



1. Roughing Step Drill
2. AS5202 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. AS5202 X-Series Port Tool
3. 15° Helical Thread Mill



Scientific Cutting Tools

AS5202 Port Kits



COMPLETE METALWORKING SOLUTIONS  
 (800) 991-4225 www.ahbinc.com  
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The SCT 1-2-3 Kit For AS5202					
Includes one drill, one port tool, and one thread mill for specific port size.					
KIT WITH ROUGHING STEP DRILL, AS5202 PORT TOOL REAMER PILOT, AND THREAD MILL					
Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	RD-AS5202-02A	AS5202-02RA	TMI234-24HA	AS5202KIT02RA	410030
AS5202-3	RD-AS5202-03A	AS5202-03RA	TMI285-24HA	AS5202KIT03RA	410032
AS5202-4	RD-AS5202-04A	AS5202-04RA	TMI335-20HA	AS5202KIT04RA	410034
AS5202-5	RD-AS5202-05A	AS5202-05RA	TMI370-20HA	AS5202KIT05RA	410036
AS5202-6	RD-AS5202-06A	AS5202-06RA	TMI370-18HA	AS5202KIT06RA	410038
AS5202-8	RD-AS5202-08A	AS5202-08RA	TMI495-16HA	AS5202KIT08RA	410040
KIT WITH DFX DRILL, AS5202 COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL					
Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	DFX3-276A	AS5202-02XA	TMI234-24HA	AS5202KIT02XA	410042
AS5202-3	DFX3-338A	AS5202-03XA	TMI285-24HA	AS5202KIT03XA	410044
AS5202-4	DFX3-393A	AS5202-04XA	TMI335-20HA	AS5202KIT04XA	410046
AS5202-5	DFX3-455A	AS5202-05XA	TMI370-20HA	AS5202KIT05XA	410048
AS5202-6	DFX3-513A	AS5202-06XA	TMI370-18HA	AS5202KIT06XA	410050
AS5202-8	DFX3-693A	AS5202-08XA	TMI495-16HA	AS5202KIT08XA	410052

There are two kits available for completing an AS5202 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.

This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AITiN+ coated.



1. Roughing Step Drill
2. SAEJ1926 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. SAEJ1926 X-Series Port Tool
3. 15° Helical Thread Mill



## SAEJ1926 Port Kits

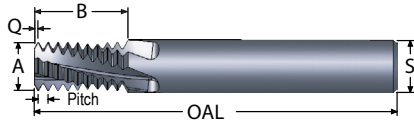
This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AlTiN+ coated.

The SCT 1-2-3 Kit For SAEJ1926					
Includes one drill, one port tool, and one thread mill for specific port size.					
KIT WITH ROUGHING STEP DRILL, SAE PORT TOOL REAMER PILOT, AND THREAD MILL					
Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
SAEJ1926-2	RD-SAE-02A	SAEJ1926-02RA	TMI234-24HA	SAEKIT02RA	410000
SAEJ1926-3	RD-SAE-03A	SAEJ1926-03RA	TMI285-24HA	SAEKIT03RA	410002
SAEJ1926-4	RD-SAE-04A	SAEJ1926-04RA	TMI335-20HA	SAEKIT04RA	410004
SAEJ1926-5	RD-SAE-05A	SAEJ1926-05RA	TMI370-20HA	SAEKIT05RA	410006
SAEJ1926-6	RD-SAE-06A	SAEJ1926-06RA	TMI370-18HA	SAEKIT06RA	410008
SAEJ1926-8	RD-SAE-08A	SAEJ1926-08RA	TMI495-16HA	SAEKIT08RA	410010
KIT WITH DFX DRILL, SAE COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL					
Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
SAEJ1926-2	DFX3-272A	SAEJ1926-02XA	TMI234-24HA	SAEKIT02XA	410012
SAEJ1926-3	DFX3-335A	SAEJ1926-03XA	TMI285-24HA	SAEKIT03XA	410014
SAEJ1926-4	DFX3-389A	SAEJ1926-04XA	TMI335-20HA	SAEKIT04XA	410016
SAEJ1926-5	DFX3-452A	SAEJ1926-05XA	TMI370-20HA	SAEKIT05XA	410018
SAEJ1926-6	DFX3-509A	SAEJ1926-06XA	TMI370-18HA	SAEKIT06XA	410020
SAEJ1926-8	DFX3-689A	SAEJ1926-08XA	TMI495-16HA	SAEKIT08XA	410022

There are two kits available for completing an SAEJ1926 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.

