

RAPID THREAD

New design indexable threadmilling inserts and tool holders allow for a profitable and effective way to produce external and internal applications quickly while generating superior surface finish.

Diameters:

.312", .375", .500", .625", .750",
1.000", 1.250", 1.500"

Insert Sizes:

12mm (0.472"), 14mm (0.551"),
21mm (0.827"), 30mm (1.181"),
40mm (1.575")

Thread Forms:

UN, ISO, NPT, NPTF, W, BSPT,
NPS, NPSF, ABUT, PG

Applications:

All threading applications
performed on a milling machine

Materials:

Steel, Stainless Steel, Cast Iron,
Aluminum, Titanium and other high
temperature or nickel based alloys

Series:

MTE D - End mill, Steel, Single Eff.
MTE D-2 - End mill, Steel, Two Eff.
MTE D-C - End mill, Carbide, Single Eff.
MTF D - Shell mill, Steel



Series Features:

- **NEW** New design for all threadmilling inserts and tool holders
- **NEW** New easy to decipher nomenclature
- **NEW** Additional thread forms now available
- Nickel-plated tool holders provide resistance to corrosion/abrasion
- Improved rigidity
- Improved chip removal

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Member IMC Group
Ingersoll
Cutting Tools

HIGHLIGHTS

Ingersoll Cutting Tools has implemented a new design change that affects all indexable threadmilling inserts and tool holders.

Inserts

The new design inserts can be identified by the two rear chamfers along with new designations defined by "-1"



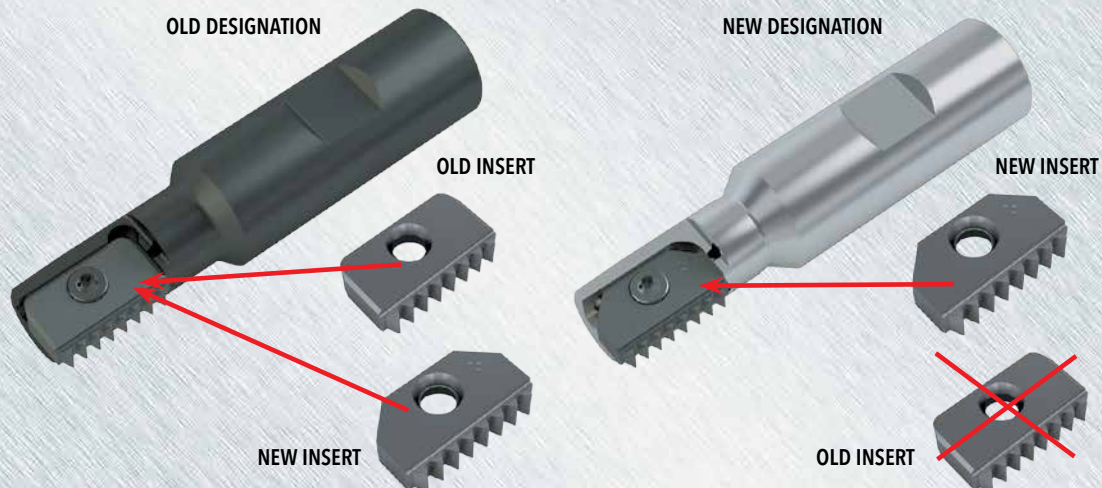
Tool Holders

Tool holder pockets have also been modified to accommodate the new design inserts. Bodies were redesigned for higher rigidity. Nickel plating provides more resistance to corrosion and abrasion for better chip flow.



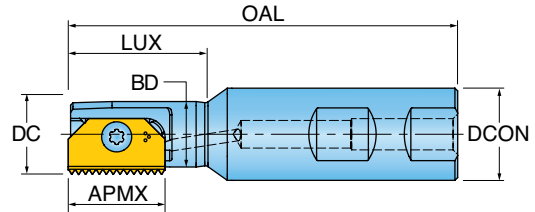
IMPORTANT NOTE:

The old inserts can only be clamped onto the older tools, while the new inserts can be clamped on either the new or old tools. Attached are the catalog pages of the new inserts and tools, and a list of the new item designations and catalog numbers vs. the old ones.



SERIES MTE D

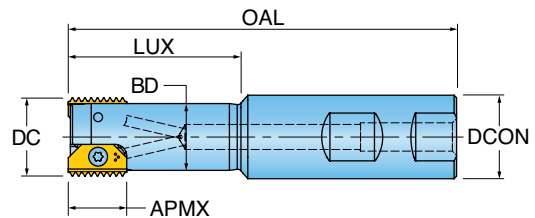
INDEXABLE THREAD MILL HOLDERS - WELDON STEEL



Part Number	DC Cutting Dia.	APMX Depth of Cut Max.	INSL Insert Length	LUX Usable Length Max.	OAL Overall Length	BD Body Diameter	ZEFF Effective Flutes	DCON Shank Dia.
MTE D0.375-A-W0.75-12	0.375	0.472	0.472 (12 mm)	0.55	3.35	0.30	1	0.750
MTE D0.39-1-W0.75-12	0.390	0.472	0.472 (12 mm)	0.64	3.35	0.30	1	0.750
MTE D0.50-1-W0.75-14	0.500	0.551	0.551 (14 mm)	0.70	2.95	0.37	1	0.750
MTE D0.54-1-W0.75-14	0.540	0.551	0.551 (14 mm)	0.77	2.98	0.38	1	0.750
MTE D0.57-1-W0.75-14	0.570	0.551	0.551 (14 mm)	1.00	3.20	0.41	1	0.750
MTE D0.67-1-W0.75-14	0.670	0.551	0.551 (14 mm)	1.18	3.35	0.51	1	0.750
MTE D0.79-1-W0.75-21	0.790	0.827	0.827 (21 mm)	1.57	3.70	0.59	1	0.750
MTE D0.94-1-W0.75-21	0.940	0.827	0.827 (21 mm)	-	5.00	-	1	0.750
MTE D1.16-1-W1.00-30	1.156	1.181	1.181 (30 mm)	1.96	4.25	0.87	1	1.000
MTE D1.25-1-W1.00-30	1.250	1.181	1.181 (30 mm)	-	6.00	-	1	1.000
MTE D1.50-1-W1.25-30	1.500	1.181	1.181 (30 mm)	-	6.00	-	1	1.250
MTE D1.75-1-W1.50-40	1.750	1.575	1.575 (40 mm)	3.31	6.00	1.38	1	1.500

