,0 *0.551*	49 *1.929*	66,4 *2.614*	72,0 *2.835*	3,5 *0.138*	3.50X2.70	4,2 *0.165*	3	B
T32-PN01B06-6X1-63R	10139486	M6	1,0	4,4 *0.173*	18,0 *0.709*	59 *2.323*	75,6 *2.976*	82,4 *3.244*	4,5 *0.177*	4.50X3.40	5,0 *0.197*	3	B

T32-PNB

Through holes – Metric coarse threads

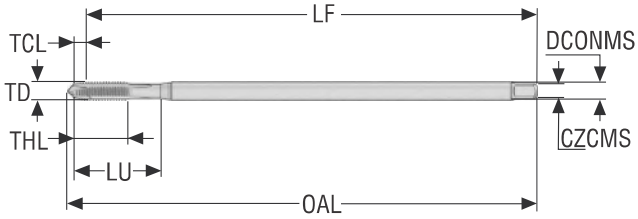


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B06-8X1.25-63R	10139488	M8	1,25	5,7 *0.224*	20,0 *0.787*	67 *2.638*	84,3 *3.319*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	6,8 *0.268*	3	B
T32-PN01B06-9X1.25-63R	10139489	M9	1,25	5,7 *0.224*	20,0 *0.787*	67 *2.638*	84,3 *3.319*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	7,8 *0.307*	3	B
T32-PN01B06-10X1.5-63R	10139490	M10	1,5	6,84 *0.269*	20,0 *0.787*	77 *3.031*	93,16 *3.668*	100,0 *3.937*	7,0 *0.276*	7.00X5.50	8,5 *0.335*	3	B
T32-PN01B06-12X1.75-63R	10139491	M12	1,75	8,01 *0.315*	24,0 *0.945*	83 *3.268*	101,99 *4.015*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	B
T32-PN01B06-14X2-63R	10139492	M14	2,0	9,14 *0.360*	25,0 *0.984*	81 *3.189*	100,86 *3.971*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	3	B
T32-PN01B06-16X2-63R	10139493	M16	2,0	9,24 *0.364*	32,0 *1.260*	68 *2.677*	100,76 *3.967*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	3	B
T32-PN01B06-18X2.5-63R	10139494	M18	2,5	11,38 *0.448*	32,0 *1.260*	81 *3.189*	113,62 *4.473*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	15,5 *0.610*	4	B
T32-PN01B06-20X2.5-63R	10139495	M20	2,5	11,58 *0.456*	32,0 *1.260*	95 *3.740*	128,42 *5.056*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	B
T32-PN01B06-22X2.5-63R	10139496	M22	2,5	11,78 *0.464*	32,0 *1.260*	93 *3.661*	128,22 *5.048*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,5 *0.768*	4	B
T32-PN01B06-24X3-63R	10139497	M24	3,0	13,68 *0.539*	38,0 *1.496*	113 *4.449*	146,32 *5.761*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	B
T32-PN01B06-27X3-63R	10139498	M27	3,0	13,88 *0.546*	38,0 *1.496*	97 *3.819*	146,12 *5.753*	160,0 *6.299*	20,0 *0.787*	20.00X16.00	24,0 *0.945*	4	B
T32-PN01B06-30X3.5-63R	10139499	M30	3,5	15,93 *0.627*	45,0 *1.772*	115 *4.528*	164,07 *6.459*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	26,5 *1.043*	4	B
T32-PN01B06-33X3.5-63R	10139500	M33	3,5	15,93 *0.627*	45,0 *1.772*	113 *4.449*	164,07 *6.459*	180,0 *7.087*	25,0 *0.984*	25.00X20.00	29,5 *1.161*	4	B
T32-PN01B06-36X4-63R	10139501	M36	4,0	17,97 *0.707*	50,0 *1.969*	131 *5.157*	182,03 *7.167*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	32,0 *1.260*	4	B
T32-PN01B06-39X4-63R	10139502	M39	4,0	17,97 *0.707*	50,0 *1.969*	102 *4.016*	182,03 *7.167*	200,0 *7.874*	32,0 *1.260*	32.00X24.00	35,0 *1.378*	4	B
T32-PN01B06-42X4.5-63R	10139503	M42	4,5	20,02 *0.788*	60,0 *2.362*	102 *4.016*	179,98 *7.086*	200,0 *7.874*	32,0 *1.260*	32.00X24.00	37,5 *1.476*	5	B
T32-PN01B06-45X4.5-63R	10139504	M45	4,5	20,02 *0.788*	60,0 *2.362*	117 *4.606*	199,98 *7.873*	220,0 *8.661*	36,0 *1.417*	36.00X29.00	40,5 *1.594*	5	B
T32-PN01B06-48X5-63R	10139505	M48	5,0	22,07 *0.869*	65,0 *2.559*	147 *5.787*	227,93 *8.974*	250,0 *9.843*	36,0 *1.417*	36.00X29.00	43,0 *1.693*	5	B
T32-PN01B06-52X5-63R	10139506	M52	5,0	22,07 *0.869*	65,0 *2.559*	120 *4.724*	227,93 *8.974*	250,0 *9.843*	40,0 *1.575*	40.00X32.00	47,0 *1.850*	5	B

T32-PNB

Through holes – Metric coarse threads

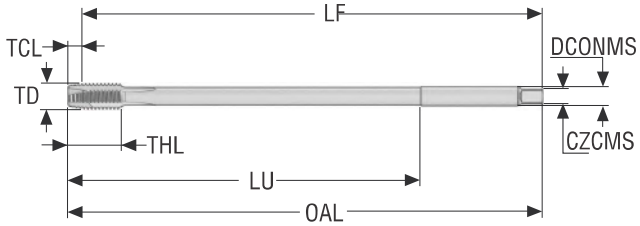


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371/EL
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B04-3X0.5-63R	10139652	M3	0,5	2,28 *0.090*	10,0 *0.394*	18 *0.709*	97,72 *3.847*	101,2 *3.984*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	B
T32-PN01B04-4X0.7-63R	10139653	M4	0,7	3,33 *0.131*	12,0 *0.472*	21 *0.827*	121,67 *4.790*	126,6 *4.984*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	B
T32-PN01B04-5X0.8-63R	10139654	M5	0,8	3,68 *0.145*	14,0 *0.551*	25 *0.984*	136,32 *5.367*	142,0 *5.591*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	B
T32-PN01B04-6X1-63R	10139655	M6	1,0	4,41 *0.174*	18,0 *0.709*	30 *1.181*	155,59 *6.126*	162,4 *6.394*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	B

T32-PNB

Through holes – Metric coarse threads

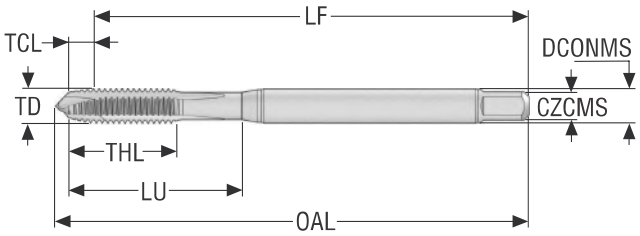


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376/EL
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B07-8X1.25-63R	10139656	M8	1,25	5,7 *0.224*	20,0 *0.787*	157 *6.181*	174,3 *6.862*	180,0 *7.087*	6,0 *0.236*	6.00X4.90	6,8 *0.268*	3	B
T32-PN01B07-10X1.5-63R	10139657	M10	1,5	6,84 *0.269*	20,0 *0.787*	177 *6.969*	193,16 *7.605*	200,0 *7.874*	7,0 *0.276*	7.00X5.50	8,5 *0.335*	3	B
T32-PN01B07-12X1.75-63R	10139658	M12	1,75	8,01 *0.315*	24,0 *0.945*	83 *3.268*	211,99 *8.346*	220,0 *8.661*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	B
T32-PN01B07-16X2-63R	10139659	M16	2,0	9,24 *0.364*	32,0 *1.260*	191 *7.520*	210,76 *8.298*	220,0 *8.661*	11,0 *0.433*	11.00X9.00	14,0 *0.551*	3	B

T32-PNB

Through holes – Metric coarse threads, 6G

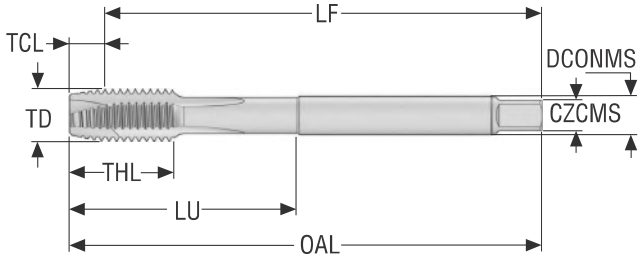


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6G
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B03-3X0.5-61R	10139474	M3	0,5	2,28 *0.090*	10,0 *0.394*	18 *0.709*	53,72 *2.115*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	B
T32-PN01B03-4X0.7-61R	10139475	M4	0,7	3,33 *0.131*	12,0 *0.472*	21 *0.827*	59,67 *2.349*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	B
T32-PN01B03-5X0.8-61R	10139476	M5	0,8	3,68 *0.145*	14,0 *0.551*	25 *0.984*	66,32 *2.611*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	B
T32-PN01B03-6X1-61R	10139477	M6	1,0	4,41 *0.174*	18,0 *0.709*	30 *1.181*	75,59 *2.976*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	B
T32-PN01B03-7X1-61R	10139478	M7	1,0	4,41 *0.174*	18,0 *0.709*	30 *1.181*	75,59 *2.976*	82,9 *3.264*	7,0 *0.276*	7.00X5.50	6,0 *0.236*	3	B
T32-PN01B03-8X1.25-61R	10139479	M8	1,25	5,43 *0.214*	20,0 *0.787*	35 *1.378*	84,57 *3.330*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	B
T32-PN01B03-9X1.25-61R	10139480	M9	1,25	5,7 *0.224*	20,0 *0.787*	35 *1.378*	84,3 *3.319*	91,7 *3.610*	9,0 *0.354*	9.00X7.00	7,8 *0.307*	3	B
T32-PN01B03-10X1.5-61R	10139481	M10	1,5	6,84 *0.269*	20,0 *0.787*	39 *1.535*	93,16 *3.668*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	B

T32-PNB

Through holes – Metric coarse threads, 6G

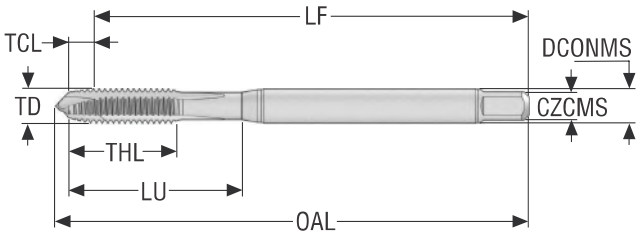


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6G
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B06-12X1.75-61R	10139564	M12	1,75	8,01 *0.315*	24,0 *0.945*	83 *3.268*	101,99 *4.015*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	B
T32-PN01B06-16X2-61R	10139565	M16	2,0	9,24 *0.364*	32,0 *1.260*	68 *2.677*	100,76 *3.967*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	3	B
T32-PN01B06-20X2.5-61R	10139566	M20	2,5	11,58 *0.456*	32,0 *1.260*	95 *3.740*	128,42 *5.056*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	B
T32-PN01B06-24X3-61R	10139567	M24	3,0	13,68 *0.539*	38,0 *1.496*	113 *4.449*	146,32 *5.761*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	B

T32-PNB

Through holes – Metric coarse threads, left hand thread

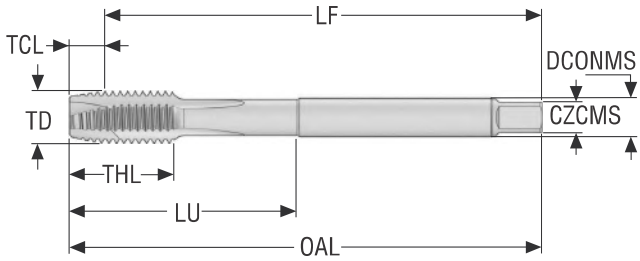


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B03-3X0.5-63L	10139466	M3	0,5	2,2 *0.087*	10,0 *0.394*	18 *0.709*	53,8 *2.118*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	B
T32-PN01B03-4X0.7-63L	10139467	M4	0,7	3,3 *0.130*	12,0 *0.472*	21 *0.827*	59,7 *2.350*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	B
T32-PN01B03-5X0.8-63L	10139468	M5	0,8	3,6 *0.142*	14,0 *0.551*	25 *0.984*	66,4 *2.614*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	B
T32-PN01B03-6X1-63L	10139469	M6	1,0	4,4 *0.173*	18,0 *0.709*	30 *1.181*	75,6 *2.976*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	B
T32-PN01B03-7X1-63L	10139470	M7	1,0	4,4 *0.173*	18,0 *0.709*	30 *1.181*	75,6 *2.976*	82,9 *3.264*	7,0 *0.276*	7.00X5.50	6,0 *0.236*	3	B
T32-PN01B03-8X1.25-63L	10139471	M8	1,25	5,4 *0.213*	20,0 *0.787*	35 *1.378*	84,6 *3.331*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	B
T32-PN01B03-9X1.25-63L	10139472	M9	1,25	5,7 *0.224*	20,0 *0.787*	35 *1.378*	84,3 *3.319*	91,7 *3.610*	9,0 *0.354*	9.00X7.00	7,8 *0.307*	3	B
T32-PN01B03-10X1.5-63L	10139473	M10	1,5	6,8 *0.268*	20,0 *0.787*	39 *1.535*	93,2 *3.669*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	B

T32-PNB

Through holes – Metric coarse threads, left hand thread

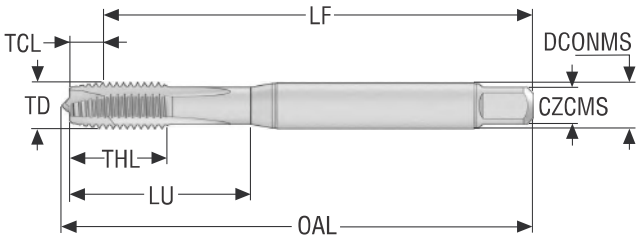


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN01B06-12X1.75-63L	10139560	M12	1,75	8,01 *0.315*	24,0 *0.945*	83 *3.268*	101,99 *4.015*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	B
T32-PN01B06-16X2-63L	10139561	M16	2,0	9,24 *0.364*	32,0 *1.260*	68 *2.677*	100,76 *3.967*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	3	B
T32-PN01B06-20X2.5-63L	10139562	M20	2,5	11,58 *0.456*	32,0 *1.260*	95 *3.740*	128,42 *5.056*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	B
T32-PN01B06-24X3-63L	10139563	M24	3,0	13,68 *0.539*	38,0 *1.496*	113 *4.449*	146,32 *5.761*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	B

T32-PNB

Through holes – MF threads

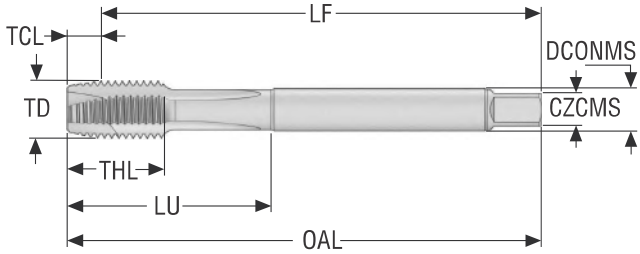


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN02B03-8X1-63R	10139449	MF8X1	1,0	4,41 *0.174*	20,0 *0.787*	35 *1.378*	85,59 *3.370*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	B
T32-PN02B03-10X1-63R	10139450	MF10X1	1,0	4,77 *0.188*	20,0 *0.787*	35 *1.378*	85,23 *3.356*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	B
T32-PN02B03-10X1.25-63R	10139451	MF10X1.25	1,25	5,8 *0.228*	20,0 *0.787*	39 *1.535*	94,2 *3.709*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,8 *0.346*	3	B

T32-PNB

Through holes – MF threads



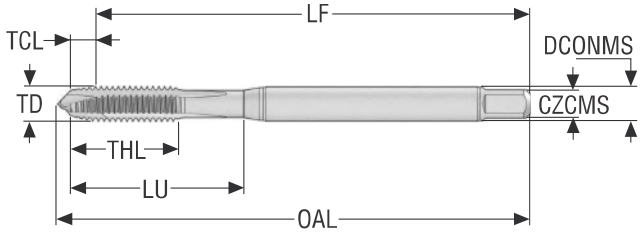
- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN374
- Thread tolerance class: 6H
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN02B05-8X1-63R	10139507	MF8X1	1,0	4,67 *0.184*	20,0 *0.787*	67 *2.638*	85,33 *3.359*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	B
T32-PN02B05-10X0.75-63R	10139508	MF10X0.75	0,75	3,73 *0.147*	18,0 *0.709*	67 *2.638*	86,27 *3.396*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,2 *0.362*	3	B
T32-PN02B05-10X1-63R	10139509	MF10X1	1,0	4,79 *0.189*	20,0 *0.787*	67 *2.638*	85,21 *3.355*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	B
T32-PN02B05-10X1.25-63R	10139510	MF10X1.25	1,25	5,8 *0.228*	20,0 *0.787*	77 *3.031*	94,2 *3.709*	100,0 *3.937*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	B
T32-PN02B05-12X1-63R	10139511	MF12X1	1,0	4,89 *0.193*	20,0 *0.787*	73 *2.874*	95,11 *3.744*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,0 *0.433*	3	B
T32-PN02B05-12X1.25-63R	10139512	MF12X1.25	1,25	5,94 *0.234*	20,0 *0.787*	73 *2.874*	94,06 *3.703*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,8 *0.425*	3	B
T32-PN02B05-12X1.5-63R	10139513	MF12X1.5	1,5	6,97 *0.274*	20,0 *0.787*	73 *2.874*	93,03 *3.663*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	B
T32-PN02B05-14X1-63R	10139514	MF14X1	1,0	4,99 *0.196*	20,0 *0.787*	71 *2.795*	95,01 *3.741*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,0 *0.512*	3	B
T32-PN02B05-14X1.25-63R	10139515	MF14X1.25	1,25	6,04 *0.238*	20,0 *0.787*	71 *2.795*	93,96 *3.699*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,8 *0.504*	3	B
T32-PN02B05-14X1.5-63R	10139516	MF14X1.5	1,5	7,07 *0.278*	20,0 *0.787*	71 *2.795*	92,93 *3.659*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	3	B
T32-PN02B05-16X1-63R	10139517	MF16X1	1,0	5,09 *0.200*	20,0 *0.787*	58 *2.283*	94,91 *3.737*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,0 *0.591*	3	B
T32-PN02B05-16X1.5-63R	10139518	MF16X1.5	1,5	7,17 *0.282*	20,0 *0.787*	58 *2.283*	92,83 *3.655*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	3	B
T32-PN02B05-18X1.5-63R	10139519	MF18X1.5	1,5	7,27 *0.286*	24,0 *0.945*	66 *2.598*	102,73 *4.044*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	B
T32-PN02B05-18X2-63R	10139520	MF18X2	2,0	9,34 *0.368*	27,0 *1.063*	81 *3.189*	115,66 *4.554*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,0 *0.630*	4	B
T32-PN02B05-20X1.5-63R	10139521	MF20X1.5	1,5	7,47 *0.294*	24,0 *0.945*	80 *3.150*	117,53 *4.627*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	18,5 *0.728*	4	B
T32-PN02B05-20X2-63R	10139522	MF20X2	2,0	9,54 *0.376*	27,0 *1.063*	95 *3.740*	130,46 *5.136*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	18,0 *0.709*	4	B
T32-PN02B05-22X1.5-63R	10139523	MF22X1.5	1,5	7,67 *0.302*	24,0 *0.945*	78 *3.071*	117,33 *4.619*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	20,5 *0.807*	4	B
T32-PN02B05-22X2-63R	10139524	MF22X2	2,0	9,74 *0.383*	27,0 *1.063*	93 *3.661*	130,26 *5.128*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	20,0 *0.787*	4	B
T32-PN02B05-24X1.5-63R	10139525	MF24X1.5	1,5	7,5 *0.295*	27,0 *1.063*	93 *3.661*	132,5 *5.217*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,5 *0.886*	4	B
T32-PN02B05-24X2-63R	10139526	MF24X2	2,0	9,57 *0.377*	27,0 *1.063*	93 *3.661*	130,43 *5.135*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,0 *0.866*	4	B
T32-PN02B05-27X1.5-63R	10139527	MF27X1.5	1,5	7,7 *0.303*	27,0 *1.063*	77 *3.031*	132,3 *5.209*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	25,5 *1.004*	4	B

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN02B05-27X2-63R	10139528	MF27X2	2,0	9,77 *0.385*	27,0 *1.063*	77 *3.031*	130,23 *5.127*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	25,0 *0.984*	4	B
T32-PN02B05-30X1.5-63R	10139529	MF30X1.5	1,5	7,7 *0.303*	27,0 *1.063*	85 *3.346*	142,3 *5.602*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,5 *1.122*	4	B
T32-PN02B05-30X2-63R	10139530	MF30X2	2,0	9,77 *0.385*	27,0 *1.063*	85 *3.346*	140,23 *5.521*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,0 *1.102*	4	B

T32-PNB

Through holes – UNC threads

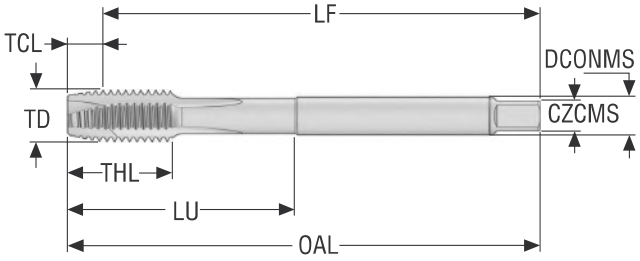


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 2B
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN08B03-4-40-21R	10139452	UNC4-40	2,845 *0.112*	*40.0*	2,81 *0.111*	10,0 *0.394*	18 *0.709*	53,19 *2.094*	56,0 *2.205*	3,5 *0.138*	3.50X2.70	2.35 *0.093*	3	B
T32-PN08B03-5-40-21R	10139453	UNC5-40	3,175 *0.125*	*40.0*	2,92 *0.115*	10,0 *0.394*	18 *0.709*	53,08 *2.090*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2.65 *0.104*	3	B
T32-PN08B03-6-32-21R	10139454	UNC6-32	3,505 *0.138*	*32.0*	3,71 *0.146*	12,0 *0.472*	20 *0.787*	52,29 *2.059*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2.85 *0.112*	3	B
T32-PN08B03-8-32-21R	10139455	UNC8-32	4,166 *0.164*	*32.0*	3,59 *0.141*	12,0 *0.472*	21 *0.827*	59,41 *2.339*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3.5 *0.138*	3	B
T32-PN08B03-10-24-21R	10139456	UNC10-24	4,826 *0.190*	*24.0*	4,82 *0.190*	14,0 *0.551*	25 *0.984*	65,18 *2.566*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	3.9 *0.154*	3	B
T32-PN08B03-12-24-21R	10139457	UNC12-24	5,486 *0.216*	*24.0*	4,69 *0.185*	18,0 *0.709*	30 *1.181*	75,31 *2.965*	82,2 *3.236*	6,0 *0.236*	6.00X4.90	4.5 *0.177*	3	B
T32-PN08B03-1/4-20-21R	10139458	UNC1/4-20	6,35 *0.250*	*20.0*	5,6 *0.220*	18,0 *0.709*	32 *1.260*	74,4 *2.929*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5.1 *0.201*	3	B
T32-PN08B03-5/16-18-21R	10139459	UNC5/16-18	7,937 *0.312*	*18.0*	6,26 *0.246*	20,0 *0.787*	35 *1.378*	83,74 *3.297*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6.6 *0.260*	3	B
T32-PN08B03-3/8-16-21R	10139460	UNC3/8-16	9,525 *0.375*	*16.0*	7,28 *0.287*	20,0 *0.787*	39 *1.535*	92,72 *3.650*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8.0 *0.315*	3	B

T32-PNB

Through holes – UNC threads

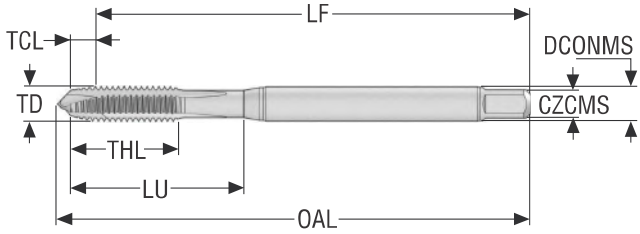


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 2B
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN08B06-7/16-14-21R	10139531	UNC7/16-14	11,112 *0.437*	*14.0*	8,27 *0.326*	22,0 *0.866*	76 *2.992*	91,73 *3.611*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,3 *0.366*	3	B
T32-PN08B06-1/2-13-21R	10139540	UNC1/2-13	12,7 *0.500*	*13.0*	9,01 *0.355*	24,0 *0.945*	83 *3.268*	100,99 *3.976*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,7 *0.421*	3	B
T32-PN08B06-9/16-12-21R	10139533	UNC9/16-12	14,287 *0.562*	*12.0*	9,76 *0.384*	25,0 *0.984*	81 *3.189*	100,24 *3.946*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,3 *0.484*	3	B
T32-PN08B06-5/8-11-21R	10139534	UNC5/8-11	15,875 *0.625*	*11.0*	10,51 *0.414*	32,0 *1.260*	68 *2.677*	99,49 *3.917*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	13,5 *0.531*	3	B
T32-PN08B06-3/4-10-21R	10139535	UNC3/4-10	19,05 *0.750*	*10.0*	11,55 *0.455*	32,0 *1.260*	81 *3.189*	113,45 *4.467*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	B
T32-PN08B06-7/8-9-21R	10139536	UNC7/8-9	22,225 *0.875*	*9.0*	13,04 *0.513*	32,0 *1.260*	93 *3.661*	126,96 *4.998*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,5 *0.768*	4	B
T32-PN08B06-1-8-21R	10139537	UNC1-8	25,4 *1.000*	*8.0*	14,86 *0.585*	38,0 *1.496*	97 *3.819*	145,14 *5.714*	160,0 *6.299*	20,0 *0.787*	20.00X16.00	22,25 *0.876*	4	B
T32-PN08B06-1_1/8-7-21R	10139756	UNC1 1/8-7	28,575 *1.125*	*7.0*	16,48 *0.649*	45,0 *1.772*	115 *4.528*	163,52 *6.438*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	25,0 *0.984*	4	B
T32-PN08B06-1_1/4-7-21R	10139538	UNC1 1/4-7	31,75 *1.250*	*7.0*	16,74 *0.659*	45,0 *1.772*	115 *4.528*	163,26 *6.428*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	28,0 *1.102*	4	B
T32-PN08B06-1_3/8-6-21R	10139532	UNC1 3/8-6	34,925 *1.375*	*6.0*	19,04 *0.750*	50,0 *1.969*	131 *5.157*	180,96 *7.124*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	30,75 *1.211*	4	B
T32-PN08B06-1_1/2-6-21R	10139539	UNC1 1/2-6	38,1 *1.500*	*6.0*	19,3 *0.760*	55,0 *2.165*	131 *5.157*	180,7 *7.114*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	34,0 *1.339*	4	B

T32-PNB

Through holes – UNF threads

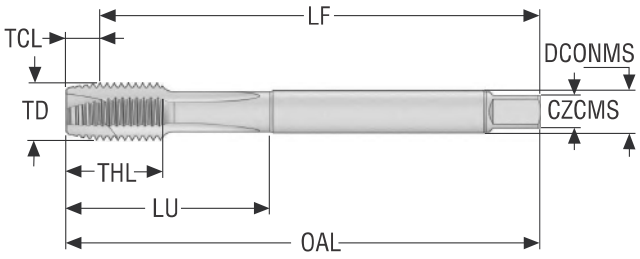


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 2B
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN09B03-10-32-21R	10139461	UNF10-32	4,826 *0.190*	*32.0*	3,8 *0.150*	14,0 *0.551*	25 *0.984*	66,2 *2.606*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,1 *0.161*	3	B
T32-PN09B03-12-28-21R	10139462	UNF12-28	5,486 *0.216*	*28.0*	4,01 *0.158*	18,0 *0.709*	30 *1.181*	75,99 *2.992*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	4,6 *0.181*	3	B
T32-PN09B03-1/4-28-21R	10139463	UNF1/4-28	6,35 *0.250*	*28.0*	4,24 *0.167*	18,0 *0.709*	30 *1.181*	75,76 *2.983*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,5 *0.217*	3	B
T32-PN09B03-5/16-24-21R	10139464	UNF5/16-24	7,937 *0.312*	*24.0*	4,89 *0.193*	20,0 *0.787*	35 *1.378*	85,11 *3.351*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,9 *0.272*	3	B
T32-PN09B03-3/8-24-21R	10139465	UNF3/8-24	9,525 *0.375*	*24.0*	5,22 *0.206*	20,0 *0.787*	35 *1.378*	84,78 *3.338*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	B

T32-PNB

Through holes – UNF threads

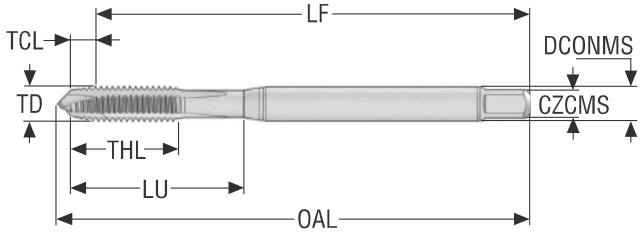


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN374
- Thread tolerance class: 2B
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN09B05-7/16-20-21R	10139542	UNF7/16-20	11,112 *0.437*	*20.0*	5,88 *0.231*	20,0 *0.787*	76 *2.992*	94,12 *3.706*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,9 *0.390*	3	B
T32-PN09B05-1/2-20-21R	10139551	UNF1/2-20	12,7 *0.500*	*20.0*	6,28 *0.247*	20,0 *0.787*	73 *2.874*	93,72 *3.690*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,5 *0.453*	3	B
T32-PN09B05-9/16-18-21R	10139544	UNF9/16-18	14,287 *0.562*	*18.0*	6,69 *0.263*	20,0 *0.787*	71 *2.795*	93,31 *3.674*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,0 *0.512*	3	B
T32-PN09B05-5/8-18-21R	10139545	UNF5/8-18	15,875 *0.625*	*18.0*	6,76 *0.266*	20,0 *0.787*	58 *2.283*	93,24 *3.671*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	3	B
T32-PN09B05-3/4-16-21R	10139546	UNF3/4-16	19,05 *0.750*	*16.0*	7,81 *0.307*	24,0 *0.945*	66 *2.598*	102,19 *4.023*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	17,5 *0.689*	4	B
T32-PN09B05-7/8-14-21R	10139547	UNF7/8-14	22,225 *0.875*	*14.0*	8,96 *0.353*	24,0 *0.945*	78 *3.071*	116,04 *4.569*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	20,5 *0.807*	4	B
T32-PN09B05-1-12-21R	10139548	UNF1-12	25,4 *1.000*	*12.0*	10,44 *0.411*	27,0 *1.063*	93 *3.661*	129,56 *5.101*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	23,3 *0.917*	4	B
T32-PN09B05-1_1/8-12-21R	10139757	UNF1 1/8-12	28,575 *1.125*	*12.0*	10,37 *0.408*	27,0 *1.063*	85 *3.346*	139,63 *5.497*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	26,5 *1.043*	4	B
T32-PN09B05-1_1/4-12-21R	10139549	UNF1 1/4-12	31,75 *1.250*	*12.0*	10,29 *0.405*	27,0 *1.063*	85 *3.346*	139,71 *5.500*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	29,5 *1.161*	4	B
T32-PN09B05-1_3/8-12-21R	10139543	UNF1 3/8-12	34,925 *1.375*	*12.0*	10,55 *0.415*	30,0 *1.181*	101 *3.976*	159,45 *6.278*	170,0 *6.693*	28,0 *1.102*	28.00X22.00	32,8 *1.291*	4	B
T32-PN09B05-1_1/2-12-21R	10139550	UNF1 1/2-12	38,1 *1.500*	*12.0*	10,48 *0.413*	30,0 *1.181*	101 *3.976*	159,52 *6.280*	170,0 *6.693*	28,0 *1.102*	28.00X22.00	36,0 *1.417*	4	B

T32-PNB

Through holes – G threads

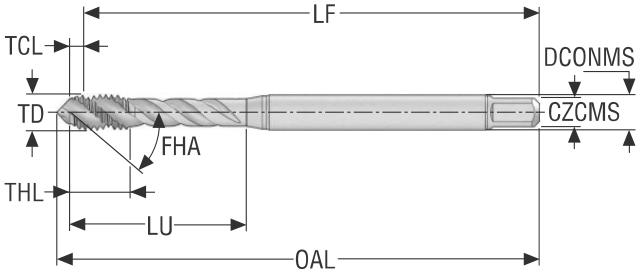


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN5156
- Thread tolerance class: NORMAL
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-PN21B09-1/8-28-11R	10139552	G1/8	9,728 *0.383*	*28.0*	4,76 *0.187*	18,0 *0.709*	67 *2.638*	85,24 *3.356*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	B
T32-PN21B09-1/4-19-11R	10139553	G1/4	13,157 *0.518*	*19.0*	6,77 *0.267*	22,0 *0.866*	71 *2.795*	93,23 *3.670*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	11,8 *0.465*	3	B
T32-PN21B09-3/8-19-11R	10139554	G3/8	16,662 *0.656*	*19.0*	6,89 *0.271*	22,0 *0.866*	58 *2.283*	93,11 *3.666*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,25 *0.600*	4	B
T32-PN21B09-1/2-14-11R	10139555	G1/2	20,955 *0.825*	*14.0*	9,22 *0.363*	25,0 *0.984*	80 *3.150*	115,78 *4.558*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,0 *0.748*	4	B
T32-PN21B09-5/8-14-11R	10139556	G5/8	22,911 *0.902*	*14.0*	9,4 *0.370*	25,0 *0.984*	78 *3.071*	115,6 *4.551*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	B
T32-PN21B09-3/4-14-11R	10139557	G3/4	26,441 *1.041*	*14.0*	9,36 *0.369*	28,0 *1.102*	77 *3.031*	130,64 *5.143*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	24,5 *0.965*	4	B
T32-PN21B09-7/8-14-11R	10139558	G7/8	30,201 *1.189*	*14.0*	9,03 *0.356*	30,0 *1.181*	85 *3.346*	140,97 *5.550*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,25 *1.112*	4	B
T32-PN21B09-1-11-11R	10139559	G1	33,249 *1.309*	*11.0*	11,49 *0.452*	32,0 *1.260*	93 *3.661*	148,51 *5.847*	160,0 *6.299*	25,0 *0.984*	25.00X20.00	30,75 *1.211*	4	B

T32-R40NC-micro

Blind holes – Metric coarse threads

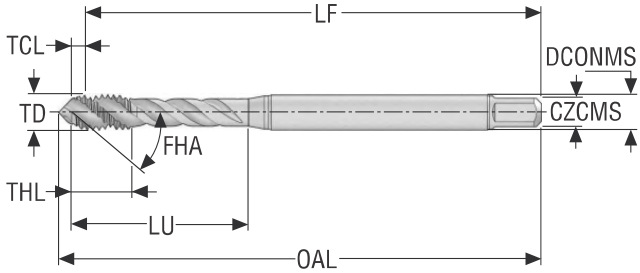


- Substrate: HSS-PM
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 4H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C03-1X0.25-41R	10139129	M1	0,25	0,59 *0.023*	6,0 *0.236*	13 *0.512*	39,41 *1.552*	40,9 *1.610*	2,5 *0.098*	2.50X2.10	0,75 *0.030*	2	C
T32-R40N01C03-1.1X0.25-41R	10139130	M1.1	0,25	0,59 *0.023*	6,0 *0.236*	13 *0.512*	39,41 *1.552*	41,0 *1.614*	2,5 *0.098*	2.50X2.10	0,85 *0.033*	2	C
T32-R40N01C03-1.2X0.25-41R	10139131	M1.2	0,25	0,59 *0.023*	6,0 *0.236*	13 *0.512*	39,41 *1.552*	41,1 *1.618*	2,5 *0.098*	2.50X2.10	0,95 *0.037*	2	C
T32-R40N01C03-1.4X0.3-41R	10139132	M1.4	0,3	0,69 *0.027*	8,0 *0.315*	13 *0.512*	39,31 *1.548*	41,3 *1.626*	2,5 *0.098*	2.50X2.10	1,1 *0.043*	2	C

T32-R40NC-micro

Blind holes – Metric coarse threads

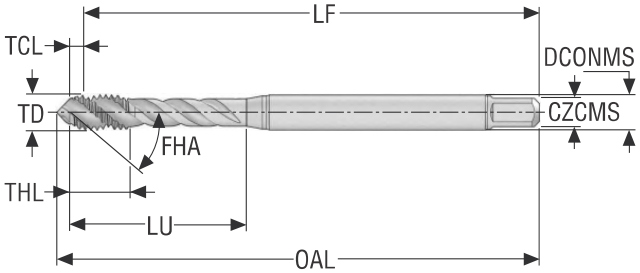


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C03-1.6X0.35-63R	10139133	M1.6	0,35	0,8 *0.031*	8,0 *0.315*	13 *0.512*	39,2 *1.543*	41,4 *1.630*	2,5 *0.098*	2.50X2.10	1,25 *0.049*	2	C
T32-R40N01C03-1.7X0.35-63R	10139134	M1.7	0,35	0,8 *0.031*	8,0 *0.315*	13 *0.512*	39,2 *1.543*	41,5 *1.634*	2,5 *0.098*	2.50X2.10	1,35 *0.053*	2	C
T32-R40N01C03-1.8X0.35-63R	10139135	M1.8	0,35	0,8 *0.031*	8,0 *0.315*	13 *0.512*	39,2 *1.543*	41,6 *1.638*	2,5 *0.098*	2.50X2.10	1,45 *0.057*	2	C
T32-R40N01C03-2X0.4-63R	10139136	M2	0,4	1,03 *0.041*	10,0 *0.394*	13 *0.512*	43,974 *1.731*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,6 *0.063*	2	C
T32-R40N01C03-2.2X0.45-63R	10139137	M2.2	0,45	1,15 *0.045*	10,0 *0.394*	13 *0.512*	43,847 *1.726*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,75 *0.069*	2	C
T32-R40N01C03-2.3X0.4-63R	10139138	M2.3	0,4	1,05 *0.041*	10,0 *0.394*	13 *0.512*	43,948 *1.730*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,9 *0.075*	2	C
T32-R40N01C03-2.5X0.45-63R	10139139	M2.5	0,45	1,06 *0.042*	5,0 *0.197*	14 *0.551*	48,94 *1.927*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,05 *0.081*	2	C
T32-R40N01C03-2.6X0.45-63R	10139140	M2.6	0,45	1,15 *0.045*	5,0 *0.197*	14 *0.551*	48,847 *1.923*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,15 *0.085*	2	C

T32-R40NC

Blind holes – Metric coarse threads

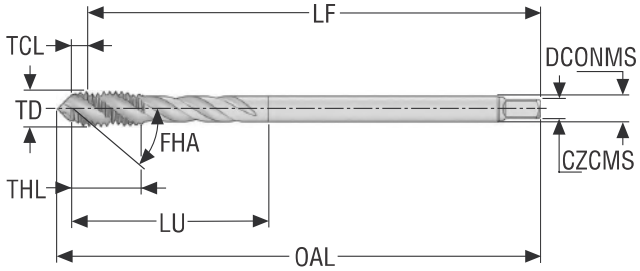


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C03-3X0.5-63R	10139141	M3	0,5	1,2 *0.047*	5,0 *0.197*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	C
T32-R40N01C03-3.5X0.6-63R	10139142	M3.5	0,6	1,36 *0.054*	6,0 *0.236*	20 *0.787*	54,64 *2.151*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,9 *0.114*	3	C
T32-R40N01C03-4X0.7-63R	10139143	M4	0,7	1,54 *0.061*	7,0 *0.276*	21 *0.827*	61,46 *2.420*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	C
T32-R40N01C03-5X0.8-63R	10139144	M5	0,8	1,9 *0.075*	8,0 *0.315*	25 *0.984*	68,1 *2.681*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T32-R40N01C03-6X1-63R	10139145	M6	1,0	2,28 *0.090*	10,0 *0.394*	30 *1.181*	77,72 *3.060*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C
T32-R40N01C03-7X1-63R	10139146	M7	1,0	2,28 *0.090*	10,0 *0.394*	30 *1.181*	77,72 *3.060*	82,9 *3.264*	7,0 *0.276*	7.00X5.50	6,0 *0.236*	3	C
T32-R40N01C03-8X1.25-63R	10139147	M8	1,25	3,11 *0.122*	13,0 *0.512*	35 *1.378*	86,89 *3.421*	91,7 *3.610*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	C
T32-R40N01C03-9X1.25-63R	10139148	M9	1,25	3,11 *0.122*	13,0 *0.512*	35 *1.378*	86,89 *3.421*	91,7 *3.610*	9,0 *0.354*	9.00X7.00	7,8 *0.307*	3	C
T32-R40N01C03-10X1.5-63R	10139149	M10	1,5	3,76 *0.148*	15,0 *0.591*	39 *1.535*	96,24 *3.789*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T32-R40NC

Blind holes – Metric coarse threads



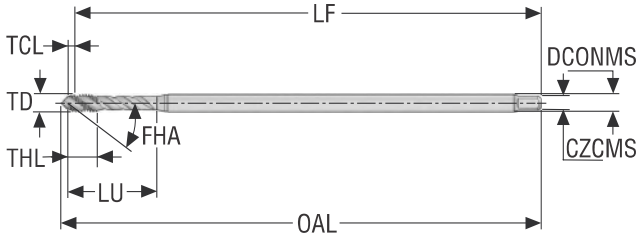
- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C06-3X0.5-63R	10139568	M3	0,5	1,17 *0.046*	5,0 *0.197*	36 *1.417*	54,83 *2.159*	57,2 *2.252*	2,2 *0.087*	2.20X1.80	2,5 *0.098*	3	C
T32-R40N01C06-4X0.7-63R	10139570	M4	0,7	1,72 *0.068*	8,0 *0.315*	43 *1.693*	61,28 *2.413*	64,6 *2.543*	2,8 *0.110*	2.80X2.10	3,3 *0.130*	3	C
T32-R40N01C06-5X0.8-63R	10139571	M5	0,8	1,9 *0.075*	10,0 *0.394*	49 *1.929*	68,1 *2.681*	72,0 *2.835*	3,5 *0.138*	3.50X2.70	4,2 *0.165*	3	C
T32-R40N01C06-6X1-63R	10139572	M6	1,0	2,28 *0.090*	12,0 *0.472*	59 *2.323*	77,72 *3.060*	82,4 *3.244*	4,5 *0.177*	4.50X3.40	5,0 *0.197*	3	C
T32-R40N01C06-8X1.25-63R	10139574	M8	1,25	3,11 *0.122*	15,0 *0.591*	67 *2.638*	86,89 *3.421*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	6,8 *0.268*	3	C
T32-R40N01C06-9X1.25-63R	10139575	M9	1,25	3,21 *0.126*	15,0 *0.591*	67 *2.638*	86,79 *3.417*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	7,8 *0.307*	3	C
T32-R40N01C06-10X1.5-63R	10139576	M10	1,5	3,76 *0.148*	17,0 *0.669*	77 *3.031*	96,24 *3.789*	100,0 *3.937*	7,0 *0.276*	7.00X5.50	8,5 *0.335*	3	C
T32-R40N01C06-12X1.75-63R	10139577	M12	1,75	4,41 *0.174*	18,0 *0.709*	83 *3.268*	105,59 *4.157*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T32-R40N01C06-14X2-63R	10139578	M14	2,0	5,07 *0.200*	20,0 *0.787*	81 *3.189*	104,93 *4.131*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	4	C
T32-R40N01C06-16X2-63R	10139579	M16	2,0	5,15 *0.203*	20,0 *0.787*	68 *2.677*	104,85 *4.128*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	C
T32-R40N01C06-18X2.5-63R	10139580	M18	2,5	6,31 *0.248*	25,0 *0.984*	81 *3.189*	118,69 *4.673*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	15,5 *0.610*	4	C
T32-R40N01C06-20X2.5-63R	10139581	M20	2,5	6,51 *0.256*	25,0 *0.984*	95 *3.740*	133,49 *5.256*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	C
T32-R40N01C06-22X2.5-63R	10139582	M22	2,5	6,51 *0.256*	25,0 *0.984*	93 *3.661*	133,49 *5.256*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,5 *0.768*	4	C
T32-R40N01C06-24X3-63R	10139583	M24	3,0	7,81 *0.307*	30,0 *1.181*	113 *4.449*	152,19 *5.992*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C
T32-R40N01C06-27X3-63R	10139584	M27	3,0	7,81 *0.307*	30,0 *1.181*	97 *3.819*	152,19 *5.992*	160,0 *6.299*	20,0 *0.787*	20.00X16.00	24,0 *0.945*	4	C
T32-R40N01C06-30X3.5-63R	10139585	M30	3,5	8,88 *0.350*	35,0 *1.378*	115 *4.528*	171,12 *6.737*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	26,5 *1.043*	4	C
T32-R40N01C06-33X3.5-63R	10139586	M33	3,5	8,88 *0.350*	35,0 *1.378*	113 *4.449*	171,12 *6.737*	180,0 *7.087*	25,0 *0.984*	25.00X20.00	29,5 *1.161*	4	C
T32-R40N01C06-36X4-63R	10139587	M36	4,0	9,94 *0.391*	40,0 *1.575*	131 *5.157*	190,06 *7.483*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	32,0 *1.260*	4	C
T32-R40N01C06-39X4-63R	10139588	M39	4,0	9,94 *0.391*	40,0 *1.575*	102 *4.016*	190,06 *7.483*	200,0 *7.874*	32,0 *1.260*	32.00X24.00	35,0 *1.378*	4	C
T32-R40N01C06-42X4.5-63R	10139589	M42	4,5	11,01 *0.433*	45,0 *1.772*	102 *4.016*	188,99 *7.441*	200,0 *7.874*	32,0 *1.260*	32.00X24.00	37,5 *1.476*	5	C

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C06-45X4.5-63R	10139590	M45	4,5	11,01 *0.433*	45,0 *1.772*	117 *4.606*	208,99 *8.228*	220,0 *8.661*	36,0 *1.417*	36.00X29.00	40,5 *1.594*	5	C
T32-R40N01C06-48X5-63R	10139591	M48	5,0	12,08 *0.476*	50,0 *1.969*	147 *5.787*	237,92 *9.367*	250,0 *9.843*	36,0 *1.417*	36.00X29.00	43,0 *1.693*	5	C
T32-R40N01C06-52X5-63R	10139592	M52	5,0	12,08 *0.476*	50,0 *1.969*	120 *4.724*	237,92 *9.367*	250,0 *9.843*	40,0 *1.575*	40.00X32.00	47,0 *1.850*	5	C

T32-R40NC

Blind holes – Metric coarse threads

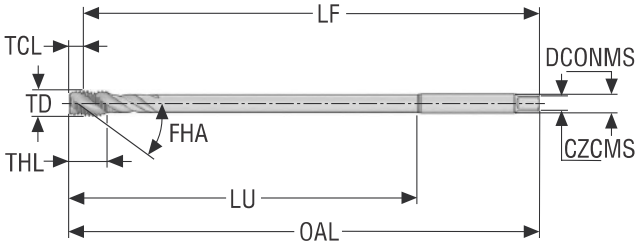


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371/EL
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C04-3X0.5-63R	10139179	M3	0,5	1,17 *0.046*	5,0 *0.197*	18 *0.709*	98,83 *3.891*	101,2 *3.984*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	C
T32-R40N01C04-4X0.7-63R	10139180	M4	0,7	1,45 *0.057*	7,0 *0.276*	21 *0.827*	123,55 *4.864*	126,6 *4.984*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	C
T32-R40N01C04-5X0.8-63R	10139181	M5	0,8	1,9 *0.075*	8,0 *0.315*	25 *0.984*	138,1 *5.437*	142,0 *5.591*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T32-R40N01C04-6X1-63R	10139182	M6	1,0	2,28 *0.090*	10,0 *0.394*	30 *1.181*	157,72 *6.209*	162,4 *6.394*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C

T32-R40NC

Blind holes – Metric coarse threads

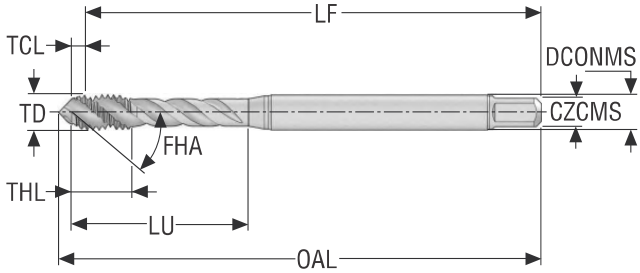


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376/EL
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C07-8X1.25-63R	10139183	M8	1,25	3,11 *0.122*	15,0 *0.591*	157 *6.181*	176,89 *6.964*	180,0 *7.087*	6,0 *0.236*	6.00X4.90	6,8 *0.268*	3	C
T32-R40N01C07-10X1.5-63R	10139185	M10	1,5	3,76 *0.148*	17,0 *0.669*	177 *6.969*	196,24 *7.726*	200,0 *7.874*	7,0 *0.276*	7.00X5.50	8,5 *0.335*	3	C
T32-R40N01C07-12X1.75-63R	10139186	M12	1,75	4,41 *0.174*	18,0 *0.709*	193 *7.598*	215,59 *8.488*	220,0 *8.661*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T32-R40N01C07-16X2-63R	10139187	M16	2,0	5,21 *0.205*	20,0 *0.787*	178 *7.008*	214,79 *8.456*	220,0 *8.661*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	C

T32-R40NC

Blind holes – Metric coarse threads, 6G

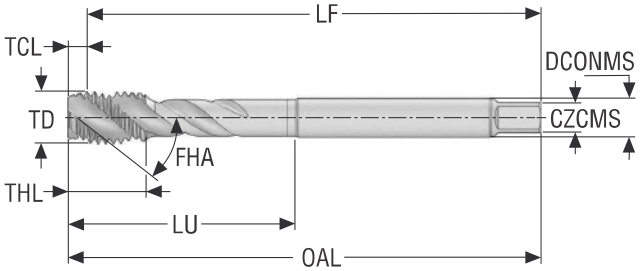


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6G
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C03-3X0.5-61R	10139173	M3	0,5	1,2 *0.047*	5,0 *0.197*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	C
T32-R40N01C03-4X0.7-61R	10139174	M4	0,7	1,54 *0.061*	7,0 *0.276*	21 *0.827*	61,46 *2.420*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	C
T32-R40N01C03-5X0.8-61R	10139175	M5	0,8	1,9 *0.075*	8,0 *0.315*	25 *0.984*	68,1 *2.681*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T32-R40N01C03-6X1-61R	10139176	M6	1,0	2,28 *0.090*	10,0 *0.394*	30 *1.181*	77,72 *3.060*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C
T32-R40N01C03-8X1.25-61R	10139177	M8	1,25	3,11 *0.122*	13,0 *0.512*	35 *1.378*	86,89 *3.421*	91,7 *3.610*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	C
T32-R40N01C03-10X1.5-61R	10139178	M10	1,5	3,76 *0.148*	15,0 *0.591*	39 *1.535*	96,24 *3.789*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T32-R40NC

Blind holes – Metric coarse threads, 6G

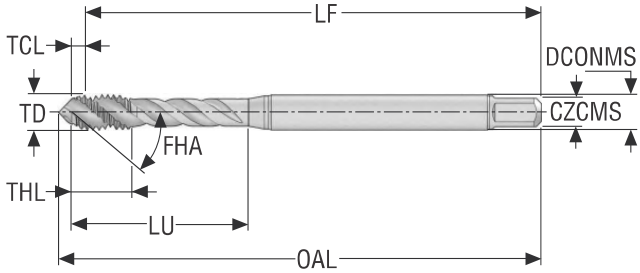


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6G
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N01C06-12X1.75-61R	10139649	M12	1,75	4,41 *0.174*	18,0 *0.709*	83 *3.268*	105,59 *4.157*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T32-R40N01C06-16X2-61R	10139650	M16	2,0	5,15 *0.203*	20,0 *0.787*	81 *3.189*	104,85 *4.128*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	14,0 *0.551*	4	C
T32-R40N01C06-20X2.5-61R	10139651	M20	2,5	6,51 *0.256*	25,0 *0.984*	95 *3.740*	133,49 *5.256*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	C

T32-R40NC

Blind holes – Metric coarse threads, left hand thread

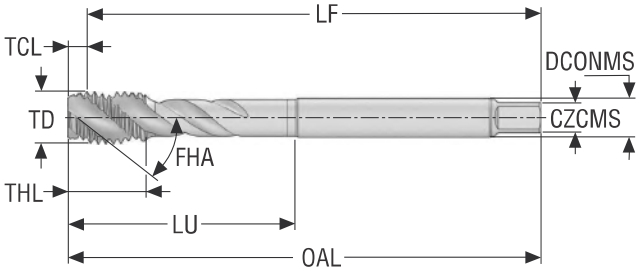


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-L40N01C03-3X0.5-63L	10139167	M3	0,5	1,2 *0.047*	5,0 *0.197*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	C
T32-L40N01C03-4X0.7-63L	10139168	M4	0,7	1,54 *0.061*	7,0 *0.276*	21 *0.827*	61,46 *2.420*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	C
T32-L40N01C03-5X0.8-63L	10139169	M5	0,8	1,9 *0.075*	8,0 *0.315*	25 *0.984*	68,1 *2.681*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T32-L40N01C03-6X1-63L	10139170	M6	1,0	2,28 *0.090*	10,0 *0.394*	30 *1.181*	77,72 *3.060*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C
T32-L40N01C03-8X1.25-63L	10139171	M8	1,25	3,11 *0.122*	13,0 *0.512*	35 *1.378*	86,89 *3.421*	91,7 *3.610*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	C
T32-L40N01C03-10X1.5-63L	10139172	M10	1,5	3,76 *0.148*	15,0 *0.591*	39 *1.535*	96,24 *3.789*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T32-R40NC

Blind holes – Metric coarse threads, left hand thread

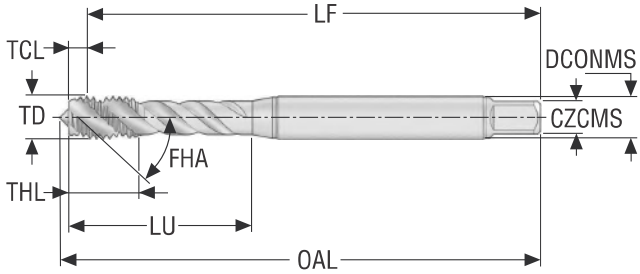


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-L40N01C06-12X1.75-63L	10139645	M12	1,75	4,41 *0.174*	18,0 *0.709*	83 *3.268*	105,59 *4.157*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T32-L40N01C06-16X2-63L	10139646	M16	2,0	5,15 *0.203*	20,0 *0.787*	68 *2.677*	104,85 *4.128*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	C
T32-L40N01C06-20X2.5-63L	10139647	M20	2,5	6,51 *0.256*	25,0 *0.984*	95 *3.740*	133,49 *5.256*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	C
T32-L40N01C06-24X3-63L	10139648	M24	3,0	7,81 *0.307*	30,0 *1.181*	113 *4.449*	152,19 *5.992*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C

T32-R40NC

Blind holes – MF threads

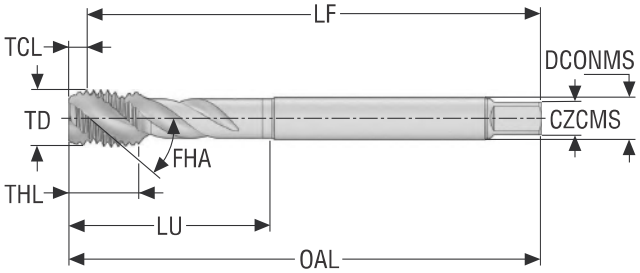


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N02C03-8X1-63R	10139150	MF8X1	1,0	2,58 *0.102*	13,0 *0.512*	35 *1.378*	87,42 *3.442*	91,7 *3.610*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	C
T32-R40N02C03-10X1-63R	10139151	MF10X1	1,0	2,68 *0.106*	13,0 *0.512*	35 *1.378*	87,32 *3.438*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	C
T32-R40N02C03-10X1.25-63R	10139152	MF10X1.25	1,25	3,21 *0.126*	15,0 *0.591*	39 *1.535*	96,79 *3.811*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,8 *0.346*	3	C

T32-R40NC

Blind holes – MF threads



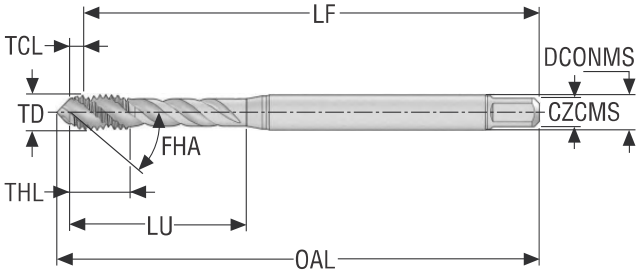
- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN374
- Thread tolerance class: 6H
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N02C05-8X1-63R	10139593	MF8X1	1,0	2,58 *0.102*	10,0 *0.394*	67 *2.638*	87,42 *3.442*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	C
T32-R40N02C05-10X0.75-63R	10139594	MF10X0.75	0,75	2,13 *0.084*	10,0 *0.394*	67 *2.638*	87,87 *3.459*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,2 *0.362*	3	C
T32-R40N02C05-10X1-63R	10139595	MF10X1	1,0	2,68 *0.106*	13,0 *0.512*	67 *2.638*	87,32 *3.438*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	C
T32-R40N02C05-10X1.25-63R	10139596	MF10X1.25	1,25	3,21 *0.126*	15,0 *0.591*	77 *3.031*	96,79 *3.811*	100,0 *3.937*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	C
T32-R40N02C05-12X1-63R	10139597	MF12X1	1,0	2,79 *0.110*	10,0 *0.394*	73 *2.874*	97,21 *3.827*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,0 *0.433*	3	C
T32-R40N02C05-12X1.25-63R	10139598	MF12X1.25	1,25	3,34 *0.131*	15,0 *0.591*	73 *2.874*	96,66 *3.806*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,8 *0.425*	3	C
T32-R40N02C05-12X1.5-63R	10139599	MF12X1.5	1,5	3,87 *0.152*	15,0 *0.591*	73 *2.874*	96,13 *3.785*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	C
T32-R40N02C05-14X1-63R	10139600	MF14X1	1,0	2,89 *0.114*	10,0 *0.394*	71 *2.795*	97,11 *3.823*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,0 *0.512*	4	C
T32-R40N02C05-14X1.25-63R	10139601	MF14X1.25	1,25	3,44 *0.135*	15,0 *0.591*	71 *2.795*	96,56 *3.802*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,8 *0.504*	4	C
T32-R40N02C05-14X1.5-63R	10139602	MF14X1.5	1,5	3,97 *0.156*	15,0 *0.591*	71 *2.795*	96,03 *3.781*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	4	C
T32-R40N02C05-16X1-63R	10139603	MF16X1	1,0	2,79 *0.110*	10,0 *0.394*	58 *2.283*	97,21 *3.827*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,0 *0.591*	4	C
T32-R40N02C05-16X1.5-63R	10139604	MF16X1.5	1,5	4,07 *0.160*	15,0 *0.591*	58 *2.283*	95,93 *3.777*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	C
T32-R40N02C05-18X1.5-63R	10139605	MF18X1.5	1,5	4,17 *0.164*	17,0 *0.669*	66 *2.598*	105,83 *4.167*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	C
T32-R40N02C05-18X2-63R	10139606	MF18X2	2,0	5,25 *0.207*	20,0 *0.787*	81 *3.189*	119,75 *4.715*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,0 *0.630*	4	C
T32-R40N02C05-20X1.5-63R	10139607	MF20X1.5	1,5	4,37 *0.172*	17,0 *0.669*	80 *3.150*	120,63 *4.749*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	18,5 *0.728*	4	C
T32-R40N02C05-20X2-63R	10139608	MF20X2	2,0	5,45 *0.215*	20,0 *0.787*	95 *3.740*	134,55 *5.297*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	18,0 *0.709*	4	C
T32-R40N02C05-22X1.5-63R	10139609	MF22X1.5	1,5	4,37 *0.172*	17,0 *0.669*	78 *3.071*	120,63 *4.749*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	20,5 *0.807*	4	C
T32-R40N02C05-22X2-63R	10139610	MF22X2	2,0	5,45 *0.215*	20,0 *0.787*	93 *3.661*	134,55 *5.297*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	20,0 *0.787*	4	C
T32-R40N02C05-24X1.5-63R	10139611	MF24X1.5	1,5	4,39 *0.173*	20,0 *0.787*	93 *3.661*	135,61 *5.339*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,5 *0.886*	4	C
T32-R40N02C05-24X2-63R	10139612	MF24X2	2,0	5,67 *0.223*	20,0 *0.787*	93 *3.661*	134,33 *5.289*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,0 *0.866*	4	C

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N02C05-27X1.5-63R	10139613	MF27X1.5	1,5	4,59 *0.181*	20,0 *0.787*	77 *3.031*	135,41 *5.331*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	25,5 *1.004*	4	C
T32-R40N02C05-27X2-63R	10139614	MF27X2	2,0	5,67 *0.223*	20,0 *0.787*	77 *3.031*	134,33 *5.289*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	25,0 *0.984*	4	C
T32-R40N02C05-30X1.5-63R	10139615	MF30X1.5	1,5	4,19 *0.165*	22,0 *0.866*	85 *3.346*	145,81 *5.741*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,5 *1.122*	4	C
T32-R40N02C05-30X2-63R	10139616	MF30X2	2,0	5,67 *0.223*	22,0 *0.866*	85 *3.346*	144,33 *5.682*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,0 *1.102*	4	C

T32-R40NC

Blind holes – UNC threads

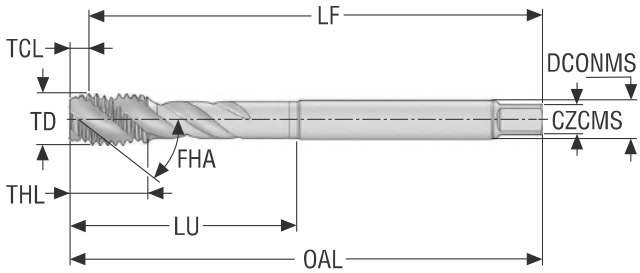


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 2B
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N08C03-4-40-21R	10139153	UNC4-40	2,845 *0.112*	*40.0*	1,45 *0.057*	5,0 *0.197*	18 *0.709*	54,55 *2.148*	56,0 *2.205*	3,5 *0.138*	3.50X2.70	2,35 *0.093*	3	C
T32-R40N08C03-5-40-21R	10139154	UNC5-40	3,175 *0.125*	*40.0*	1,5 *0.059*	7,0 *0.276*	18 *0.709*	54,5 *2.146*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,65 *0.104*	3	C
T32-R40N08C03-6-32-21R	10139155	UNC6-32	3,505 *0.138*	*32.0*	1,92 *0.076*	6,0 *0.236*	20 *0.787*	54,08 *2.129*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,85 *0.112*	3	C
T32-R40N08C03-8-32-21R	10139156	UNC8-32	4,166 *0.164*	*32.0*	1,85 *0.073*	7,0 *0.276*	21 *0.827*	61,15 *2.407*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,5 *0.138*	3	C
T32-R40N08C03-10-24-21R	10139157	UNC10-24	4,826 *0.190*	*24.0*	2,49 *0.098*	8,0 *0.315*	25 *0.984*	67,51 *2.658*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	3,9 *0.154*	3	C
T32-R40N08C03-12-24-21R	10139158	UNC12-24	5,486 *0.216*	*24.0*	2,43 *0.096*	10,0 *0.394*	30 *1.181*	77,57 *3.054*	82,2 *3.236*	6,0 *0.236*	6.00X4.90	4,5 *0.177*	3	C
T32-R40N08C03-1/4-20-21R	10139159	UNC1/4-20	6,35 *0.250*	*20.0*	2,9 *0.114*	13,0 *0.512*	32 *1.260*	77,1 *3.035*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,1 *0.201*	3	C
T32-R40N08C03-5/16-18-21R	10139160	UNC5/16-18	7,937 *0.312*	*18.0*	3,54 *0.139*	13,0 *0.512*	35 *1.378*	86,46 *3.404*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,6 *0.260*	3	C
T32-R40N08C03-3/8-16-21R	10139161	UNC3/8-16	9,525 *0.375*	*16.0*	3,99 *0.157*	15,0 *0.591*	39 *1.535*	96,01 *3.780*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,0 *0.315*	3	C

T32-R40NC

Blind holes – UNC threads

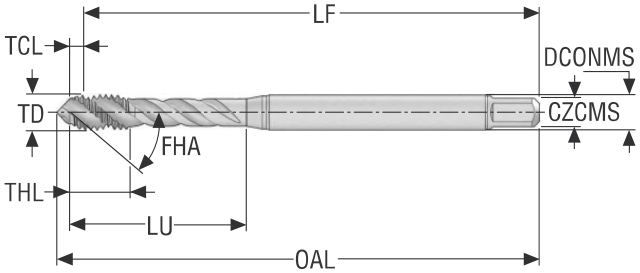


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 2B
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N08C06-7/16-14-21R	10139617	UNC7/16-14	11,112 *0.437*	*14.0*	4,6 *0.181*	15,0 *0.591*	76 *2.992*	95,4 *3.756*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,3 *0.366*	3	C
T32-R40N08C06-1/2-13-21R	10139626	UNC1/2-13	12,7 *0.500*	*13.0*	4,94 *0.194*	18,0 *0.709*	83 *3.268*	105,06 *4.136*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,7 *0.421*	4	C
T32-R40N08C06-9/16-12-21R	10139619	UNC9/16-12	14,287 *0.562*	*12.0*	5,37 *0.211*	20,0 *0.787*	81 *3.189*	104,63 *4.119*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,3 *0.484*	4	C
T32-R40N08C06-5/8-11-21R	10139620	UNC5/8-11	15,875 *0.625*	*11.0*	5,81 *0.229*	22,0 *0.866*	68 *2.677*	104,19 *4.102*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	13,5 *0.531*	4	C
T32-R40N08C06-3/4-10-21R	10139621	UNC3/4-10	19,05 *0.750*	*10.0*	6,78 *0.267*	25,0 *0.984*	81 *3.189*	118,22 *4.654*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	C
T32-R40N08C06-7/8-9-21R	10139622	UNC7/8-9	22,225 *0.875*	*9.0*	7,27 *0.286*	30,0 *1.181*	93 *3.661*	132,73 *5.226*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,5 *0.768*	4	C
T32-R40N08C06-1-8-21R	10139623	UNC1-8	25,4 *1.000*	*8.0*	8,32 *0.328*	30,0 *1.181*	97 *3.819*	151,68 *5.972*	160,0 *6.299*	20,0 *0.787*	20.00X16.00	22,25 *0.876*	4	C
T32-R40N08C06-1_1/8-7-21R	10139758	UNC1 1/8-7	28,575 *1.125*	*7.0*	9,17 *0.361*	37,0 *1.457*	115 *4.528*	170,83 *6.726*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	25,0 *0.984*	4	C
T32-R40N08C06-1_1/4-7-21R	10139624	UNC1 1/4-7	31,75 *1.250*	*7.0*	9,3 *0.366*	37,0 *1.457*	115 *4.528*	170,7 *6.720*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	28,0 *1.102*	4	C
T32-R40N08C06-1_3/8-6-21R	10139618	UNC1 3/8-6	34,925 *1.375*	*6.0*	10,5 *0.413*	40,0 *1.575*	131 *5.157*	189,5 *7.461*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	30,75 *1.211*	4	C
T32-R40N08C06-1_1/2-6-21R	10139625	UNC1 1/2-6	38,1 *1.500*	*6.0*	10,63 *0.419*	40,0 *1.575*	131 *5.157*	189,37 *7.456*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	34,0 *1.339*	4	C

T32-R40NC

Blind holes – UNF threads

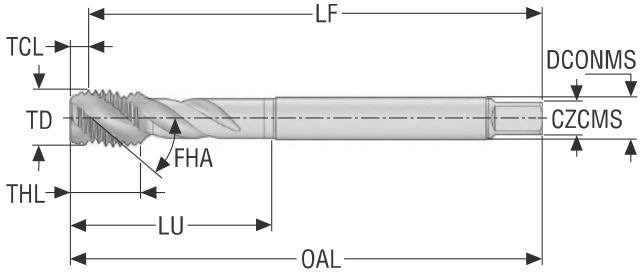


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 2B
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N09C03-10-32-21R	10139162	UNF10-32	4,826 *0.190*	*32.0*	1,96 *0.077*	8,0 *0.315*	25 *0.984*	68,04 *2.679*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,1 *0.161*	3	C
T32-R40N09C03-12-28-21R	10139163	UNF12-28	5,486 *0.216*	*28.0*	2,07 *0.081*	10,0 *0.394*	30 *1.181*	77,93 *3.068*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	4,6 *0.181*	3	C
T32-R40N09C03-1/4-28-21R	10139164	UNF1/4-28	6,35 *0.250*	*28.0*	2,19 *0.086*	10,0 *0.394*	30 *1.181*	77,81 *3.063*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,5 *0.217*	3	C
T32-R40N09C03-5/16-24-21R	10139165	UNF5/16-24	7,937 *0.312*	*24.0*	2,83 *0.111*	13,0 *0.512*	35 *1.378*	87,17 *3.432*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,9 *0.272*	3	C
T32-R40N09C03-3/8-24-21R	10139166	UNF3/8-24	9,525 *0.375*	*24.0*	2,91 *0.115*	15,0 *0.591*	35 *1.378*	87,09 *3.429*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T32-R40NC

Blind holes – UNF threads

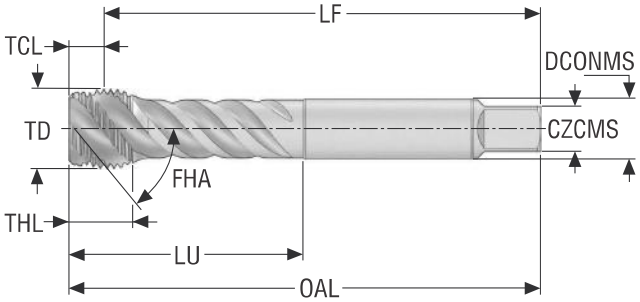


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN374
- Thread tolerance class: 2B
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N09C05-7/16-20-21R	10139627	UNF7/16-20	11,112 *0.437*	*20.0*	3,35 *0.132*	15,0 *0.591*	76 *2.992*	96,65 *3.805*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,9 *0.390*	3	C
T32-R40N09C05-1/2-20-21R	10139636	UNF1/2-20	12,7 *0.500*	*20.0*	3,51 *0.138*	15,0 *0.591*	73 *2.874*	96,49 *3.799*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,5 *0.453*	4	C
T32-R40N09C05-9/16-18-21R	10139629	UNF9/16-18	14,287 *0.562*	*18.0*	3,77 *0.148*	15,0 *0.591*	71 *2.795*	96,23 *3.789*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,0 *0.512*	4	C
T32-R40N09C05-5/8-18-21R	10139630	UNF5/8-18	15,875 *0.625*	*18.0*	3,86 *0.152*	15,0 *0.591*	58 *2.283*	96,14 *3.785*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	C
T32-R40N09C05-3/4-16-21R	10139631	UNF3/4-16	19,05 *0.750*	*16.0*	4,45 *0.175*	17,0 *0.669*	66 *2.598*	105,55 *4.156*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	17,5 *0.689*	4	C
T32-R40N09C05-7/8-14-21R	10139632	UNF7/8-14	22,225 *0.875*	*14.0*	5,15 *0.203*	17,0 *0.669*	78 *3.071*	119,85 *4.719*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	20,5 *0.807*	4	C
T32-R40N09C05-1-12-21R	10139633	UNF1-12	25,4 *1.000*	*12.0*	5,82 *0.229*	22,0 *0.866*	93 *3.661*	134,18 *5.283*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	23,3 *0.917*	4	C
T32-R40N09C05-1_1/8-12-21R	10139759	UNF1 1/8-12	28,575 *1.125*	*12.0*	5,98 *0.235*	22,0 *0.866*	85 *3.346*	144,02 *5.670*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	26,5 *1.043*	4	C
T32-R40N09C05-1_1/4-12-21R	10139634	UNF1 1/4-12	31,75 *1.250*	*12.0*	5,94 *0.234*	22,0 *0.866*	85 *3.346*	144,06 *5.672*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	29,5 *1.161*	4	C
T32-R40N09C05-1_3/8-12-21R	10139628	UNF1 3/8-12	34,925 *1.375*	*12.0*	6,07 *0.239*	22,0 *0.866*	101 *3.976*	163,93 *6.454*	170,0 *6.693*	28,0 *1.102*	28.00X22.00	32,8 *1.291*	4	C
T32-R40N09C05-1_1/2-12-21R	10139635	UNF1 1/2-12	38,1 *1.500*	*12.0*	6,04 *0.238*	24,0 *0.945*	101 *3.976*	163,96 *6.455*	170,0 *6.693*	28,0 *1.102*	28.00X22.00	36,0 *1.417*	4	C