## UN THREAD MILLS

### 15° HELICAL FLUTE SOLID CARBIDE



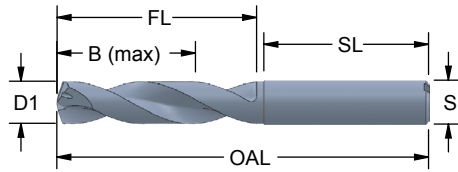
- Cuts UNC, UNF, UNEF, UNS and UNJ (internal only)
- Non-crest cutting allows maximum flexibility for plated and non-standard threads
- Long length-of-cut

MIN ID THREAD / PITCH*	"A" TOOL DIA.	"B" LENGTH OF CUT	"Q" LENGTH	"S" SHANK DIA.	CORRESPONDING PORT SIZE	OAL	FLUTES	ORDER #	EDP #
								AITiN+	AITiN+
5/16-24	0.234	0.641	0.019	0.250	AS5202-2	2.50	3	TMI234-24HA	102964
3/8-24	0.285	0.766	0.019	0.3125	AS5202-3	3.00	4	TMI285-24HA	102994
7/16-20	0.335	0.870	0.023	0.375	AS5202-4	3.00	4	TMI335-20HA	103024
9/16-18	0.370	0.911	0.025	0.375	AS5202-5	3.00	4	TMI370-18HA	103033
1/2-20	0.370	0.870	0.023	0.375	AS5202-6	3.00	4	TMI370-20HA	103034
3/4-16	0.495	1.338	0.028	0.500	AS5202-8	4.00	4	TMI495-16HA	103075

Thread mills can cut any larger size internal thread of the same pitch

## DFX DRILLS FOR AS5202 PORT SIZES

### SOLID CARBIDE, 140 DEGREE POINT, SCREW MACHINE LENGTH (3xD)

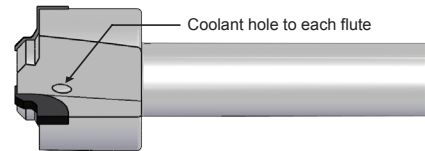
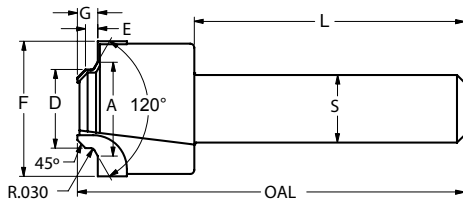


- Prepares hole for port tool by cutting minor thread diameter to size
- Coolant through for superior chip evacuation
- 140° self-centering point
- AITiN+ coating extends tool life and thermal stability

AS5202 SIZE	"S" SHANK DIA.	OAL	"D1" DRILL DIA. ± .0005	"FL" FLUTE LENGTH	"B" MAX DEPTH	"SL" SHANK LENGTH	ORDER #	EDP #
							AITiN+	AITiN+
2	8mm	79mm	0.276	1.34	0.92	1.42	DFX3-276A	407012
3	10mm	89mm	0.338	1.85	1.34	1.57	DFX3-338A	407014
4	10mm	89mm	0.393	1.85	1.26	1.57	DFX3-393A	407016
5	12mm	102mm	0.455	2.17	1.48	1.77	DFX3-455A	407018
6	14mm	107mm	0.513	2.36	1.59	1.77	DFX3-513A	407020
8	18mm	123mm	0.693	2.87	1.83	1.89	DFX3-693A	407022

## AS5202 (MS33649) PORT TOOL

### WITHOUT PILOT - CARBIDE TIPPED

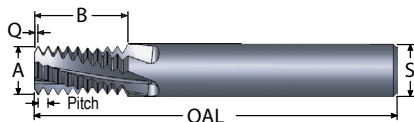


- Ideal for non-standard minor diameter lengths
- Polished flute face for optimum performance
- Meets the requirements of AS5202/MS33649 and AND10050 ports
- AITiN+ coating for improved surface finish
- Polished flute face for optimum performance
- The AS5202/MS33649 require a UNJ, the AND10050 thread requires a UN thread

