MillLine

THREADMILLING

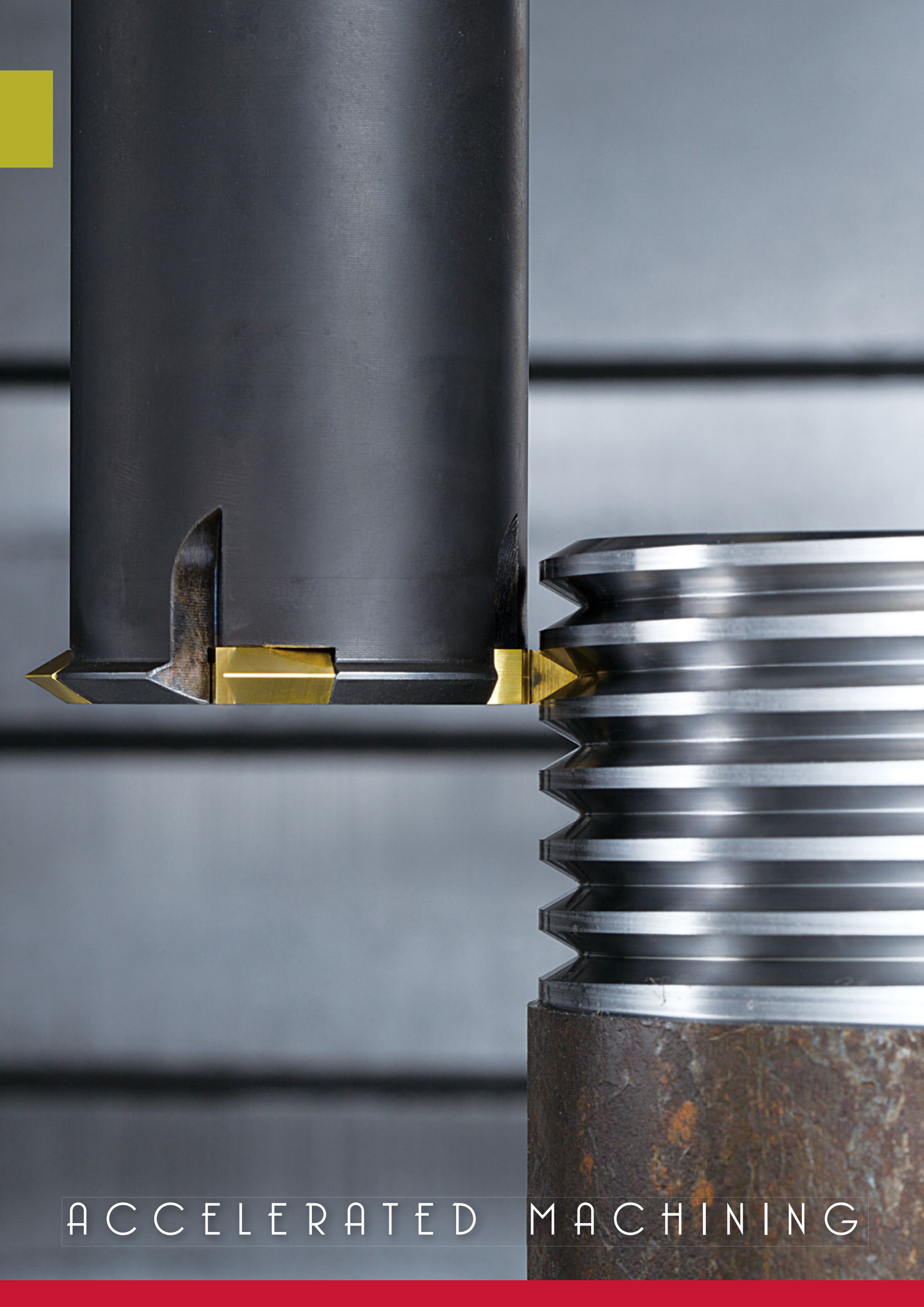
www.tungaloy.com

Tungaloy Report No. 514-G

Expansion for indexable TreadMilling

INDUSTRY 4.0

FEED the SPEED!


ACCELERATED MACHINING

THREADMILLING

TUNGALOY

Indexable thread milling holders for TAPER pipe theread are availavle for different thread type inserts such as R(BSPT eternal),Rc(BSPT internal) NPT NPTF

THREADMILLING
TUNGALOY

MillLine
Thread milling tools

New

Indexable threading mills
p.5

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

SOLIDTHREAD
p.11

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

TUNGMEISTER
p.28

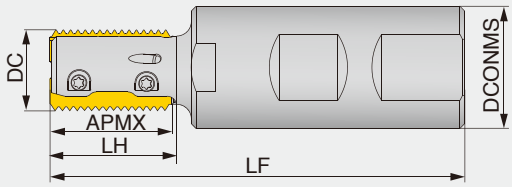
Head-changeable milling tool for less down-time than a solid tapping tool.

Indexable threading mills

New

Thread milling cutter

Indexable thread milling cutter, long edge



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

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

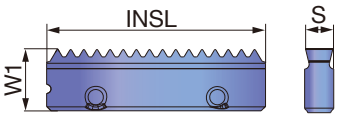
To be released at the end of August

SPARE PARTS

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

INSERTS

TL25D...



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

★ : First choice
☆ : Second choice

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

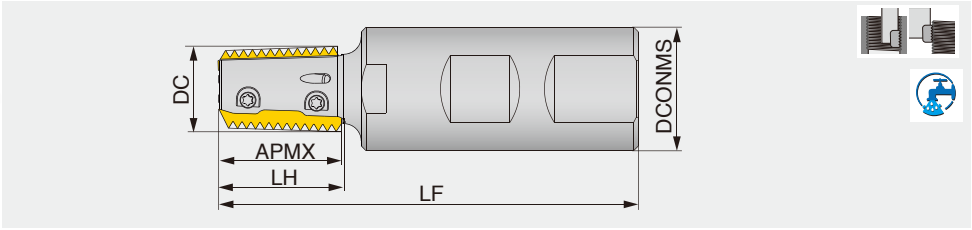
2) Does not fit the ø*D*c17 holder

★ : To be released at the end of August

New

Thread milling cutter

Indexable thread milling cutter, long edge



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

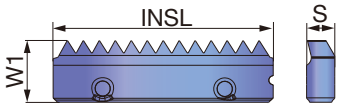
SPARE PARTS

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

New

INSERTS

TL25SEIR...



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

★ : First choice
☆ : Second choice

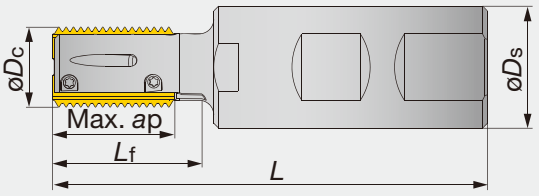
Thread type	Application	Designation	Pitch	Thread per inch	Number of threads per edge	Coated AH725	INSL	W1	S
BSPT	Internal and external	TL25SEIR14BSPT	-	14	13	●	25	7	3.1
		TL25SEIR11BSPT	-	11	10	●	25	7	3.1
NPT	Internal and external	TL25SEIR14NPT	-	14	13	●	25	7	3.1
		TL25SEIR11.5NPT	-	11.5	11	●	25	7	3.1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

● : New product

Indexable threading mills

Thread milling cutter

Indexable thread milling cutter, long edge



Designation	øDc	Max. ap	z	øDs	Lf	L	Oil hole	Insert
ETLN25M017W25.0F026R02 1)	17	25	2	25	26	85	with	LN25....
ETLN25M017W25.0F036R02 1)	17	25	2	25	36	95	with	LN25....
ETLN25M019W25.0F032R02	19	25	2	25	32	92	with	LN25....
ETLN25M019W25.0F044R02	19	25	2	25	44	104	with	LN25....
ETLN25M021W25.0F037R03	20.5	25	3	25	37	96	with	LN25....
ETLN25M021W25.0F044R03	20.5	25	3	25	44	103	with	LN25....
ETLN25M022W25.0F043R03	22	25	3	25	43	102	with	LN25....
ETLN25M022W25.0F055R03	22	25	3	25	55	114	with	LN25....
ETLN25M030W25.0F055R05	30	25	5	25	55	115	with	LN25....