SERIES MTE D-2

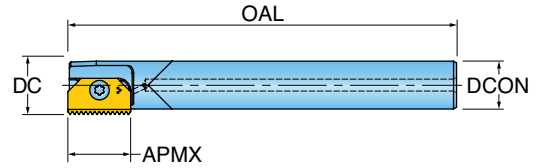
MULTI-FLUTE INDEXABLE THREAD MILL HOLDERS - WELDON STEEL



Part Number	DC Cutting Dia.	APMX Depth of Cut Max.	INSL Insert Length	LUX Usable Length Max.	OAL Overall Length	BD Body Diameter	ZEFF Effective Flutes	DCON Shank Dia.
MTE D0.79-2-W0.75-14	0.790	0.551	0.551 (14 mm)	1.54	3.66	0.63	2	0.750
MTE D1.18-2-W1.00-21	1.180	0.827	0.827 (21 mm)	1.97	4.25	0.95	2	1.000
MTE D1.56-2-W1.25-30	1.560	1.181	1.181 (30 mm)	2.84	5.13	1.18	2	1.250
MTE D2.00-2-W1.50-40	2.000	1.575	1.575 (40 mm)	3.35	6.00	1.48	2	1.500

SERIES MTE D-C

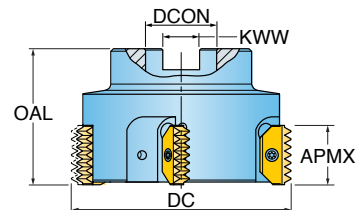
INDEXABLE THREAD MILL HOLDERS - CYLINDRICAL CARBIDE



Part Number	DC Cutting Dia.	APMX Depth of Cut Max.	INSL Insert Length	OAL Overall Length	ZEFF Effective Flutes	DCON Shank Dia.
MTE D0.39-1-C12C-12	0.390	0.472	0.472 (12 mm)	5.13	1	0.312
MTE D0.50-1-C.375C-14	0.500	0.551	0.551 (14 mm)	6.13	1	0.375
MTE D0.62-1-C.500C-14	0.620	0.551	0.551 (14 mm)	7.05	1	0.500
MTE D0.82-1-C.625C-21	0.820	0.827	0.827 (21 mm)	8.12	1	0.625

SERIES MTF D (SHELL MILL)

INDEXABLE SHELL MILL HOLDERS - MULTI-FLUTE

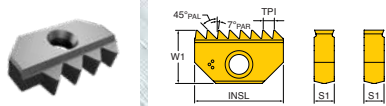


Part Number	DC Cutting Dia.	APMX Depth of Cut Max.	INSL Insert Length	OAL Overall Length	ZEFF Effective Flutes	DCON Shank Dia.	KWW Keyway	WT Weight (lbs.)
MTF D2.50-5-.75-21	2.500	0.827	0.827 (21 mm)	2.00	5	0.750	0.312	1.01
MTF D2.50-4-.75-30	2.500	1.181	1.181 (30 mm)	1.97	4	0.750	0.312	1.43
MTF D3.15-4-1.25-40	3.150	1.575	1.575 (40 mm)	2.00	4	1.250	0.500	4.63
MTF D4.00-4-1.25-30	4.000	1.181	1.181 (30 mm)	2.00	4	1.250	0.500	4.63
MTF D4.00-4-1.25-40	4.000	1.575	1.575 (40 mm)	2.00	4	1.250	0.500	4.63

NEW

ABUT (EXTERNAL & INTERNAL) INSERTS

LYEU_AB

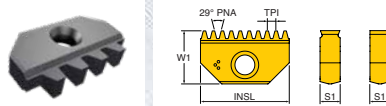


Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU21080AB-1	8	0.472	0.827 (21mm)	0.185	•	
LYEU21100AB-1	10	0.472	0.827 (21mm)	0.185	•	
LYEU21120AB-1	12	0.472	0.827 (21mm)	0.185	•	
LYEU21160AB-1	16	0.472	0.827 (21mm)	0.185	•	
LYEU30040AB-1	4	0.630	1.181 (30mm)	0.217	•	
LYEU30060AB-1	6	0.630	1.181 (30mm)	0.217	•	
LYEU30080AB-1	8	0.630	1.181 (30mm)	0.217	•	
LYEU30100AB-1	10	0.630	1.181 (30mm)	0.217	•	
LYEU30120AB-1	12	0.630	1.181 (30mm)	0.217	•	
LYEU30160AB-1	16	0.630	1.181 (30mm)	0.217	•	
LYEU40040AB-1	4	0.787	1.575 (40mm)	0.248	•	

NEW

ACME (INTERNAL) INSERTS

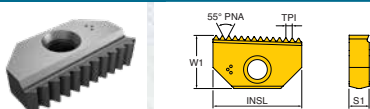
LYEU_AC



Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU21100AC-1	10	0.472	0.827 (21mm)	0.185	•	
LYEU21120AC-1	12	0.472	0.827 (21mm)	0.185	•	
LYEU30040AC-1	4	0.630	1.181 (30mm)	0.217	•	
LYEU30050AC-1	5	0.630	1.181 (30mm)	0.217	•	
LYEU30060AC-1	6	0.630	1.181 (30mm)	0.217	•	
LYEU30080AC-1	8	0.630	1.181 (30mm)	0.217	•	
LYEU30100AC-1	10	0.630	1.181 (30mm)	0.217	•	
LYEU30120AC-1	12	0.630	1.181 (30mm)	0.217	•	
LYEU40030AC-1	3	0.787	1.575 (40mm)	0.248	•	
LYEU40035AC-1	3.5	0.787	1.575 (40mm)	0.248	•	

BSPT (EXTERNAL & INTERNAL) INSERTS

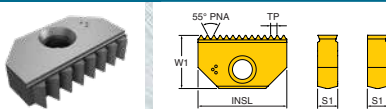
LYEU_BT



Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12190BT-1	19	0.256	0.472 (12mm)	0.114	•	
LYEU14140BT-1	14	0.311	0.551 (14mm)	0.126	•	
LYEU14190BT-1	19	0.311	0.551 (14mm)	0.126	•	
LYEU21110BT-1	11	0.496	0.827 (21mm)	0.189	•	
LYEU21140BT-1	14	0.496	0.827 (21mm)	0.189	•	
LYEU30110BT-1	11	0.657	1.181 (30mm)	0.220	•	
LYEU40110BT-1	11	0.819	1.575 (40mm)	0.252	•	