A	D	E	G	F	S	L	OAL	FLUTES	TUBE	THREAD	ORDER #	EDP #
											AITiN+	AITiN+
0.446	0.3305	0.071	0.121	0.742	0.500	2.00	2.75	3	0.125	0.3125-24 UNJF-3B	AS5202-02XA	406853
0.508	0.3925	0.071	0.121	0.805	0.500	2.00	2.75	3	0.188	0.3750-24 UNJF-3B	AS5202-03XA	406855
0.570	0.4565	0.083	0.133	0.888	0.500	2.00	2.75	3	0.250	0.4375-20 UNJF-3B	AS5202-04XA	406857
0.633	0.5195	0.083	0.133	0.950	0.500	2.00	2.75	3	0.312	0.5000-20 UNJF-3B	AS5202-05XA	406859
0.696	0.5825	0.091	0.151	1.012	0.500	2.00	2.75	3	0.375	0.5625-18 UNJF-3B	AS5202-06XA	406861
0.758	0.6455	0.102	0.162	1.105	0.500	2.00	2.88	3	0.438	0.6250-18 UNJF-3B	AS5202-07XA	406863
0.883	0.7715	0.102	0.172	1.240	0.750	2.13	3.13	3	0.500	0.7500-16 UNJF-3B	AS5202-08XA	406865

## UN THREAD MILLS

### 15° HELICAL FLUTE SOLID CARBIDE



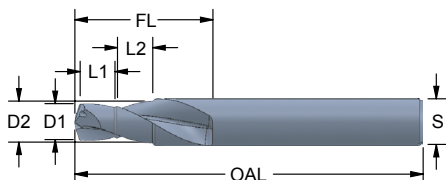
- Cuts UNC, UNF, UNEF, UNS and UNJ (internal only)
- Non-crest cutting allows maximum flexibility for plated and non-standard threads
- Long length-of-cut

MIN ID THREAD / PITCH*	"A" TOOL DIA.	"B" LENGTH OF CUT	"Q" LENGTH	"S" SHANK DIA.	CORRESPONDING PORT SIZE	OAL	FLUTES	ORDER #	EDP #
								AITiN+	AITiN+
								INTERNAL THREADS ONLY	
5/16-24	0.234	0.641	0.019	0.250	SAEJ1926-2	2.50	3	TMI234-24HA	102964
3/8-24	0.285	0.766	0.019	0.3125	SAEJ1926-3	3.00	4	TMI285-24HA	102994
7/16-20	0.335	0.870	0.023	0.375	SAEJ1926-4	3.00	4	TMI335-20HA	103024
9/16-18	0.370	0.911	0.025	0.375	SAEJ1926-5	3.00	4	TMI370-18HA	103033
1/2-20	0.370	0.870	0.023	0.375	SAEJ1926-6	3.00	4	TMI370-20HA	103034
3/4-16	0.495	1.338	0.028	0.500	SAEJ1926-8	4.00	4	TMI495-16HA	103075

Thread mills can cut any larger size internal thread of the same pitch

## ROUGHING STEP DRILLS FOR SAE J1926 PORT SIZES

SOLID CARBIDE, 140 DEGREE POINT, COOLANT THROUGH

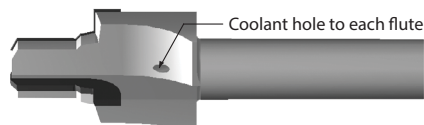
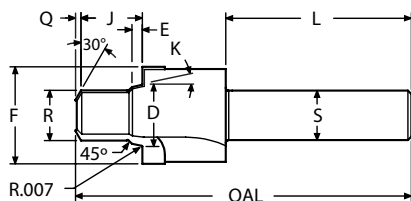


- Prepares hole for the port tool by roughing the minor-thread and sealing diameters
- Coolant through for superior chip evacuation
- 140° self-centering point
- AITiN+ coating extends tool life and thermal stability