T32-R40NC

Blind holes – G threads

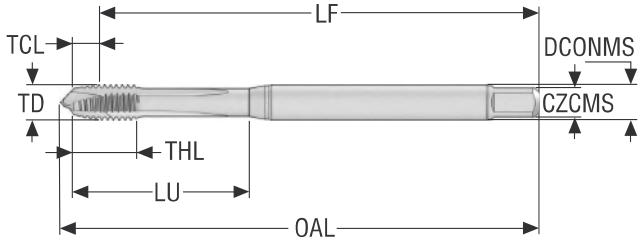


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN5156
- Thread tolerance class: NORMAL
- FHA = 40°
- For cutting data see page(s) 260

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T32-R40N21C09-1/8-28-11R	10139637	G1/8	9,728 *0.383*	*28.0*	2,67 *0.105*	10,0 *0.394*	67 *2.638*	87,33 *3.438*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	C
T32-R40N21C09-1/4-19-11R	10139638	G1/4	13,157 *0.518*	*19.0*	3,72 *0.146*	14,0 *0.551*	71 *2.795*	96,28 *3.791*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	11,8 *0.465*	3	C
T32-R40N21C09-3/8-19-11R	10139639	G3/8	16,662 *0.656*	*19.0*	3,92 *0.154*	15,0 *0.591*	58 *2.283*	96,08 *3.783*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,25 *0.600*	4	C
T32-R40N21C09-1/2-14-11R	10139640	G1/2	20,955 *0.825*	*14.0*	5,28 *0.208*	17,0 *0.669*	80 *3.150*	119,72 *4.713*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,0 *0.748*	4	C
T32-R40N21C09-5/8-14-11R	10139641	G5/8	22,911 *0.902*	*14.0*	5,21 *0.205*	20,0 *0.787*	78 *3.071*	119,79 *4.716*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C
T32-R40N21C09-3/4-14-11R	10139642	G3/4	26,441 *1.041*	*14.0*	5,45 *0.215*	20,0 *0.787*	77 *3.031*	134,55 *5.297*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	24,5 *0.965*	4	C
T32-R40N21C09-7/8-14-11R	10139643	G7/8	30,201 *1.189*	*14.0*	5,38 *0.212*	22,0 *0.866*	85 *3.346*	144,62 *5.694*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,25 *1.112*	4	C
T32-R40N21C09-1-11-11R	10139644	G1	33,249 *1.309*	*11.0*	6,56 *0.258*	24,0 *0.945*	93 *3.661*	153,44 *6.041*	160,0 *6.299*	25,0 *0.984*	25.00X20.00	30,75 *1.211*	4	C

T34-PHB-micro

Through holes – Metric coarse threads

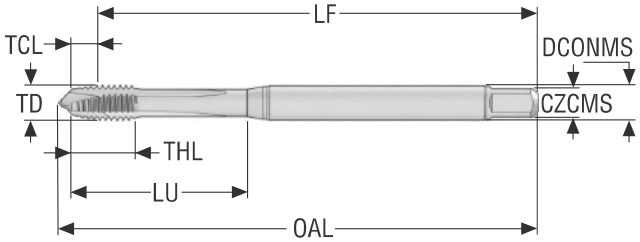


- Substrate: HSS-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 4H
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH01B03-1X0.25-41R	10139302	M1	0,25	1,13 *0.044*	6,0 *0.236*	13 *0.512*	38,87 *1.530*	40,9 *1.610*	2,5 *0.098*	2.50X2.10	0,75 *0.030*	2	B
T34-PH01B03-1.1X0.25-41R	10139303	M1.1	0,25	1,13 *0.044*	6,0 *0.236*	13 *0.512*	38,87 *1.530*	41,0 *1.614*	2,5 *0.098*	2.50X2.10	0,85 *0.033*	2	B
T34-PH01B03-1.2X0.25-41R	10139304	M1.2	0,25	1,13 *0.044*	6,0 *0.236*	13 *0.512*	38,87 *1.530*	41,1 *1.618*	2,5 *0.098*	2.50X2.10	0,95 *0.037*	2	B
T34-PH01B03-1.4X0.3-41R	10139305	M1.4	0,3	1,32 *0.052*	8,0 *0.315*	13 *0.512*	38,68 *1.523*	41,3 *1.626*	2,5 *0.098*	2.50X2.10	1,1 *0.043*	2	B

T34-PHB-micro

Through holes – Metric coarse threads

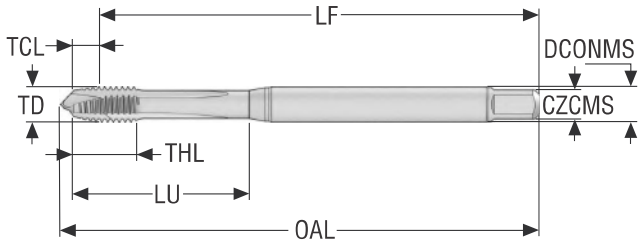


- Substrate: HSS-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6H
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH01B03-1.6X0.35-63R	10139306	M1.6	0,35	1,54 *0.061*	8,0 *0.315*	13 *0.512*	38,46 *1.514*	41,4 *1.630*	2,5 *0.098*	2.50X2.10	1,25 *0.049*	2	B
T34-PH01B03-1.7X0.35-63R	10139307	M1.7	0,35	1,54 *0.061*	8,0 *0.315*	13 *0.512*	38,46 *1.514*	41,5 *1.634*	2,5 *0.098*	2.50X2.10	1,35 *0.053*	2	B
T34-PH01B03-1.8X0.35-63R	10139308	M1.8	0,35	1,54 *0.061*	8,0 *0.315*	13 *0.512*	38,46 *1.514*	41,6 *1.638*	2,5 *0.098*	2.50X2.10	1,45 *0.057*	2	B
T34-PH01B03-2X0.4-63R	10139309	M2	0,4	1,89 *0.074*	10,0 *0.394*	13 *0.512*	43,11 *1.697*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,6 *0.063*	2	B
T34-PH01B03-2.2X0.45-63R	10139310	M2.2	0,45	2,07 *0.081*	10,0 *0.394*	13 *0.512*	42,93 *1.690*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,75 *0.069*	2	B
T34-PH01B03-2.3X0.4-63R	10139311	M2.3	0,4	1,89 *0.074*	10,0 *0.394*	13 *0.512*	43,11 *1.697*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,9 *0.075*	2	B
T34-PH01B03-2.5X0.45-63R	10139312	M2.5	0,45	2,07 *0.081*	9,0 *0.354*	14 *0.551*	47,93 *1.887*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,05 *0.081*	2	B
T34-PH01B03-2.6X0.45-63R	10139313	M2.6	0,45	2,07 *0.081*	9,0 *0.354*	14 *0.551*	47,93 *1.887*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,15 *0.085*	2	B

T34-PHB

Through holes – Metric coarse threads

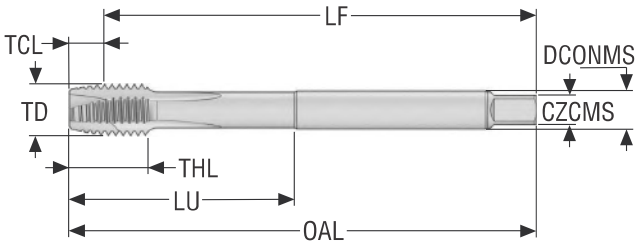


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH01B03-3X0.5-65R	10139314	M3	0,5	2,3 *0.091*	5,0 *0.197*	18 *0.709*	53,7 *2.114*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	B
T34-PH01B03-3.5X0.6-65R	10139315	M3.5	0,6	2,67 *0.105*	6,0 *0.236*	20 *0.787*	53,33 *2.100*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,9 *0.114*	3	B
T34-PH01B03-4X0.7-65R	10139316	M4	0,7	3,03 *0.119*	7,0 *0.276*	21 *0.827*	59,97 *2.361*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	B
T34-PH01B03-4.5X0.75-65R	10139317	M4.5	0,75	3,36 *0.132*	7,5 *0.295*	25 *0.984*	66,64 *2.624*	71,8 *2.827*	6,0 *0.236*	6.00X4.90	3,8 *0.150*	3	B
T34-PH01B03-5X0.8-65R	10139318	M5	0,8	3,71 *0.146*	8,0 *0.315*	25 *0.984*	66,29 *2.610*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	B
T34-PH01B03-6X1-65R	10139319	M6	1,0	4,5 *0.177*	10,0 *0.394*	30 *1.181*	75,5 *2.972*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	B
T34-PH01B03-8X1.25-65R	10139320	M8	1,25	5,48 *0.216*	13,0 *0.512*	35 *1.378*	84,52 *3.328*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	B
T34-PH01B03-10X1.5-65R	10139321	M10	1,5	6,9 *0.272*	15,0 *0.591*	39 *1.535*	93,1 *3.665*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	B

T34-PHB

Through holes – Metric coarse threads

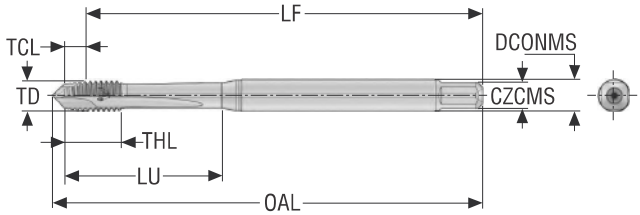


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH01B06-12X1.75-65R	10139322	M12	1,75	8,11 *0.319*	18,0 *0.709*	83 *3.268*	101,89 *4.011*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	B
T34-PH01B06-14X2-65R	10139323	M14	2,0	9,26 *0.365*	20,0 *0.787*	81 *3.189*	100,74 *3.966*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	3	B
T34-PH01B06-16X2-65R	10139324	M16	2,0	9,36 *0.369*	20,0 *0.787*	68 *2.677*	100,64 *3.962*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	3	B
T34-PH01B06-18X2.5-65R	10139325	M18	2,5	11,3 *0.445*	25,0 *0.984*	81 *3.189*	113,7 *4.476*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	15,5 *0.610*	4	B
T34-PH01B06-20X2.5-65R	10139326	M20	2,5	11,4 *0.449*	25,0 *0.984*	95 *3.740*	128,6 *5.063*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	B
T34-PH01B06-22X2.5-65R	10139327	M22	2,5	11,4 *0.449*	25,0 *0.984*	93 *3.661*	128,6 *5.063*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,5 *0.768*	4	B
T34-PH01B06-24X3-65R	10139328	M24	3,0	13,62 *0.536*	30,0 *1.181*	113 *4.449*	146,38 *5.763*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	B
T34-PH01B06-27X3-65R	10139329	M27	3,0	13,82 *0.544*	30,0 *1.181*	97 *3.819*	146,18 *5.755*	160,0 *6.299*	20,0 *0.787*	20.00X16.00	24,0 *0.945*	4	B
T34-PH01B06-30X3.5-65R	10139330	M30	3,5	15,87 *0.625*	35,0 *1.378*	115 *4.528*	164,13 *6.462*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	26,5 *1.043*	4	B
T34-PH01B06-33X3.5-65R	10139331	M33	3,5	15,87 *0.625*	35,0 *1.378*	113 *4.449*	164,13 *6.462*	180,0 *7.087*	25,0 *0.984*	25.00X20.00	29,5 *1.161*	4	B
T34-PH01B06-36X4-65R	10139332	M36	4,0	18,13 *0.714*	40,0 *1.575*	131 *5.157*	181,87 *7.160*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	32,0 *1.260*	4	B

T34B-PHB

Through holes – Metric coarse threads

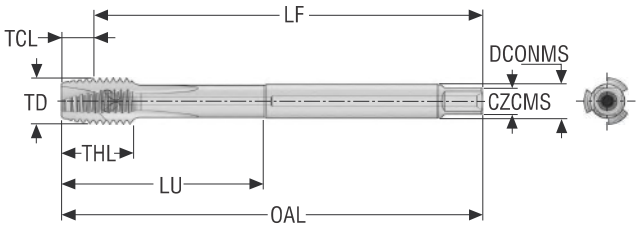


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34B-PH01B03-5X0.8-65R	10139333	M5	0,8	3,71 *0.146*	8,0 *0.315*	25 *0.984*	66,29 *2.610*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	B
T34B-PH01B03-6X1-65R	10139334	M6	1,0	4,5 *0.177*	10,0 *0.394*	30 *1.181*	75,5 *2.972*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	B
T34B-PH01B03-8X1.25-65R	10139335	M8	1,25	5,48 *0.216*	13,0 *0.512*	35 *1.378*	84,52 *3.328*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	B
T34B-PH01B03-10X1.5-65R	10139336	M10	1,5	6,9 *0.272*	15,0 *0.591*	39 *1.535*	93,1 *3.665*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	B

T34B-PHB

Through holes – Metric coarse threads

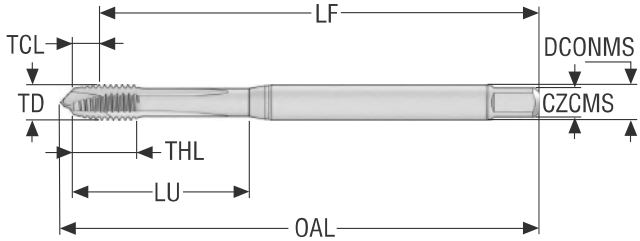


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34B-PH01B06-12X1.75-65R	10139337	M12	1,75	8,11 *0.319*	18,0 *0.709*	83 *3.268*	101,89 *4.011*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	B
T34B-PH01B06-14X2-65R	10139338	M14	2,0	9,26 *0.365*	20,0 *0.787*	81 *3.189*	100,74 *3.966*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	3	B
T34B-PH01B06-16X2-65R	10139339	M16	2,0	9,36 *0.369*	20,0 *0.787*	68 *2.677*	100,64 *3.962*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	3	B

T34-PHB

Through holes – MF threads

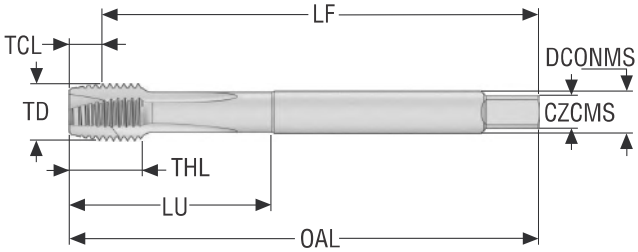


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH02B03-3X0.35-65R	10139340	MF3X0.35	0,35	1,6 *0.063*	5,0 *0.197*	18 *0.709*	54,4 *2.142*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,65 *0.104*	3	B
T34-PH02B03-3.5X0.35-65R	10139341	MF3.5X0.35	0,35	1,6 *0.063*	5,0 *0.197*	20 *0.787*	54,4 *2.142*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	3,15 *0.124*	3	B
T34-PH02B03-4X0.5-65R	10139342	MF4X0.5	0,5	2,3 *0.091*	7,0 *0.276*	21 *0.827*	60,7 *2.390*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,5 *0.138*	3	B
T34-PH02B03-5X0.5-65R	10139343	MF5X0.5	0,5	2,3 *0.091*	8,0 *0.315*	25 *0.984*	67,7 *2.665*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,5 *0.177*	3	B
T34-PH02B03-6X0.5-65R	10139344	MF6X0.5	0,5	2,34 *0.092*	10,0 *0.394*	30 *1.181*	77,66 *3.057*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,5 *0.217*	3	B
T34-PH02B03-6X0.75-65R	10139345	MF6X0.75	0,75	3,4 *0.134*	10,0 *0.394*	30 *1.181*	76,6 *3.016*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,2 *0.205*	3	B
T34-PH02B03-8X0.75-65R	10139346	MF8X0.75	0,75	3,4 *0.134*	10,0 *0.394*	30 *1.181*	76,6 *3.016*	83,6 *3.291*	8,0 *0.315*	8.00X6.20	7,2 *0.283*	3	B
T34-PH02B03-8X1-65R	10139347	MF8X1	1,0	4,45 *0.175*	13,0 *0.512*	35 *1.378*	85,55 *3.368*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	B
T34-PH02B03-10X0.75-65R	10139348	MF10X0.75	0,75	3,8 *0.150*	13,0 *0.512*	35 *1.378*	86,2 *3.394*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,2 *0.362*	3	B
T34-PH02B03-10X1-65R	10139349	MF10X1	1,0	5,25 *0.207*	13,0 *0.512*	35 *1.378*	84,75 *3.337*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	B
T34-PH02B03-10X1.25-65R	10139350	MF10X1.25	1,25	6,28 *0.247*	15,0 *0.591*	39 *1.535*	93,72 *3.690*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,8 *0.346*	3	B

T34-PHB

Through holes – MF threads

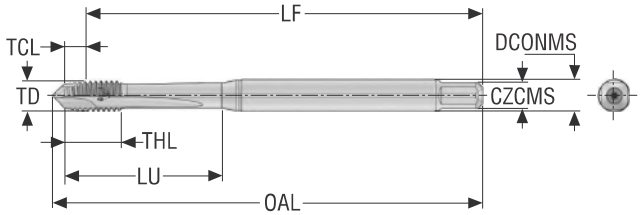


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN374
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH02B05-8X1-65R	10139351	MF8X1	1,0	4,75 *0.187*	10,0 *0.394*	35 *1.378*	85,25 *3.356*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	B
T34-PH02B05-10X1-65R	10139352	MF10X1	1,0	4,85 *0.191*	10,0 *0.394*	35 *1.378*	85,15 *3.352*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	B
T34-PH02B05-12X1-65R	10139353	MF12X1	1,0	4,98 *0.196*	10,0 *0.394*	73 *2.874*	95,02 *3.741*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,0 *0.433*	3	B
T34-PH02B05-12X1.25-65R	10139354	MF12X1.25	1,25	7,07 *0.278*	15,0 *0.591*	73 *2.874*	92,93 *3.659*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,8 *0.425*	3	B
T34-PH02B05-12X1.5-65R	10139355	MF12X1.5	1,5	6,03 *0.237*	15,0 *0.591*	73 *2.874*	93,97 *3.700*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	B
T34-PH02B05-14X1.5-65R	10139356	MF14X1.5	1,5	7,17 *0.282*	15,0 *0.591*	71 *2.795*	92,83 *3.655*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	3	B
T34-PH02B05-16X1.5-65R	10139357	MF16X1.5	1,5	7,27 *0.286*	15,0 *0.591*	58 *2.283*	92,73 *3.651*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	3	B
T34-PH02B05-18X1.5-65R	10139358	MF18X1.5	1,5	7,17 *0.282*	17,0 *0.669*	66 *2.598*	102,83 *4.048*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	B
T34-PH02B05-20X1.5-65R	10139359	MF20X1.5	1,5	7,27 *0.286*	17,0 *0.669*	80 *3.150*	117,73 *4.635*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	18,5 *0.728*	4	B
T34-PH02B05-22X1.5-65R	10139360	MF22X1.5	1,5	7,27 *0.286*	17,0 *0.669*	78 *3.071*	117,73 *4.635*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	20,5 *0.807*	4	B
T34-PH02B05-24X1.5-65R	10139361	MF24X1.5	1,5	7,41 *0.292*	20,0 *0.787*	93 *3.661*	132,59 *5.220*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,5 *0.886*	4	B

T34B-PHB

Through holes – MF threads

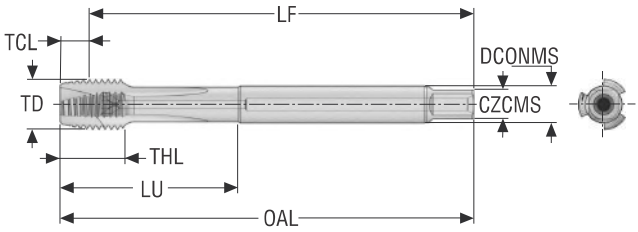


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34B-PH02B03-8X1-65R	10139362	MF8X1	1,0	4,45 *0.175*	13,0 *0.512*	35 *1.378*	85,55 *3.368*	93,4 *3.677*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	B
T34B-PH02B03-10X1-65R	10139363	MF10X1	1,0	5,25 *0.207*	13,0 *0.512*	35 *1.378*	84,75 *3.337*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	B

T34B-PHB

Through holes – MF threads

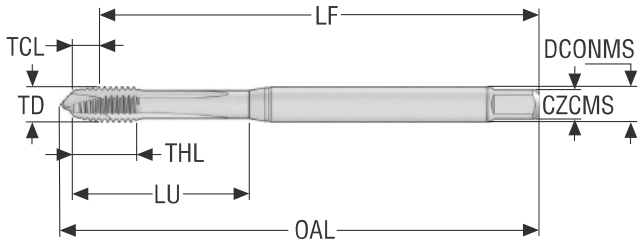


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN374
- Thread tolerance class: 6HX
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34B-PH02B05-8X1-65R	10139364	MF8X1	1,0	4,75 *0.187*	10,0 *0.394*	35 *1.378*	85,25 *3.356*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	B
T34B-PH02B05-10X1-65R	10139365	MF10X1	1,0	4,85 *0.191*	10,0 *0.394*	35 *1.378*	85,15 *3.352*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	B
T34B-PH02B05-12X1.5-65R	10139366	MF12X1.5	1,5	7,07 *0.278*	15,0 *0.591*	73 *2.874*	92,93 *3.659*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	B
T34B-PH02B05-14X1.5-65R	10139367	MF14X1.5	1,5	7,17 *0.282*	15,0 *0.591*	71 *2.795*	92,83 *3.655*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	3	B
T34B-PH02B05-16X1.5-65R	10139368	MF16X1.5	1,5	7,27 *0.286*	15,0 *0.591*	58 *2.283*	92,73 *3.651*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	3	B

T34-PHB

Through holes – UNC threads

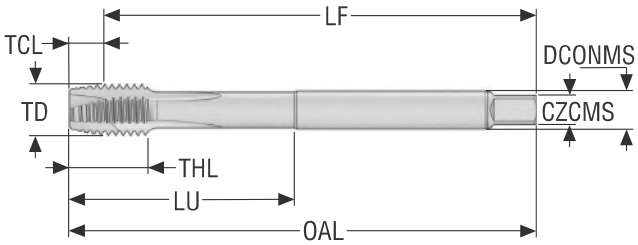


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2BX
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH08B03-4-40-22R	10139041	UNC4-40	2,845 *0.112*	*40.0*	2,83 *0.111*	5,0 *0.197*	18 *0.709*	53,17 *2.093*	56,0 *2.205*	3,5 *0.138*	3.50X2.70	2,35 *0.093*	3	B
T34-PH08B03-5-40-22R	10139042	UNC5-40	3,175 *0.125*	*40.0*	2,94 *0.116*	7,0 *0.276*	18 *0.709*	53,06 *2.089*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,65 *0.104*	3	B
T34-PH08B03-6-32-22R	10139043	UNC6-32	3,505 *0.138*	*32.0*	3,74 *0.147*	6,0 *0.236*	20 *0.787*	52,26 *2.057*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,85 *0.112*	3	B
T34-PH08B03-8-32-22R	10139044	UNC8-32	4,166 *0.164*	*32.0*	3,62 *0.143*	7,0 *0.276*	21 *0.827*	59,38 *2.338*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,5 *0.138*	3	B
T34-PH08B03-10-24-22R	10139045	UNC10-24	4,826 *0.190*	*24.0*	4,86 *0.191*	8,0 *0.315*	25 *0.984*	65,14 *2.565*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	3,9 *0.154*	3	B
T34-PH08B03-12-24-22R	10139046	UNC12-24	5,486 *0.216*	*24.0*	4,74 *0.187*	10,0 *0.394*	30 *1.181*	75,26 *2.963*	82,2 *3.236*	6,0 *0.236*	6.00X4.90	4,5 *0.177*	3	B
T34-PH08B03-1/4-20-22R	10139047	UNC1/4-20	6,35 *0.250*	*20.0*	5,65 *0.222*	13,0 *0.512*	32 *1.260*	74,35 *2.927*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,1 *0.201*	3	B
T34-PH08B03-5/16-18-22R	10139048	UNC5/16-18	7,937 *0.312*	*18.0*	6,31 *0.248*	13,0 *0.512*	35 *1.378*	83,69 *3.295*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,6 *0.260*	3	B
T34-PH08B03-3/8-16-22R	10139049	UNC3/8-16	9,525 *0.375*	*16.0*	7,37 *0.290*	15,0 *0.591*	39 *1.535*	92,63 *3.647*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,0 *0.315*	3	B

T34-PHB

Through holes – UNC threads

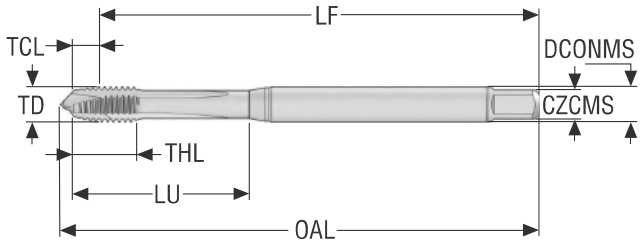


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 2BX
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH08B06-7/16-14-22R	10139050	UNC7/16-14	11,112 *0.437*	*14.0*	8,36 *0.329*	15,0 *0.591*	76 *2.992*	91,64 *3.608*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,3 *0.366*	3	B
T34-PH08B06-1/2-13-22R	10139051	UNC1/2-13	12,7 *0.500*	*13.0*	9,01 *0.355*	18,0 *0.709*	83 *3.268*	100,99 *3.976*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,7 *0.421*	3	B
T34-PH08B06-9/16-12-22R	10139052	UNC9/16-12	14,287 *0.562*	*12.0*	9,87 *0.389*	20,0 *0.787*	81 *3.189*	100,13 *3.942*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,3 *0.484*	3	B
T34-PH08B06-5/8-11-22R	10139053	UNC5/8-11	15,875 *0.625*	*11.0*	10,62 *0.418*	22,0 *0.866*	68 *2.677*	99,38 *3.913*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	13,5 *0.531*	3	B

T34-PHB

Through holes – UNF threads

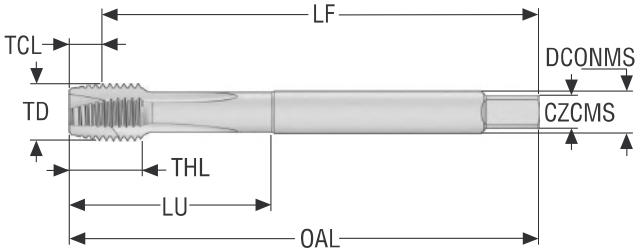


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2BX
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH09B03-4-48-22R	10139369	UNF4-48	2,845 *0.112*	*48.0*	2,48 *0.098*	5,0 *0.197*	18 *0.709*	53,52 *2.107*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,4 *0.094*	3	B
T34-PH09B03-5-44-22R	10139370	UNF5-44	3,175 *0.125*	*44.0*	2,6 *0.102*	7,0 *0.276*	18 *0.709*	53,4 *2.102*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,7 *0.106*	3	B
T34-PH09B03-6-40-22R	10139371	UNF6-40	3,505 *0.138*	*40.0*	3,05 *0.120*	6,0 *0.236*	20 *0.787*	52,95 *2.085*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,95 *0.116*	3	B
T34-PH09B03-8-36-22R	10139372	UNF8-36	4,166 *0.164*	*36.0*	3,28 *0.129*	7,0 *0.276*	21 *0.827*	59,72 *2.351*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,5 *0.138*	3	B
T34-PH09B03-10-32-22R	10139373	UNF10-32	4,826 *0.190*	*32.0*	3,5 *0.138*	8,0 *0.315*	25 *0.984*	66,5 *2.618*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,1 *0.161*	3	B
T34-PH09B03-12-28-22R	10139374	UNF12-28	5,486 *0.216*	*28.0*	4,05 *0.159*	10,0 *0.394*	30 *1.181*	75,95 *2.990*	82,2 *3.236*	6,0 *0.236*	6.00X4.90	4,6 *0.181*	3	B
T34-PH09B03-1/4-28-22R	10139375	UNF1/4-28	6,35 *0.250*	*28.0*	3,94 *0.155*	10,0 *0.394*	30 *1.181*	76,06 *2.994*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,5 *0.217*	3	B
T34-PH09B03-5/16-24-22R	10139376	UNF5/16-24	7,937 *0.312*	*24.0*	4,6 *0.181*	13,0 *0.512*	35 *1.378*	85,4 *3.362*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,9 *0.272*	3	B
T34-PH09B03-3/8-24-22R	10139377	UNF3/8-24	9,525 *0.375*	*24.0*	4,98 *0.196*	15,0 *0.591*	35 *1.378*	85,02 *3.347*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	B

T34-PHB

Through holes – UNF threads

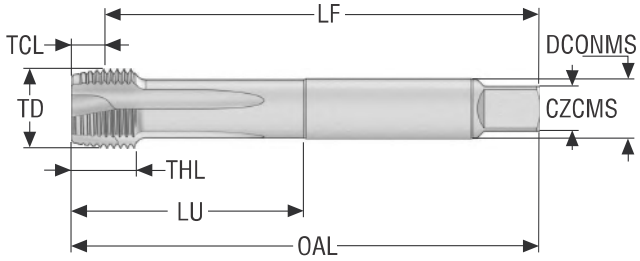


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 2BX
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH09B05-7/16-20-22R	10139378	UNF7/16-20	11,112 *0.437*	*20.0*	5,95 *0.234*	15,0 *0.591*	76 *2.992*	94,05 *3.703*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,9 *0.390*	3	B
T34-PH09B05-1/2-20-22R	10139379	UNF1/2-20	12,7 *0.500*	*20.0*	6,14 *0.242*	15,0 *0.591*	73 *2.874*	93,86 *3.695*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,5 *0.453*	3	B
T34-PH09B05-9/16-18-22R	10139380	UNF9/16-18	14,287 *0.562*	*18.0*	6,8 *0.268*	15,0 *0.591*	71 *2.795*	93,2 *3.669*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,0 *0.512*	3	B
T34-PH09B05-5/8-18-22R	10139381	UNF5/8-18	15,875 *0.625*	*18.0*	6,87 *0.270*	15,0 *0.591*	58 *2.283*	93,13 *3.667*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	3	B

T34-PHB

Through holes – G threads

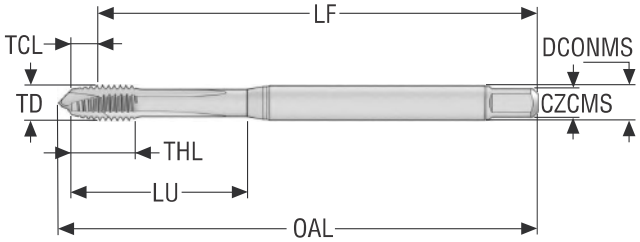


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN5156
- Thread tolerance class: NORMAL-X
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH21B09-1/8-28-12R	10139401	G1/8	9,728 *0.383*	*28.0*	4,49 *0.177*	10,0 *0.394*	36 *1.417*	85,51 *3.367*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	B
T34-PH21B09-1/4-19-12R	10139402	G1/4	13,157 *0.518*	*19.0*	6,85 *0.270*	14,0 *0.551*	71 *2.795*	93,15 *3.667*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	11,8 *0.465*	3	B
T34-PH21B09-3/8-19-12R	10139403	G3/8	16,662 *0.656*	*19.0*	6,97 *0.274*	15,0 *0.591*	58 *2.283*	93,03 *3.663*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,25 *0.600*	4	B
T34-PH21B09-1/2-14-12R	10139404	G1/2	20,955 *0.825*	*14.0*	9,0 *0.354*	17,0 *0.669*	80 *3.150*	116,0 *4.567*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,0 *0.748*	4	B
T34-PH21B09-5/8-14-12R	10139405	G5/8	22,911 *0.902*	*14.0*	9,4 *0.370*	20,0 *0.787*	78 *3.071*	115,6 *4.551*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	B
T34-PH21B09-3/4-14-12R	10139406	G3/4	26,441 *1.041*	*14.0*	9,16 *0.361*	20,0 *0.787*	77 *3.031*	130,84 *5.151*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	24,5 *0.965*	4	B
T34-PH21B09-7/8-14-12R	10139407	G7/8	30,201 *1.189*	*14.0*	9,03 *0.356*	22,0 *0.866*	85 *3.346*	140,97 *5.550*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,25 *1.112*	4	B
T34-PH21B09-1-11-12R	10139408	G1	33,249 *1.309*	*11.0*	11,49 *0.452*	24,0 *0.945*	93 *3.661*	148,51 *5.847*	160,0 *6.299*	25,0 *0.984*	25.00X20.00	30,75 *1.211*	4	B

T34-PHB

Through holes – EGM threads

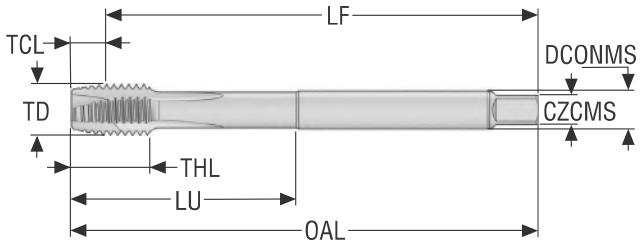


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6H mod.
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH04B03-2X0.4-64R	10139382	EGM2	0,4	2,07 *0.081*	9,0 *0.354*	14 *0.551*	47,93 *1.887*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,1 *0.083*	2	B
T34-PH04B03-2.5X0.45-64R	10139383	EGM2.5	0,45	2,13 *0.084*	10,0 *0.394*	18 *0.709*	53,87 *2.121*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,65 *0.104*	3	B
T34-PH04B03-3X0.5-64R	10139384	EGM3	0,5	2,03 *0.080*	12,0 *0.472*	21 *0.827*	60,97 *2.400*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,15 *0.124*	3	B
T34-PH04B03-4X0.7-64R	10139385	EGM4	0,7	3,27 *0.129*	14,0 *0.551*	25 *0.984*	66,73 *2.627*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	B
T34-PH04B03-5X0.8-64R	10139386	EGM5	0,8	3,72 *0.146*	18,0 *0.709*	30 *1.181*	76,28 *3.003*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,25 *0.207*	3	B
T34-PH04B03-6X1-64R	10139387	EGM6	1,0	4,7 *0.185*	18,0 *0.709*	35 *1.378*	85,3 *3.358*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,3 *0.248*	3	B
T34-PH04B03-8X1.25-64R	10139388	EGM8	1,25	5,8 *0.228*	20,0 *0.787*	39 *1.535*	94,2 *3.709*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,4 *0.331*	3	B

T34-PHB

Through holes – EGM threads

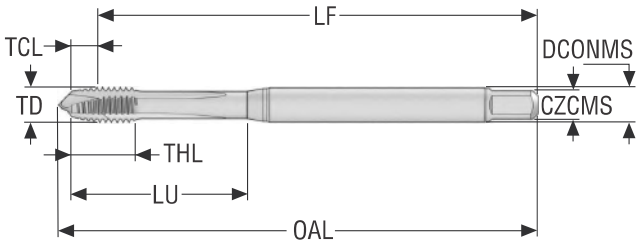


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 6H mod.
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH04B06-10X1.5-64R	10139409	EGM10	1,5	7,41 *0.292*	15,0 *0.591*	73 *2.874*	92,59 *3.645*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	B
T34-PH04B06-12X1.75-64R	10139410	EGM12	1,75	8,29 *0.326*	20,0 *0.787*	81 *3.189*	101,71 *4.004*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	4	B
T34-PH04B06-14X2-64R	10139411	EGM14	2,0	9,14 *0.360*	20,0 *0.787*	68 *2.677*	100,86 *3.971*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	B
T34-PH04B06-16X2-64R	10139412	EGM16	2,0	9,14 *0.360*	20,0 *0.787*	81 *3.189*	115,86 *4.561*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	B
T34-PH04B06-18X2.5-64R	10139413	EGM18	2,5	11,45 *0.451*	27,0 *1.063*	93 *3.661*	128,55 *5.061*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	18,75 *0.738*	4	B
T34-PH04B06-20X2.5-64R	10139414	EGM20	2,5	11,45 *0.451*	30,0 *1.181*	113 *4.449*	148,55 *5.848*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	20,75 *0.817*	4	B

T34-PHB

Through holes – EGUNC threads

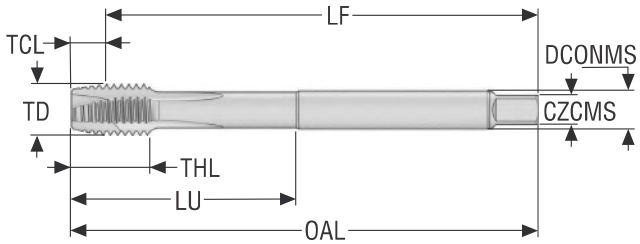


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2B
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH16B03-4-40-21R	10139389	EGUNC4-40	3,67 *0.144*	*40.0*	2,83 *0.111*	13,0 *0.512*	21 *0.827*	60,17 *2.369*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,1 *0.122*	3	B
T34-PH16B03-6-32-21R	10139390	EGUNC6-32	4,536 *0.179*	*32.0*	3,75 *0.148*	14,0 *0.551*	25 *0.984*	66,25 *2.608*	71,8 *2.827*	6,0 *0.236*	6.00X4.90	3,8 *0.150*	3	B
T34-PH16B03-8-32-21R	10139391	EGUNC8-32	5,197 *0.205*	*32.0*	3,73 *0.147*	16,0 *0.630*	30 *1.181*	76,27 *3.003*	82,1 *3.232*	6,0 *0.236*	6.00X4.90	4,4 *0.173*	3	B
T34-PH16B03-10-24-21R	10139392	EGUNC10-24	6,2 *0.244*	*24.0*	3,5 *0.138*	17,0 *0.669*	30 *1.181*	76,5 *3.012*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,2 *0.205*	3	B
T34-PH16B03-1/4-20-21R	10139393	EGUNC1/4-20	8,001 *0.315*	*20.0*	5,71 *0.225*	20,0 *0.787*	35 *1.378*	84,29 *3.319*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	6,7 *0.264*	3	B
T34-PH16B03-5/16-18-21R	10139394	EGUNC5/16-18	9,771 *0.385*	*18.0*	6,61 *0.260*	22,0 *0.866*	39 *1.535*	93,39 *3.677*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,4 *0.331*	3	B

T34-PHB

Through holes – EGUNC threads

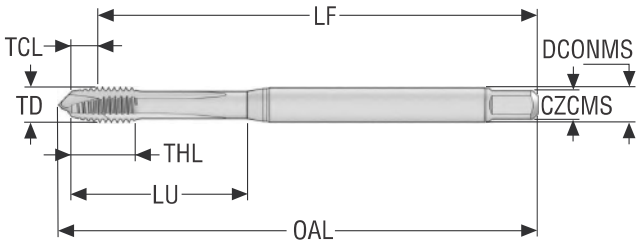


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 2B
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH16B06-3/8-16-21R	10139415	EGUNC3/8-16	11,587 *0.456*	*16.0*	7,6 *0.299*	15,0 *0.591*	73 *2.874*	92,4 *3.638*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,0 *0.394*	3	B
T34-PH16B06-7/16-14-21R	10139416	EGUNC7/16-14	13,47 *0.530*	*14.0*	8,6 *0.339*	18,0 *0.709*	81 *3.189*	101,4 *3.992*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	11,6 *0.457*	3	B
T34-PH16B06-1/2-13-21R	10139417	EGUNC1/2-13	15,237 *0.600*	*13.0*	9,3 *0.366*	18,0 *0.709*	68 *2.677*	100,7 *3.965*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	13,3 *0.524*	3	B
T34-PH16B06-9/16-12-21R	10139418	EGUNC9/16-12	17,038 *0.671*	*12.0*	9,7 *0.382*	20,0 *0.787*	68 *2.677*	100,3 *3.949*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,9 *0.587*	4	B
T34-PH16B06-5/8-11-21R	10139419	EGUNC5/8-11	18,875 *0.743*	*11.0*	10,6 *0.417*	20,0 *0.787*	81 *3.189*	114,4 *4.504*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	B
T34-PH16B06-3/4-10-21R	10139420	EGUNC3/4-10	22,349 *0.880*	*10.0*	11,8 *0.465*	25,0 *0.984*	93 *3.661*	128,2 *5.047*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,75 *0.778*	4	B

T34-PHB

Through holes – EGUNF threads

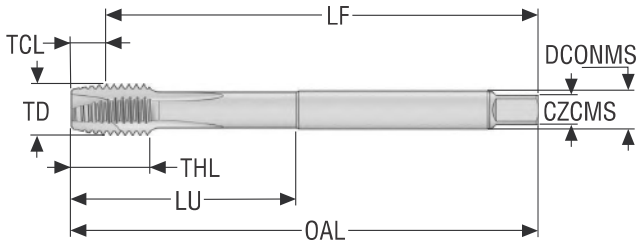


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2B
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH17B03-4-48-21R	10139395	EGUNF4-48	3,533 *0.139*	*48.0*	2,36 *0.093*	9,0 *0.354*	20 *0.787*	53,64 *2.112*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	3,0 *0.118*	3	B
T34-PH17B03-6-40-21R	10139396	EGUNF6-40	4,331 *0.171*	*40.0*	2,75 *0.108*	10,0 *0.394*	25 *0.984*	67,25 *2.648*	71,8 *2.827*	6,0 *0.236*	6.00X4.90	3,7 *0.146*	3	B
T34-PH17B03-8-36-21R	10139397	EGUNF8-36	5,083 *0.200*	*36.0*	2,93 *0.115*	13,0 *0.512*	30 *1.181*	77,07 *3.034*	82,1 *3.232*	6,0 *0.236*	6.00X4.90	4,4 *0.173*	3	B
T34-PH17B03-10-32-21R	10139398	EGUNF10-32	5,857 *0.231*	*32.0*	3,5 *0.138*	13,0 *0.512*	30 *1.181*	76,5 *3.012*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,1 *0.201*	3	B
T34-PH17B03-1/4-28-21R	10139399	EGUNF1/4-28	7,529 *0.296*	*28.0*	4,09 *0.161*	17,0 *0.669*	35 *1.378*	85,91 *3.382*	93,2 *3.669*	8,0 *0.315*	8.00X6.20	6,6 *0.260*	3	B
T34-PH17B03-5/16-24-21R	10139400	EGUNF5/16-24	9,312 *0.367*	*24.0*	5,1 *0.201*	18,0 *0.709*	35 *1.378*	84,97 *3.345*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	8,25 *0.325*	3	B

T34-PHB

Through holes – EGUNF threads

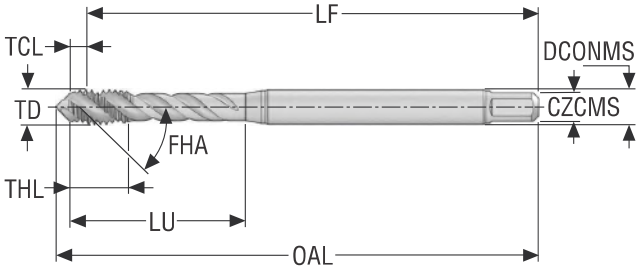


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 2B
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-PH17B06-3/8-24-21R	10139421	EGUNF3/8-24	10,899 *0.429*	*24.0*	4,43 *0.174*	12,0 *0.472*	66 *2.598*	85,57 *3.369*	90,0 *3.543*	8,0 *0.315*	8.00X6.00	9,8 *0.386*	3	B
T34-PH17B06-7/16-20-21R	10139422	EGUNF7/16-20	12,763 *0.502*	*20.0*	6,2 *0.244*	15,0 *0.591*	73 *2.874*	93,8 *3.693*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,5 *0.453*	3	B
T34-PH17B06-1/2-20-21R	10139423	EGUNF1/2-20	14,351 *0.565*	*20.0*	6,2 *0.244*	15,0 *0.591*	71 *2.795*	93,8 *3.693*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,1 *0.516*	3	B
T34-PH17B06-9/16-18-21R	10139424	EGUNF9/16-18	16,121 *0.635*	*18.0*	6,9 *0.272*	15,0 *0.591*	58 *2.283*	93,1 *3.665*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,7 *0.579*	4	B
T34-PH17B06-5/8-18-21R	10139425	EGUNF5/8-18	17,709 *0.697*	*18.0*	6,9 *0.272*	15,0 *0.591*	66 *2.598*	103,1 *4.059*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	16,25 *0.640*	4	B
T34-PH17B06-3/4-16-21R	10139426	EGUNF3/4-16	21,112 *0.831*	*16.0*	7,9 *0.311*	17,0 *0.669*	80 *3.150*	117,1 *4.610*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,5 *0.768*	4	B

T34-R45HC-micro

Blind holes – Metric coarse threads

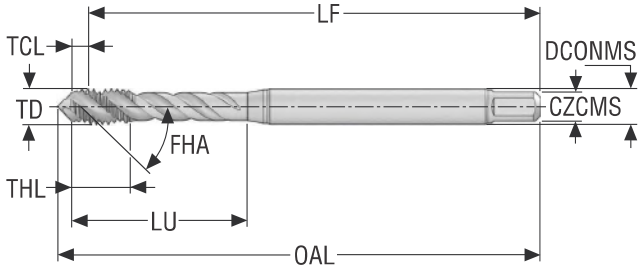


- Substrate: HSS-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 4H
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H01C03-1X0.25-41R	10138952	M1	0,25	0,59 *0.023*	6,0 *0.236*	13 *0.512*	39,41 *1.552*	40,9 *1.610*	2,5 *0.098*	2.50X2.10	0,75 *0.030*	2	C
T34-R45H01C03-1.1X0.25-41R	10138953	M1.1	0,25	0,59 *0.023*	6,0 *0.236*	13 *0.512*	39,41 *1.552*	41,0 *1.614*	2,5 *0.098*	2.50X2.10	0,85 *0.033*	2	C
T34-R45H01C03-1.2X0.25-41R	10138954	M1.2	0,25	0,59 *0.023*	6,0 *0.236*	13 *0.512*	39,41 *1.552*	41,1 *1.618*	2,5 *0.098*	2.50X2.10	0,95 *0.037*	2	C
T34-R45H01C03-1.4X0.3-41R	10138955	M1.4	0,3	0,69 *0.027*	8,0 *0.315*	13 *0.512*	39,31 *1.548*	41,3 *1.626*	2,5 *0.098*	2.50X2.10	1,1 *0.043*	2	C

T34-R45HC-micro

Blind holes – Metric coarse threads

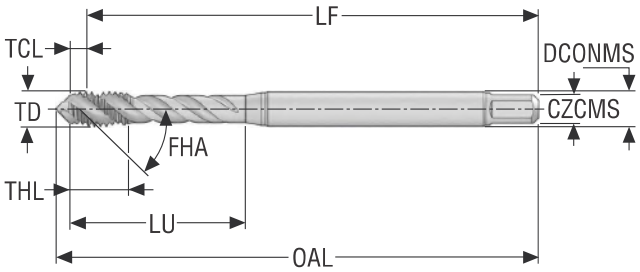


- Substrate: HSS-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6H
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H01C03-1.6X0.35-63R	10138956	M1.6	0,35	0,8 *0.031*	8,0 *0.315*	13 *0.512*	39,2 *1.543*	41,4 *1.630*	2,5 *0.098*	2.50X2.10	1,25 *0.049*	2	C
T34-R45H01C03-1.7X0.35-63R	10138957	M1.7	0,35	0,8 *0.031*	8,0 *0.315*	13 *0.512*	39,2 *1.543*	41,5 *1.634*	2,5 *0.098*	2.50X2.10	1,35 *0.053*	2	C
T34-R45H01C03-1.8X0.35-63R	10138958	M1.8	0,35	0,8 *0.031*	8,0 *0.315*	13 *0.512*	39,2 *1.543*	41,6 *1.638*	2,5 *0.098*	2.50X2.10	1,45 *0.057*	2	C
T34-R45H01C03-2X0.4-63R	10138959	M2	0,4	1,05 *0.041*	10,0 *0.394*	13 *0.512*	43,95 *1.730*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,6 *0.063*	2	C
T34-R45H01C03-2.2X0.45-63R	10138960	M2.2	0,45	1,15 *0.045*	10,0 *0.394*	13 *0.512*	43,85 *1.726*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,75 *0.069*	2	C
T34-R45H01C03-2.3X0.4-63R	10138961	M2.3	0,4	1,05 *0.041*	10,0 *0.394*	13 *0.512*	43,95 *1.730*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,9 *0.075*	2	C
T34-R45H01C03-2.5X0.45-63R	10138962	M2.5	0,45	1,06 *0.042*	5,0 *0.197*	14 *0.551*	48,94 *1.927*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,05 *0.081*	2	C
T34-R45H01C03-2.6X0.45-63R	10138963	M2.6	0,45	1,15 *0.045*	5,0 *0.197*	14 *0.551*	48,85 *1.923*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,15 *0.085*	2	C

T34-R45HC

Blind holes – Metric coarse threads

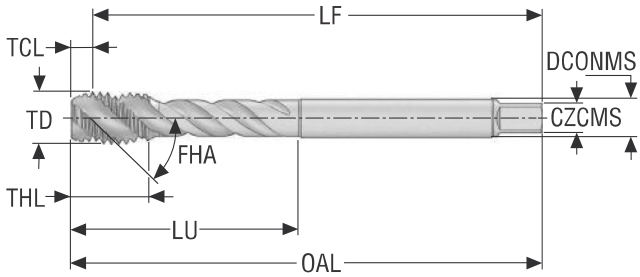


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H01C03-3X0.5-65R	10138964	M3	0,5	1,2 *0.047*	5,0 *0.197*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	C
T34-R45H01C03-3.5X0.6-65R	10138966	M3.5	0,6	1,31 *0.052*	6,0 *0.236*	20 *0.787*	54,69 *2.153*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,9 *0.114*	3	C
T34-R45H01C03-4X0.7-65R	10138967	M4	0,7	1,82 *0.072*	7,0 *0.276*	21 *0.827*	61,18 *2.409*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	C
T34-R45H01C03-4.5X0.75-65R	10138968	M4.5	0,75	1,82 *0.072*	7,5 *0.295*	25 *0.984*	68,18 *2.684*	71,8 *2.827*	6,0 *0.236*	6.00X4.90	3,8 *0.150*	3	C
T34-R45H01C03-5X0.8-65R	10138969	M5	0,8	2,01 *0.079*	8,0 *0.315*	25 *0.984*	67,99 *2.677*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T34-R45H01C03-6X1-65R	10138970	M6	1,0	2,32 *0.091*	10,0 *0.394*	30 *1.181*	77,68 *3.058*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C
T34-R45H01C03-8X1.25-65R	10138971	M8	1,25	3,16 *0.124*	13,0 *0.512*	35 *1.378*	86,84 *3.419*	91,7 *3.610*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	C
T34-R45H01C03-10X1.5-65R	10138972	M10	1,5	3,81 *0.150*	15,0 *0.591*	39 *1.535*	96,19 *3.787*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T34-R45HC

Blind holes – Metric coarse threads

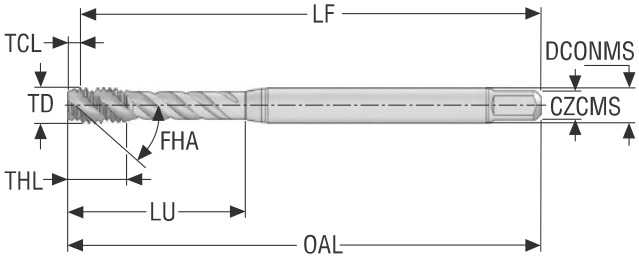


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H01C06-12X1.75-65R	10138973	M12	1,75	4,47 *0.176*	18,0 *0.709*	83 *3.268*	105,53 *4.155*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T34-R45H01C06-14X2-65R	10138974	M14	2,0	5,11 *0.201*	20,0 *0.787*	81 *3.189*	104,89 *4.130*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	4	C
T34-R45H01C06-16X2-65R	10138975	M16	2,0	5,21 *0.205*	20,0 *0.787*	68 *2.677*	104,79 *4.126*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	C
T34-R45H01C06-18X2.5-65R	10138976	M18	2,5	6,28 *0.247*	25,0 *0.984*	81 *3.189*	118,72 *4.674*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	15,5 *0.610*	4	C
T34-R45H01C06-20X2.5-65R	10138977	M20	2,5	6,28 *0.247*	25,0 *0.984*	95 *3.740*	133,72 *5.265*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	17,5 *0.689*	4	C
T34-R45H01C06-22X2.5-65R	10138978	M22	2,5	6,28 *0.247*	25,0 *0.984*	93 *3.661*	133,72 *5.265*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,5 *0.768*	4	C
T34-R45H01C06-24X3-65R	10138979	M24	3,0	7,48 *0.294*	30,0 *1.181*	113 *4.449*	152,52 *6.005*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C
T34-R45H01C06-27X3-65R	10138980	M27	3,0	7,68 *0.302*	30,0 *1.181*	97 *3.819*	152,32 *5.997*	160,0 *6.299*	20,0 *0.787*	20.00X16.00	24,0 *0.945*	4	C
T34-R45H01C06-30X3.5-65R	10138981	M30	3,5	8,75 *0.344*	35,0 *1.378*	115 *4.528*	171,25 *6.742*	180,0 *7.087*	22,0 *0.866*	22.00X18.00	26,5 *1.043*	4	C
T34-R45H01C06-33X3.5-65R	10138982	M33	3,5	8,75 *0.344*	35,0 *1.378*	113 *4.449*	171,25 *6.742*	180,0 *7.087*	25,0 *0.984*	25.00X20.00	29,5 *1.161*	4	C
T34-R45H01C06-36X4-65R	10138983	M36	4,0	10,02 *0.394*	40,0 *1.575*	131 *5.157*	189,98 *7.480*	200,0 *7.874*	28,0 *1.102*	28.00X22.00	32,0 *1.260*	4	C

T34-R45HE

Blind holes – Metric coarse threads

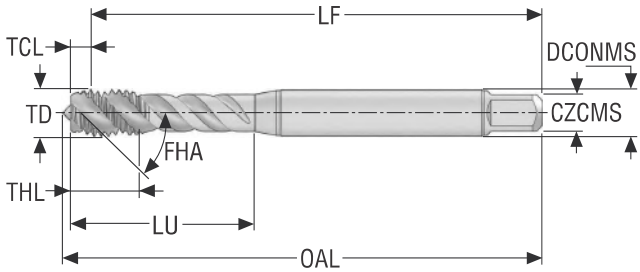


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H01E03-3X0.5-65R	10138991	M3	0,5	0,81 *0.032*	5,0 *0.197*	18 *0.709*	55,19 *2.173*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,5 *0.098*	3	E
T34-R45H01E03-3.5X0.6-65R	10138992	M3.5	0,6	0,94 *0.037*	6,0 *0.236*	20 *0.787*	55,06 *2.168*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,9 *0.114*	3	E
T34-R45H01E03-4X0.7-65R	10138993	M4	0,7	1,18 *0.046*	7,0 *0.276*	21 *0.827*	61,82 *2.434*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,3 *0.130*	3	E
T34-R45H01E03-4.5X0.75-65R	10138994	M4.5	0,75	1,18 *0.046*	7,5 *0.295*	25 *0.984*	68,82 *2.709*	71,8 *2.827*	6,0 *0.236*	6.00X4.90	3,8 *0.150*	3	E
T34-R45H01E03-5X0.8-65R	10138995	M5	0,8	1,31 *0.052*	8,0 *0.315*	25 *0.984*	68,69 *2.704*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	E
T34-R45H01E03-6X1-65R	10138996	M6	1,0	1,57 *0.062*	10,0 *0.394*	30 *1.181*	78,43 *3.088*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	E
T34-R45H01E03-8X1.25-65R	10138997	M8	1,25	2,23 *0.088*	13,0 *0.512*	35 *1.378*	87,77 *3.456*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	E
T34-R45H01E03-10X1.5-65R	10138998	M10	1,5	2,6 *0.102*	15,0 *0.591*	39 *1.535*	97,4 *3.835*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	E

T34-R45HE

Blind holes – Metric coarse threads

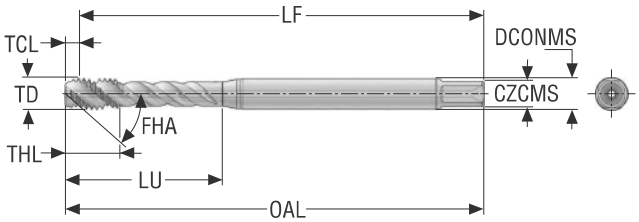


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H01E06-12X1.75-65R	10138999	M12	1,75	3,18 *0.125*	18,0 *0.709*	83 *3.268*	106,82 *4.206*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	E
T34-R45H01E06-14X2-65R	10139000	M14	2,0	3,65 *0.144*	20,0 *0.787*	81 *3.189*	106,35 *4.187*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	4	E
T34-R45H01E06-16X2-65R	10139001	M16	2,0	3,75 *0.148*	20,0 *0.787*	68 *2.677*	106,25 *4.183*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	E

T34A-R45HC

Blind holes – Metric coarse threads

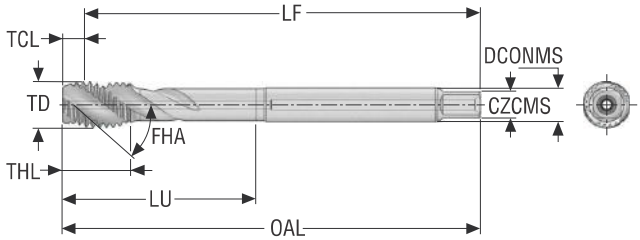


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34A-R45H01C03-5X0.8-65R	10138984	M5	0,8	1,94 *0.076*	8,0 *0.315*	25 *0.984*	68,06 *2.680*	70,0 *2.756*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	C
T34A-R45H01C03-6X1-65R	10138985	M6	1,0	2,32 *0.091*	10,0 *0.394*	30 *1.181*	77,68 *3.058*	80,0 *3.150*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	3	C
T34A-R45H01C03-8X1.25-65R	10138986	M8	1,25	3,16 *0.124*	13,0 *0.512*	35 *1.378*	86,84 *3.419*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,8 *0.268*	3	C
T34A-R45H01C05-10X1.5-65R	10138987	M10	1,5	3,81 *0.150*	17,0 *0.669*	39 *1.535*	96,19 *3.787*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T34A-R45HC

Blind holes – Metric coarse threads

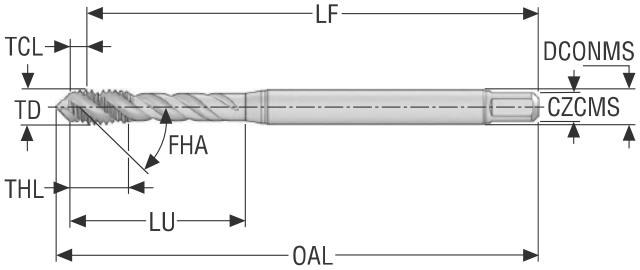


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34A-R45H01C06-12X1.75-65R	10138988	M12	1,75	4,47 *0.176*	18,0 *0.709*	83 *3.268*	105,53 *4.155*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,2 *0.402*	3	C
T34A-R45H01C06-14X2-65R	10138989	M14	2,0	5,11 *0.201*	20,0 *0.787*	81 *3.189*	104,89 *4.130*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,0 *0.472*	4	C
T34A-R45H01C06-16X2-65R	10138990	M16	2,0	5,21 *0.205*	20,0 *0.787*	68 *2.677*	104,79 *4.126*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,0 *0.551*	4	C

T34-R45HC

Blind holes – MF threads

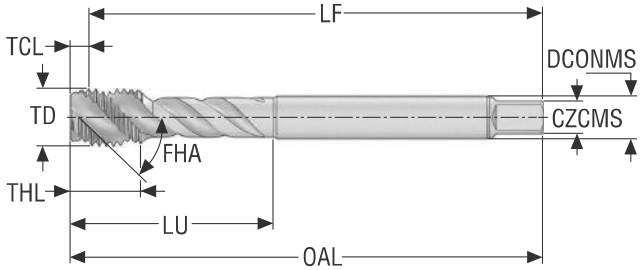


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H02C03-3X0.35-65R	10139002	MF3X0.35	0,35	0,7 *0.028*	5,0 *0.197*	18 *0.709*	55,3 *2.177*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,65 *0.104*	3	C
T34-R45H02C03-3.5X0.35-65R	10139003	MF3.5X0.35	0,35	0,69 *0.027*	5,0 *0.197*	20 *0.787*	55,31 *2.178*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	3,15 *0.124*	3	C
T34-R45H02C03-4X0.5-65R	10139004	MF4X0.5	0,5	1,31 *0.052*	7,0 *0.276*	21 *0.827*	61,69 *2.429*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,5 *0.138*	3	C
T34-R45H02C03-5X0.5-65R	10139005	MF5X0.5	0,5	1,2 *0.047*	8,0 *0.315*	25 *0.984*	68,8 *2.709*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,5 *0.177*	3	C
T34-R45H02C03-6X0.5-65R	10139006	MF6X0.5	0,5	1,22 *0.048*	10,0 *0.394*	30 *1.181*	78,78 *3.102*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,5 *0.217*	3	C
T34-R45H02C03-6X0.75-65R	10139007	MF6X0.75	0,75	1,77 *0.070*	10,0 *0.394*	30 *1.181*	78,23 *3.080*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,2 *0.205*	3	C
T34-R45H02C03-8X0.75-65R	10139008	MF8X0.75	0,75	2,07 *0.081*	10,0 *0.394*	30 *1.181*	77,93 *3.068*	81,7 *3.217*	8,0 *0.315*	8.00X6.20	7,2 *0.283*	3	C
T34-R45H02C03-8X1-65R	10139009	MF8X1	1,0	2,62 *0.103*	13,0 *0.512*	35 *1.378*	87,38 *3.440*	91,7 *3.610*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	C
T34-R45H02C03-10X0.75-65R	10139011	MF10X0.75	0,75	2,17 *0.085*	13,0 *0.512*	35 *1.378*	87,83 *3.458*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,2 *0.362*	3	C
T34-R45H02C03-10X1-65R	10139012	MF10X1	1,0	2,72 *0.107*	13,0 *0.512*	35 *1.378*	87,28 *3.436*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	C
T34-R45H02C03-10X1.25-65R	10139013	MF10X1.25	1,25	3,26 *0.128*	15,0 *0.591*	39 *1.535*	96,74 *3.809*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	8,8 *0.346*	3	C

T34-R45HC

Blind holes – MF threads

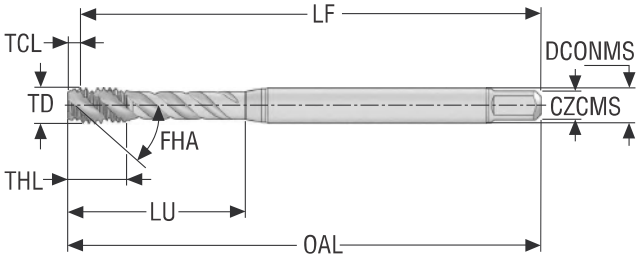


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN374
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H02C05-8X1-65R	10139014	MF8X1	1,0	2,62 *0.103*	10,0 *0.394*	35 *1.378*	87,38 *3.440*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	C
T34-R45H02C05-10X1-65R	10139015	MF10X1	1,0	2,62 *0.103*	10,0 *0.394*	35 *1.378*	87,38 *3.440*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	C
T34-R45H02C05-12X1-65R	10139016	MF12X1	1,0	2,83 *0.111*	10,0 *0.394*	73 *2.874*	97,17 *3.826*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,0 *0.433*	3	C
T34-R45H02C05-12X1.25-65R	10139017	MF12X1.25	1,25	3,38 *0.133*	15,0 *0.591*	73 *2.874*	96,62 *3.804*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,8 *0.425*	3	C
T34-R45H02C05-12X1.5-65R	10139018	MF12X1.5	1,5	3,93 *0.155*	15,0 *0.591*	73 *2.874*	96,07 *3.782*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	C
T34-R45H02C05-14X1.5-65R	10139019	MF14X1.5	1,5	4,03 *0.159*	15,0 *0.591*	71 *2.795*	95,97 *3.778*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	4	C
T34-R45H02C05-16X1.5-65R	10139020	MF16X1.5	1,5	4,13 *0.163*	15,0 *0.591*	58 *2.283*	95,87 *3.774*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	C
T34-R45H02C05-18X1.5-65R	10139021	MF18X1.5	1,5	4,13 *0.163*	17,0 *0.669*	66 *2.598*	105,87 *4.168*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	C
T34-R45H02C05-20X1.5-65R	10139022	MF20X1.5	1,5	4,13 *0.163*	17,0 *0.669*	80 *3.150*	120,87 *4.759*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	18,5 *0.728*	4	C
T34-R45H02C05-22X1.5-65R	10139023	MF22X1.5	1,5	4,13 *0.163*	17,0 *0.669*	78 *3.071*	120,87 *4.759*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	20,5 *0.807*	4	C
T34-R45H02C05-24X1.5-65R	10139024	MF24X1.5	1,5	4,25 *0.167*	20,0 *0.787*	93 *3.661*	135,75 *5.344*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	22,5 *0.886*	4	C

T34-R45HE

Blind holes – MF threads

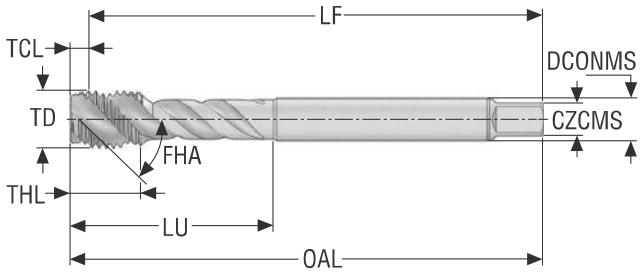


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H02E03-8X1-65R	10139032	MF8X1	1,0	1,87 *0.074*	13,0 *0.512*	35 *1.378*	88,13 *3.470*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	E
T34-R45H02E03-10X1-65R	10139033	MF10X1	1,0	1,97 *0.078*	13,0 *0.512*	35 *1.378*	88,03 *3.466*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	E

T34-R45HE

Blind holes – MF threads

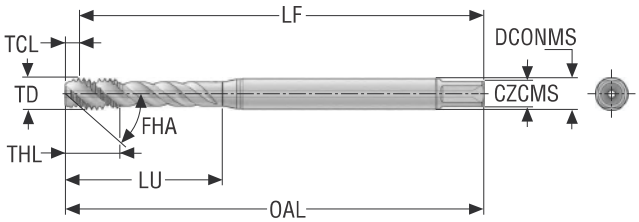


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN374
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H02E05-8X1-65R	10139034	MF8X1	1,0	1,87 *0.074*	10,0 *0.394*	35 *1.378*	88,13 *3.470*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	E
T34-R45H02E05-10X1-65R	10139035	MF10X1	1,0	1,87 *0.074*	10,0 *0.394*	35 *1.378*	88,13 *3.470*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	E
T34-R45H02E05-12X1.5-65R	10139036	MF12X1.5	1,5	2,81 *0.111*	15,0 *0.591*	73 *2.874*	97,19 *3.826*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	E
T34-R45H02E05-14X1.5-65R	10139037	MF14X1.5	1,5	3,01 *0.119*	15,0 *0.591*	71 *2.795*	96,99 *3.819*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	4	E
T34-R45H02E05-16X1.5-65R	10139038	MF16X1.5	1,5	3,01 *0.119*	15,0 *0.591*	58 *2.283*	96,99 *3.819*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	E

T34A-R45HC

Blind holes – MF threads

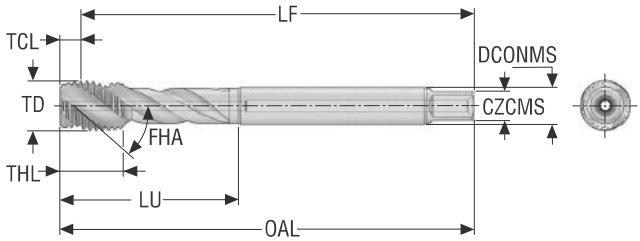


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34A-R45H02C03-8X1-65R	10139025	MF8X1	1,0	2,62 *0.103*	13,0 *0.512*	35 *1.378*	87,38 *3.440*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	C
T34A-R45H02C03-10X1-65R	10139026	MF10X1	1,0	2,72 *0.107*	13,0 *0.512*	35 *1.378*	87,28 *3.436*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	C

T34A-R45HC

Blind holes – MF threads

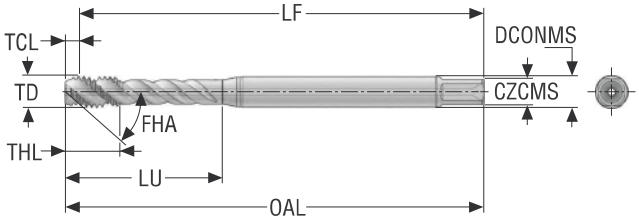


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN374
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34A-R45H02C05-8X1-65R	10139027	MF8X1	1,0	2,62 *0.103*	10,0 *0.394*	35 *1.378*	87,38 *3.440*	90,0 *3.543*	6,0 *0.236*	6.00X4.90	7,0 *0.276*	3	C
T34A-R45H02C05-10X1-65R	10139028	MF10X1	1,0	2,62 *0.103*	10,0 *0.394*	35 *1.378*	87,38 *3.440*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,0 *0.354*	3	C
T34A-R45H02C05-12X1.5-65R	10139029	MF12X1.5	1,5	3,93 *0.155*	15,0 *0.591*	73 *2.874*	96,07 *3.782*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	C
T34A-R45H02C05-14X1.5-65R	10139030	MF14X1.5	1,5	4,03 *0.159*	15,0 *0.591*	71 *2.795*	95,97 *3.778*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	4	C
T34A-R45H02C05-16X1.5-65R	10139031	MF16X1.5	1,5	4,13 *0.163*	15,0 *0.591*	58 *2.283*	95,87 *3.774*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	C

T34A-R45HE

Blind holes – MF threads

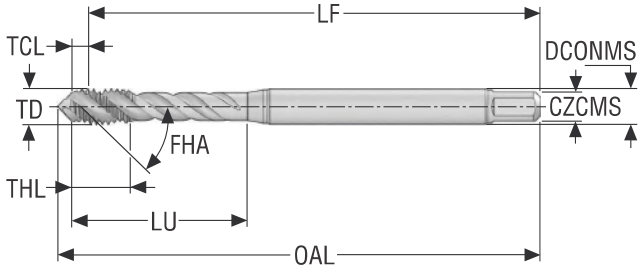


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6HX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34A-R45H02E03-8X1-65R	10139039	MF8X1	1,0	1,87 *0.074*	13,0 *0.512*	35 *1.378*	88,13 *3.470*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	7,0 *0.276*	3	E
T34A-R45H02E03-10X1-65R	10139040	MF10X1	1,0	1,97 *0.078*	13,0 *0.512*	35 *1.378*	88,03 *3.466*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	9,0 *0.354*	3	E

T34-R45HC

Blind holes – UNC threads

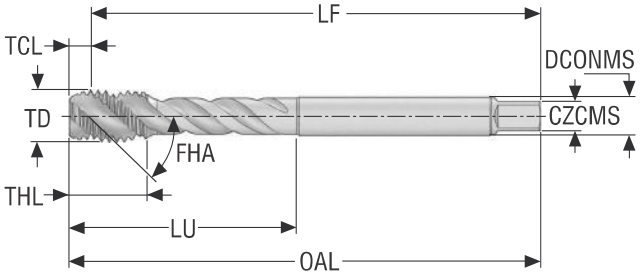


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2BX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H08C03-4-40-22R	10139054	UNC4-40	2,845 *0.112*	*40.0*	1,48 *0.058*	5,0 *0.197*	18 *0.709*	54,52 *2.146*	56,0 *2.205*	3,5 *0.138*	3.50X2.70	2,35 *0.093*	3	C
T34-R45H08C03-5-40-22R	10139055	UNC5-40	3,175 *0.125*	*40.0*	1,53 *0.060*	7,0 *0.276*	18 *0.709*	54,47 *2.144*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,65 *0.104*	3	C
T34-R45H08C03-6-32-22R	10139056	UNC6-32	3,505 *0.138*	*32.0*	1,95 *0.077*	6,0 *0.236*	20 *0.787*	54,05 *2.128*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,85 *0.112*	3	C
T34-R45H08C03-8-32-22R	10139057	UNC8-32	4,166 *0.164*	*32.0*	1,89 *0.074*	7,0 *0.276*	21 *0.827*	61,11 *2.406*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,5 *0.138*	3	C
T34-R45H08C03-10-24-22R	10139058	UNC10-24	4,826 *0.190*	*24.0*	2,53 *0.100*	8,0 *0.315*	25 *0.984*	67,47 *2.656*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	3,9 *0.154*	3	C
T34-R45H08C03-12-24-22R	10139059	UNC12-24	5,486 *0.216*	*24.0*	2,47 *0.097*	10,0 *0.394*	30 *1.181*	77,53 *3.052*	82,2 *3.236*	6,0 *0.236*	6.00X4.90	4,5 *0.177*	3	C
T34-R45H08C03-1/4-20-22R	10139060	UNC1/4-20	6,35 *0.250*	*20.0*	2,94 *0.116*	13,0 *0.512*	32 *1.260*	77,06 *3.034*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,1 *0.201*	3	C
T34-R45H08C03-5/16-18-22R	10139061	UNC5/16-18	7,937 *0.312*	*18.0*	3,59 *0.141*	13,0 *0.512*	35 *1.378*	86,41 *3.402*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,6 *0.260*	3	C
T34-R45H08C03-3/8-16-22R	10139062	UNC3/8-16	9,525 *0.375*	*16.0*	4,03 *0.159*	15,0 *0.591*	39 *1.535*	95,97 *3.778*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,0 *0.315*	3	C