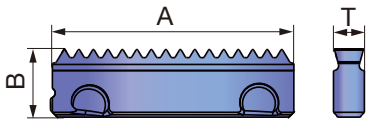
1) Inserts with a thread pitch of ≥ 3 mm or ≥ 8TPI are not moutable

SPARE PARTS

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

INSERTS

LN25...



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

★ : First choice
☆ : Second choice

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

2) Does not fit the øDc17 holder

●: Line-up

STANDARD CUTTING CONDITIONS

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

• Climb milling is recommended.

Insert installation

1. Use airgun or rug to thoughrouly clean all the insert pockets free from dust or chips.

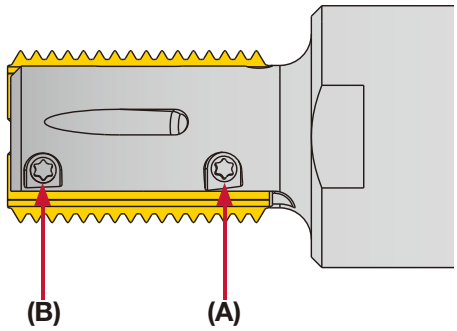
2. Lightly tighten Screw "A" first, then Screw "B" until the insert becomes stationary.

3. Lightly tighten the screws for other insert(s) in the same matter as mentioned in 2 above.

4. Firmly tighten Screw "A", then Screw "B".
Use the recommended torque strengths when tightening the screws.

5. Firmly tighten the screws for other insert(s) in the same manner as mentioned in 4 above.

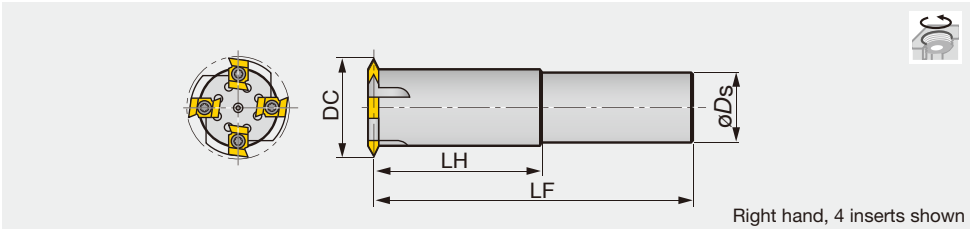
6. Inspect to make sure there is no gap between the insert and the insert seat. Measure the radial runout before use.



Indexable threading mills

Single tooth threading mills

Indexable threading mills



Right hand, 4 inserts shown

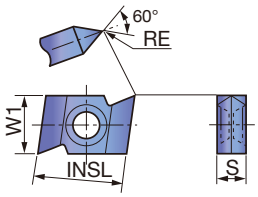
Designation	DC	CICT	øDs	LH	LF	Range of internal thread	Insert
D23-D25-45R	23	1	25	45	115	M28 - M30	T1-R...
D25-D25-45R	25	1	25	45	115	M32 - M42	T1-R...
D38-D32-85R	38	2	32	85	165	M45 - M56	T1-R...
D50-D42-100R	50	4	42	100	190	M58 - M68	T1-R...
D55-D42-100R	55	4	42	100	190	M64 - M85	T2-R...
D60-D42-100R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

SPARE PARTS

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

INSERTS (Partial profile)

T*-R...



		Coated
		GH330
P	Steel	★
M	Stainless	★
K	Cast iron	
N	Non-ferrous	
S	Superalloys	
H	Hard materials	

★ : First choice
☆ : Second choice

Designation	RE	Coated GH330	INSL	W1	S
T1-R14	0.14	●	14.4	9.525	4.76
T1-R28	0.28	●	14.4	9.525	4.76
T2-R14	0.14	●	17.8	12.7	6.35
T2-R28	0.28	●	17.8	12.7	6.35

● : Line-up

STANDARD CUTTING CONDITIONS

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

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

THREADING MILLS AND APPLICABLE THREADS

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

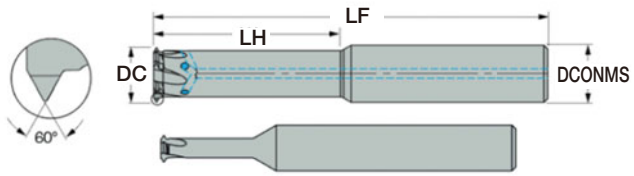
Designation System for Solid Carbide Endmills

MTEC□ | **06** | **04** | **C** | **ISO**

- **MTEC□** — ThreadMilling Endmill Carbide
  - I - Single Point
  - S - Short
  - SH - Short for Hardened steel
  - B - with Coolant Bore
  - Q - with Coolant Bore with long neck
  - Z - with Coolant hole with through hole
  - D - with Drilling (end mill) cutting edge
  - E - for External thread
- **06** — Shank Dia.
- **04** — Tool Dia.
- **C** — No. of Flutes
  - C = 3 flutes
  - D = 4 flutes
  - E = 5 flutes
  - F = 6 flutes
- **ISO** — Thread Standard

MTECI-60 (Partical profile)

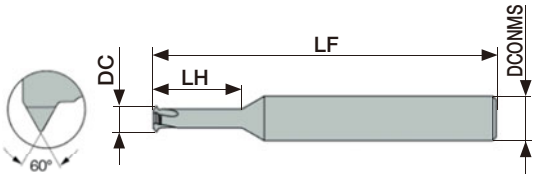
MTECI-A60

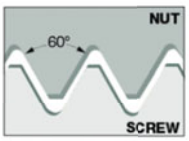


Designation	ISO Metric						Unified							DCONMS	DC	NOF	LH	LF	Oil hole	Grade
	Pitch				Application range		TPI				Application range									
	Internal		External		Fine	Coarse	Internal		External		UNC	UNF	UNS							
	min	max	min	max			min	max	min	max										
MTECI03019C5A60	0.35	0.6	0.35	0.6	M2.5X0.45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

ISO metric

MTECI-ISO





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

ISO metric

MTEC-ISO

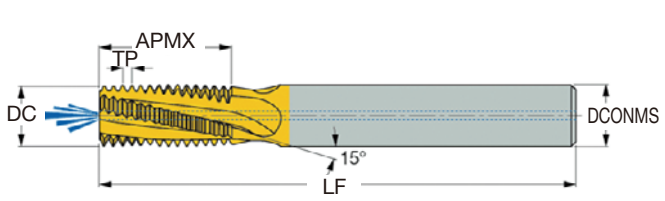
Solid Carbide Internal Threading
Endmills for ISO metric Thread Profile

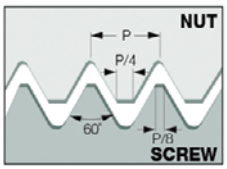
Designation	Pitch	Application range		DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		Fine	Coarse							
MTEC06022C50.5ISO	0.5	M3	≥M4	6	2.2	3	5.3	58	Without	AH725
MTEC06038C100.5ISO	0.5	-	≥M5	6	3.8	3	10.3	58	Without	AH725
MTEC06031C70.7ISO	0.7	M4	≥M5	6	3.1	3	7.4	58	Without	AH725
MTEC06045C100.75ISO	0.75	-	≥M6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

ISO metric

MTECB-ISO

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

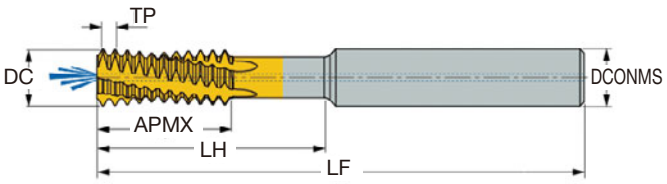


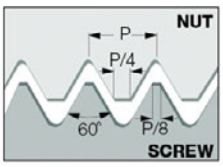


Designation	Pitch	Application range Fine	Application range Coarse	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECB06038C100.5ISO	0.5	-	≥M5	6	3.8	3	10.3	58	With	AH725
MTECB06031C70.7ISO	0.7	M4	≥M5	6	3.1	3	7.4	58	With	AH725
MTECB06045C100.75ISO	0.75	-	≥M6	6	4.5	3	10.1	58	With	AH725
MTECB1010D240.75ISO	0.75	-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