SAE SIZE	"S" SHANK DIA.	OAL	"D1"	"D2"	"L1"	"L2"	"FL" FLUTE LENGTH	"SL" SHANK LENGTH	ORDER #	EDP #
									AITiN+	AITiN+
2	8mm	79mm	0.255	0.315	0.370	0.37	1.16	1.95	RD-SAE-02A	407024
3	10mm	89mm	0.317	0.378	0.370	0.37	1.32	2.19	RD-SAE-03A	407026
4	10mm	89mm	0.372	0.431	0.427	0.42	1.50	2.51	RD-SAE-04A	407028
5	12mm	102mm	0.434	0.494	0.427	0.42	1.66	2.55	RD-SAE-05A	407030
6	14mm	107mm	0.491	0.551	0.482	0.48	1.86	2.35	RD-SAE-06A	407032
8	18mm	123mm	0.672	0.740	0.557	0.55	2.04	2.21	RD-SAE-08A	407034

## SAE J1926 (MS16142) O-RING BOSS PORT TOOL

REAMER PILOT - CARBIDE TIPPED - COOLANT THROUGH



- Reams minor thread diameter to size
- Often called ORB (followed by port size number)
- Meets the requirements of SAE J1926/1
- Precision ground for maximum concentricity
- AITiN+ coating extends tool life
- Meets the requirements of MS16142

K	D	E	F	R	J	Q	L	S	OAL	TUBE	THREAD	SAE#	ORDER #	EDP#	
													AITiN+	AITiN+	
12"	0.3605	0.082	0.682	0.271	0.479	0.032	1.75	0.500	3.00	3	0.125	0.3125-24 UNF-2B	SAE#2	SAEJ1926-02R-X3A	406203
12"	0.4235	0.082	0.760	0.333	0.479	0.040	1.75	0.500	3.00	3	0.188	0.3750-24 UNF-2B	SAE#3	SAEJ1926-03R-X3A	406207
12"	0.4895	0.101	0.838	0.388	0.558	0.045	1.88	0.500	3.12	3	0.250	0.4375-20 UNF-2B	SAE#4	SAEJ1926-04R-X3A	406211
12"	0.5525	0.101	0.916	0.450	0.558	0.045	1.88	0.500	3.12	3	0.312	0.5000-20 UNF-2B	SAE#5	SAEJ1926-05R-X3A	406215
12"	0.6185	0.105	0.990	0.507	0.620	0.055	1.88	0.500	3.38	3	0.375	0.5625-18 UNF-2B	SAE#6	SAEJ1926-06R-X3A	406219
15"	0.8135	0.108	1.198	0.688	0.699	0.070	2.12	0.750	3.70	3	0.500	0.7500-16 UNF-2B	SAE#8	SAEJ1926-08R-X3A	406223

# SAE J1926 PORT KIT

This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AlTiN+ coated.



1. Roughing Step Drill
2. SAE J1926 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. SAE J1926 X-Series Port Tool
3. 15° Helical Thread Mill

## The SCT 1-2-3 Kit For SAE J1926

*Includes one drill, one port tool, and one thread mill for specific port size.*

### KIT WITH ROUGHING STEP DRILL, SAE PORT TOOL REAMER PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
SAEJ1926-2	RD-SAE-02A	SAEJ1926-02RA	TMI234-24HA	<b>SAEKIT02RA</b>	<b>410000</b>
SAEJ1926-3	RD-SAE-03A	SAEJ1926-03RA	TMI285-24HA	<b>SAEKIT03RA</b>	<b>410002</b>
SAEJ1926-4	RD-SAE-04A	SAEJ1926-04RA	TMI335-20HA	<b>SAEKIT04RA</b>	<b>410004</b>
SAEJ1926-5	RD-SAE-05A	SAEJ1926-05RA	TMI370-20HA	<b>SAEKIT05RA</b>	<b>410006</b>
SAEJ1926-6	RD-SAE-06A	SAEJ1926-06RA	TMI370-18HA	<b>SAEKIT06RA</b>	<b>410008</b>
SAEJ1926-8	RD-SAE-08A	SAEJ1926-08RA	TMI495-16HA	<b>SAEKIT08RA</b>	<b>410010</b>