W (EXTERNAL & INTERNAL) INSERTS

LYEU_BW

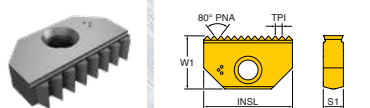


Part Number	TP Thread Pitch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12190BW-1	19.00	0.256	0.472 (12mm)	0.114	•	
LYEU14140BW-1	14.00	0.311	0.551 (14mm)	0.126	•	
LYEU14160BW-1	16.00	0.311	0.551 (14mm)	0.126	•	
LYEU14190BW-1	19.00	0.311	0.551 (14mm)	0.126	•	
LYEU14200BW-1	20.00	0.311	0.551 (14mm)	0.126	•	
LYEU14240BW-1	24.00	0.311	0.551 (14mm)	0.126	•	
LYEU21110BW-1	11.00	0.496	0.827 (21mm)	0.189	•	
LYEU21140BW-1	14.00	0.496	0.827 (21mm)	0.189	•	
LYEU21160BW-1	16.00	0.496	0.827 (21mm)	0.189	•	
LYEU21190BW-1	19.00	0.496	0.827 (21mm)	0.189	•	
LYEU21200BW-1	20.00	0.496	0.827 (21mm)	0.189	•	
LYEU30110BW-1	11.00	0.657	1.181 (30mm)	0.220	•	
LYEU30140BW-1	14.00	0.657	1.181 (30mm)	0.220	•	
LYEU30160BW-1	16.00	0.657	1.181 (30mm)	0.220	•	
LYEU40080BW-1	8.00	0.819	1.575 (40mm)	0.252	•	
LYEU40110BW-1	11.00	0.819	1.575 (40mm)	0.252	•	

NEW

PG (EXTERNAL & INTERNAL) INSERTS

LYEU_PG

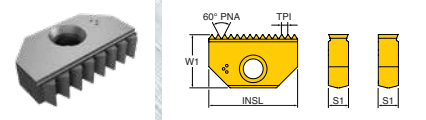


Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU14180PG-1	18	0.311	0.551 (14mm)	0.126	•	
LYEU21160PG-1	16	0.496	0.827 (21mm)	0.189	•	
LYEU21180PG-1	18	0.496	0.827 (21mm)	0.189	•	
LYEU30160PG-1	16	0.657	1.181 (30mm)	0.220	•	

NEW

NPS (EXTERNAL & INTERNAL) INSERTS

LYEU_NS

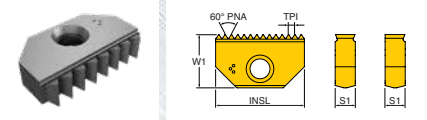


Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12180NS-1	18	0.256	0.472 (12mm)	0.114	•	
LYEU14140NS-1	14	0.311	0.551 (14mm)	0.126	•	
LYEU14180NS-1	18	0.311	0.551 (14mm)	0.126	•	
LYEU21115NS-1	11.5	0.496	0.827 (21mm)	0.189	•	
LYEU21140NS-1	14	0.472	0.827 (21mm)	0.185	•	
LYEU30080NS-1	8	0.630	1.181 (30mm)	0.217	•	
LYEU30115NS-1	11.5	0.630	1.181 (30mm)	0.217	•	
LYEU40080NS-1	8	0.787	1.575 (40mm)	0.248	•	
LYEU40115NS-1	11.5	0.787	1.575 (40mm)	0.248	•	

NEW

NPSF (EXTERNAL & INTERNAL) INSERTS

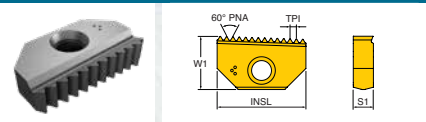
LYEU_NSF



Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12180NSF-1	18	0.248	0.472 (12mm)	0.114	•	
LYEU14140NSF-1	14	0.295	0.551 (14mm)	0.122	•	
LYEU14180NSF-1	18	0.295	0.551 (14mm)	0.122	•	
LYEU21115NSF-1	11.5	0.472	0.827 (21mm)	0.185	•	
LYEU21140NSF-1	14	0.472	0.827 (21mm)	0.185	•	
LYEU30080NSF-1	8	0.630	1.181 (30mm)	0.217	•	
LYEU30115NSF-1	11.5	0.630	1.181 (30mm)	0.217	•	
LYEU40080NSF-1	8	0.787	1.575 (40mm)	0.248	•	
LYEU40115NSF-1	11.5	0.787	1.575 (40mm)	0.248	•	

NPT (EXTERNAL & INTERNAL) INSERTS

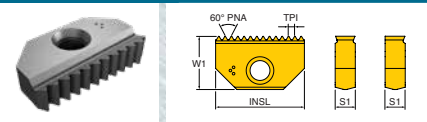
LYEU_NT



Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12180NT-1	18	0.256	0.472 (12mm)	0.114	•	
LYEU14140NT-1	14	0.311	0.551 (14mm)	0.126	•	
LYEU14180NT-1	18	0.311	0.551 (14mm)	0.126	•	
LYEU21115NT-1	11.5	0.496	0.827 (21mm)	0.189	•	
LYEU21140NT-1	14	0.496	0.827 (21mm)	0.189	•	
LYEU30080NT-1	8	0.657	1.181 (30mm)	0.220	•	
LYEU30115NT-1	11.5	0.657	1.181 (30mm)	0.220	•	
LYEU40080NT-1	8	0.819	1.575 (40mm)	0.252	•	
LYEU40115NT-1	11.5	0.819	1.575 (40mm)	0.252	•	

NPTF (EXTERNAL & INTERNAL) INSERTS

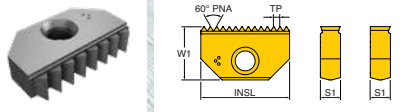
LYEU_NF



Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12180NF-1	18	0.256	0.472 (12mm)	0.114	•	
LYEU14140NF-1	14	0.311	0.551 (14mm)	0.126	•	
LYEU14180NF-1	18	0.311	0.551 (14mm)	0.126	•	
LYEU21115NF-1	11.5	0.496	0.827 (21mm)	0.189	•	
LYEU21140NF-1	14	0.496	0.827 (21mm)	0.189	•	
LYEU30080NF-1	8	0.630	1.181 (30mm)	0.217	•	
LYEU30115NF-1	11.5	0.657	1.181 (30mm)	0.220	•	
LYEU40080NF-1	8	0.787	1.575 (40mm)	0.248	•	
LYEU40115NF-1	11.5	0.787	1.575 (40mm)	0.248	•	