T34-R45HC

Blind holes – UNC threads

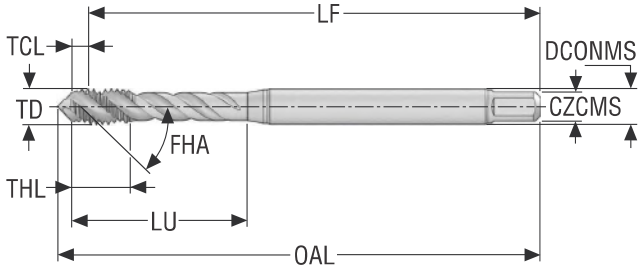


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 2BX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H08C06-7/16-14-22R	10139063	UNC7/16-14	11,112 *0.437*	*14.0*	4,65 *0.183*	15,0 *0.591*	76 *2.992*	95,35 *3.754*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,3 *0.366*	3	C
T34-R45H08C06-1/2-13-22R	10139064	UNC1/2-13	12,7 *0.500*	*13.0*	4,99 *0.196*	18,0 *0.709*	83 *3.268*	105,01 *4.134*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	10,7 *0.421*	4	C
T34-R45H08C06-9/16-12-22R	10139065	UNC9/16-12	14,287 *0.562*	*12.0*	5,43 *0.214*	20,0 *0.787*	81 *3.189*	104,57 *4.117*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,3 *0.484*	4	C
T34-R45H08C06-5/8-11-22R	10139066	UNC5/8-11	15,875 *0.625*	*11.0*	5,87 *0.231*	22,0 *0.866*	68 *2.677*	104,13 *4.100*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	13,5 *0.531*	4	C

T34-R45HC

Blind holes – UNF threads

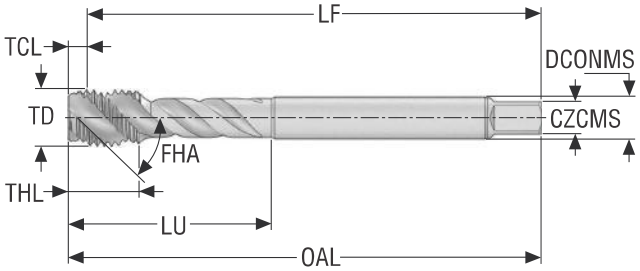


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2BX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H09C03-4-48-22R	10139067	UNF4-48	2,845 *0.112*	*48.0*	1,29 *0.051*	5,0 *0.197*	18 *0.709*	54,71 *2.154*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,4 *0.094*	3	C
T34-R45H09C03-5-44-22R	10139068	UNF5-44	3,175 *0.125*	*44.0*	1,35 *0.053*	7,0 *0.276*	18 *0.709*	54,65 *2.152*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,7 *0.106*	3	C
T34-R45H09C03-6-40-22R	10139073	UNF6-40	3,505 *0.138*	*40.0*	1,59 *0.063*	6,0 *0.236*	20 *0.787*	54,41 *2.142*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	2,95 *0.116*	3	C
T34-R45H09C03-8-36-22R	10139074	UNF8-36	4,166 *0.164*	*36.0*	1,71 *0.067*	7,0 *0.276*	21 *0.827*	61,29 *2.413*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,5 *0.138*	3	C
T34-R45H09C03-10-32-22R	10139075	UNF10-32	4,826 *0.190*	*32.0*	2,0 *0.079*	8,0 *0.315*	25 *0.984*	68,0 *2.677*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,1 *0.161*	3	C
T34-R45H09C03-12-28-22R	10139076	UNF12-28	5,486 *0.216*	*28.0*	2,11 *0.083*	10,0 *0.394*	30 *1.181*	77,89 *3.067*	82,2 *3.236*	6,0 *0.236*	6.00X4.90	4,6 *0.181*	3	C
T34-R45H09C03-1/4-28-22R	10139077	UNF1/4-28	6,35 *0.250*	*28.0*	2,23 *0.088*	10,0 *0.394*	30 *1.181*	77,77 *3.062*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,5 *0.217*	3	C
T34-R45H09C03-5/16-24-22R	10139078	UNF5/16-24	7,937 *0.312*	*24.0*	2,87 *0.113*	13,0 *0.512*	35 *1.378*	87,13 *3.430*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,9 *0.272*	3	C
T34-R45H09C03-3/8-24-22R	10139079	UNF3/8-24	9,525 *0.375*	*24.0*	2,96 *0.117*	15,0 *0.591*	35 *1.378*	87,04 *3.427*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	8,5 *0.335*	3	C

T34-R45HC

Blind holes – UNF threads

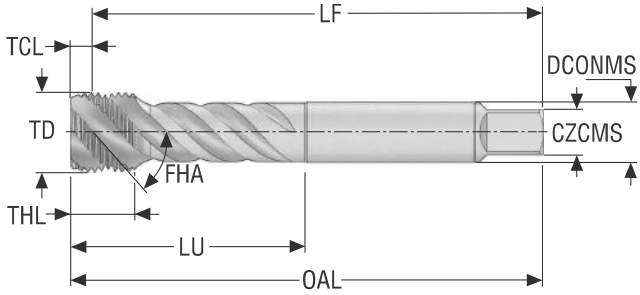


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN374
- Thread tolerance class: 2BX
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H09C05-7/16-20-22R	10139080	UNF7/16-20	11,112 *0.437*	*20.0*	3,39 *0.133*	15,0 *0.591*	76 *2.992*	96,61 *3.804*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	9,9 *0.390*	3	C
T34-R45H09C05-1/2-20-22R	10139081	UNF1/2-20	12,7 *0.500*	*20.0*	3,56 *0.140*	15,0 *0.591*	73 *2.874*	96,44 *3.797*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,5 *0.453*	4	C
T34-R45H09C05-9/16-18-22R	10139082	UNF9/16-18	14,287 *0.562*	*18.0*	3,86 *0.152*	15,0 *0.591*	71 *2.795*	96,14 *3.785*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,0 *0.512*	4	C
T34-R45H09C05-5/8-18-22R	10139083	UNF5/8-18	15,875 *0.625*	*18.0*	3,91 *0.154*	15,0 *0.591*	58 *2.283*	96,09 *3.783*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	C

T34-R45HC

Blind holes – G threads

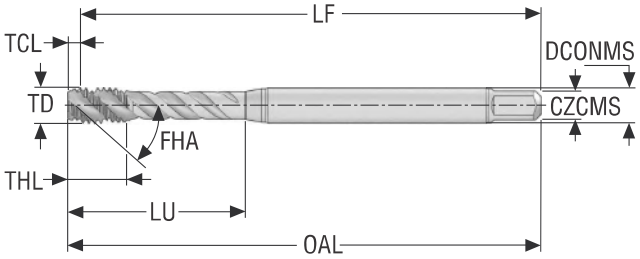


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN5156
- Thread tolerance class: NORMAL-X
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H21C09-1/8-28-12R	10139084	G1/8	9,728 *0.383*	*28.0*	2,43 *0.096*	10,0 *0.394*	36 *1.417*	87,57 *3.448*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	8,8 *0.346*	3	C
T34-R45H21C09-1/4-19-12R	10139085	G1/4	13,157 *0.518*	*19.0*	3,66 *0.144*	14,0 *0.551*	71 *2.795*	96,34 *3.793*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	11,8 *0.465*	3	C
T34-R45H21C09-3/8-19-12R	10139086	G3/8	16,662 *0.656*	*19.0*	3,67 *0.144*	15,0 *0.591*	58 *2.283*	96,33 *3.793*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	15,25 *0.600*	4	C
T34-R45H21C09-1/2-14-12R	10139087	G1/2	20,955 *0.825*	*14.0*	4,93 *0.194*	17,0 *0.669*	80 *3.150*	120,07 *4.727*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,0 *0.748*	4	C
T34-R45H21C09-5/8-14-12R	10139088	G5/8	22,911 *0.902*	*14.0*	5,06 *0.199*	20,0 *0.787*	78 *3.071*	119,94 *4.722*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	21,0 *0.827*	4	C
T34-R45H21C09-3/4-14-12R	10139089	G3/4	26,441 *1.041*	*14.0*	5,05 *0.199*	20,0 *0.787*	73 *2.874*	134,95 *5.313*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	24,5 *0.965*	4	C
T34-R45H21C09-7/8-14-12R	10139090	G7/8	30,201 *1.189*	*14.0*	4,98 *0.196*	22,0 *0.866*	85 *3.346*	145,02 *5.709*	150,0 *5.906*	22,0 *0.866*	22.00X18.00	28,25 *1.112*	4	C
T34-R45H21C09-1-11-12R	10139091	G1	33,249 *1.309*	*11.0*	6,56 *0.258*	24,0 *0.945*	93 *3.661*	153,44 *6.041*	160,0 *6.299*	25,0 *0.984*	25.00X20.00	30,75 *1.211*	4	C

T34-R45HE

Blind holes – EGM threads

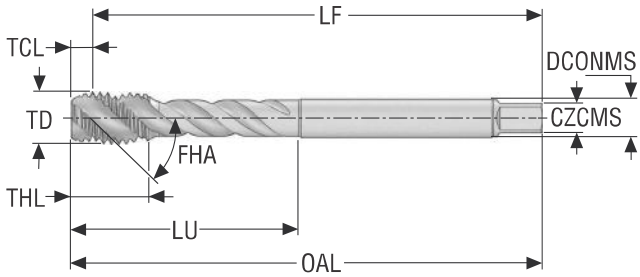


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 6H mod.
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H04E03-2X0.4-64R	10139092	EGM2	0,4	0,73 *0.029*	5,0 *0.197*	14 *0.551*	49,27 *1.940*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,1 *0.083*	2	E
T34-R45H04E03-2.5X0.45-64R	10139093	EGM2.5	0,45	0,75 *0.030*	5,0 *0.197*	18 *0.709*	55,25 *2.175*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,65 *0.104*	3	E
T34-R45H04E03-3X0.5-64R	10139094	EGM3	0,5	0,83 *0.033*	5,0 *0.197*	21 *0.827*	62,17 *2.448*	63,0 *2.480*	4,5 *0.177*	4.50X3.40	3,15 *0.124*	3	E
T34-R45H04E03-4X0.7-64R	10139095	EGM4	0,7	1,15 *0.045*	8,0 *0.315*	25 *0.984*	68,85 *2.711*	70,0 *2.756*	6,0 *0.236*	6.00X4.90	4,2 *0.165*	3	E
T34-R45H04E03-5X0.8-64R	10139096	EGM5	0,8	1,19 *0.047*	10,0 *0.394*	30 *1.181*	78,81 *3.103*	80,0 *3.150*	6,0 *0.236*	6.00X4.90	5,25 *0.207*	3	E
T34-R45H04E03-6X1-64R	10139097	EGM6	1,0	1,81 *0.071*	10,0 *0.394*	35 *1.378*	88,19 *3.472*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,3 *0.248*	3	E
T34-R45H04E03-8X1.25-64R	10139098	EGM8	1,25	2,2 *0.087*	13,0 *0.512*	39 *1.535*	97,8 *3.850*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,4 *0.331*	3	E

T34-R45HE

Blind holes – EGM threads

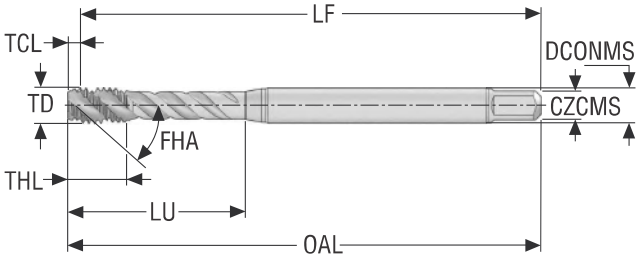


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 6H mod.
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H04E06-10X1.5-64R	10139111	EGM10	1,5	2,83 *0.111*	15,0 *0.591*	73 *2.874*	97,17 *3.826*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,5 *0.413*	3	E
T34-R45H04E06-12X1.75-64R	10139112	EGM12	1,75	3,21 *0.126*	20,0 *0.787*	81 *3.189*	106,79 *4.204*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	12,5 *0.492*	4	E
T34-R45H04E06-14X2-64R	10139113	EGM14	2,0	3,67 *0.144*	20,0 *0.787*	68 *2.677*	106,33 *4.186*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,5 *0.571*	4	E
T34-R45H04E06-16X2-64R	10139114	EGM16	2,0	3,67 *0.144*	20,0 *0.787*	81 *3.189*	121,33 *4.777*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	E
T34-R45H04E06-18X2.5-64R	10139115	EGM18	2,5	4,45 *0.175*	27,0 *1.063*	93 *3.661*	135,55 *5.337*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	18,75 *0.738*	4	E
T34-R45H04E06-20X2.5-64R	10139116	EGM20	2,5	4,55 *0.179*	30,0 *1.181*	113 *4.449*	155,45 *6.120*	160,0 *6.299*	18,0 *0.709*	18.00X14.50	20,75 *0.817*	4	E

T34-R45HE

Blind holes – EGUNC threads

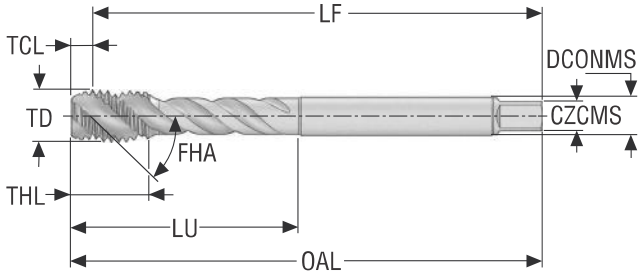


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2B
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H16E03-4-40-21R	10139099	EGUNC4-40	3,67 *0.144*	*40.0*	1,0 *0.039*	7,0 *0.276*	21 *0.827*	62,0 *2.441*	63,0 *2.480*	4,5 *0.177*	4.50X3.40	3,1 *0.122*	3	E
T34-R45H16E03-6-32-21R	10139100	EGUNC6-32	4,536 *0.179*	*32.0*	1,32 *0.052*	8,0 *0.315*	25 *0.984*	68,68 *2.704*	70,0 *2.756*	6,0 *0.236*	6.00X4.90	3,8 *0.150*	3	E
T34-R45H16E03-8-32-21R	10139101	EGUNC8-32	5,197 *0.205*	*32.0*	1,32 *0.052*	10,0 *0.394*	30 *1.181*	78,68 *3.098*	80,0 *3.150*	6,0 *0.236*	6.00X4.90	4,4 *0.173*	3	E
T34-R45H16E03-10-24-21R	10139102	EGUNC10-24	6,2 *0.244*	*24.0*	1,64 *0.065*	12,0 *0.472*	30 *1.181*	78,36 *3.085*	80,0 *3.150*	7,0 *0.276*	7.00X5.50	5,2 *0.205*	3	E
T34-R45H16E03-1/4-20-21R	10139103	EGUNC1/4-20	8,001 *0.315*	*20.0*	2,29 *0.090*	15,0 *0.591*	35 *1.378*	87,71 *3.453*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,7 *0.264*	3	E
T34-R45H16E03-5/16-18-21R	10139104	EGUNC5/16-18	9,771 *0.385*	*18.0*	2,5 *0.098*	18,0 *0.709*	39 *1.535*	97,5 *3.839*	100,0 *3.937*	10,0 *0.394*	10.00X8	8,4 *0.331*	3	E

T34-R45HE

Blind holes – EGUNC threads

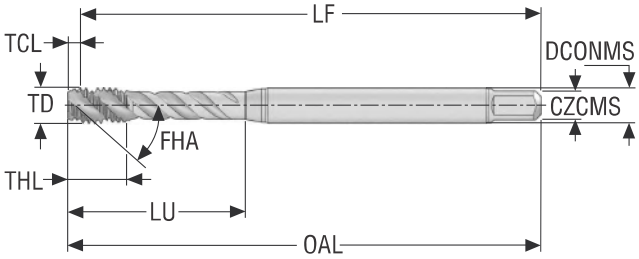


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 2B
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H16E06-3/8-16-21R	10139117	EGUNC3/8-16	11,587 *0.456*	*16.0*	2,99 *0.118*	15,0 *0.591*	73 *2.874*	97,01 *3.819*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	10,0 *0.394*	3	E
T34-R45H16E06-7/16-14-21R	10139118	EGUNC7/16-14	13,47 *0.530*	*14.0*	3,3 *0.130*	18,0 *0.709*	81 *3.189*	106,7 *4.201*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	11,6 *0.457*	3	E
T34-R45H16E06-1/2-13-21R	10139119	EGUNC1/2-13	15,237 *0.600*	*13.0*	3,74 *0.147*	18,0 *0.709*	68 *2.677*	106,26 *4.183*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	13,3 *0.524*	3	E
T34-R45H16E06-9/16-12-21R	10139120	EGUNC9/16-12	17,038 *0.671*	*12.0*	3,6 *0.142*	20,0 *0.787*	68 *2.677*	106,4 *4.189*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	14,9 *0.587*	4	E
T34-R45H16E06-5/8-11-21R	10139121	EGUNC5/8-11	18,875 *0.743*	*11.0*	4,3 *0.169*	20,0 *0.787*	81 *3.189*	120,7 *4.752*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,5 *0.650*	4	E
T34-R45H16E06-3/4-10-21R	10139122	EGUNC3/4-10	22,349 *0.880*	*10.0*	4,8 *0.189*	25,0 *0.984*	93 *3.661*	135,2 *5.323*	140,0 *5.512*	18,0 *0.709*	18.00X14.50	19,75 *0.778*	4	E

T34-R45HE

Blind holes – EGUNF threads

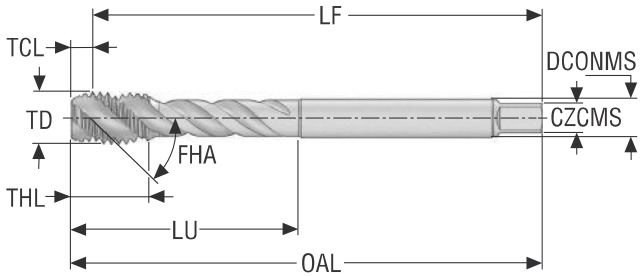


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN371
- Thread tolerance class: 2B
- FHA = 45°
- For cutting data see page(s) 262”

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H17E03-4-48-21R	10139105	EGUNF4-48	3,533 *0.139*	*48.0*	0,83 *0.033*	6,0 *0.236*	20 *0.787*	55,17 *2.172*	56,0 *2.205*	4,0 *0.157*	4.00X3.00	3,0 *0.118*	3	E
T34-R45H17E03-6-40-21R	10139106	EGUNF6-40	4,331 *0.171*	*40.0*	1,12 *0.044*	7,0 *0.276*	25 *0.984*	68,88 *2.712*	70,0 *2.756*	6,0 *0.236*	6.00X4.90	3,7 *0.146*	3	E
T34-R45H17E03-8-36-21R	10139107	EGUNF8-36	5,083 *0.200*	*36.0*	1,32 *0.052*	9,0 *0.354*	30 *1.181*	78,68 *3.098*	80,0 *3.150*	6,0 *0.236*	6.00X4.90	4,4 *0.173*	3	E
T34-R45H17E03-10-32-21R	10139108	EGUNF10-32	5,857 *0.231*	*32.0*	1,23 *0.048*	9,0 *0.354*	30 *1.181*	78,77 *3.101*	80,0 *3.150*	6,0 *0.236*	6.00X4.90	5,1 *0.201*	3	E
T34-R45H17E03-1/4-28-21R	10139109	EGUNF1/4-28	7,529 *0.296*	*28.0*	1,74 *0.069*	10,0 *0.394*	35 *1.378*	88,26 *3.475*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	6,6 *0.260*	3	E
T34-R45H17E03-5/16-24-21R	10139110	EGUNF5/16-24	9,312 *0.367*	*24.0*	2,52 *0.099*	12,0 *0.472*	35 *1.378*	87,48 *3.444*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	8,25 *0.325*	3	E

T34-R45HE

Blind holes – EGUNF threads

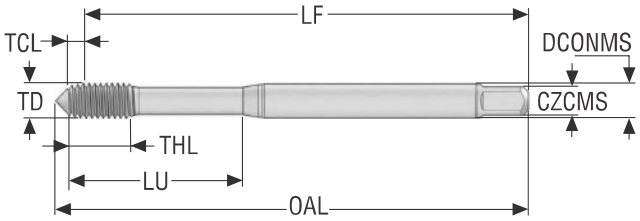


- Substrate: HSSE-PM
- Coating: TiAlN + WC/C
- Standard: DIN376
- Thread tolerance class: 2B
- FHA = 45°
- For cutting data see page(s) 262

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T34-R45H17E06-3/8-24-21R	10139123	EGUNF3/8-24	10,899 *0.429*	*24.0*	2,0 *0.079*	12,0 *0.472*	66 *2.598*	88,0 *3.465*	90,0 *3.543*	8,0 *0.315*	8.00X6.00	9,8 *0.386*	3	E
T34-R45H17E06-7/16-20-21R	10139124	EGUNF7/16-20	12,763 *0.502*	*20.0*	2,5 *0.098*	15,0 *0.591*	73 *2.874*	97,5 *3.839*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,5 *0.453*	3	E
T34-R45H17E06-1/2-20-21R	10139125	EGUNF1/2-20	14,351 *0.565*	*20.0*	2,5 *0.098*	15,0 *0.591*	71 *2.795*	97,5 *3.839*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	13,1 *0.516*	3	E
T34-R45H17E06-9/16-18-21R	10139126	EGUNF9/16-18	16,121 *0.635*	*18.0*	2,58 *0.102*	15,0 *0.591*	58 *2.283*	97,42 *3.835*	100,0 *3.937*	12,0 *0.472*	12.00X9.00	14,7 *0.579*	4	E
T34-R45H17E06-5/8-18-21R	10139127	EGUNF5/8-18	17,709 *0.697*	*18.0*	2,7 *0.106*	15,0 *0.591*	66 *2.598*	107,3 *4.224*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	16,25 *0.640*	4	E
T34-R45H17E06-3/4-16-21R	10139128	EGUNF3/4-16	21,112 *0.831*	*16.0*	3,0 *0.118*	17,0 *0.669*	80 *3.150*	122,0 *4.803*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,5 *0.768*	4	E

T33-FNC

Blind and through holes – Metric coarse threads

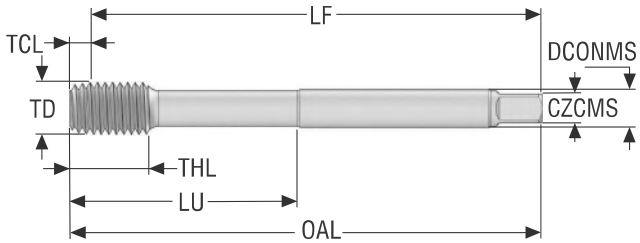


- Substrate: HSSE-PM
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FN01C03-2X0.4-65R	10139189	M2	0,4	1,02 *0.040*	8,0 *0.315*	8 *0.315*	43,98 *1.731*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,85 *0.073*	0	C
T33-FN01C03-2.5X0.45-65R	10139190	M2.5	0,45	1,1 *0.043*	9,0 *0.354*	9 *0.354*	48,9 *1.925*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,33 *0.092*	0	C
T33-FN01C03-3X0.5-65R	10139191	M3	0,5	1,2 *0.047*	10,0 *0.394*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,8 *0.110*	0	C
T33-FN01C03-4X0.7-65R	10139192	M4	0,7	1,6 *0.063*	7,0 *0.276*	21 *0.827*	61,4 *2.417*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,7 *0.146*	0	C
T33-FN01C03-5X0.8-65R	10139193	M5	0,8	2,1 *0.083*	8,0 *0.315*	25 *0.984*	67,9 *2.673*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,65 *0.183*	0	C
T33-FN01C03-6X1-65R	10139195	M6	1,0	2,3 *0.091*	10,0 *0.394*	30 *1.181*	77,7 *3.059*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,6 *0.220*	0	C
T33-FN01C03-8X1.25-65R	10139196	M8	1,25	3,1 *0.122*	13,0 *0.512*	35 *1.378*	86,9 *3.421*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,45 *0.293*	0	C
T33-FN01C03-10X1.5-65R	10139197	M10	1,5	3,5 *0.138*	15,0 *0.591*	39 *1.535*	96,5 *3.799*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	9,35 *0.368*	0	C

T33-FNC

Blind and through holes – Metric coarse threads

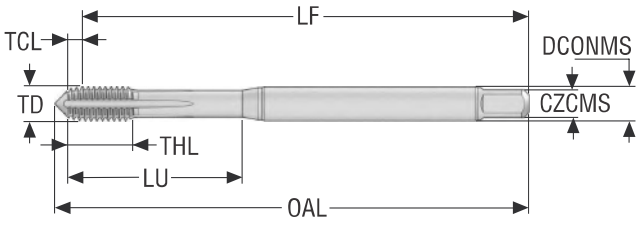


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FN01C06-12X1.75-65R	10139198	M12	1,75	3,7 *0.146*	18,0 *0.709*	83 *3.268*	106,3 *4.185*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	11,25 *0.443*	0	C
T33-FN01C06-14X2-65R	10139199	M14	2,0	4,6 *0.181*	20,0 *0.787*	81 *3.189*	105,4 *4.150*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	13,1 *0.516*	0	C
T33-FN01C06-16X2-65R	10139200	M16	2,0	4,6 *0.181*	20,0 *0.787*	81 *3.189*	105,4 *4.150*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	15,1 *0.594*	0	C
T33-FN01C06-18X2.5-65R	10139201	M18	2,5	5,76 *0.227*	25,0 *0.984*	81 *3.189*	119,24 *4.694*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,85 *0.663*	0	C
T33-FN01C06-20X2.5-65R	10139202	M20	2,5	5,8 *0.228*	25,0 *0.984*	95 *3.740*	134,2 *5.283*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	18,85 *0.742*	0	C

T33-FSNC

Blind and through holes – Metric coarse threads

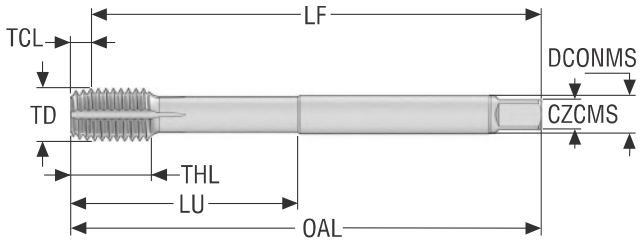


- Substrate: HSSE-PM
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN01C03-2X0.4-65R	10139204	M2	0,4	1,02 *0.040*	8,0 *0.315*	8 *0.315*	43,98 *1.731*	46,3 *1.823*	2,8 *0.110*	2.80X2.10	1,85 *0.073*	3	C
T33-FSN01C03-2.5X0.45-65R	10139205	M2.5	0,45	1,1 *0.043*	9,0 *0.354*	9 *0.354*	48,9 *1.925*	51,7 *2.035*	2,8 *0.110*	2.80X2.10	2,33 *0.092*	3	C
T33-FSN01C03-3X0.5-65R	10139206	M3	0,5	1,2 *0.047*	10,0 *0.394*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,8 *0.110*	3	C
T33-FSN01C03-4X0.7-65R	10139207	M4	0,7	1,6 *0.063*	7,0 *0.276*	21 *0.827*	61,4 *2.417*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,7 *0.146*	5	C
T33-FSN01C03-5X0.8-65R	10139208	M5	0,8	2,1 *0.083*	8,0 *0.315*	25 *0.984*	67,9 *2.673*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,65 *0.183*	5	C
T33-FSN01C03-6X1-65R	10139209	M6	1,0	2,3 *0.091*	10,0 *0.394*	30 *1.181*	77,7 *3.059*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,6 *0.220*	5	C
T33-FSN01C03-8X1.25-65R	10139210	M8	1,25	3,1 *0.122*	13,0 *0.512*	35 *1.378*	86,9 *3.421*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,45 *0.293*	5	C
T33-FSN01C03-10X1.5-65R	10139211	M10	1,5	3,5 *0.138*	15,0 *0.591*	39 *1.535*	96,5 *3.799*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	9,35 *0.368*	5	C

T33-FSNC

Blind and through holes– Metric coarse threads

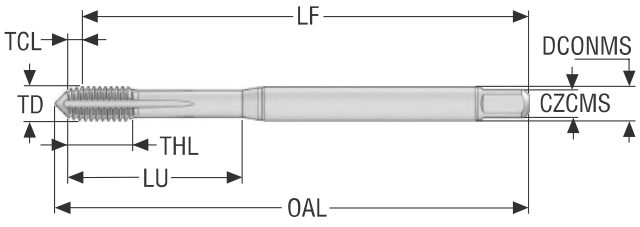


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN01C06-12X1.75-65R	10139212	M12	1,75	3,9 *0.154*	18,0 *0.709*	83 *3.268*	106,1 *4.177*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	11,25 *0.443*	5	C
T33-FSN01C06-14X2-65R	10139213	M14	2,0	4,77 *0.188*	20,0 *0.787*	81 *3.189*	105,23 *4.143*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	13,1 *0.516*	6	C
T33-FSN01C06-16X2-65R	10139214	M16	2,0	4,6 *0.181*	20,0 *0.787*	81 *3.189*	105,4 *4.150*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	15,1 *0.594*	6	C
T33-FSN01C06-18X2.5-65R	10139215	M18	2,5	5,76 *0.227*	25,0 *0.984*	81 *3.189*	119,24 *4.694*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,85 *0.663*	6	C
T33-FSN01C06-20X2.5-65R	10139216	M20	2,5	5,47 *0.215*	25,0 *0.984*	95 *3.740*	134,53 *5.296*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	18,85 *0.742*	6	C

T33-FSNC

Blind and through holes – Metric coarse threads, 6GX

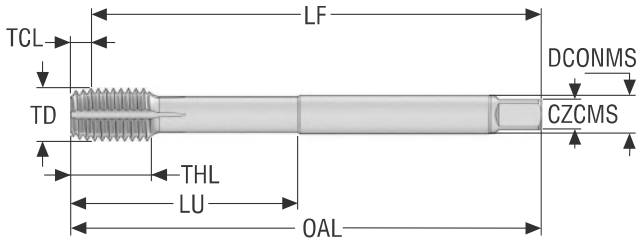


- Substrate: HSSE-PM
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6GX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN01C03-3X0.5-62R	10139258	M3	0,5	1,2 *0.047*	10,0 *0.394*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,8 *0.110*	3	C
T33-FSN01C03-4X0.7-62R	10139259	M4	0,7	1,7 *0.067*	7,0 *0.276*	21 *0.827*	61,3 *2.413*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,7 *0.146*	5	C
T33-FSN01C03-5X0.8-62R	10139260	M5	0,8	2,2 *0.087*	8,0 *0.315*	25 *0.984*	67,8 *2.669*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,65 *0.183*	5	C
T33-FSN01C03-6X1-62R	10139261	M6	1,0	2,3 *0.091*	10,0 *0.394*	30 *1.181*	77,7 *3.059*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,6 *0.220*	5	C
T33-FSN01C03-8X1.25-62R	10139262	M8	1,25	3,2 *0.126*	13,0 *0.512*	35 *1.378*	86,8 *3.417*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,45 *0.293*	5	C
T33-FSN01C03-10X1.5-62R	10139263	M10	1,5	4,4 *0.173*	15,0 *0.591*	39 *1.535*	95,6 *3.764*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	9,35 *0.368*	5	C

T33-FSNC

Blind and through holes – Metric coarse threads, 6GX

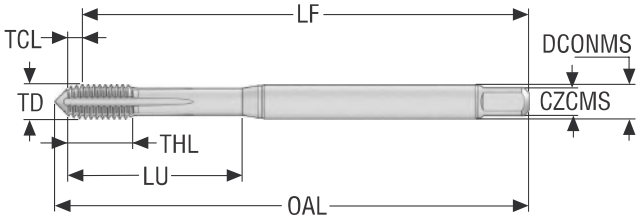


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 6GX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN01C06-12X1.75-62R	10139264	M12	1,75	3,9 *0.154*	18,0 *0.709*	83 *3.268*	106,1 *4.177*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	11,25 *0.443*	5	C
T33-FSN01C06-14X2-62R	10139265	M14	2,0	4,77 *0.188*	20,0 *0.787*	81 *3.189*	105,23 *4.143*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	13,1 *0.516*	6	C
T33-FSN01C06-16X2-62R	10139266	M16	2,0	5,88 *0.231*	20,0 *0.787*	81 *3.189*	104,12 *4.099*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	15,1 *0.594*	6	C
T33-FSN01C06-18X2.5-62R	10139267	M18	2,5	5,47 *0.215*	25,0 *0.984*	81 *3.189*	119,53 *4.706*	125,0 *4.921*	14,0 *0.551*	14.00X11.00	16,85 *0.663*	6	C
T33-FSN01C06-20X2.5-62R	10139268	M20	2,5	6,68 *0.263*	25,0 *0.984*	95 *3.740*	133,32 *5.249*	140,0 *5.512*	16,0 *0.630*	16.00X12.00	18,85 *0.742*	6	C

T33-FSNC

Blind and through holes – MF threads

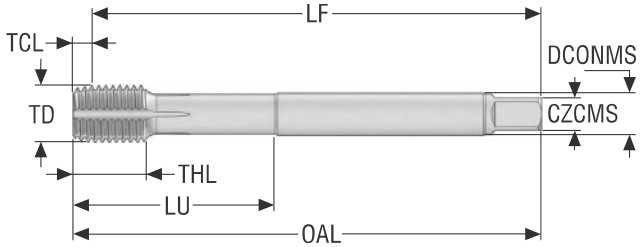


- Substrate: HSSE-PM
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN02C03-4X0.5-65R	10139217	MF4X0.5	0,5	1,4 *0.055*	7,0 *0.276*	21 *0.827*	61,6 *2.425*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,8 *0.150*	5	C
T33-FSN02C03-5X0.5-65R	10139218	MF5X0.5	0,5	1,2 *0.047*	8,0 *0.315*	25 *0.984*	68,8 *2.709*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,8 *0.189*	5	C
T33-FSN02C03-6X0.5-65R	10139219	MF6X0.5	0,5	1,35 *0.053*	10,0 *0.394*	30 *1.181*	78,65 *3.096*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,8 *0.228*	5	C
T33-FSN02C03-6X0.75-65R	10139220	MF6X0.75	0,75	1,8 *0.071*	10,0 *0.394*	30 *1.181*	78,2 *3.079*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,7 *0.224*	5	C
T33-FSN02C03-8X1-65R	10139221	MF8X1	1,0	2,25 *0.089*	13,0 *0.512*	35 *1.378*	87,75 *3.455*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,6 *0.299*	5	C
T33-FSN02C03-10X1-65R	10139222	MF10X1	1,0	2,9 *0.114*	13,0 *0.512*	35 *1.378*	87,1 *3.429*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,6 *0.378*	5	C
T33-FSN02C03-10X1.25-65R	10139223	MF10X1.25	1,25	3,1 *0.122*	15,0 *0.591*	39 *1.535*	96,9 *3.815*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	9,45 *0.372*	5	C

T33-FSNC

Blind and through holes – MF threads

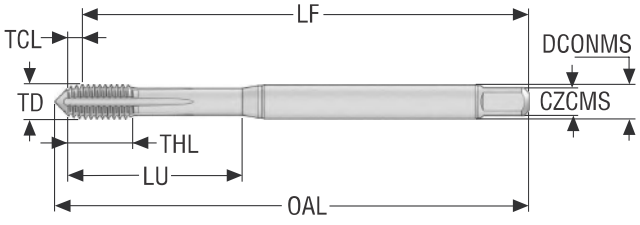


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN374
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN02C05-12X1-65R	10139224	MF12X1	1,0	3,27 *0.129*	10,0 *0.394*	73 *2.874*	96,73 *3.808*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,6 *0.457*	5	C
T33-FSN02C05-12X1.25-65R	10139225	MF12X1.25	1,25	3,96 *0.156*	15,0 *0.591*	73 *2.874*	96,04 *3.781*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,45 *0.451*	5	C
T33-FSN02C05-12X1.5-65R	10139226	MF12X1.5	1,5	4,15 *0.163*	15,0 *0.591*	73 *2.874*	95,85 *3.774*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,35 *0.447*	5	C
T33-FSN02C05-16X1.5-65R	10139227	MF16X1.5	1,5	4,33 *0.170*	15,0 *0.591*	71 *2.795*	95,67 *3.767*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	15,35 *0.604*	6	C
T33-FSN02C05-18X1.5-65R	10139228	MF18X1.5	1,5	4,4 *0.173*	17,0 *0.669*	66 *2.598*	105,6 *4.157*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	17,35 *0.683*	6	C
T33-FSN02C05-20X1.5-65R	10139229	MF20X1.5	1,5	4,6 *0.181*	17,0 *0.669*	80 *3.150*	120,4 *4.740*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,35 *0.762*	6	C

T33-FSNC

Blind and through holes – UNC threads

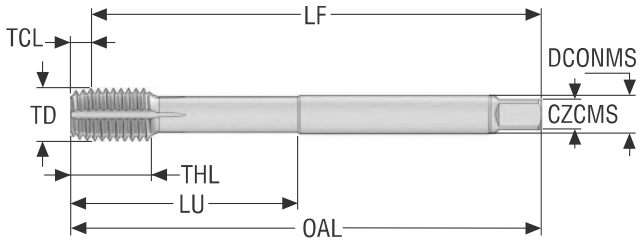


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 2BX
- For cutting data see page(s) 264

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN08C03-5-40-22R	10139230	UNC5-40	3,175 *0.125*	*40.0*	1,6 *0.063*	7,0 *0.276*	18 *0.709*	54,4 *2.142*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,9 *0.114*	3	C
T33-FSN08C03-6-32-22R	10139231	UNC6-32	3,505 *0.138*	*32.0*	1,8 *0.071*	6,0 *0.236*	20 *0.787*	54,2 *2.134*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	3,15 *0.124*	3	C
T33-FSN08C03-8-32-22R	10139232	UNC8-32	4,166 *0.164*	*32.0*	2,0 *0.079*	7,0 *0.276*	21 *0.827*	61,0 *2.402*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,8 *0.150*	5	C
T33-FSN08C03-10-24-22R	10139233	UNC10-24	4,826 *0.190*	*24.0*	2,7 *0.106*	8,0 *0.315*	25 *0.984*	67,3 *2.650*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,35 *0.171*	5	C
T33-FSN08C03-12-24-22R	10139234	UNC12-24	5,486 *0.216*	*24.0*	2,7 *0.106*	10,0 *0.394*	30 *1.181*	77,3 *3.043*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,0 *0.197*	5	C
T33-FSN08C03-1/4-20-22R	10139235	UNC1/4-20	6,35 *0.250*	*20.0*	3,9 *0.154*	13,0 *0.512*	30 *1.181*	76,1 *2.996*	80,0 *3.150*	7,0 *0.276*	7.00X5.50	5,75 *0.226*	5	C
T33-FSN08C03-5/16-18-22R	10139236	UNC5/16-18	7,937 *0.312*	*18.0*	3,6 *0.142*	13,0 *0.512*	35 *1.378*	86,4 *3.402*	93,3 *3.673*	8,2 *0.323*	8.20X6.20	7,3 *0.287*	5	C
T33-FSN08C03-3/8-16-22R	10139237	UNC3/8-16	9,525 *0.375*	*16.0*	4,74 *0.187*	15,0 *0.591*	39 *1.535*	95,26 *3.750*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	8,8 *0.346*	5	C

T33-FSNC

Blind and through holes– UNC threads

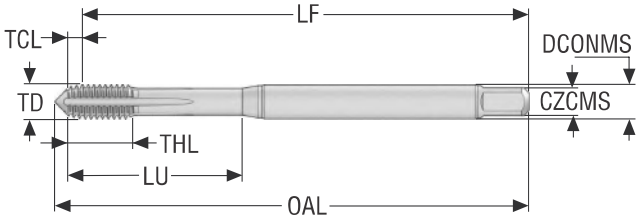


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN376
- Thread tolerance class: 2BX
- For cutting data see page(s) 264

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN08C06-7/16-14-22R	10139238	UNC7/16-14	11,112 *0.437*	*14.0*	5,4 *0.213*	15,0 *0.591*	76 *2.992*	94,6 *3.724*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	10,25 *0.404*	5	C
T33-FSN08C06-1/2-13-22R	10139239	UNC1/2-13	12,7 *0.500*	*13.0*	5,8 *0.228*	18,0 *0.709*	83 *3.268*	104,2 *4.102*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	11,8 *0.465*	5	C
T33-FSN08C06-5/8-11-22R	10139240	UNC5/8-11	15,875 *0.625*	*11.0*	6,8 *0.268*	20,0 *0.787*	81 *3.189*	103,2 *4.063*	110,0 *4.331*	11,0 *0.433*	11.00X9.00	14,8 *0.583*	6	C

T33-FSNC

Blind and through holes – UNF threads

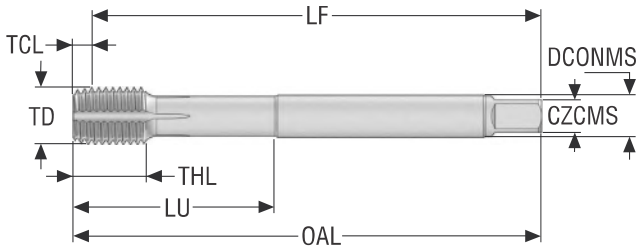


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN371
- Thread tolerance class: 2BX
- For cutting data see page(s) 264

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN09C03-5-44-22R	10139241	UNF5-44	3,175 *0.125*	*44.0*	1,4 *0.055*	7,0 *0.276*	18 *0.709*	54,6 *2.150*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,92 *0.115*	3	C
T33-FSN09C03-6-40-22R	10139242	UNF6-40	3,505 *0.138*	*40.0*	1,6 *0.063*	6,0 *0.236*	20 *0.787*	54,4 *2.142*	57,4 *2.260*	4,0 *0.157*	4.00X3.00	3,22 *0.127*	3	C
T33-FSN09C03-8-36-22R	10139243	UNF8-36	4,166 *0.164*	*36.0*	1,8 *0.071*	7,0 *0.276*	21 *0.827*	61,2 *2.409*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,85 *0.152*	5	C
T33-FSN09C03-10-32-22R	10139244	UNF10-32	4,826 *0.190*	*32.0*	1,9 *0.075*	8,0 *0.315*	25 *0.984*	68,1 *2.681*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,45 *0.175*	5	C
T33-FSN09C03-12-28-22R	10139245	UNF12-28	5,486 *0.216*	*28.0*	1,9 *0.075*	10,0 *0.394*	30 *1.181*	78,1 *3.075*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,1 *0.201*	5	C
T33-FSN09C03-1/4-28-22R	10139246	UNF1/4-28	6,35 *0.250*	*28.0*	2,23 *0.088*	10,0 *0.394*	30 *1.181*	77,77 *3.062*	82,4 *3.244*	7,0 *0.276*	7.00X5.50	5,95 *0.234*	5	C
T33-FSN09C03-5/16-24-22R	10139247	UNF5/16-24	7,937 *0.312*	*24.0*	2,6 *0.102*	13,0 *0.512*	35 *1.378*	87,4 *3.441*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,45 *0.293*	5	C
T33-FSN09C03-3/8-24-22R	10139248	UNF3/8-24	9,525 *0.375*	*24.0*	3,5 *0.138*	15,0 *0.591*	35 *1.378*	86,5 *3.406*	90,0 *3.543*	10,0 *0.394*	10.00X8.00	9,05 *0.356*	5	C

T33-FSNC

Blind and through holes – UNF threads

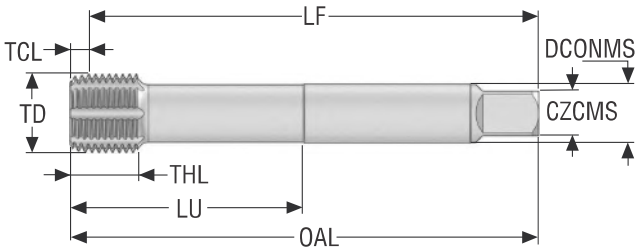


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN374
- Thread tolerance class: 2BX
- For cutting data see page(s) 264

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN09C05-7/16-20-22R	10139249	UNF7/16-20	11,112 *0.437*	*20.0*	3,8 *0.150*	15,0 *0.591*	76 *2.992*	96,2 *3.787*	100,0 *3.937*	8,0 *0.315*	8.00X6.20	10,55 *0.415*	5	C
T33-FSN09C05-1/2-20-22R	10139250	UNF1/2-20	12,7 *0.500*	*20.0*	3,8 *0.150*	15,0 *0.591*	83 *3.268*	106,2 *4.181*	110,0 *4.331*	9,0 *0.354*	9.00X7.00	12,15 *0.478*	5	C
T33-FSN09C05-5/8-18-22R	10139251	UNF5/8-18	15,875 *0.625*	*18.0*	4,7 *0.185*	15,0 *0.591*	68 *2.677*	105,3 *4.146*	110,0 *4.331*	12,0 *0.472*	12.00X9.00	15,25 *0.600*	6	C

T33-FSNC

Blind and through holes – G threads

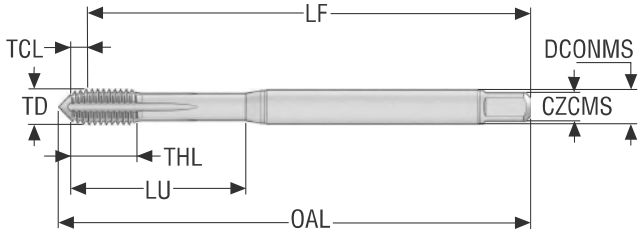


- Substrate: HSSE
- Coating: TiAlN + TiN
- Standard: DIN5156
- Thread tolerance class: NORMAL-X
- For cutting data see page(s) 264

Designation	Item number	TDZ	TD	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm *Inch*	*TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSN21C09-1/8-28-12R	10139252	G1/8	9,728 *0.383*	*28.0*	2,6 *0.102*	10,0 *0.394*	67 *2.638*	87,4 *3.441*	90,0 *3.543*	7,0 *0.276*	7.00X5.50	9,25 *0.364*	5	C
T33-FSN21C09-1/4-19-12R	10139253	G1/4	13,157 *0.518*	*19.0*	3,7 *0.146*	14,0 *0.551*	71 *2.795*	96,3 *3.791*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	12,55 *0.494*	6	C
T33-FSN21C09-3/8-19-12R	10139254	G3/8	16,662 *0.656*	*19.0*	3,85 *0.152*	15,0 *0.591*	71 *2.795*	96,15 *3.785*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	16,05 *0.632*	7	C
T33-FSN21C09-1/2-14-12R	10139255	G1/2	20,955 *0.825*	*14.0*	5,1 *0.201*	17,0 *0.669*	80 *3.150*	119,9 *4.720*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	20,1 *0.791*	7	C
T33-FSN21C09-5/8-14-12R	10139256	G5/8	22,911 *0.902*	*14.0*	5,1 *0.201*	20,0 *0.787*	78 *3.071*	119,9 *4.720*	125,0 *4.921*	18,0 *0.709*	18.00X14.50	22,05 *0.868*	7	C
T33-FSN21C09-3/4-14-12R	10139257	G3/4	26,441 *1.041*	*14.0*	5,1 *0.201*	22,0 *0.866*	73 *2.874*	134,9 *5.311*	140,0 *5.512*	20,0 *0.787*	20.00X16.00	25,6 *1.008*	7	C

T33-FSCC

Blind and through holes – Metric coarse threads

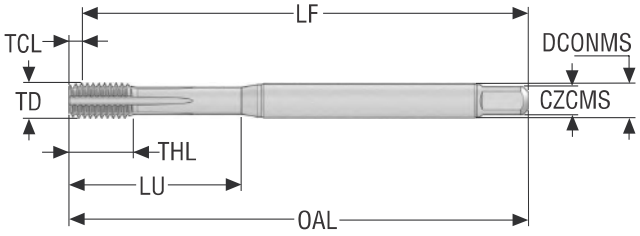


- Substrate: HSSE-PM
- Coating: TiN + TiCN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSC01C03-3X0.5-65R	10139282	M3	0,5	1,2 *0.047*	10,0 *0.394*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,8 *0.110*	3	C
T33-FSC01C03-4X0.7-65R	10139283	M4	0,7	1,6 *0.063*	7,0 *0.276*	21 *0.827*	61,4 *2.417*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,7 *0.146*	5	C
T33-FSC01C03-5X0.8-65R	10139284	M5	0,8	2,1 *0.083*	8,0 *0.315*	25 *0.984*	67,9 *2.673*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,65 *0.183*	5	C
T33-FSC01C03-6X1-65R	10139285	M6	1,0	2,3 *0.091*	10,0 *0.394*	30 *1.181*	77,7 *3.059*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,6 *0.220*	5	C
T33-FSC01C03-8X1.25-65R	10139286	M8	1,25	3,1 *0.122*	13,0 *0.512*	35 *1.378*	86,9 *3.421*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,45 *0.293*	5	C
T33-FSC01C03-10X1.5-65R	10139287	M10	1,5	3,5 *0.138*	15,0 *0.591*	39 *1.535*	96,5 *3.799*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	9,35 *0.368*	5	C

T33-FSCE

Blind and through holes – Metric coarse threads

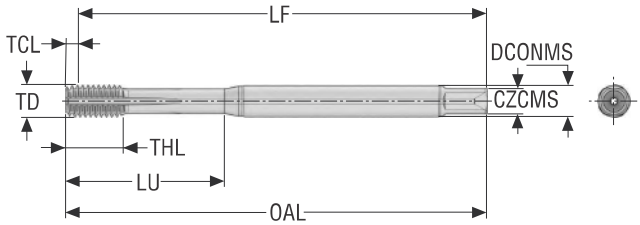


- Substrate: HSSE-PM
- Coating: TiN + TiCN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSC01E03-3X0.5-65R	10139288	M3	0,5	1,2 *0.047*	10,0 *0.394*	18 *0.709*	54,8 *2.157*	57,2 *2.252*	3,5 *0.138*	3.50X2.70	2,8 *0.110*	3	E
T33-FSC01E03-4X0.7-65R	10139289	M4	0,7	1,6 *0.063*	7,0 *0.276*	21 *0.827*	61,4 *2.417*	63,0 *2.480*	4,5 *0.177*	4.50X3.40	3,7 *0.146*	5	E
T33-FSC01E03-5X0.8-65R	10139290	M5	0,8	1,5 *0.059*	8,0 *0.315*	25 *0.984*	68,5 *2.697*	70,0 *2.756*	6,0 *0.236*	6.00X4.90	4,65 *0.183*	5	E

T33A-FSCE

Blind holes – Metric coarse threads

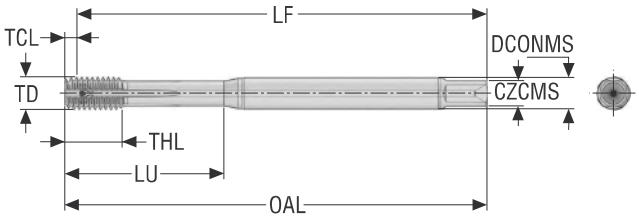


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiN + TiCN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33A-FSC01E03-5X0.8-65R	10139294	M5	0,8	1,7 *0.067*	8,0 *0.315*	25 *0.984*	68,3 *2.689*	70,0 *2.756*	6,0 *0.236*	6.00X4.90	4,65 *0.183*	5	E
T33A-FSC01E03-6X1-65R	10139295	M6	1,0	1,95 *0.077*	10,0 *0.394*	30 *1.181*	78,05 *3.073*	80,0 *3.150*	6,0 *0.236*	6.00X4.90	5,6 *0.220*	5	E
T33A-FSC01E03-8X1.25-65R	10139296	M8	1,25	2,55 *0.100*	13,0 *0.512*	35 *1.378*	87,45 *3.443*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	7,45 *0.293*	5	E
T33A-FSC01E03-10X1.5-65R	10139297	M10	1,5	2,84 *0.112*	15,0 *0.591*	39 *1.535*	97,16 *3.825*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	9,35 *0.368*	5	E

T33B-FSCE

Through holes – Metric coarse threads

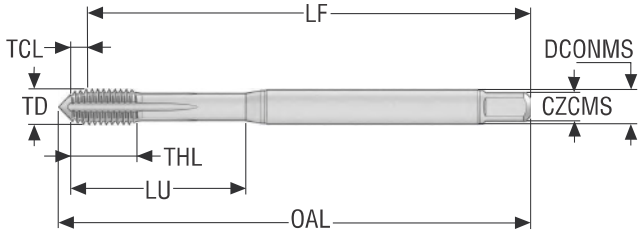


- Internal coolant
- Substrate: HSSE-PM
- Coating: TiN + TiCN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33B-FSC01E03-5X0.8-65R	10139298	M5	0,8	1,57 *0.062*	8,0 *0.315*	25 *0.984*	68,43 *2.694*	70,0 *2.756*	6,0 *0.236*	6.00X4.90	4,65 *0.183*	5	E
T33B-FSC01E03-6X1-65R	10139299	M6	1,0	1,95 *0.077*	10,0 *0.394*	30 *1.181*	78,05 *3.073*	80,0 *3.150*	6,0 *0.236*	6.00X4.90	5,6 *0.220*	5	E
T33B-FSC01E03-8X1.25-65R	10139300	M8	1,25	2,42 *0.095*	13,0 *0.512*	35 *1.378*	87,58 *3.448*	90,0 *3.543*	8,0 *0.315*	8.00X6.20	7,45 *0.293*	5	E
T33B-FSC01E03-10X1.5-65R	10139301	M10	1,5	2,84 *0.112*	15,0 *0.591*	39 *1.535*	97,16 *3.825*	100,0 *3.937*	10,0 *0.394*	10.00X8.00	9,35 *0.368*	5	E

T33-FSCC

Blind and through holes – MF threads

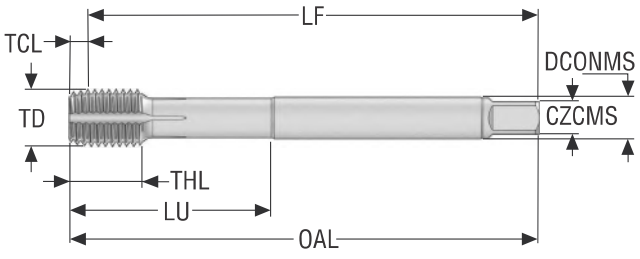


- Substrate: HSSE-PM
- Coating: TiN + TiCN
- Standard: DIN371
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSC02C03-4X0.5-65R	10139269	MF4X0.5	0,5	1,4 *0.055*	7,0 *0.276*	21 *0.827*	61,6 *2.425*	64,6 *2.543*	4,5 *0.177*	4.50X3.40	3,8 *0.150*	5	C
T33-FSC02C03-5X0.5-65R	10139270	MF5X0.5	0,5	1,2 *0.047*	8,0 *0.315*	25 *0.984*	68,8 *2.709*	72,0 *2.835*	6,0 *0.236*	6.00X4.90	4,8 *0.189*	5	C
T33-FSC02C03-6X0.5-65R	10139271	MF6X0.5	0,5	1,35 *0.053*	10,0 *0.394*	30 *1.181*	78,65 *3.096*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,8 *0.228*	5	C
T33-FSC02C03-6X0.75-65R	10139272	MF6X0.75	0,75	1,8 *0.071*	10,0 *0.394*	30 *1.181*	78,2 *3.079*	82,4 *3.244*	6,0 *0.236*	6.00X4.90	5,7 *0.224*	5	C
T33-FSC02C03-8X1-65R	10139273	MF8X1	1,0	2,25 *0.089*	13,0 *0.512*	35 *1.378*	87,75 *3.455*	93,3 *3.673*	8,0 *0.315*	8.00X6.20	7,6 *0.299*	5	C
T33-FSC02C03-10X1-65R	10139274	MF10X1	1,0	2,9 *0.114*	13,0 *0.512*	35 *1.378*	87,1 *3.429*	91,8 *3.614*	10,0 *0.394*	10.00X8.00	9,6 *0.378*	5	C
T33-FSC02C03-10X1.25-65R	10139275	MF10X1.25	1,25	4,0 *0.157*	15,0 *0.591*	39 *1.535*	96,0 *3.780*	101,8 *4.008*	10,0 *0.394*	10.00X8.00	9,45 *0.372*	5	C

T33-FSCC

Blind and through holes – MF threads

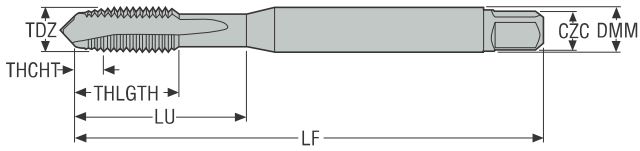


- Substrate: HSSE
- Coating: TiN + TiCN
- Standard: DIN374
- Thread tolerance class: 6HX
- For cutting data see page(s) 264

Designation	Item number	TDZ	Pitch	TCL	THL	LU	LF	OAL	DCONMS	CZCMS	PHDR Ø	NOF	THCHT
			mm	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		mm *Inch*		
T33-FSC02C05-12X1-65R	10139276	MF12X1	1,0	3,27 *0.129*	10,0 *0.394*	73 *2.874*	96,73 *3.808*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,6 *0.457*	5	C
T33-FSC02C05-12X1.25-65R	10139277	MF12X1.25	1,25	3,96 *0.156*	15,0 *0.591*	73 *2.874*	96,04 *3.781*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,45 *0.451*	5	C
T33-FSC02C05-12X1.5-65R	10139278	MF12X1.5	1,5	4,2 *0.165*	15,0 *0.591*	73 *2.874*	95,8 *3.772*	100,0 *3.937*	9,0 *0.354*	9.00X7.00	11,35 *0.447*	5	C
T33-FSC02C05-16X1.5-65R	10139279	MF16X1.5	1,5	4,33 *0.170*	15,0 *0.591*	71 *2.795*	95,67 *3.767*	100,0 *3.937*	11,0 *0.433*	11.00X9.00	15,35 *0.604*	5	C
T33-FSC02C05-18X1.5-65R	10139280	MF18X1.5	1,5	4,4 *0.173*	17,0 *0.669*	66 *2.598*	105,6 *4.157*	110,0 *4.331*	14,0 *0.551*	14.00X11.00	17,35 *0.683*	5	C
T33-FSC02C05-20X1.5-65R	10139281	MF20X1.5	1,5	4,6 *0.181*	17,0 *0.669*	80 *3.150*	120,4 *4.740*	125,0 *4.921*	16,0 *0.630*	16.00X12.00	19,35 *0.762*	5	C

MTP-P001

Through holes

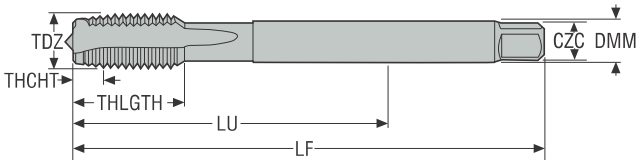


- For cutting data see page(s) 268
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M3X0.50ISO6H-TB-P001	02999886	M3	0,5	–	4,5 *0.177*	12,0 *0.472*	12,0 *0.472*	61,625 *2.426*	2,5 *0.098*	4.50X3.40	3	SECO-DIN	6H	B
MTP-M4X0.70ISO6H-TB-P001	02999887	M4	0,7	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	68,075 *2.680*	3,4 *0.134*	6.00X4.90	3	SECO-DIN	6H	B
MTP-M5X0.80ISO6H-TB-P001	02999888	M5	0,8	–	6,0 *0.236*	15,0 *0.591*	15,0 *0.591*	76,3 *3.004*	4,3 *0.169*	6.00X4.90	3	SECO-DIN	6H	B
MTP-M6X1.00ISO6H-TB-P001	02999889	M6	1,0	–	8,0 *0.315*	18,0 *0.709*	18,0 *0.709*	85,375 *3.361*	5,1 *0.201*	8.00X6.20	3	SECO-DIN	6H	B
MTP-M8X1.25ISO6H-TB-P001	02999890	M8	1,25	–	10,0 *0.394*	20,0 *0.787*	20,0 *0.787*	94,21875 *3.709*	6,8 *0.268*	10.00X8.00	3	SECO-DIN	6H	B
MTP-M10X1.50ISO6H-TB-P001	02999891	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	95,875 *3.775*	8,6 *0.339*	10.00X8.00	3	SECO-DIN	6H	B

MTP-P002

Through holes

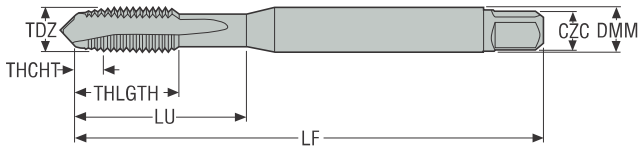


- For cutting data see page(s) 268
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-P002	02999892	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,1875 *4.141*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-P002	02999893	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,5 *4.114*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-P002	02999894	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-P002	02999895	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	112,63 *4.434*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-P002	02999896	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	133,125 *5.241*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	B

MTP-P003

Through holes

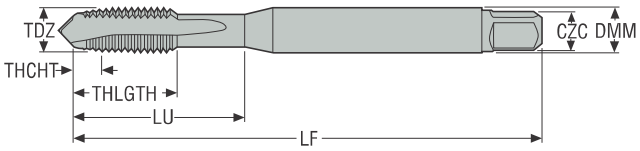


- For cutting data see page(s) 268
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M1X0.25ISO5HX-TB-P003	02999897	M1	0,25	–	2,5 *0.098*	20,0 *0.787*	5,0 *0.197*	38,87 *1.530*	0,75 *0.030*	2.50X2.10	2	DIN371	5HX	B
MTP-M1.2X0.25ISO5HX-TB-P003	02999898	M1.2	0,25	–	2,5 *0.098*	20,0 *0.787*	5,0 *0.197*	38,87 *1.530*	0,95 *0.037*	2.50X2.10	2	DIN371	5HX	B
MTP-M1.4X0.30ISO5HX-TB-P003	02999899	M1.4	0,3	–	2,5 *0.098*	20,0 *0.787*	6,5 *0.256*	38,65 *1.522*	1,1 *0.043*	2.50X2.10	2	DIN371	5HX	B
MTP-M1.6X0.35ISO6HX-TB-P003	02999900	M1.6	0,35	–	2,5 *0.098*	12,5 *0.492*	7,0 *0.276*	38,42 *1.513*	1,3 *0.051*	2.50X2.10	2	DIN371	6HX	B
MTP-M1.8X0.35ISO6HX-TB-P003	02999901	M1.8	0,35	–	2,5 *0.098*	20,0 *0.787*	7,0 *0.276*	38,42 *1.513*	1,5 *0.059*	2.50X2.10	2	DIN371	6HX	B
MTP-M2X0.40ISO6HX-TB-P003	02999902	M2	0,4	–	2,8 *0.110*	9,0 *0.354*	6,0 *0.236*	43,2 *1.701*	1,6 *0.063*	2.80X2.10	2	DIN371	6HX	B
MTP-M2.2X0.45ISO6HX-TB-P003	02999903	M2.2	0,45	–	2,8 *0.110*	12,0 *0.472*	7,0 *0.276*	42,97 *1.692*	1,8 *0.071*	2.80X2.10	2	DIN371	6HX	B
MTP-M2.3X0.40ISO6HX-TB-P003	02999904	M2.3	0,4	–	2,8 *0.110*	12,0 *0.472*	7,0 *0.276*	43,2 *1.701*	1,9 *0.075*	2.80X2.10	2	DIN371	6HX	B
MTP-M2.5X0.45ISO6HX-TB-P003	02999905	M2.5	0,45	–	2,8 *0.110*	12,5 *0.492*	8,0 *0.315*	47,97 *1.889*	2,1 *0.083*	2.80X2.10	2	DIN371	6HX	B
MTP-M2.6X0.45ISO6HX-TB-P003	02999906	M2.6	0,45	–	2,8 *0.110*	12,5 *0.492*	8,0 *0.315*	47,97 *1.889*	2,15 *0.085*	2.80X2.10	2	DIN371	6HX	B
MTP-M3X0.50ISO6HX-TB-P003	02999907	M3	0,5	–	3,5 *0.138*	18,0 *0.709*	8,9 *0.350*	53,6875 *2.114*	2,5 *0.098*	3.50X2.70	3	DIN371	6HX	B
MTP-M3.5X0.60ISO6HX-TB-P003	02999908	M3.5	0,6	–	4,0 *0.157*	20,0 *0.787*	10,8 *0.425*	53,225 *2.095*	2,9 *0.114*	4.00X3.00	3	DIN371	6HX	B
MTP-M4X0.70ISO6HX-TB-P003	02999909	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	11,7 *0.461*	59,7625 *2.353*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	B
MTP-M5X0.80ISO6HX-TB-P003	02999910	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	12,6 *0.496*	66,3 *2.610*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	B
MTP-M6X1.00ISO6HX-TB-P003	02999911	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	14,5 *0.571*	75,375 *2.968*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	B
MTP-M7X1.00ISO6HX-TB-P003	02999912	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	14,5 *0.571*	78,275 *3.082*	6,1 *0.240*	7.00X5.50	3	DIN371	6HX	B
MTP-M8X1.25ISO6HX-TB-P003	02999913	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	17,4 *0.685*	84,21875 *3.316*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.50ISO6HX-TB-P003	02999914	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	19,2 *0.756*	93,0625 *3.664*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	B

MTP-P003-A

Through holes

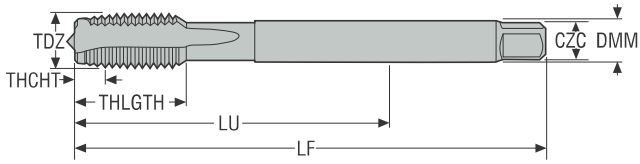


- For cutting data see page(s) 268
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.70ISO6HX-TB-P003-A	02999929	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	11,7 *0.461*	59,73 *2.352*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	B
MTP-M5X0.80ISO6HX-TB-P003-A	02999930	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	12,6 *0.496*	66,35 *2.612*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	B
MTP-M6X1.00ISO6HX-TB-P003-A	02999931	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	14,5 *0.571*	75,51 *2.973*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	B
MTP-M7X1.00ISO6HX-TB-P003-A	02999932	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	14,5 *0.571*	75,51 *2.973*	6,1 *0.240*	7.00X5.50	3	DIN371	6HX	B
MTP-M8X1.25ISO6HX-TB-P003-A	02999933	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	17,4 *0.685*	84,48 *3.326*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.50ISO6HX-TB-P003-A	02999934	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	19,2 *0.756*	93,46 *3.680*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	B

MTP-P004

Through holes

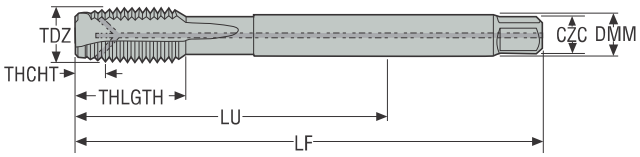


- For cutting data see page(s) 268
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.70ISO6HX-TB-P004	02999915	M4	0,7	–	2,8 *0.110*	43,0 *1.693*	12,0 *0.472*	59,7625 *2.353*	3,4 *0.134*	2.80X2.10	3	DIN376	6HX	B
MTP-M5X0.80ISO6HX-TB-P004	02999916	M5	0,8	–	3,5 *0.138*	49,0 *1.929*	13,2 *0.520*	66,3 *2.610*	4,3 *0.169*	3.50X2.70	3	DIN376	6HX	B
MTP-M6X1.00ISO6HX-TB-P004	02999917	M6	1,0	–	4,5 *0.177*	59,0 *2.323*	15,1 *0.594*	75,375 *2.968*	5,1 *0.201*	4.50X3.40	3	DIN376	6HX	B
MTP-M8X1.25ISO6HX-TB-P004	02999918	M8	1,25	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	84,21875 *3.316*	6,8 *0.268*	6.00X4.90	3	DIN376	6HX	B
MTP-M10X1.50ISO6HX-TB-P004	02999919	M10	1,5	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	93,0625 *3.664*	8,6 *0.339*	7.00X5.50	3	DIN376	6HX	B
MTP-M12X1.75ISO6HX-TB-P004	02999920	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	101,90625 *4.012*	10,4 *0.409*	9.00X7.00	4	DIN376	6HX	B
MTP-M14X2.00ISO6HX-TB-P004	02999921	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	100,75 *3.967*	12,1 *0.476*	11.00X9.00	4	DIN376	6HX	B
MTP-M16X2.00ISO6HX-TB-P004	02999922	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	100,75 *3.967*	14,1 *0.555*	12.00X9.00	4	DIN376	6HX	B
MTP-M18X2.50ISO6HX-TB-P004	02999923	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	114,46 *4.506*	15,7 *0.618*	14.00X11.00	4	DIN376	6HX	B
MTP-M20X2.50ISO6HX-TB-P004	02999924	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	128,4375 *5.057*	17,7 *0.697*	16.00X12.00	4	DIN376	6HX	B
MTP-M22X2.50ISO6HX-TB-P004	02999925	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	129,36 *5.093*	19,7 *0.776*	18.00X14.50	4	DIN376	6HX	B
MTP-M24X3.00ISO6HX-TB-P004	02999926	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	146,125 *5.753*	21,0 *0.827*	18.00X14.50	4	DIN376	6HX	B
MTP-M27X3.00ISO6HX-TB-P004	02999927	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	147,37 *5.802*	24,0 *0.945*	20.00X16.00	4	DIN376	6HX	B
MTP-M30X3.50ISO6HX-TB-P004	02999928	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	165,42 *6.513*	26,5 *1.043*	22.00X18.00	4	DIN376	6HX	B

MTP-P004-A

Through holes

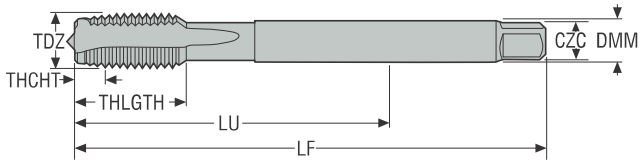


- For cutting data see page(s) 268
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6HX-TB-P004-A	02999935	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	101,90625 *4.012*	10,4 *0.409*	9.00X7.00	4	DIN376	6HX	B
MTP-M14X2.00ISO6HX-TB-P004-A	02999936	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	101,41 *3.993*	12,1 *0.476*	11.00X9.00	4	DIN376	6HX	B
MTP-M16X2.00ISO6HX-TB-P004-A	02999937	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	100,75 *3.967*	14,1 *0.555*	12.00X9.00	4	DIN376	6HX	B
MTP-M18X2.50ISO6HX-TB-P004-A	02999938	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	114,46 *4.506*	15,7 *0.618*	14.00X11.00	4	DIN376	6HX	B
MTP-M20X2.50ISO6HX-TB-P004-A	02999939	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	129,46 *5.097*	17,7 *0.697*	16.00X12.00	4	DIN376	6HX	B
MTP-M22X2.50ISO6HX-TB-P004-A	02999940	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	129,36 *5.093*	19,7 *0.776*	18.00X14.50	4	DIN376	6HX	B
MTP-M24X3.00ISO6HX-TB-P004-A	02999941	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	146,125 *5.753*	21,0 *0.827*	18.00X14.50	4	DIN376	6HX	B
MTP-M27X3.00ISO6HX-TB-P004-A	02999942	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	147,37 *5.802*	24,0 *0.945*	20.00X16.00	4	DIN376	6HX	B
MTP-M30X3.50ISO6HX-TB-P004-A	02999943	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	165,42 *6.513*	26,5 *1.043*	22.00X18.00	4	DIN376	6HX	B