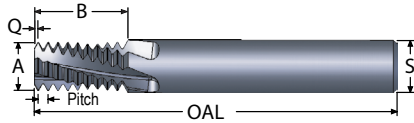
### KIT WITH DFX DRILL, SAE COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
SAEJ1926-2	DFX3-272A	SAEJ1926-02XA	TMI234-24HA	<b>SAEKIT02XA</b>	<b>410012</b>
SAEJ1926-3	DFX3-335A	SAEJ1926-03XA	TMI285-24HA	<b>SAEKIT03XA</b>	<b>410014</b>
SAEJ1926-4	DFX3-389A	SAEJ1926-04XA	TMI335-20HA	<b>SAEKIT04XA</b>	<b>410016</b>
SAEJ1926-5	DFX3-452A	SAEJ1926-05XA	TMI370-20HA	<b>SAEKIT05XA</b>	<b>410018</b>
SAEJ1926-6	DFX3-509A	SAEJ1926-06XA	TMI370-18HA	<b>SAEKIT06XA</b>	<b>410020</b>
SAEJ1926-8	DFX3-689A	SAEJ1926-08XA	TMI495-16HA	<b>SAEKIT08XA</b>	<b>410022</b>

There are two kits available for completing an SAE J1926 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.

## UN THREAD MILLS

### 15° HELICAL FLUTE SOLID CARBIDE



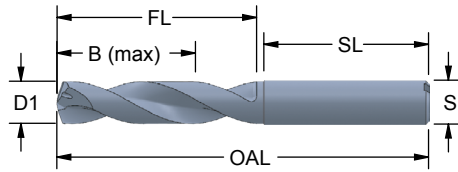
- Cuts UNC, UNF, UNEF, UNS and UNJ (internal only)
- Non-crest cutting allows maximum flexibility for plated and non-standard threads
- Long length-of-cut

MIN ID THREAD / PITCH*	"A" TOOL DIA.	"B" LENGTH OF CUT	"Q" LENGTH	"S" SHANK DIA.	CORRESPONDING PORT SIZE	OAL	FLUTES	ORDER #	EDP #
								AITiN+	AITiN+
INTERNAL THREADS ONLY									
5/16-24	0.234	0.641	0.019	0.250	AS5202-2	2.50	3	TMI234-24HA	102964
3/8-24	0.285	0.766	0.019	0.3125	AS5202-3	3.00	4	TMI285-24HA	102994
7/16-20	0.335	0.870	0.023	0.375	AS5202-4	3.00	4	TMI335-20HA	103024
9/16-18	0.370	0.911	0.025	0.375	AS5202-5	3.00	4	TMI370-18HA	103033
1/2-20	0.370	0.870	0.023	0.375	AS5202-6	3.00	4	TMI370-20HA	103034
3/4-16	0.495	1.338	0.028	0.500	AS5202-8	4.00	4	TMI495-16HA	103075

Thread mills can cut any larger size internal thread of the same pitch

## DFX DRILLS FOR AS5202 PORT SIZES

### SOLID CARBIDE, 140 DEGREE POINT, SCREW MACHINE LENGTH (3xD)

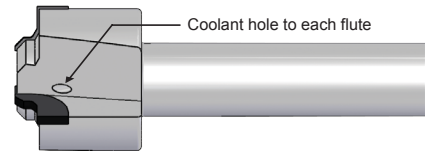
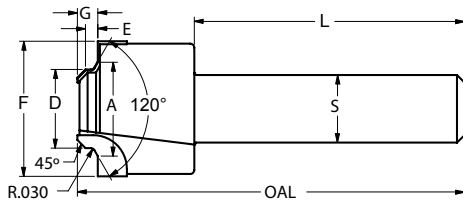


- Prepares hole for port tool by cutting minor thread diameter to size
- Coolant through for superior chip evacuation
- 140° self-centering point
- AITiN+ coating extends tool life and thermal stability

AS5202 SIZE	"S" SHANK DIA.	OAL	"D1" DRILL DIA. ± .0005	"FL" FLUTE LENGTH	"B" MAX DEPTH	"SL" SHANK LENGTH	ORDER #	EDP #
							AITiN+	AITiN+
2	8mm	79mm	0.276	1.34	0.92	1.42	DFX3-276A	407012
3	10mm	89mm	0.338	1.85	1.34	1.57	DFX3-338A	407014
4	10mm	89mm	0.393	1.85	1.26	1.57	DFX3-393A	407016
5	12mm	102mm	0.455	2.17	1.48	1.77	DFX3-455A	407018
6	14mm	107mm	0.513	2.36	1.59	1.77	DFX3-513A	407020
8	18mm	123mm	0.693	2.87	1.83	1.89	DFX3-693A	407022