ISO (INTERNAL) INSERTS

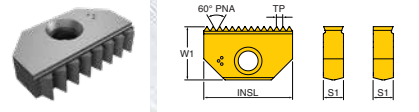
LYEU_IS



Part Number	TP Thread Pitch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12050IS-1	0.50	0.256	0.472 (12mm)	0.114	•	
LYEU12075IS-1	0.75	0.256	0.472 (12mm)	0.114	•	
LYEU12100IS-1	1.00	0.256	0.472 (12mm)	0.114	•	
LYEU12125IS-1	1.25	0.256	0.472 (12mm)	0.114	•	
LYEU12150IS-1	1.50	0.256	0.472 (12mm)	0.114	•	
LYEU12175IS-1	1.75	0.256	0.472 (12mm)	0.114	•	
LYEU14050IS-1	0.50	0.311	0.551 (14mm)	0.126	•	
LYEU14075IS-1	0.75	0.311	0.551 (14mm)	0.126	•	
LYEU14100IS-1	1.00	0.311	0.551 (14mm)	0.126	•	
LYEU14125IS-1	1.25	0.311	0.551 (14mm)	0.126	•	
LYEU14150IS-1	1.50	0.311	0.551 (14mm)	0.126	•	
LYEU14175IS-1	1.75	0.311	0.551 (14mm)	0.126	•	
LYEU14200IS-1	2.00	0.311	0.551 (14mm)	0.126	•	
LYEU14250IS-1	2.50	0.311	0.551 (14mm)	0.126	•	
LYEU21100IS-1	1.00	0.496	0.827 (21mm)	0.189	•	
LYEU21150IS-1	1.50	0.496	0.827 (21mm)	0.189	•	
LYEU21175IS-1	1.75	0.496	0.827 (21mm)	0.189	•	
LYEU21200IS-1	2.00	0.496	0.827 (21mm)	0.189	•	
LYEU21250IS-1	2.50	0.496	0.827 (21mm)	0.189	•	
LYEU21300IS-1	3.00	0.496	0.827 (21mm)	0.189	•	
LYEU21350IS-1	3.50	0.496	0.827 (21mm)	0.189	•	
LYEU30150IS-1	1.50	0.657	1.181 (30mm)	0.220	•	
LYEU30200IS-1	2.00	0.657	1.181 (30mm)	0.220	•	
LYEU30300IS-1	3.00	0.657	1.181 (30mm)	0.220	•	
LYEU30350IS-1	3.50	0.657	1.181 (30mm)	0.220	•	
LYEU30400IS-1	4.00	0.657	1.181 (30mm)	0.220	•	
LYEU30450IS-1	4.50	0.657	1.181 (30mm)	0.220	•	
LYEU30500IS-1	5.00	0.657	1.181 (30mm)	0.220	•	
LYEU40150IS-1	1.50	0.819	1.575 (40mm)	0.252	•	
LYEU40200IS-1	2.00	0.819	1.575 (40mm)	0.252	•	
LYEU40300IS-1	3.00	0.819	1.575 (40mm)	0.252	•	
LYEU40350IS-1	3.50	0.819	1.575 (40mm)	0.252	•	
LYEU40400IS-1	4.00	0.819	1.575 (40mm)	0.252	•	
LYEU40450IS-1	4.50	0.819	1.575 (40mm)	0.252	•	
LYEU40500IS-1	5.00	0.819	1.575 (40mm)	0.252	•	
LYEU40550IS-1	5.50	0.819	1.575 (40mm)	0.252	•	
LYEU40600IS-1	6.00	0.819	1.575 (40mm)	0.252	•	

ISO (EXTERNAL) INSERTS

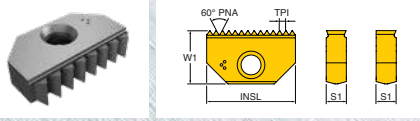
LYEU_IS-X



Part Number	TP Thread Pitch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU14075IS-X-1	0.75	0.311	0.551 (14mm)	0.126	•	
LYEU14100IS-X-1	1.00	0.311	0.551 (14mm)	0.126	•	
LYEU14125IS-X-1	1.25	0.311	0.551 (14mm)	0.126	•	
LYEU14150IS-X-1	1.50	0.311	0.551 (14mm)	0.126	•	
LYEU14175IS-X-1	1.75	0.311	0.551 (14mm)	0.126	•	
LYEU14200IS-X-1	2.00	0.311	0.551 (14mm)	0.126	•	
LYEU14250IS-X-1	2.50	0.311	0.551 (14mm)	0.126	•	
LYEU21100IS-X-1	1.00	0.496	0.827 (21mm)	0.189	•	
LYEU21150IS-X-1	1.50	0.496	0.827 (21mm)	0.189	•	
LYEU21200IS-X-1	2.00	0.496	0.827 (21mm)	0.189	•	
LYEU21250IS-X-1	2.50	0.496	0.827 (21mm)	0.189	•	
LYEU21300IS-X-1	3.00	0.496	0.827 (21mm)	0.189	•	
LYEU30150IS-X-1	1.50	0.657	1.181 (30mm)	0.220	•	
LYEU30200IS-X-1	2.00	0.657	1.181 (30mm)	0.220	•	
LYEU30300IS-X-1	3.00	0.657	1.181 (30mm)	0.220	•	
LYEU30350IS-X-1	3.50	0.657	1.181 (30mm)	0.220	•	
LYEU30400IS-X-1	4.00	0.657	1.181 (30mm)	0.220	•	
LYEU40150IS-X-1	1.50	0.819	1.575 (40mm)	0.252	•	
LYEU40200IS-X-1	2.00	0.819	1.575 (40mm)	0.252	•	
LYEU40300IS-X-1	3.00	0.819	1.575 (40mm)	0.252	•	
LYEU40400IS-X-1	4.00	0.819	1.575 (40mm)	0.252	•	
LYEU40500IS-X-1	5.00	0.819	1.575 (40mm)	0.252	•	
LYEU40600IS-X-1	6.00	0.819	1.575 (40mm)	0.252	•	