MTP-P011

Through holes



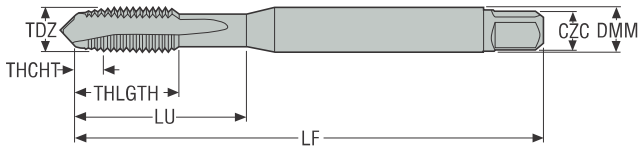
- For cutting data see page(s) 268
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.50ISO6HX-TB-P011	02999944	MF4X0.5	0,5	–	2,8 *0.110*	43,0 *1.693*	12,0 *0.472*	60,6875 *2.389*	3,5 *0.138*	2.80X2.10	3	DIN374	6HX	B
MTP-M5X0.50ISO6HX-TB-P011	02999945	MF5X0.5	0,5	–	3,5 *0.138*	49,0 *1.929*	13,0 *0.512*	67,57 *2.660*	4,5 *0.177*	3.50X2.70	3	DIN374	6HX	B
MTP-M6X0.75ISO6HX-TB-P011	02999946	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	15,0 *0.591*	76,5 *3.012*	5,3 *0.209*	4.50X3.40	3	DIN374	6HX	B
MTP-M8X0.75ISO6HX-TB-P011	02999947	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	15,0 *0.591*	76,43 *3.009*	7,3 *0.287*	6.00X4.90	3	DIN374	6HX	B
MTP-M8X1.00ISO6HX-TB-P011	02999948	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	85,375 *3.361*	7,1 *0.280*	6.00X4.90	3	DIN374	6HX	B
MTP-M10X0.75ISO6HX-TB-P011	02999949	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	86,42 *3.402*	9,3 *0.366*	7.00X5.50	3	DIN374	6HX	B
MTP-M10X1.00ISO6HX-TB-P011	02999950	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	85,375 *3.361*	9,1 *0.358*	7.00X5.50	3	DIN374	6HX	B
MTP-M10X1.25ISO6HX-TB-P011	02999951	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	98,51875 *3.879*	8,8 *0.346*	7.00X5.50	3	DIN374	6HX	B
MTP-M12X1.00ISO6HX-TB-P011	02999952	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	95,36 *3.754*	11,1 *0.437*	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.25ISO6HX-TB-P011	02999953	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	94,21875 *3.709*	10,8 *0.425*	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.50ISO6HX-TB-P011	02999954	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	93,37 *3.676*	10,6 *0.417*	9.00X7.00	4	DIN374	6HX	B
MTP-M14X1.00ISO6HX-TB-P011	02999955	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,35 *3.754*	13,1 *0.516*	11.00X9.00	4	DIN374	6HX	B
MTP-M14X1.25ISO6HX-TB-P011	02999956	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	94,33 *3.714*	12,8 *0.504*	11.00X9.00	4	DIN374	6HX	B
MTP-M14X1.50ISO6HX-TB-P011	02999957	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	93,0625 *3.664*	12,6 *0.496*	11.00X9.00	4	DIN374	6HX	B
MTP-M16X1.00ISO6HX-TB-P011	02999958	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	95,35 *3.754*	15,1 *0.594*	12.00X9.00	4	DIN374	6HX	B
MTP-M16X1.50ISO6HX-TB-P011	02999959	MF16X1.5	1,5	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	93,0625 *3.664*	14,6 *0.575*	12.00X9.00	4	DIN374	6HX	B
MTP-M18X1.00ISO6HX-TB-P011	02999960	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	105,35 *4.148*	17,1 *0.673*	14.00X11.00	4	DIN374	6HX	B
MTP-M18X1.50ISO6HX-TB-P011	02999961	MF18X1.5	1,5	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	103,35 *4.069*	16,6 *0.654*	14.00X11.00	4	DIN374	6HX	B
MTP-M20X1.00ISO6HX-TB-P011	02999962	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	120,24 *4.734*	19,1 *0.752*	16.00X12.00	4	DIN374	6HX	B
MTP-M20X1.50ISO6HX-TB-P011	02999963	MF20X1.5	1,5	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	118,25 *4.656*	18,6 *0.732*	16.00X12.00	4	DIN374	6HX	B
MTP-M22X1.50ISO6HX-TB-P011	02999964	MF22X1.5	1,5	–	18,0 *0.709*	78,0 *3.071*	25,0 *0.984*	118,25 *4.656*	20,5 *0.807*	18.00X14.50	4	DIN374	6HX	B
MTP-M24X1.50ISO6HX-TB-P011	02999965	MF24X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	133,23 *5.245*	22,5 *0.886*	18.00X14.50	4	DIN374	6HX	B

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M24X2.00ISO6HX-TB-P011	02999966	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	131,28 *5.169*	22,0 *0.866*	18.00X14.50	4	DIN374	6HX	B
MTP-M25X1.50ISO6HX-TB-P011	02999967	MF25X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	133,23 *5.245*	23,5 *0.925*	18.00X14.50	4	DIN374	6HX	B
MTP-M26X1.50ISO6HX-TB-P011	02999968	MF26X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	133,23 *5.245*	24,5 *0.965*	18.00X14.50	4	DIN374	6HX	B
MTP-M27X1.50ISO6HX-TB-P011	02999969	MF27X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	133,22 *5.245*	25,5 *1.004*	20.00X16.00	4	DIN374	6HX	B
MTP-M27X2.00ISO6HX-TB-P011	02999970	MF27X2.0	2,0	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	131,28 *5.169*	25,0 *0.984*	20.00X16.00	4	DIN374	6HX	B
MTP-M28X1.50ISO6HX-TB-P011	02999971	MF28X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	133,22 *5.245*	26,5 *1.043*	20.00X16.00	4	DIN374	6HX	B
MTP-M30X1.50ISO6HX-TB-P011	02999972	MF30X1.5	1,5	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	143,22 *5.639*	28,5 *1.122*	22.00X18.00	4	DIN374	6HX	B
MTP-M30X2.00ISO6HX-TB-P011	02999973	MF30X2.0	2,0	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	141,27 *5.562*	28,0 *1.102*	22.00X18.00	4	DIN374	6HX	B

MTP-M003-A

Through holes

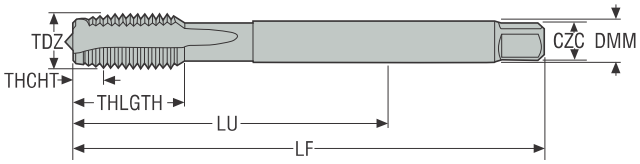


- For cutting data see page(s) 270
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.70ISO6H-TB-M003-A	03000094	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	11,7 *0.461*	59,82 *2.355*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-M003-A	03000095	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	12,6 *0.496*	66,4 *2.614*	4,3 *0.169*	6.00X4.90	3	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-M003-A	03000096	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	14,5 *0.571*	75,375 *2.968*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-M003-A	03000097	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	17,4 *0.685*	84,21875 *3.316*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-M003-A	03000098	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	19,2 *0.756*	93,0625 *3.664*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	B

MTP-M004

Through holes

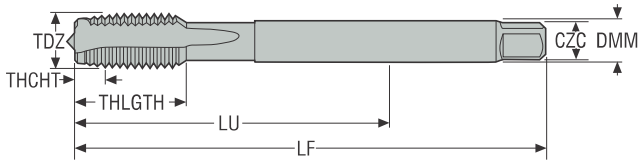


- For cutting data see page(s) 270
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-M004	03000087	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	101,90625 *4.012*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-M004	03000088	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	100,75 *3.967*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-M004	03000090	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	100,75 *3.967*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-M004	03000091	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	113,4375 *4.466*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-M004	03000092	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	128,4375 *5.057*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	B

MTP-M004-A

Through holes

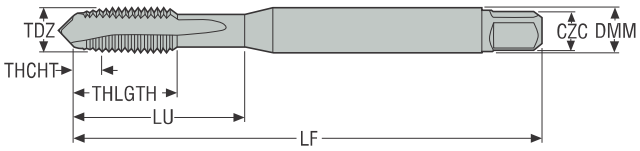


- For cutting data see page(s) 270
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-M004-A	03000099	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	101,90625 *4.012*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-M004-A	03000100	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	101,14 *3.982*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-M004-A	03000101	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	101,05 *3.978*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-M004-A	03000102	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	114,15 *4.494*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-M004-A	03000103	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	129,15 *5.085*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	B
MTP-M22X2.50ISO6H-TB-M004-A	03000104	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	129,53 *5.100*	19,7 *0.776*	18.00X14.50	4	DIN376	6H	B
MTP-M24X3.00ISO6H-TB-M004-A	03000105	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	147,58 *5.810*	21,0 *0.827*	18.00X14.50	4	DIN376	6H	B

MTP-N001

Through holes

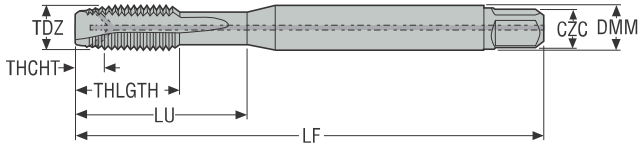


- For cutting data see page(s) 272
- Coating: BRIGHT
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M3X0.50ISO6H-TB-N001	03000136	M3	0,5	–	3,5 *0.138*	16,0 *0.630*	9,0 *0.354*	54,625 *2.151*	2,5 *0.098*	3.50X2.70	2	DIN371	6H	B
MTP-M4X0.70ISO6H-TB-N001	03000137	M4	0,7	–	4,5 *0.177*	19,0 *0.748*	12,0 *0.472*	59,85 *2.356*	3,4 *0.134*	4.50X3.40	2	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-N001	03000138	M5	0,8	–	6,0 *0.236*	23,0 *0.906*	13,0 *0.512*	66,4 *2.614*	4,3 *0.169*	6.00X4.90	2	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-N001	03000139	M6	1,0	–	6,0 *0.236*	27,0 *1.063*	15,0 *0.591*	75,375 *2.968*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-N001	03000140	M8	1,25	–	8,0 *0.315*	28,0 *1.102*	18,0 *0.709*	84,21875 *3.316*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-N001	03000141	M10	1,5	–	10,0 *0.394*	30,0 *1.181*	20,0 *0.787*	93,25 *3.671*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	B

MTP-N001-A

Through holes

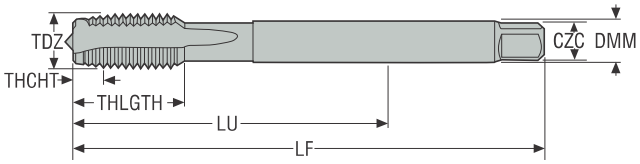


- For cutting data see page(s) 272
- Coating: BRIGHT
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.70ISO6H-TB-N001-A	03000145	M4	0,7	–	4,5 *0.177*	19,0 *0.748*	12,0 *0.472*	59,85 *2.356*	3,4 *0.134*	4.50X3.40	2	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-N001-A	03000146	M5	0,8	–	6,0 *0.236*	23,0 *0.906*	13,0 *0.512*	66,4 *2.614*	4,3 *0.169*	6.00X4.90	2	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-N001-A	03000147	M6	1,0	–	6,0 *0.236*	27,0 *1.063*	15,0 *0.591*	75,5 *2.972*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-N001-A	03000148	M8	1,25	–	8,0 *0.315*	28,0 *1.102*	18,0 *0.709*	84,37 *3.322*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-N001-A	03000149	M10	1,5	–	10,0 *0.394*	30,0 *1.181*	20,0 *0.787*	93,25 *3.671*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	B

MTP-N002

Through holes

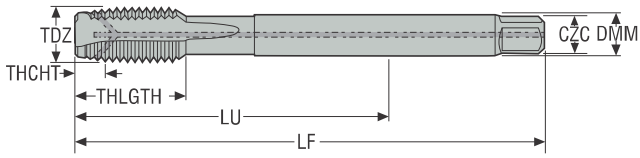


- For cutting data see page(s) 272
- Coating: BRIGHT
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-N002	03000142	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	102,1 *4.020*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-N002	03000143	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	101,0 *3.976*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-N002	03000144	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	101,0 *3.976*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B

MTP-N002-A

Through holes

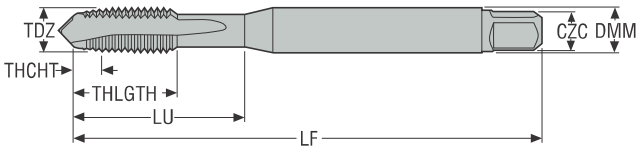


- For cutting data see page(s) 272
- Coating: BRIGHT
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-N002-A	03000150	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	102,1 *4.020*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-N002-A	03000151	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	101,0 *3.976*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-N002-A	03000152	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	101,0 *3.976*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B

MTP-S001

Through holes

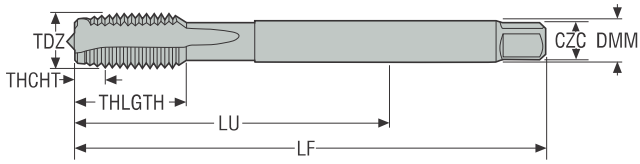


- For cutting data see page(s) 278
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M2X0.40ISO6HX-TB-S001	10001159	M2	0,4	–	2,8 *0.110*	8,0 *0.315*	8,0 *0.315*	43,2 *1.701*	1,6 *0.063*	2.80X2.10	2	DIN371	6HX	B
MTP-M2.5X0.45ISO6HX-TB-S001	10001161	M2.5	0,45	–	2,8 *0.110*	9,0 *0.354*	9,0 *0.354*	47,97 *1.889*	2,1 *0.083*	2.80X2.10	2	DIN371	6HX	B
MTP-M3X0.50ISO6HX-TB-S001	10001162	M3	0,5	–	3,5 *0.138*	10,0 *0.394*	10,0 *0.394*	53,75 *2.116*	2,5 *0.098*	3.50X2.70	2	DIN371	6HX	B
MTP-M3.5X0.60ISO6HX-TB-S001	10001163	M3.5	0,6	–	4,0 *0.157*	12,0 *0.472*	12,0 *0.472*	53,3 *2.098*	2,9 *0.114*	4.00X3.00	3	DIN371	6HX	B
MTP-M4X0.70ISO6HX-TB-S001	10001164	M4	0,7	–	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	59,85 *2.356*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	B
MTP-M5X0.80ISO6HX-TB-S001	10001165	M5	0,8	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	66,4 *2.614*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	B
MTP-M6X1.00ISO6HX-TB-S001	10001166	M6	1,0	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	75,5 *2.972*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	B
MTP-M8X1.25ISO6HX-TB-S001	10001167	M8	1,25	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	84,37 *3.322*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.50ISO6HX-TB-S001	10001168	M10	1,5	–	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	93,25 *3.671*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	B

MTP-S002

Through holes

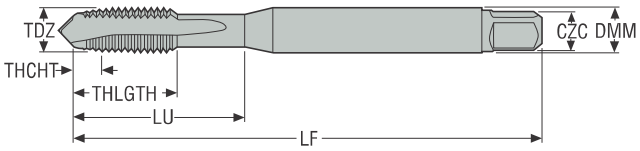


- For cutting data see page(s) 278
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6HX-TB-S002	10001169	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	102,12 *4.020*	10,4 *0.409*	9.00X7.00	4	DIN376	6HX	B
MTP-M16X2.00ISO6HX-TB-S002	10001170	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	101,0 *3.976*	14,1 *0.555*	12.00X9.00	4	DIN376	6HX	B
MTP-M20X2.50ISO6HX-TB-S002	10001171	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	128,75 *5.069*	17,7 *0.697*	16.00X12.00	4	DIN376	6HX	B

MTP-S011

Through holes

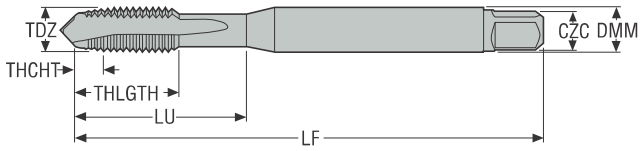


- For cutting data see page(s) 278
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M6X0.75ISO6HX-TB-S011	10001176	MF6X0.75	0,75	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	76,62 *3.017*	5,25 *0.207*	6.00X4.90	3	DIN371	6HX	B
MTP-M8X0.750ISO6HX-TB-S011	10001177	MF8X0.75	0,75	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	86,62 *3.410*	7,25 *0.285*	8.00X6.20	3	DIN371	6HX	B
MTP-M8X1.00ISO6HX-TB-S011	10001178	MF8X1	1,0	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	85,5 *3.366*	7,0 *0.276*	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.00ISO6HX-TB-S011	10001179	MF10X1	1,0	–	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	95,5 *3.760*	9,0 *0.354*	10.00X8.00	3	DIN371	6HX	B
MTP-M12X1.00ISO6HX-TB-S011	10001180	MF12X1	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	95,5 *3.760*	11,0 *0.433*	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.50ISO6HX-TB-S011	10001181	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	93,25 *3.671*	10,5 *0.413*	9.00X7.00	4	DIN374	6HX	B
MTP-M14X1.50ISO6HX-TB-S011	10001182	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	93,25 *3.671*	12,5 *0.492*	11.00X9.00	4	DIN374	6HX	B

MTP-S012

Through holes

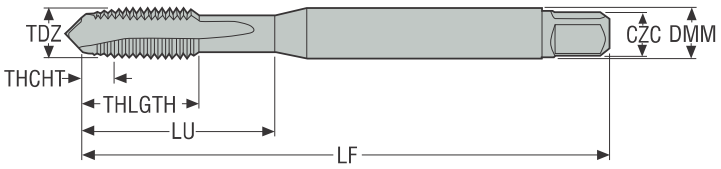


- For cutting data see page(s) 278
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-MJ4X0.70ISO4H-TB-S012	10001172	MJ4X0.7	0,7	–	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	59,85 *2.356*	3,4 *0.134*	4.50X3.40	3	DIN371	4H	B
MTP-MJ5X0.80ISO4H-TB-S012	10001173	MJ5X0.8	0,8	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	66,4 *2.614*	4,3 *0.169*	6.00X4.90	3	DIN371	4H	B
MTP-MJ6X1.00ISO4H-TB-S012	10001174	MJ6X1	1,0	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	75,5 *2.972*	5,1 *0.201*	6.00X4.90	3	DIN371	4H	B
MTP-MJ8X1.25ISO4H-TB-S012	10001175	MJ8X1.25	1,25	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	84,37 *3.322*	6,9 *0.272*	8.00X6.20	3	DIN371	4H	B

MTP-S013

Through holes

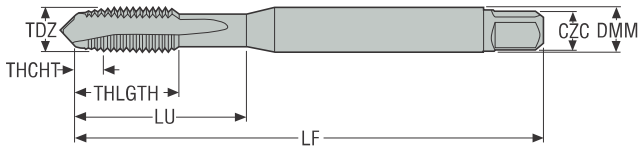


- For cutting data see page(s) 278
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					
MTP-EGM4X0.7ISO4H-TB-S013 *MTP-STIM4X0.7ISO4H-TB-S013*	10001218	EGM4	0,7	–	6,0 *0.236*	16 *0.630*	16,0 *0.630*	66,9 *2.632*	4,2 *0.165*	6.00X4.90	3	DIN40435	4H	B
MTP-EGM5X0.8ISO4H-TB-S013 *MTP-STIM5X0.8ISO4H-TB-S013*	10001219	EGM5	0,8	–	6,0 *0.236*	23 *0.906*	15,0 *0.591*	76,4 *3.008*	5,3 *0.207*	6.00X4.90	3	DIN40435	4H	B
MTP-EGM6X1.0ISO4H-TB-S013 *MTP-STIM6X1.0ISO4H-TB-S013*	10001220	EGM6	1,0	–	8,0 *0.315*	35 *1.378*	18,0 *0.709*	85,5 *3.366*	6,3 *0.248*	8.00X6.20	3	DIN40435	4H	B
MTP-EGM8X1.25ISO4H-TB-S013 *MTP-STIM8X1.25ISO4H-TB-S013*	10001221	EGM8	1,25	–	10,0 *0.394*	34 *1.319*	20,0 *0.787*	94,4 *3.715*	8,4 *0.331*	10.00X8.00	3	DIN40435	4H	B

MTP-S042

Through holes

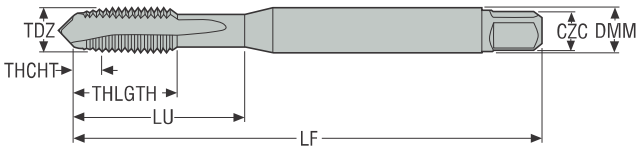


- For cutting data see page(s) 278
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-10-32UNJF3B-TB-S042	10001183	UNJF10-32	–	32.0	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	66,43 *2.615*	4,15 *0.163*	6.00X4.90	3	DIN2184-1	3B	B
MTP-1/4-28UNJF3B-TB-S042	10001184	UNJF1/4-28	–	28.0	7,0 *0.276*	25,0 *0.984*	15,0 *0.591*	75,92 *2.989*	5,6 *0.220*	7.00X5.50	3	DIN2184-1	3B	B
MTP-5/16-24UNJF3B-TB-S042	10001186	UNJF5/16-24	–	24.0	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	85,24 *3.356*	7,0 *0.276*	8.00X6.20	3	DIN2184-1	3B	B
MTP-3/8-24UNJF3B-TB-S042	10001185	UNJF3/8-24	–	24.0	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	95,24 *3.750*	8,6 *0.339*	10.00X8.00	3	DIN2184-1	3B	B

MTP-S043

Through holes

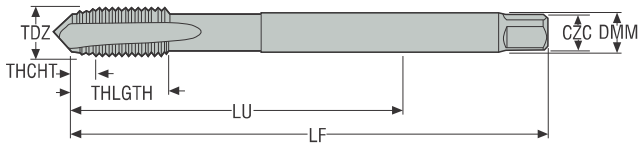


- For cutting data see page(s) 278
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-10-32EGUNF3B-TB-S043	10001214	EGUN10-32	–	32.0	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	76,43 *3.009*	5,1 *0.201*	6.00X4.90	3	DIN2184-1	3B	B
MTP-1/4-28EGUNF3B-TB-S043	10001215	EGUNF1/4-28	–	28.0	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	85,92 *3.383*	6,6 *0.260*	8.00X6.20	3	DIN2184-1	3B	B
MTP-5/16-24EGUNF3B-TB-S043	10001216	EGUNF5/16-24	–	24.0	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	95,24 *3.750*	8,2 *0.323*	10.00X8.00	3	DIN2184-1	3B	B
MTP-3/8-24EGUNF3B-TB-S043	10001217	EGUNF3/8-24	–	24.0	8,0 *0.315*	76,0 *2.992*	20,0 *0.787*	95,24 *3.750*	9,8 *0.386*	8.00X6.20	3	DIN2184-1	3B	B

MTP-V002

Through holes

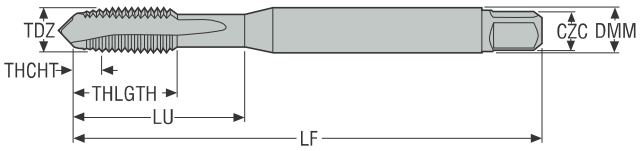


- For cutting data see page(s) 286
- Coating: TiN
- Substrate: HSS-E
- Long version

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M14X2.00ISO6H-TB-V002	03019091	M14	2,0	–	11,0 *0.433*	151,0 *5.945*	25,0 *0.984*	171,0 *6.732*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-V002	03019093	M20	2,5	–	16,0 *0.630*	179,0 *7.047*	30,0 *1.181*	212,75 *8.376*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	B

MTP-V007

Through holes

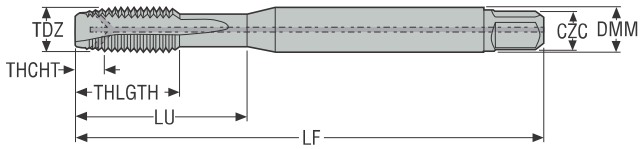


- For cutting data see page(s) 286
- Coating: TiN
- Substrate: HSS-E ≤ M2,5; HSS-PM > M2,5

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M7X1.00ISO6H-TB-V007	03019111	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	14,5 *0.571*	75,375 *2.968*	6,1 *0.240*	7.00X5.50	3	DIN371	6H	B

MTP-V007-A

Through holes

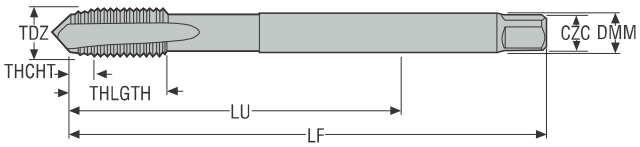


- For cutting data see page(s) 286
- Coating: TiN
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.70ISO6H-TB-V007-A	03000184	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	59,87 *2.357*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	B

MTP-V008

Through holes

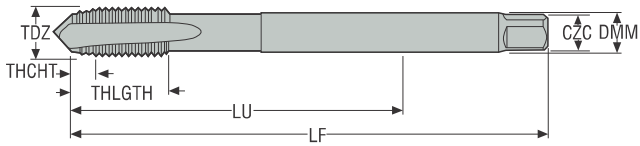


- For cutting data see page(s) 286
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M3X0.50ISO6H-TB-V008	03019124	M3	0,5	–	2,2 *0.087*	37,0 *1.457*	9,5 *0.374*	53,6875 *2.114*	2,5 *0.098*	2.20X1.80	3	DIN376	6H	B
MTP-M4X0.70ISO6H-TB-V008	03019125	M4	0,7	–	2,8 *0.110*	43,0 *1.693*	11,9 *0.469*	59,7625 *2.353*	3,4 *0.134*	2.80X2.10	3	DIN376	6H	B
MTP-M5X0.80ISO6H-TB-V008	03019126	M5	0,8	–	3,5 *0.138*	49,0 *1.929*	13,2 *0.520*	66,3 *2.610*	4,3 *0.169*	3.50X2.70	3	DIN376	6H	B
MTP-M6X1.00ISO6H-TB-V008	03019127	M6	1,0	–	4,5 *0.177*	59,0 *2.323*	15,1 *0.594*	75,375 *2.968*	5,1 *0.201*	4.50X3.40	3	DIN376	6H	B
MTP-M8X1.25ISO6H-TB-V008	03019128	M8	1,25	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	88,4375 *3.482*	6,8 *0.268*	6.00X4.90	3	DIN376	6H	B
MTP-M10X1.50ISO6H-TB-V008	03019129	M10	1,5	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	93,0625 *3.664*	8,6 *0.339*	7.00X5.50	3	DIN376	6H	B

MTP-V008-A

Through holes

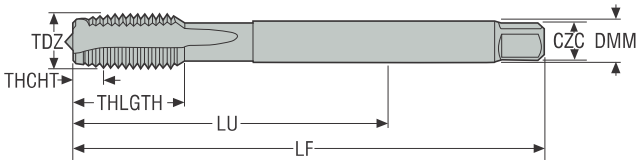


- For cutting data see page(s) 286
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-V008-A	03000189	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	16,0 *0.630*	102,57 *4.038*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-V008-A	03000190	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	101,61 *4.000*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-V008-A	03000191	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	20,0 *0.787*	101,61 *4.000*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-V008-A	03000192	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	25,0 *0.984*	114,68 *4.515*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-V008-A	03000193	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	128,4375 *5.057*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	B
MTP-M22X2.50ISO6H-TB-V008-A	03000194	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	25,0 *0.984*	129,46 *5.097*	19,7 *0.776*	18.00X14.50	4	DIN376	6H	B
MTP-M24X3.00ISO6H-TB-V008-A	03000195	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	30,0 *1.181*	146,125 *5.753*	21,0 *0.827*	18.00X14.50	4	DIN376	6H	B
MTP-M27X3.00ISO6H-TB-V008-A	03000196	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	30,0 *1.181*	147,49 *5.807*	24,0 *0.945*	20.00X16.00	4	DIN376	6H	B
MTP-M30X3.50ISO6H-TB-V008-A	03000197	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	36,0 *1.417*	165,53 *6.517*	26,5 *1.043*	22.00X18.00	4	DIN376	6H	B
MTP-M33X3.50ISO6H-TB-V008-A	03000198	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	50,0 *1.969*	165,53 *6.517*	29,5 *1.161*	25.00X20.00	4	DIN376	6H	B
MTP-M36X4.00ISO6H-TB-V008-A	03000199	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	55,0 *2.165*	183,93 *7.241*	32,0 *1.260*	28.00X22.00	4	DIN376	6H	B

MTP-V014

Through holes

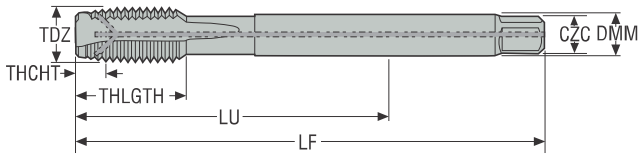


- For cutting data see page(s) 288
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M9X1.00ISO6H-TB-V014	03000358	MF9X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	17,0 *0.669*	85,375 *3.361*	8,1 *0.319*	7.00X5.50	3	DIN374	6H	B
MTP-M11X1.00ISO6H-TB-V014	03000359	MF11X1.0	1,0	–	8,0 *0.315*	63,0 *2.480*	18,0 *0.709*	85,375 *3.361*	10,1 *0.398*	8.00X6.20	3	DIN374	6H	B
MTP-M11X1.25ISO6H-TB-V014	03000360	MF11X1.25	1,25	–	8,0 *0.315*	63,0 *2.480*	22,0 *0.866*	84,21875 *3.316*	9,8 *0.386*	8.00X6.20	3	DIN374	6H	B
MTP-M14X1.00ISO6H-TB-V014	03019140	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,375 *3.755*	13,1 *0.516*	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.25ISO6H-TB-V014	03019141	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	94,21875 *3.709*	12,8 *0.504*	11.00X9.00	3	DIN374	6H	B
MTP-M16X1.00ISO6H-TB-V014	03019143	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	95,375 *3.755*	15,1 *0.594*	12.00X9.00	3	DIN374	6H	B
MTP-M18X1.00ISO6H-TB-V014	03019145	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	105,375 *4.149*	17,1 *0.673*	14.00X11.00	4	DIN374	6H	B
MTP-M20X1.00ISO6H-TB-V014	03019147	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	120,375 *4.739*	19,1 *0.752*	16.00X12.00	4	DIN374	6H	B
MTP-M24X2.00ISO6H-TB-V014	03019152	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	130,75 *5.148*	22,0 *0.866*	18.00X14.50	4	DIN374	6H	B
MTP-M25X1.50ISO6H-TB-V014	03019153	MF25X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	133,34 *5.250*	23,5 *0.925*	18.00X14.50	4	DIN374	6H	B
MTP-M26X1.50ISO6H-TB-V014	03019155	MF26X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	133,34 *5.250*	24,5 *0.965*	18.00X14.50	4	DIN374	6H	B
MTP-M27X1.50ISO6H-TB-V014	03019156	MF27X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	133,35 *5.250*	25,5 *1.004*	20.00X16.00	4	DIN374	6H	B
MTP-M27X2.00ISO6H-TB-V014	03019157	MF27X2.0	2,0	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	131,39 *5.173*	25,0 *0.984*	20.00X16.00	4	DIN374	6H	B
MTP-M28X1.50ISO6H-TB-V014	03019158	MF28X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	133,35 *5.250*	26,5 *1.043*	20.00X16.00	4	DIN374	6H	B
MTP-M30X1.50ISO6H-TB-V014	03019159	MF30X1.5	1,5	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	143,33 *5.643*	28,5 *1.122*	22.00X18.00	4	DIN374	6H	B
MTP-M30X2.00ISO6H-TB-V014	03019160	MF30X2.0	2,0	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	141,39 *5.567*	28,0 *1.102*	22.00X18.00	4	DIN374	6H	B

MTP-V014-A

Through holes

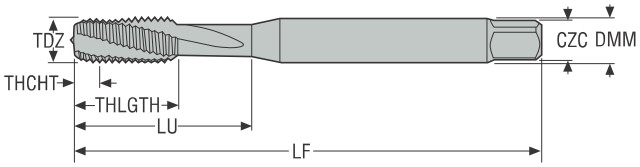


- For cutting data see page(s) 288
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M6X0.75ISO6H-TB-V014-A	03000200	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	15,1 *0.594*	76,66 *3.018*	5,3 *0.209*	4.50X3.40	3	DIN374	6H	B
MTP-M8X0.75ISO6H-TB-V014-A	03000201	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	14,9 *0.587*	76,58 *3.015*	7,3 *0.287*	6.00X4.90	3	DIN374	6H	B
MTP-M10X0.75ISO6H-TB-V014-A	03000203	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	86,58 *3.409*	9,3 *0.366*	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.25ISO6H-TB-V014-A	03000205	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	94,61 *3.725*	8,8 *0.346*	7.00X5.50	3	DIN374	6H	B
MTP-M12X1.00ISO6H-TB-V014-A	03000206	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	95,49 *3.759*	11,1 *0.437*	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.25ISO6H-TB-V014-A	03000207	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	94,5 *3.720*	10,8 *0.425*	9.00X7.00	3	DIN374	6H	B
MTP-M14X1.00ISO6H-TB-V014-A	03000209	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,49 *3.759*	13,1 *0.516*	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.25ISO6H-TB-V014-A	03000210	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	94,5 *3.720*	12,8 *0.504*	11.00X9.00	3	DIN374	6H	B
MTP-M16X1.00ISO6H-TB-V014-A	03000212	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	95,49 *3.759*	15,1 *0.594*	12.00X9.00	3	DIN374	6H	B
MTP-M18X1.00ISO6H-TB-V014-A	03000214	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	105,49 *4.153*	17,1 *0.673*	14.00X11.00	4	DIN374	6H	B
MTP-M18X1.50ISO6H-TB-V014-A	03000215	MF18X1.5	1,5	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	103,0625 *4.058*	16,6 *0.654*	14.00X11.00	4	DIN374	6H	B
MTP-M20X1.00ISO6H-TB-V014-A	03000216	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	120,33 *4.737*	19,1 *0.752*	16.00X12.00	4	DIN374	6H	B
MTP-M20X1.50ISO6H-TB-V014-A	03000217	MF20X1.5	1,5	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	118,0625 *4.648*	18,6 *0.732*	16.00X12.00	4	DIN374	6H	B
MTP-M22X1.50ISO6H-TB-V014-A	03000218	MF22X1.5	1,5	–	18,0 *0.709*	78,0 *3.071*	25,0 *0.984*	118,0625 *4.648*	20,5 *0.807*	18.00X14.50	4	DIN374	6H	B
MTP-M24X1.50ISO6H-TB-V014-A	03000219	MF24X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	133,34 *5.250*	22,5 *0.886*	18.00X14.50	4	DIN374	6H	B
MTP-M24X2.00ISO6H-TB-V014-A	03000220	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	130,75 *5.148*	22,0 *0.866*	18.00X14.50	4	DIN374	6H	B

MTH-P001

Blind holes

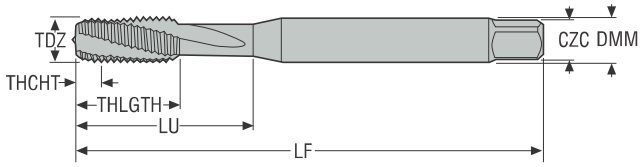


- For cutting data see page(s) 266
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6H-BC-P001	02999974	M3	0,5	–	4,5 *0.177*	12,0 *0.472*	12,0 *0.472*	61,625 *2.426*	2,5 *0.098*	4.50X3.40	3	SECO-DIN	6H	C
MTH-M4X0.70ISO6H-BC-P001	02999975	M4	0,7	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	67,97 *2.676*	3,4 *0.134*	6.00X4.90	3	SECO-DIN	6H	C
MTH-M5X0.80ISO6H-BC-P001	02999976	M5	0,8	–	6,0 *0.236*	15,0 *0.591*	15,0 *0.591*	77,67 *3.058*	4,3 *0.169*	6.00X4.90	3	SECO-DIN	6H	C
MTH-M6X1.00ISO6H-BC-P001	02999977	M6	1,0	–	8,0 *0.315*	18,0 *0.709*	18,0 *0.709*	87,25 *3.435*	5,1 *0.201*	8.00X6.20	3	SECO-DIN	6H	C
MTH-M8X1.25ISO6H-BC-P001	02999978	M8	1,25	–	10,0 *0.394*	20,0 *0.787*	20,0 *0.787*	96,5625 *3.802*	6,8 *0.268*	10.00X8.00	3	SECO-DIN	6H	C
MTH-M10X1.50ISO6H-BC-P001	02999979	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	95,875 *3.775*	8,6 *0.339*	10.00X8.00	3	SECO-DIN	6H	C

MTH-P001-A

Blind holes

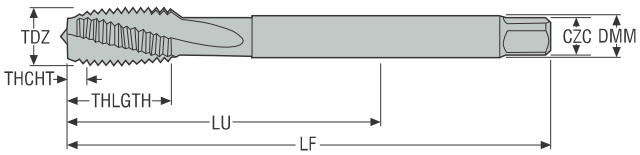


- For cutting data see page(s) 266
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.70ISO6H-BC-P001-A	02999985	M4	0,7	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	67,97 *2.676*	3,4 *0.134*	6.00X4.90	3	SECO-DIN	6H	C
MTH-M5X0.80ISO6H-BC-P001-A	02999986	M5	0,8	–	6,0 *0.236*	15,0 *0.591*	15,0 *0.591*	77,67 *3.058*	4,3 *0.169*	6.00X4.90	3	SECO-DIN	6H	C
MTH-M6X1.00ISO6H-BC-P001-A	02999987	M6	1,0	–	8,0 *0.315*	18,0 *0.709*	18,0 *0.709*	87,07 *3.428*	5,1 *0.201*	8.00X6.20	3	SECO-DIN	6H	C
MTH-M8X1.25ISO6H-BC-P001-A	02999988	M8	1,25	–	10,0 *0.394*	20,0 *0.787*	20,0 *0.787*	96,32 *3.792*	6,8 *0.268*	10.00X8.00	3	SECO-DIN	6H	C
MTH-M10X1.50ISO6H-BC-P001-A	02999989	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	95,57 *3.763*	8,6 *0.339*	10.00X8.00	3	SECO-DIN	6H	C

MTH-P002

Blind holes

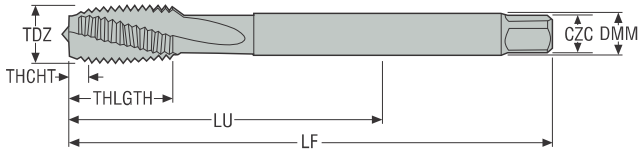


- For cutting data see page(s) 266
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-P002	02999980	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,1875 *4.141*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-P002	02999981	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,5 *4.114*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-P002	02999982	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-P002	02999983	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	118,125 *4.651*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-P002	02999984	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	133,125 *5.241*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C

MTH-P002-A

Blind holes

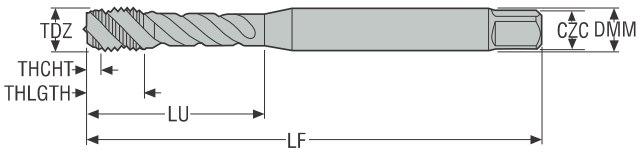


- For cutting data see page(s) 266
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-P002-A	02999990	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	104,38 *4.109*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-P002-A	02999991	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	103,74 *4.084*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-P002-A	02999992	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	103,74 *4.084*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-P002-A	02999993	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	117,05 *4.608*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-P002-A	02999994	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	132,05 *5.199*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C

MTH-P003

Blind holes

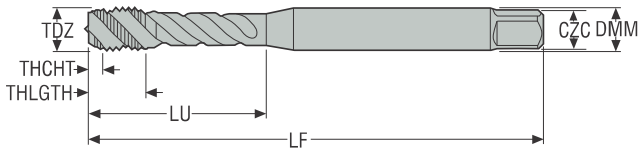


- For cutting data see page(s) 266
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M1.6X0.35ISO6HX-BC-P003	02999995	M1.6	0,35	–	2,5 *0.098*	6,0 *0.236*	4,0 *0.157*	39,3 *1.547*	1,3 *0.051*	2.50X2.10	2	DIN371	6HX	C
MTH-M2X0.40ISO6HX-BC-P003	02999996	M2	0,4	–	2,8 *0.110*	9,0 *0.354*	4,0 *0.157*	44,2 *1.740*	1,6 *0.063*	2.80X2.10	2	DIN371	6HX	C
MTH-M2.2X0.45ISO6HX-BC-P003	02999997	M2.2	0,45	–	2,8 *0.110*	12,0 *0.472*	4,0 *0.157*	44,1 *1.736*	1,8 *0.071*	2.80X2.10	2	DIN371	6HX	C
MTH-M2.3X0.40ISO6HX-BC-P003	02999998	M2.3	0,4	–	2,8 *0.110*	12,0 *0.472*	4,0 *0.157*	44,2 *1.740*	1,9 *0.075*	2.80X2.10	2	DIN371	6HX	C
MTH-M2.5X0.45ISO6HX-BC-P003	02999999	M2.5	0,45	–	2,8 *0.110*	12,5 *0.492*	4,0 *0.157*	49,1 *1.933*	2,1 *0.083*	2.80X2.10	2	DIN371	6HX	C
MTH-M2.6X0.45ISO6HX-BC-P003	03000000	M2.6	0,45	–	2,8 *0.110*	12,5 *0.492*	4,0 *0.157*	49,1 *1.933*	2,15 *0.085*	2.80X2.10	2	DIN371	6HX	C
MTH-M3X0.50ISO6HX-BC-P003	03000001	M3	0,5	–	3,5 *0.138*	18,0 *0.709*	5,9 *0.232*	54,625 *2.151*	2,5 *0.098*	3.50X2.70	3	DIN371	6HX	C
MTH-M3.5X0.60ISO6HX-BC-P003	03000002	M3.5	0,6	–	4,0 *0.157*	20,0 *0.787*	7,0 *0.276*	54,35 *2.140*	2,9 *0.114*	4.00X3.00	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-P003	03000003	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	61,075 *2.405*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-P003	03000004	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	7,7 *0.303*	67,8 *2.669*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-P003	03000006	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	10,0 *0.394*	77,25 *3.041*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	C
MTH-M7X1.00ISO6HX-BC-P003	03000007	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	10,0 *0.394*	77,25 *3.041*	6,1 *0.240*	7.00X5.50	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-P003	03000008	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	11,6 *0.457*	86,5625 *3.408*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-P003	03000009	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	15,1 *0.594*	95,875 *3.775*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	C

MTH-P003-A

Blind holes

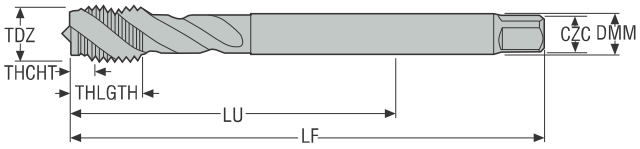


- For cutting data see page(s) 266
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.70ISO6HX-BC-P003-A	03000024	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	61,075 *2.405*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-P003-A	03000025	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	7,7 *0.303*	68,1 *2.681*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-P003-A	03000026	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	10,0 *0.394*	77,39 *3.047*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	C
MTH-M7X1.00ISO6HX-BC-P003-A	03000027	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	10,0 *0.394*	77,25 *3.041*	6,1 *0.240*	7.00X5.50	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-P003-A	03000028	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	11,6 *0.457*	86,5625 *3.408*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-P003-A	03000029	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	15,1 *0.594*	95,875 *3.775*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	C

MTH-P004

Blind holes

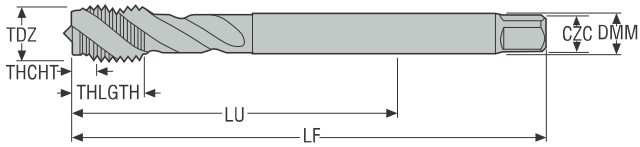


- For cutting data see page(s) 266
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M5X0.80ISO6HX-BC-P004	03000010	M5	0,8	–	3,5 *0.138*	49,0 *1.929*	8,0 *0.315*	67,8 *2.669*	4,3 *0.169*	3.50X2.70	3	DIN376	6HX	C
MTH-M6X1.00ISO6HX-BC-P004	03000011	M6	1,0	–	4,5 *0.177*	59,0 *2.323*	10,0 *0.394*	77,25 *3.041*	5,1 *0.201*	4.50X3.40	3	DIN376	6HX	C
MTH-M7X1.00ISO6HX-BC-P004	03000012	M7	1,0	–	5,5 *0.217*	59,0 *2.323*	10,0 *0.394*	77,25 *3.041*	6,1 *0.240*	5.50X4.30	3	DIN376	6HX	C
MTH-M8X1.25ISO6HX-BC-P004	03000013	M8	1,25	–	6,0 *0.236*	67,0 *2.638*	13,0 *0.512*	86,5625 *3.408*	6,8 *0.268*	6.00X4.90	3	DIN376	6HX	C
MTH-M10X1.50ISO6HX-BC-P004	03000014	M10	1,5	–	7,0 *0.276*	77,0 *3.031*	20,0 *0.787*	95,875 *3.775*	8,6 *0.339*	7.00X5.50	3	DIN376	6HX	C
MTH-M12X1.75ISO6HX-BC-P004	03000015	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	16,0 *0.630*	105,59 *4.157*	10,4 *0.409*	9.00X7.00	3	DIN376	6HX	C
MTH-M14X2.00ISO6HX-BC-P004	03000016	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,5 *4.114*	12,1 *0.476*	11.00X9.00	3	DIN376	6HX	C
MTH-M16X2.00ISO6HX-BC-P004	03000017	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	20,0 *0.787*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	4	DIN376	6HX	C
MTH-M18X2.50ISO6HX-BC-P004	03000018	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	25,0 *0.984*	118,75 *4.675*	15,7 *0.618*	14.00X11.00	4	DIN376	6HX	C
MTH-M20X2.50ISO6HX-BC-P004	03000019	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	133,75 *5.266*	17,7 *0.697*	16.00X12.00	4	DIN376	6HX	C
MTH-M22X2.50ISO6HX-BC-P004	03000020	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	25,0 *0.984*	133,73 *5.265*	19,7 *0.776*	18.00X14.50	4	DIN376	6HX	C
MTH-M24X3.00ISO6HX-BC-P004	03000021	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	30,0 *1.181*	152,72 *6.013*	21,0 *0.827*	18.00X14.50	4	DIN376	6HX	C
MTH-M27X3.00ISO6HX-BC-P004	03000022	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	30,0 *1.181*	152,76 *6.014*	24,0 *0.945*	20.00X16.00	4	DIN376	6HX	C
MTH-M30X3.50ISO6HX-BC-P004	03000023	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	36,0 *1.417*	171,78 *6.763*	26,5 *1.043*	22.00X18.00	4	DIN376	6HX	C

MTH-P004-A

Blind holes

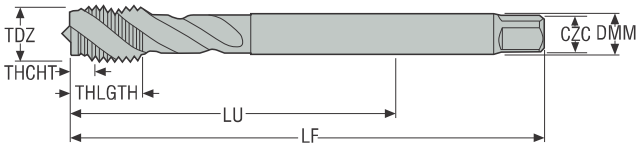


- For cutting data see page(s) 266
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-P004-A	03000030	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	16,0 *0.630*	105,59 *4.157*	10,4 *0.409*	9.00X7.00	3	DIN376	6HX	C
MTH-M14X2.00ISO6HX-BC-P004-A	03000031	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	105,08 *4.137*	12,1 *0.476*	11.00X9.00	3	DIN376	6HX	C
MTH-M16X2.00ISO6HX-BC-P004-A	03000032	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	20,0 *0.787*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	4	DIN376	6HX	C
MTH-M18X2.50ISO6HX-BC-P004-A	03000033	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	25,0 *0.984*	118,75 *4.675*	15,7 *0.618*	14.00X11.00	4	DIN376	6HX	C
MTH-M20X2.50ISO6HX-BC-P004-A	03000034	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	133,75 *5.266*	17,7 *0.697*	16.00X12.00	4	DIN376	6HX	C
MTH-M22X2.50ISO6HX-BC-P004-A	03000036	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	25,0 *0.984*	133,73 *5.265*	19,7 *0.776*	18.00X14.50	4	DIN376	6HX	C
MTH-M24X3.00ISO6HX-BC-P004-A	03000037	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	30,0 *1.181*	152,72 *6.013*	21,0 *0.827*	18.00X14.50	4	DIN376	6HX	C
MTH-M27X3.00ISO6HX-BC-P004-A	03000038	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	30,0 *1.181*	151,75 *5.974*	24,0 *0.945*	20.00X16.00	4	DIN376	6HX	C
MTH-M30X3.50ISO6HX-BC-P004-A	03000039	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	36,0 *1.417*	171,78 *6.763*	26,5 *1.043*	22.00X18.00	4	DIN376	6HX	C

MTH-P011

Blind holes



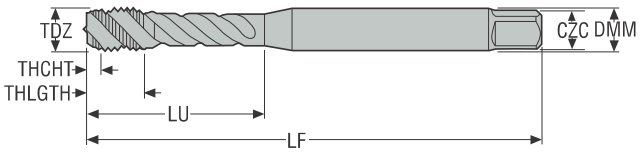
- For cutting data see page(s) 266
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.50ISO6HX-BC-P011	03000040	MF4X0.5	0,5	–	2,8 *0.110*	43,0 *1.693*	7,0 *0.276*	61,625 *2.426*	3,5 *0.138*	2.80X2.10	3	DIN374	6HX	C
MTH-M5X0.50ISO6HX-BC-P011	03000041	MF5X0.5	0,5	–	3,5 *0.138*	49,0 *1.929*	8,0 *0.315*	68,75 *2.707*	4,5 *0.177*	3.50X2.70	3	DIN374	6HX	C
MTH-M6X0.75ISO6HX-BC-P011	03000042	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	10,0 *0.394*	77,7 *3.059*	5,3 *0.209*	4.50X3.40	3	DIN374	6HX	C
MTH-M8X0.75ISO6HX-BC-P011	03000043	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	13,0 *0.512*	77,72 *3.060*	7,3 *0.287*	6.00X4.90	3	DIN374	6HX	C
MTH-M8X1.00ISO6HX-BC-P011	03000044	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	13,0 *0.512*	87,2 *3.433*	7,1 *0.280*	6.00X4.90	3	DIN374	6HX	C
MTH-M10X0.75ISO6HX-BC-P011	03000045	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	13,0 *0.512*	87,73 *3.454*	9,3 *0.366*	7.00X5.50	3	DIN374	6HX	C
MTH-M10X1.00ISO6HX-BC-P011	03000046	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	13,0 *0.512*	87,25 *3.435*	9,1 *0.358*	7.00X5.50	3	DIN374	6HX	C
MTH-M10X1.25ISO6HX-BC-P011	03000047	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	15,0 *0.591*	96,5625 *3.802*	8,8 *0.346*	7.00X5.50	3	DIN374	6HX	C
MTH-M12X1.00ISO6HX-BC-P011	03000048	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	15,0 *0.591*	97,25 *3.829*	11,1 *0.437*	9.00X7.00	3	DIN374	6HX	C
MTH-M12X1.25ISO6HX-BC-P011	03000049	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	15,0 *0.591*	96,5625 *3.802*	10,8 *0.425*	9.00X7.00	3	DIN374	6HX	C
MTH-M12X1.50ISO6HX-BC-P011	03000050	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	15,0 *0.591*	96,07 *3.782*	10,6 *0.417*	9.00X7.00	3	DIN374	6HX	C
MTH-M14X1.00ISO6HX-BC-P011	03000051	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	15,0 *0.591*	97,11 *3.823*	13,1 *0.516*	11.00X9.00	3	DIN374	6HX	C
MTH-M14X1.25ISO6HX-BC-P011	03000052	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	15,0 *0.591*	96,5625 *3.802*	12,8 *0.504*	11.00X9.00	3	DIN374	6HX	C
MTH-M14X1.50ISO6HX-BC-P011	03000053	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	15,0 *0.591*	95,875 *3.775*	12,6 *0.496*	11.00X9.00	3	DIN374	6HX	C
MTH-M16X1.00ISO6HX-BC-P011	03000054	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	15,0 *0.591*	97,25 *3.829*	15,1 *0.594*	12.00X9.00	4	DIN374	6HX	C
MTH-M16X1.50ISO6HX-BC-P011	03000055	MF16X1.5	1,5	–	12,0 *0.472*	58,0 *2.283*	15,0 *0.591*	95,875 *3.775*	14,6 *0.575*	12.00X9.00	4	DIN374	6HX	C
MTH-M18X1.00ISO6HX-BC-P011	03000056	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	17,0 *0.669*	105,875 *4.168*	17,1 *0.673*	14.00X11.00	4	DIN374	6HX	C
MTH-M18X1.50ISO6HX-BC-P011	03000057	MF18X1.5	1,5	–	14,0 *0.551*	66,0 *2.598*	17,0 *0.669*	105,71 *4.162*	16,6 *0.654*	14.00X11.00	4	DIN374	6HX	C
MTH-M20X1.00ISO6HX-BC-P011	03000058	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	17,0 *0.669*	122,25 *4.813*	19,1 *0.752*	16.00X12.00	4	DIN374	6HX	C
MTH-M20X1.50ISO6HX-BC-P011	03000059	MF20X1.5	1,5	–	16,0 *0.630*	80,0 *3.150*	17,0 *0.669*	120,875 *4.759*	18,6 *0.732*	16.00X12.00	4	DIN374	6HX	C
MTH-M22X1.50ISO6HX-BC-P011	03000060	MF22X1.5	1,5	–	18,0 *0.709*	78,0 *3.071*	17,0 *0.669*	120,875 *4.759*	20,5 *0.807*	18.00X14.50	4	DIN374	6HX	C
MTH-M24X1.50ISO6HX-BC-P011	03000061	MF24X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	135,875 *5.349*	22,5 *0.886*	18.00X14.50	4	DIN374	6HX	C

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M24X2.00ISO6HX-BC-P011	03000062	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	134,7 *5.303*	22,0 *0.866*	18.00X14.50	4	DIN374	6HX	C
MTH-M25X1.50ISO6HX-BC-P011	03000063	MF25X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	135,7 *5.343*	23,5 *0.925*	18.00X14.50	4	DIN374	6HX	C
MTH-M26X1.50ISO6HX-BC-P011	03000064	MF26X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	135,7 *5.343*	24,5 *0.965*	18.00X14.50	4	DIN374	6HX	C
MTH-M27X1.50ISO6HX-BC-P011	03000065	MF27X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	135,875 *5.349*	25,5 *1.004*	20.00X16.00	4	DIN374	6HX	C
MTH-M27X2.00ISO6HX-BC-P011	03000066	MF27X2.0	2,0	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	134,73 *5.304*	25,0 *0.984*	20.00X16.00	4	DIN374	6HX	C
MTH-M28X1.50ISO6HX-BC-P011	03000067	MF28X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	135,72 *5.343*	26,5 *1.043*	20.00X16.00	4	DIN374	6HX	C
MTH-M30X1.50ISO6HX-BC-P011	03000068	MF30X1.5	1,5	–	22,0 *0.866*	85,0 *3.346*	20,0 *0.787*	150,0 *5.906*	28,5 *1.122*	22.00X18.00	4	DIN374	6HX	C
MTH-M30X2.00ISO6HX-BC-P011	03000069	MF30X2.0	2,0	–	22,0 *0.866*	85,0 *3.346*	20,0 *0.787*	144,73 *5.698*	28,0 *1.102*	22.00X18.00	4	DIN374	6HX	C

MTH-M003

Blind holes

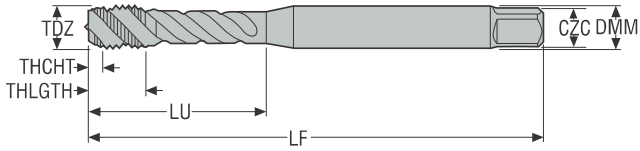


- For cutting data see page(s) 270
- Coating: TiCN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M1.6X0.35ISO6H-BC-M003	03000106	M1.6	0,35	–	2,5 *0.098*	6,0 *0.236*	4,0 *0.157*	39,21 *1.544*	1,3 *0.051*	2.50X2.10	2	DIN371	6H	C
MTH-M2X0.40ISO6H-BC-M003	03000107	M2	0,4	–	2,8 *0.110*	9,0 *0.354*	4,0 *0.157*	44,2 *1.740*	1,6 *0.063*	2.80X2.10	3	DIN371	6H	C
MTH-M2.2X0.45ISO6H-BC-M003	03000108	M2.2	0,45	–	2,8 *0.110*	12,0 *0.472*	4,0 *0.157*	44,41 *1.748*	1,8 *0.071*	2.80X2.10	3	DIN371	6H	C
MTH-M2.3X0.40ISO6H-BC-M003	03000109	M2.3	0,4	–	2,8 *0.110*	12,0 *0.472*	4,0 *0.157*	44,4 *1.748*	1,9 *0.075*	2.80X2.10	3	DIN371	6H	C
MTH-M2.5X0.45ISO6H-BC-M003	03000110	M2.5	0,45	–	2,8 *0.110*	12,5 *0.492*	4,0 *0.157*	49,32 *1.942*	2,1 *0.083*	2.80X2.10	3	DIN371	6H	C
MTH-M2.6X0.45ISO6H-BC-M003	03000111	M2.6	0,45	–	2,8 *0.110*	12,5 *0.492*	4,0 *0.157*	49,32 *1.942*	2,15 *0.085*	2.80X2.10	3	DIN371	6H	C
MTH-M3X0.50ISO6H-BC-M003	03000112	M3	0,5	–	3,5 *0.138*	18,0 *0.709*	5,9 *0.232*	54,625 *2.151*	2,5 *0.098*	3.50X2.70	3	DIN371	6H	C
MTH-M3.5X0.60ISO6H-BC-M003	03000113	M3.5	0,6	–	4,0 *0.157*	20,0 *0.787*	7,0 *0.276*	54,35 *2.140*	2,9 *0.114*	4.00X3.00	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-M003	03000114	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	61,075 *2.405*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-M003	03000115	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	7,7 *0.303*	67,8 *2.669*	4,3 *0.169*	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-M003	03000116	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	10,0 *0.394*	77,25 *3.041*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	C
MTH-M7X1.00ISO6H-BC-M003	03000117	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	10,0 *0.394*	77,25 *3.041*	6,1 *0.240*	7.00X5.50	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-M003	03000118	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	11,6 *0.457*	86,5625 *3.408*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-M003	03000119	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	15,1 *0.594*	95,875 *3.775*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	C

MTH-M003-A

Blind holes

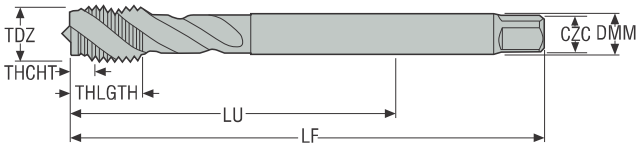


- For cutting data see page(s) 270
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.70ISO6H-BC-M003-A	03000125	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	61,075 *2.405*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-M003-A	03000126	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	7,7 *0.303*	67,8 *2.669*	4,3 *0.169*	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-M003-A	03000127	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	10,0 *0.394*	77,25 *3.041*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	C
MTH-M7X1.00ISO6H-BC-M003-A	03000128	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	10,0 *0.394*	77,57 *3.054*	6,1 *0.240*	7.00X5.50	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-M003-A	03000129	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	11,6 *0.457*	86,5625 *3.408*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-M003-A	03000130	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	15,1 *0.594*	95,875 *3.775*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	C

MTH-M004

Blind holes

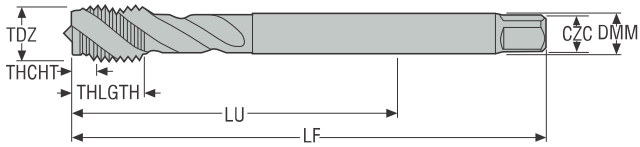


- For cutting data see page(s) 270
- Coating: TiCN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-M004	03000120	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,1875 *4.141*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-M004	03000121	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,5 *4.114*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-M004	03000122	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	20,0 *0.787*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-M004	03000123	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	25,0 *0.984*	118,125 *4.651*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-M004	03000124	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	133,125 *5.241*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C

MTH-M004-A

Blind holes

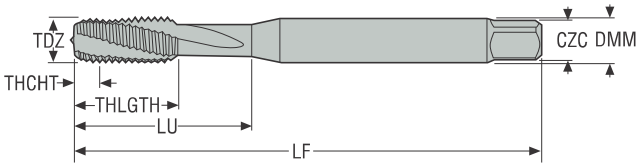


- For cutting data see page(s) 270
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-M004-A	03000131	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,1875 *4.141*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-M004-A	03000132	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	105,63 *4.159*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-M004-A	03000133	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	20,0 *0.787*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-M004-A	03000134	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	25,0 *0.984*	119,42 *4.702*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-M004-A	03000135	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	134,43 *5.293*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C

MTH-N001

Blind holes

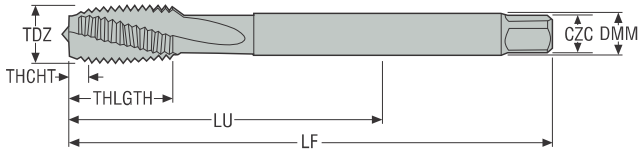


- For cutting data see page(s) 272
- Coating: BRIGHT
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6H-BC-N001	03000153	M3	0,5	–	3,5 *0.138*	18,0 *0.709*	9,0 *0.354*	54,625 *2.151*	2,5 *0.098*	3.50X2.70	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-N001	03000154	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	12,0 *0.472*	61,075 *2.405*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-N001	03000155	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	68,2 *2.685*	4,3 *0.169*	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-N001	03000156	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	77,25 *3.041*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-N001	03000157	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	18,0 *0.709*	87,0 *3.425*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-N001	03000158	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	96,3 *3.791*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	C

MTH-N002

Blind holes

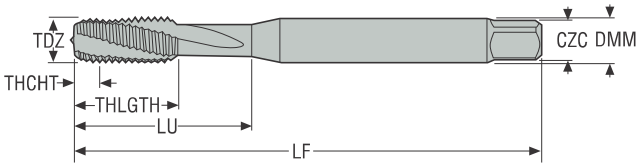


- For cutting data see page(s) 272
- Coating: BRIGHT
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-N002	03000159	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,25 *4.144*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-N002	03000160	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,6 *4.118*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-N002	03000161	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	3	DIN376	6H	C

MTH-S001

Blind holes

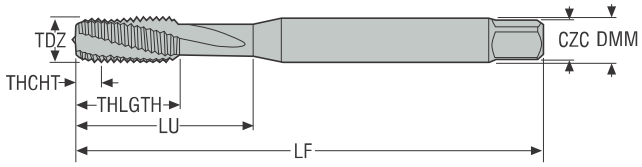


- For cutting data see page(s) 274
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6HX-BC-S001	10001105	M3	0,5	–	3,5 *0.138*	8,0 *0.315*	8,0 *0.315*	54,75 *2.156*	2,5 *0.098*	3.50X2.70	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S001	10001106	M4	0,7	–	4,5 *0.177*	10,5 *0.413*	10,5 *0.413*	61,25 *2.411*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S001	10001107	M5	0,8	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	68,0 *2.677*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S001	10001108	M6	1,0	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	77,5 *3.051*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S001	10001109	M8	1,25	–	8,0 *0.315*	20,5 *0.807*	20,5 *0.807*	86,87 *3.420*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S001	10001110	M10	1,5	–	10,0 *0.394*	25,5 *1.004*	25,5 *1.004*	96,25 *3.789*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	C

MTH-S002

Blind holes

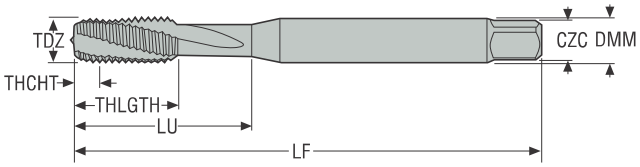


- For cutting data see page(s) 274
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-S002	10001111	M12	1,75	–	12,0 *0.472*	30,5 *1.201*	30,5 *1.201*	105,09 *4.137*	10,4 *0.409*	12.00X9.00	4	DIN371	6HX	C
MTH-M16X2.00ISO6HX-BC-S002	10001112	M16	2,0	–	16,0 *0.630*	39,5 *1.555*	39,5 *1.555*	104,4 *4.110*	14,1 *0.555*	16.00X12.00	4	DIN371	6HX	C

MTH-S003

Blind holes

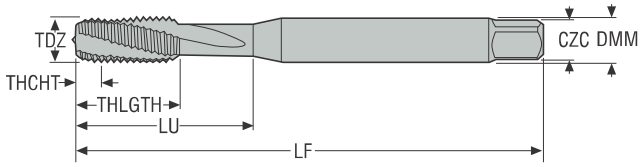


- For cutting data see page(s) 274
- Coating: TiN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6HX-BC-S003	10001073	M3	0,5	–	3,5 *0.138*	8,0 *0.315*	8,0 *0.315*	54,75 *2.156*	2,5 *0.098*	3.50X2.70	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S003	10001074	M4	0,7	–	4,5 *0.177*	10,5 *0.413*	10,5 *0.413*	61,25 *2.411*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S003	10001075	M5	0,8	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	68,0 *2.677*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S003	10001076	M6	1,0	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	77,5 *3.051*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S003	10001077	M8	1,25	–	8,0 *0.315*	20,5 *0.807*	20,5 *0.807*	86,87 *3.420*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S003	10001078	M10	1,5	–	10,0 *0.394*	25,5 *1.004*	25,5 *1.004*	96,25 *3.789*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	C

MTH-S004

Blind holes

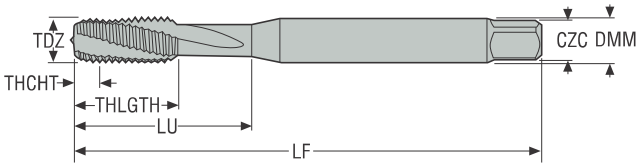


- For cutting data see page(s) 274
- Coating: TiN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-S004	10001079	M12	1,75	–	12,0 *0.472*	30,5 *1.201*	30,5 *1.201*	105,09 *4.137*	10,4 *0.409*	12.00X9.00	4	DIN371	6HX	C
MTH-M16X2.00ISO6HX-BC-S004	10001080	M16	2,0	–	16,0 *0.630*	39,5 *1.555*	39,5 *1.555*	104,4 *4.110*	14,1 *0.555*	16.00X12.00	4	DIN371	6HX	C

MTH-S011

Blind holes

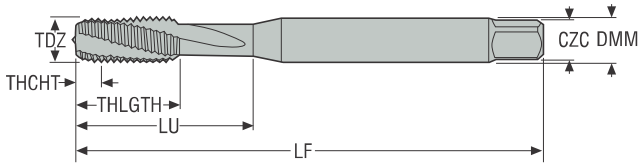


- For cutting data see page(s) 274
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M8X1.00ISO6HX-BC-S011	10001082	MF8X1	1,0	–	8,0 *0.315*	20,0 *0.787*	20,0 *0.787*	87,5 *3.445*	7,0 *0.276*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.00ISO6HX-BC-S011	10001083	MF10X1	1,0	–	10,0 *0.394*	24,0 *0.945*	24,0 *0.945*	87,5 *3.445*	9,0 *0.354*	10.00X8.00	3	DIN371	6HX	C
MTH-M10X1.25ISO6HX-BC-S011	10001084	MF10X1.25	1,25	–	10,0 *0.394*	24,5 *0.965*	24,5 *0.965*	96,87 *3.814*	8,75 *0.344*	10.00X8.00	3	DIN371	6HX	C
MTH-M12X1.25ISO6HX-BC-S011	10001085	MF12X1.25	1,25	–	12,0 *0.472*	28,5 *1.122*	28,5 *1.122*	96,49 *3.799*	10,75 *0.423*	12.00X9.00	4	DIN371	6HX	C
MTH-M12X1.50ISO6HX-BC-S011	10001086	MF12X1.5	1,5	–	12,0 *0.472*	29,5 *1.161*	29,5 *1.161*	95,8 *3.772*	10,5 *0.413*	12.00X9.00	4	DIN371	6HX	C

MTH-S012

Blind holes

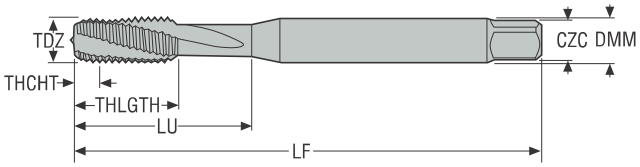


- For cutting data see page(s) 274
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-MJ3X0.50ISO4H-BC-S012	10001069	MJ3X0.5	0,5	–	3,5 *0.138*	8,0 *0.315*	8,0 *0.315*	54,75 *2.156*	2,6 *0.102*	3.50X2.70	3	DIN371	4H	C
MTH-MJ4X0.70ISO4H-BC-S012	10001070	MJ4X0.7	0,7	–	4,5 *0.177*	10,5 *0.413*	10,5 *0.413*	61,25 *2.411*	3,4 *0.134*	4.50X3.40	3	DIN371	4H	C
MTH-MJ5X0.80ISO4H-BC-S012	10001071	MJ5X0.8	0,8	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	68,0 *2.677*	4,3 *0.169*	6.00X4.90	3	DIN371	4H	C
MTH-MJ6X1.00ISO4H-BC-S012	10001072	MJ6X1	1,0	–	6,0 *0.236*	15,5 *0.610*	15,5 *0.610*	77,5 *3.051*	5,1 *0.201*	6.00X4.90	3	DIN371	4H	C

MTH-S031

Blind holes

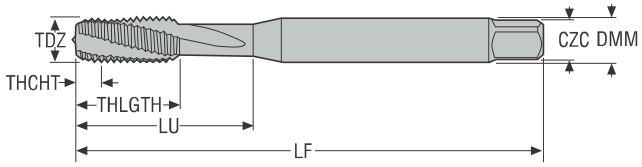


- For cutting data see page(s) 274
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-2-56UNC2B-BC-S031	10001113	UNC2-56	–	56.0	2,8 *0.110*	9,0 *0.354*	9,0 *0.354*	43,87 *1.727*	1,85 *0.073*	2.80X2.10	3	DIN2184-1	2B	C
MTH-3-48UNC2B-BC-S031	10001114	UNC3-48	–	48.0	2,8 *0.110*	9,0 *0.354*	9,0 *0.354*	48,68 *1.917*	2,1 *0.083*	2.80X2.10	3	DIN2184-1	2B	C
MTH-4-40UNC2B-BC-S031	10001115	UNC4-40	–	40.0	3,5 *0.138*	10,0 *0.394*	10,0 *0.394*	54,41 *2.142*	2,35 *0.093*	3.50X2.70	3	DIN2184-1	2B	C
MTH-6-32UNC2B-BC-S031	10001116	UNC6-32	–	32.0	4,0 *0.157*	12,0 *0.472*	12,0 *0.472*	54,02 *2.127*	2,85 *0.112*	4.00X3.00	3	DIN2184-1	2B	C
MTH-8-32UNC2B-BC-S031	10001117	UNC8-32	–	32.0	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	61,02 *2.402*	3,5 *0.138*	4.50X3.40	3	DIN2184-1	2B	C
MTH-10-24UNC2B-BC-S031	10001119	UNC10-24	–	24.0	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	67,35 *2.652*	3,9 *0.154*	6.00X4.90	3	DIN2184-1	2B	C
MTH-1/4-20UNC2B-BC-S031	10001120	UNC1/4-20	–	20.0	7,0 *0.276*	15,0 *0.591*	15,0 *0.591*	76,44 *3.009*	5,1 *0.201*	7.00X5.50	3	DIN2184-1	2B	C
MTH-5/16-18UNC2B-BC-S031	10001122	UNC5/16-18	–	18.0	8,0 *0.315*	18,0 *0.709*	18,0 *0.709*	86,05 *3.388*	6,6 *0.260*	8.00X6.20	3	DIN2184-1	2B	C
MTH-3/8-16UNC2B-BC-S031	10001121	UNC3/8-16	–	16.0	10,0 *0.394*	20,0 *0.787*	20,0 *0.787*	95,55 *3.762*	8,0 *0.315*	10.00X8.00	4	DIN2184-1	2B	C

MTH-S032

Blind holes

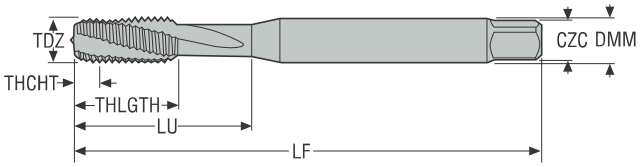


- For cutting data see page(s) 274
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-4-40UNJC3B-BC-S032	10001087	UNJC4-40	–	40.0	3,5 *0.138*	8,0 *0.315*	8,0 *0.315*	54,41 *2.142*	2,3 *0.091*	3.50X2.70	3	DIN2184-1	3B	C
MTH-6-32UNJC3B-BC-S032	10001088	UNJC6-32	–	32.0	4,0 *0.157*	10,0 *0.394*	10,0 *0.394*	54,02 *2.127*	2,8 *0.110*	4.00X3.00	3	DIN2184-1	3B	C
MTH-8-32UNJC3B-BC-S032	10001089	UNJC8-32	–	32.0	4,5 *0.177*	11,0 *0.433*	11,0 *0.433*	61,02 *2.402*	3,5 *0.138*	4.50X3.40	3	DIN2184-1	3B	C
MTH-10-24UNJC3B-BC-S032	10001090	UNJC10-24	–	24.0	6,0 *0.236*	13,5 *0.531*	13,5 *0.531*	67,35 *2.652*	3,9 *0.154*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-20UNJC3B-BC-S032	10001091	UNJC1/4-20	–	20.0	7,0 *0.276*	17,5 *0.689*	17,5 *0.689*	76,82 *3.024*	5,2 *0.205*	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-18UNJC3B-BC-S032	10001093	UNJC5/16-18	–	18.0	8,0 *0.315*	21,0 *0.827*	21,0 *0.827*	86,47 *3.404*	6,7 *0.264*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-16UNJC3B-BC-S032	10001092	UNJC3/8-16	–	16.0	10,0 *0.394*	25,0 *0.984*	25,0 *0.984*	96,03 *3.781*	8,1 *0.319*	10.00X8.00	3	DIN2184-1	3B	C