## AS5202 (MS33649) PORT TOOL

### WITHOUT PILOT - CARBIDE TIPPED



- Ideal for non-standard minor diameter lengths
- Polished flute face for optimum performance
- Meets the requirements of AS5202/MS33649 and AND10050 ports
- AITiN+ coating for improved surface finish
- Polished flute face for optimum performance
- The AS5202/MS33649 require a UNJ, the AND10050 thread requires a UN thread

A	D	E	G	F	S	L	OAL	FLUTES	TUBE	THREAD	ORDER #	EDP #
											AITiN+	AITiN+
0.446	0.3305	0.071	0.121	0.742	0.500	2.00	2.75	3	0.125	0.3125-24 UNJF-3B	AS5202-02XA	406853
0.508	0.3925	0.071	0.121	0.805	0.500	2.00	2.75	3	0.188	0.3750-24 UNJF-3B	AS5202-03XA	406855
0.570	0.4565	0.083	0.133	0.888	0.500	2.00	2.75	3	0.250	0.4375-20 UNJF-3B	AS5202-04XA	406857
0.633	0.5195	0.083	0.133	0.950	0.500	2.00	2.75	3	0.312	0.5000-20 UNJF-3B	AS5202-05XA	406859
0.696	0.5825	0.091	0.151	1.012	0.500	2.00	2.75	3	0.375	0.5625-18 UNJF-3B	AS5202-06XA	406861
0.758	0.6455	0.102	0.162	1.105	0.500	2.00	2.88	3	0.438	0.6250-18 UNJF-3B	AS5202-07XA	406863
0.883	0.7715	0.102	0.172	1.240	0.750	2.13	3.13	3	0.500	0.7500-16 UNJF-3B	AS5202-08XA	406865

# AS5202 PORT KIT

This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AlTiN+ coated.



1. Roughing Step Drill
2. AS5202 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. AS5202 X-Series Port Tool
3. 15° Helical Thread Mill

## The SCT 1-2-3 Kit For AS5202

*Includes one drill, one port tool, and one thread mill for specific port size.*

### KIT WITH ROUGHING STEP DRILL, AS5202 PORT TOOL REAMER PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	RD-AS5202-02A	AS5202-02RA	TMI234-24HA	AS5202KIT02RA	410030
AS5202-3	RD-AS5202-03A	AS5202-03RA	TMI285-24HA	AS5202KIT03RA	410032
AS5202-4	RD-AS5202-04A	AS5202-04RA	TMI335-20HA	AS5202KIT04RA	410034
AS5202-5	RD-AS5202-05A	AS5202-05RA	TMI370-20HA	AS5202KIT05RA	410036
AS5202-6	RD-AS5202-06A	AS5202-06RA	TMI370-18HA	AS5202KIT06RA	410038
AS5202-8	RD-AS5202-08A	AS5202-08RA	TMI495-16HA	AS5202KIT08RA	410040

### KIT WITH DFX DRILL, AS5202 COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL

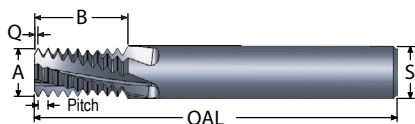
Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	DFX3-276A	AS5202-02XA	TMI234-24HA	AS5202KIT02XA	410042
AS5202-3	DFX3-338A	AS5202-03XA	TMI285-24HA	AS5202KIT03XA	410044
AS5202-4	DFX3-393A	AS5202-04XA	TMI335-20HA	AS5202KIT04XA	410046
AS5202-5	DFX3-455A	AS5202-05XA	TMI370-20HA	AS5202KIT05XA	410048
AS5202-6	DFX3-513A	AS5202-06XA	TMI370-18HA	AS5202KIT06XA	410050
AS5202-8	DFX3-693A	AS5202-08XA	TMI495-16HA	AS5202KIT08XA	410052

There are two kits available for completing an AS5202 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.