UN (INTERNAL) INSERTS

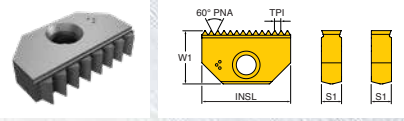
LYEU_UN



Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU12160UN-1	16	0.256	0.472 (12mm)	0.114	•	
LYEU12180UN-1	18	0.256	0.472 (12mm)	0.114	•	
LYEU12200UN-1	20	0.256	0.472 (12mm)	0.114	•	
LYEU12240UN-1	24	0.256	0.472 (12mm)	0.114	•	
LYEU12280UN-1	28	0.256	0.472 (12mm)	0.114	•	
LYEU12320UN-1	32	0.256	0.472 (12mm)	0.114	•	
LYEU14100UN-1	10	0.311	0.551 (14mm)	0.126	•	
LYEU14110UN-1	11	0.311	0.551 (14mm)	0.126	•	
LYEU14120UN-1	12	0.311	0.551 (14mm)	0.126	•	
LYEU14140UN-1	14	0.311	0.551 (14mm)	0.126	•	
LYEU14160UN-1	16	0.311	0.551 (14mm)	0.126	•	
LYEU14180UN-1	18	0.311	0.551 (14mm)	0.126	•	
LYEU14200UN-1	20	0.311	0.551 (14mm)	0.126	•	
LYEU14240UN-1	24	0.311	0.551 (14mm)	0.126	•	
LYEU14270UN-1	27	0.311	0.551 (14mm)	0.126	•	
LYEU14280UN-1	28	0.311	0.551 (14mm)	0.126	•	
LYEU14320UN-1	32	0.311	0.551 (14mm)	0.126	•	
LYEU21070UN-1	7	0.496	0.827 (21mm)	0.189	•	
LYEU21080UN-1	8	0.496	0.827 (21mm)	0.189	•	
LYEU21100UN-1	10	0.496	0.827 (21mm)	0.189	•	
LYEU21120UN-1	12	0.496	0.827 (21mm)	0.189	•	
LYEU21140UN-1	14	0.496	0.827 (21mm)	0.189	•	
LYEU21160UN-1	16	0.496	0.827 (21mm)	0.189	•	
LYEU21180UN-1	18	0.496	0.827 (21mm)	0.189	•	
LYEU21200UN-1	20	0.496	0.827 (21mm)	0.189	•	
LYEU21240UN-1	24	0.496	0.827 (21mm)	0.189	•	
LYEU30050UN-1	5	0.657	1.181 (30mm)	0.220	•	
LYEU30060UN-1	6	0.657	1.181 (30mm)	0.220	•	
LYEU30080UN-1	8	0.657	1.181 (30mm)	0.220	•	
LYEU30100UN-1	10	0.657	1.181 (30mm)	0.220	•	
LYEU30120UN-1	12	0.657	1.181 (30mm)	0.220	•	
LYEU30140UN-1	14	0.657	1.181 (30mm)	0.220	•	
LYEU30160UN-1	16	0.657	1.181 (30mm)	0.220	•	
LYEU30180UN-1	18	0.657	1.181 (30mm)	0.220	•	
LYEU30200UN-1	20	0.657	1.181 (30mm)	0.220	•	
LYEU40040UN-1	4	0.819	1.575 (40mm)	0.252	•	
LYEU40045UN-1	4.5	0.819	1.575 (40mm)	0.252	•	
LYEU40060UN-1	6	0.819	1.575 (40mm)	0.252	•	
LYEU40080UN-1	8	0.819	1.575 (40mm)	0.252	•	
LYEU40110UN-1	10	0.819	1.575 (40mm)	0.252	•	
LYEU40120UN-1	12	0.819	1.575 (40mm)	0.252	•	
LYEU40140UN-1	14	0.819	1.575 (40mm)	0.252	•	
LYEU40160UN-1	16	0.819	1.575 (40mm)	0.252	•	

UN (EXTERNAL) INSERTS

LYEU_UN-X



Part Number	TPI Threads Per Inch	W1 Insert Width	INSL Insert Length	S1 Overall Insert Thickness	Grade	IN2005
LYEU14120UN-X-1	12	0.311	0.551 (14mm)	0.126	•	
LYEU14140UN-X-1	14	0.311	0.551 (14mm)	0.126	•	
LYEU14160UN-X-1	16	0.311	0.551 (14mm)	0.126	•	
LYEU14180UN-X-1	18	0.311	0.551 (14mm)	0.126	•	
LYEU14200UN-X-1	20	0.311	0.551 (14mm)	0.126	•	
LYEU14240UN-X-1	24	0.311	0.551 (14mm)	0.126	•	
LYEU14280UN-X-1	28	0.311	0.551 (14mm)	0.126	•	
LYEU14320UN-X-1	32	0.311	0.551 (14mm)	0.126	•	
LYEU21100UN-X-1	10	0.496	0.827 (21mm)	0.189	•	
LYEU21120UN-X-1	12	0.496	0.827 (21mm)	0.189	•	
LYEU21140UN-X-1	14	0.496	0.827 (21mm)	0.189	•	
LYEU21160UN-X-1	16	0.496	0.827 (21mm)	0.189	•	
LYEU21180UN-X-1	18	0.496	0.827 (21mm)	0.189	•	
LYEU21200UN-X-1	20	0.496	0.827 (21mm)	0.189	•	
LYEU21240UN-X-1	24	0.496	0.827 (21mm)	0.189	•	
LYEU30060UN-X-1	6	0.657	1.181 (30mm)	0.220	•	
LYEU30080UN-X-1	8	0.657	1.181 (30mm)	0.220	•	
LYEU30100UN-X-1	10	0.657	1.181 (30mm)	0.220	•	
LYEU30120UN-X-1	12	0.657	1.181 (30mm)	0.220	•	
LYEU30140UN-X-1	14	0.657	1.181 (30mm)	0.220	•	
LYEU30160UN-X-1	16	0.657	1.181 (30mm)	0.220	•	
LYEU30180UN-X-1	18	0.657	1.181 (30mm)	0.220	•	
LYEU30200UN-X-1	20	0.657	1.181 (30mm)	0.220	•	
LYEU40060UN-X-1	6	0.819	1.575 (40mm)	0.252	•	
LYEU40080UN-X-1	8	0.819	1.575 (40mm)	0.252	•	
LYEU40110UN-X-1	11	0.819	1.575 (40mm)	0.252	•	
LYEU40120UN-X-1	12	0.819	1.575 (40mm)	0.252	•	
LYEU40140UN-X-1	14	0.819	1.575 (40mm)	0.252	•	
LYEU40160UN-X-1	16	0.819	1.575 (40mm)	0.252	•	