MTH-S041

Blind holes

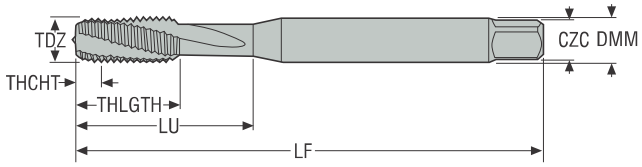


- For cutting data see page(s) 276
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-6-40UNF3B-BC-S041	10001123	UNF6-40	–	40.0	4,0 *0.157*	12,0 *0.472*	12,0 *0.472*	54,41 *2.142*	2,95 *0.116*	4.00X3.00	3	DIN2184-1	3B	C
MTH-8-36UNF3B-BC-S041	10001126	UNF8-36	–	36.0	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	61,24 *2.411*	3,5 *0.138*	4.50X3.40	3	DIN2184-1	3B	C
MTH-10-32UNF3B-BC-S041	10001127	UNF10-32	–	32.0	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	68,02 *2.678*	4,1 *0.161*	6.00X4.90	3	DIN2184-1	3B	C
MTH-12-28UNF3B-BC-S041	10001129	UNF12-28	–	28.0	6,0 *0.236*	15,0 *0.591*	15,0 *0.591*	77,46 *3.050*	4,6 *0.181*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNF3B-BC-S041	10001130	UNF1/4-28	–	28.0	7,0 *0.276*	25,0 *0.984*	15,0 *0.591*	77,46 *3.050*	5,5 *0.217*	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNF3B-BC-S041	10001133	UNF5/16-24	–	24.0	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	87,03 *3.426*	6,9 *0.272*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNF3B-BC-S041	10001131	UNF3/8-24	–	24.0	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	97,03 *3.820*	8,5 *0.335*	10.00X8.00	4	DIN2184-1	3B	C

MTH-S042

Blind holes

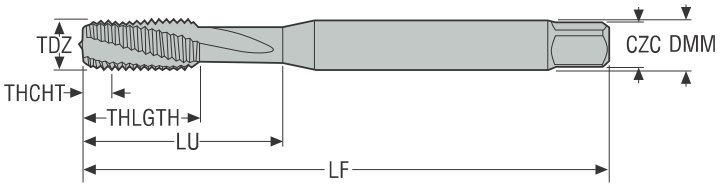


- For cutting data see page(s) 276
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-6-40UNJF3B-BC-S042	10001094	UNJF6-40	–	40.0	4,0 *0.157*	9,5 *0.374*	9,5 *0.374*	54,41 *2.142*	2,95 *0.116*	4.00X3.00	3	DIN2184-1	3B	C
MTH-8-36UNJF3B-BC-S042	10001095	UNJF8-36	–	36.0	4,5 *0.177*	11,0 *0.433*	11,0 *0.433*	61,24 *2.411*	3,6 *0.142*	4.50X3.40	3	DIN2184-1	3B	C
MTH-10-32UNJF3B-BC-S042	10001097	UNJF10-32	–	32.0	6,0 *0.236*	12,5 *0.492*	12,5 *0.492*	68,02 *2.678*	4,15 *0.163*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNJF3B-BC-S042	10001098	UNJF1/4-28	–	28.0	7,0 *0.276*	16,0 *0.630*	16,0 *0.630*	77,73 *3.060*	5,6 *0.220*	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNJF3B-BC-S042	10001100	UNJF5/16-24	–	24.0	8,0 *0.315*	20,0 *0.787*	20,0 *0.787*	87,35 *3.439*	7,0 *0.276*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNJF3B-BC-S042	10001099	UNJF3/8-24	–	24.0	10,0 *0.394*	23,0 *0.906*	23,0 *0.906*	97,35 *3.833*	8,6 *0.339*	10.00X8.00	3	DIN2184-1	3B	C

MTH-S043

Blind holes

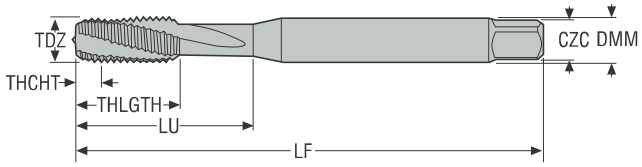


- For cutting data see page(s) 276
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					
MTH-10-32EGUNF3B-BC-S043 *MTH-10-32STIUNF3B-BC-S043*	10001199	EGUN10-32	–	32.0	6,0 *0.236*	23 *0.906*	15,0 *0.591*	77,8 *3.062*	5,1 *0.201*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28EGUNF3B-BC-S043 *MTH-1/4-28STIUNF3B-BC-S043*	10001200	EGUNF1/4-28	–	28.0	8,0 *0.315*	30 *1.161*	18,0 *0.709*	87,5 *3.443*	6,6 *0.260*	8.00X6.20	3	DIN2184-1	3B	C
MTH-5/16-24EGUNF3B-BC-S043 *MTH-5/16-24STIUNF3B-BC-S043*	10001201	EGUNF5/16-24	–	24.0	10,0 *0.394*	34 *1.319*	20,0 *0.787*	97,0 *3.820*	8,2 *0.323*	10.00X8.00	3	DIN2184-1	3B	C
MTH-3/8-24EGUNF3B-BC-S043 *MTH-3/8-24STIUNF3B-BC-S043*	10001202	EGUNF3/8-24	–	24.0	8,0 *0.315*	76 *2.992*	20,0 *0.787*	97,0 *3.820*	9,8 *0.386*	8.00X6.20	4	DIN2184-1	3B	C

MTH-S044

Blind holes

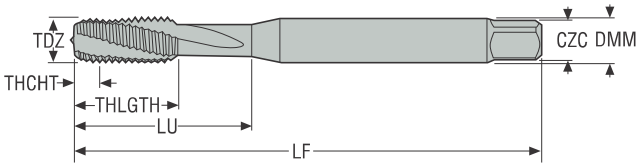


- For cutting data see page(s) 276
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					
MTH-10-32EGUNF3B-BC-S044 *MTH-10-32STIUNF3B-BC-S044*	10001101	EGUNF10-32	–	32.0	6,0 *0.236*	15 *0.591*	15,0 *0.591*	78,0 *3.072*	5,1 *0.201*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28EGUNF3B-BC-S044 *MTH-1/4-28STIUNF3B-BC-S044*	10001102	EGUNF1/4-28	–	28.0	8,0 *0.315*	18 *0.709*	18,0 *0.709*	87,7 *3.454*	6,6 *0.260*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24EGUNF3B-BC-S044 *MTH-3/8-24STIUNF3B-BC-S044*	10001103	EGUNF3/8-24	–	24.0	11,0 *0.433*	20 *0.787*	20,0 *0.787*	87,0 *3.426*	9,8 *0.386*	11.00X9.00	4	DIN2184-1	3B	C
MTH-5/16-24EGUNF3B-BC-S044 *MTH-5/16-24STIUNF3B-BC-S044*	10001104	EGUNF5/16-24	–	24.0	10,0 *0.394*	20 *0.787*	20,0 *0.787*	87,4 *3.439*	8,2 *0.323*	10.00X8.00	3	DIN2184-1	3B	C

MTH-S101

Blind holes

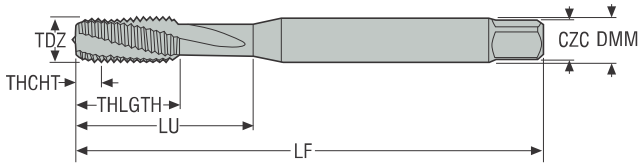


- For cutting data see page(s) 276
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M2X0.40ISO6HX-BC-S101	10001134	M2	0,4	–	2,8 *0.110*	8,0 *0.315*	8,0 *0.315*	44,0 *1.732*	1,6 *0.063*	2.80X2.10	3	DIN371	6HX	C
MTH-M2.5X0.45ISO6HX-BC-S101	10001135	M2.5	0,45	–	2,8 *0.110*	9,0 *0.354*	9,0 *0.354*	48,87 *1.924*	2,1 *0.083*	2.80X2.10	3	DIN371	6HX	C
MTH-M3X0.50ISO6HX-BC-S101	10001136	M3	0,5	–	3,5 *0.138*	10,0 *0.394*	10,0 *0.394*	54,75 *2.156*	2,5 *0.098*	3.50X2.70	3	DIN371	6HX	C
MTH-M3.5X0.60ISO6HX-BC-S101	10001137	M3.5	0,6	–	4,0 *0.157*	12,0 *0.472*	12,0 *0.472*	54,5 *2.146*	2,9 *0.114*	4.00X3.00	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S101	10001138	M4	0,7	–	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	61,25 *2.411*	3,4 *0.134*	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S101	10001139	M5	0,8	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	68,0 *2.677*	4,3 *0.169*	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S101	10001140	M6	1,0	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	77,2 *3.039*	5,1 *0.201*	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S101	10001141	M8	1,25	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	86,49 *3.405*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S101	10001142	M10	1,5	–	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	95,8 *3.772*	8,6 *0.339*	10.00X8.00	3	DIN371	6HX	C

MTH-S102

Blind holes

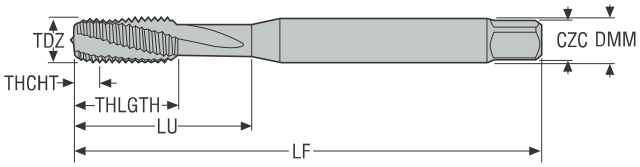


- For cutting data see page(s) 276
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-S102	10001143	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,09 *4.137*	10,4 *0.409*	9.00X7.00	4	DIN376	6HX	C
MTH-M16X2.00ISO6HX-BC-S102	10001145	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,4 *4.110*	14,1 *0.555*	12.00X9.00	4	DIN376	6HX	C
MTH-M20X2.50ISO6HX-BC-S102	10001146	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	133,0 *5.236*	17,7 *0.697*	16.00X12.00	4	DIN376	6HX	C

MTH-S111

Blind holes

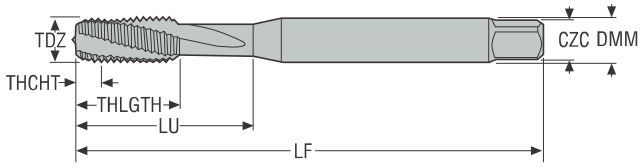


- For cutting data see page(s) 276
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M6X0.75ISO6HX-BC-S111	10001147	MF6X0.75	0,75	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	77,89 *3.067*	5,25 *0.207*	6.00X4.90	3	DIN371	6HX	C
MTH-M8X0.75ISO6HX-BC-S111	10001148	MF8X0.75	0,75	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	87,89 *3.460*	7,25 *0.285*	8.00X6.20	3	DIN371	6HX	C
MTH-M8X1.00ISO6HX-BC-S111	10001149	MF8X1	1,0	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	87,2 *3.433*	7,0 *0.276*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.00ISO6HX-BC-S111	10001150	MF10X1	1,0	–	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	97,2 *3.827*	9,0 *0.354*	10.00X8.00	3	DIN371	6HX	C
MTH-M12X1.50ISO6HX-BC-S111	10001151	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	95,8 *3.772*	10,5 *0.413*	9.00X7.00	4	DIN374	6HX	C
MTH-M14X1.50ISO6HX-BC-S111	10001152	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,8 *3.772*	12,5 *0.492*	11.00X9.00	4	DIN374	6HX	C

MTH-S112

Blind holes

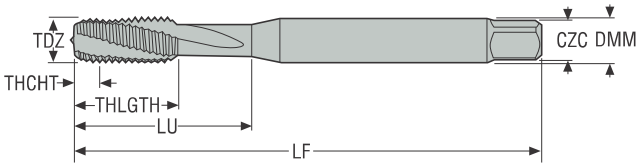


- For cutting data see page(s) 276
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-MJ3X0.50ISO4H-BC-S112	10001203	MJ3X0.5	0,5	–	3,5 *0.138*	10,0 *0.394*	10,0 *0.394*	54,75 *2.156*	2,6 *0.102*	3.50X2.70	3	DIN371	4H	C
MTH-MJ4X0.70ISO4H-BC-S112	10001204	MJ4X0.7	0,7	–	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	61,25 *2.411*	3,4 *0.134*	4.50X3.40	3	DIN371	4H	C
MTH-MJ5X0.80ISO4H-BC-S112	10001205	MJ5X0.8	0,8	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	68,0 *2.677*	4,3 *0.169*	6.00X4.90	3	DIN371	4H	C
MTH-MJ6X1.00ISO4H-BC-S112	10001206	MJ6X1	1,0	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	77,2 *3.039*	5,1 *0.201*	6.00X4.90	3	DIN371	4H	C
MTH-MJ8X1.25ISO4H-BC-S112	10001207	MJ8X1.25	1,25	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	86,49 *3.405*	6,9 *0.272*	8.00X6.20	3	DIN371	4H	C
MTH-MJ10X1.5ISO4H-BC-S112	10001208	MJ10X1.5	1,5	–	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	95,8 *3.772*	8,7 *0.343*	10.00X8.00	3	DIN371	4H	C

MTH-S142

Blind holes

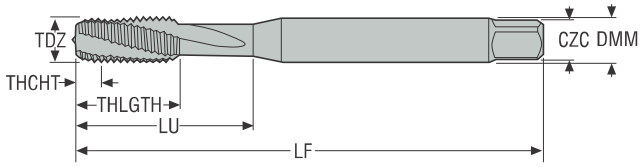


- For cutting data see page(s) 276
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-10-32UNJF3B-BC-S142	10001153	UNJF10-32	–	32.0	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	68,02 *2.678*	4,15 *0.163*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNJF3B-BC-S142	10001154	UNJF1/4-28	–	28.0	7,0 *0.276*	25,0 *0.984*	15,0 *0.591*	77,73 *3.060*	5,6 *0.220*	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNJF3B-BC-S142	10001155	UNJF5/16-24	–	24.0	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	87,03 *3.426*	7,0 *0.276*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNJF3B-BC-S142	10001156	UNJF3/8-24	–	24.0	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	97,03 *3.820*	8,6 *0.339*	10.00X8.00	3	DIN2184-1	3B	C

MTH-V011

Blind holes

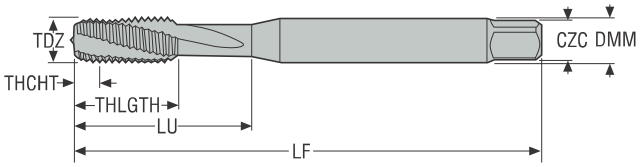


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M8X0.75ISO6HX-BC-V011	03000162	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	13,0 *0.512*	87,9375 *3.462*	7,3 *0.287*	6.00X4.90	3	DIN374	6HX	C
MTH-M18X1.00ISO6HX-BC-V011	03000174	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	17,0 *0.669*	106,51 *4.193*	17,1 *0.673*	14.00X11.00	3	DIN374	6HX	C
MTH-M20X1.00ISO6HX-BC-V011	03000176	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	17,0 *0.669*	121,53 *4.785*	19,1 *0.752*	16.00X12.00	3	DIN374	6HX	C

MTH-V015

Blind holes

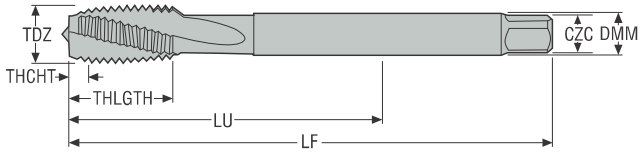


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6H-BC-V015	03019188	M3	0,5	–	3,5 *0.138*	18,0 *0.709*	9,0 *0.354*	54,625 *2.151*	2,5 *0.098*	3.50X2.70	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-V015	03019189	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	11,0 *0.433*	61,075 *2.405*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-V015	03019190	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	67,8 *2.669*	4,3 *0.169*	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-V015	03019191	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	77,25 *3.041*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-V015	03019193	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	18,0 *0.709*	86,5625 *3.408*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-V015	03019194	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	95,875 *3.775*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	C

MTH-V016

Blind holes

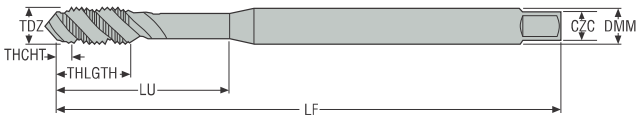


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-V016	03019195	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,1875 *4.141*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-V016	03019196	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,5 *4.114*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-V016	03019197	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,5 *4.114*	14,1 *0.555*	12.00X9.00	3	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-V016	03019198	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	118,125 *4.651*	15,7 *0.618*	14.00X11.00	3	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V016	03019199	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	133,125 *5.241*	17,7 *0.697*	16.00X12.00	3	DIN376	6H	C
MTH-M22X2.50ISO6H-BC-V016	03019200	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	133,125 *5.241*	19,7 *0.776*	18.00X14.50	4	DIN376	6H	C
MTH-M24X3.00ISO6H-BC-V016	03019201	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	151,75 *5.974*	21,0 *0.827*	18.00X14.50	4	DIN376	6H	C
MTH-M27X3.00ISO6H-BC-V016	03019202	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	151,75 *5.974*	24,0 *0.945*	20.00X16.00	4	DIN376	6H	C
MTH-M30X3.50ISO6H-BC-V016	03019203	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	171,79 *6.763*	26,5 *1.043*	22.00X18.00	4	DIN376	6H	C
MTH-M33X3.50ISO6H-BC-V016	03019204	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	50,0 *1.969*	171,79 *6.763*	29,5 *1.161*	25.00X20.00	4	DIN376	6H	C
MTH-M36X4.00ISO6H-BC-V016	03019205	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	55,0 *2.165*	190,7 *7.508*	32,0 *1.260*	28.00X22.00	4	DIN376	6H	C

MTH-V025

Blind holes

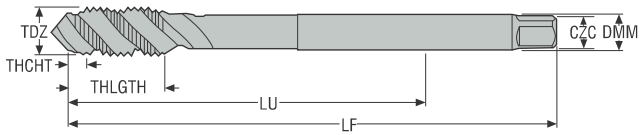


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-E
- Long version

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M6X1.00ISO6H-BC-V025	02880644	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	10,0 *0.394*	122,25 *4.813*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	C

MTH-V026

Blind holes

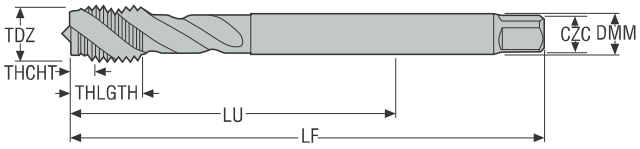


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-E
- Long version

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M14X2.00ISO6H-BC-V026	02880648	M14	2,0	–	11,0 *0.433*	151,0 *5.945*	20,0 *0.787*	174,5 *6.870*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V026	02880651	M20	2,5	–	16,0 *0.630*	179,0 *7.047*	25,0 *0.984*	217,125 *8.548*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C

MTH-V029

Blind holes

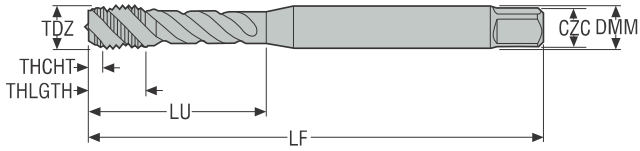


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6G-BC-V029	02880658	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	16,0 *0.630*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	3	DIN376	6G	C
MTH-M14X2.00ISO6G-BC-V029	02880659	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	20,0 *0.787*	104,5 *4.114*	12,1 *0.476*	11.00X9.00	3	DIN376	6G	C
MTH-M16X2.00ISO6G-BC-V029	02880660	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	20,0 *0.787*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	4	DIN376	6G	C
MTH-M20X2.50ISO6G-BC-V029	02880661	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	140,0 *5.512*	17,7 *0.697*	16.00X12.00	4	DIN376	6G	C

MTH-V030

Blind holes

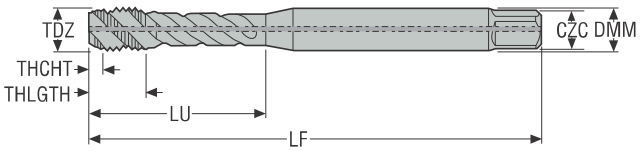


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-E ≤ M2,5; HSS-PM > M2,5

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M7X1.00ISO6H-BC-V030	02880669	M7	1,0	–	7,0 *0.276*	31,0 *1.220*	10,0 *0.394*	77,25 *3.041*	6,1 *0.240*	7.00X5.50	3	DIN371	6H	C

MTH-V030-A

Blind holes

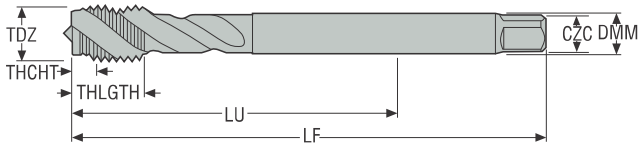


- For cutting data see page(s) 282
- Coating: TiN
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.70ISO6H-BC-V030-A	03000228	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	61,39 *2.417*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	C

MTH-V033

Blind holes

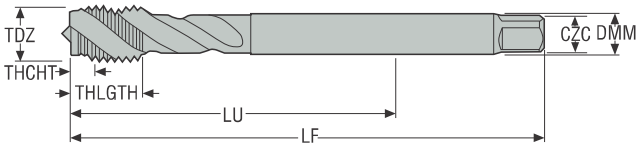


- For cutting data see page(s) 284
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M6X1.00ISO6H-BC-V033	02880683	M6	1,0	–	4,5 *0.177*	59,0 *2.323*	10,0 *0.394*	77,25 *3.041*	5,1 *0.201*	4.50X3.40	3	DIN376	6H	C
MTH-M8X1.25ISO6H-BC-V033	02880684	M8	1,25	–	6,0 *0.236*	67,0 *2.638*	13,0 *0.512*	86,5625 *3.408*	6,8 *0.268*	6.00X4.90	3	DIN376	6H	C
MTH-M10X1.50ISO6H-BC-V033	02880686	M10	1,5	–	7,0 *0.276*	77,0 *3.031*	15,0 *0.591*	95,875 *3.775*	8,6 *0.339*	7.00X5.50	3	DIN376	6H	C
MTH-M39X4.00ISO6H-BC-V033	03000221	M39	4,0	–	32,0 *1.260*	102,0 *4.016*	40,0 *1.575*	189,9 *7.476*	35,0 *1.378*	32.00X24.00	4	DIN376	6H	C
MTH-M42X4.50ISO6H-BC-V033	03000223	M42	4,5	–	32,0 *1.260*	102,0 *4.016*	45,0 *1.772*	188,77 *7.432*	37,5 *1.476*	32.00X24.00	4	DIN376	6H	C
MTH-M48X5.00ISO6H-BC-V033	03000224	M48	5,0	–	36,0 *1.417*	147,0 *5.787*	50,0 *1.969*	237,65 *9.356*	43,0 *1.693*	36.00X29.00	4	DIN376	6H	C
MTH-M52X5.00ISO6H-BC-V033	03000225	M52	5,0	–	40,0 *1.575*	120,0 *4.724*	50,0 *1.969*	237,65 *9.356*	47,0 *1.850*	40.00X32.00	5	DIN376	6H	C
MTH-M56X5.50ISO6H-BC-V033	03000226	M56	5,5	–	40,0 *1.575*	120,0 *4.724*	55,0 *2.165*	236,52 *9.312*	50,5 *1.988*	40.00X32.00	5	DIN376	6H	C
MTH-M64X6.00ISO6H-BC-V033	03000227	M64	6,0	–	50,0 *1.969*	178,0 *7.008*	60,0 *2.362*	300,4 *11.827*	58,0 *2.283*	50.00X39.00	6	DIN376	6H	C

MTH-V033-A

Blind holes

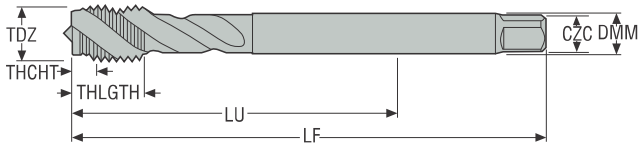


- For cutting data see page(s) 284
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M18X2.50ISO6H-BC-V033-A	03000236	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	25,0 *0.984*	118,27 *4.656*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V033-A	03000237	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	133,125 *5.241*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C
MTH-M22X2.50ISO6H-BC-V033-A	03000238	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	25,0 *0.984*	133,125 *5.241*	19,7 *0.776*	18.00X14.50	4	DIN376	6H	C
MTH-M24X3.00ISO6H-BC-V033-A	03000239	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	30,0 *1.181*	151,75 *5.974*	21,0 *0.827*	18.00X14.50	4	DIN376	6H	C
MTH-M27X3.00ISO6H-BC-V033-A	03000240	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	30,0 *1.181*	152,15 *5.990*	24,0 *0.945*	20.00X16.00	4	DIN376	6H	C
MTH-M30X3.50ISO6H-BC-V033-A	03000241	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	36,0 *1.417*	171,02 *6.733*	26,5 *1.043*	22.00X18.00	4	DIN376	6H	C
MTH-M33X3.50ISO6H-BC-V033-A	03000242	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	50,0 *1.969*	171,02 *6.733*	29,5 *1.161*	25.00X20.00	4	DIN376	6H	C
MTH-M36X4.00ISO6H-BC-V033-A	03000243	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	55,0 *2.165*	189,9 *7.476*	32,0 *1.260*	28.00X22.00	4	DIN376	6H	C
MTH-M39X4.00ISO6H-BC-V033-A	03000244	M39	4,0	–	32,0 *1.260*	102,0 *4.016*	40,0 *1.575*	189,9 *7.476*	35,0 *1.378*	32.00X24.00	4	DIN376	6H	C
MTH-M42X4.50ISO6H-BC-V033-A	03000245	M42	4,5	–	32,0 *1.260*	102,0 *4.016*	45,0 *1.772*	188,77 *7.432*	37,5 *1.476*	32.00X24.00	4	DIN376	6H	C
MTH-M48X5.00ISO6H-BC-V033-A	03000246	M48	5,0	–	36,0 *1.417*	147,0 *5.787*	50,0 *1.969*	237,65 *9.356*	43,0 *1.693*	36.00X29.00	4	DIN376	6H	C
MTH-M52X5.00ISO6H-BC-V033-A	03000247	M52	5,0	–	40,0 *1.575*	120,0 *4.724*	50,0 *1.969*	237,65 *9.356*	47,0 *1.850*	40.00X32.00	5	DIN376	6H	C
MTH-M56X5.50ISO6H-BC-V033-A	03000248	M56	5,5	–	40,0 *1.575*	120,0 *4.724*	55,0 *2.165*	236,52 *9.312*	50,5 *1.988*	40.00X32.00	5	DIN376	6H	C
MTH-M64X6.00ISO6H-BC-V033-A	03000249	M64	6,0	–	50,0 *1.969*	178,0 *7.008*	60,0 *2.362*	300,4 *11.827*	58,0 *2.283*	50.00X39.00	6	DIN376	6H	C

MTH-V038

Blind holes

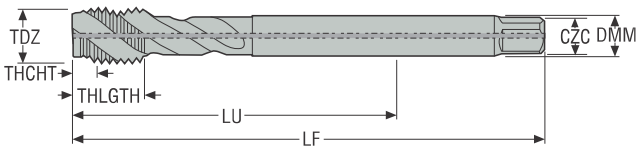


- For cutting data see page(s) 284
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					
MTH-M9X1.00ISO6H-BC-V038 *MTH-M9X1.00ISO6H-BC-V038*	03000361	MF9X1.0	1,0	–	7,0 *0.276*	67 *2.638*	17,0 *0.669*	87,3 *3.435*	8,1 *0.319*	7.00X5.50	3	DIN374	6H	C
MTH-M11X1.00ISO6H-BC-V038 *MTH-M11X1.00ISO6H-BC-V038*	03000362	MF11X1.0	1,0	–	8,0 *0.315*	63 *2.480*	18,0 *0.709*	87,3 *3.435*	10,1 *0.398*	8.00X6.20	3	DIN374	6H	C
MTH-M11X1.25ISO6H-BC-V038 *MTH-M11X1.25ISO6H-BC-V038*	03000363	MF11X1.25	1,25	–	8,0 *0.315*	63 *2.480*	22,0 *0.866*	86,6 *3.408*	9,8 *0.386*	8.00X6.20	3	DIN374	6H	C
MTH-M14X1.00ISO6H-BC-V038 *MTH-M14X1.00ISO6H-BC-V038*	02880698	MF14X1.0	1,0	–	11,0 *0.433*	71 *2.795*	15,0 *0.591*	107,3 *4.222*	13,1 *0.516*	11.00X9.00	3	DIN374	6H	C
MTH-M14X1.25ISO6H-BC-V038 *MTH-M14X1.25ISO6H-BC-V038*	02880699	MF14X1.25	1,25	–	11,0 *0.433*	71 *2.795*	15,0 *0.591*	106,6 *4.195*	12,8 *0.504*	11.00X9.00	3	DIN374	6H	C
MTH-M16X1.00ISO6H-BC-V038 *MTH-M16X1.00ISO6H-V038*	02880702	MF16X1.0	1,0	–	12,0 *0.472*	58 *2.283*	15,0 *0.591*	97,3 *3.829*	15,1 *0.594*	12.00X9.00	4	DIN374	6H	C
MTH-M18X1.00ISO6H-BC-V038 *MTH-M18X1.00ISO6H-BC-V038*	02880704	MF18X1.0	1,0	–	14,0 *0.551*	66 *2.598*	17,0 *0.669*	107,3 *4.222*	17,1 *0.673*	14.00X11.00	4	DIN374	6H	C
MTH-M20X1.00ISO6H-BC-V038 *MTH-M20X1.00ISO6H-BC-V038*	02880706	MF20X1.0	1,0	–	16,0 *0.630*	80 *3.150*	17,0 *0.669*	122,3 *4.813*	19,1 *0.752*	16.00X12.00	4	DIN374	6H	C
MTH-M24X2.00ISO6H-BC-V038 *MTH-M24X2.00ISO6H-BC-V038*	02880710	MF24X2.0	2,0	–	18,0 *0.709*	93 *3.661*	20,0 *0.787*	120,9 *4.759*	22,0 *0.866*	18.00X14.50	4	DIN374	6H	C
MTH-M25X1.50ISO6H-BC-V038 *MTH-M25X1.50ISO6H-BC-V038*	02880711	MF25X1.5	1,5	–	18,0 *0.709*	93 *3.661*	20,0 *0.787*	135,9 *5.349*	23,5 *0.925*	18.00X14.50	4	DIN374	6H	C
MTH-M26X1.50ISO6H-BC-V038 *MTH-M26X1.50ISO6H-BC-V038*	02880712	MF26X1.5	1,5	–	18,0 *0.709*	93 *3.661*	20,0 *0.787*	135,5 *5.335*	24,5 *0.965*	18.00X14.50	4	DIN374	6H	C
MTH-M27X1.50ISO6H-BC-V038 *MTH-M27X1.50ISO6H-BC-V038*	02880713	MF27X1.5	1,5	–	20,0 *0.787*	77 *3.031*	20,0 *0.787*	135,9 *5.349*	25,5 *1.004*	20.00X16.00	4	DIN374	6H	C
MTH-M27X2.00ISO6H-BC-V038 *MTH-M27X2.00ISO6H-BC-V038*	02880714	MF27X2.0	2,0	–	20,0 *0.787*	77 *3.031*	20,0 *0.787*	134,5 *5.295*	25,0 *0.984*	20.00X16.00	4	DIN374	6H	C
MTH-M28X1.50ISO6H-BC-V038 *MTH-M28X1.50ISO6H-BC-V038*	02880715	MF28X1.5	1,5	–	20,0 *0.787*	77 *3.031*	20,0 *0.787*	135,5 *5.335*	26,5 *1.043*	20.00X16.00	4	DIN374	6H	C
MTH-M30X1.50ISO6H-BC-V038 *MTH-M30X1.50ISO6H-BC-V038*	02880717	MF30X1.5	1,5	–	22,0 *0.866*	85 *3.346*	20,0 *0.787*	145,5 *5.729*	28,5 *1.122*	22.00X18.00	4	DIN374	6H	C
MTH-M30X2.00ISO6H-BC-V038 *MTH-M30X2.00ISO6H-BC-V038*	02880718	MF30X2.0	2,0	–	22,0 *0.866*	85 *3.346*	20,0 *0.787*	144,4 *5.685*	28,0 *1.102*	22.00X18.00	4	DIN374	6H	C

MTH-V038-A

Blind holes



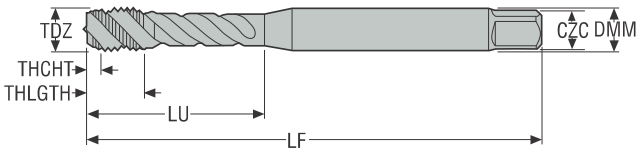
- For cutting data see page(s) 284
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M6X0.75ISO6H-BC-V038-A	03000250	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	10,0 *0.394*	77,74 *3.061*	5,3 *0.209*	4.50X3.40	3	DIN374	6H	C
MTH-M8X0.75ISO6H-BC-V038-A	03000251	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	13,0 *0.512*	77,7 *3.059*	7,3 *0.287*	6.00X4.90	3	DIN374	6H	C
MTH-M10X0.75ISO6H-BC-V038-A	03000253	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	13,0 *0.512*	87,71 *3.453*	9,3 *0.366*	7.00X5.50	3	DIN374	6H	C
MTH-M10X1.25ISO6H-BC-V038-A	03000255	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	15,0 *0.591*	96,59 *3.803*	8,8 *0.346*	7.00X5.50	3	DIN374	6H	C
MTH-M12X1.00ISO6H-BC-V038-A	03000256	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	15,0 *0.591*	97,05 *3.821*	11,1 *0.437*	9.00X7.00	3	DIN374	6H	C
MTH-M12X1.25ISO6H-BC-V038-A	03000257	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	15,0 *0.591*	96,49 *3.799*	10,8 *0.425*	9.00X7.00	3	DIN374	6H	C
MTH-M14X1.00ISO6H-BC-V038-A	03000259	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	15,0 *0.591*	97,05 *3.821*	13,1 *0.516*	11.00X9.00	3	DIN374	6H	C
MTH-M14X1.25ISO6H-BC-V038-A	03000260	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	15,0 *0.591*	96,49 *3.799*	12,8 *0.504*	11.00X9.00	3	DIN374	6H	C
MTH-M16X1.00ISO6H-BC-V038-A	03000262	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	15,0 *0.591*	97,05 *3.821*	15,1 *0.594*	12.00X9.00	4	DIN374	6H	C
MTH-M18X1.00ISO6H-BC-V038-A	03000264	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	17,0 *0.669*	106,65 *4.199*	17,1 *0.673*	14.00X11.00	4	DIN374	6H	C
MTH-M18X1.50ISO6H-BC-V038-A	03000265	MF18X1.5	1,5	–	14,0 *0.551*	66,0 *2.598*	17,0 *0.669*	105,52 *4.154*	16,6 *0.654*	14.00X11.00	4	DIN374	6H	C
MTH-M20X1.00ISO6H-BC-V038-A	03000266	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	17,0 *0.669*	121,65 *4.789*	19,1 *0.752*	16.00X12.00	4	DIN374	6H	C
MTH-M20X1.50ISO6H-BC-V038-A	03000267	MF20X1.5	1,5	–	16,0 *0.630*	80,0 *3.150*	17,0 *0.669*	120,875 *4.759*	18,6 *0.732*	16.00X12.00	4	DIN374	6H	C
MTH-M22X1.50ISO6H-BC-V038-A	03000268	MF22X1.5	1,5	–	18,0 *0.709*	78,0 *3.071*	17,0 *0.669*	120,875 *4.759*	20,5 *0.807*	18.00X14.50	4	DIN374	6H	C
MTH-M24X1.50ISO6H-BC-V038-A	03000269	MF24X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	135,52 *5.335*	22,5 *0.886*	18.00X14.50	4	DIN374	6H	C
MTH-M24X2.00ISO6H-BC-V038-A	03000270	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	134,4 *5.291*	22,0 *0.866*	18.00X14.50	4	DIN374	6H	C
MTH-M25X1.50ISO6H-BC-V038-A	03000271	MF25X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	135,52 *5.335*	23,5 *0.925*	18.00X14.50	4	DIN374	6H	C
MTH-M26X1.50ISO6H-BC-V038-A	03000272	MF26X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	135,52 *5.335*	24,5 *0.965*	18.00X14.50	4	DIN374	6H	C
MTH-M27X1.50ISO6H-BC-V038-A	03000273	MF27X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	135,52 *5.335*	25,5 *1.004*	20.00X16.00	4	DIN374	6H	C
MTH-M27X2.00ISO6H-BC-V038-A	03000274	MF27X2.0	2,0	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	134,4 *5.291*	25,0 *0.984*	20.00X16.00	4	DIN374	6H	C
MTH-M28X1.50ISO6H-BC-V038-A	03000275	MF28X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	135,52 *5.335*	26,5 *1.043*	20.00X16.00	4	DIN374	6H	C

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M30X1.50ISO6H-BC-V038-A	03000276	MF30X1.5	1,5	–	22,0 *0.866*	85,0 *3.346*	20,0 *0.787*	145,52 *5.729*	28,5 *1.122*	22.00X18.00	4	DIN374	6H	C
MTH-M30X2.00ISO6H-BC-V038-A	03000277	MF30X2.0	2,0	–	22,0 *0.866*	85,0 *3.346*	20,0 *0.787*	144,4 *5.685*	28,0 *1.102*	22.00X18.00	4	DIN374	6H	C

MTH-V043

Blind holes

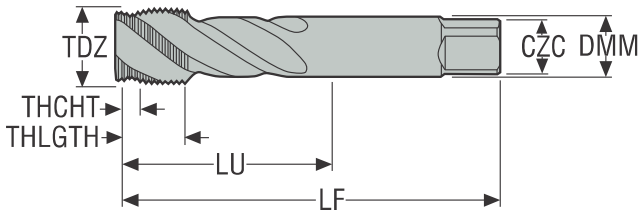


- For cutting data see page(s) 284
- Coating: TiN
- Substrate: HSS-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-3/4-16UNF-BC-V043	03000279	UNF3/4-16	–	16.0	14,0 *0.551*	77,5 *3.051*	25,0 *0.984*	120,63 *4.749*	17,6 *0.693*	14.00X11.00	4	DIN2184-1	2B	C
MTH-7/8-14UNF-BC-V043	03000280	UNF7/8-14	–	14.0	18,0 *0.709*	93,0 *3.661*	25,0 *0.984*	135,0 *5.315*	20,6 *0.811*	18.00X14.50	4	DIN2184-1	2B	C
MTH-1-12UNF-BC-V043	03000281	UNF1-12	–	12.0	18,0 *0.709*	113,0 *4.449*	30,0 *1.181*	154,17 *6.070*	23,5 *0.925*	18.00X14.50	4	DIN2184-1	2B	C

MTH-V045

Blind holes

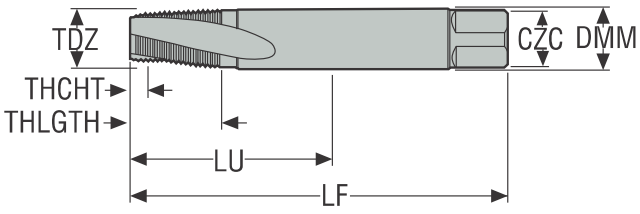


- For cutting data see page(s) 284
- Coating: TiN
- Substrate: HSS-PM ≤ G3/8, HSS-E > G3/8

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-1.1/8-11G-BC-V045	02880747	G1.1/8-11	–	11.0	28,0 *1.102*	101,0 *3.976*	22,0 *0.866*	163,7 *6.445*	35,5 *1.398*	28.00X22.00	4	DIN5156	NORMAL	C
MTH-1.1/4-11G-BC-V045	02880748	G1.1/4-11	–	11.0	32,0 *1.260*	72,0 *2.835*	22,0 *0.866*	163,7 *6.445*	39,5 *1.555*	32.00X24.00	4	DIN5156	NORMAL	C
MTH-1.1/2-11G-BC-V045	02880749	G1.1/2-11	–	11.0	36,0 *1.417*	87,0 *3.425*	23,0 *0.906*	183,7 *7.232*	45,4 *1.787*	36.00X29.00	4	DIN5156	NORMAL	C

MTH-V048

Blind holes

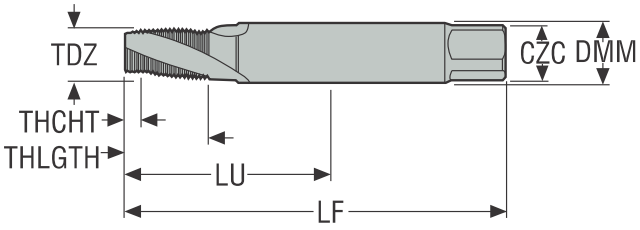


- For cutting data see page(s) 290
- Vaporised
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-1/16-27NPT-XC-V048	02880750	NPT1/16-27	–	27.0	7,95 *0.313*	56,0 *2.205*	14,0 *0.551*	80,0 *3.150*	6,15 *0.242*	7.95X5.94	3	DIN/ANSI	NORMAL	C
MTH-1/8-27NPT-XC-V048	02880751	NPT1/8-27	–	27.0	11,1 *0.437*	64,0 *2.520*	14,0 *0.551*	90,0 *3.543*	8,4 *0.331*	11.10X8.33	4	DIN/ANSI	NORMAL	C
MTH-1/4-18NPT-XC-V048	02880752	NPT1/4-18	–	18.0	14,27 *0.562*	59,0 *2.323*	20,0 *0.787*	100,0 *3.937*	11,1 *0.437*	14.27X10.69	4	DIN/ANSI	NORMAL	C
MTH-3/8-18NPT-XC-V048	02880753	NPT3/8-18	–	18.0	17,78 *0.700*	67,0 *2.638*	20,0 *0.787*	110,0 *4.331*	14,3 *0.563*	17.78X13.49	5	DIN/ANSI	NORMAL	C
MTH-1/2-14NPT-XC-V048	02880754	NPT1/2-14	–	14.0	17,45 *0.687*	79,0 *3.110*	26,0 *1.024*	125,0 *4.921*	17,9 *0.705*	17.45X13.08	5	DIN/ANSI	NORMAL	C
MTH-3/4-14NPT-XC-V048	02880755	NPT3/4-14	–	14.0	23,01 *0.906*	78,0 *3.071*	26,0 *1.024*	140,0 *5.512*	23,2 *0.913*	23.01X17.25	5	DIN/ANSI	NORMAL	C
MTH-1-11.5NPT-XC-V048	02880756	NPT1-11.5	–	11.5	28,58 *1.125*	58,0 *2.283*	31,0 *1.220*	150,0 *5.906*	29,0 *1.142*	28.58X21.41	5	DIN/ANSI	NORMAL	C

MTH-V050

Blind holes

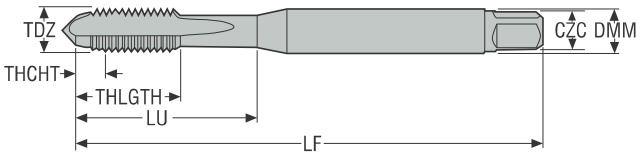


- For cutting data see page(s) 290
- Vaporised
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-1/16-27NPTF-XC-V050	02880757	NPTF1/16-27	–	27.0	7,95 *0.313*	56,0 *2.205*	14,0 *0.551*	80,0 *3.150*	6,1 *0.240*	7.95X5.94	3	DIN/ANSI	NORMAL	C
MTH-1/8-27NPTF-XC-V050	02880758	NPTF1/8-27	–	27.0	11,1 *0.437*	64,0 *2.520*	14,0 *0.551*	90,0 *3.543*	8,4 *0.331*	11.10X8.33	4	DIN/ANSI	NORMAL	C
MTH-1/4-18NPTF-XC-V050	02880759	NPTF1/4-18	–	18.0	14,27 *0.562*	59,0 *2.323*	20,0 *0.787*	100,0 *3.937*	11,0 *0.433*	14.27X10.69	4	DIN/ANSI	NORMAL	C
MTH-3/8-18NPTF-XC-V050	02880760	NPTF3/8-18	–	18.0	17,78 *0.700*	67,0 *2.638*	20,0 *0.787*	110,0 *4.331*	14,3 *0.563*	17.78X13.49	5	DIN/ANSI	NORMAL	C
MTH-1/2-14NPTF-XC-V050	02880761	NPTF1/2-14	–	14.0	17,45 *0.687*	79,0 *3.110*	26,0 *1.024*	125,0 *4.921*	17,6 *0.693*	17.45X13.08	5	DIN/ANSI	NORMAL	C
MTH-3/4-14NPTF-XC-V050	02880762	NPTF3/4-14	–	14.0	23,01 *0.906*	78,0 *3.071*	26,0 *1.024*	140,0 *5.512*	23,0 *0.906*	23X17.25	5	DIN/ANSI	NORMAL	C

MTS-K101

Blind and through holes

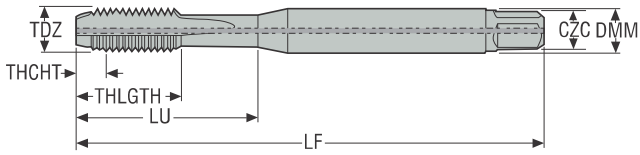


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M3X0.50ISO6HX-XC-K101	03305497	M3	0,5	–	3,5 *0.138*	18,0 *0.709*	9,0 *0.354*	54,63 *2.151*	2,5 *0.098*	3.50X2.70	4	DIN371	6HX	C
MTS-M4X0.70ISO6HX-XC-K101	03305498	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	12,0 *0.472*	61,08 *2.405*	3,4 *0.134*	4.50X3.40	4	DIN371	6HX	C
MTS-M5X0.80ISO6HX-XC-K101	03305499	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	67,80 *2.669*	4,3 *0.169*	6.00X4.90	5	DIN371	6HX	C
MTS-M6X1.00ISO6HX-XC-K101	03305500	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	77,25 *3.041*	5,1 *0.201*	6.00X4.90	5	DIN371	6HX	C
MTS-M8X1.25ISO6HX-XC-K101	03305501	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	18,0 *0.709*	86,56 *3.408*	6,8 *0.268*	8.00X6.20	5	DIN371	6HX	C
MTS-M10X1.50ISO6HX-XC-K101	03305502	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	95,88 *3.775*	8,6 *0.339*	10.00X8.00	5	DIN371	6HX	C

MTS-K101-A

Blind and through holes

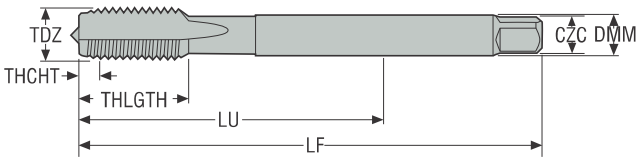


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M4X0.70ISO6HX-XC-K101-A	03305448	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	12,0 *0.472*	61,07 *2.404*	3,4 *0.134*	4.50X3.40	4	DIN371	6HX	C
MTS-M5X0.80ISO6HX-XC-K101-A	03305450	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	67,80 *2.669*	4,3 *0.169*	6.00X4.90	5	DIN371	6HX	C
MTS-M5X0.80ISO6HX-XE-K101-A	03305460	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	67,80 *2.669*	4,3 *0.169*	6.00X4.90	5	DIN371	6HX	E
MTS-M6X1.00ISO6HX-XC-K101-A	03305451	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	77,25 *3.041*	5,1 *0.201*	6.00X4.90	5	DIN371	6HX	C
MTS-M6X1.00ISO6HX-XE-K101-A	03305461	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	78,25 *3.081*	5,1 *0.201*	6.00X4.90	5	DIN371	6HX	E
MTS-M8X1.25ISO6HX-XC-K101-A	03305452	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	18,0 *0.709*	86,56 *3.408*	6,8 *0.268*	8.00X6.20	5	DIN371	6HX	C
MTS-M8X1.25ISO6HX-XE-K101-A	03305462	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	18,0 *0.709*	87,81 *3.457*	6,8 *0.268*	8.00X6.20	5	DIN371	6HX	E
MTS-M10X1.50ISO6HX-XC-K101-A	03305453	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	95,88 *3.775*	8,6 *0.339*	10.00X8.00	5	DIN371	6HX	C
MTS-M10X1.50ISO6HX-XE-K101-A	03305463	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	97,38 *3.834*	8,6 *0.339*	10.00X8.00	5	DIN371	6HX	E

MTS-K002

Blind and through holes

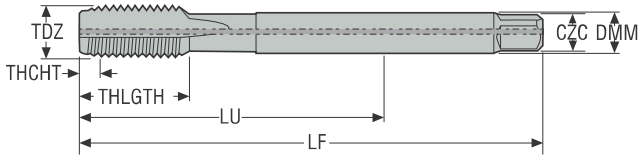


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M27X3.00ISO6HX-XC-K002	02999880	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	151,6 *5.969*	24,0 *0.945*	20.00X16.00	4	DIN376	6HX	C
MTS-M30X3.50ISO6HX-XC-K002	02999881	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	170,2 *6.701*	26,5 *1.043*	22.00X18.00	4	DIN376	6HX	C
MTS-M33X3.50ISO6HX-XC-K002	02999882	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	50,0 *1.969*	170,2 *6.701*	29,5 *1.161*	25.00X20.00	4	DIN376	6HX	C
MTS-M36X4.00ISO6HX-XC-K002	02999883	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	55,0 *2.165*	188,8 *7.433*	32,0 *1.260*	28.00X22.00	4	DIN376	6HX	C
MTS-M39X4.00ISO6HX-XC-K002	02999884	M39	4,0	–	32,0 *1.260*	102,0 *4.016*	60,0 *2.362*	188,8 *7.433*	35,0 *1.378*	32.00X24.00	4	DIN376	6HX	C
MTS-M42X4.50ISO6HX-XC-K002	02999885	M42	4,5	–	32,0 *1.260*	102,0 *4.016*	60,0 *2.362*	187,4 *7.378*	37,5 *1.476*	32.00X24.00	4	DIN376	6HX	C

MTS-K002-A

Blind and through holes

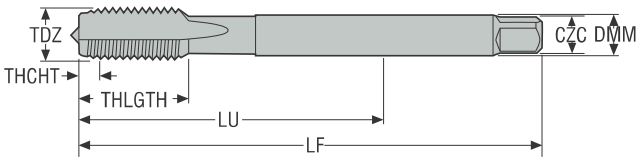


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M27X3.00ISO6HX-XC-K002-A	02999838	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	152,5 *6.004*	24,0 *0.945*	20.00X16.00	4	DIN376	6HX	C
MTS-M30X3.50ISO6HX-XC-K002-A	02999839	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	171,25 *6.742*	26,5 *1.043*	22.00X18.00	4	DIN376	6HX	C
MTS-M33X3.50ISO6HX-XC-K002-A	02999840	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	50,0 *1.969*	170,2 *6.701*	29,5 *1.161*	25.00X20.00	4	DIN376	6HX	C
MTS-M36X4.00ISO6HX-XC-K002-A	02999841	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	55,0 *2.165*	188,8 *7.433*	32,0 *1.260*	28.00X22.00	4	DIN376	6HX	C
MTS-M39X4.00ISO6HX-XC-K002-A	02999842	M39	4,0	–	32,0 *1.260*	102,0 *4.016*	60,0 *2.362*	188,8 *7.433*	35,0 *1.378*	32.00X24.00	4	DIN376	6HX	C
MTS-M42X4.50ISO6HX-XC-K002-A	02999843	M42	4,5	–	32,0 *1.260*	102,0 *4.016*	60,0 *2.362*	187,4 *7.378*	37,5 *1.476*	32.00X24.00	4	DIN376	6HX	C

MTS-K102

Blind and through holes

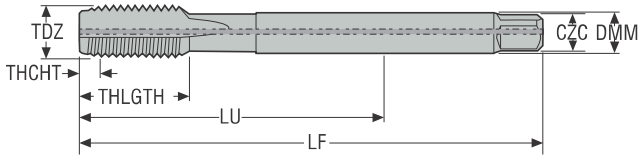


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M8X1.25ISO6HX-XC-K102	03305503	M8	1,25	–	6,0 *0.236*	67,0 *2.638*	20,0 *0.787*	86,56 *3.408*	6,8 *0.268*	6.00X4.90	5	DIN376	6HX	C
MTS-M10X1.50ISO6HX-XC-K102	03305504	M10	1,5	–	7,0 *0.276*	77,0 *3.031*	23,5 *0.925*	95,88 *3.775*	8,6 *0.339*	7.00X5.50	5	DIN376	6HX	C
MTS-M12X1.75ISO6HX-XC-K102	03305505	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,19 *4.141*	10,4 *0.409*	9.00X7.00	5	DIN376	6HX	C
MTS-M14X2.00ISO6HX-XC-K102	03305506	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,50 *4.114*	12,1 *0.476*	11.00X9.00	5	DIN376	6HX	C
MTS-M16X2.00ISO6HX-XC-K102	03305507	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,50 *4.114*	14,1 *0.555*	12.00X9.00	5	DIN376	6HX	C
MTS-M18X2.50ISO6HX-XC-K102	03305508	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	118,13 *4.651*	15,7 *0.618*	14.00X11.00	5	DIN376	6HX	C
MTS-M20X2.50ISO6HX-XC-K102	03305509	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	133,13 *5.241*	17,7 *0.697*	16.00X12.00	5	DIN376	6HX	C
MTS-M22X2.50ISO6HX-XC-K102	03305510	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	133,13 *5.241*	19,7 *0.776*	18.00X14.50	5	DIN376	6HX	C
MTS-M24X3.00ISO6HX-XC-K102	03305511	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	151,75 *5.974*	21,0 *0.827*	18.00X14.50	5	DIN376	6HX	C

MTS-K102-A

Blind and through holes

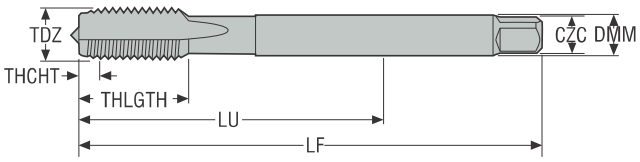


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M12X1.75ISO6HX-XC-K102-A	03305454	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	105,19 *4.141*	10,4 *0.409*	9.00X7.00	5	DIN376	6HX	C
MTS-M12X1.75ISO6HX-XE-K102-A	03305464	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	106,94 *4.210*	10,4 *0.409*	9.00X7.00	5	DIN376	6HX	E
MTS-M14X2.00ISO6HX-XC-K102-A	03305455	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	104,50 *4.114*	12,1 *0.476*	11.00X9.00	5	DIN376	6HX	C
MTS-M16X2.00ISO6HX-XC-K102-A	03305456	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,50 *4.114*	14,1 *0.555*	12.00X9.00	5	DIN376	6HX	C
MTS-M16X2.00ISO6HX-XE-K102-A	03305465	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	106,50 *4.193*	14,1 *0.555*	12.00X9.00	5	DIN376	6HX	E
MTS-M20X2.50ISO6HX-XC-K102-A	03305457	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	133,13 *5.241*	17,7 *0.697*	16.00X12.00	5	DIN376	6HX	C
MTS-M22X2.50ISO6HX-XC-K102-A	03305458	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	133,13 *5.241*	19,7 *0.776*	18.00X14.50	5	DIN376	6HX	C
MTS-M24X3.00ISO6HX-XC-K102-A	03305459	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	151,75 *5.974*	21,0 *0.827*	18.00X14.50	5	DIN376	6HX	C

MTS-K111

Blind and through holes

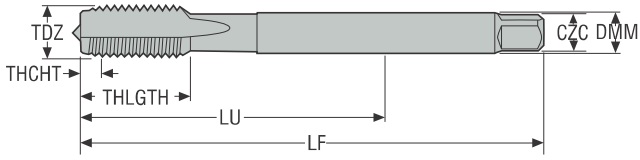


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M10X1.00ISO6HX-XC-K111	03305466	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	18,0 *0.709*	87,25 *3.435*	9,0 *0.354*	7.00X5.50	5	DIN374	6HX	C
MTS-M10X1.25ISO6HX-XC-K111	03305467	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	20,0 *0.787*	96,56 *3.802*	8,8 *0.346*	7.00X5.50	5	DIN374	6HX	C
MTS-M12X1.25ISO6HX-XC-K111	03305468	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	96,56 *3.802*	10,75 *0.423*	9.00X7.00	5	DIN374	6HX	C
MTS-M12X1.50ISO6HX-XC-K111	03305469	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	95,88 *3.775*	10,5 *0.413*	9.00X7.00	5	DIN374	6HX	C
MTS-M14X1.50ISO6HX-XC-K111	03305470	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,88 *3.775*	12,5 *0.492*	11.00X9.00	5	DIN374	6HX	C
MTS-M16X1.50ISO6HX-XC-K111	03305471	MF16X1.5	1,5	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	95,88 *3.775*	14,5 *0.571*	12.00X9.00	5	DIN374	6HX	C
MTS-M18X1.50ISO6HX-XC-K111	03305472	MF18X1.5	1,5	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	105,88 *4.168*	16,5 *0.650*	14.00X11.00	5	DIN374	6HX	C
MTS-M20X1.50ISO6HX-XC-K111	03305473	MF20X1.5	1,5	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	120,88 *4.759*	18,5 *0.728*	16.00X12.00	5	DIN374	6HX	C

MTS-K121

Blind and through holes

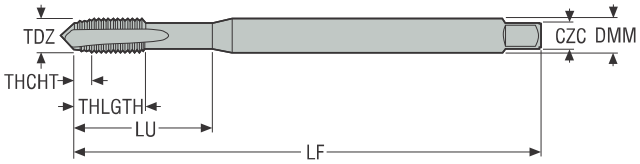


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-1/8-28G-XC-K121	03305474	G1/8-28	–	28,0	7,0 *0.276*	67,0 *2.638*	13,0 *0.512*	87,51 *3.445*	8,8 *0.346*	7.00X5.50	4	DIN5156	NORMAL-X	C
MTS-1/4-19G-XC-K121	03305475	G1/4-19	–	19,0	11,0 *0.433*	71,0 *2.795*	15,0 *0.591*	96,32 *3.792*	11,8 *0.465*	11.00X9.00	4	DIN5156	NORMAL-X	C
MTS-3/8-19G-XC-K121	03305476	G3/8-19	–	19,0	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	96,32 *3.792*	15,25 *0.600*	12.00X9.00	5	DIN5156	NORMAL-X	C
MTS-1/2-14G-XC-K121	03305477	G1/2-14	–	14,0	16,0 *0.630*	80,0 *3.150*	21,0 *0.827*	120,01 *4.725*	19,0 *0.748*	16.00X12.00	5	DIN5156	NORMAL-X	C
MTS-3/4-14G-XC-K121	03305478	G3/4-14	–	14,0	20,0 *0.787*	77,0 *3.031*	21,0 *0.827*	135,01 *5.315*	24,5 *0.965*	20.00X16.00	6	DIN5156	NORMAL-X	C
MTS-1-11G-XC-K121	03305479	G1-11	–	11,0	25,0 *0.984*	93,0 *3.661*	27,0 *1.063*	153,65 *6.049*	30,75 *1.211*	25.00X20.00	6	DIN5156	NORMAL-X	C

MTS-K131

Blind and through holes

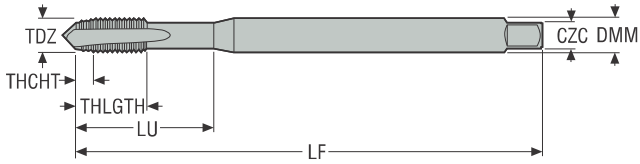


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-1/4-20UNC-XC-K131	03305480	UNC1/4-20	–	20.0	7,0 *0.276*	25,0 *0.984*	15,6 *0.614*	76,50 *3.012*	5,1 *0.201*	8.25X5.5	5	DIN2184-1	2BX	C
MTS-5/16-18UNC-XC-K131	03305481	UNC5/16-18	–	18.0	8,0 *0.315*	33,5 *1.319*	18,7 *0.736*	86,12 *3.391*	6,6 *0.260*	9.25X6.20	5	DIN2184-1	2BX	C
MTS-3/8-16UNC-XC-K131	03305482	UNC3/8-16	–	16.0	10,0 *0.394*	38,0 *1.496*	20,6 *0.811*	95,63 *3.765*	8,0 *0.315*	11.25X8.00	5	DIN2184-1	2BX	C
MTS-7/16-14UNC-XC-K131	03305483	UNC7/16-14	–	14.0	8,0 *0.315*	72,7 *2.862*	20,0 *0.787*	95,01 *3.741*	9,4 *0.370*	9.25X6.20	5	DIN2184-1	2BX	C
MTS-1/2-13UNC-XC-K131	03305484	UNC1/2-13	–	13.0	9,0 *0.354*	81,9 *3.224*	23,0 *0.906*	104,63 *4.119*	10,8 *0.425*	10.25X7.00	5	DIN2184-1	2BX	C
MTS-5/8-11UNC-XC-K131	03305485	UNC5/8-11	–	11.0	12,0 *0.472*	65,7 *2.587*	23,0 *0.906*	103,65 *4.081*	13,5 *0.531*	12.25X9.00	5	DIN2184-1	2BX	C
MTS-3/4-10UNC-XC-K131	03305486	UNC3/4-10	–	10.0	14,0 *0.551*	77,5 *3.051*	30,0 *1.181*	118,02 *4.646*	16,5 *0.650*	14.25X11.00	5	DIN2184-1	2BX	C
MTS-7/8-9UNC-XC-K131	03305487	UNC7/8-9	–	9.0	18,0 *0.709*	90,95 *3.581*	34,0 *1.339*	132,24 *5.206*	19,5 *0.768*	17.25X14.5	5	DIN2184-1	2BX	C

MTS-K141

Blind and through holes

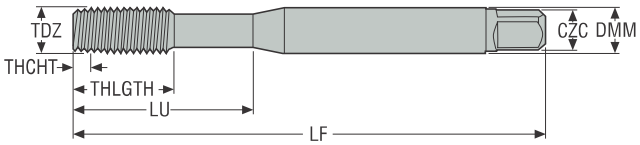


- For cutting data see page(s) 280
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-1/4-28UNF-XC-K141	03305488	UNF1/4-28	–	28.0	7,0 *0.276*	25,0 *0.984*	15,6 *0.614*	77,50 *3.051*	5,5 *0.217*	8.25X5.5	5	DIN2184-1	2BX	C
MTS-5/16-24UNF-XC-K141	03305489	UNF5/16-24	–	24.0	8,0 *0.315*	33,5 *1.319*	18,7 *0.736*	87,09 *3.429*	6,9 *0.272*	9.25X6.20	5	DIN2184-1	2BX	C
MTS-3/8-24UNF-XC-K141	03305491	UNF3/8-24	–	24.0	10,0 *0.394*	38,0 *1.496*	20,6 *0.811*	97,09 *3.822*	8,5 *0.335*	11.25X8.00	5	DIN2184-1	2BX	C
MTS-7/16-20UNF-XC-K141	03305492	UNF7/16-20	–	20.0	8,0 *0.315*	72,7 *2.862*	20,0 *0.787*	96,51 *3.800*	9,9 *0.390*	9.25X6.20	5	DIN2184-1	2BX	C
MTS-1/2-20UNF-XC-K141	03305493	UNF1/2-20	–	20.0	9,0 *0.354*	71,9 *2.831*	23,0 *0.906*	106,51 *4.193*	11,5 *0.453*	10.25X7.00	5	DIN2184-1	2BX	C
MTS-5/8-18UNF-XC-K141	03305494	UNF5/8-18	–	18.0	12,0 *0.472*	55,7 *2.193*	23,0 *0.906*	106,12 *4.178*	14,5 *0.571*	12.25X9.00	5	DIN2184-1	2BX	C
MTS-3/4-16UNF-XC-K141	03305495	UNF3/4-16	–	16.0	14,0 *0.551*	62,5 *2.461*	25,0 *0.984*	120,63 *4.749*	17,5 *0.689*	14.25X11.00	5	DIN2184-1	2BX	C
MTS-7/8-14UNF-XC-K141	03305496	UNF7/8-14	–	14.0	18,0 *0.709*	75,95 *2.990*	25,0 *0.984*	135,01 *5.315*	20,4 *0.803*	17.25X14.5	5	DIN2184-1	2BX	C

MF-V054

Forming holes

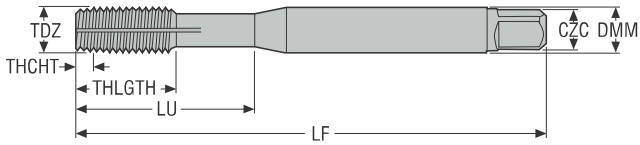


- For cutting data see page(s) 292
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M1X0.25ISO5HX-XC-V054	03000282	*	M1	0,25	–	2,5 *0.098*	20,0 *0.787*	5,5 *0.217*	39,25 *1.545*	0,89 *0.035*	2.50X2.10	3	DIN2174	5HX	C
MF-M1.1X0.25ISO5HX-XC-V054	03000283	*	M1.1	0,25	–	2,5 *0.098*	20,0 *0.787*	5,5 *0.217*	39,25 *1.545*	0,99 *0.039*	2.50X2.10	3	DIN2174	5HX	C
MF-M1.2X0.25ISO5HX-XC-V054	03000284	*	M1.2	0,25	–	2,5 *0.098*	20,0 *0.787*	5,5 *0.217*	39,25 *1.545*	1,09 *0.043*	2.50X2.10	3	DIN2174	5HX	C
MF-M1.4X0.30ISO5HX-XC-V054	03000285	*	M1.4	0,3	–	2,5 *0.098*	20,0 *0.787*	7,0 *0.276*	39,1 *1.539*	1,27 *0.050*	2.50X2.10	3	DIN2174	5HX	C
MF-M1.6X0.35ISO6HX-XC-V054	03000286	*	M1.6	0,35	–	2,5 *0.098*	20,0 *0.787*	8,0 *0.315*	38,95 *1.533*	1,45 *0.057*	2.50X2.10	3	DIN2174	6HX	C
MF-M1.7X0.35ISO6HX-XC-V054	03000287	*	M1.7	0,35	–	2,5 *0.098*	20,0 *0.787*	8,0 *0.315*	38,95 *1.533*	1,55 *0.061*	2.50X2.10	3	DIN2174	6HX	C
MF-M1.8X0.35ISO6HX-XC-V054	03000288	*	M1.8	0,35	–	2,5 *0.098*	20,0 *0.787*	8,0 *0.315*	38,95 *1.533*	1,65 *0.065*	2.50X2.10	3	DIN2174	6HX	C
MF-M2.2X0.45ISO6HX-XC-V054	03000290	*	M2.2	0,45	–	2,8 *0.110*	12,0 *0.472*	7,0 *0.276*	43,65 *1.719*	2,0 *0.079*	2.80X2.10	3	DIN2174	6HX	C
MF-M2.3X0.40ISO6HX-XC-V054	03000291	*	M2.3	0,4	–	2,8 *0.110*	12,0 *0.472*	7,0 *0.276*	43,8 *1.724*	2,12 *0.083*	2.80X2.10	3	DIN2174	6HX	C
MF-M2.6X0.45ISO6HX-XC-V054	03000293	*	M2.6	0,45	–	2,8 *0.110*	14,0 *0.551*	8,0 *0.315*	48,65 *1.915*	2,4 *0.094*	2.80X2.10	3	DIN2174	6HX	C

MF-V055

Forming holes

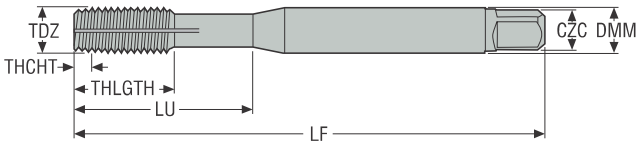


- With channels for lubrication
- For cutting data see page(s) 292
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M7X1.00ISO6HX-XC-V055	02880467	*	M7	1,0	–	7,0 *0.276*	30,0 *1.181*	15,0 *0.591*	77,0 *3.031*	6,55 *0.258*	7.00X5.50	5	DIN2174	6HX	C
MF-M24X3.00ISO6HX-XC-V055	02880474	–	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	36,0 *1.417*	151,0 *5.945*	22,65 *0.892*	18.00X14.50	8	DIN2174	6HX	C
MF-M27X3.00ISO6HX-XC-V055	03000294	–	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	36,0 *1.417*	149,5 *5.886*	25,65 *1.010*	20.00X16.00	8	DIN2174	6HX	C
MF-M30X3.50ISO6HX-XC-V055	03000295	–	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	40,0 *1.575*	167,75 *6.604*	28,45 *1.120*	22.00X18.00	10	DIN2174	6HX	C
MF-M33X3.50ISO6HX-XC-V055	03000296	–	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	40,0 *1.575*	167,75 *6.604*	31,45 *1.238*	25.00X20.00	10	DIN2174	6HX	C
MF-M36X4.00ISO6HX-XC-V055	03000297	–	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	50,0 *1.969*	186,0 *7.323*	34,23 *1.348*	28.00X22.00	10	DIN2174	6HX	C
MF-M39X4.00ISO6HX-XC-V055	03000298	–	M39	4,0	–	32,0 *1.260*	102,0 *4.016*	50,0 *1.969*	186,0 *7.323*	37,23 *1.466*	32.00X24.00	10	DIN2174	6HX	C
MF-M42X4.50ISO6HX-XC-V055	03000299	–	M42	4,5	–	32,0 *1.260*	102,0 *4.016*	50,0 *1.969*	184,25 *7.254*	40,0 *1.575*	32.00X24.00	10	DIN2174	6HX	C
MF-M48X5.00ISO6HX-XC-V055	03000300	–	M48	5,0	–	36,0 *1.417*	147,0 *5.787*	60,0 *2.362*	232,5 *9.154*	45,8 *1.803*	36.00X29.00	12	DIN2174	6HX	C

MF-V056

Forming holes

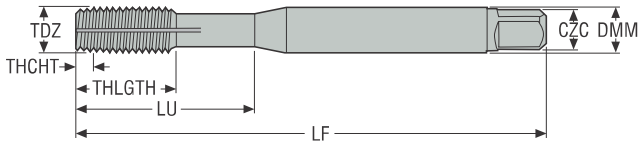


- With channels for lubrication
- For cutting data see page(s) 292
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-4-40UNC-XC-V056	03000306	*	UNC4-40	–	40.0	3,5 *0.138*	18,0 *0.709*	9,0 *0.354*	53,78 *2.117*	2,6 *0.102*	3.50X2.70	4	DIN2184-1	2BX	C
MF-3/4-10UNC-XC-V056	03000317	–	UNC3/4-10	–	10.0	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	116,11 *4.571*	17,93 *0.706*	14.00X11.00	7	DIN2184-1	2BX	C
MF-7/8-9UNC-XC-V056	03000318	–	UNC7/8-9	–	9.0	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	131,53 *5.178*	20,98 *0.826*	18.00X14.50	7	DIN2184-1	2BX	C
MF-1-8UNC-XC-V056	03000319	–	UNC1-8	–	8.0	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	150,47 *5.924*	24,0 *0.945*	18.00X14.50	8	DIN2184-1	2BX	C

MF-V057

Forming holes

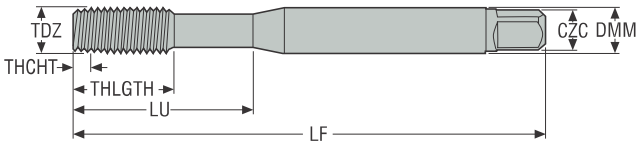


- With channels for lubrication
- For cutting data see page(s) 292
- Coating: TiN
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-3/4-16UNF-XC-V057	03000327	–	UNF3/4-16	–	16.0	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	119,44 *4.702*	18,35 *0.722*	14.00X11.00	7	DIN2184-1	2BX	C
MF-1-12UNF-XC-V057	03000328	–	UNF1-12	–	12.0	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	152,59 *6.007*	24,46 *0.963*	18.00X14.50	8	DIN2184-1	2BX	C

MF-V058

Forming holes

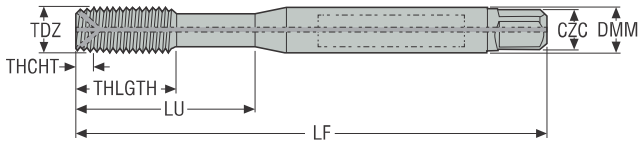


- For cutting data see page(s) 292
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M3.5X0.60ISO6GX-XC-V058	02880476	*	M3.5	0,6	–	4,0 *0.157*	20,0 *0.787*	11,0 *0.433*	54,2 *2.134*	3,2 *0.126*	4.00X3.00	4	DIN2174	6GX	C
MF-M12X1.75ISO6GX-XC-V058	02880482	*	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	104,75 *4.124*	11,2 *0.441*	9.00X7.00	5	DIN2174	6GX	C

MF-V060-A

Forming holes

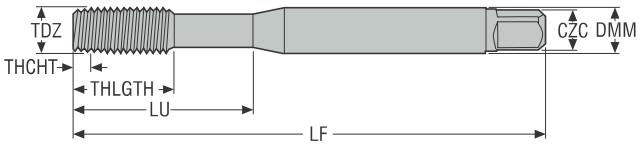


- For cutting data see page(s) 292
- Coating: TiN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M12X1.75ISO6HX-XC-V060-A	02880487	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	104,75 *4.124*	11,2 *0.441*	9.00X7.00	5	DIN2174	6HX	C
MF-M14X2.00ISO6HX-XC-V060-A	03000329	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	103,0 *4.055*	13,1 *0.516*	11.00X9.00	6	DIN2174	6HX	C
MF-M16X2.00ISO6HX-XC-V060-A	03000330	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	104,0 *4.094*	15,1 *0.594*	12.00X9.00	6	DIN2174	6HX	C
MF-M18X2.50ISO6HX-XC-V060-A	03000331	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	116,25 *4.577*	16,9 *0.665*	14.00X11.00	7	DIN2174	6HX	C
MF-M20X2.50ISO6HX-XC-V060-A	03000332	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	132,5 *5.217*	18,9 *0.744*	16.00X12.00	7	DIN2174	6HX	C
MF-M22X2.50ISO6HX-XC-V060-A	03000333	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	131,25 *5.167*	20,9 *0.823*	18.00X14.50	7	DIN2174	6HX	C
MF-M24X3.00ISO6HX-XC-V060-A	03000334	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	149,5 *5.886*	22,65 *0.892*	18.00X14.50	8	DIN2174	6HX	C
MF-M27X3.00ISO6HX-XC-V060-A	03000335	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	149,5 *5.886*	25,65 *1.010*	20.00X16.00	8	DIN2174	6HX	C
MF-M30X3.50ISO6HX-XC-V060-A	03000336	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	169,5 *6.673*	28,45 *1.120*	22.00X18.00	10	DIN2174	6HX	C
MF-M33X3.50ISO6HX-XC-V060-A	03000337	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	50,0 *1.969*	167,75 *6.604*	31,45 *1.238*	25.00X20.00	10	DIN2174	6HX	C
MF-M36X4.00ISO6HX-XC-V060-A	03000338	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	55,0 *2.165*	186,0 *7.323*	34,23 *1.348*	28.00X22.00	10	DIN2174	6HX	C
MF-M39X4.00ISO6HX-XC-V060-A	03000339	M39	4,0	–	32,0 *1.260*	102,0 *4.016*	60,0 *2.362*	186,0 *7.323*	37,23 *1.466*	32.00X24.00	10	DIN2174	6HX	C
MF-M42X4.50ISO6HX-XC-V060-A	03000340	M42	4,5	–	32,0 *1.260*	102,0 *4.016*	60,0 *2.362*	184,25 *7.254*	40,0 *1.575*	32.00X24.00	10	DIN2174	6HX	C
MF-M48X5.00ISO6HX-XC-V060-A	03000341	M48	5,0	–	36,0 *1.417*	147,0 *5.787*	60,0 *2.362*	232,5 *9.154*	45,8 *1.803*	36.00X29.00	12	DIN2174	6HX	C

MF-V063

Forming holes

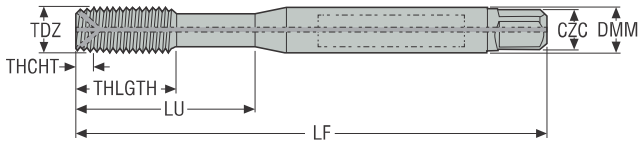


- For cutting data see page(s) 292
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M7X0.75ISO6HX-XC-V063	02880490	*	MF7X0.75	0,75	–	7,0 *0.276*	30,0 *1.181*	15,0 *0.591*	77,75 *3.061*	6,65 *0.262*	7.00X5.50	5	DIN2174	6HX	C
MF-M8X0.75ISO6HX-XC-V063	02880491	–	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	18,0 *0.709*	77,37 *3.046*	7,65 *0.301*	6.00X4.90	5	DIN2174	6HX	C
MF-M8X1.00ISO6HX-XC-V063	02880492	–	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	86,5 *3.406*	7,55 *0.297*	6.00X4.90	5	DIN2174	6HX	C
MF-M10X1.00ISO6HX-XC-V063	02880493	–	MF10X1.0	1,0	–	7,0 *0.276*	75,0 *2.953*	20,0 *0.787*	87,0 *3.425*	9,55 *0.376*	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.25ISO6HX-XC-V063	02880494	–	MF10X1.25	1,25	–	7,0 *0.276*	75,0 *2.953*	20,0 *0.787*	96,25 *3.789*	9,45 *0.372*	7.00X5.50	5	DIN2174	6HX	C
MF-M14X1.00ISO6HX-XC-V063	02880498	–	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	97,0 *3.819*	13,55 *0.533*	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.25ISO6HX-XC-V063	02880499	–	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,62 *3.765*	13,45 *0.530*	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.50ISO6HX-XC-V063	02880500	–	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,5 *3.760*	13,35 *0.526*	11.00X9.00	6	DIN2174	6HX	C

MF-V063-A

Forming holes



- For cutting data see page(s) 292
- Coating: TiN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M5X0.50ISO6HX-XC-V063-A	03000342	MF5X0.5	0,5	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	68,25 *2.687*	4,8 *0.189*	6.00X4.90	5	DIN2174	6HX	C
MF-M6X0.75ISO6HX-XC-V063-A	03000343	MF6X0.75	0,75	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	77,37 *3.046*	5,65 *0.222*	6.00X4.90	5	DIN2174	6HX	C
MF-M8X0.75ISO6HX-XC-V063-A	03000344	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	15,0 *0.591*	77,37 *3.046*	7,65 *0.301*	6.00X4.90	5	DIN2174	6HX	C
MF-M8X1.00ISO6HX-XC-V063-A	03000345	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	86,5 *3.406*	7,55 *0.297*	6.00X4.90	5	DIN2174	6HX	C
MF-M10X0.75ISO6HX-XC-V063-A	03000346	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	18,0 *0.709*	87,37 *3.440*	9,65 *0.380*	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.00ISO6HX-XC-V063-A	03000347	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	18,0 *0.709*	86,5 *3.406*	9,55 *0.376*	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.25ISO6HX-XC-V063-A	03000349	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	20,0 *0.787*	95,62 *3.765*	9,45 *0.372*	7.00X5.50	5	DIN2174	6HX	C
MF-M12X1.00ISO6HX-XC-V063-A	03000350	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	97,0 *3.819*	11,55 *0.455*	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.25ISO6HX-XC-V063-A	03000351	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	95,62 *3.765*	11,45 *0.451*	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.50ISO6HX-XC-V063-A	03000352	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	94,75 *3.730*	11,35 *0.447*	9.00X7.00	5	DIN2174	6HX	C
MF-M14X1.00ISO6HX-XC-V063-A	03000353	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	96,5 *3.799*	13,55 *0.533*	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.25ISO6HX-XC-V063-A	03000354	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,62 *3.765*	13,45 *0.530*	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.50ISO6HX-XC-V063-A	03000355	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	95,5 *3.760*	13,35 *0.526*	11.00X9.00	6	DIN2174	6HX	C
MF-M16X1.00ISO6HX-XC-V063-A	03000356	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	96,5 *3.799*	15,55 *0.612*	12.00X9.00	6	DIN2174	6HX	C
MF-M16X1.50ISO6HX-XC-V063-A	03000357	MF16X1.5	1,5	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	95,5 *3.760*	15,35 *0.604*	12.00X9.00	6	DIN2174	6HX	C

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SECO HIGH FEED SP

YOUR CHALLENGE
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OUR SOLUTION
The High Feed SP easily cuts ISO P, M and S materials to increase material removal rates and extend tool life.