MTECQ-ISO

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

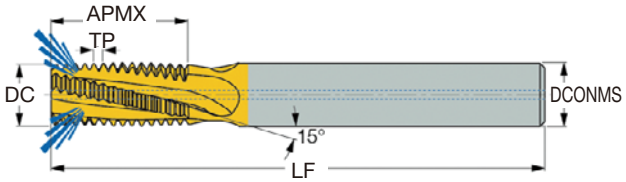


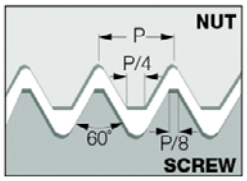


Designation	Pitch	Application range	DCONMS	DC	NOF	APMX	LH	LF	Oil hole	Grade
MTECQ1212D381.0ISO	1	≥M14	12	12	4	21	38	84	With	AH725
MTECQ1010D301.5ISO	1.5	≥M13	10	10	4	18	30	73	With	AH725
MTECQ2020F562.0ISO	2	≥M24	20	20	6	34	56	105	With	AH725
MTECQ2020D453.5ISO	3.5	≥M26	20	20	4	28	45.5	105	With	AH725

MTECZ-ISO

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



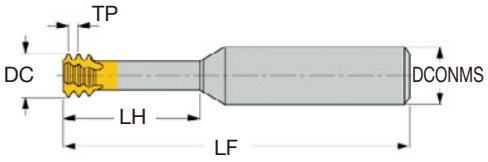


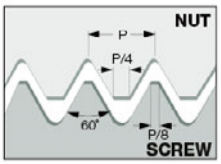
Designation	Pitch	Application range		DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		Fine	Coarse							
MTECZ0808D161.0ISO	1	-	≥M10	8	8	4	16.5	64	With	AH725
MTECZ06048C101.0ISO	1	M6	≥M7	6	4.8	3	10.5	58	With	AH725
MTECZ0606C141.25ISO	1.25	M8	≥M10	6	6	3	14.4	58	With	AH725
MTECZ0606C191.25ISO	1.25	M8	≥M10	6	6	3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

ISO metric

MTECS-ISO

Small Diameter Solid Carbide
Threading Endmills for
Internal ISO metric Profile

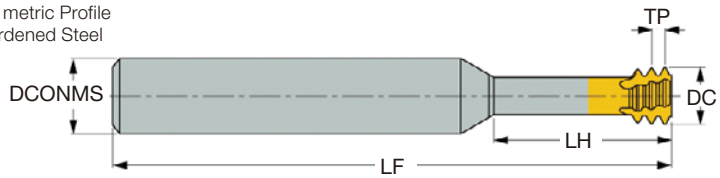


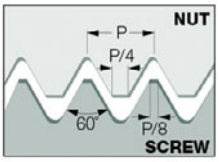


Designation	Pitch	Application range Fine	Application range Coarse	DCONMS	DC	NOF	LH	LF	Oil hole	Grade
MTECS03007C20.25ISO	0.25	≥M1		3	0.72	3	2.5	39	Without	AH725
MTECS03009C30.25ISO	0.25	≥M1.2		3	0.9	3	3	39	Without	AH725
MTECS03011C40.3ISO	0.3	≥M1.4		3	1.05	3	4	39	Without	AH725
MTECS03012C50.35ISO	0.35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

MTECSH-ISO

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



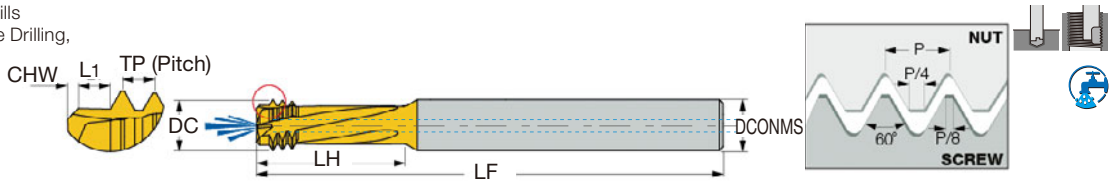


Designation	Pitch	Application range Fine	Application range Coarse	DCONMS	DC	NOF	LH	LF	Oil hole	Grade
MTECSH03012C50.35ISO	0.35	≥M1.6		3	1.2	3	4.8	39	Without	AH750
MTECSH03016C60.4ISO	0.4	≥M2		3	1.55	3	6	39	Without	AH750
MTECSH06016C40.4ISO	0.4	≥M2		6	1.55	3	4.5	58	Without	AH750
MTECSH06017C50.45ISO	0.45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

ISO metric

MTECD-ISO

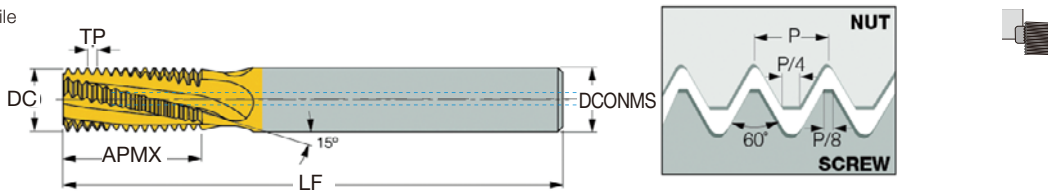
Small Diameter Short Left-Hand Cutting Solid Carbide Endmills for Internal ISO metric Profile Drilling, Threading and Chamfering



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

MTEC E-ISO

Solid Carbide External Threading Endmills for ISO metric Thread Profile

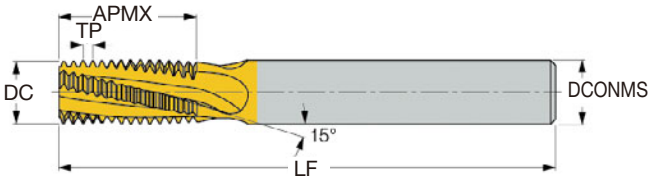


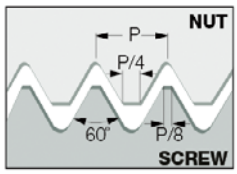
Designation	Pitch	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECE1010D161.0ISO	1	10	10	4	16.5	73	Without	AH725
MTECE1010D161.25ISO	1.25	10	10	4	16.9	73	Without	AH725
MTECE1010D151.5ISO	1.5	10	10	4	15.8	73	Without	AH725
MTECE1212D201.5ISO	1.5	12	12	4	20.3	84	Without	AH725
MTECE1212D201.75ISO	1.75	12	12	4	20.1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

Unified

MTEC-UN

Solid Carbide Threading Endmills
for Internal UN Thread Profile



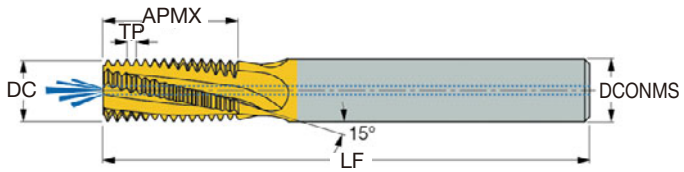


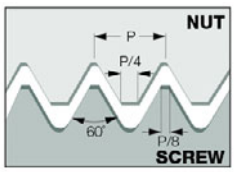
Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		UNC	UNF	UNEF							
MTEC06032C632UN	32	#8	#10	#12	6	3.2	3	6.8	58	Without	AH725
MTEC0604C1128UN	28	-	7/16-1/2	-	6	4	3	11.3	58	Without	AH725
MTEC0606C1428UN	28	-	-	7/16-1/2	6	6	3	14.5	58	Without	AH725
MTEC0605C1424UN	24	-	5/16	-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

Unified

MTECB-UN

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

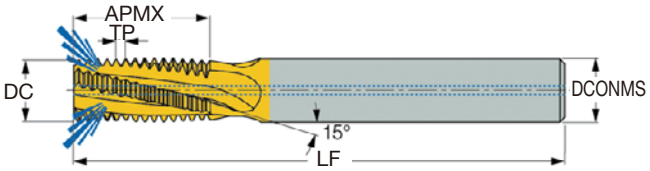


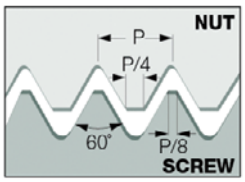


Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		UNC	UNF	UNEF							
MTECB06032C632UN	32	#8	#10	#12	6	3.2	3	6.8	58	With	AH725
MTECB0606C1432UN	32	-	-	7/16-1/2	6	6	3	16	58	With	AH725
MTECB0605C1128UN	28	-	1/4	-	6	5	3	11.3	58	With	AH725
MTECB08066C1424UN	24	-	5/16	-	8	6.6	3	14.3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