MACHINING DATA FOR INDEXABLE INSERT THREADING TOOLS

Main ISO-group	Workpiece Material	Condition	Material Group	Tensile Strength (N/mm ²)	Hardness	IN 2005	
						Cutting speed (SFM)	
P	Non-alloy Steel, Cast Steel, Free Cutting Steel	< 0,25 % C	Annealed	1	420	125	330-1085
		>= 0,25 % C	Annealed	2	650	190	265-690
		< 0,55 % C	Quenched and Tempered	3	850	250	215-600
		>= 0,55 % C	Annealed	4	750	220	360-590
	Low Alloy Steel and Cast Steel (with less than 5 % C)	Quenched and Tempered	5	1000	300	315-525	
		Annealed	6	600	200	300-525	
		Quenched and Tempered	7	930	275	215-660	
		Quenched and Tempered	8	1000	300	230-690	
	High Alloy Steel, Cast Steel and Tool Steel	Quenched and Tempered	9	1200	350	315-525	
		Annealed	10	680	200	430-600	
		Quenched and Tempered	11	1100	325	245-330	
M	Stainless Steel and Cast Steel	Ferritic, martensitic	12	680	200	360-600	
		Martensitic	13	820	240	230-510	
		Austenitic	14	600	180	280-330	
K	Gray Cast Iron (GG)	Ferritic	15	-	180	230-495	
		Pearlitic	16	-	260	360-500	
	Cast Iron Nodular (GGG)	Ferritic	17	-	160	400-525	
		Pearlitic	18	-	250	245-525	
	Malleable Cast Iron	Ferritic	19	-	130	400-525	
		Pearlitic	20	-	230	360-500	
N	Aluminum-wrought Alloy	Uncured	21	-	60	525-985	
		Cured	22	-	100	525-985	
	Aluminum Cast Alloy	<=12 % Si	Uncured	23	-	75	525-985
		Cured	24	-	90	525-985	
	Copper Alloys	>12 % Si	High temperature	25	-	130	525-985
		>1% Pb	Free cutting	26	-	110	525-985
			Brass	27	-	90	525-985
			Electrolytic copper	28	-	100	525-985
	Non-metallic	Duroplastics, fiber plastics	29	-	-	525-985	
		Hard Rubber	30	-	-	330-1315	
S	High Temp Alloys	Fe-based	Annealed	31	-	200	65-330
			Cured	32	-	280	65-330
		Ni/Co-based	Annealed	33	-	250	65-330
			Cured	34	-	350	65-330
			Cast	35	-	320	65-330
	Titanium & Titanium Alloys		36	RM 400	-	65-330	
		Alpha & beta alloys, cured	37	RM 1050	-	65-330	
H	Hardened Steel	Hardened	38	-	55 HRC	180-215	
		Hardened	39	-	60 HRC	150-180	
	Chilled Cast Iron	Cast	40	-	400	300-345	
	Cast Iron Nodular (GGG)	Hardened	41	-	55 HRC	180-215	

* For application specific feed rates, please refer to RapidThread Advisor - http://www.imc-companies.com/mtin_usa/

NEW/OLD PART NUMBERS

MTE D			
NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323190	MTE D0.375-A-W0.75-12	3026115	12Y1H-0301384R01
3346927	MTE D0.39-1-W0.75-12	3026116	12Y1H-0301384R02
3346920	MTE D0.50-1-W0.75-14	3026126	12Y1J-0501984R01
3320040	MTE D0.54-1-W0.75-14	3026128	12Y1J-0500984R01
3108492	MTE D0.57-1-W0.75-14	3026129	12Y1J-0501284R01
3346926	MTE D0.67-1-W0.75-14	3026131	12Y1J-0601384R01
3346910	MTE D0.79-1-W0.75-21	3026232	12Y1N-0701684R01
3346922	MTE D0.94-1-W0.75-21	3026143	12Y1N-0903084R01
3323480	MTE D1.16-1-W1.00-30	3026151	12Y1S-1102080R01
3346925	MTE D1.25-1-W1.00-30	3026152	12Y1S-1203780R01
3323481	MTE D1.50-1-W1.25-30	3026153	12Y1S-1503781R01
3323565	MTE D1.75-1-W1.50-40	3026163	12Y1U-1703386R01

MTE D-2			
NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3346928	MTE D0.79-2-W0.75-14	3026132	12Y1J-0701684R01
3320210	MTE D1.18-2-W1.00-21	3026144	12Y1N-1102080R01
3346930	MTE D1.56-2-W1.25-30	3026231	12Y1S-1502881R01
3323566	MTE D2.00-2-W1.50-40	3026164	12Y1U-1903386R01

MTE D-C			
NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323191	MTE D0.39-1-C12C-12	3181178	12Y5H-03035R7R01
3346923	MTE D0.50-1-C.375C-14	3026127	12Y5J-05044R8R01
3346924	MTE D0.62-1-C.500C-14	3026130	12Y5J-06052S4R01
3108493	MTE D0.82-1-C.625C-21	3026142	12Y5N-08060S6R01

MTF D			
NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3320209	MTF D2.50-5-.75-21	3181183	12Y1N-24019D1R01
3323478	MTF D2.50-4-.75-30	3026156	12Y1S-24019D1R01
3323479	MTF D4.00-4-1.25-30	3181184	12Y1S-39025D4R01
3323562	MTF D4.00-4-1.25-40	3026166	12Y1U-39027D4R01
3323563	MTF D3.15-4-1.25-40	3026165	12Y1U-31023D3R01

NEW/OLD PART NUMBERS

ABUT (AM. BUTTRESS) THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323493	LYEU21100AB-1		
3323494	LYEU21120AB-1		
3323495	LYEU21160AB-1		
3323496	LYEU21080AB-1		
3323378	LYEU30100AB-1		
3323379	LYEU30120AB-1		
3323447	LYEU30160AB-1		
5569496	LYEU30040AB-1		
5569519	LYEU30060AB-1		
3323448	LYEU30080AB-1		
3323553	LYEU40040AB-1		



ACME THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323497	LYEU21100AC-1		
3323498	LYEU21120AC-1		
3323368	LYEU30040AC-1		
3323370	LYEU30050AC-1		
3323369	LYEU30060AC-1		
3323371	LYEU30080AC-1		
3323366	LYEU30100AC-1		
3323367	LYEU30120AC-1		
3323537	LYEU40030AC-1		
3323539	LYEU40035AC-1		



BSPT THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323185	LYEU12190BT-1	5813040	LYEU12190BT
5669466	LYEU14140BT-1	5813086	LYEU14140BT
3320026	LYEU14190BT-1	5813087	LYEU14190BT
5669484	LYEU21110BT-1	5813099	LYEU21110BT
3320126	LYEU21140BT-1	5813100	LYEU21140BT
3323449	LYEU30110BT-1	5813118	LYEU30110BT
3323551	LYEU40110BT-1	5813131	LYEU40110BT

PG THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3320025	LYEU14180PG-1		
3320133	LYEU21160PG-1		
3320134	LYEU21180PG-1		
3323452	LYEU30160PG-1		