YOUR CHALLENGE
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OUR SOLUTION
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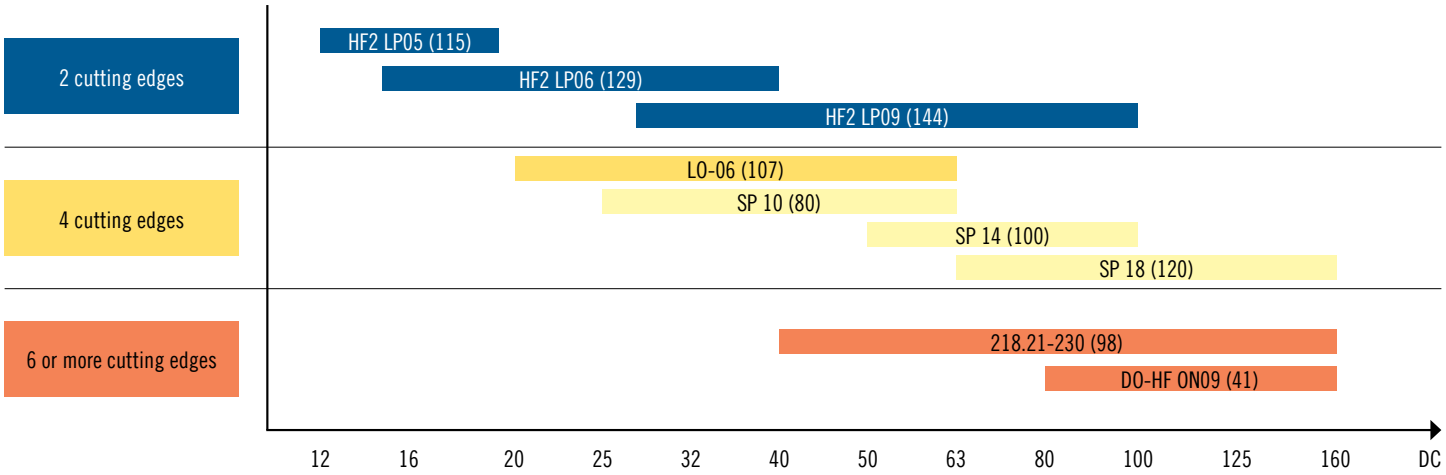
POSITIONING HIGH FEED CUTTERS



Cost per edge index (xx) based on SP14, F40M Price list 2022

INSERT RANGE OVERVIEW

DESIGNATION	IC IN MM	AN IN MM	RE IN MM	S IN MM	CUTTING RAKE IN °	GRADES																	
						COATED															UNCOATED		
						MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SPKT10T317TN-M10	10,0	11,0	1,7	3,97	13,0 °	■	■	■			■		■	■	■		■				■			
SPKT10T317TN-MD12	10,0	11,0	1,7	3,97	5,0 °	■		■	■				■								■			
SPKT140523TN-M14	14,0	11,0	2,3	5,56	13,0 °		■	■			■		■	■	■		■				■			
SPKT140523TN-MD16	14,0	11,0	2,3	5,56	5,0 °	■	■	■	■				■		■		■				■			
SPKT180630TN-M14	18,0	11,0	3,0	6,35	12,0 °	■	■	■					■	■	■		■				■			
SPKT180630TN-MD16	18,0	11,0	3,0	6,35	5,0 °	■		■	■				■								■			

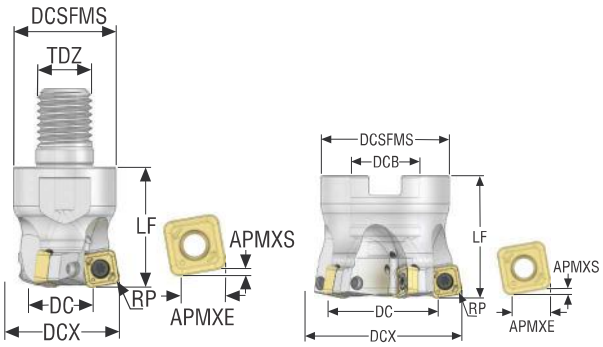
Please note, that the shown data are just an extract. More products available.
For more information please visit www.secotools.com.

HIGH FEED SP

For challenging ISO P, M and S materials, the Seco High Feed SP features a combination of dedicated cutting geometries and insert grades, as well as optimized lead angles, that combine to boost material removal rates, maximize chip evacuation and extend tool life. Packed with versility, one High Feed SP tool optimizes copy milling, ramping, pocketing, face milling and plunging operations to reduce tooling inventory further. Designed for ease of use, the milling tools provide simple foolproof insert indexing that prevents operator mistakes, unexpected machine downtime and scrapped parts.

- 3 insert sizes, with IC = 10, 14 & 18mm
- 30 items in metric version, Ø32 to Ø160mm
- 19 items in inch version, Ø01.25 to Ø06.00
- Standard and close pitch
- Well proven SPKT inserts with a range of premium Seco grades optimized for tough materials.

R217/220.21-SP10 – Metric



- For insert selection and cutting data recommendations, see page(s) 497-499
- For complete insert programme, see page(s) 826
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm	kg		
R217.21-1632.RE-SP10.3A	10097555	Combimaster	15,7	32,0	3	1,1	7,0	–	30,0	35,0	2,83	4,3	47,7	62,0	0,3	21600	SPKT10T317
R217.21-1635.RE-SP10.3A	10097557	Combimaster	18,7	35,0	3	1,1	7,0	–	30,0	35,0	2,8	3,5	53,7	68,0	0,2	20700	SPKT10T317
R217.21-1635.RE-SP10.4A	10097558	Combimaster	18,7	35,0	4	1,1	7,0	–	30,0	35,0	2,8	3,5	53,7	68,0	0,3	20700	SPKT10T317
R217.21-2040.RE-SP10.4A	10097559	Combimaster	23,7	40,0	4	1,1	7,0	–	36,5	40,0	2,79	2,7	63,7	78,0	0,4	19300	SPKT10T317
R217.21-2040.RE-SP10.5A	10097560	Combimaster	23,7	40,0	5	1,1	7,0	–	36,5	40,0	2,79	2,7	63,7	78,0	0,3	19300	SPKT10T317
R217.21-2042.RE-SP10.4A	10097561	Combimaster	25,7	42,0	4	1,1	7,0	–	36,5	40,0	2,8	2,5	67,7	82,0	0,6	18800	SPKT10T317
R217.21-2042.RE-SP10.5A	10097562	Combimaster	25,7	42,0	5	1,1	7,0	–	36,5	40,0	2,8	2,5	67,7	82,0	0,4	18800	SPKT10T317
R220.21-0050-SP10.5A	10097563	Arbor	33,7	50,0	5	1,1	7,0	22,0	41,0	40,0	2,8	1,9	83,7	98,0	0,4	17300	SPKT10T317
R220.21-0050-SP10.6A	10097564	Arbor	33,7	50,0	6	1,1	7,0	22,0	41,0	40,0	2,8	1,9	83,7	98,0	0,4	17300	SPKT10T317
R220.21-0052-SP10.5A	10097565	Arbor	35,7	52,0	5	1,1	7,0	22,0	49,0	40,0	2,8	1,8	87,7	102,0	0,4	17000	SPKT10T317
R220.21-0052-SP10.6A	10097566	Arbor	35,7	52,0	6	1,1	7,0	22,0	49,0	40,0	2,8	1,8	87,7	102,0	0,6	17000	SPKT10T317
R220.21-0063-SP10.6A	10097567	Arbor	46,7	63,0	6	1,1	7,0	22,0	49,0	40,0	2,8	1,3	109,7	124,0	1,0	15800	SPKT10T317
R220.21-0063-SP10.7A	10097568	Arbor	46,7	63,0	7	1,1	7,0	22,0	49,0	40,0	2,8	1,3	109,7	124,0	1,0	15800	SPKT10T317

For Combimaster Shanks, see Machining Navigator Tooling System

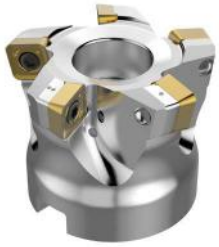
Spare Parts

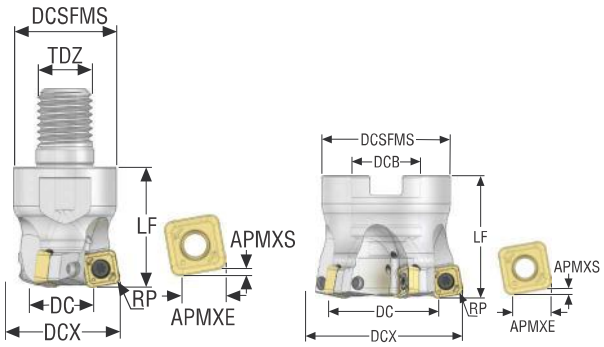
Accessories

For cutter	Arbor screw	Insert screw	Insert clamping torque	Torque key
R217.21-..	–	C03508-T10P	3.0NM	T00-10P30
R217.21-2040-2042-4A	–	C03509-T10P	3.0NM	T00-10P30
R220.21-0050-0063	220.17-692	C03509-T10P	3.0NM	T00-10P30
R220.21-0050-0052-6A	220.17-692	C03508-T10P	3.0NM	T00-10P30

Torque and fixed keys, see page 869

R217/220.21-SP10 – Inch





- For insert selection and cutting data recommendations, see page(s) 497-499
- For complete insert programme, see page(s) 826
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			inch	inch		inch	inch	inch	inch	inch	inch		inch	inch	lbs		
R217.21-01.25.16RE-SP10.3A	10097569	Combimaster	0.606	1.250	3	0.043	0.276	–	1.181	1.378	0.111	5,6	1.856	2.421	1.100	21600	SPKT10T317
R217.21-01.50.20RE-SP10.4A	10097571	Combimaster	0.858	1.500	4	0.043	0.276	–	1.437	1.575	0.110	3,0	2.358	2.921	1.100	19300	SPKT10T317
R220.21-02.00-SP10.5A	10128666	Arbor	1.358	2.000	5	0.043	0.276	0.750	1.789	1.500	0.110	1,9	3.358	3.921	0.880	17300	SPKT10T317
R220.21-02.00-SP10.6A	10097573	Arbor	1.358	2.000	6	0.043	0.276	0.750	1.789	1.500	0.110	1,9	3.358	3.921	1.320	17300	SPKT10T317
R220.21-02.50-SP10.6A	10128667	Arbor	1.858	2.500	6	0.043	0.276	0.750	1.789	1.500	0.110	1,3	4.358	4.921	1.100	15800	SPKT10T317
R220.21-02.50-SP10.7A	10097574	Arbor	1.858	2.500	7	0.043	0.276	0.750	1.789	1.500	0.110	1,3	4.358	4.921	1.320	15800	SPKT10T317

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert clamping torque	Torque key
R217.21-..	–	C03508-T10P	26.6IN.LBS	T00-10P30
R220.21-02.00	UC6S3/8UNFX1-1/4	C03508-T10P	26.6IN.LBS	T00-10P30
R220.21-02.50	UC6S3/8UNFX1-1/4	C03509-T10P	26.6IN.LBS	T00-10P30

Torque and fixed keys, see page 869

R220.21-SP10 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	SPKT10T317TN-M10 MP2501	1,1 *0.044*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
P2	SPKT10T317TN-M10 MP2501	1,1 *0.044*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
P3	SPKT10T317TN-M10 MP2501	1,1 *0.044*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
P4	SPKT10T317TN-M10 MP2501	1,1 *0.044*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
P5	SPKT10T317TN-M10 MP2501	1,1 *0.044*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
P6	SPKT10T317TN-M10 MP2501	1,1 *0.044*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
P7	SPKT10T317TN-MD12 MP2501	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
P8	SPKT10T317TN-MD12 MP2501	1,1 *0.044*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
P11	SPKT10T317TN-MD12 MP2501	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
P12	SPKT10T317TN-M10 MS2500	0,85 *0.034*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
M1	SPKT10T317TN-M10 MS2050	1,1 *0.044*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
M2	SPKT10T317TN-M10 MS2050	1,1 *0.044*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
M3	SPKT10T317TN-M10 MS2050	0,85 *0.034*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
M4	SPKT10T317TN-M10 F40M	0,85 *0.034*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
M5	SPKT10T317TN-M10 F40M	0,85 *0.034*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
K1	SPKT10T317TN-MD12 MK2050	1,1 *0.044*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K2	SPKT10T317TN-MD12 MK2050	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
K3	SPKT10T317TN-MD12 MK2050	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
K4	SPKT10T317TN-MD12 MK2050	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
K5	SPKT10T317TN-MD12 MK2050	1,1 *0.044*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
K6	SPKT10T317TN-MD12 MK2050	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
K7	SPKT10T317TN-MD12 MK2050	1,1 *0.044*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
S1	SPKT10T317TN-M10 MS2500	0,85 *0.034*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
S2	SPKT10T317TN-M10 MS2500	0,85 *0.034*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
S3	SPKT10T317TN-M10 MS2500	0,85 *0.034*	0,48 *0.019*	0,48 *0.019*	0,55 *0.022*
S11	SPKT10T317TN-M10 MS2050	0,85 *0.034*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S12	SPKT10T317TN-M10 MS2050	0,85 *0.034*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S13	SPKT10T317TN-M10 MS2050	0,85 *0.034*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
H5	SPKT10T317TN-MD12 MP1501	0,85 *0.034*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
H8	SPKT10T317TN-MD12 MP1501	0,85 *0.034*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
H11	SPKT10T317TN-MD12 MP1501	0,85 *0.034*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
H12	SPKT10T317TN-M10 MS2500	0,85 *0.034*	0,38 *0.015*	0,38 *0.015*	0,46 *0.018*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

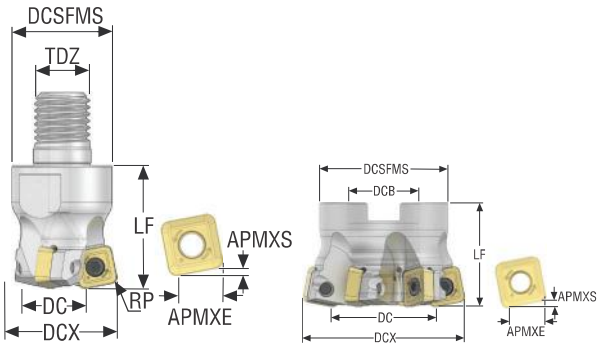
R220.21-SP10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			T350M			F40M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	325 *1075*	375 *1225*	455 *1500*	320 *1050*	370 *1225*	445 *1450*	275 *900*	315 *1025*	380 *1250*	280 *920*	325 *1075*	385 *1275*	245 *800*	280 *920*	335 *1100*
P2	310 *1025*	360 *1175*	430 *1400*	315 *1025*	360 *1175*	430 *1400*	260 *850*	305 *1000*	360 *1175*	270 *890*	315 *1025*	375 *1225*	235 *770*	275 *900*	325 *1075*
P3	275 *900*	315 *1025*	380 *1250*	270 *890*	310 *1025*	375 *1225*	230 *750*	265 *870*	320 *1050*	235 *770*	270 *890*	330 *1075*	205 *670*	235 *770*	285 *940*
P4	245 *800*	285 *940*	335 *1100*	240 *790*	280 *920*	330 *1075*	205 *670*	235 *770*	280 *920*	210 *690*	245 *800*	290 *950*	185 *610*	210 *690*	250 *820*
P5	235 *770*	270 *890*	320 *1050*	230 *750*	265 *870*	315 *1025*	195 *640*	225 *740*	270 *890*	200 *660*	230 *750*	275 *900*	175 *570*	200 *660*	240 *790*
P6	260 *850*	305 *1000*	360 *1175*	260 *850*	300 *980*	355 *1175*	220 *720*	255 *840*	300 *980*	225 *740*	260 *850*	310 *1025*	195 *640*	225 *740*	270 *890*
P7	245 *800*	285 *940*	340 *1125*	245 *800*	285 *940*	335 *1100*	205 *670*	240 *790*	285 *940*	210 *690*	245 *800*	290 *950*	185 *610*	215 *710*	255 *840*
P8	230 *750*	265 *870*	320 *1050*	225 *740*	260 *850*	315 *1025*	190 *620*	225 *740*	270 *890*	195 *640*	230 *750*	275 *900*	170 *560*	200 *660*	240 *790*
P11	240 *790*	280 *920*	330 *1075*	235 *770*	275 *900*	325 *1075*	200 *660*	235 *770*	275 *900*	205 *670*	240 *790*	285 *940*	180 *590*	210 *690*	245 *800*
P12	155 *510*	180 *590*	215 *710*	155 *510*	175 *570*	205 *670*	130 *425*	150 *490*	180 *590*	135 *445*	155 *510*	180 *590*	115 *375*	135 *445*	155 *510*
M1	— —	— —	— —	225 *740*	260 *850*	310 *1025*	195 *640*	225 *740*	270 *890*	210 *690*	245 *800*	290 *950*	190 *620*	220 *720*	265 *870*
M2	— —	— —	— —	185 *610*	215 *710*	255 *840*	165 *540*	190 *620*	225 *740*	175 *570*	200 *660*	235 *770*	155 *510*	180 *590*	215 *710*
M3	— —	— —	— —	150 *490*	170 *560*	200 *660*	130 *425*	150 *490*	180 *590*	140 *460*	160 *520*	190 *620*	125 *410*	145 *475*	170 *560*
M4	— —	— —	— —	115 *375*	135 *445*	155 *510*	100 *330*	115 *375*	140 *460*	190 *620*	215 *710*	255 *840*	100 *330*	115 *375*	135 *445*
M5	— —	— —	— —	95 *310*	110 *360*	130 *425*	85 *280*	95 *310*	115 *375*	190 *620*	215 *710*	255 *840*	80 *260*	95 *310*	110 *360*
K1	245 *800*	285 *940*	340 *1125*	250 *820*	285 *940*	340 *1125*	205 *670*	240 *790*	285 *940*	215 *710*	250 *820*	295 *970*	190 *620*	215 *710*	260 *850*
K2	220 *720*	255 *840*	305 *1000*	220 *720*	255 *840*	300 *980*	185 *610*	215 *710*	255 *840*	190 *620*	220 *720*	260 *850*	165 *540*	190 *620*	225 *740*
K3	185 *610*	215 *710*	255 *840*	185 *610*	215 *710*	255 *840*	155 *510*	180 *590*	215 *710*	160 *520*	185 *610*	220 *720*	140 *460*	160 *520*	190 *620*
K4	180 *590*	205 *670*	245 *800*	175 *570*	205 *670*	245 *800*	150 *490*	175 *570*	205 *670*	155 *510*	180 *590*	210 *690*	135 *445*	155 *510*	185 *610*
K5	110 *360*	125 *410*	150 *490*	110 *360*	125 *410*	150 *490*	90 *295*	105 *345*	125 *410*	95 *310*	110 *360*	130 *425*	85 *280*	95 *310*	115 *375*
K6	155 *510*	180 *590*	215 *710*	155 *510*	180 *590*	215 *710*	130 *425*	155 *510*	180 *590*	135 *445*	155 *510*	185 *610*	120 *395*	135 *445*	160 *520*
K7	140 *460*	165 *540*	195 *640*	140 *460*	160 *520*	190 *620*	120 *395*	135 *445*	165 *540*	120 *395*	140 *460*	165 *540*	105 *345*	125 *410*	145 *475*
S1	— —	— —	— —	55 *180*	65 *215*	75 *245*	47 *155*	55 *180*	65 *215*	50 *165*	60 *195*	70 *230*	46 *150*	55 *180*	60 *195*
S2	— —	— —	— —	45 *150*	50 *165*	60 *195*	38 *125*	43 *140*	50 *165*	41 *135*	47 *155*	55 *180*	37 *120*	42 *140*	50 *165*
S3	— —	— —	— —	40 *130*	45 *150*	55 *180*	33 *110*	38 *125*	45 *150*	35 *115*	41 *135*	48 *155*	32 *105*	37 *120*	44 *145*
S11	— —	— —	— —	80 *260*	90 *295*	105 *345*	65 *215*	75 *245*	90 *295*	70 *230*	80 *260*	95 *310*	65 *215*	75 *245*	85 *280*
S12	— —	— —	— —	55 *180*	60 *195*	75 *245*	46 *150*	55 *180*	60 *195*	48 *155*	55 *180*	65 *215*	44 *145*	50 *165*	60 *195*
S13	— —	— —	— —	32 *105*	36 *120*	43 *140*	26 *85*	30 *100*	36 *120*	28 *90*	33 *110*	38 *125*	26 *85*	30 *100*	35 *115*
H5	50 *165*	60 *195*	70 *230*	46 *150*	55 *180*	65 *215*	41 *135*	47 *155*	55 *180*	44 *145*	50 *165*	60 *195*	39 *130*	44 *145*	50 *165*
H8	55 *180*	65 *215*	75 *245*	49 *160*	55 *180*	65 *215*	43 *140*	50 *165*	60 *195*	47 *155*	55 *180*	65 *215*	41 *135*	47 *155*	55 *180*
H11	65 *215*	75 *245*	90 *295*	60 *195*	70 *230*	80 *260*	50 *165*	60 *195*	70 *230*	55 *180*	65 *215*	75 *245*	49 *160*	55 *180*	65 *215*
H12	100 *330*	115 *375*	135 *445*	95 *310*	110 *360*	130 *425*	85 *280*	95 *310*	115 *375*	85 *280*	95 *310*	115 *375*	75 *245*	85 *280*	100 *330*
H21	55 *180*	65 *215*	75 *245*	49 *160*	55 *180*	65 *215*	43 *140*	50 *165*	60 *195*	47 *155*	55 *180*	65 *215*	41 *135*	47 *155*	55 *180*

R220.21-SP10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MM4500			MK2050			MS2050			MS2500			MP2050		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	195 *640*	230 *750*	270 *890*	285 *940*	330 *1075*	395 *1300*	265 *870*	310 *1025*	370 *1225*	350 *1150*	405 *1325*	485 *1600*	315 *1025*	365 *1200*	435 *1425*
P2	190 *620*	220 *720*	265 *870*	270 *890*	315 *1025*	375 *1225*	260 *850*	300 *980*	360 *1175*	340 *1125*	395 *1300*	470 *1550*	305 *1000*	355 *1175*	425 *1400*
P3	165 *540*	190 *620*	230 *750*	240 *790*	275 *900*	330 *1075*	225 *740*	260 *850*	315 *1025*	295 *970*	340 *1125*	410 *1350*	265 *870*	305 *1000*	370 *1225*
P4	150 *490*	170 *560*	205 *670*	215 *710*	245 *800*	290 *950*	200 *660*	235 *770*	275 *900*	265 *870*	305 *1000*	360 *1175*	235 *770*	275 *900*	325 *1075*
P5	140 *460*	165 *540*	195 *640*	205 *670*	235 *770*	280 *920*	190 *620*	220 *720*	265 *870*	250 *820*	290 *950*	345 *1125*	225 *740*	260 *850*	310 *1025*
P6	160 *520*	185 *610*	220 *720*	230 *750*	265 *870*	310 *1025*	215 *710*	250 *820*	295 *970*	280 *920*	325 *1075*	385 *1275*	255 *840*	295 *970*	350 *1150*
P7	150 *490*	175 *570*	205 *670*	215 *710*	250 *820*	295 *970*	205 *670*	235 *770*	280 *920*	265 *870*	310 *1025*	365 *1200*	240 *790*	280 *920*	330 *1075*
P8	140 *460*	160 *520*	195 *640*	200 *660*	230 *750*	280 *920*	190 *620*	220 *720*	265 *870*	245 *800*	285 *940*	345 *1125*	220 *720*	255 *840*	310 *1025*
P11	145 *475*	170 *560*	200 *660*	210 *690*	240 *790*	285 *940*	195 *640*	230 *750*	270 *890*	260 *850*	300 *980*	355 *1175*	235 *770*	270 *890*	320 *1050*
P12	95 *310*	110 *360*	125 *410*	135 *445*	155 *510*	185 *610*	130 *425*	145 *475*	175 *570*	165 *540*	190 *620*	225 *740*	150 *490*	175 *570*	205 *670*
M1	165 *540*	190 *620*	225 *740*	— —	— —	— —	210 *690*	245 *800*	290 *950*	245 *800*	285 *940*	335 *1100*	220 *720*	255 *840*	305 *1000*
M2	135 *445*	155 *510*	185 *610*	— —	— —	— —	175 *570*	200 *660*	235 *770*	200 *660*	235 *770*	275 *900*	180 *590*	210 *690*	250 *820*
M3	110 *360*	125 *410*	145 *475*	— —	— —	— —	140 *460*	160 *520*	190 *620*	160 *520*	185 *610*	220 *720*	145 *475*	165 *540*	195 *640*
M4	85 *280*	95 *310*	115 *375*	— —	— —	— —	110 *360*	125 *410*	145 *475*	125 *410*	145 *475*	170 *560*	115 *375*	130 *425*	155 *510*
M5	70 *230*	80 *260*	95 *310*	— —	— —	— —	90 *295*	105 *345*	120 *395*	105 *345*	120 *395*	140 *460*	95 *310*	110 *360*	130 *425*
K1	— —	— —	— —	295 *970*	340 *1125*	405 *1325*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	265 *870*	305 *1000*	360 *1175*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	220 *720*	260 *850*	305 *1000*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	210 *690*	245 *800*	290 *950*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	130 *425*	150 *490*	180 *590*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	185 *610*	215 *710*	255 *840*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	165 *540*	195 *640*	230 *750*	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	26 *85*	30 *100*	35 *115*	— —	— —	— —	50 *165*	60 *195*	70 *230*	60 *195*	70 *230*	85 *280*	55 *180*	65 *215*	75 *245*
S2	21 *70*	24 *80*	28 *90*	— —	— —	— —	41 *135*	47 *155*	55 *180*	50 *165*	55 *180*	65 *215*	45 *150*	50 *165*	60 *195*
S3	18 *60*	21 *70*	25 *80*	— —	— —	— —	35 *115*	41 *135*	48 *155*	43 *140*	49 *160*	60 *195*	39 *130*	45 *150*	55 *180*
S11	36 *120*	41 *135*	49 *160*	— —	— —	— —	70 *230*	80 *260*	95 *310*	85 *280*	95 *310*	115 *375*	75 *245*	85 *280*	105 *345*
S12	33 *110*	38 *125*	45 *150*	— —	— —	— —	48 *155*	55 *180*	65 *215*	60 *195*	65 *215*	80 *260*	55 *180*	60 *195*	70 *230*
S13	19 *60*	22 *70*	26 *85*	— —	— —	— —	28 *90*	33 *110*	38 *125*	35 *115*	40 *130*	47 *155*	31 *100*	36 *120*	42 *140*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	55 *180*	65 *215*	80 *260*
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	105 *345*	120 *395*	145 *475*	95 *310*	110 *360*	130 *425*
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

R217/220.21-SP14 – Metric



- For insert selection and cutting data recommendations, see page(s) 502-504
- For complete insert programme, see page(s) 826
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm	kg		
R217.21-2040.RE-SP14.3A	10135958	Combimaster	17,0	40,0	3	1,8	10,0	–	36,5	45,0	4,06	2,9	57,0	78,0	0,4	11900	SPKT140523
R220.21-0050-SP14.4A	10068147	Arbor	27,1	50,0	4	1,8	10,0	22,0	41,0	40,0	4,02	3,5	77,1	98,0	0,3	10700	SPKT140523
R220.21-0050-SP14.5A	10068148	Arbor	27,1	50,0	5	1,8	10,0	22,0	41,0	40,0	4,04	1,8	77,1	98,0	0,5	10700	SPKT140523
R220.21-0052-SP14.4A	10068149	Arbor	29,1	52,0	4	1,8	10,0	22,0	49,0	40,0	4,02	3,2	81,1	102,0	0,3	10500	SPKT140523
R220.21-0052-SP14.5A	10101535	Arbor	29,1	52,0	5	1,8	10,0	22,0	49,0	40,0	4,02	3,2	81,1	102,0	0,7	10500	SPKT140523
R220.21-0063-SP14.5A	10068150	Arbor	40,1	63,0	5	1,8	10,0	27,0	49,0	50,0	4,01	2,3	103,1	124,0	0,4	9600	SPKT140523
R220.21-0063-SP14.6A	10068151	Arbor	40,1	63,0	6	1,8	10,0	27,0	49,0	50,0	4,01	2,3	103,1	124,0	0,5	9600	SPKT140523
R220.21-0066-SP14.5A	10068152	Arbor	43,0	66,0	5	1,8	10,0	27,0	61,0	50,0	4,02	2,1	109,0	130,0	0,7	9400	SPKT140523
R220.21-0066-SP14.6A	10101540	Arbor	43,0	66,0	6	1,8	10,0	27,0	61,0	50,0	4,02	2,1	109,0	130,0	0,5	9400	SPKT140523
R220.21-0080-SP14.6A	10068154	Arbor	57,0	80,0	6	1,8	10,0	27,0	61,0	50,0	4,01	1,6	137,0	158,0	0,5	8500	SPKT140523
R220.21-0080-SP14.7A	10068155	Arbor	57,0	80,0	7	1,8	10,0	27,0	61,0	50,0	4,01	1,6	137,0	158,0	0,6	8500	SPKT140523
R220.21-0084-SP14.6A	10068156	Arbor	61,0	84,0	6	1,8	10,0	32,0	79,0	50,0	4,01	1,5	145,0	166,0	0,9	8300	SPKT140523
R220.21-0100-SP14.8A	10068157	Arbor	77,0	100,0	8	1,8	10,0	32,0	79,0	50,0	4,01	1,2	177,0	198,0	0,5	7600	SPKT140523
R220.21-0125-SP14.9A	10132522	Arbor	102,0	125,0	9	1,8	10,0	40,0	90,0	63,0	4,0	0,9	227,0	248,0	3,2	6800	SPKT140523

For Combimaster Shanks, see Machining Navigator Tooling System

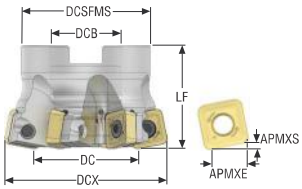
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert clamping torque	Torque key
R217.21-..	–	C45011-T20P	5.0NM	T00-20P50
R220.21-0050-0052	220.17-692M	C45011-T20P	5.0NM	T00-20P50
R220.21-0063	MLC6S12X30	C45011-T20P	5.0NM	T00-20P50
R220.21-0066-0080	MC6S12X40	C45011-T20P	5.0NM	T00-20P50
R220.21-0084-0100	MLC6S16X35	C45011-T20P	5.0NM	T00-20P50
R220.21-0125	MC6S20X50	C45011-T20P	5.0NM	T00-20P50

Torque and fixed keys, see page 869

R220.21-SP14 – inch



- For insert selection and cutting data recommendations, see page(s) 502-504
- For complete insert programme, see page(s) 826
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			inch	inch		inch	inch	inch	inch	inch	inch		inch	inch	lbs		
R220.21-02.00-SP14.4A	10068158	Arbor	1.098	2.000	4	0.071	0.394	0.750	1.789	1.500	0.158	3,3	3.098	3.921	1.540	10700	SPKT140523
R220.21-02.00-SP14.5A	10068159	Arbor	1.098	2.000	5	0.071	0.394	0.750	1.789	1.500	0.158	3,3	3.098	3.921	1.100	10700	SPKT140523
R220.21-02.50-SP14.5A	10068160	Arbor	1.594	2.500	5	0.071	0.394	0.750	1.789	1.500	0.158	2,2	4.094	4.921	1.100	9600	SPKT140523
R220.21-02.50-SP14.6A	10068161	Arbor	1.594	2.500	6	0.071	0.394	0.750	1.789	1.500	0.158	2,2	4.094	4.921	1.100	9600	SPKT140523
R220.21-03.00-SP14.6A	10068162	Arbor	2.094	3.000	6	0.071	0.394	1.000	2.289	2.000	0.158	1,7	4.583	5.921	1.320	8500	SPKT140523
R220.21-03.00-SP14.7A	10068163	Arbor	2.094	3.000	7	0.071	0.394	1.000	2.289	2.000	0.158	1,7	4.583	5.921	1.100	8500	SPKT140523
R220.21-04.00-SP14.8A	10068164	Arbor	3.094	4.000	8	0.071	0.394	1.500	3.539	2.000	0.158	1,2	7.094	7.921	1.100	7600	SPKT140523

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert clamping torque	Torque key
R220.21-02.00-02.50	UC6S3/8UNFX1-1/4	C45011-T20P	44.3IN.LBS	T00-20P50
R220.21-03.00	UC6S1/2UNFX1-1/2	C45011-T20P	44.3IN.LBS	T00-20P50
R220.21-04.00	ULC6S3/4UNFX11/2	C45011-T20P	44.3IN.LBS	T00-20P50

Torque and fixed keys, see page 869

R220.21-SP14 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	SPKT140523TN-M14 MP2501	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P2	SPKT140523TN-M14 MP2501	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P3	SPKT140523TN-M14 MP2501	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P4	SPKT140523TN-M14 MP2501	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P5	SPKT140523TN-M14 MP2501	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P6	SPKT140523TN-M14 MP2501	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P7	SPKT140523TN-MD16 MP2501	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
P8	SPKT140523TN-MD16 MP2501	1,8 *0.070*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
P11	SPKT140523TN-MD16 MP2501	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
P12	SPKT140523TN-M14 MS2500	1,4 *0.055*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*
M1	SPKT140523TN-M14 MS2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
M2	SPKT140523TN-M14 MS2050	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
M3	SPKT140523TN-M14 MS2050	1,4 *0.055*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
M4	SPKT140523TN-M14 F40M	1,4 *0.055*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
M5	SPKT140523TN-M14 F40M	1,4 *0.055*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
K1	SPKT140523TN-MD16 MK2050	1,8 *0.070*	1,2 *0.048*	1,2 *0.048*	1,5 *0.060*
K2	SPKT140523TN-MD16 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
K3	SPKT140523TN-MD16 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
K4	SPKT140523TN-MD16 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
K5	SPKT140523TN-MD16 MK2050	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K6	SPKT140523TN-MD16 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
K7	SPKT140523TN-MD16 MK2050	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
S1	SPKT140523TN-M14 MS2500	1,4 *0.055*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
S2	SPKT140523TN-M14 MS2500	1,4 *0.055*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
S3	SPKT140523TN-M14 MS2500	1,4 *0.055*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
S11	SPKT140523TN-M14 MS2050	1,4 *0.055*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
S12	SPKT140523TN-M14 MS2050	1,4 *0.055*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
S13	SPKT140523TN-M14 MS2050	1,4 *0.055*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
H5	SPKT140523TN-MD16 MP1501	1,4 *0.055*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
H8	SPKT140523TN-MD16 MP1501	1,4 *0.055*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
H11	SPKT140523TN-MD16 MP1501	1,4 *0.055*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
H12	SPKT140523TN-M14 MS2500	1,4 *0.055*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

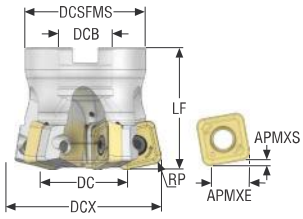
R220.21-SP14 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			T350M			F40M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	300 *980*	350 *1150*	410 *1350*	290 *950*	335 *1100*	405 *1325*	250 *820*	295 *970*	345 *1125*	250 *820*	295 *970*	350 *1150*	220 *720*	255 *840*	305 *1000*
P2	290 *950*	340 *1125*	400 *1300*	280 *920*	330 *1075*	395 *1300*	245 *800*	285 *940*	335 *1100*	245 *800*	285 *940*	340 *1125*	210 *690*	250 *820*	300 *980*
P3	250 *820*	290 *950*	350 *1150*	250 *820*	290 *950*	345 *1125*	210 *690*	245 *800*	295 *970*	215 *710*	255 *840*	300 *980*	190 *620*	220 *720*	260 *850*
P4	220 *720*	255 *840*	310 *1025*	220 *720*	255 *840*	305 *1000*	185 *610*	215 *710*	260 *850*	190 *620*	225 *740*	265 *870*	165 *540*	195 *640*	230 *750*
P5	215 *710*	255 *840*	295 *970*	210 *690*	245 *800*	290 *950*	180 *590*	210 *690*	250 *820*	180 *590*	215 *710*	255 *840*	160 *520*	185 *610*	220 *720*
P6	240 *790*	285 *940*	335 *1100*	235 *770*	275 *900*	325 *1075*	205 *670*	240 *790*	280 *920*	205 *670*	240 *790*	285 *940*	175 *570*	210 *690*	250 *820*
P7	230 *750*	270 *890*	315 *1025*	220 *720*	260 *850*	310 *1025*	190 *620*	225 *740*	265 *870*	195 *640*	225 *740*	270 *890*	165 *540*	195 *640*	235 *770*
P8	210 *690*	245 *800*	295 *970*	210 *690*	245 *800*	290 *950*	175 *570*	205 *670*	250 *820*	180 *590*	215 *710*	255 *840*	160 *520*	185 *610*	220 *720*
P11	220 *720*	260 *850*	305 *1000*	215 *710*	250 *820*	300 *980*	185 *610*	220 *720*	255 *840*	185 *610*	220 *720*	260 *850*	165 *540*	190 *620*	225 *740*
P12	145 *475*	170 *560*	200 *660*	140 *460*	160 *520*	200 *660*	120 *395*	140 *460*	165 *540*	120 *395*	140 *460*	175 *570*	105 *345*	120 *395*	150 *490*
M1	— —	— —	— —	200 *660*	235 *770*	285 *940*	180 *590*	215 *710*	250 *820*	190 *620*	220 *720*	265 *870*	170 *560*	200 *660*	240 *790*
M2	— —	— —	— —	170 *560*	195 *640*	235 *770*	150 *490*	175 *570*	210 *690*	155 *510*	185 *610*	220 *720*	140 *460*	165 *540*	200 *660*
M3	— —	— —	— —	135 *445*	155 *510*	190 *620*	120 *395*	140 *460*	165 *540*	125 *410*	145 *475*	180 *590*	115 *375*	130 *425*	160 *520*
M4	— —	— —	— —	105 *345*	120 *395*	150 *490*	95 *310*	110 *360*	130 *425*	170 *560*	195 *640*	240 *790*	90 *295*	105 *345*	125 *410*
M5	— —	— —	— —	90 *295*	100 *330*	125 *410*	80 *260*	90 *295*	110 *360*	170 *560*	195 *640*	240 *790*	75 *245*	85 *280*	105 *345*
K1	230 *750*	270 *890*	315 *1025*	220 *720*	260 *850*	310 *1025*	195 *640*	225 *740*	265 *870*	195 *640*	225 *740*	270 *890*	170 *560*	195 *640*	235 *770*
K2	205 *670*	240 *790*	280 *920*	200 *660*	230 *750*	275 *900*	170 *560*	200 *660*	235 *770*	175 *570*	200 *660*	240 *790*	150 *490*	175 *570*	210 *690*
K3	175 *570*	205 *670*	240 *790*	170 *560*	195 *640*	235 *770*	145 *475*	170 *560*	200 *660*	145 *475*	170 *560*	205 *670*	125 *410*	150 *490*	175 *570*
K4	165 *540*	195 *640*	225 *740*	160 *520*	185 *610*	225 *740*	140 *460*	165 *540*	190 *620*	140 *460*	165 *540*	195 *640*	120 *395*	140 *460*	170 *560*
K5	100 *330*	120 *395*	140 *460*	100 *330*	115 *375*	135 *445*	85 *280*	100 *330*	120 *395*	85 *280*	100 *330*	120 *395*	75 *245*	85 *280*	105 *345*
K6	145 *475*	170 *560*	200 *660*	140 *460*	165 *540*	195 *640*	120 *395*	145 *475*	170 *560*	125 *410*	145 *475*	170 *560*	105 *345*	125 *410*	150 *490*
K7	130 *425*	150 *490*	180 *590*	125 *410*	145 *475*	175 *570*	110 *360*	130 *425*	150 *490*	110 *360*	130 *425*	150 *490*	95 *310*	110 *360*	130 *425*
S1	— —	— —	— —	50 *165*	60 *195*	70 *230*	44 *145*	50 *165*	60 *195*	46 *150*	55 *180*	65 *215*	42 *140*	48 *155*	60 *195*
S2	— —	— —	— —	41 *135*	48 *155*	60 *195*	35 *115*	41 *135*	49 *160*	37 *120*	43 *140*	50 *165*	33 *110*	39 *130*	47 *155*
S3	— —	— —	— —	36 *120*	42 *140*	50 *165*	31 *100*	36 *120*	43 *140*	32 *105*	37 *120*	46 *150*	29 *95*	34 *110*	42 *140*
S11	— —	— —	— —	70 *230*	80 *260*	100 *330*	60 *195*	70 *230*	85 *280*	65 *215*	75 *245*	90 *295*	60 *195*	65 *215*	80 *260*
S12	— —	— —	— —	49 *160*	55 *180*	70 *230*	42 *140*	49 *160*	60 *195*	44 *145*	50 *165*	60 *195*	40 *130*	46 *150*	55 *180*
S13	— —	— —	— —	29 *95*	33 *110*	40 *130*	25 *80*	28 *90*	34 *110*	26 *85*	30 *100*	36 *120*	23 *75*	27 *90*	33 *110*
H5	48 *155*	55 *180*	65 *215*	42 *140*	48 *155*	60 *195*	38 *125*	44 *145*	50 *165*	40 *130*	46 *150*	55 *180*	35 *115*	40 *130*	50 *165*
H8	50 *165*	60 *195*	70 *230*	46 *150*	55 *180*	65 *215*	40 *130*	47 *155*	55 *180*	44 *145*	50 *165*	60 *195*	38 *125*	44 *145*	55 *180*
H11	60 *195*	70 *230*	85 *280*	55 *180*	60 *195*	75 *245*	48 *155*	55 *180*	65 *215*	50 *165*	60 *195*	75 *245*	44 *145*	50 *165*	65 *215*
H12	90 *295*	105 *345*	125 *410*	90 *295*	105 *345*	125 *410*	75 *245*	90 *295*	105 *345*	80 *260*	90 *295*	110 *360*	70 *230*	80 *260*	95 *310*
H21	50 *165*	60 *195*	70 *230*	46 *150*	55 *180*	65 *215*	40 *130*	47 *155*	55 *180*	44 *145*	50 *165*	60 *195*	38 *125*	44 *145*	55 *180*

R220.21-SP14 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MM4500			MK2050			MS2050			MS2500			MP2050		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	175 *570*	205 *670*	250 *820*	285 *940*	330 *1075*	400 *1300*	240 *790*	280 *920*	335 *1100*	315 *1025*	365 *1200*	440 *1450*	280 *920*	330 *1075*	395 *1300*
P2	170 *560*	200 *660*	240 *790*	275 *900*	325 *1075*	385 *1275*	235 *770*	275 *900*	330 *1075*	305 *1000*	360 *1175*	430 *1400*	275 *900*	320 *1050*	385 *1275*
P3	150 *490*	180 *590*	215 *710*	245 *800*	285 *940*	340 *1125*	205 *670*	240 *790*	290 *950*	270 *890*	315 *1025*	380 *1250*	245 *800*	285 *940*	340 *1125*
P4	135 *445*	155 *510*	185 *610*	215 *710*	250 *820*	300 *980*	180 *590*	215 *710*	255 *840*	240 *790*	280 *920*	335 *1100*	215 *710*	250 *820*	300 *980*
P5	130 *425*	150 *490*	180 *590*	205 *670*	240 *790*	285 *940*	175 *570*	205 *670*	245 *800*	230 *750*	265 *870*	320 *1050*	205 *670*	240 *790*	285 *940*
P6	145 *475*	170 *560*	200 *660*	230 *750*	270 *890*	320 *1050*	195 *640*	230 *750*	275 *900*	255 *840*	300 *980*	355 *1175*	230 *750*	270 *890*	320 *1050*
P7	135 *445*	160 *520*	190 *620*	220 *720*	255 *840*	305 *1000*	185 *610*	215 *710*	255 *840*	240 *790*	280 *920*	335 *1100*	215 *710*	255 *840*	305 *1000*
P8	130 *425*	150 *490*	180 *590*	205 *670*	240 *790*	285 *940*	175 *570*	205 *670*	245 *800*	230 *750*	265 *870*	320 *1050*	205 *670*	240 *790*	285 *940*
P11	130 *425*	155 *510*	185 *610*	210 *690*	250 *820*	295 *970*	180 *590*	210 *690*	250 *820*	235 *770*	275 *900*	325 *1075*	210 *690*	245 *800*	295 *970*
P12	85 *280*	100 *330*	120 *395*	135 *445*	160 *520*	195 *640*	115 *375*	135 *445*	165 *540*	150 *490*	175 *570*	215 *710*	135 *445*	155 *510*	195 *640*
M1	145 *475*	175 *570*	205 *670*	— —	— —	— —	190 *620*	220 *720*	265 *870*	220 *720*	255 *840*	305 *1000*	195 *640*	230 *750*	275 *900*
M2	125 *410*	145 *475*	170 *560*	— —	— —	— —	155 *510*	185 *610*	220 *720*	180 *590*	215 *710*	255 *840*	165 *540*	190 *620*	230 *750*
M3	100 *330*	115 *375*	140 *460*	— —	— —	— —	125 *410*	145 *475*	180 *590*	145 *475*	170 *560*	205 *670*	130 *425*	150 *490*	185 *610*
M4	75 *245*	90 *295*	110 *360*	— —	— —	— —	100 *330*	115 *375*	140 *460*	115 *375*	130 *425*	160 *520*	105 *345*	120 *395*	145 *475*
M5	65 *215*	75 *245*	90 *295*	— —	— —	— —	80 *260*	95 *310*	115 *375*	95 *310*	110 *360*	135 *445*	85 *280*	100 *330*	120 *395*
K1	— —	— —	— —	295 *970*	350 *1150*	420 *1375*	— —	— —	— —	— —	— —	— —	220 *720*	255 *840*	305 *1000*
K2	— —	— —	— —	265 *870*	310 *1025*	370 *1225*	— —	— —	— —	— —	— —	— —	195 *640*	230 *750*	270 *890*
K3	— —	— —	— —	225 *740*	265 *870*	315 *1025*	— —	— —	— —	— —	— —	— —	165 *540*	195 *640*	230 *750*
K4	— —	— —	— —	215 *710*	250 *820*	300 *980*	— —	— —	— —	— —	— —	— —	155 *510*	185 *610*	220 *720*
K5	— —	— —	— —	130 *425*	155 *510*	185 *610*	— —	— —	— —	— —	— —	— —	95 *310*	115 *375*	135 *445*
K6	— —	— —	— —	190 *620*	220 *720*	265 *870*	— —	— —	— —	— —	— —	— —	140 *460*	160 *520*	195 *640*
K7	— —	— —	— —	170 *560*	200 *660*	235 *770*	— —	— —	— —	— —	— —	— —	125 *410*	145 *475*	170 *560*
S1	23 *75*	27 *90*	33 *110*	— —	— —	— —	46 *150*	55 *180*	65 *215*	55 *180*	65 *215*	80 *260*	50 *165*	60 *195*	70 *230*
S2	19 *60*	22 *70*	27 *90*	— —	— —	— —	37 *120*	43 *140*	50 *165*	45 *150*	50 *165*	65 *215*	40 *130*	47 *155*	55 *180*
S3	17 *55*	19 *60*	24 *80*	— —	— —	— —	32 *105*	37 *120*	46 *150*	39 *130*	46 *150*	55 *180*	36 *120*	41 *135*	50 *165*
S11	33 *110*	38 *125*	46 *150*	— —	— —	— —	65 *215*	75 *245*	90 *295*	75 *245*	90 *295*	110 *360*	70 *230*	80 *260*	100 *330*
S12	30 *100*	35 *115*	43 *140*	— —	— —	— —	44 *145*	50 *165*	60 *195*	55 *180*	60 *195*	75 *245*	48 *155*	55 *180*	70 *230*
S13	18 *60*	20 *65*	25 *80*	— —	— —	— —	26 *85*	30 *100*	36 *120*	31 *100*	36 *120*	44 *145*	28 *90*	33 *110*	40 *130*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	41 *135*	47 *155*	60 *195*
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	45 *150*	50 *165*	65 *215*
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	50 *165*	60 *195*	75 *245*
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	100 *330*	115 *375*	140 *460*	90 *295*	105 *345*	125 *410*
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	45 *150*	50 *165*	65 *215*

R220.21-SP18 – Metric



- For insert selection and cutting data recommendations, see page(s) 507-509
- For complete insert programme, see page(s) 826
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm	kg		
R220.21-0063-SP18.5A	10097579	Arbor	33,7	63,0	5	2,5	14,0	22,0	49,0	50,0	5,41	2,4	96,7	124,0	1,0	5800	SPKT180630
R220.21-0066-SP18.5A	10097580	Arbor	36,7	66,0	5	2,5	14,0	27,0	61,0	55,0	5,4	3,4	102,7	130,0	0,9	5700	SPKT180630
R220.21-0080-SP18.5A	10097581	Arbor	50,7	80,0	5	2,5	14,0	27,0	61,0	50,0	5,4	2,4	130,7	158,0	0,5	5100	SPKT180630
R220.21-0080-SP18.6A	10097582	Arbor	50,7	80,0	6	2,5	14,0	27,0	61,0	50,0	5,4	2,4	130,7	158,0	1,4	5100	SPKT180630
R220.21-0100-SP18.7A	10097583	Arbor	70,7	100,0	7	2,5	14,0	32,0	79,0	50,0	5,39	1,7	170,7	198,0	0,5	4500	SPKT180630
R220.21-0125-SP18.8A	10097584	Arbor	95,6	125,0	8	2,5	14,0	40,0	90,0	63,0	5,39	1,2	220,6	248,0	2,0	4000	SPKT180630
R220.21-8160-SP18.10A	10097585	Arbor	130,6	160,0	10	2,5	14,0	40,0	90,0	63,0	5,39	0,9	290,6	318,0	1,4	3600	SPKT180630

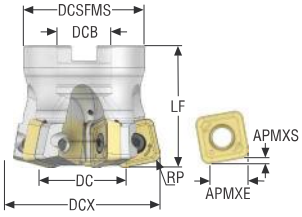
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Lid	Lid screw	Arbor screw	Insert clamping torque	Torque key
R220.21-0063	MLC6S10X45	C05013-T20P	–	–	–	5.0NM	T00-20P50
R220.21-0066	MLC6S12X50	C05013-T20P	–	–	–	5.0NM	T00-20P50
R220.21-0080	MC6S12X40	C05013-T20P	–	–	–	5.0NM	T00-20P50
R220.21-0100	MLC6S16X35	C05013-T20P	–	–	–	5.0NM	T00-20P50
R220.21-0125	MC6S20X50	C05013-T20P	–	–	–	5.0NM	T00-20P50
R220.21-8160	–	C05013-T20P	SC160-53	MF6S4X10	MC6S12X40	5.0NM	T00-20P50

Torque and fixed keys, see page 869

R220.21-SP18 – inch



- For insert selection and cutting data recommendations, see page(s) 507-509
- For complete insert programme, see page(s) 826
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			inch	inch		inch	inch	inch	inch	inch	inch		inch	inch	lbs		
R220.21-02.50-SP18.5A	10097586	Arbor	1.346	2.500	5	0.098	0.551	0.750	1.789	2.000	0.213	3,7	3.846	4.921	1.320	5800	SPKT180630
R220.21-03.00-SP18.5A	10128670	Arbor	1.846	3.000	5	0.098	0.551	1.000	2.289	2.000	0.213	2,6	4.846	5.921	1.980	5100	SPKT180630
R220.21-03.00-SP18.6A	10097587	Arbor	1.846	3.000	6	0.098	0.551	1.000	2.289	2.000	0.213	2,6	4.846	5.921	1.980	5100	SPKT180630
R220.21-04.00-SP18.7A	10097588	Arbor	2.846	4.000	7	0.098	0.551	1.500	3.539	2.000	0.212	1,7	6.846	7.921	1.320	4500	SPKT180630
R220.21-05.00-SP18.8A	10097589	Arbor	3.843	5.000	8	0.098	0.551	1.500	3.539	2.500	0.212	1,2	8.843	9.921	6.610	4000	SPKT180630
R220.21-06.00-SP18.10A	10097590	Arbor	4.843	6.000	10	0.098	0.551	2.000	4.909	2.500	0.212	1,0	10.843	11.921	8.160	3700	SPKT180630

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert clamping torque	Lid	Lid Screw	Torque key
R220.21-02.50	UC6S3/8UNFX11/2	C05013-T20P	44.3IN.LBS	–	–	T00-20P50
R220.21-03.00	UC6S1/2UNFX1-1/2	C05013-T20P	44.3IN.LBS	–	–	T00-20P50
R220.21-04.00	ULC6S3/4UNFX11/2	C05013-T20P	44.3IN.LBS	–	–	T00-20P50
R220.21-05.00	UC6S3/4UNFX2	C05013-T20P	44.3IN.LBS	–	–	T00-20P50
R220.21-06.00	–	C05013-T20P	44.3IN.LBS	SC-160-90	MF6S4X10	T00-20P50

Torque and fixed keys, see page 869

R220.21-SP18 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	SPKT180630TN-M14 MP2501	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P2	SPKT180630TN-M14 MP2501	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P3	SPKT180630TN-M14 MP2501	2,5 *0.10*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
P4	SPKT180630TN-M14 MP2501	2,5 *0.10*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
P5	SPKT180630TN-M14 MP2501	2,5 *0.10*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
P6	SPKT180630TN-M14 MP2501	2,5 *0.10*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
P7	SPKT180630TN-MD16 MP2501	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P8	SPKT180630TN-MD16 MP2501	2,5 *0.10*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P11	SPKT180630TN-MD16 MP2501	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P12	SPKT180630TN-M14 MS2500	2,0 *0.075*	0,65 *0.026*	0,65 *0.026*	0,70 *0.028*
M1	SPKT180630TN-M14 MS2050	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
M2	SPKT180630TN-M14 MS2050	2,5 *0.10*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
M3	SPKT180630TN-M14 MS2050	2,0 *0.075*	0,75 *0.030*	0,75 *0.030*	0,85 *0.034*
M4	SPKT180630TN-M14 F40M	2,0 *0.075*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
M5	SPKT180630TN-M14 F40M	2,0 *0.075*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K1	SPKT180630TN-MD16 MK2050	2,5 *0.10*	1,2 *0.048*	1,2 *0.048*	1,3 *0.050*
K2	SPKT180630TN-MD16 MK2050	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K3	SPKT180630TN-MD16 MK2050	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K4	SPKT180630TN-MD16 MK2050	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K5	SPKT180630TN-MD16 MK2050	2,5 *0.10*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
K6	SPKT180630TN-MD16 MK2050	2,5 *0.10*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K7	SPKT180630TN-MD16 MK2050	2,5 *0.10*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
S1	SPKT180630TN-M14 MS2500	2,0 *0.075*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
S2	SPKT180630TN-M14 MS2500	2,0 *0.075*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
S3	SPKT180630TN-M14 MS2500	2,0 *0.075*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S11	SPKT180630TN-M14 MS2050	2,0 *0.075*	0,75 *0.030*	0,75 *0.030*	0,85 *0.034*
S12	SPKT180630TN-M14 MS2050	2,0 *0.075*	0,75 *0.030*	0,75 *0.030*	0,85 *0.034*
S13	SPKT180630TN-M14 MS2050	2,0 *0.075*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
H5	SPKT180630TN-MD16 MP1501	2,0 *0.075*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
H8	SPKT180630TN-MD16 MP1501	2,0 *0.075*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H11	SPKT180630TN-MD16 MP1501	2,0 *0.075*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
H12	SPKT180630TN-M14 MS2500	2,0 *0.075*	0,48 *0.019*	0,48 *0.019*	0,55 *0.022*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

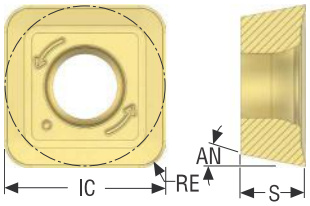
R220.21-SP18 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			T350M			F40M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	285 *940*	325 *1075*	395 *1300*	275 *900*	315 *1025*	375 *1225*	240 *790*	275 *900*	330 *1075*	240 *790*	275 *900*	325 *1075*	205 *670*	240 *790*	285 *940*
P2	270 *890*	310 *1025*	380 *1250*	265 *870*	305 *1000*	365 *1200*	225 *740*	260 *850*	320 *1050*	230 *750*	265 *870*	320 *1050*	200 *660*	230 *750*	275 *900*
P3	240 *790*	275 *900*	330 *1075*	235 *770*	270 *890*	325 *1075*	200 *660*	230 *750*	275 *900*	205 *670*	235 *770*	280 *920*	175 *570*	205 *670*	245 *800*
P4	210 *690*	240 *790*	290 *950*	205 *670*	235 *770*	285 *940*	175 *570*	200 *660*	245 *800*	180 *590*	205 *670*	250 *820*	155 *510*	180 *590*	215 *710*
P5	205 *670*	235 *770*	285 *940*	200 *660*	230 *750*	270 *890*	175 *570*	200 *660*	240 *790*	175 *570*	200 *660*	235 *770*	150 *490*	175 *570*	205 *670*
P6	230 *750*	265 *870*	320 *1050*	225 *740*	255 *840*	305 *1000*	195 *640*	225 *740*	265 *870*	195 *640*	225 *740*	265 *870*	170 *560*	195 *640*	230 *750*
P7	220 *720*	250 *820*	300 *980*	210 *690*	240 *790*	285 *940*	185 *610*	210 *690*	250 *820*	185 *610*	210 *690*	250 *820*	160 *520*	185 *610*	220 *720*
P8	200 *660*	230 *750*	275 *900*	195 *640*	225 *740*	270 *890*	170 *560*	195 *640*	230 *750*	170 *560*	195 *640*	235 *770*	150 *490*	170 *560*	205 *670*
P11	215 *710*	245 *800*	290 *950*	205 *670*	235 *770*	280 *920*	180 *590*	205 *670*	245 *800*	180 *590*	205 *670*	245 *800*	155 *510*	180 *590*	210 *690*
P12	140 *460*	155 *510*	185 *610*	130 *425*	150 *490*	185 *610*	115 *375*	130 *425*	155 *510*	115 *375*	130 *425*	160 *520*	100 *330*	115 *375*	140 *460*
M1	— —	— —	— —	190 *620*	220 *720*	265 *870*	170 *560*	195 *640*	240 *790*	180 *590*	205 *670*	245 *800*	165 *540*	185 *610*	225 *740*
M2	— —	— —	— —	160 *520*	185 *610*	220 *720*	145 *475*	165 *540*	200 *660*	150 *490*	170 *560*	205 *670*	135 *445*	155 *510*	185 *610*
M3	— —	— —	— —	130 *425*	145 *475*	175 *570*	115 *375*	130 *425*	160 *520*	120 *395*	135 *445*	165 *540*	110 *360*	125 *410*	150 *490*
M4	— —	— —	— —	100 *330*	115 *375*	135 *445*	90 *295*	100 *330*	125 *410*	160 *520*	185 *610*	220 *720*	85 *280*	95 *310*	115 *375*
M5	— —	— —	— —	85 *280*	95 *310*	115 *375*	75 *245*	85 *280*	100 *330*	160 *520*	185 *610*	220 *720*	70 *230*	80 *260*	95 *310*
K1	215 *710*	245 *800*	305 *1000*	210 *690*	240 *790*	290 *950*	180 *590*	205 *670*	255 *840*	185 *610*	210 *690*	250 *820*	160 *520*	185 *610*	220 *720*
K2	195 *640*	225 *740*	270 *890*	190 *620*	215 *710*	260 *850*	165 *540*	190 *620*	225 *740*	165 *540*	190 *620*	225 *740*	145 *475*	165 *540*	195 *640*
K3	165 *540*	190 *620*	230 *750*	160 *520*	185 *610*	220 *720*	140 *460*	160 *520*	190 *620*	140 *460*	160 *520*	190 *620*	120 *395*	140 *460*	165 *540*
K4	160 *520*	180 *590*	215 *710*	155 *510*	175 *570*	210 *690*	135 *445*	155 *510*	180 *590*	135 *445*	155 *510*	180 *590*	115 *375*	135 *445*	160 *520*
K5	95 *310*	110 *360*	135 *445*	95 *310*	110 *360*	130 *425*	80 *260*	90 *295*	110 *360*	80 *260*	95 *310*	115 *375*	70 *230*	80 *260*	100 *330*
K6	140 *460*	160 *520*	190 *620*	135 *445*	155 *510*	185 *610*	115 *375*	135 *445*	160 *520*	115 *375*	135 *445*	160 *520*	100 *330*	115 *375*	140 *460*
K7	125 *410*	140 *460*	170 *560*	120 *395*	140 *460*	165 *540*	105 *345*	120 *395*	145 *475*	105 *345*	120 *395*	145 *475*	90 *295*	105 *345*	125 *410*
S1	— —	— —	— —	48 *155*	55 *180*	65 *215*	42 *140*	47 *155*	55 *180*	43 *140*	49 *160*	60 *195*	39 *130*	45 *150*	55 *180*
S2	— —	— —	— —	39 *130*	44 *145*	55 *180*	34 *110*	38 *125*	46 *150*	35 *115*	40 *130*	48 *155*	32 *105*	36 *120*	43 *140*
S3	— —	— —	— —	34 *110*	39 *130*	47 *155*	30 *100*	34 *110*	41 *135*	31 *100*	35 *115*	42 *140*	28 *90*	32 *105*	38 *125*
S11	— —	— —	— —	65 *215*	75 *245*	90 *295*	60 *195*	65 *215*	80 *260*	60 *195*	70 *230*	85 *280*	55 *180*	60 *195*	75 *245*
S12	— —	— —	— —	47 *155*	55 *180*	65 *215*	40 *130*	46 *150*	55 *180*	42 *140*	47 *155*	55 *180*	38 *125*	43 *140*	50 *165*
S13	— —	— —	— —	27 *90*	31 *100*	37 *120*	23 *75*	27 *90*	32 *105*	24 *80*	28 *90*	33 *110*	22 *70*	25 *80*	30 *100*
H5	46 *150*	50 *165*	60 *195*	40 *130*	45 *150*	55 *180*	36 *120*	41 *135*	49 *160*	38 *125*	43 *140*	55 *180*	33 *110*	38 *125*	46 *150*
H8	49 *160*	55 *180*	65 *215*	43 *140*	49 *160*	60 *195*	39 *130*	44 *145*	50 *165*	41 *135*	47 *155*	55 *180*	36 *120*	41 *135*	49 *160*
H11	60 *195*	65 *215*	80 *260*	50 *165*	60 *195*	70 *230*	46 *150*	50 *165*	60 *195*	49 *160*	55 *180*	70 *230*	42 *140*	48 *155*	60 *195*
H12	90 *295*	100 *330*	120 *395*	85 *280*	95 *310*	115 *375*	75 *245*	85 *280*	100 *330*	75 *245*	85 *280*	100 *330*	65 *215*	75 *245*	90 *295*
H21	49 *160*	55 *180*	65 *215*	43 *140*	49 *160*	60 *195*	39 *130*	44 *145*	50 *165*	41 *135*	47 *155*	55 *180*	36 *120*	41 *135*	49 *160*

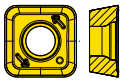
R220.21-SP18 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MS2050			MS2500			MP2050		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	270 *890*	310 *1025*	370 *1225*	230 *750*	260 *850*	315 *1025*	300 *980*	345 *1125*	410 *1350*	270 *890*	310 *1025*	370 *1225*
P2	260 *850*	300 *980*	360 *1175*	220 *720*	255 *840*	305 *1000*	290 *950*	335 *1100*	400 *1300*	260 *850*	300 *980*	360 *1175*
P3	230 *750*	265 *870*	320 *1050*	195 *640*	225 *740*	270 *890*	255 *840*	290 *950*	350 *1150*	230 *750*	265 *870*	315 *1025*
P4	200 *660*	230 *750*	280 *920*	170 *560*	195 *640*	235 *770*	225 *740*	255 *840*	310 *1025*	200 *660*	230 *750*	280 *920*
P5	195 *640*	225 *740*	265 *870*	165 *540*	190 *620*	225 *740*	215 *710*	250 *820*	295 *970*	195 *640*	225 *740*	265 *870*
P6	220 *720*	255 *840*	300 *980*	185 *610*	215 *710*	255 *840*	245 *800*	280 *920*	330 *1075*	220 *720*	250 *820*	300 *980*
P7	210 *690*	240 *790*	285 *940*	175 *570*	200 *660*	240 *790*	230 *750*	265 *870*	315 *1025*	205 *670*	240 *790*	280 *920*
P8	195 *640*	220 *720*	265 *870*	165 *540*	185 *610*	225 *740*	215 *710*	245 *800*	295 *970*	190 *620*	220 *720*	265 *870*
P11	200 *660*	230 *750*	275 *900*	170 *560*	195 *640*	235 *770*	225 *740*	255 *840*	305 *1000*	200 *660*	230 *750*	275 *900*
P12	130 *425*	150 *490*	180 *590*	110 *360*	125 *410*	155 *510*	145 *475*	165 *540*	200 *660*	130 *425*	145 *475*	180 *590*
M1	— —	— —	— —	180 *590*	205 *670*	245 *800*	210 *690*	240 *790*	285 *940*	185 *610*	215 *710*	255 *840*
M2	— —	— —	— —	150 *490*	170 *560*	205 *670*	175 *570*	200 *660*	235 *770*	155 *510*	180 *590*	215 *710*
M3	— —	— —	— —	120 *395*	135 *445*	165 *540*	140 *460*	155 *510*	190 *620*	125 *410*	140 *460*	170 *560*
M4	— —	— —	— —	95 *310*	105 *345*	125 *410*	110 *360*	125 *410*	150 *490*	95 *310*	110 *360*	135 *445*
M5	— —	— —	— —	75 *245*	90 *295*	105 *345*	90 *295*	105 *345*	125 *410*	80 *260*	90 *295*	110 *360*
K1	285 *940*	325 *1075*	390 *1275*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	255 *840*	290 *950*	345 *1125*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	215 *710*	245 *800*	290 *950*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	205 *670*	235 *770*	280 *920*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	125 *410*	145 *475*	175 *570*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	180 *590*	205 *670*	245 *800*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	160 *520*	185 *610*	220 *720*	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	43 *140*	49 *160*	60 *195*	55 *180*	60 *195*	70 *230*	48 *155*	55 *180*	65 *215*
S2	— —	— —	— —	35 *115*	40 *130*	48 *155*	43 *140*	48 *155*	60 *195*	38 *125*	44 *145*	50 *165*
S3	— —	— —	— —	31 *100*	35 *115*	42 *140*	38 *125*	43 *140*	50 *165*	34 *110*	38 *125*	46 *150*
S11	— —	— —	— —	60 *195*	70 *230*	85 *280*	75 *245*	85 *280*	100 *330*	65 *215*	75 *245*	90 *295*
S12	— —	— —	— —	42 *140*	47 *155*	55 *180*	50 *165*	60 *195*	70 *230*	46 *150*	50 *165*	65 *215*
S13	— —	— —	— —	24 *80*	28 *90*	33 *110*	30 *100*	34 *110*	41 *135*	27 *90*	30 *100*	37 *120*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	49 *160*	55 *180*	70 *230*
H12	— —	— —	— —	— —	— —	— —	95 *310*	105 *345*	125 *410*	85 *280*	95 *310*	115 *375*
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

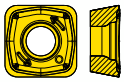
SPKT10/14/18



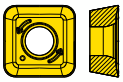
SP10-M10



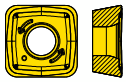
SP10-MD12



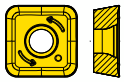
SP14-M14



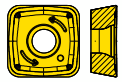
SP14-MD16



SP18-M14



SP18-MD16



Designation	IC	RE	S	AN°	GAN	Grades Coated														Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*			MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F30M	F40M	H15	H25
SPKT10T317TN-M10	10,0 *0.394*	1,7 *0.067*	3,97 *0.156*	11,0	13,0 °	■	■	■			■		■	■	■		■			■		
SPKT10T317TN-MD12	10,0 *0.394*	1,7 *0.067*	3,97 *0.156*	11,0	5,0 °	■		■	■				■							■		
SPKT140523TN-M14	14,0 *0.551*	2,3 *0.091*	5,56 *0.219*	11,0	13,0 °		■	■			■		■	■	■		■			■		
SPKT140523TN-MD16	14,0 *0.551*	2,3 *0.091*	5,56 *0.219*	11,0	5,0 °	■	■	■	■				■		■		■			■		
SPKT180630TN-M14	18,0 *0.709*	3,0 *0.118*	6,35 *0.250*	11,0	12,0 °	■	■	■					■	■	■		■			■		
SPKT180630TN-MD16	18,0 *0.709*	3,0 *0.118*	6,35 *0.250*	11,0	5,0 °	■		■	■				■							■		

UNCOMPROMISED PERFORMANCE AND LOWER COST PER EDGE

SECO HELICAL SN8-13

YOUR CHALLENGE
Economize production operations to meet customer demand for continuous job price improvements.