MTECZ-UN

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

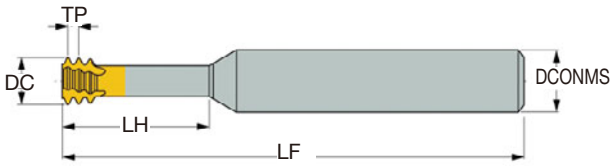


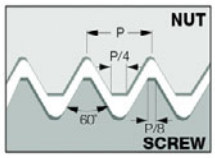


Designation	TPI	Application range			DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
		UNC	UNF	UNEF							
MTECZ1010D2220UN	20	-	1/2	-	10	10	4	22.3	73	With	AH725
MTECZ12113D2618UN	18	-	9/16-5/8	1 1/8-1 5/8	12	11.3	4	26.1	84	With	AH725
MTECZ08067C1616UN	16	3/8	-	-	8	6.7	3	16.7	64	With	AH725
MTECZ16144D3410UN	10	3/4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

MTECS-UN

Small Diameter Solid Carbide UN
Profile Threading Endmills for Steel





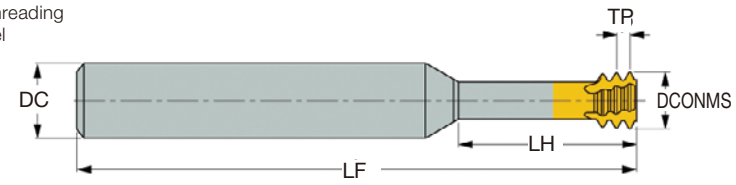
Designation	TPI	Application range UNC	Application range UNF	DCONMS	DC	NOF	LH	LF	Oil hole	Grade
MTECS03012C880UN	80	-	#0	3	1.15	3	8	39	Without	AH725
MTECS03015C672UN	72	-	#1	3	1.45	3	6	39	Without	AH725
MTECS06016C656UN	56	#2	#3	6	1.65	3	6.6	58	Without	AH725
MTECS06016C456UN	56	#2	#3	6	1.65	3	4.4	58	Without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

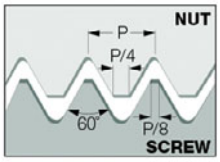
SOLIDTHREAD
TUNGALOY

Unified

MTECSH-UN

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

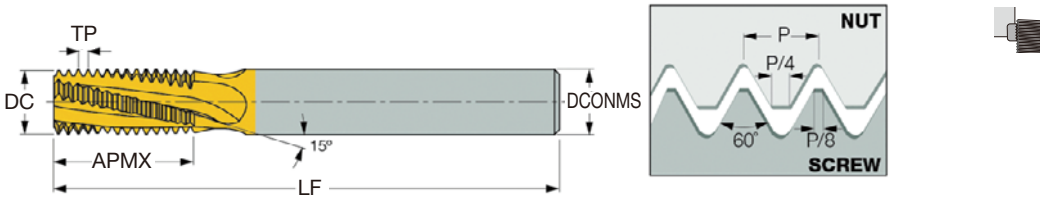




Designation	TPI	Application range UNC	Application range UNF	DCONMS	DC	NOF	LH	LF	Oil hole	Grade
MTECSH06012C480UN	80	-	#0	6	1.15	3	4	58	Without	AH725
MTECSH06016C656UN	56	#2	#3	6	1.65	3	6.6	58	Without	AH725
MTECSH06019C548UN	48	#3	#4	6	1.9	3	5.2	58	Without	AH725
MTECSH06021C640UN	40	#4	-	6	2.1	3	6.3	58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

MTEC E-UN

Solid Carbide Threading Endmills with
UN Form for External Threading

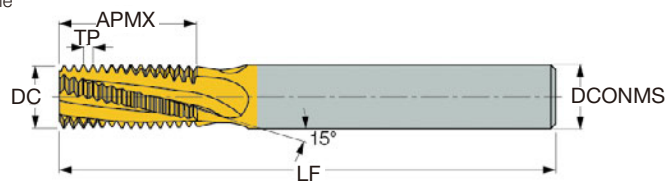


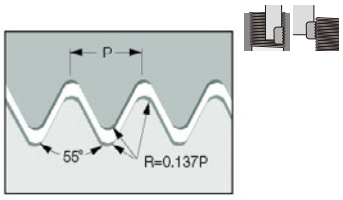
Designation	TPI	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECE1010D1624UN	24	10	10	4	16.4	73	Without	AH725
MTECE1212E2120UN	20	12	12	5	21	84	Without	AH725

Whitworth

MTEC-W

Solid Carbide Threading Endmills for Internal or External BSP Thread Profile

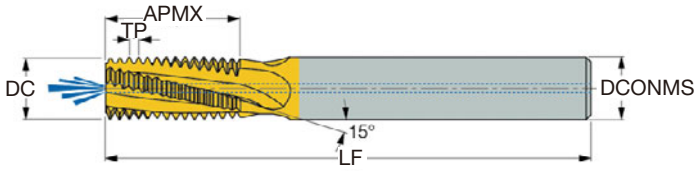


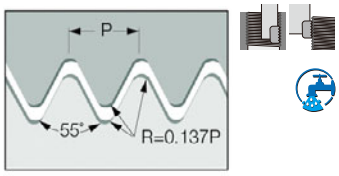


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTEC0606C928W	28	1/8	6	6	3	9.5	58	Without	AH725
MTEC0808C1419W	19	1/4-3/8	8	8	3	14	64	Without	AH725
MTEC1212D1914W	14	1/2-7/8	12	12	4	19.3	84	Without	AH725
MTEC1212D2614W	14	1/2-7/8	12	12	4	26.3	84	Without	AH725
MTEC1212C2411W	11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

MTECB-W

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

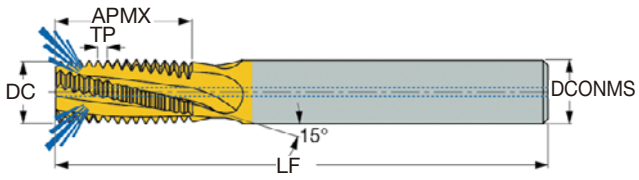


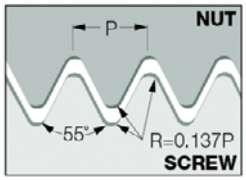


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECB08078C1428W	28	1/8	8	7.8	3	14.1	64	With	AH725
MTECB1010D1619W	19	1/4-3/8	10	10	4	16.7	73	With	AH725
MTECB1616E2614W	14	1/2-7/8	16	16	5	26.3	105	With	AH725
MTECB1616D3811W	11	≥1	16	16	4	38.1	105	With	AH725
MTECB2020E4711W	11	≥1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

MTECZ-W

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

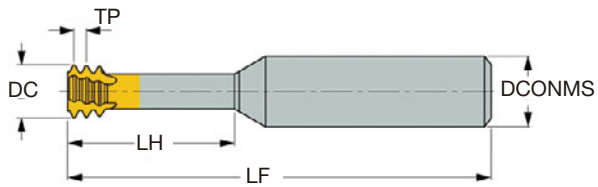


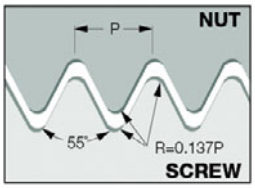


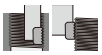
Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECZ08078C1428W	28	1/8	8	7.8	3	14.1	64	With	AH725
MTECZ1010D1619W	19	1/4-3/8	10	10	4	16.7	73	With	AH725
MTECZ1616E2614W	14	1/2-7/8	16	16	5	26.3	101	With	AH725