NPS THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323130	LYEU12180NS-1		
3320032	LYEU14140NS-1		
3320031	LYEU14180NS-1		
3320128	LYEU21115NS-1		
3320129	LYEU21140NS-1		
3323373	LYEU30115NS-1		
3323376	LYEU30080NS-1		
3323542	LYEU40115NS-1		
3323543	LYEU40080NS-1		



NPSF THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323136	LYEU12180NSF-1		
3320030	LYEU14140NSF-1		
3320029	LYEU14180NSF-1		
3320130	LYEU21115NSF-1		
3320132	LYEU21140NSF-1		
3323374	LYEU30115NSF-1		
3323377	LYEU30080NSF-1		
3323544	LYEU40115NSF-1		
3323545	LYEU40080NSF-1		



NEW/OLD PART NUMBERS

NPT THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
5669450	LYEU12180NT-1	5813036	LYEU12180NT
5669458	LYEU14140NT-1	5813035	LYEU14140NT
5669467	LYEU14180NT-1	5813058	LYEU14180NT
5669476	LYEU21115NT-1	5813101	LYEU21115NT
5669479	LYEU21140NT-1	5813102	LYEU21140NT
5669491	LYEU30115NT-1	5813034	LYEU30115NT
5669493	LYEU30080NT-1	5813116	LYEU30080NT
3223546	LYEU40115NT-1	5813129	LYEU40115NT
3323547	LYEU40080NT-1	5813130	LYEU40080NT

NPTF THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323149	LYEU12180NF-1	5813071	LYEU12180NF
3320028	LYEU14140NF-1	5813088	LYEU14140NF
3320027	LYEU14180NF-1	5813000	LYEU14180NF
5669478	LYEU21115NF-1	5813045	LYEU21115NF
3320125	LYEU21140NF-1	5813003	LYEU21140NF
3323375	LYEU30115NF-1	5813117	LYEU30115NF
3323372	LYEU30080NF-1	5813004	LYEU30080NF
3323550	LYEU40080NF-1	5813006	LYEU40080NF

W (WHITWORTH) THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
5669451	LYEU12190BW-1	5813066	LYEU12190BW
5669460	LYEU14140BW-1	5813084	LYEU14140BW
3320024	LYEU14160BW-1	5812997	LYEU14160BW
5669464	LYEU14190BW-1	5813085	LYEU14190BW
3320021	LYEU14200BW-1	5812998	LYEU14200BW
3320023	LYEU14240BW-1	5812999	LYEU14240BW
5669474	LYEU21110BW-1	5813041	LYEU21110BW
5669480	LYEU21140BW-1	5813042	LYEU21140BW
3320121	LYEU21160BW-1	5813043	LYEU21160BW
3320122	LYEU21190BW-1	5813001	LYEU21190BW
3320123	LYEU21200BW-1	5813002	LYEU21200BW
3323450	LYEU30140BW-1	5813114	LYEU30140BW
3323451	LYEU30160BW-1	5813115	LYEU30160BW
5669492	LYEU30110BW-1	5813044	LYEU30110BW
3323540	LYEU40110BW-1	5813127	LYEU40110BW
3323541	LYEU40080BW-1	5813128	LYEU40080BW

NEW/OLD PART NUMBERS

INTERNAL ISO THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323073	LYEU12050IS-1	5813024	LYEU12050IS
3323071	LYEU12075IS-1	5813025	LYEU12075IS
5669448	LYEU12100IS-1	5813067	LYEU12100IS
5669453	LYEU12125IS-1	5813068	LYEU12125IS
5669449	LYEU12150IS-1	5813010	LYEU12150IS
5669471	LYEU14050IS-1	5813018	LYEU14050IS
5669468	LYEU14075IS-1	5813090	LYEU14075IS
5669327	LYEU14100IS-1	5813089	LYEU14100IS
3319983	LYEU14125IS-1	5813046	LYEU14125IS
5669321	LYEU14150IS-1	5813055	LYEU14150IS
3319986	LYEU14175IS-1	5812944	LYEU14175IS
5669332	LYEU14200IS-1	5813054	LYEU14200IS
5669457	LYEU14250IS-1	5813053	LYEU14250IS
5669329	LYEU21100IS-1	5813051	LYEU21100IS
5669323	LYEU21150IS-1	5813050	LYEU21150IS
3320075	LYEU21175IS-1	5812945	LYEU21175IS
5669334	LYEU21200IS-1	5813048	LYEU21200IS
5669483	LYEU21250IS-1	5813108	LYEU21250IS
5669475	LYEU21300IS-1	5813047	LYEU21300IS
5669477	LYEU21350IS-1	5813065	LYEU21350IS
5669326	LYEU30150IS-1	5812948	LYEU30150IS
5669336	LYEU30200IS-1	5813038	LYEU30200IS
5669488	LYEU30300IS-1	5812949	LYEU30300IS
3323362	LYEU30350IS-1	5812950	LYEU30350IS
5669486	LYEU30400IS-1	5812951	LYEU30400IS
5669489	LYEU30450IS-1	5812952	LYEU30450IS
5669490	LYEU30500IS-1	5813039	LYEU30500IS
3323517	LYEU40150IS-1	5813137	LYEU40150IS
5669500	LYEU40200IS-1	5813138	LYEU40200IS
3323518	LYEU40300IS-1	5813139	LYEU40300IS
3323519	LYEU40350IS-1	5813140	LYEU40350IS
5669499	LYEU40400IS-1	5812954	LYEU40400IS
3323520	LYEU40450IS-1	5813037	LYEU40450IS
3323522	LYEU40500IS-1	5812955	LYEU40500IS
3323524	LYEU40550IS-1	5813141	LYEU40550IS
5669497	LYEU40600IS-1	5812956	LYEU40600IS