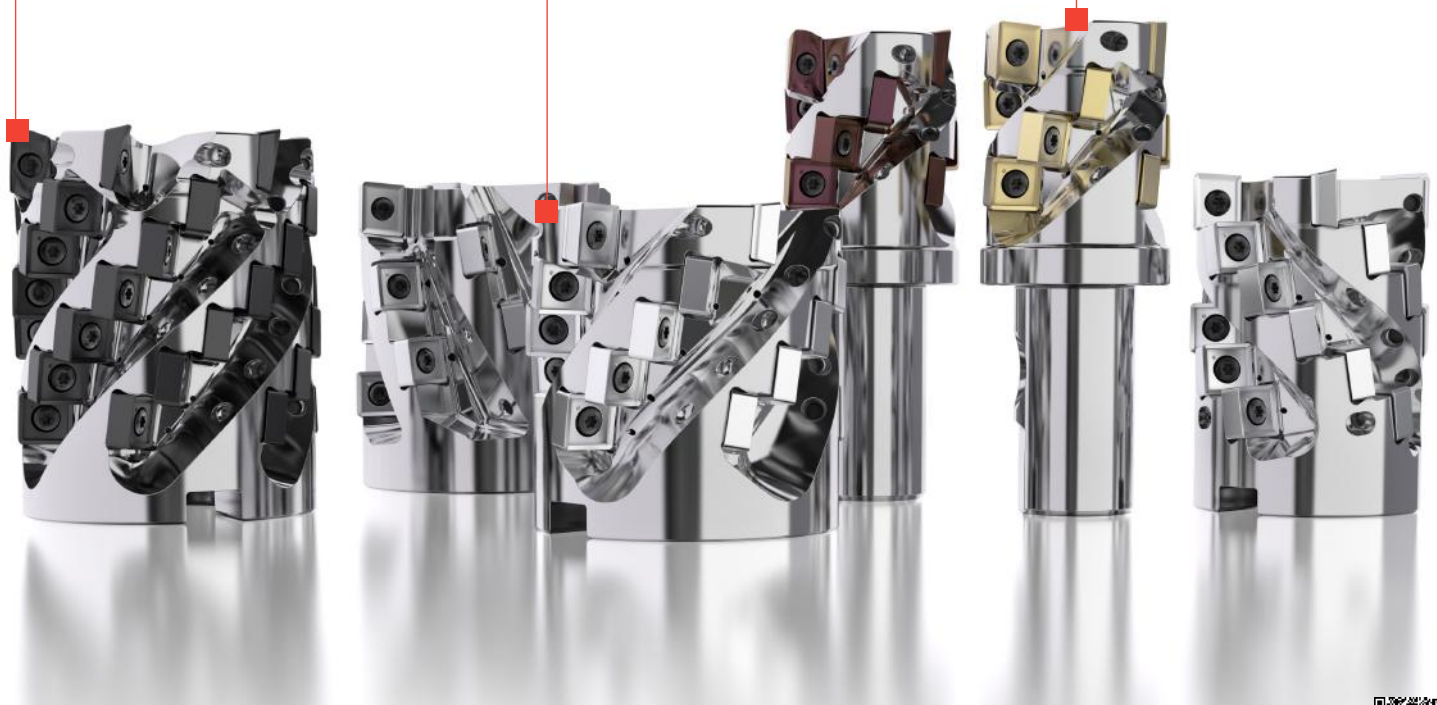
OUR SOLUTION
Reduce production costs with 8-edged helix inserts that lower cost per edge.

YOUR CHALLENGE
Overcome helical roughing issues in situations with high productivity, weak fixtures, long reach, difficult materials and low machine power.

OUR SOLUTION
Sub-families of tools optimized for various applications within one range of cutters that offers various helix hands, front insert design and radii options.

YOUR CHALLENGE
Lack of skilled workforce leads to machine downtime, quality issues and scrap, putting a stop to unattended production to reduce costs.

OUR SOLUTION
Robust and easy-to-index cutter ensures correct mounting of front and helix inserts.



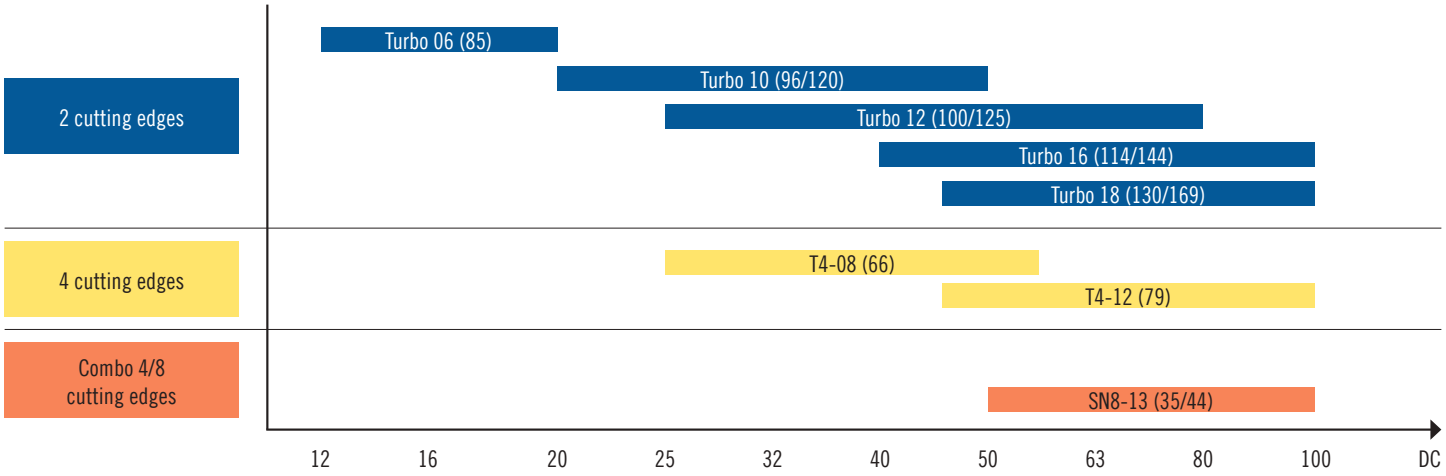
Visit **SECOTOOLS.COM** or scan the QR code and find out more information.

SECO HELICAL SN8-13

UNCOMPROMISED PERFORMANCE AND LOWER COST PER EDGE

Keep up with customer demand for lower part prices. The Seco Helical SN8-13 features double-sided helix inserts with eight cutting edges that significantly lower cost per edge to boost slotting, side milling and circular rough milling efficiency. Built for difficult applications involving ISO P, M, K and S materials, the cutters offer application-specific sub-family designs featuring left or right-hand helixes, half or full effective teeth options, two front insert and many radii choices for long tool life and maximum chip evacuation. Reliable and user-friendly, the Helical SN8-13 also eliminates incorrect indexing of front and helix inserts, reducing operator error.

POSITIONING HELICAL MILLING

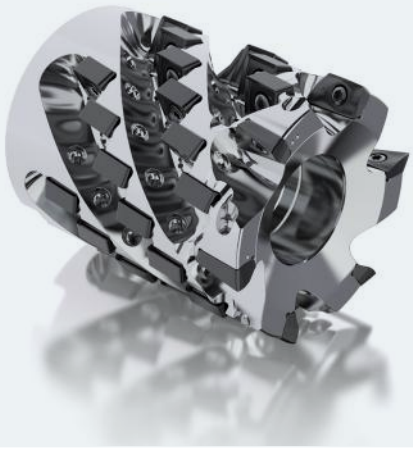


Cost per edge index (direct pressed/ground) based on XOMX12 2022 F40 M list price

Please note that the data shown is just an extract and more products are available.
For more information please visit www.secotools.com.

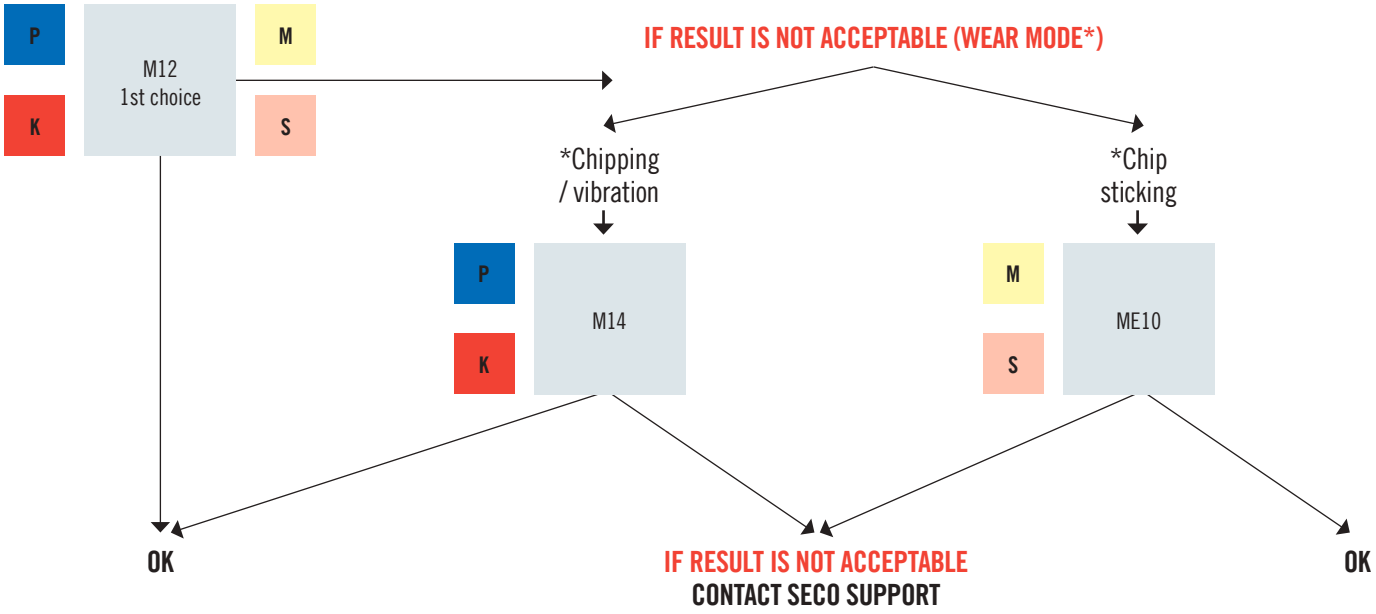
CUSTOMER BENEFITS

- High MRR for increased productivity
- Exceptionally low cost per edge
- Long tool life in P, M, K and S materials
- Tackle difficult applications easily

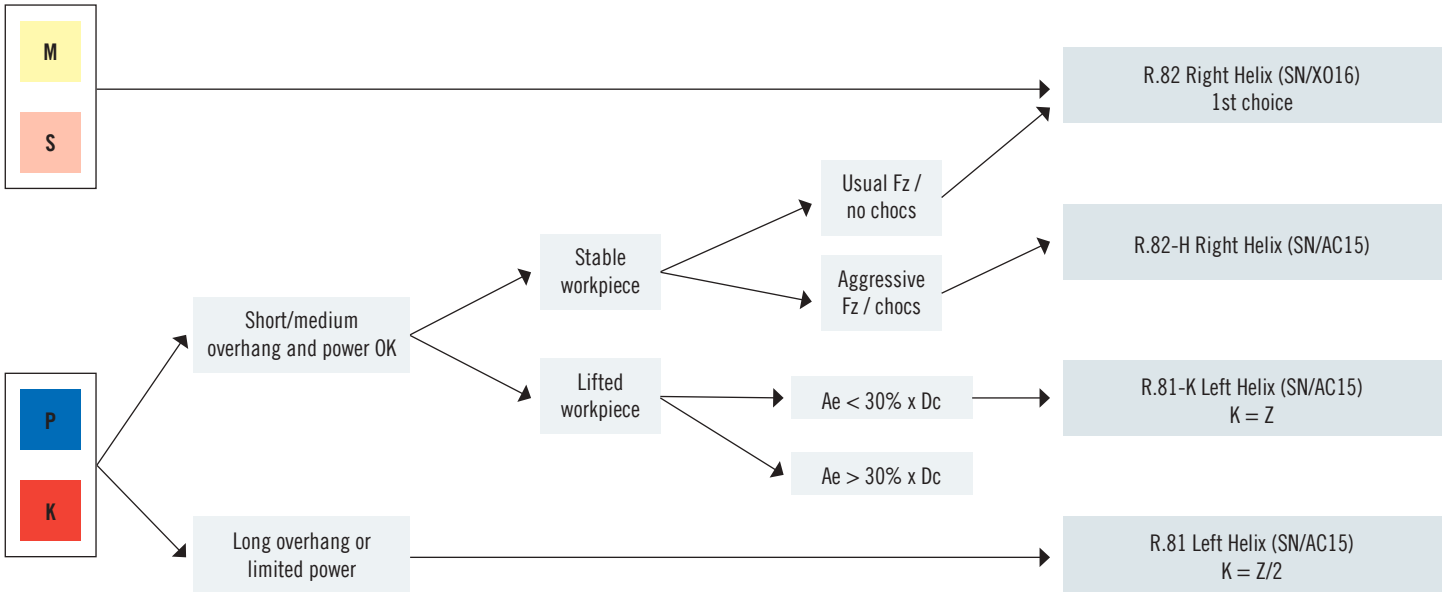


SECO HELICAL SN8-13

HELICAL SN8-13 – INSERT GEOMETRY CHOICE FLOW



HELICAL SN8-13 – SUB FAMILY CHOICE FLOW



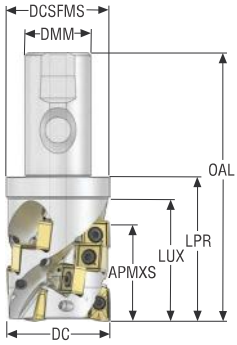
Please note that the data shown is just an extract and more products are available.
For more information please visit www.secotools.com.

HELICAL SN8-13

Keep up with customer demand for lower part prices. The Seco Helical SN8-13 features double-sided helix inserts with eight cutting edges that significantly lower cost per edge to boost slotting, side milling and circular rough milling efficiency. Built for difficult applications involving ISO P, M, K and S materials, the cutters offer application-specific sub-family designs featuring left or right-hand helixes, half or full effective teeth options, two front insert and many radii choices for long tool life and maximum chip evacuation. Reliable and user-friendly, the Helical SN8-13 also eliminates incorrect indexing of front and helix inserts, reducing operator error.

- Range is built with 4 sub families built with SN13 helix insert:
- SN.U13 insert offering 8 cutting edges in 3 geometries and several grades
- R217/220.82: XO16 lead insert = First choice
- R217/220.82-H: AC15 lead insert = Heavy Duty, R220.69-15H replacement
- R217/220.81: AC15 lead insert = Low Power, R215/220.59 replacement
- R217/220.81-K: AC15 lead insert = Long reach, R215/220.59 replacement

R217.82-SNXO16 – Metric



- For insert selection and cutting data recommendations, see page(s) 162-163
- For complete insert programme, see page(s) 813, 837, 838
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	DCSFMS	LUX	LPR	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm	mm		kg	
R217.82-3250.3S-047-SNXO16.3A	10127480	Seco-Weldon	50,0	3	12	47,0	32,0	50,0	60,0	70,0	130,0	11800	1,0	XO.X1605 / SN.U1306

Spare Parts

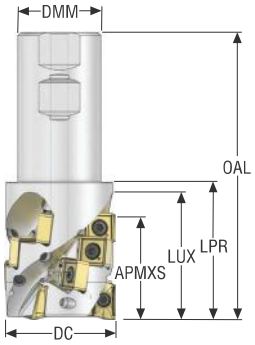
For cutter	Insert screw	Insert screw 2
	C55011-T15P	C04011-T15P

Accessories

Insert clamping torque	Insert clamping torque 2	Torque key	Torque key 2
5.0NM	3.5NM	T00-15P50	T00-15P35

Torque and fixed keys, see page 869

R217.82-SNXO16 – inch



- For insert selection and cutting data recommendations, see page(s) 162-163
- For complete insert programme, see page(s) 813, 837, 838
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LUX	LPR	OAL	RPMX	Weight	Insert
			inch			inch	inch	inch	inch	inch		lbs	
R217.82-02.00-3-1.85-SNXO16.3A	10127485	Weldon	2.000	3	12	1.850	1.500	2.362	2.441	5.169	11800	2.650	XO.X1605 / SN.U1306

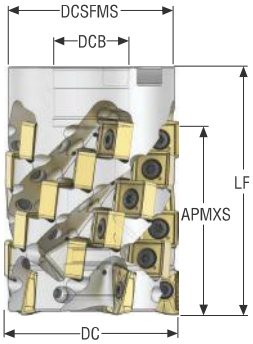
Spare Parts

Accessories

For cutter	Insert screw	Insert screw 2	Insert clamping torque	Insert clamping torque 2	Torque key	Torque key 2
	C55011-T15P	C04011-T15P	5.0NM	3.5NM	T00-15P50	T00-15P35

Torque and fixed keys, see page 869

R220.82-SNXO16 – Metric



- For insert selection and cutting data recommendations, see page(s) 162-163
- For complete insert programme, see page(s) 813, 837, 838
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm			mm	mm	mm	mm		kg	
R220.82-0063-047-SNXO16.4A	10127481	Arbor	63,0	4	16	47,0	27,0	59,0	70,0	10500	0,9	XO.X1605 / SN.U1306
R220.82-0063-069-SNXO16.5A	10127482	Arbor	63,0	5	30	69,0	27,0	59,0	90,0	10500	1,2	XO.X1605 / SN.U1306
R220.82-0080-068-SNXO16.5A	10127483	Arbor	80,0	5	30	68,0	32,0	75,0	90,0	6500	2,0	XO.X1605 / SN.U1306
R220.82-0080-079-SNXO16.6A	10127484	Arbor	80,0	6	42	79,0	32,0	75,0	100,0	6500	2,2	XO.X1605 / SN.U1306

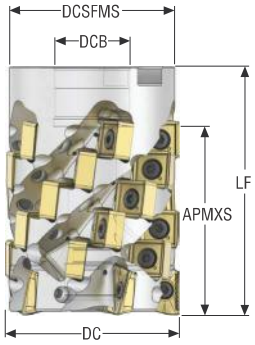
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert screw 2	Insert clamping torque	Insert clamping torque 2	Torque key	Torque key 2
R220.82-0063-047	MC6S12X60	C55011-T15P	C04011-T15P	5.0NM	3.5NM	T00-15P50	T00-15P35
R220.82-0063-069	MC6S12X80	C55011-T15P	C04011-T15P	5.0NM	3.5NM	T00-15P50	T00-15P35
R220.82-0080	MP6S16X80	C55011-T15P	C04011-T15P	5.0NM	3.5NM	T00-15P50	T00-15P35

Torque and fixed keys, see page 869

R220.82-SNXO16 – inch



- For insert selection and cutting data recommendations, see page(s) 162-163
- For complete insert programme, see page(s) 813, 837, 838
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	RPMX	Weight	Insert
			inch			inch	inch	inch	inch		lbs	
R220.82-02.50-1.85-SNXO16.4A	10127486	Arbor	2.500	4	16	1.850	1.000	2.323	2.750	10500	1.980	XO.X1605 / SN.U1306
R220.82-02.50-2.75-SNXO16.5A	10127487	Arbor	2.500	5	30	2.717	1.000	2.323	3.500	10500	2.650	XO.X1605 / SN.U1306
R220.82-03.00-2.68-SNXO16.5A	10127488	Arbor	3.000	5	30	2.677	1.250	2.795	3.500	6500	3.750	XO.X1605 / SN.U1306
R220.82-03.00-3.11-SNXO16.6A	10127489	Arbor	3.000	6	42	3.110	1.250	2.795	3.938	6500	4.190	XO.X1605 / SN.U1306

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert screw 2	Insert clamping torque	Insert clamping torque 2	Torque key	Torque key 2
R220.82-02.50.4A	UC6S1/2UNFX2-1/4	C55011-T15P	C04011-T15P	5.0NM	3.5NM	T00-15P50	T00-15P35
R220.82-02.50.5A	UC6S1/2UNFX3	C55011-T15P	C04011-T15P	5.0NM	3.5NM	T00-15P50	T00-15P35
R220.82-03.00	UP6S5/8UNFX3-1/4	C55011-T15P	C04011-T15P	5.0NM	3.5NM	T00-15P50	T00-15P35

Torque and fixed keys, see page 869

R217/220.82-SNXO16 – Insert selection – mm/*Inch*

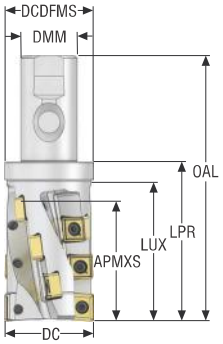
SMG			f_z		
			100%	30%	10%
P1	XOMX160508TR-M13 MP2501	SNXU130612TN-M12 MP2501	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
P2	XOMX160508TR-M13 MP2501	SNXU130612TN-M12 MP2501	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
P3	XOMX160508TR-M13 MP2501	SNXU130612TN-M12 MP2501	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
P4	XOMX160508TR-M13 MP2501	SNXU130612TN-M12 MP2501	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
P5	XOMX160508TR-MD14 MP1501	SNGU130612TN-M14 MP1501	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
P6	XOMX160508TR-MD14 MP1501	SNGU130612TN-M14 MP1501	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P7	XOMX160508TR-MD14 MP1501	SNGU130612TN-M14 MP1501	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P8	XOMX160508TR-MD14 MP1501	SNGU130612TN-M14 MP1501	0,15 *0.0060*	0,17 *0.0065*	0,25 *0.010*
P11	XOMX160508TR-ME11 T350M	SNXU130612TN-M12 T350M	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P12	XOMX160508TR-ME11 T350M	SNXU130612TN-M12 T350M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M1	XOMX160508R-M09 MS2050	SNGU130612EN-ME10 MS2050	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M2	XOMX160508R-M09 MS2050	SNGU130612EN-ME10 MS2050	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
M3	XOMX160508R-M09 MS2050	SNGU130612EN-ME10 MS2050	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*
M4	XOMX160508TR-ME11 MS2050	SNGU130612EN-ME10 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M5	XOMX160508TR-ME11 MS2050	SNGU130612EN-ME10 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
K1	XOMX160508TR-M13 MK2050	SNGU130612TN-M14 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
K2	XOMX160508TR-M13 MK2050	SNGU130612TN-M14 MK2050	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
K3	XOMX160508TR-M13 MK2050	SNGU130612TN-M14 MK2050	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
K4	XOMX160508TR-M13 MK2050	SNGU130612TN-M14 MK2050	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
K5	XOMX160508TR-M13 MK2050	SNGU130612TN-M14 MK2050	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
K6	XOMX160508TR-M13 MK2050	SNGU130612TN-M14 MK2050	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
K7	XOMX160508TR-M13 MK2050	SNGU130612TN-M14 MK2050	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
S1	XOMX160508TR-ME11 F40M	SNGU130612EN-ME10 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
S2	XOMX160508TR-ME11 F40M	SNGU130612EN-ME10 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
S3	XOMX160508TR-ME11 F40M	SNGU130612EN-ME10 MS2050	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S11	XOMX160508TR-ME11 MS2050	SNGU130612EN-ME10 MS2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S12	XOMX160508TR-ME11 MS2050	SNGU130612EN-ME10 MS2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S13	XOMX160508TR-ME11 MS2050	SNGU130612EN-ME10 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
H5	XOMX160508TR-ME11 MS2050	SNGU130612EN-ME10 MS2050	— —	— —	— —
H8	XOMX160508TR-MD14 MP1501	SNGU130612TN-M14 MP1501	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
H11	XOMX160508TR-MD14 MP1501	SNGU130612TN-M14 MP1501	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
H12	XOMX160508TR-MD14 MP1501	SNGU130612TN-M14 MP1501	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.82-SNXO16 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			T350M			MS2500			MK2050			MS2050			MP2050			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	140 *460*	155 *510*	165 *540*	120 *395*	135 *445*	145 *475*
P2	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	140 *460*	155 *510*	160 *520*	120 *395*	135 *445*	145 *475*
P3	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	130 *425*	145 *475*	155 *510*	110 *360*	125 *410*	135 *445*
P4	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	130 *425*	135 *445*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	105 *345*	120 *395*	130 *425*
P5	120 *395*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	120 *395*	130 *425*	140 *460*	110 *360*	125 *410*	135 *445*	120 *395*	135 *445*	145 *475*	105 *345*	120 *395*	130 *425*
P6	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	135 *445*	140 *460*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	130 *425*	145 *475*	155 *510*	110 *360*	125 *410*	135 *445*
P7	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	105 *345*	120 *395*	130 *425*
P8	120 *395*	135 *445*	145 *475*	115 *375*	135 *445*	140 *460*	110 *360*	125 *410*	135 *445*	120 *395*	140 *460*	145 *475*	115 *375*	130 *425*	140 *460*	105 *345*	125 *410*	130 *425*	120 *395*	135 *445*	145 *475*	100 *330*	120 *395*	125 *410*
P11	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	130 *425*	135 *445*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	105 *345*	120 *395*	130 *425*
P12	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	85 *280*	100 *330*	110 *360*	100 *330*	115 *375*	125 *410*	80 *260*	95 *310*	105 *345*
M1	— —	— —	— —	115 *375*	130 *425*	140 *460*	110 *360*	130 *425*	140 *460*	120 *395*	135 *445*	145 *475*	— —	— —	— —	110 *360*	130 *425*	140 *460*	120 *395*	135 *445*	145 *475*	105 *345*	120 *395*	130 *425*
M2	— —	— —	— —	105 *345*	120 *395*	130 *425*	105 *345*	115 *375*	125 *410*	110 *360*	125 *410*	135 *445*	— —	— —	— —	105 *345*	115 *375*	125 *410*	110 *360*	125 *410*	135 *445*	95 *310*	110 *360*	120 *395*
M3	— —	— —	— —	95 *310*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	100 *330*	115 *375*	125 *410*	— —	— —	— —	90 *295*	105 *345*	115 *375*	95 *310*	115 *375*	120 *395*	85 *280*	100 *330*	110 *360*
M4	— —	— —	— —	80 *260*	95 *310*	105 *345*	105 *345*	120 *395*	130 *425*	85 *280*	100 *330*	110 *360*	— —	— —	— —	75 *245*	90 *295*	100 *330*	85 *280*	100 *330*	110 *360*	70 *230*	85 *280*	95 *310*
M5	— —	— —	— —	70 *230*	85 *280*	95 *310*	105 *345*	120 *395*	130 *425*	75 *245*	90 *295*	100 *330*	— —	— —	— —	65 *215*	80 *260*	90 *295*	75 *245*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*
K1	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	— —	— —	— —	135 *445*	155 *510*	165 *540*	— —	— —	— —	— —	— —	— —	105 *345*	120 *395*	130 *425*
K2	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	110 *360*	120 *395*	135 *445*	— —	— —	— —	130 *425*	145 *475*	155 *510*	— —	— —	— —	— —	— —	— —	100 *330*	115 *375*	125 *410*
K3	110 *360*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	— —	— —	— —	120 *395*	135 *445*	145 *475*	— —	— —	— —	— —	— —	— —	90 *295*	105 *345*	115 *375*
K4	110 *360*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	95 *310*	110 *360*	120 *395*	— —	— —	— —	120 *395*	135 *445*	145 *475*	— —	— —	— —	— —	— —	— —	90 *295*	105 *345*	115 *375*
K5	80 *260*	95 *310*	105 *345*	75 *245*	90 *295*	100 *330*	70 *230*	85 *280*	95 *310*	— —	— —	— —	95 *310*	110 *360*	115 *375*	— —	— —	— —	— —	— —	— —	60 *195*	75 *245*	85 *280*
K6	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	— —	— —	— —	115 *375*	125 *410*	140 *460*	— —	— —	— —	— —	— —	— —	80 *260*	95 *310*	105 *345*
K7	95 *310*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	85 *280*	100 *330*	105 *345*	— —	— —	— —	105 *345*	120 *395*	130 *425*	— —	— —	— —	— —	— —	— —	75 *245*	90 *295*	100 *330*
S1	— —	— —	— —	42 *140*	55 *180*	65 *215*	38 *125*	50 *165*	60 *195*	46 *150*	60 *195*	70 *230*	— —	— —	— —	38 *125*	50 *165*	60 *195*	45 *150*	60 *195*	70 *230*	35 *115*	46 *150*	55 *180*
S2	— —	— —	— —	34 *110*	46 *150*	55 *180*	31 *100*	41 *135*	48 *155*	37 *120*	50 *165*	60 *195*	— —	— —	— —	31 *100*	41 *135*	48 *155*	36 *120*	48 *155*	55 *180*	28 *90*	37 *120*	43 *140*
S3	— —	— —	— —	30 *100*	40 *130*	47 *155*	27 *90*	36 *120*	42 *140*	33 *110*	43 *140*	50 *165*	— —	— —	— —	27 *90*	36 *120*	42 *140*	32 *105*	42 *140*	50 *165*	25 *80*	32 *105*	38 *125*
S11	— —	— —	— —	60 *195*	75 *245*	85 *280*	55 *180*	70 *230*	75 *245*	65 *215*	80 *260*	90 *295*	— —	— —	— —	55 *180*	70 *230*	75 *245*	65 *215*	80 *260*	85 *280*	48 *155*	65 *215*	70 *230*
S12	— —	— —	— —	41 *135*	55 *180*	65 *215*	37 *120*	49 *160*	55 *180*	45 *150*	60 *195*	70 *230*	— —	— —	— —	37 *120*	49 *160*	55 *180*	44 *145*	60 *195*	65 *215*	34 *110*	44 *145*	50 *165*
S13	— —	— —	— —	24 *80*	32 *105*	37 *120*	21 *70*	28 *90*	33 *110*	26 *85*	35 *115*	40 *130*	— —	— —	— —	21 *70*	28 *90*	33 *110*	25 *80*	34 *110*	40 *130*	19 *60*	26 *85*	30 *100*
H5	42 *140*	55 *180*	65 *215*	35 *115*	46 *150*	55 *180*	34 *110*	44 *145*	55 *180*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	29 *95*	39 *130*	46 *150*
H8	46 *150*	60 *195*	70 *230*	38 *125*	50 *165*	60 *195*	36 *120*	48 *155*	55 *180*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	31 *100*	41 *135*	48 *155*
H11	55 *180*	70 *230*	80 *260*	45 *150*	60 *195*	70 *230*	43 *140*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —	— —	— —	— —	47 *155*	60 *195*	70 *230*	37 *120*	49 *160*	60 *195*
H12	75 *245*	90 *295*	100 *330*	70 *230*	85 *280*	95 *310*	65 *215*	80 *260*	90 *295*	75 *245*	90 *295*	100 *330*	— —	— —	— —	— —	— —	— —	75 *245*	90 *295*	100 *330*	55 *180*	70 *230*	80 *260*

R217.81-SNAC15 Left Helix Troubleshooter – Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 791, 813
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	DCSFMS	LUX	LPR	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm	mm		kg	
R217.81-3250.3S-068-SNAC15.2	10127496	Seco-Weldon	50,0	2	12	68,0	32,0	50,0	79,0	90,0	150,0	8300	1,1	AC.T1506 / SN.U1306

Spare Parts

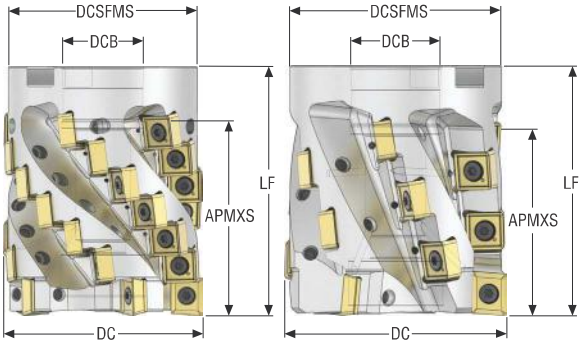
For cutter	Insert screw
R217.81-..	C55011-T15P

Accessories

Insert clamping torque	Torque key
5.0NM	T00-15P50

Torque and fixed keys, see page 869

R220.81-SNAC15 – Left Helix Troubleshooter - Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 791, 813
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm			mm	mm	mm	mm		kg	
R220.81-0063-068-SNAC15.2A	10127497	Arbor	63,0	2	12	68,0	27,0	59,0	90,0	7400	1,2	AC.T1506 / SN.U1306
R220.81-0063-068-SNAC15.4KA	10127494	Arbor	63,0	4	24	68,0	27,0	59,0	90,0	7400	1,1	AC.T1506 / SN.U1306
R220.81-0080-068-SNAC15.3A	10127498	Arbor	80,0	3	18	68,0	32,0	75,5	90,0	6500	2,2	AC.T1506 / SN.U1306
R220.81-0080-079-SNAC15.5KA	10127495	Arbor	80,0	5	35	79,0	32,0	75,0	100,0	6500	2,2	AC.T1506 / SN.U1306
R220.81-0100-068-SNAC15.4A	10127499	Arbor	100,0	4	24	68,0	40,0	91,0	90,0	5800	3,4	AC.T1506 / SN.U1306

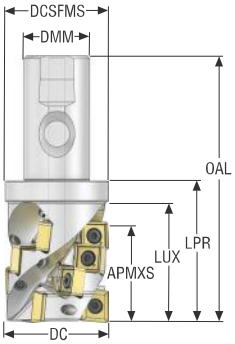
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert clamping torque	Torque key
R220.81-0063	MP6S12X80	C55011-T15P	5.0NM	T00-15P50
R220.81-0080	MP6S16X80	C55011-T15P	5.0NM	T00-15P50
R220.81-0100	MP6S20X80	C55011-T15P	5.0NM	T00-15P50

Torque and fixed keys, see page 869

R217.82-SNAC15 – Right Helix for Heavy Duty – Metric



- For insert selection and cutting data recommendations, see page(s) 154-156
- For complete insert programme, see page(s) 791, 813
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	DCSFMS	LUX	LPR	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm	mm		kg	
R217.82-3250.3S-046-SNAC15.3HA	10127490	Seco-Weldon	50,0	3	12	47,0	32,0	50,0	57,0	68,0	128,0	8300	1,0	AC.T1506 / SN.U1306

Spare Parts

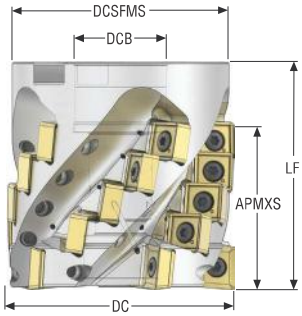
For cutter	Insert screw
	C55011-T15P

Accessories

Insert clamping torque	Torque key
5.0NM	T00-15P50

Torque and fixed keys, see page 869

R220-82-SNAC15 Right Helix for Heavy Duty – Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 791, 813
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm			mm	mm	mm	mm		kg	
R220.82-0063-046-SNAC15.4HA	10127491	Arbor	63,0	4	16	46,0	27,0	59,0	70,0	7400	0,9	AC.T1506 / SN.U1306
R220.82-0080-057-SNAC15.5HA	10127492	Arbor	80,0	5	25	57,0	32,0	75,0	80,0	6500	1,8	AC.T1506 / SN.U1306
R220.82-0100-057-SNAC15.6HA	10127493	Arbor	100,0	6	30	57,0	40,0	90,0	75,0	5800	2,6	AC.T1506 / SN.U1306

Spare Parts

For cutter	Arbor screw	Insert screw
R220.82-0063	MC6S12X60	C55011-T15P
R220.82-0080	MC6S16X70	C55011-T15P
R220.82-0100	–	C55011-T15P

Accessories

Arbor screw	Insert clamping torque	Torque key
–	5.0NM	T00-15P50
–	5.0NM	T00-15P50
MC6S20X50	5.0NM	T00-15P50

Torque and fixed keys, see page 869

R217/220.82-SNAC15 – Insert selection – mm/*Inch*

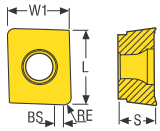
SMG			f_z		
			100%	30%	10%
P1	ACET150612TR-M11 MP2501	SNXU130612TN-M12 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P2	ACET150612TR-M11 MP2501	SNXU130612TN-M12 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P3	ACET150612TR-M11 MP2501	SNXU130612TN-M12 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P4	ACET150612TR-M11 MP2501	SNXU130612TN-M12 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P5	ACET150612TR-M11 MP2501	SNGU130612TN-M14 MP2501	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P6	ACET150612TR-M11 MP2501	SNGU130612TN-M14 MP2501	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P7	ACET150612TR-M11 MP2501	SNGU130612TN-M14 MP2501	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P8	ACET150612TR-M11 MP2501	SNGU130612TN-M14 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P11	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P12	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M1	ACET150612TR-ME10 MS2050	SNGU130612EN-ME10 MS2050	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
M2	ACET150612TR-ME10 MS2050	SNGU130612EN-ME10 MS2050	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M3	ACET150612TR-ME10 MS2050	SNGU130612EN-ME10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M4	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
M5	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
K1	ACET150612TR-M14 MK1500	SNGU130612TN-M14 MK2050	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K2	ACET150612TR-M14 MK1500	SNGU130612TN-M14 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K3	ACET150612TR-M14 MK1500	SNGU130612TN-M14 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K4	ACET150612TR-M14 MK1500	SNGU130612TN-M14 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K5	ACET150612TR-M14 MK1500	SNGU130612TN-M14 MK2050	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K6	ACET150612TR-M14 MK1500	SNGU130612TN-M14 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K7	ACET150612TR-M14 MK1500	SNGU130612TN-M14 MK2050	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
S1	ACET150612TR-M11 F40M	SNXU130612TN-M12 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
S2	ACET150612TR-M11 F40M	SNXU130612TN-M12 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
S3	ACET150612TR-M11 F40M	SNXU130612TN-M12 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S11	ACET150612TR-ME10 MS2050	SNGU130612EN-ME10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S12	ACET150612TR-ME10 MS2050	SNGU130612EN-ME10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S13	ACET150612TR-ME10 MS2050	SNGU130612EN-ME10 MS2050	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H5	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
H8	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
H11	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
H12	ACET150612TR-M11 T350M	SNXU130612TN-M12 T350M	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

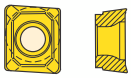
R217/220.82-SNAC15 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			T350M			MS2500			MK2050			MS2050			MP2050			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	145 *475*	160 *520*	170 *560*	140 *460*	155 *510*	165 *540*	130 *425*	145 *475*	155 *510*	145 *475*	160 *520*	170 *560*	140 *460*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	140 *460*	155 *510*	165 *540*	125 *410*	140 *460*	150 *490*
P2	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	140 *460*	155 *510*	165 *540*	120 *395*	135 *445*	145 *475*
P3	135 *445*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	120 *395*	135 *445*	145 *475*	135 *445*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	120 *395*	135 *445*	145 *475*	130 *425*	150 *490*	155 *510*	115 *375*	130 *425*	140 *460*
P4	125 *410*	145 *475*	150 *490*	120 *395*	140 *460*	145 *475*	115 *375*	130 *425*	140 *460*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	130 *425*	135 *445*	125 *410*	140 *460*	150 *490*	105 *345*	120 *395*	130 *425*
P5	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	125 *410*	140 *460*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	105 *345*	120 *395*	130 *425*
P6	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	130 *425*	145 *475*	155 *510*	110 *360*	125 *410*	135 *445*
P7	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	125 *410*	145 *475*	150 *490*	110 *360*	125 *410*	135 *445*
P8	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	105 *345*	120 *395*	130 *425*
P11	125 *410*	140 *460*	150 *490*	120 *395*	140 *460*	145 *475*	115 *375*	130 *425*	140 *460*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	130 *425*	135 *445*	125 *410*	140 *460*	150 *490*	105 *345*	120 *395*	130 *425*
P12	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	90 *295*	105 *345*	115 *375*	105 *345*	120 *395*	130 *425*	95 *310*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	100 *330*	115 *375*	125 *410*	85 *280*	100 *330*	110 *360*
M1	— —	— —	— —	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	120 *395*	140 *460*	150 *490*	— —	— —	— —	115 *375*	130 *425*	140 *460*	120 *395*	140 *460*	145 *475*	110 *360*	125 *410*	135 *445*
M2	— —	— —	— —	110 *360*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	115 *375*	130 *425*	140 *460*	— —	— —	— —	105 *345*	120 *395*	130 *425*	110 *360*	125 *410*	135 *445*	100 *330*	115 *375*	125 *410*
M3	— —	— —	— —	95 *310*	110 *360*	120 *395*	95 *310*	110 *360*	115 *375*	100 *330*	115 *375*	125 *410*	— —	— —	— —	95 *310*	110 *360*	115 *375*	100 *330*	115 *375*	125 *410*	85 *280*	105 *345*	110 *360*
M4	— —	— —	— —	80 *260*	100 *330*	105 *345*	110 *360*	125 *410*	135 *445*	85 *280*	105 *345*	110 *360*	— —	— —	— —	80 *260*	95 *310*	105 *345*	85 *280*	100 *330*	110 *360*	75 *245*	90 *295*	100 *330*
M5	— —	— —	— —	70 *230*	90 *295*	95 *310*	110 *360*	125 *410*	135 *445*	75 *245*	95 *310*	100 *330*	— —	— —	— —	70 *230*	85 *280*	95 *310*	75 *245*	90 *295*	100 *330*	65 *215*	80 *260*	90 *295*
K1	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	— —	— —	— —	140 *460*	155 *510*	165 *540*	— —	— —	— —	— —	— —	— —	110 *360*	125 *410*	135 *445*
K2	120 *395*	135 *445*	145 *475*	120 *395*	130 *425*	140 *460*	110 *360*	125 *410*	135 *445*	— —	— —	— —	135 *445*	150 *490*	160 *520*	— —	— —	— —	— —	— —	— —	100 *330*	115 *375*	125 *410*
K3	110 *360*	130 *425*	140 *460*	110 *360*	125 *410*	135 *445*	100 *330*	115 *375*	125 *410*	— —	— —	— —	125 *410*	140 *460*	150 *490*	— —	— —	— —	— —	— —	— —	95 *310*	110 *360*	120 *395*
K4	110 *360*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	— —	— —	— —	120 *395*	135 *445*	145 *475*	— —	— —	— —	— —	— —	— —	90 *295*	105 *345*	115 *375*
K5	85 *280*	100 *330*	110 *360*	80 *260*	95 *310*	105 *345*	70 *230*	85 *280*	95 *310*	— —	— —	— —	95 *310*	110 *360*	120 *395*	— —	— —	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*
K6	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	90 *295*	105 *345*	115 *375*	— —	— —	— —	115 *375*	130 *425*	140 *460*	— —	— —	— —	— —	— —	— —	85 *280*	100 *330*	110 *360*
K7	95 *310*	115 *375*	120 *395*	90 *295*	110 *360*	115 *375*	85 *280*	100 *330*	110 *360*	— —	— —	— —	110 *360*	125 *410*	135 *445*	— —	— —	— —	— —	— —	— —	75 *245*	95 *310*	100 *330*
S1	— —	— —	— —	44 *145*	60 *195*	65 *215*	39 *130*	55 *180*	60 *195*	48 *155*	65 *215*	70 *230*	— —	— —	— —	39 *130*	55 *180*	60 *195*	47 *155*	60 *195*	70 *230*	36 *120*	48 *155*	55 *180*
S2	— —	— —	— —	35 *115*	47 *155*	55 *180*	32 *105*	42 *140*	50 *165*	39 *130*	50 *165*	60 *195*	— —	— —	— —	32 *105*	42 *140*	50 *165*	38 *125*	50 *165*	60 *195*	29 *95*	38 *125*	45 *150*
S3	— —	— —	— —	32 *105*	41 *135*	49 *160*	28 *90*	37 *120*	43 *140*	34 *110*	45 *150*	55 *180*	— —	— —	— —	28 *90*	37 *120*	43 *140*	33 *110*	44 *145*	50 *165*	26 *85*	34 *110*	39 *130*
S11	— —	— —	— —	60 *195*	75 *245*	85 *280*	55 *180*	70 *230*	80 *260*	65 *215*	80 *260*	90 *295*	— —	— —	— —	55 *180*	70 *230*	80 *260*	65 *215*	80 *260*	90 *295*	50 *165*	65 *215*	75 *245*
S12	— —	— —	— —	43 *140*	55 *180*	65 *215*	38 *125*	50 *165*	60 *195*	47 *155*	60 *195*	70 *230*	— —	— —	— —	38 *125*	50 *165*	60 *195*	45 *150*	60 *195*	70 *230*	35 *115*	46 *150*	55 *180*
S13	— —	— —	— —	25 *80*	33 *110*	39 *130*	22 *70*	30 *100*	35 *115*	27 *90*	36 *120*	42 *140*	— —	— —	— —	22 *70*	30 *100*	35 *115*	26 *85*	35 *115*	41 *135*	20 *65*	27 *90*	31 *100*
H5	44 *145*	60 *195*	65 *215*	37 *120*	48 *155*	55 *180*	35 *115*	46 *150*	55 *180*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	31 *100*	40 *130*	48 *155*
H8	48 *155*	60 *195*	70 *230*	39 *130*	50 *165*	60 *195*	37 *120*	49 *160*	60 *195*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	33 *110*	43 *140*	50 *165*
H11	55 *180*	70 *230*	80 *260*	47 *155*	60 *195*	70 *230*	45 *150*	60 *195*	70 *230*	— —	— —	— —	— —	— —	— —	— —	— —	— —	49 *160*	65 *215*	75 *245*	39 *130*	50 *165*	60 *195*
H12	80 *260*	95 *310*	105 *345*	75 *245*	90 *295*	100 *330*	65 *215*	80 *260*	90 *295*	80 *260*	95 *310*	100 *330*	— —	— —	— —	— —	— —	— —	75 *245*	90 *295*	100 *330*	60 *195*	75 *245*	80 *260*

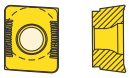
AC..15



M10/M11/M14/MD15

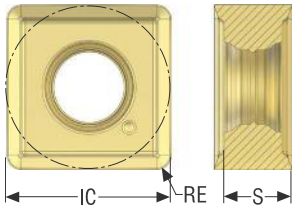


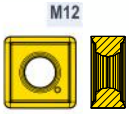
ME10

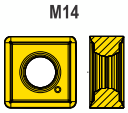


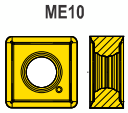
Designation	RE	BS	L	W1	S	GAN	Grades Coated															Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F30M	F40M	H15	H25
ACET150612TR-ME10	1,2 *0.047*	0,13 *0.005*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	22,0 °									■						■		
ACET150612TL-M11	1,2 *0.047*	0,13 *0.005*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	14,0 °															■		
ACET150612TR-M11	1,2 *0.047*	0,13 *0.005*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	14,0 °	■		■				■				■	■			■		
ACET150631TR-M11	3,1 *0.122*	0,0 –	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	14,0 °															■		
ACET150612TL-M14	1,2 *0.047*	0,13 *0.005*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °															■		
ACET150612TR-M14	1,2 *0.047*	0,13 *0.005*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °			■				■					■			■		
ACET150630TR-M14	3,0 *0.118*	0,0 –	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °												■					
ACET150631TR-M14	3,1 *0.122*	0,0 –	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °															■		
ACET150660TL-M14	6,0 *0.236*	0,0 –	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °															■		
ACET150660TR-M14	6,0 *0.236*	0,0 –	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °												■			■		
ACET150612TR-MD15	1,2 *0.047*	0,13 *0.005*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °	■			■								■					
ACET150630TR-MD15	3,0 *0.118*	0,0 –	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °	■																
ACMT150612TR-M14	1,2 *0.047*	0,13 *0.005*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °			■									■			■		

SN.U13



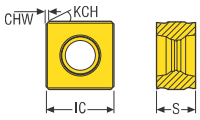


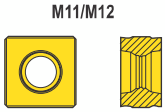




Designation	IC	RE	S	GAN	Grades Coated															Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F30M	F40M	H15	H25
SNGU130612EN-ME10	13,587 *0.535*	1,2 *0.047*	5,56 *0.219*	26,0 °		■							■	■							
SNGU130612TN-M14	13,6 *0.535*	1,2 *0.047*	5,56 *0.219*	23,0 °	■		■					■									
SNXU130612TN-M12	13,587 *0.535*	1,2 *0.047*	5,56 *0.219*	21,0 °			■					■	■	■		■			■		

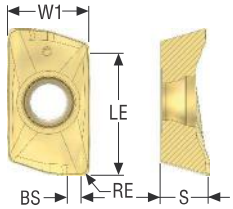
SNHX11/14





Designation	CHW	S	IC	KCH°	GAN	Grades Coated														Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F30M	F40M	H15	H25
SNHX1106TN8-M11	0,5 *0.020*	6,35 *0.250*	11,0 *0.433*	45,0	10,0 °			■									■			■		
SNHX1406TN8-M12	0,8 *0.031*	6,35 *0.250*	14,5 *0.571*	45,0	10,0 °			■									■			■		

XO.X16



E07/M09

M13

MD14

ME11

XOMX-M09

Designation	RE	BS	LE	W1	S	GAN	Grades Coated														Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F30M	F40M	H15	H25
XOEX160504FR-E07	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	23,0 °																■
XOEX160508FR-E07	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	23,0 °																■
XOEX160504R-M09	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °			■	■											■	
XOEX160508R-M09	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °		■	■	■					■	■		■			■	
XOEX160516R-M09	1,6 *0.063*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °									■	■					■	
XOEX160520R-M09	2,0 *0.079*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °									■						■	
XOEX160524R-M09	2,4 *0.094*	1,8 *0.071*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °		■							■						■	
XOEX160531R-M09	3,1 *0.122*	1,6 *0.063*	15,3 *0.602*	10,2 *0.402*	5,9 *0.232*	14,0 °		■							■	■					■	
XOEX160540R-M09	4,0 *0.157*	1,2 *0.047*	15,2 *0.598*	10,2 *0.402*	5,9 *0.232*	14,0 °									■						■	
XOEX160550R-M09	5,0 *0.197*	0,3 *0.012*	15,0 *0.591*	10,2 *0.402*	5,59 *0.220*	14,0 °									■						■	
XOEX160563R-M09	6,3 *0.248*	0,2 *0.008*	14,7 *0.579*	10,2 *0.402*	5,34 *0.210*	14,0 °									■						■	
XOMX160504TR-ME11	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	19,0 °			■												■	
XOMX160508TR-ME11	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	19,0 °		■	■					■	■			■			■	
XOMX160512TR-ME11	1,2 *0.047*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	19,0 °			■												■	
XOMX160516TR-ME11	1,6 *0.063*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	18,0 °			■												■	
XOMX160520TR-ME11	2,0 *0.079*	1,9 *0.075*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	18,0 °			■						■						■	
XOMX160531TR-ME11	3,1 *0.122*	1,6 *0.063*	15,4 *0.606*	10,2 *0.402*	5,93 *0.233*	19,0 °		■							■						■	
XOMX160540TR-ME11	4,0 *0.157*	1,2 *0.047*	15,2 *0.598*	10,2 *0.402*	5,93 *0.233*	19,0 °									■						■	
XOMX160550TR-ME11	5,0 *0.197*	0,3 *0.012*	15,0 *0.591*	10,2 *0.402*	5,56 *0.219*	18,0 °									■						■	
XOMX160563TR-ME11	6,3 *0.248*	0,2 *0.008*	14,6 *0.575*	10,2 *0.402*	5,3 *0.209*	18,0 °									■						■	
XOMX160508R-M09	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °									■						■	
XOMX160508TR-M13	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,98 *0.235*	9,0 °	■		■	■			■	■				■			■	
XOMX160516TR-M13	1,6 *0.063*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,98 *0.235*	9,0 °															■	

Designation	RE	BS	LE	W1	S	GAN	Grades Coated														Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F30M	F40M	H15	H25
XOMX160531TR-M13	3,1 *0.122*	1,6 *0.063*	15,4 *0.606*	10,2 *0.402*	5,98 *0.235*	9,0 °															■		
XOMX160504TR-MD14	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	6,01 *0.237*	4,0 °								■									
XOMX160508TR-MD14	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	6,01 *0.237*	4,0 °	■			■				■				■					

EXPAND YOUR TOOL HOLDING VERSATILITY

SECO HYDRAULIC CHUCKS

YOUR CHALLENGE
Machines sit idle because complicated, time-consuming costly holders require special systems and operator training.

OUR SOLUTION
Tool changes are fast, easy and simple to perform with Seco Hydraulic Chucks and Reduction Sleeves, in drilling, reaming, tapping and light milling.

YOUR CHALLENGE
Inability to reach narrow and deep part areas during light milling and drilling operations.

OUR SOLUTION
The HCS Slim version Seco Hydraulic Chuck provides extended tooling reach for effective workpiece accessibility.

YOUR CHALLENGE
Varied, challenging materials and machining conditions require multiple tool holders.

OUR SOLUTION
With its compact and robust design, the Seco reinforced HCR Hydraulic Chuck ensure strong clamping and withstand high radial cutting forces when to provide full tool engagement while machining a variety of tough materials.

Visit **SECOTOOLS.COM** or scan the QR code and find out more information.

CUSTOMER BENEFITS

- Comprehensive range of hydraulic chucks
- Compatible with all common machine tool spindle interfaces
- Range includes conventional (HC), reinforced power (HCR) and slim (HCS) designs
- Available slotted reduction sleeves in sealed and peripherical coolant versions
- Chucks support Seco round tools for the utmost performance

SECO HYDRAULIC CHUCKS

ELIMINATE COMPLICATED TOOL HOLDING

Seco Hydraulic Chucks and Reduction Sleeves provide simple, easy-to-use, versatile tool holding. To overcome specific machining challenges cost effectively, these chucks are available in three versions, each able to accommodate several tool shank size variations for reduced tooling inventory. The HC Conventional version delivers precision holding for drilling, reaming and light milling. As a universal solution, the HCR Reinforced version provides effective holding for all applications from HSM to HPM, and for all kind of tool shank types like Cylindrical, Weldon and Whistle Notch. The HCS Slim holder is ideal to access deep, narrow part cavities during 5-axis machining at high speeds

PRODUCT NUMBER	DESIGNATION	HC: CONVEN-TIONAL	HCR: REIN-FORCED	HCS: SLIM
10137125	HSKA63-HCR12-080		■	
10137126	HSKA63-HCR20-080		■	
10137127	HSKA100-HCR20-090		■	
10137128	HSKA100-HCR32-100		■	
10137129	DIN40ADB-HCR12-050		■	
10137130	DIN40ADB-HCR20-064		■	
10137131	DIN50ADB-HCR20-064		■	
10137132	DIN50ADB-HCR32-081		■	
10137133	CAT40ADB-HCR20-064		■	
10137134	CAT40TFADB-HCR20-064		■	
10137135	CAT50ADB-HCR32-081		■	
10137136	BT30ADB-HCR12-069		■	
10137137	BT30ADB-HCR20-090		■	
10137138	BT30TFADB-HCR12-069		■	
10137139	BT30TFADB-HCR20-090		■	
10137140	BT40ADB-HCR12-058		■	
10137141	BT40ADB-HCR20-072		■	
10137142	BT40TFADB-HCR12-058		■	
10137143	BT40TFADB-HCR20-072		■	
10137144	BT50ADB-HCR20-083		■	
10137145	BT50ADB-HCR32-090		■	
10137146	C6-HCR12-065		■	
10137147	C6-HCR20-080		■	
10137148	HSKA50-HCR20-094		■	
10137261	HSKA63-HC06-070	■		
10137262	HSKA63-HC08-070	■		
10137263	HSKA63-HC10-080	■		
10137264	HSKA63-HC12-085	■		
10137265	HSKA63-HC14-085	■		
10137266	HSKA63-HC16-090	■		
10137267	HSKA63-HC20-090	■		
10137268	HSKA63-HC25-120	■		
10137269	HSKA63-HC32-125	■		
10137270	HSKA100-HC12-095	■		
10137271	HSKA100-HC16-100	■		
10137272	HSKA100-HC20-105	■		
10137273	HSKA100-HC25-110	■		
10137274	HSKA100-HC32-110	■		
10137275	DIN40ADB-HC06-080	■		
10137276	DIN40ADB-HC08-080	■		

PRODUCT NUMBER	DESIGNATION	HC: CONVEN-TIONAL	HCR: REIN-FORCED	HCS: SLIM
10137277	DIN40ADB-HC10-080	■		
10137278	DIN40ADB-HC12-080	■		
10137279	DIN40ADB-HC16-080	■		
10137280	DIN50ADB-HC12-080	■		
10138581	DIN40ADB-HC20-080	■		
10138582	DIN50ADB-HC20-080	■		
10138583	DIN50ADB-HC32-103	■		
10137281	CAT40ADB-HC06-063	■		
10137282	CAT40ADB-HC08-063	■		
10137283	CAT40ADB-HC10-063	■		
10137284	CAT40ADB-HC12-063	■		
10137285	CAT40ADB-HC16-063	■		
10137286	CAT40ADB-HC20-063	■		
10137287	CAT40TFADB-HC06-080	■		
10137288	CAT40TFADB-HC08-080	■		
10137289	CAT40TFADB-HC10-080	■		
10137290	CAT40TFADB-HC12-080	■		
10137291	CAT40TFADB-HC16-080	■		
10137292	CAT40TFADB-HC20-080	■		
10137293	CAT50ADB-HC12-081	■		
10137294	CAT50ADB-HC20-081	■		
10137295	CAT50ADB-HC25-081	■		
10137296	CAT50ADB-HC32-081	■		
10137297	BT40ADB-HC06-090	■		
10137298	BT40ADB-HC08-090	■		
10137299	BT40ADB-HC10-090	■		
10137300	BT40ADB-HC12-090	■		
10137301	BT40ADB-HC16-090	■		
10137302	BT40ADB-HC20-090	■		
10137303	BT50ADB-HC20-090	■		
10137304	BT50ADB-HC32-120	■		
10137328	HSKA63-HCS06-145			■
10137329	HSKA63-HCS08-145			■
10137330	HSKA63-HCS10-145			■
10137331	HSKA63-HCS12-145			■
10137332	HSKA63-HCS16-145			■
10137333	HSKA63-HCS20-145			■
10137334	HSKA100-HCS06-150			■
10137335	HSKA100-HCS08-150			■
10137336	HSKA100-HCS10-150			■

PRODUCT NUMBER	DESIGNATION	HC: CONVEN-TIONAL	HCR: REIN-FORCED	HCS: SLIM
10137337	HSKA100-HCS12-150			■
10137338	HSKA100-HCS16-150			■
10137339	HSKA100-HCS20-150			■
10137340	BT40ADB-HCS06-150			■
10137341	BT40ADB-HCS08-150			■
10137342	BT40ADB-HCS10-150			■
10137343	BT40ADB-HCS12-150			■
10137344	BT40ADB-HCS16-150			■
10137345	BT40ADB-HCS20-150			■
10137346	BT40TFADB-HCS06-150			■
10137347	BT40TFADB-HCS08-150			■
10137348	BT40TFADB-HCS10-150			■
10137349	BT40TFADB-HCS12-150			■
10137350	BT40TFADB-HCS16-150			■
10137351	BT40TFADB-HCS20-150			■
10137352	ST20-HC12-100	■		
10137353	ST20-HC20-100	■		
10137354	ST32-HC20-140	■		
10137305	C5-HC06-065	■		
10137306	C5-HC08-065	■		
10137307	C5-HC10-075	■		
10137308	C5-HC12-080	■		
10137309	C5-HC16-085	■		
10137310	C5-HC20-085	■		
10137311	C5-HC25-095	■		
10137312	C6-HC06-065	■		
10137313	C6-HC08-065	■		
10137314	C6-HC10-075	■		
10137315	C6-HC12-080	■		
10137316	C6-HC16-085	■		
10137317	C6-HC20-085	■		
10137318	C6-HC25-095	■		
10137319	C6-HC32-100	■		
10137320	C8-HC20-095	■		
10137321	C8-HC32-105	■		
10137322	G5-HC20-090	■		
10137323	G6-HC25-100	■		
10137324	G6-HC32-100	■		

Tool holders for round tools clamping

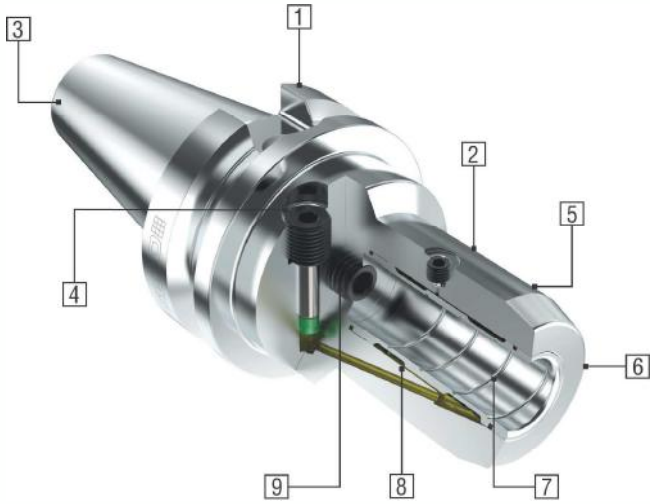
		Power milling chuck	Hydraulic chuck HC	Hydraulic chuck HCR	Hydraulic chuck HCS
		PMC	HC 5834		
Operations	Finishing milling	■■■□□	■■■■■	■■■■■	■■■■■
	Medium milling	■■■■□	■■■□□	■■■■■	■■□□□
	Rough milling	■■■■□	NA	■■■■■	NA
	High speed milling	■□□□□	■■■■□	■■■■□	■■■■□
	Drilling	■■■□□	■■■□□	■■■□□	■■■□□
	Reaming	■■□□□	■■■■■	■■■□□	■■■□□
	Tapping	NA	NA	NA	NA
Characteristics	Clamping range (mm)	∅6 – ∅32	∅3 – ∅32	∅12 – ∅20 – ∅32 in direct ∅3 – ∅32 through sleeves	∅6 – ∅20
	Clamping range (inch)	∅0.75 – ∅1.25	∅0.118 – ∅1.25	∅0.472 – ∅0.787 – ∅125 in direct ∅0.118 – ∅1.25 through sleeves	∅0.236 – ∅0.787
	Run-out	>10 µm/.0004" (3x ∅)	≤3 µm/.0001'	≤3 µm/.0001"	≤3 µm/.0001'
	Max RPM*	15 000 rpm	40 000 rpm	50 000 rpm (∅32/1.25" max 25 000 rpm)	40 000 rpm
	Transmittable torque	1500 Nm/1106 ft/lb (∅32 mm/1.25")	650 Nm/480 ft/lb (∅32 mm/1.25") (250 Nm for Seco-Capto/Graflex)	900 Nm/664 ft/lb (∅32 mm/1.25")	231 Nm/170 ft/lb (∅20 mm/0.787")
	Tool change	Spanner	Locking hex key	Locking hex key	Locking hex key
	Axial adjustment	Screw		Screw	Screw
	Max coolant pressure*	30 bar/435 psi	80 bar/1160 psi (70 bar/1015 psi for Seco-Capto/Graflex)	80 bar/1160 psi	80 bar/1160 psi
	Type of cooling	Central		Central	Central
	Balancing quality	Pre-balanced	G2.5 - 25 000 or U≤1g.mm (except Seco-Capto)	G2.5 - 25 000 or U≤1g.mm	G2.5 - 25 000 or U≤1g.mm
	Option	Stop screws for through coolant Sleeves	Sleeves (sealed or peripheral coolant)	Sleeves (sealed or peripheral coolant)	Sleeves (sealed or peripheral coolant)
Recommandations		▪ Ideal for heavy duty operations, high chips removale rates ▪ Alternative to shrinkfit or Weldon ▪ Easy to implement ▪ Versatile through use of reduction sleeves	▪ Semi-finishing and finishing operations in High Speed Cutting (HSC) ▪ Not recommended for heavy milling with big radial loads ▪ Simple to use, but needs maintenance ▪ Flexibility thru red. sleeves ▪ Dampening effect	▪ Universal chuck, for heavy roughing applications (HPM) or High Speed Cutting (HSC) in all kind of applications ▪ High rigidity, high torques ▪ Very easy to use ▪ Flexibility thru red. Sleeves ▪ Damping effect	▪ For semi-finishing and finishing applications in deep cavities, like M&D ▪ Very easy to use ▪ Flexibility thru red. Sleeves
Tool shank quality		Recommanded: h6 (max h7)	Needs to be: h6		

*** Depending on the holder's machine side taper type and size**

Hydraulic expansion chucks – HC (former 5834), HCR and HCS

Hydraulic chucks, that use oil pressure to compress an internal membrane within the holder body, feature repeatable low runout, quick and easy tool change, and are effective for reaming, drilling, threading and light milling with end mills at high spindle speeds. The HCR Power version can perform High Machining Performance thanks to a high radial rigidity, as well as High-Speed Machining.

Most important features	
1	Fine balanced in standard at G2,5-25,000 rpm or ≤1 g.mm (Seco-Capto: G6,3-20.000 rpm)
2	HC version with body shape according to DIN69882-7
3	Made from Premium material, high mechanical strength and good resistance to thermal shocks
4	Very easy to use, just turn one screw until stop. Not additional equipment needed
5	Good gripping forces (shank tolerance h6 maximum), especially Power version offering high clamping forces
6	Repeatable runout ≤ 3 µm HC Straight shanks: runout ≤ 6 µm
7	Helical groove to ensure oil-free or debris-free tool shank surface
8	Oil reservoir acts as a damping agent
9	Axial stop screw for tool length adjustment



Our standard designs

HC Conventional version

The HC conventional hydro-chucks are an easy and efficient solution for high precision works like for drilling, reaming, threading, and light milling in all kind of components. Can be used along with slotted reduction sleeves offering a great flexibility.

Very easy tool changes, reducing set-up times, without need of peripherical equipment's.

HCR Reinforced version

The HCR reinforced version is a universal solution for round tools, dedicated for all kind of machining applications from high performance machining (HPM) to high-speed cutting (HSC)

Its short and compact design offers a high radial rigidity, and high gripping forces (up to 900 Nm for diam 32 !)

Fine balanced, it is suitable for high-speed applications up to 50.000 rpm (diam. 12 and 20 mm).

The range features a direct clamping for diam. 12, 20 and 32, but various other diameters can be clamped through slotted reduction sleeves. All kind of tool shank types can be clamped even in direct mount.

HCS Slim 3° version

The HCS Slim 3° designs are ideal for excellent workpiece accessibility, machining of narrow and deep areas in light milling and drilling operations.

This range is completed with cylindrical extensions enabling to build long and slim assemblies once mounted into the HCR Power chucks for example.

Reduction sleeves for hydraulic chucks

Slotted reduction sleeves from diam. 12, 20 and 32 mm allow the clamping of several different tool shank sizes with just one toolholder, offering a great flexibility and reducing inventory costs.

They are available in two versions:

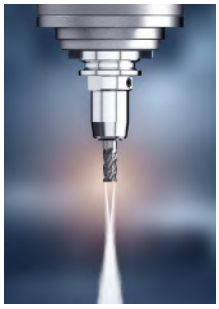
– coolant-proof for tools with coolant facilities,

– with peripheral coolant channels for tools without internal cooling holes.

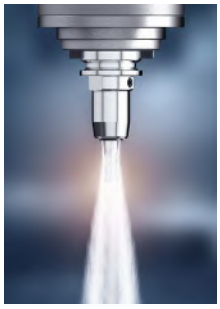
Both versions are equipped with a length pre-adjustement ring.

Runout and transmissible torque will remain unchanged.

All kind of tool shank types can be mounted into the sleeves



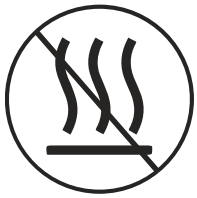
Sealed reduction sleeves 05FHC for tools with coolant holes



Reduction sleeves 05FHC…L1 with peripheral coolant channels for tools without coolant holes

Acceptable tool shanks

	Designs	Cylindrical Form A	Weldon 1 flat Form B	Weldon 2 flats Form B	Whistle Notch Form E
Direct clamping	HC (Conventional)	∅ 6 - 32 mm *∅ 0.236 - 1.260”*	∅ 6 - 20 mm *∅ 0.236 - 0.787”*	∅ 25 - 32 mm *∅ 1 - 1.260”*	∅ 6 - 32 mm *∅ 0.236 - 1.260”*
	HCR (Reinforced)	∅ 6 - 32 mm *∅ 0.236 - 1.260”*	∅ 6 - 20 mm *∅ 0.236 - 0.787”*	∅ 25 - 32 mm *∅ 1 - 1.260”*	∅ 6 - 32 mm *∅ 0.236 - 1.260”*
	HC (Capto/Graflex)	∅ 6 - 32 mm *∅ 0.236 - 1.260”*	∅ 6 - 20 mm *∅ 0.236 - 0.787”*	cannot be clamped in direct	cannot be clamped in direct
	HCS (Slim)	∅ 6 - 32 mm *∅ 0.236 - 1.260”*	∅ 6 - 20 mm *∅ 0.236 - 0.787”*	cannot be clamped in direct	cannot be clamped in direct
Through reduction sleeves	HC (Conventional)	∅ 3 - 25 mm *∅ 0.118 - 1”*	∅ 6 - 20 mm *∅ 0.236 - 0.787”*	∅ 25 mm *∅ 1”*	∅ 6 - 25 mm *∅ 0.236 - 1”*
	HCR (Reinforced)	∅ 3 - 25 mm *∅ 0.118 - 1”*	∅ 6 - 20 mm *∅ 0.236 - 0.787”*	∅ 25 mm *∅ 1”*	∅ 6 - 25 mm *∅ 0.236 - 1”*
	HCS (Slim)	∅ 3 - 25 mm *∅ 0.118 - 1”*	∅ 6 - 20 mm *∅ 0.236 - 0.787”*	∅ 25 mm *∅ 1”*	∅ 6 - 25 mm *∅ 0.236 - 1”*



Hydraulic chucks are not Shrinkfit chucks: don't heat them!