MTECS-W

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





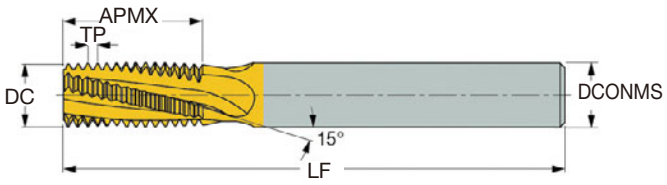


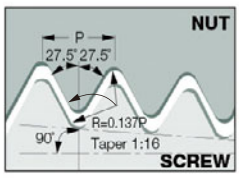
Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECS08078C1928W	28	1/8	8	7.8	3	19.5	64	Without	AH725
MTECS1010D3019W	19	1/4-3/8	10	10	4	30	73	Without	AH725
MTECS1212D3714W	14	1/2-7/8	12	12	4	37	84	Without	AH725

BSPT

MTEC-BSPT

Solid Carbide Threading Endmills for External or Internal BSPT Thread Profile



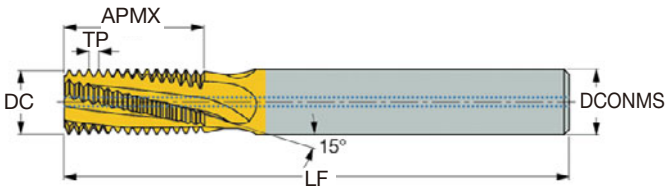


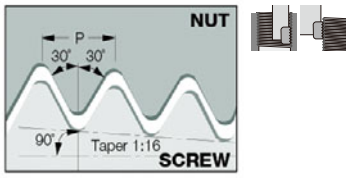
Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTEC0606C928BSPT	28	1/8	6	6	3	9.5	58	Without	AH725
MTEC0808C1419BSPT	19	1/4-3/8	8	8	3	14	64	Without	AH725
MTEC1212D1914BSPT	14	1/2-7/8	12	12	4	19.1	84	Without	AH725
MTEC1616D2811BSPT	11	1-2	16	16	4	28.9	105	Without	AH725

NPT

MTEC-NPT

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

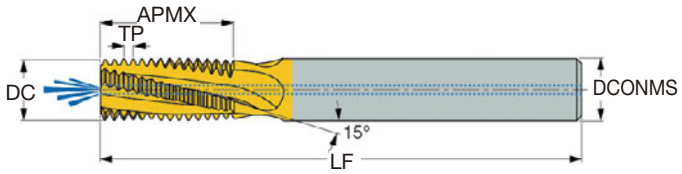


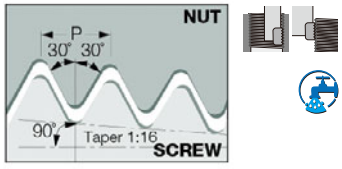


Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTEC0606C927NPT	27	1/16-1/8	6	6	3	9.9	58	Without	AH725
MTEC0808C1418NPT	18	1/4-3/8	8	8	3	14.8	64	Without	AH725
MTEC1212D2014NPT	14	1/2-3/4	12	12	4	20.9	84	Without	AH725
MTEC1616D2711.5NPT	11.5	1-2	16	16	4	27.6	105	Without	AH725
MTEC2020D398NPT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

MTECB-NPT

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



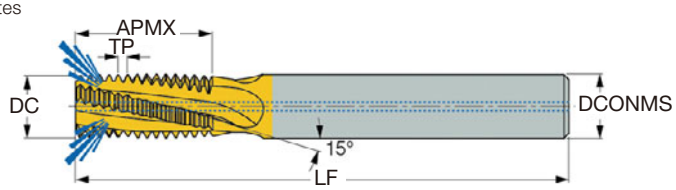


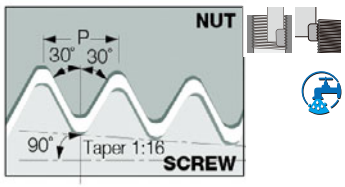
Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECB08076C1027NPT	27	1/8	8	7.6	3	10.8	64	With	AH725
MTECB1010D1618NPT	18	1/4-3/8	10	10	4	16.2	73	With	AH725
MTECB16155D2214NPT	14	1/2-3/4	16	15.5	4	22.7	105	With	AH725

NPTF

MTECZ-NPTF

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



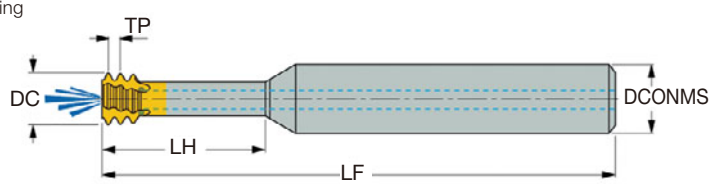


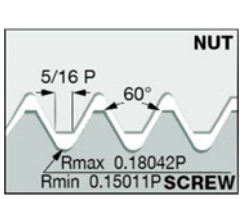
Designation	TPI	Application range	DCONMS	DC	NOF	APMX	LF	Oil hole	Grade
MTECZ08076C1027NPTF	27	1/8	8	7.6	3	10.8	64	With	AH725
MTECZ1010D1618NPTF	18	1/4-3/8	10	10	4	16.2	73	With	AH725

MJ

MTECS-MJ

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



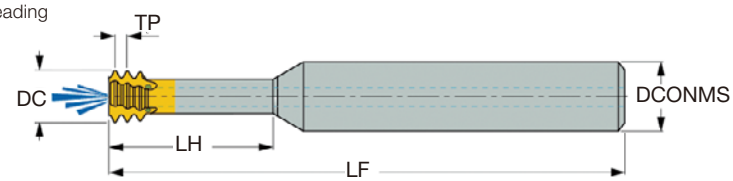


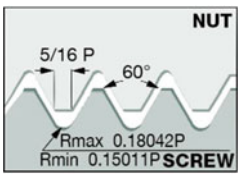
Designation	Pitch	Application range	DCONMS	DC	NOF	LH	LF	Oil hole	Grade
MTECS06032C100.7MJ	0.7	4	6	3.2	3	10	58	Without	AH725
MTECS06039C120.8MJ	0.8	5	6	3.9	3	12.5	58	Without	AH725
MTECS06048C151.0MJ	1	6	6	4.8	3	15	58	Without	AH725
MTECS08061C201.25MJ	1.25	8	8	6.1	3	20	64	With	AH725
MTECS0808C251.5MJ	1.5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

UNJ

MTECS-UNJ

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





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

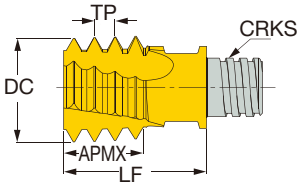
Designation System for TungMeister

VMT	100	L06	IS	15	-	4	S05
TungMeister ThreadMilling VMT : Full profile VTR : Partial profile	Tool Dia. x10	Cutting Length	Thread Profile ISO UN W	Pitch x10 TPI		No. of Flutes	Connection Size

ISO metric

VMT***IS

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

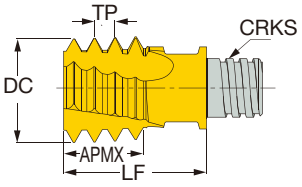


Designation	Pitch	Application range Fine	Application range Coarse	DC	NOF	APMX	LF	CRKS	Oil hole	Grade
VMT100L06IS07-4S05	0.75	-	≥M12	10	4	6	12.8	S05	AH725	KEYV-S05
VMT100L06IS10-4S05	1	-	≥M12	10	4	6	12.8	S05	AH725	KEYV-S05
VMT100L06IS15-4S05	1.5	-	≥M14	10	4	6	12.8	S05	AH725	KEYV-S05
VMT120L09IS15-4S06	1.5	-	≥M16	12	4	9	14.3	S06	AH725	KEYV-T25
VMT120L10IS20-4S06	2	M16	≥M17	12	4	10	14.3	S06	AH725	KEYV-T25
VMT160L12IS15-6S08	1.5	-	≥M20	16	6	12	19	S08	AH725	KEYV-T30L
VMT160L12IS20-5S08	2	-	≥M19	16	5	12	19	S08	AH725	KEYV-T30L
VMT150L13IS25-5S08	2.5	M20	≥M22	15.4	5	12.5	19	S08	AH725	KEYV-T30L
VMT160L12IS30-3S08	3	M24	≥M25	16	3	12	19	S08	AH725	KEYV-T30L