EXTERNAL ISO THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3319979	LYEU14075IS-X-1	5812941	LYEU14075IS-X
5669328	LYEU14100IS-X-1	5813026	LYEU14100IS-X
3319980	LYEU14125IS-X-1	5813076	LYEU14125IS-X
5669322	LYEU14150IS-X-1	5813077	LYEU14150IS-X
3319981	LYEU14175IS-X-1	5812942	LYEU14175IS-X
5669331	LYEU14200IS-X-1	5813078	LYEU14200IS-X
3319982	LYEU14250IS-X-1	5812943	LYEU14250IS-X
5669330	LYEU21100IS-X-1	5813052	LYEU21100IS-X
5669324	LYEU21150IS-X-1	5813104	LYEU21150IS-X
5669333	LYEU21200IS-X-1	5813105	LYEU21200IS-X
3320073	LYEU21250IS-X-1	5813106	LYEU21250IS-X
3320074	LYEU21300IS-X-1	5813016	LYEU21300IS-X
5669325	LYEU30150IS-X-1	5813056	LYEU30150IS-X
5669335	LYEU30200IS-X-1	5812946	LYEU30200IS-X
3323363	LYEU30300IS-X-1	5813119	LYEU30300IS-X
3323364	LYEU30350IS-X-1	5812947	LYEU30350IS-X
3323365	LYEU30400IS-X-1	5813049	LYEU30400IS-X
3323531	LYEU40150IS-X-1	5813132	LYEU40150IS-X
3323532	LYEU40200IS-X-1	5813133	LYEU40200IS-X
3323533	LYEU40300IS-X-1	5813134	LYEU40300IS-X
3323534	LYEU40400IS-X-1	5812953	LYEU40400IS-X
3323535	LYEU40500IS-X-1	5813135	LYEU40500IS-X
3323536	LYEU40600IS-X-1	5813136	LYEU40600IS-X

NEW/OLD PART NUMBERS

INTERNAL UN THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3323108	LYEU12160UN-1	5812971	LYEU12160UN
5669452	LYEU12180UN-1	5813069	LYEU12180UN
3323090	LYEU12200UN-1	5812970	LYEU12200UN
3323078	LYEU12240UN-1	5813070	LYEU12240UN
3323077	LYEU12280UN-1	5812969	LYEU12280UN
3323075	LYEU12320UN-1	5812968	LYEU12320UN
5669463	LYEU14100UN-1	5813009	LYEU14100UN
5669469	LYEU14110UN-1	5607297	LYEU14110UN
5669461	LYEU14120UN-1	5813095	LYEU14120UN
5669462	LYEU14140UN-1	5813029	LYEU14140UN
5669459	LYEU14160UN-1	5813096	LYEU14160UN
5669465	LYEU14180UN-1	5813030	LYEU14180UN
3319999	LYEU14200UN-1	5813097	LYEU14200UN
3320001	LYEU14240UN-1	5812972	LYEU14240UN
3320018	LYEU14270UN-1	5813098	LYEU14270UN
3320019	LYEU14280UN-1	5813031	LYEU14280UN
3320020	LYEU14320UN-1	5813057	LYEU14320UN
5669481	LYEU21070UN-1	5813109	LYEU21070UN
5669473	LYEU21080UN-1	5813007	LYEU21080UN
3320095	LYEU21100UN-1	5813110	LYEU21100UN
5669518	LYEU21120UN-1	5813027	LYEU21120UN
5669485	LYEU21140UN-1	5813028	LYEU21140UN
5669482	LYEU21160UN-1	5813111	LYEU21160UN
3320105	LYEU21180UN-1	5813112	LYEU21180UN
3320106	LYEU21200UN-1	5813113	LYEU21200UN
3320107	LYEU21240UN-1	5812976	LYEU21240UN
3323343	LYEU30050UN-1	5813599	LYEU30050UN
5669495	LYEU30060UN-1	5813125	LYEU30060UN
5669487	LYEU30080UN-1	5813126	LYEU30080UN
3323337	LYEU30100UN-1	5813008	LYEU30100UN
5669494	LYEU30120UN-1	5813122	LYEU30120UN
3323339	LYEU30140UN-1	5813123	LYEU30140UN
3323340	LYEU30160UN-1	5813124	LYEU30160UN
3323341	LYEU30180UN-1	5812978	LYEU30180UN
3323342	LYEU30200UN-1	5812977	LYEU30200UN
3323507	LYEU40040UN-1	5812960	LYEU40040UN
3323508	LYEU40045UN-1	5812959	LYEU40045UN
3323509	LYEU40060UN-1	5813032	LYEU40060UN
5669498	LYEU40080UN-1	5813033	LYEU40080UN
3323504	LYEU40120UN-1	5812957	LYEU40120UN
3323505	LYEU40140UN-1	5812980	LYEU40140UN
3323506	LYEU40160UN-1	5812979	LYEU40160UN

EXTERNAL UN THREADFORM

NEW Item Number	NEW Part Number	OLD Item Number	OLD Part Number
3319987	LYEU14120UN-X-1	5812975	LYEU14120UN-X
3319988	LYEU14140UN-X-1	5813079	LYEU14140UN-X
3319989	LYEU14160UN-X-1	5813080	LYEU14160UN-X
3319990	LYEU14180UN-X-1	5813081	LYEU14180UN-X
3319991	LYEU14200UN-X-1	5812974	LYEU14200UN-X
3319997	LYEU14240UN-X-1	5813082	LYEU14240UN-X
3319998	LYEU14280UN-X-1	5812973	LYEU14280UN-X
5669470	LYEU14320UN-X-1	5813083	LYEU14320UN-X
3320079	LYEU21100UN-X-1	5812987	LYEU21100UN-X
3320082	LYEU21120UN-X-1	5813107	LYEU21120UN-X
3320087	LYEU21140UN-X-1	5812985	LYEU21140UN-X
3320088	LYEU21160UN-X-1	5812984	LYEU21160UN-X
3320090	LYEU21180UN-X-1	5812983	LYEU21180UN-X
3320091	LYEU21200UN-X-1	5812982	LYEU21200UN-X
3320093	LYEU21240UN-X-1	5812981	LYEU21240UN-X
3323350	LYEU30060UN-X-1	5812994	LYEU30060UN-X
3323351	LYEU30080UN-X-1	5813121	LYEU30080UN-X
3323344	LYEU30100UN-X-1	5812993	LYEU30100UN-X
3323352	LYEU30120UN-X-1	5813120	LYEU30120UN-X
3323346	LYEU30140UN-X-1	5812992	LYEU30140UN-X
3323347	LYEU30160UN-X-1	5812990	LYEU30160UN-X
3323348	LYEU30180UN-X-1	5812989	LYEU30180UN-X
3323349	LYEU30200UN-X-1	5812988	LYEU30200UN-X
3323510	LYEU40110UN-X-1	5812962	LYEU40110UN-X
3323511	LYEU40120UN-X-1	5812961	LYEU40120UN-X
3323512	LYEU40140UN-X-1	5812996	LYEU40140UN-X
3323514	LYEU40160UN-X-1	5812995	LYEU40160UN-X
3323515	LYEU40060UN-X-1	5812964	LYEU40060UN-X
3323516	LYEU40080UN-X-1	5812963	LYEU40080UN-X



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