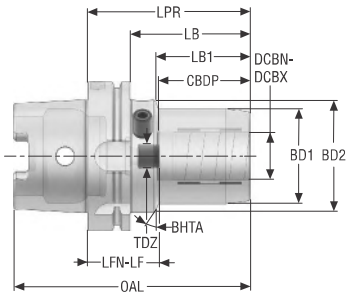
Hydraulic expansion chucks (HC-5834)

Clamping ∅	Max rpm (min $^{-1}$)				Minimum clamping depth	
	Standard design HC		Reinforced design HCR	Slim design 3° HCS		
	HSK-A, DIN, BT, BT T/F, CAT	Seco-Capto, Graflex, CAT T/F	All	All	Standard HC and Reinforced HCR in HSK-A, DIN, BT, BT T/F, CAT, Seco-Capto, Graflex	Standard HC in CAT-T/F, and all slim HCS 3°
6 mm *0.236"*	50.000	40.000		40.000	27 mm *1.063"*	27 mm *1.063"*
8 mm *0.315"*	50.000	40.000		40.000	27 mm *1.063"*	27 mm *1.063"*
10 mm *0.394"*	50.000	40.000		40.000	31 mm *1.220"*	32 mm *1.260"*
12 mm *0.472"*	50.000	40.000	50.000	40.000	36 mm *1.417"*	37 mm *1.457"*
14 mm *0.551"*	50.000	40.000		40.000	36 mm *1.417"*	37 mm *1.457"*
16 mm *0.630"*	50.000	40.000		40.000	39 mm *1.535"*	42 mm *1.654"*
20 mm *0.787"*	50.000	40.000	50.000	40.000	41 mm *1.614"*	42 mm *1.654"*
25 mm *0.984"*	25.000	25.000		25.000	47 mm *1.850"*	48 mm *1.890"*
32 mm *1.260"*	25.000	25.000	25.000	25.000	51 mm *2.000"*	55 mm *2.165"*

– Operating temperature: 20-50°C
– Max. coolant pressure: 80 bar/1160 psi, Seco-Capto and Graflex: 70 bar/1015 psi
– Adjustment range of the length: 10 mm. Tool must be inserted at recommended minimum clamping length (see chart)
– Tool shank quality: h6 or better
– Adapt your parameters in case of long tools, heavy tools, and when using extensions
– HC Straight shanks limited to maxi 10.000 rpm

HC – Hydraulic chucks – DIN69882-7 – Metric / *Inch*

HSK-A/ ISO12164-1-HSK-A



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For HSK sealing plugs, coolant tubes and tube spanners, see page(s) 394
- For ISO attribute explanation, see page 14

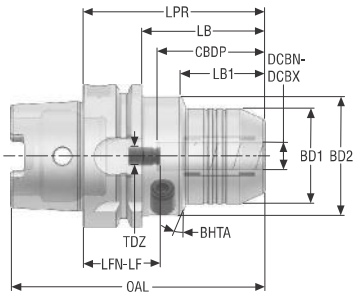
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balancing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
HSKA63-HC06-070	10137261	HSK-A63	6,0 *0.236*	70,0 *2.756*	44,05 *1.734*	24,0 *0.945*	38,5 *1.516*	50,0 *1.969*	26,0 *1.024*	101,9 *4.012*	33,0 *1.299*	43,0 *1.693*	M5	20,0	1	G2.5	1,0 *2.200*
HSKA63-HC08-070	10137262	HSK-A63	8,0 *0.315*	70,0 *2.756*	44,05 *1.734*	25,0 *0.984*	38,5 *1.516*	50,0 *1.969*	28,0 *1.102*	101,9 *4.012*	33,0 *1.299*	43,0 *1.693*	M6	20,0	1	G2.5	1,0 *2.200*
HSKA63-HC10-080	10137263	HSK-A63	10,0 *0.394*	80,0 *3.150*	54,05 *2.128*	35,0 *1.378*	42,5 *1.673*	50,0 *1.969*	30,0 *1.181*	111,9 *4.406*	39,0 *1.535*	49,0 *1.929*	M8x1	20,0	1	G2.5	1,0 *2.200*
HSKA63-HC12-085	10137264	HSK-A63	12,0 *0.472*	85,0 *3.346*	59,05 *2.325*	40,0 *1.575*	47,5 *1.870*	50,0 *1.969*	32,0 *1.260*	116,9 *4.602*	39,0 *1.535*	49,0 *1.929*	M10x1	20,0	1	G2.5	1,1 *2.430*
HSKA63-HC14-085	10137265	HSK-A63	14,0 *0.551*	85,0 *3.346*	59,05 *2.325*	40,0 *1.575*	47,5 *1.870*	50,0 *1.969*	34,0 *1.339*	116,9 *4.602*	39,0 *1.535*	49,0 *1.929*	M10x1	20,0	1	G2.5	1,1 *2.430*
HSKA63-HC16-090	10137266	HSK-A63	16,0 *0.630*	90,0 *3.543*	64,05 *2.522*	46,0 *1.811*	50,5 *1.988*	50,0 *1.969*	38,0 *1.496*	121,9 *4.799*	41,0 *1.614*	51,0 *2.008*	M12x1	20,0	1	G2.5	1,2 *2.650*
HSKA63-HC20-090	10137267	HSK-A63	20,0 *0.787*	90,0 *3.543*	64,05 *2.522*	48,0 *1.890*	52,5 *2.067*	50,0 *1.969*	42,0 *1.654*	121,9 *4.799*	39,0 *1.535*	49,0 *1.929*	M16x1	20,0	1	G2.5	1,2 *2.650*
HSKA63-HC25-120	10137268	HSK-A63	25,0 *0.984*	120,0 *4.724*	94,05 *3.703*	–	58,5 *2.303*	–	57,0 *2.244*	151,9 *5.980*	63,0 *2.480*	73,0 *2.874*	M16x1	–	1	G2.5	2,1 *4.630*
HSKA63-HC32-125	10137269	HSK-A63	32,0 *1.260*	125,0 *4.921*	99,05 *3.900*	82,8 *3.260*	62,5 *2.461*	50,0 *1.969*	62,0 *2.441*	156,9 *6.177*	64,0 *2.520*	74,0 *2.913*	M16x1	–	1	G2.5	2,3 *5.070*
HSKA100-HC12-095	10137270	HSK-A100	12,0 *0.472*	95,0 *3.740*	66,05 *2.600*	47,0 *1.850*	47,5 *1.870*	50,3 *1.978*	32,0 *1.260*	144,9 *5.705*	49,0 *1.929*	59,0 *2.323*	M10x1	20,0	1	G2.5	2,5 *5.510*
HSKA100-HC16-100	10137271	HSK-A100	16,0 *0.630*	100,0 *3.937*	71,05 *2.797*	53,0 *2.087*	50,5 *1.988*	50,3 *1.978*	38,0 *1.496*	149,9 *5.902*	51,0 *2.008*	61,0 *2.402*	M12x1	20,0	1	G2.5	2,6 *5.730*
HSKA100-HC20-105	10137272	HSK-A100	20,0 *0.787*	105,0 *4.134*	76,05 *2.994*	59,0 *2.323*	52,5 *2.067*	50,3 *1.978*	42,0 *1.654*	154,9 *6.098*	54,0 *2.126*	64,0 *2.520*	M16x1	20,0	1	G2.5	2,7 *5.950*
HSKA100-HC25-110	10137273	HSK-A100	25,0 *0.984*	110,0 *4.331*	81,05 *3.191*	62,0 *2.441*	58,5 *2.303*	63,3 *2.490*	57,0 *2.244*	159,9 *6.295*	53,0 *2.087*	63,0 *2.480*	M16x1	20,0	1	G2.5	3,4 *7.500*
HSKA100-HC32-110	10137274	HSK-A100	32,0 *1.260*	110,0 *4.331*	81,05 *3.191*	62,0 *2.441*	62,5 *2.461*	75,3 *2.963*	64,0 *2.520*	159,9 *6.295*	49,0 *1.929*	59,0 *2.323*	M16x1	20,0	1	G2.5	3,7 *8.160*

Accessories

For size	Key
HSKA63, DCBN = 6-20	H05-4
HSKA63, DCBN = 25-32	H06-4
HSKA100, DCBN = 12-20	H05-4
HSKA100, DCBN = 25-32	H06-4

HSK-A/ ISO12164-1-HSK-A

HCR – Hydraulic chucks, reinforced – Metric / *Inch*



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For HSK sealing plugs, coolant tubes and tube spanners, see page(s) 394
- For ISO attribute explanation, see page 14

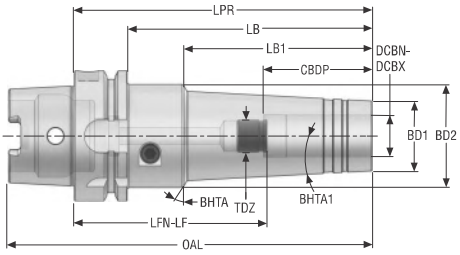
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
HSKA50-HCR20-094	10137148	HSK-A50	20,0 *0.787*	94,0 *3.701*	68,05 *2.679*	51,8 *2.039*	52,5 *2.067*	40,3 *1.585*	42,0 *1.654*	118,9 *4.681*	41,5 *1.634*	41,5 *1.634*	–	–	1	G2.5	1,0 *2.200*
HSKA63-HCR12-080	10137125	HSK-A63	12,0 *0.472*	80,0 *3.150*	54,05 *2.128*	36,5 *1.437*	47,5 *1.870*	52,5 *2.067*	42,0 *1.654*	111,9 *4.406*	34,0 *1.339*	44,0 *1.732*	M8x1	20,0	1	G2.5	1,3 *2.870*
HSKA63-HCR20-080	10137126	HSK-A63	20,0 *0.787*	80,0 *3.150*	54,05 *2.128*	–	52,5 *2.067*	–	52,5 *2.067*	111,9 *4.406*	29,0 *1.142*	39,0 *1.535*	M8x1	–	1	G2.5	1,3 *2.870*
HSKA100-HCR20-090	10137127	HSK-A100	20,0 *0.787*	90,0 *3.543*	61,05 *2.404*	–	52,5 *2.067*	–	52,5 *2.067*	139,9 *5.508*	39,0 *1.535*	49,0 *1.929*	M8x1	–	1	G2.5	2,8 *6.170*
HSKA100-HCR32-100	10137128	HSK-A100	32,0 *1.260*	100,0 *3.937*	71,05 *2.797*	–	62,5 *2.461*	–	72,0 *2.835*	149,9 *5.902*	39,0 *1.535*	49,0 *1.929*	M8x1	–	1	G2.5	3,7 *8.160*

Accessories

For	Key
HSKA50	H05-4
HSKA63	H05-4
HSKA100-HCR20	H05-4
HSKA100-HCR32	H06-4

HCS – Hydraulic chucks, slim – Metric / *Inch*

HSK-A/ ISO12164-1-HSK-A



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
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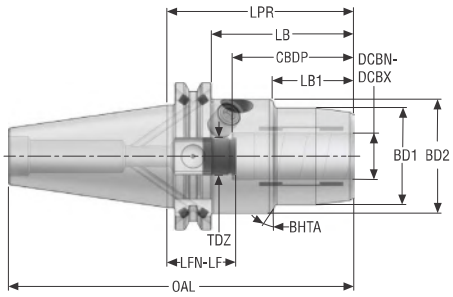
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	BHTA1°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*						kg *lbs*
HSKA63-HCS06-145	10137328	HSK-A63	6,0 *0.236*	145,0 *5.709*	119,0 *4.685*	90,0 *3.543*	37,0 *1.457*	50,0 *1.969*	20,0 *0.787*	177,0 *6.969*	108,0 *4.252*	118,0 *4.646*	M5x0.8	30,0	3,0	1	G2.5	1,5 *3.310*
HSKA63-HCS08-145	10137329	HSK-A63	8,0 *0.315*	145,0 *5.709*	119,0 *4.685*	90,0 *3.543*	37,0 *1.457*	50,0 *1.969*	22,0 *0.866*	177,0 *6.969*	108,0 *4.252*	118,0 *4.646*	M6x1	30,0	3,0	1	G2.5	1,5 *3.310*
HSKA63-HCS10-145	10137330	HSK-A63	10,0 *0.394*	145,0 *5.709*	119,0 *4.685*	90,0 *3.543*	42,0 *1.654*	50,0 *1.969*	24,0 *0.945*	177,0 *6.969*	103,0 *4.055*	113,0 *4.449*	M8x1	30,0	3,0	1	G2.5	1,5 *3.310*
HSKA63-HCS12-145	10137331	HSK-A63	12,0 *0.472*	145,0 *5.709*	119,0 *4.685*	90,0 *3.543*	49,0 *1.929*	50,0 *1.969*	25,0 *0.984*	177,0 *6.969*	98,0 *3.858*	108,0 *4.252*	M10x1	30,0	3,0	1	G2.5	1,6 *3.530*
HSKA63-HCS16-145	10137332	HSK-A63	16,0 *0.630*	145,0 *5.709*	119,0 *4.685*	90,0 *3.543*	51,0 *2.008*	50,0 *1.969*	32,0 *1.260*	177,0 *6.969*	93,0 *3.661*	103,0 *4.055*	M12x1	30,0	3,0	1	G2.5	1,8 *3.970*
HSKA63-HCS20-145	10137333	HSK-A63	20,0 *0.787*	145,0 *5.709*	119,0 *4.685*	90,0 *3.543*	53,0 *2.087*	50,0 *1.969*	34,0 *1.339*	177,0 *6.969*	93,0 *3.661*	103,0 *4.055*	M16x1	30,0	3,0	1	G2.5	1,9 *4.190*
HSKA100-HCS06-150	10137334	HSK-A100	6,0 *0.236*	150,0 *5.906*	121,0 *4.764*	90,0 *3.543*	37,0 *1.457*	50,0 *1.969*	20,0 *0.787*	200,0 *7.874*	113,0 *4.449*	123,0 *4.843*	M5x0.8	30,0	3,0	1	G2.5	3,0 *6.610*
HSKA100-HCS08-150	10137335	HSK-A100	8,0 *0.315*	150,0 *5.906*	121,0 *4.764*	90,0 *3.543*	37,0 *1.457*	50,0 *1.969*	22,0 *0.866*	200,0 *7.874*	113,0 *4.449*	123,0 *4.843*	M6x1	30,0	3,0	1	G2.5	3,1 *6.830*
HSKA100-HCS10-150	10137336	HSK-A100	10,0 *0.394*	150,0 *5.906*	121,0 *4.764*	90,0 *3.543*	42,5 *1.673*	50,0 *1.969*	24,0 *0.945*	200,0 *7.874*	108,0 *4.252*	118,0 *4.646*	M8x1	30,0	3,0	1	G2.5	3,1 *6.830*
HSKA100-HCS12-150	10137337	HSK-A100	12,0 *0.472*	150,0 *5.906*	121,0 *4.764*	90,0 *3.543*	48,0 *1.890*	50,0 *1.969*	25,0 *0.984*	200,0 *7.874*	103,0 *4.055*	113,0 *4.449*	M10x1	30,0	3,0	1	G2.5	3,1 *6.830*
HSKA100-HCS16-150	10137338	HSK-A100	16,0 *0.630*	150,0 *5.906*	121,0 *4.764*	90,0 *3.543*	52,0 *2.047*	50,0 *1.969*	32,0 *1.260*	200,0 *7.874*	98,0 *3.858*	108,0 *4.252*	M12x1	30,0	3,0	1	G2.5	3,4 *7.500*
HSKA100-HCS20-150	10137339	HSK-A100	20,0 *0.787*	150,0 *5.906*	121,0 *4.764*	90,0 *3.543*	52,0 *2.047*	50,0 *1.969*	34,0 *1.339*	200,0 *7.874*	100,0 *3.937*	110,0 *4.331*	M16x1	30,0	3,0	1	G2.5	3,4 *7.500*

Accessories

For	Key
All	H05-4

HC – Hydraulic chucks, standard – Metric / *Inch*

DIN 69871-ADB



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

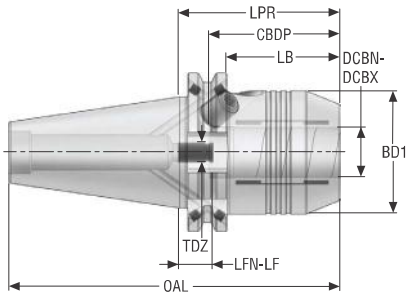
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
DIN40ADB-HC06-080	10137275	DIN40 ADB	6,0 *0.236*	80,5 *3.169*	61,45 *2.419*	29,5 *1.161*	38,5 *1.516*	49,3 *1.939*	26,0 *1.024*	148,75 *5.856*	43,5 *1.713*	53,5 *2.106*	M5	20,0	1	G2.5	1,3 *2.870*
DIN40ADB-HC08-080	10137276	DIN40 ADB	8,0 *0.315*	80,5 *3.169*	61,45 *2.419*	30,0 *1.181*	38,5 *1.516*	49,3 *1.939*	28,0 *1.102*	148,75 *5.856*	43,5 *1.713*	53,5 *2.106*	M6	20,0	1	G2.5	1,3 *2.870*
DIN40ADB-HC10-080	10137277	DIN40 ADB	10,0 *0.394*	80,5 *3.169*	61,45 *2.419*	31,0 *1.220*	42,5 *1.673*	49,3 *1.939*	30,0 *1.181*	148,75 *5.856*	39,5 *1.555*	49,5 *1.949*	M8x1	20,0	1	G2.5	1,3 *2.870*
DIN40ADB-HC12-080	10137278	DIN40 ADB	12,0 *0.472*	80,5 *3.169*	61,45 *2.419*	31,5 *1.240*	47,5 *1.870*	49,3 *1.939*	32,0 *1.260*	148,75 *5.856*	34,5 *1.358*	44,5 *1.752*	M10x1	20,0	1	G2.5	1,3 *2.870*
DIN40ADB-HC16-080	10137279	DIN40 ADB	16,0 *0.630*	80,5 *3.169*	61,45 *2.419*	33,0 *1.299*	50,5 *1.988*	49,3 *1.939*	38,0 *1.496*	148,75 *5.856*	31,5 *1.240*	41,5 *1.634*	M12x1	20,0	1	G2.5	1,4 *3.090*
DIN40ADB-HC20-080	10138581	DIN40 ADB	20,0 *0.787*	80,5 *3.169*	61,45 *2.419*	34,0 *1.339*	52,5 *2.067*	49,3 *1.939*	42,0 *1.654*	148,75 *5.856*	29,5 *1.161*	39,5 *1.555*	M16x1	20,0	1	G2.5	1,4 *3.090*
DIN50ADB-HC12-080	10137280	DIN50 ADB	12,0 *0.472*	80,5 *3.169*	61,45 *2.419*	31,5 *1.240*	47,5 *1.870*	49,3 *1.939*	32,0 *1.260*	182,1 *7.169*	34,5 *1.358*	44,5 *1.752*	M10x1	20,0	1	G2.5	3,0 *6.610*
DIN50ADB-HC20-080	10138582	DIN50 ADB	20,0 *0.787*	80,5 *3.169*	61,45 *2.419*	34,0 *1.339*	52,5 *2.067*	49,3 *1.939*	42,0 *1.654*	182,1 *7.169*	29,5 *1.161*	39,5 *1.555*	M16x1	20,0	1	G2.5	3,2 *7.050*
DIN50ADB-HC32-103	10138583	DIN50 ADB	32,0 *1.260*	103,2 *4.063*	84,15 *3.313*	62,5 *2.461*	62,5 *2.461*	70,3 *2.766*	64,0 *2.520*	204,8 *8.063*	42,2 *1.661*	52,2 *2.055*	M16x1	20,0	1	G2.5	4,3 *9.480*

Accessories

For	Key
DIN40	H05-4
DIN50, DCBN = 12-20	H05-4
DIN50, DCBN = 32	H06-4

DIN 69871-ADB

HCR – Hydraulic chucks, reinforced – Metric / *Inch*



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

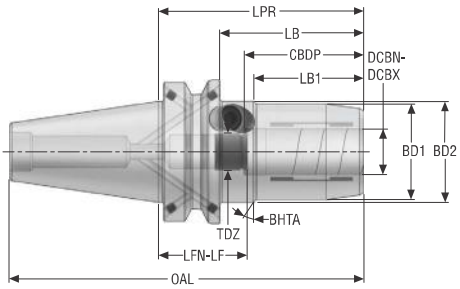
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
DIN40ADB-HCR12-050	10137129	DIN40 ADB	12,0 *0.472*	50,0 *1.969*	31,0 *1.220*	–	47,5 *1.870*	–	42,0 *1.654*	118,25 *4.656*	4,0 *0.157*	14,0 *0.551*	M8x1	–	0	G2.5	1,1 *2.430*
DIN40ADB-HCR20-064	10137130	DIN40 ADB	20,0 *0.787*	64,5 *2.539*	45,45 *1.789*	–	52,5 *2.067*	–	49,25 *1.939*	132,75 *5.226*	13,5 *0.531*	23,5 *0.925*	M8x1	–	0	G2.5	1,1 *2.430*
DIN50ADB-HCR20-064	10137131	DIN50 ADB	20,0 *0.787*	64,5 *2.539*	45,5 *1.791*	–	52,5 *2.067*	–	49,25 *1.939*	166,0 *6.535*	13,5 *0.531*	23,5 *0.925*	M8x1	–	0	G2.5	3,1 *6.830*
DIN50ADB-HCR32-081	10137132	DIN50 ADB	32,0 *1.260*	81,0 *3.189*	61,95 *2.439*	–	62,5 *2.461*	–	72,0 *2.835*	182,6 *7.189*	20,0 *0.787*	30,0 *1.181*	M8x1	–	0	G2.5	4,1 *9.040*

Accessories

For size	Key
DIN40	H05-4
DIN50, DCBN = 20	H05-4
DIN50, DCBN = 32	H06-4

HC – Hydraulic chucks, standard – Metric / *Inch*

BT JIS B 6339-ADB



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

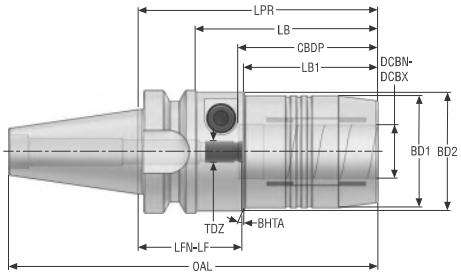
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balancing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
BT40ADB-HC06-090	10137297	BT40 ADB	6,0 *0.236*	90,0 *3.543*	63,0 *2.480*	43,0 *1.693*	38,5 *1.516*	44,5 *1.752*	26,05 *1.026*	155,4 *6.118*	53,0 *2.087*	63,0 *2.480*	M5	20,0	1	G2.5	1,3 *2.870*
BT40ADB-HC08-090	10137298	BT40 ADB	8,0 *0.315*	90,0 *3.543*	63,0 *2.480*	44,5 *1.752*	38,5 *1.516*	44,5 *1.752*	28,0 *1.102*	155,4 *6.118*	53,0 *2.087*	63,0 *2.480*	M6x1	20,0	1	G2.5	1,4 *3.090*
BT40ADB-HC10-090	10137299	BT40 ADB	10,0 *0.394*	90,0 *3.543*	63,0 *2.480*	44,5 *1.752*	42,5 *1.673*	44,5 *1.752*	30,0 *1.181*	155,4 *6.118*	49,0 *1.929*	59,0 *2.323*	M8x1	20,0	1	G2.5	1,4 *3.090*
BT40ADB-HC12-090	10137300	BT40 ADB	12,0 *0.472*	90,0 *3.543*	63,0 *2.480*	44,5 *1.752*	47,5 *1.870*	44,5 *1.752*	32,0 *1.260*	155,4 *6.118*	44,0 *1.732*	54,0 *2.126*	M10x1	20,0	1	G2.5	1,4 *3.090*
BT40ADB-HC16-090	10137301	BT40 ADB	16,0 *0.630*	90,0 *3.543*	63,0 *2.480*	47,5 *1.870*	50,5 *1.988*	44,5 *1.752*	38,0 *1.496*	155,4 *6.118*	41,0 *1.614*	51,0 *2.008*	M12x1	20,0	1	G2.5	1,4 *3.090*
BT40ADB-HC20-090	10137302	BT40 ADB	20,0 *0.787*	90,0 *3.543*	63,0 *2.480*	47,5 *1.870*	52,5 *2.067*	44,5 *1.752*	42,0 *1.654*	155,4 *6.118*	39,0 *1.535*	49,0 *1.929*	M16x1	20,0	1	G2.5	1,5 *3.310*
BT50ADB-HC20-090	10137303	BT50 ADB	20,0 *0.787*	90,0 *3.543*	52,0 *2.047*	34,0 *1.339*	52,5 *2.067*	49,3 *1.939*	42,0 *1.654*	191,8 *7.551*	39,0 *1.535*	49,0 *1.929*	M16x1	20,0	1	G2.5	3,9 *8.600*
BT50ADB-HC32-120	10137304	BT50 ADB	32,0 *1.260*	120,0 *4.724*	82,0 *3.228*	62,5 *2.461*	62,5 *2.461*	70,3 *2.766*	64,0 *2.520*	221,8 *8.732*	59,0 *2.323*	69,0 *2.717*	M16x1	20,0	1	G2.5	5,1 *11.240*

Accessories

For size	Key
BT40, DCBN = 6	H05-4
BT40, DCBN = 8-20	H05-4
BT50, DCBN = 20	H05-4
BT50, DCBN = 32	H06-4

BT JIS B 6339-ADB

HCR – Hydraulic chucks, reinforced – **Metric** / *Inch*



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

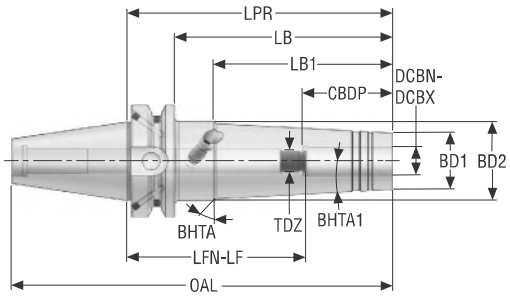
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
BT30ADB-HCR12-069	10137136	BT30 ADB	12,0 *0.472*	69,0 *2.717*	47,0 *1.850*	32,0 *1.260*	47,5 *1.870*	44,5 *1.752*	42,0 *1.654*	117,4 *4.622*	23,0 *0.906*	33,0 *1.299*	M8x1	20,0	0	G2.5	0,9 *1.980*
BT30ADB-HCR20-090	10137137	BT30 ADB	20,0 *0.787*	90,0 *3.543*	68,0 *2.677*	50,0 *1.969*	52,5 *2.067*	44,5 *1.752*	42,0 *1.654*	138,4 *5.449*	39,0 *1.535*	49,0 *1.929*	M8x1	20,0	0	G2.5	1,0 *2.200*
BT40ADB-HCR12-058	10137140	BT40 ADB	12,0 *0.472*	58,0 *2.283*	31,0 *1.220*	–	47,5 *1.870*	–	42,0 *1.654*	123,4 *4.858*	12,0 *0.472*	22,0 *0.866*	M8x1	–	0	G2.5	1,2 *2.650*
BT40ADB-HCR20-072	10137141	BT40 ADB	20,0 *0.787*	72,5 *2.854*	45,5 *1.791*	–	52,5 *2.067*	–	49,25 *1.939*	137,9 *5.429*	21,5 *0.846*	31,5 *1.240*	M8x1	–	0	G2.5	1,4 *3.090*
BT50ADB-HCR20-083	10137144	BT50 ADB	20,0 *0.787*	83,5 *3.287*	45,5 *1.791*	–	52,5 *2.067*	–	49,25 *1.939*	185,3 *7.295*	32,5 *1.280*	42,5 *1.673*	M8x1	–	0	G2.5	4,1 *9.040*
BT50ADB-HCR32-090	10137145	BT50 ADB	32,0 *1.260*	90,0 *3.543*	52,0 *2.047*	–	62,5 *2.461*	–	72,0 *2.835*	191,8 *7.551*	29,0 *1.142*	39,0 *1.535*	M8x1	–	0	G2.5	4,7 *10.360*

Accessories

For size	Key
BT30	H05-4
BT40	H05-4
BT50, DCBN = 20	H05-4
BT50, DCBN = 32	H06-4

HCS – Hydraulic chucks, slim – Metric / *Inch*

BT JIS B 6339-ADB



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

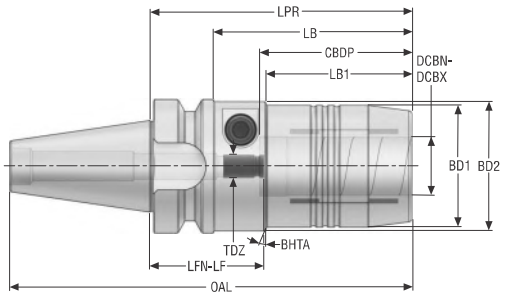
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	BHTA1°	RFID hole	Balancing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*						kg *lbs*
BT40ADB-HCS06-150	10137340	BT40 ADB	6,0 *0.236*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	37,0 *1.457*	44,5 *1.752*	20,0 *0.787*	215,4 *8.480*	113,0 *4.449*	123,0 *4.843*	M5x0.8	30,0	3,0	1	G2.5	1,7 *3.750*
BT40ADB-HCS08-150	10137341	BT40 ADB	8,0 *0.315*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	37,0 *1.457*	44,5 *1.752*	22,0 *0.866*	215,4 *8.480*	113,0 *4.449*	123,0 *4.843*	M6x1	30,0	3,0	1	G2.5	1,8 *3.970*
BT40ADB-HCS10-150	10137342	BT40 ADB	10,0 *0.394*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	42,0 *1.654*	44,5 *1.752*	24,0 *0.945*	215,4 *8.480*	110,0 *4.331*	120,0 *4.724*	M8x1	30,0	3,0	1	G2.5	1,8 *3.970*
BT40ADB-HCS12-150	10137343	BT40 ADB	12,0 *0.472*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	47,0 *1.850*	44,5 *1.752*	25,0 *0.984*	215,4 *8.480*	105,0 *4.134*	115,0 *4.528*	M10x1	30,0	3,0	1	G2.5	1,8 *3.970*
BT40ADB-HCS16-150	10137344	BT40 ADB	16,0 *0.630*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	52,0 *2.047*	44,5 *1.752*	32,0 *1.260*	215,4 *8.480*	100,0 *3.937*	110,0 *4.331*	M12x1	30,0	3,0	1	G2.5	2,0 *4.410*
BT40ADB-HCS20-150	10137345	BT40 ADB	20,0 *0.787*	150,0 *5.906*	123,0 *4.843*	–	52,0 *2.047*	46,9 *1.846*	34,0 *1.339*	215,4 *8.480*	100,0 *3.937*	110,0 *4.331*	M16x1	–	3,0	1	G2.5	2,1 *4.630*

Accessories

For size	Key
All	H04-4

BT Taper-Face-ADB

HCR – Hydraulic chucks, reinforced – Metric / *Inch*



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

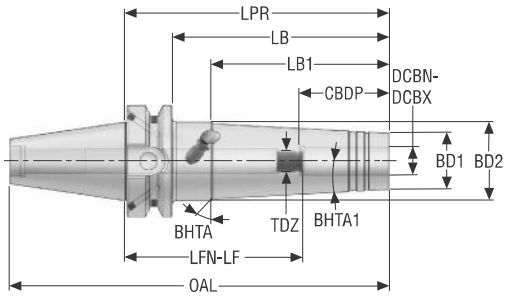
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
BT30TFADB-HCR12-069	10137138	BT30 TF ADB	12,0 *0.472*	69,0 *2.717*	47,0 *1.850*	32,0 *1.260*	47,5 *1.870*	44,5 *1.752*	42,0 *1.654*	117,4 *4.622*	23,0 *0.906*	33,0 *1.299*	M8x1	20,0	0	G2.5	0,9 *1.980*
BT30TFADB-HCR20-090	10137139	BT30 TF ADB	20,0 *0.787*	90,0 *3.543*	68,0 *2.677*	50,0 *1.969*	52,5 *2.067*	44,5 *1.752*	42,0 *1.654*	138,4 *5.449*	39,0 *1.535*	49,0 *1.929*	M8x1	20,0	0	G2.5	1,0 *2.200*
BT40TFADB-HCR12-058	10137142	BT40 TF ADB	12,0 *0.472*	58,0 *2.283*	31,0 *1.220*	–	47,5 *1.870*	–	42,0 *1.654*	123,4 *4.858*	12,0 *0.472*	22,0 *0.866*	M8x1	–	0	G2.5	1,2 *2.650*
BT40TFADB-HCR20-072	10137143	BT40 TF ADB	20,0 *0.787*	72,5 *2.854*	45,5 *1.791*	–	52,5 *2.067*	–	49,25 *1.939*	137,9 *5.429*	21,5 *0.846*	31,5 *1.240*	M8x1	–	0	G2.5	1,4 *3.090*

Accessories

For size	Key
All	H05-4

HCS – Hydraulic chucks, slim – Metric / *Inch*

BT Taper-Face-ADB



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

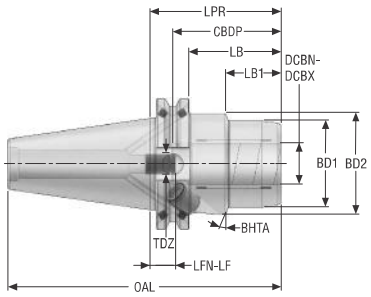
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	BHTA1°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*						kg *lbs*
BT40TFADB-HCS06-150	10137346	BT40 TF ADB	6,0 *0.236*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	37,0 *1.457*	44,5 *1.752*	20,0 *0.787*	215,4 *8.480*	113,0 *4.449*	123,0 *4.843*	M5x0.8	30,0	3,0	1	G2.5	1,6 *3.530*
BT40TFADB-HCS08-150	10137347	BT40 TF ADB	8,0 *0.315*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	37,0 *1.457*	44,5 *1.752*	22,0 *0.866*	215,4 *8.480*	113,0 *4.449*	123,0 *4.843*	M6x1	30,0	3,0	1	G2.5	1,7 *3.750*
BT40TFADB-HCS10-150	10137348	BT40 TF ADB	10,0 *0.394*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	42,0 *1.654*	44,5 *1.752*	24,0 *0.945*	215,4 *8.480*	110,0 *4.331*	120,0 *4.724*	M8x1	30,0	3,0	1	G2.5	1,7 *3.750*
BT40TFADB-HCS12-150	10137349	BT40 TF ADB	12,0 *0.472*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	47,0 *1.850*	44,5 *1.752*	25,0 *0.984*	215,4 *8.480*	103,0 *4.055*	113,0 *4.449*	M10x1	30,0	3,0	1	G2.5	1,8 *3.970*
BT40TFADB-HCS16-150	10137350	BT40 TF ADB	16,0 *0.630*	150,0 *5.906*	123,0 *4.843*	100,0 *3.937*	52,0 *2.047*	44,5 *1.752*	32,0 *1.260*	215,4 *8.480*	100,0 *3.937*	110,0 *4.331*	M12x1	30,0	3,0	1	G2.5	2,0 *4.410*
BT40TFADB-HCS20-150	10137351	BT40 TF ADB	20,0 *0.787*	150,0 *5.906*	123,0 *4.843*	–	52,0 *2.047*	46,9 *1.846*	34,0 *1.339*	215,4 *8.480*	100,0 *3.937*	110,0 *4.331*	M16x1	–	3,0	1	G2.5	2,1 *4.630*

Accessories

For size	Key
All	H04-4

HC – Hydraulic chucks, standard – Metric / *Inch*

CAT / ASME B5.50-1994-ADB



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

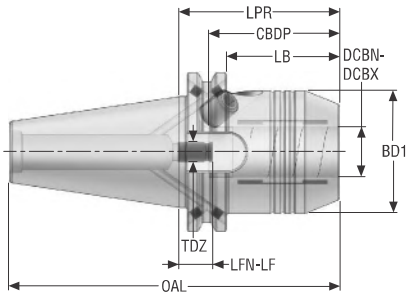
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
CAT40ADB-HC06-063	10137281	CAT40 ADB	6,0 *0.236*	63,5 *2.500*	44,45 *1.750*	24,56 *0.967*	38,5 *1.516*	44,5 *1.750*	26,0 *1.024*	131,75 *5.187*	26,5 *1.043*	36,5 *1.437*	M5	20,0	1	G2.5	1,1 *2.430*
CAT40ADB-HC08-063	10137282	CAT40 ADB	8,0 *0.315*	63,5 *2.500*	44,45 *1.750*	25,56 *1.006*	38,5 *1.516*	49,0 *1.929*	28,0 *1.102*	131,75 *5.187*	26,5 *1.043*	36,5 *1.437*	M5	20,0	1	G2.5	1,2 *2.650*
CAT40ADB-HC10-063	10137283	CAT40 ADB	10,0 *0.394*	63,5 *2.500*	44,45 *1.750*	27,56 *1.085*	42,5 *1.673*	49,0 *1.929*	30,0 *1.181*	131,75 *5.187*	22,5 *0.886*	32,5 *1.280*	M5	20,0	1	G2.5	1,2 *2.650*
CAT40ADB-HC12-063	10137284	CAT40 ADB	12,0 *0.472*	63,5 *2.500*	44,45 *1.750*	26,56 *1.046*	47,5 *1.870*	49,0 *1.929*	32,0 *1.260*	131,75 *5.187*	17,5 *0.689*	27,5 *1.083*	M10x1	20,0	1	G2.5	1,2 *2.650*
CAT40ADB-HC16-063	10137285	CAT40 ADB	16,0 *0.630*	63,5 *2.500*	44,45 *1.750*	27,56 *1.085*	51,0 *2.008*	49,0 *1.929*	38,0 *1.496*	131,75 *5.187*	14,5 *0.571*	24,5 *0.965*	M10x1	20,0	1	G2.5	1,2 *2.650*
CAT40ADB-HC20-063	10137286	CAT40 ADB	20,0 *0.787*	63,5 *2.500*	44,45 *1.750*	25,56 *1.006*	52,5 *2.067*	49,0 *1.929*	42,0 *1.654*	131,75 *5.187*	12,5 *0.492*	22,5 *0.886*	M10x1	20,0	1	G2.5	1,2 *2.650*
CAT50ADB-HC12-081	10137293	CAT50 ADB	12,0 *0.472*	81,0 *3.189*	61,95 *2.439*	40,0 *1.575*	47,5 *1.870*	49,0 *1.929*	32,0 *1.260*	182,6 *7.189*	35,0 *1.378*	45,0 *1.772*	M10x1	20,0	1	G2.5	3,1 *6.830*
CAT50ADB-HC20-081	10137294	CAT50 ADB	20,0 *0.787*	81,0 *3.189*	61,95 *2.439*	46,0 *1.811*	52,5 *2.067*	51,0 *2.008*	42,0 *1.654*	182,6 *7.189*	30,0 *1.181*	40,0 *1.575*	M10x1	20,0	1	G2.5	3,1 *6.830*
CAT50ADB-HC25-081	10137295	CAT50 ADB	25,0 *0.984*	81,0 *3.189*	61,95 *2.439*	36,0 *1.417*	58,5 *2.303*	68,0 *2.677*	48,0 *1.890*	182,6 *7.189*	24,0 *0.945*	34,0 *1.339*	M10x1	20,0	1	G2.5	3,6 *7.940*
CAT50ADB-HC32-081	10137296	CAT50 ADB	32,0 *1.260*	81,0 *3.189*	61,95 *2.439*	40,0 *1.575*	62,5 *2.461*	75,0 *2.953*	62,0 *2.441*	182,6 *7.189*	20,0 *0.787*	30,0 *1.181*	M10x1	20,0	1	G2.5	3,8 *8.380*

Accessories

For size	Key
CAT40	H05-4
CAT50, DCBN = 12-25	H05-4
CAT50, DCBN = 32	H06-4

CAT / ASME B5.50-1994-ADB

HCR – Hydraulic chucks, reinforced – Metric / *Inch*



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

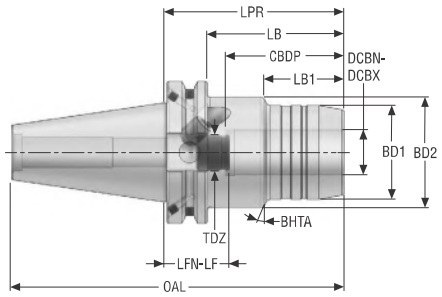
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
CAT40ADB-HCR20-064	10137133	CAT40 ADB	20,0 *0.787*	64,5 *2.539*	45,45 *1.789*	–	52,5 *2.067*	–	49,25 *1.939*	132,75 *5.226*	13,5 *0.531*	23,5 *0.925*	M8x1	–	0	G2.5	1,3 *2.870*
CAT50ADB-HCR32-081	10137135	CAT50 ADB	32,0 *1.260*	81,0 *3.189*	61,95 *2.439*	–	62,5 *2.461*	–	72,0 *2.835*	182,6 *7.189*	20,0 *0.787*	30,0 *1.181*	M8x1	–	0	G2.5	4,0 *8.820*

Accessories

For size	Key
CAT40	H05-4
CAT50	H06-4

HC – Hydraulic chucks, standard – Metric / *Inch*

CAT TF / ASME B5.50-2009-ADB



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

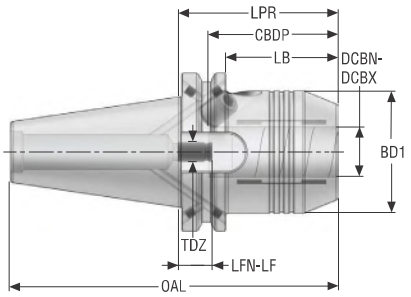
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balancing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
CAT40TFADB-HC06-080	10137287	CAT40 TF ADB	6,0 *0.236*	80,0 *3.150*	60,95 *2.400*	29,5 *1.161*	37,0 *1.457*	49,5 *1.949*	26,0 *1.024*	148,25 *5.837*	43,0 *1.693*	53,0 *2.087*	M5x0.8	30,0	1	G2.5	1,5 *3.310*
CAT40TFADB-HC08-080	10137288	CAT40 TF ADB	8,0 *0.315*	80,0 *3.150*	60,95 *2.400*	30,0 *1.181*	37,0 *1.457*	49,5 *1.949*	28,0 *1.102*	148,25 *5.837*	43,0 *1.693*	53,0 *2.087*	M6x1	30,0	1	G2.5	1,4 *3.090*
CAT40TFADB-HC10-080	10137289	CAT40 TF ADB	10,0 *0.394*	80,0 *3.150*	60,95 *2.400*	31,0 *1.220*	42,0 *1.654*	49,5 *1.949*	30,0 *1.181*	148,25 *5.837*	40,0 *1.575*	50,0 *1.969*	M8x1	30,0	1	G2.5	1,4 *3.090*
CAT40TFADB-HC12-080	10137290	CAT40 TF ADB	12,0 *0.472*	80,0 *3.150*	60,95 *2.400*	31,5 *1.240*	47,0 *1.850*	49,5 *1.949*	32,0 *1.260*	148,25 *5.837*	35,0 *1.378*	45,0 *1.772*	M10x1	30,0	1	G2.5	1,5 *3.310*
CAT40TFADB-HC16-080	10137291	CAT40 TF ADB	16,0 *0.630*	80,0 *3.150*	60,95 *2.400*	33,0 *1.299*	52,0 *2.047*	49,5 *1.949*	38,0 *1.496*	148,25 *5.837*	30,0 *1.181*	40,0 *1.575*	M12x1	30,0	1	G2.5	1,5 *3.310*
CAT40TFADB-HC20-080	10137292	CAT40 TF ADB	20,0 *0.787*	80,0 *3.150*	60,95 *2.400*	34,0 *1.339*	52,0 *2.047*	49,5 *1.949*	42,0 *1.654*	148,25 *5.837*	30,0 *1.181*	40,0 *1.575*	M16x1	30,0	1	G2.5	1,5 *3.310*

Accessories

For size	Key
All	H05-4

CAT TF / ASME B5.50-2009-ADB

HCR – Hydraulic chucks, reinforced – Metric / *Inch*



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

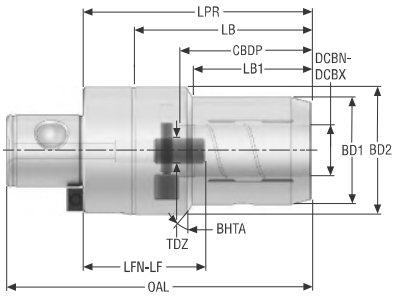
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
CAT40TFADB-HCR20-064	10137134	CAT40 TF ADB	20,0 *0.787*	64,5 *2.539*	45,45 *1.789*	–	52,5 *2.067*	–	49,25 *1.939*	132,75 *5.226*	13,5 *0.531*	23,5 *0.925*	M8x1	–	0	G2.5	1,3 *2.870*

Accessories

For size	Key
All	H05-4

Graflex®

HC – Hydraulic chucks, standard – Metric / *Inch*



- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

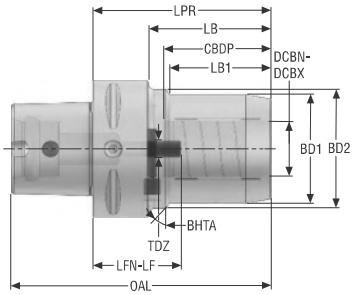
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
G5-HC20-090	10137322	G5	20,0 *0.787*	90,0 *3.543*	70,0 *2.756*	47,0 *1.850*	52,0 *2.047*	50,0 *1.969*	42,0 *1.654*	120,0 *4.724*	38,0 *1.496*	48,0 *1.890*	M10x1.5	30,0	0	PB	1,2 *2.650*
G6-HC25-100	10137323	G6	25,0 *0.984*	100,0 *3.937*	74,0 *2.913*	50,0 *1.969*	58,0 *2.283*	63,0 *2.480*	58,0 *2.283*	140,0 *5.512*	42,0 *1.654*	52,0 *2.047*	M10x1.5	45,0	0	PB	2,3 *5.070*
G6-HC32-100	10137324	G6	32,0 *1.260*	100,0 *3.937*	74,0 *2.913*	–	63,0 *2.480*	–	64,0 *2.520*	140,0 *5.512*	37,0 *1.457*	62,0 *2.441*	–	–	0	PB	2,3 *5.070*

Accessories

For size	Key
All	H04-4

Seco-Capto™

HC – Hydraulic chucks, standard – Metric / *Inch*



- Run-out ≤3 µm
- For ISO attribute explanation, see page 14

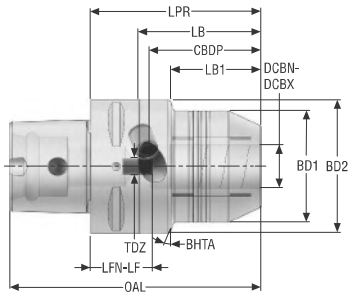
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
C5-HC06-065	10137305	C5	6,0 *0.236*	65,0 *2.559*	45,0 *1.772*	23,0 *0.906*	38,0 *1.496*	50,0 *1.969*	26,0 *1.024*	95,0 *3.740*	27,0 *1.063*	37,0 *1.457*	M5x0.8	30,0	1	–	0,8 *1.760*
C5-HC08-065	10137306	C5	8,0 *0.315*	65,0 *2.559*	45,0 *1.772*	24,0 *0.945*	38,0 *1.496*	50,0 *1.969*	28,0 *1.102*	95,0 *3.740*	27,0 *1.063*	37,0 *1.457*	M5x0.8	30,0	1	–	0,8 *1.760*
C5-HC10-075	10137307	C5	10,0 *0.394*	75,0 *2.953*	55,0 *2.165*	34,0 *1.339*	42,0 *1.654*	50,0 *1.969*	30,0 *1.181*	105,0 *4.134*	33,0 *1.299*	43,0 *1.693*	M8x1.25	30,0	1	–	0,9 *1.980*
C5-HC12-080	10137308	C5	12,0 *0.472*	80,0 *3.150*	60,0 *2.362*	40,0 *1.575*	47,0 *1.850*	50,0 *1.969*	32,0 *1.260*	110,0 *4.331*	33,0 *1.299*	43,0 *1.693*	M10x1.5	30,0	1	–	0,9 *1.980*
C5-HC16-085	10137309	C5	16,0 *0.630*	85,0 *3.346*	65,0 *2.559*	46,0 *1.811*	50,0 *1.969*	50,0 *1.969*	38,0 *1.496*	115,0 *4.528*	35,0 *1.378*	45,0 *1.772*	M10x1.5	30,0	1	–	1,0 *2.200*
C5-HC20-085	10137310	C5	20,0 *0.787*	85,0 *3.346*	65,0 *2.559*	47,0 *1.850*	52,0 *2.047*	50,0 *1.969*	42,0 *1.654*	115,0 *4.528*	33,0 *1.299*	43,0 *1.693*	M10x1.5	30,0	1	–	1,1 *2.430*
C5-HC25-095	10137311	C5	25,0 *0.984*	95,0 *3.740*	75,0 *2.953*	–	58,0 *2.283*	–	58,0 *2.283*	125,0 *4.921*	37,0 *1.457*	47,0 *1.850*	M10x1.5	–	1	–	1,7 *3.750*
C6-HC06-065	10137312	C6	6,0 *0.236*	65,0 *2.559*	40,0 *1.575*	23,0 *0.906*	38,0 *1.496*	50,0 *1.969*	26,0 *1.024*	103,0 *4.055*	27,0 *1.063*	37,0 *1.457*	M5x0.8	30,0	1	–	1,2 *2.650*
C6-HC08-065	10137313	C6	8,0 *0.315*	65,0 *2.559*	40,0 *1.575*	24,0 *0.945*	38,0 *1.496*	50,0 *1.969*	28,0 *1.102*	103,0 *4.055*	27,0 *1.063*	37,0 *1.457*	M5x0.8	30,0	1	–	1,2 *2.650*
C6-HC10-075	10137314	C6	10,0 *0.394*	75,0 *2.953*	50,0 *1.969*	34,0 *1.339*	42,0 *1.654*	50,0 *1.969*	30,0 *1.181*	113,0 *4.449*	33,0 *1.299*	43,0 *1.693*	M8x1.25	30,0	1	–	1,2 *2.650*
C6-HC12-080	10137315	C6	12,0 *0.472*	80,0 *3.150*	55,0 *2.165*	40,0 *1.575*	47,0 *1.850*	50,0 *1.969*	32,0 *1.260*	118,0 *4.646*	33,0 *1.299*	43,0 *1.693*	M10x1.5	30,0	1	–	1,3 *2.870*
C6-HC16-085	10137316	C6	16,0 *0.630*	85,0 *3.346*	60,0 *2.362*	46,0 *1.811*	50,0 *1.969*	50,0 *1.969*	38,0 *1.496*	123,0 *4.843*	35,0 *1.378*	45,0 *1.772*	M10x1.5	30,0	1	–	1,4 *3.090*
C6-HC20-085	10137317	C6	20,0 *0.787*	85,0 *3.346*	60,0 *2.362*	47,0 *1.850*	52,0 *2.047*	50,0 *1.969*	42,0 *1.654*	123,0 *4.843*	33,0 *1.299*	43,0 *1.693*	M10x1.5	30,0	1	–	1,4 *3.090*
C6-HC25-095	10137318	C6	25,0 *0.984*	95,0 *3.740*	70,0 *2.756*	–	58,0 *2.283*	–	58,0 *2.283*	133,0 *5.236*	37,0 *1.457*	47,0 *1.850*	–	–	1	–	2,0 *4.410*
C6-HC32-100	10137319	C6	32,0 *1.260*	100,0 *3.937*	78,0 *3.071*	–	63,0 *2.480*	–	64,0 *2.520*	138,0 *5.433*	37,0 *1.457*	47,0 *1.850*	M10x1.5	–	1	–	2,3 *5.070*
C8-HC20-095	10137320	C8	20,0 *0.787*	95,0 *3.740*	62,0 *2.441*	47,0 *1.850*	52,0 *2.047*	50,0 *1.969*	42,0 *1.654*	143,0 *5.630*	43,0 *1.693*	53,0 *2.087*	M10x1.5	30,0	1	–	2,4 *5.290*
C8-HC32-105	10137321	C8	32,0 *1.260*	105,0 *4.134*	72,0 *2.835*	60,0 *2.362*	63,0 *2.480*	70,0 *2.756*	64,0 *2.520*	153,0 *6.024*	42,0 *1.654*	52,0 *2.047*	M10x1.5	30,0	1	G6.3	3,2 *7.050*

Accessories

For size	Key
All	H04-4

HCR – Hydraulic chucks, reinforced – Metric / *Inch*

Seco-Capto™



- Run-out ≤3 µm
- For reduction sleeves, see page(s) 405, 406
- For ISO attribute explanation, see page 14

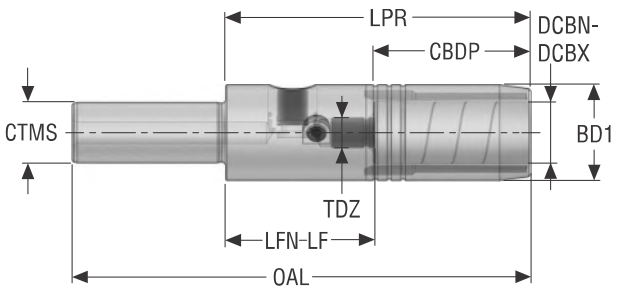
Designation	Item number	CTMS	DCBN-DCBX	LPR	LB	LB1	CBDP	BD2	BD1	OAL	LFN	LF	TDZ	BHTA°	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*					kg *lbs*
C6-HCR12-075	10137146	C6	12,0 *0.472*	75,0 *2.953*	53,0 *2.087*	33,0 *1.299*	47,5 *1.870*	62,5 *2.461*	42,0 *1.654*	113,0 *4.449*	29,0 *1.142*	39,0 *1.535*	M8x1	20,0	0	G2.5	1,5 *3.310*
C6-HCR20-080	10137147	C6	20,0 *0.787*	80,0 *3.150*	57,4 *2.260*	41,0 *1.614*	52,5 *2.067*	62,5 *2.461*	52,5 *2.067*	118,0 *4.646*	29,0 *1.142*	39,0 *1.535*	M8x1	20,0	0	G2.5	1,6 *3.530*

Accessories

For size	Key
All	H05-4

Cylindrical

HC – Hydraulic chucks, standard – Metric / *Inch*



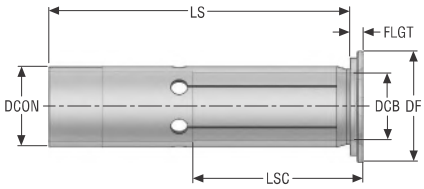
- Run-out ≤6 µm
- For ISO attribute explanation, see page 14

Designation	Item number	CTMS	DCBN-DCBX	LPR	CBDP	BD1	OAL	LFN	LF	TDZ	RFID hole	Balan-cing	Weight
			mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*				kg *lbs*
ST20-HC12-100	10137352	20	12,0 *0.472*	100,0 *3.937*	47,5 *1.870*	25,0 *0.984*	150,0 *5.906*	54,0 *2.126*	64,0 *2.520*	M6	0	G2.5	0,5 *1.100*
ST20-HC20-100	10137353	20	20,0 *0.787*	100,0 *3.937*	51,5 *2.028*	31,5 *1.240*	150,0 *5.906*	49,0 *1.929*	59,0 *2.323*	M10x1	0	G2.5	0,6 *1.320*
ST32-HC20-090	10137354	32	20,0 *0.787*	90,0 *3.543*	51,5 *2.028*	31,5 *1.240*	150,0 *5.906*	39,0 *1.535*	49,0 *1.929*	M10x1	0	G2.5	0,8 *1.760*

Accessories

For size	Key
All	H05-4

Reduction sleeves for hydraulic chucks – Metric / *Inch*

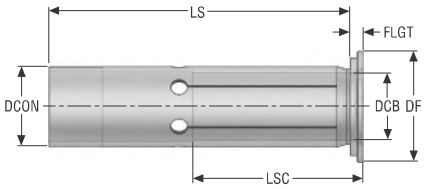


- Nominal clamping diameter only (no clamping range): tool shank tolerance h6 maximum
- ...L1 = with peripheral coolant
- For ISO attribute explanation, see page 14

Designation	Item number	Machine side DCON	Workpiece side DCB	LS	FLGT	DF	LSC
		mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*
05FHC1203	10137358	12,0 *0.472*	3,0 *0.118*	45,0 *0.608*	2,0 *0.079*	16,5 *0.650*	15,45 *0.608*
05FHC1204	10137359	12,0 *0.472*	4,0 *0.157*	45,0 *0.620*	2,0 *0.079*	16,5 *0.650*	15,75 *0.620*
05FHC1205	10137360	12,0 *0.472*	5,0 *0.197*	45,0 *0.634*	2,0 *0.079*	16,5 *0.650*	16,1 *0.634*
05FHC1206	10137361	12,0 *0.472*	6,0 *0.236*	45,0 *0.953*	2,0 *0.079*	16,5 *0.650*	24,21 *0.953*
05FHC1208	10137362	12,0 *0.472*	8,0 *0.315*	45,0 *0.977*	2,0 *0.079*	16,5 *0.650*	24,81 *0.977*
05FHC1210	10137363	12,0 *0.472*	10,0 *0.394*	45,0 *1.000*	2,0 *0.079*	16,5 *0.650*	25,41 *1.000*
05FHC2003	10137364	20,0 *0.787*	3,0 *0.118*	50,5 *0.616*	2,0 *0.079*	24,0 *0.945*	15,65 *0.616*
05FHC2004	10137365	20,0 *0.787*	4,0 *0.157*	50,5 *0.628*	2,0 *0.079*	24,0 *0.945*	15,95 *0.628*
05FHC2005	10137366	20,0 *0.787*	5,0 *0.197*	50,5 *0.640*	2,0 *0.079*	24,0 *0.945*	16,25 *0.640*
05FHC2006	10137367	20,0 *0.787*	6,0 *0.236*	50,5 *1.006*	2,0 *0.079*	24,0 *0.945*	25,55 *1.006*
05FHC2008	10137368	20,0 *0.787*	8,0 *0.315*	50,5 *1.030*	2,0 *0.079*	24,0 *0.945*	26,15 *1.030*
05FHC2010	10137369	20,0 *0.787*	10,0 *0.394*	50,5 *1.211*	2,0 *0.079*	24,0 *0.945*	30,75 *1.211*
05FHC2012	10137370	20,0 *0.787*	12,0 *0.472*	50,5 *1.367*	2,0 *0.079*	24,0 *0.945*	34,71 *1.367*
05FHC2014	10137371	20,0 *0.787*	14,0 *0.551*	50,5 *1.390*	2,0 *0.079*	24,0 *0.945*	35,31 *1.390*
05FHC2016	10137372	20,0 *0.787*	16,0 *0.630*	50,5 *1.414*	2,0 *0.079*	24,0 *0.945*	35,91 *1.414*
05FHC3206	10137373	32,0 *1.260*	6,0 *0.236*	60,5 *0.922*	2,0 *0.079*	35,5 *1.398*	23,42 *0.922*
05FHC3208	10137374	32,0 *1.260*	8,0 *0.315*	60,5 *0.946*	2,0 *0.079*	35,5 *1.398*	24,03 *0.946*
05FHC3210	10137375	32,0 *1.260*	10,0 *0.394*	60,5 *1.107*	2,0 *0.079*	35,5 *1.398*	28,13 *1.107*
05FHC3212	10137376	32,0 *1.260*	12,0 *0.472*	60,5 *1.131*	2,0 *0.079*	35,5 *1.398*	28,73 *1.131*
05FHC3214	10137377	32,0 *1.260*	14,0 *0.551*	60,5 *1.155*	2,0 *0.079*	35,5 *1.398*	29,33 *1.155*
05FHC3216	10137378	32,0 *1.260*	16,0 *0.630*	60,5 *1.583*	2,0 *0.079*	35,5 *1.398*	40,2 *1.583*

Designation	Item number	Machine side DCON	Workpiece side DCB	LS	FLGT	DF	LSC
		mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*
05FHC3218	10137379	32,0 *1.260*	18,0 *0.709*	60,5 *1.594*	2,0 *0.079*	35,5 *1.398*	40,5 *1.594*
05FHC3220	10137380	32,0 *1.260*	20,0 *0.787*	60,5 *1.618*	2,0 *0.079*	35,5 *1.398*	41,1 *1.618*
05FHC3225	10137381	32,0 *1.260*	25,0 *0.984*	60,5 *1.846*	2,0 *0.079*	35,5 *1.398*	46,9 *1.846*
05FHC1203L1	10137409	12,0 *0.472*	3,0 *0.118*	45,0 *0.608*	2,0 *0.079*	16,5 *0.650*	15,45 *0.608*
05FHC1204L1	10137410	12,0 *0.472*	4,0 *0.157*	45,0 *0.620*	2,0 *0.079*	16,5 *0.650*	15,75 *0.620*
05FHC1205L1	10137411	12,0 *0.472*	5,0 *0.197*	45,0 *0.632*	2,0 *0.079*	16,5 *0.650*	16,05 *0.632*
05FHC1206L1	10137412	12,0 *0.472*	6,0 *0.236*	45,0 *0.953*	2,0 *0.079*	16,5 *0.650*	24,21 *0.953*
05FHC1208L1	10137413	12,0 *0.472*	8,0 *0.315*	45,0 *0.977*	2,0 *0.079*	16,5 *0.650*	24,81 *0.977*
05FHC2003L1	10137414	20,0 *0.787*	3,0 *0.118*	50,5 *0.616*	2,0 *0.079*	24,0 *0.945*	15,65 *0.616*
05FHC2004L1	10137415	20,0 *0.787*	4,0 *0.157*	50,5 *0.628*	2,0 *0.079*	24,0 *0.945*	15,95 *0.628*
05FHC2005L1	10137416	20,0 *0.787*	5,0 *0.197*	50,5 *0.640*	2,0 *0.079*	24,0 *0.945*	16,25 *0.640*
05FHC2006L1	10137417	20,0 *0.787*	6,0 *0.236*	50,5 *1.007*	2,0 *0.079*	24,0 *0.945*	25,57 *1.007*
05FHC2008L1	10137418	20,0 *0.787*	8,0 *0.315*	50,5 *1.030*	2,0 *0.079*	24,0 *0.945*	26,15 *1.030*
05FHC2010L1	10137419	20,0 *0.787*	10,0 *0.394*	50,5 *1.211*	2,0 *0.079*	24,0 *0.945*	30,75 *1.211*
05FHC2012L1	10137420	20,0 *0.787*	12,0 *0.472*	50,5 *1.367*	2,0 *0.079*	24,0 *0.945*	34,71 *1.367*
05FHC2014L1	10137421	20,0 *0.787*	14,0 *0.551*	50,5 *1.390*	2,0 *0.079*	24,0 *0.945*	35,31 *1.390*
05FHC2016L1	10137422	20,0 *0.787*	16,0 *0.630*	50,5 *1.414*	2,0 *0.079*	24,0 *0.945*	35,91 *1.414*
05FHC3206L1	10137423	32,0 *1.260*	6,0 *0.236*	60,5 *0.922*	2,0 *0.079*	35,5 *1.398*	23,42 *0.922*
05FHC3208L1	10137424	32,0 *1.260*	8,0 *0.315*	60,5 *0.946*	2,0 *0.079*	35,5 *1.398*	24,02 *0.946*
05FHC3210L1	10137425	32,0 *1.260*	10,0 *0.394*	60,5 *1.107*	2,0 *0.079*	35,5 *1.398*	28,13 *1.107*
05FHC3212L1	10137426	32,0 *1.260*	12,0 *0.472*	60,5 *1.131*	2,0 *0.079*	35,5 *1.398*	28,73 *1.131*
05FHC3214L1	10137427	32,0 *1.260*	14,0 *0.551*	60,5 *1.155*	2,0 *0.079*	35,5 *1.398*	29,33 *1.155*
05FHC3216L1	10137428	32,0 *1.260*	16,0 *0.630*	60,5 *1.583*	2,0 *0.079*	35,5 *1.398*	40,2 *1.583*
05FHC3218L1	10137429	32,0 *1.260*	18,0 *0.709*	60,5 *1.594*	2,0 *0.079*	35,5 *1.398*	40,5 *1.594*
05FHC3220L1	10137430	32,0 *1.260*	20,0 *0.787*	60,5 *1.618*	2,0 *0.079*	35,5 *1.398*	41,1 *1.618*
05FHC3225L1	10137431	32,0 *1.260*	25,0 *0.984*	60,5 *1.847*	2,0 *0.079*	35,5 *1.398*	46,91 *1.847*

Reduction sleeves for hydraulic chucks – Metric / *Inch*



- Nominal clamping diameter only (no clamping range): tool shank tolerance h6 maximum
- ...L1 = with peripheral coolant
- For ISO attribute explanation, see page 14

Designation	Item number	Machine side DCON	Workpiece side DCB	LS	FLGT	DF	LSC
		mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*
05FHC120125	10137382	12,0 *0.472*	3,175 *0.125*	45,0 *0.610*	2,0 *0.079*	16,5 *0.650*	15,5 *0.610*
05FHC120187	10137383	12,0 *0.472*	4,763 *0.188*	45,0 *0.629*	2,0 *0.079*	16,5 *0.650*	15,98 *0.629*
05FHC120250	10137384	12,0 *0.472*	6,35 *0.250*	45,0 *0.957*	2,0 *0.079*	16,5 *0.650*	24,31 *0.957*
05FHC120312	10137385	12,0 *0.472*	7,938 *0.313*	45,0 *0.976*	2,0 *0.079*	16,5 *0.650*	24,79 *0.976*
05FHC120375	10137386	12,0 *0.472*	9,525 *0.375*	45,0 *0.995*	2,0 *0.079*	16,5 *0.650*	25,27 *0.995*
05FHC200125	10137387	20,0 *0.787*	3,175 *0.125*	50,5 *0.618*	2,0 *0.079*	24,0 *0.945*	15,7 *0.618*
05FHC200187	10137388	20,0 *0.787*	4,763 *0.188*	50,5 *0.637*	2,0 *0.079*	24,0 *0.945*	16,18 *0.637*
05FHC200250	10137389	20,0 *0.787*	6,35 *0.250*	50,5 *1.010*	2,0 *0.079*	24,0 *0.945*	25,65 *1.010*
05FHC200312	10137390	20,0 *0.787*	7,938 *0.313*	50,5 *1.029*	2,0 *0.079*	24,0 *0.945*	26,13 *1.029*
05FHC200375	10137391	20,0 *0.787*	9,525 *0.375*	50,5 *1.048*	2,0 *0.079*	24,0 *0.945*	26,61 *1.048*
05FHC200437	10137392	20,0 *0.787*	11,113 *0.438*	50,5 *1.224*	2,0 *0.079*	24,0 *0.945*	31,08 *1.224*
05FHC200500	10137393	20,0 *0.787*	12,7 *0.500*	50,5 *1.375*	2,0 *0.079*	24,0 *0.945*	34,92 *1.375*
05FHC200562	10137394	20,0 *0.787*	14,288 *0.563*	50,5 *1.394*	2,0 *0.079*	24,0 *0.945*	35,4 *1.394*
05FHC200625	10137395	20,0 *0.787*	15,875 *0.625*	50,5 *1.412*	2,0 *0.079*	24,0 *0.945*	35,87 *1.412*
05FHC320250	10137396	32,0 *1.260*	6,35 *0.250*	60,5 *0.926*	2,0 *0.079*	35,5 *1.398*	23,53 *0.926*
05FHC320312	10137397	32,0 *1.260*	7,938 *0.313*	60,5 *0.945*	2,0 *0.079*	35,5 *1.398*	24,0 *0.945*
05FHC320375	10137398	32,0 *1.260*	9,525 *0.375*	60,5 *1.102*	2,0 *0.079*	35,5 *1.398*	27,98 *1.102*
05FHC320437	10137399	32,0 *1.260*	11,113 *0.438*	60,5 *1.120*	2,0 *0.079*	35,5 *1.398*	28,46 *1.120*
05FHC320500	10137400	32,0 *1.260*	12,7 *0.500*	60,5 *1.139*	2,0 *0.079*	35,5 *1.398*	28,94 *1.139*
05FHC320562	10137401	32,0 *1.260*	14,288 *0.563*	60,5 *1.158*	2,0 *0.079*	35,5 *1.398*	29,41 *1.158*
05FHC320625	10137402	32,0 *1.260*	15,875 *0.625*	60,5 *1.581*	2,0 *0.079*	35,5 *1.398*	40,16 *1.581*

Designation	Item number	Machine side DCON	Workpiece side DCB	LS	FLGT	DF	LSC
		mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*	mm *inch*
05FHC320687	10137403	32,0 *1.260*	17,462 *0.687*	60,5 *1.588*	2,0 *0.079*	35,5 *1.398*	40,34 *1.588*
05FHC320750	10137404	32,0 *1.260*	19,05 *0.750*	60,5 *1.607*	2,0 *0.079*	35,5 *1.398*	40,81 *1.607*
05FHC320812	10137405	32,0 *1.260*	20,637 *0.812*	60,5 *1.600*	2,0 *0.079*	35,5 *1.398*	40,63 *1.600*
05FHC320875	10137406	32,0 *1.260*	22,225 *0.875*	60,5 *1.619*	2,0 *0.079*	35,5 *1.398*	41,11 *1.619*
05FHC320937	10137407	32,0 *1.260*	23,812 *0.937*	60,5 *1.833*	2,0 *0.079*	35,5 *1.398*	46,55 *1.833*
05FHC321000	10137408	32,0 *1.260*	25,4 *1.000*	60,5 *1.850*	2,0 *0.079*	35,5 *1.398*	47,0 *1.850*
05FHC120125L1	10137432	12,0 *0.472*	3,175 *0.125*	45,0 *0.610*	2,0 *0.079*	16,5 *0.650*	15,5 *0.610*
05FHC120187L1	10137433	12,0 *0.472*	4,763 *0.188*	45,0 *0.629*	2,0 *0.079*	16,5 *0.650*	15,98 *0.629*
05FHC120250L1	10137434	12,0 *0.472*	6,35 *0.250*	45,0 *0.957*	2,0 *0.079*	16,5 *0.650*	24,31 *0.957*
05FHC120312L1	10137435	12,0 *0.472*	7,938 *0.313*	45,0 *0.976*	2,0 *0.079*	16,5 *0.650*	24,79 *0.976*
05FHC120375L1	10137436	12,0 *0.472*	9,525 *0.375*	45,0 *0.995*	2,0 *0.079*	16,5 *0.650*	25,27 *0.995*
05FHC200187L1	10137438	20,0 *0.787*	4,763 *0.188*	50,5 *0.637*	2,0 *0.079*	24,0 *0.945*	16,18 *0.637*
05FHC200250L1	10137439	20,0 *0.787*	6,35 *0.250*	50,5 *1.010*	2,0 *0.079*	24,0 *0.945*	25,65 *1.010*
05FHC200312L1	10137440	20,0 *0.787*	7,938 *0.313*	50,5 *1.029*	2,0 *0.079*	24,0 *0.945*	26,13 *1.029*
05FHC200375L1	10137441	20,0 *0.787*	9,525 *0.375*	50,5 *1.048*	2,0 *0.079*	24,0 *0.945*	26,61 *1.048*
05FHC200437L1	10137442	20,0 *0.787*	11,113 *0.438*	50,5 *1.224*	2,0 *0.079*	24,0 *0.945*	31,1 *1.224*
05FHC200500L1	10137443	20,0 *0.787*	12,7 *0.500*	50,5 *1.375*	2,0 *0.079*	24,0 *0.945*	34,92 *1.375*
05FHC200562L1	10137444	20,0 *0.787*	14,288 *0.563*	50,5 *1.394*	2,0 *0.079*	24,0 *0.945*	35,4 *1.394*
05FHC200625L1	10137445	20,0 *0.787*	15,875 *0.625*	50,5 *1.412*	2,0 *0.079*	24,0 *0.945*	35,87 *1.412*
05FHC201250L1	10137437	20,0 *0.787*	3,175 *0.125*	50,5 *0.618*	2,0 *0.079*	24,0 *0.945*	15,7 *0.618*
05FHC320500L1	10137446	32,0 *1.260*	12,7 *0.500*	60,5 *1.139*	2,0 *0.079*	35,5 *1.398*	28,94 *1.139*
05FHC320625L1	10137447	32,0 *1.260*	15,875 *0.625*	60,5 *1.581*	2,0 *0.079*	35,5 *1.398*	40,16 *1.581*
05FHC320750L1	10137448	32,0 *1.260*	19,05 *0.750*	60,5 *1.607*	2,0 *0.079*	35,5 *1.398*	40,82 *1.607*
05FHC320875L1	10137449	32,0 *1.260*	22,225 *0.875*	60,5 *1.619*	2,0 *0.079*	35,5 *1.398*	41,11 *1.619*
05FHC321000L1	10137450	32,0 *1.260*	25,4 *1.000*	60,5 *1.850*	2,0 *0.079*	35,5 *1.398*	47,0 *1.850*