Unified

VMT***UN

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

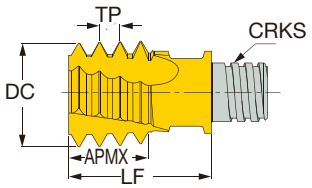


Designation	TPI	Application range UNC	Application range UNF	Application range UNFF	DC	NOF	APMX	LF	CRKS	Oil hole	Grade
VMT100L06UN24-4S05	24	-	-	9/16-5/8	10	4	5.3	12.8	S05	AH725	KEYV-S05
VMT100L06UN20-4S05	20	-	1/2	-	10	4	5.1	12.8	S05	AH725	KEYV-S05
VMT100L06UN18-4S05	18	-	9/16-5/8	1 1/8-1 5/8	10	4	5.6	12.8	S05	AH725	KEYV-S05
VMT120L10UN16-4S06	16	-	3/4	-	12	4	9	14.3	S06	AH725	KEYV-T25
VMT120L10UN14-4S06	14	-	7/8	-	12	4	9	14.3	S06	AH725	KEYV-T25
VMT160L13UN12-5S08	12	-	1-1 1/2	-	16	5	12.7	19	S08	AH725	KEYV-T30L
VMT150L13UN10-4S08	10	3/4	-	-	15.4	4	12.7	19	S08	AH725	KEYV-T30L
VMT160L11UN09-3S08	9	7/8	-	-	16	3	11.3	19	S08	AH725	KEYV-T30L
VMT160L12UN08-3S08	8	1	-	-	16	3	12.7	19	S08	AH725	KEYV-T30L

Whitworth

VMT***W

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

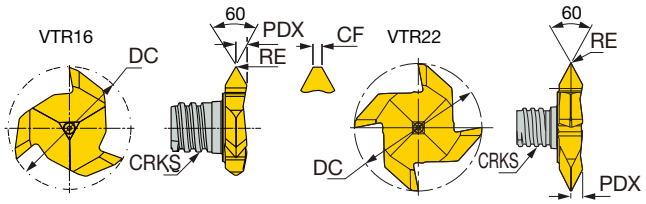


Designation	TPI	Application range	DC	NOF	APMX	LF	CRKS	Oil hole	Grade
VMT100L06W19-4S05	19	1/4-3/8	10	4	5.3	12.8	S05	AH725	KEYV-S05
VMT160L12W14-4S08	14	1/2-7/8	16	4	12.7	19	S08	AH725	KEYV-T30L
VMT160L11W11-4S08	11	≥1	16	4	11.6	19	S08	AH725	KEYV-T30L

60° partial profile

VTR***IS

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

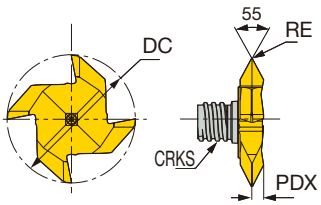


Designation	Pitch		Smallest Possible thread	DC	RE	CF	PDX	NOF	CRKS	Oil hole	Grade
	P min	P max									
VTR160L12IS05-3S06	0.5	2	M20	15.7	-	0.05	1.4	3	S06	GH130	KEYV-177
VTR160L12IS15-3S06	1.5	2	M22	15.7	0.05	-	1.4	3	S06	GH130	KEYV-177
VTR220L28IS30-4S08	3	4.5	M36	21.7	0.2	-	2.8	4	S08	GH130	KEYV-217

55° partial profile

VTR***W

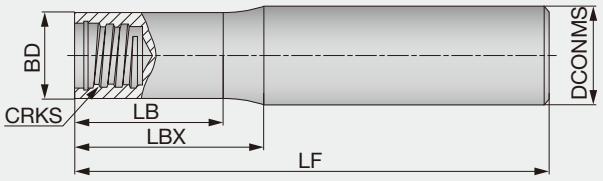
Interchangeable Solid Carbide Milling Head with Threaded Connection for Internal or External 55° Partial Profile Thread Milling



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

VSSD...

TungMeister, straight neck and cylindrical shank

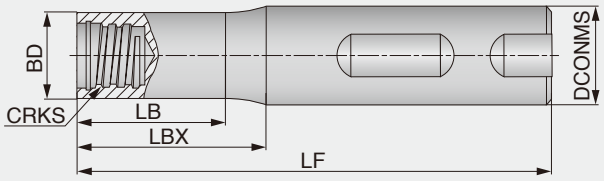


CRKS = Connection screw size

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

VSSD**W...

TungMeister, straight neck and weldon shank

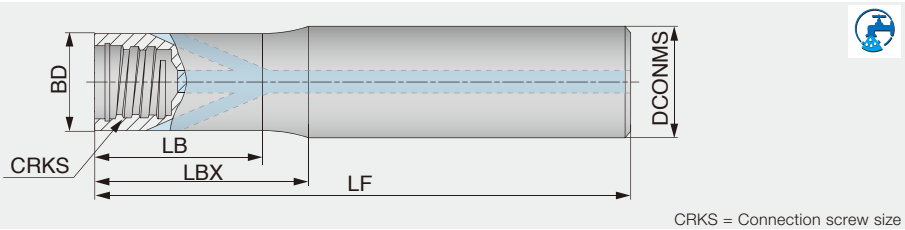


CRKS = Connection screw size

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

VSSD**-W-A

TungMeister, straight shank and neck with coolant hole

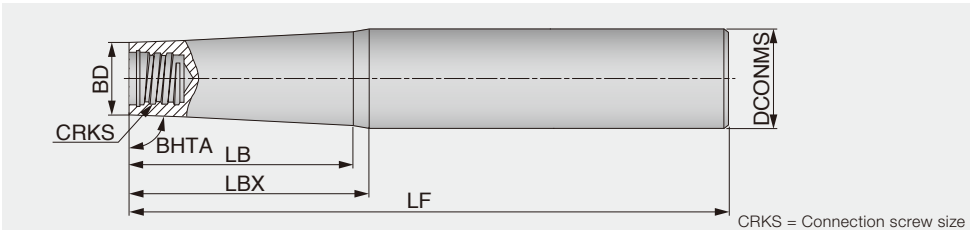


CRKS = Connection screw size

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

VTSD...

TungMeister, straight shank and taper neck

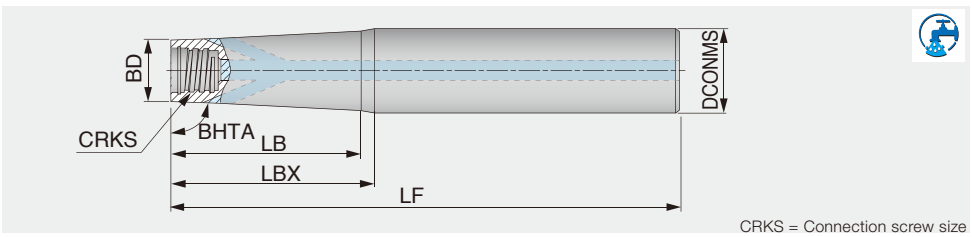


CRKS = Connection screw size

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

VTSD**-W-A

TungMeister, straight shank and taper neck with coolant hole

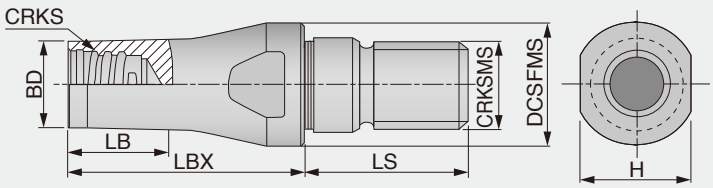


CRKS = Connection screw size

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

VAD**-M...

TungFlex conversion adaptor with TungMeister



CRKS = Connection screw size

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

Wrench

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

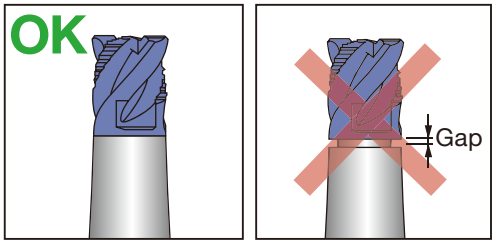
Note: Optional parts

Torque wrenches

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

CAUTIONARY POINTS IN USE

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



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STANDARD CUTTING CONDITIONS

ISO	Material		Condition	Tensile strength [N/mm2]	Hardness HB
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	420	125
		≥ 0.25 %C	Annealed	650	190
		< 0.55 %C	Quenched and tempered	850	250
		≥ 0.55 %C	Annealed	750	220
			Quenched and tempered	1000	300
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200
			Quenched and tempered	930	275
				1000	300
				1200	350
	High alloyed steel, cast steel, and tool steel		Annealed	680	200
			Quenched and tempered	1100	325
	Stainless steel and cast steel		Ferritic/martensitic	680	200
			Martensitic	820	240
M	Stainless steel		Annealed	600	180
K	Cast iron nodular (GGG)		Ferritic/martensitic		180
			Pearlitic		260
	Grey cast iron (GG)		Ferritic		160
			Pearlitic		250
	Malleable cast iron		Ferritic		130
			Pearlitic		230
N	Aluminum- wrought alloy		Not cureable		60
			Cured		100
	Aluminum-cast, alloyed	=<12% Si	Not cureable		75
			Cured		90
		>12% Si	High temperature		130
	Copper alloys	>1% Pb	Free cutting		110
			Brass		90
			Electrolitic copper		100
	Non-metallic		Duroplastics, fiber plastics		
			Hard rubber		
S	High temp. alloys	Fe based	Annealed		200
			Cured		280
		Ni or Co based	Annealed		250
			Cured		350
			Cast		320
	Titanium Ti alloys			RM 400	
			Alpha+beta alloys cured	RM 1050	
H	Hardened steel		Hardened		55 HRC
			Hardened		60 HRC
	Chilled cast iron		Cast		400
	Cast iron		Hardened		55 HRC

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

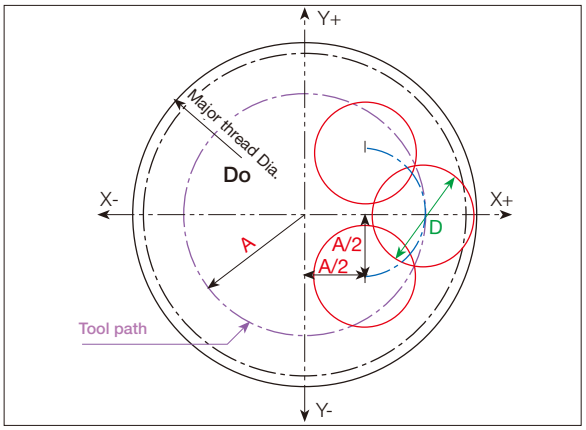
h long cutting flute, reduce feed rate by 40%.

Thread Milling CNC Program for Internal Thread

Right-hand thread (climb milling) from bottom up.
Program is based on tool center.
This method of programming needs no tool radius compensation value, other than an offset for wear

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

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



General Program

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

Internal Thread

Example: M20x2.0 **IN-RH** (Thread depth 20 mm)
Tool : **MTEC1010C27 2.0ISO**
(Cutting dia. 10 mm)
A=(**Do**-**D**)/2=(20-10)/2=5
A/2=2.5
(Tool compensation of radius=0)

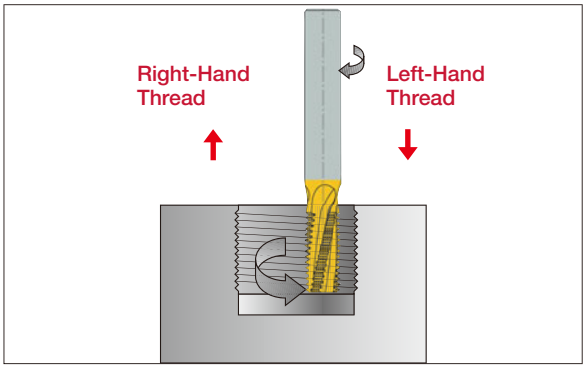
G90 G0 G54 G43 G17 **H1X0 Y0 Z10 S**4000
G0 **Z**-20
G01 G91 G41 **D1X** 2.5 **Y**-2.5 **Z0 F**840
G03 **X**2.5 **Y**2.5 **R**2.5 **Z**0.25 F420
G03 **X0 Y0 I**-5.0 **J0 Z**2.0
G03 **X**-2.5 **Y**2.5 **R**2.5 **Z**0.25
G01 G40 **X**-2.5 **Y**-2.5 **Z0**
G90 G0 **X0 Y0 Z0**
M30
%

F (Center of tool) = n x *f* x z

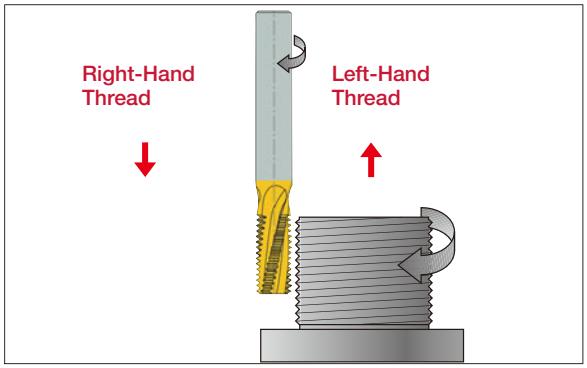
F (Cutting edge) = $\frac{Do - D}{Do}$ x n x *f* x z

n : Number of revolutions
f : rev / tooth
z : Number of edge

Internal Thread



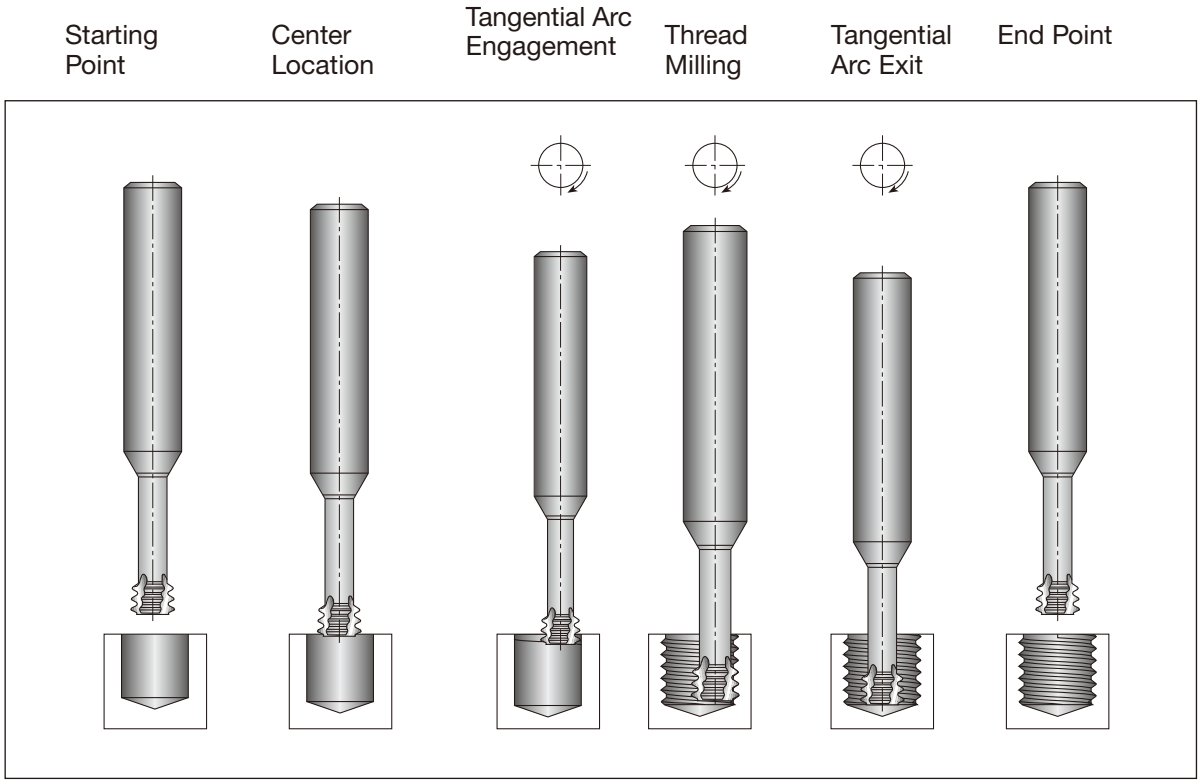
External Thread



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

MTECS
Small Diameter, Short type

Thread Milling - Recommended Procedure



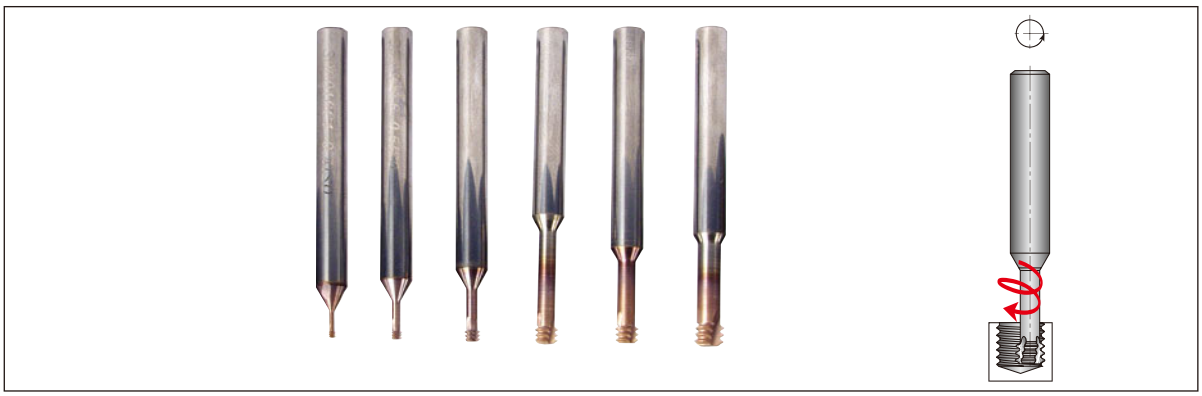
STANDARD CUTTING CONDITIONS

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

MTECS
Small Diameter, Short type

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

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



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

SolidThread vs. Tap

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

Features

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

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Check our site and our App to get more info!

Tungaloy Corporation (Head office)
11-1 Yoshima-Kogyodanchi
Iwaki-city, Fukushima, 970-1144 Japan
Phone: +81-246-36-8501
Fax: +81-246-36-8542
www.tungaloy.co.jp

Tungaloy America, Inc.
3726 N Ventura Drive
Arlington Heights,IL 60004, U.S.A.
Phone: +1-888-554-8394
Fax: +1-888-554-8392
www.tungaloy.com/us

Tungaloy Canada
432 Elgin St. Unit 3
Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779
Fax: +1-519-758-5791
www.tungaloy.com/ca

Tungaloy de Mexico S.A.
C Los Arellano 113,
Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410
Fax: +52-449-929-5411
www.tungaloy.com/mx

Tungaloy do Brasil Ltda.
Avd. Independencia N4158 Residencial Flora
13280-000 Vinhedo, São Paulo, Brasil
Phone: +55-19-38262757
Fax: +55-19-38262757
www.tungaloy.com/br

Tungaloy Germany GmbH
An der Alten Ziegelei 1
D-40789 Monheim, Germany
Phone: +49-2173-90420-0
Fax: +49-2173-90420-19
www.tungaloy.de

Tungaloy France S.A.S.
ZA Courtaboeuf - Le Rio
1 rue de la Terre de feu
F-91952 Courtaboeuf Cedex, France
Phone: +33-1-6486-4300
Fax: +33-1-6907-7817
www.tungaloy.fr

Tungaloy Italia S.r.l.
Via E. Andolfato 10
I-20126 Milano, Italy
Phone: +39-02-252012-1
Fax: +39-02-252012-65
www.tungaloy.it

Tungaloy Czech s.r.o.
Turanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391
Fax: +420-532 123 392
www.tungaloy.cz

Tungaloy Ibérica S.L.
C/Miquel Servet, 43B, Nau 7
Pol. Ind. Bufalvent
ES-08243 Manresa (BCN), Spain
Phone: +34 93 113 1360
Fax: +34 93 876 2798
www.tungaloy.es

Tungaloy Scandinavia AB
Bultgatan 38
442 40 Kungälv, Sweden
Phone: +46-462119200
www.tungaloy.se

Tungaloy Rus, LLC
115432, Moscow, Andropov Avenue, 18,
building 7, 11th floor (office 3). Metro station
"Technopark". Business center «I-Land».
Phone: +7-499-683-01-80/81
www.tungaloy.com/ru

Tungaloy Polska Sp. z o.o.
ul. Genewska 24
03-963 Warszawa, Poland
Phone: +48-22-617-0890
Fax: +48-22-617-0890
www.tungaloy.com/pl

Tungaloy U.K. Ltd
Gallan Park
Watling Street
Cannock WS11 0XG, UK
Phone: +44 121 4000 231
Fax: +44 121 270 9694
www.tungaloy.com/uk
salesinfo@tungaloyuk.co.uk

Tungaloy Hungary Kft
Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: +36 1 781-6846
Fax: +36 1 781-6866
www.tungaloy.com/hu
info@tungaloytools.hu

Tungaloy Turkey
Dudullu,OSB 4. Cad No:4
34776 Umraniye Istanbul, TURKEY
Phone: +90 216 540 04 67
Fax: +90 216 540 04 87
www.tungaloy.com.tr
info@tungaloy.com.tr

Tungaloy Benelux b.v.
Tjalk 70
NL-2411 NZ Bodegraven, Netherlands
Phone: +31 172 630 420
Fax: +31 172 630 429
www.tungaloy-benelux.com

Tungaloy Croatia
Ulica bana Josipa Jelačića 87,
10430 Samobor
Phone: +385 1 3326 604
Fax: +385 1 3327 683
www.tungaloy.hr

Tungaloy Cutting Tool (Shanghai) Co.,Ltd.
Rm No 401 No.88 Zhabei
Jiangchang No.3 Rd
Shanghai 200436, China
Phone: +86-21-3632-1880
Fax: +86-21-3621-1918
www.tungaloy.com/cn

Tungaloy Cutting Tools Taiwan Co.,Ltd.
9F.No.293, Zhongyang Rd.
Xinzhuang Dist.
New Taipei City 24251
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy Cutting Tool (Thailand) Co.,Ltd.
Interlink tower 4th Fl.
1858/5-7 Bangna-Trad Road
km.5 Bangna, Bangna, Bangkok 10260
Thailand
Phone: +66-2-751-5711
Fax: +66-2-751-5715
www.tungaloy.co.th

Tungaloy Singapore (Pte.), Ltd.
62 Ubi Road 1, #06-11 Oxley BizHub 2
Singapore 408734
Phone: +65-6391-1833
Fax: +65-6299-4557
www.tungaloy.com/sg

Tungaloy Vietnam
LE04.38, Lexington Residence
67 Mai Chi Tho St., Dist. 2,
Ho Chi Minh City, Vietnam
Phone: +84-2837406660
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Tungaloy India Pvt. Ltd.
Indiabulls Finance Centre,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai -400013, India
Phone: +91-22-6124-8804
Fax: +91-22-6124-8899
www.tungaloy.com/in

Tungaloy Korea Co., Ltd
#1312, Byucksan Digital Valley 5-cha
Beotkkot-ro 244, Geumcheon-gu
153-788 Seoul, Korea
Phone: +82-2-2621-6161
Fax: +82-2-6393-8952
www.tungaloy.com/kr

Tungaloy Malaysia Sdn Bhd
50 K-2, Kelana Mall, Jalan SS6/14
Kelana Jaya, 47301
Petaling Jaya, Selangor Darul Ehsan
Malaysia
Phone: +603-7805-3222
Fax: +603-7804-8563
www.tungaloy.com/my

Tungaloy Australia Pty Ltd
PO Box 2232, 68/1470
Ferntree Gully Road, Knoxfield
Victoria 3180, Australia
Phone: +61-3-9755-8147
Fax: +61-3-9755-6070
www.tungaloy.com.au

PT. Tungaloy Indonesia
Kompleks Grand Wisata Block AA-10 No.3-5
Cibitung
Bekasi 17510, Indonesia
Phone: +62-21-8261-5808
Fax: +62-21-8261-5809
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