## UN THREAD MILLS

### 15° HELICAL FLUTE SOLID CARBIDE



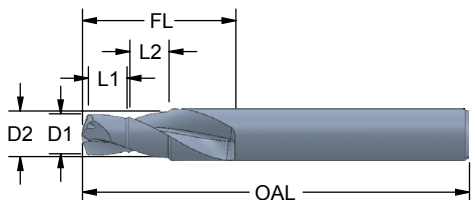
- Cuts UNC, UNF, UNEF, UNS and UNJ (internal only)
- Non-crest cutting allows maximum flexibility for plated and non-standard threads
- Long length-of-cut

MIN ID THREAD / PITCH*	"A" TOOL DIA.	"B" LENGTH OF CUT	"Q" LENGTH	"S" SHANK DIA.	CORRESPONDING PORT SIZE	OAL	FLUTES	ORDER #	EDP #
								AITiN+	AITiN+
5/16-24	0.234	0.641	0.019	0.250	AS5202-2	2.50	3	TMI234-24HA	102964
3/8-24	0.285	0.766	0.019	0.3125	AS5202-3	3.00	4	TMI285-24HA	102994
7/16-20	0.335	0.870	0.023	0.375	AS5202-4	3.00	4	TMI335-20HA	103024
9/16-18	0.370	0.911	0.025	0.375	AS5202-5	3.00	4	TMI370-18HA	103033
1/2-20	0.370	0.870	0.023	0.375	AS5202-6	3.00	4	TMI370-20HA	103034
3/4-16	0.495	1.338	0.028	0.500	AS5202-8	4.00	4	TMI495-16HA	103075

Thread mills can cut any larger size internal thread of the same pitch

## ROUGHING STEP DRILLS FOR AS5202 PORT SIZES

SOLID CARBIDE, 140 DEGREE POINT, COOLANT THROUGH

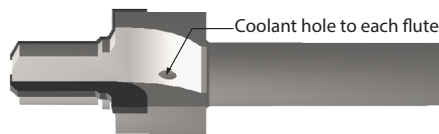
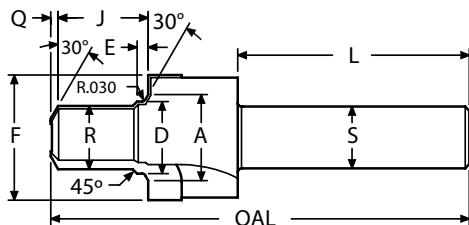


- Prepares hole for the port tool by roughing the minor-thread and sealing diameters
- Coolant through for superior chip evacuation
- 140° self-centering point
- AITiN+ coating extends tool life and thermal stability

SAE SIZE	"S" SHANK DIA.	OAL	"D1"	"D2"	"L1"	"L2"	"FL" FLUTE LENGTH	"SL" SHANK LENGTH	ORDER #	EDP #
									AITiN+	AITiN+
2	8mm	79mm	0.260	0.315	0.499	0.49	1.29	1.82	RD-AS5202-02A	407036
3	10mm	89mm	0.323	0.376	0.505	0.50	1.45	2.06	RD-AS5202-03A	407038
4	12mm	102mm	0.377	0.440	0.561	0.56	1.66	2.35	RD-AS5202-04A	407040
5	14mm	107mm	0.439	0.503	0.561	0.56	1.82	2.39	RD-AS5202-05A	407042
6	14mm	107mm	0.497	0.551	0.603	0.60	1.98	2.23	RD-AS5202-06A	407044
8	20mm	108mm	0.677	0.755	0.713	0.71	2.22	2.03	RD-AS5202-08A	407046

## AS5202 (MS33649) - REAMER PILOT PORT TOOL

COOLANT THROUGH - CARBIDE TIPPED



- Reams minor thread diameter to size
- Precision ground for maximum concentricity
- Meets the requirements of AS5202/MS33649
- AITiN+ coated tool for higher cutting speed
- This port requires a UNJ thread which specifies a larger minor thread diameter

A	D	E	F	J	Q	R	L	S	OAL	FLUTES	TUBE	THREAD	ORDER #	EDP #
													AITiN+	AITiN+
0.446	0.3305	0.071	0.742	0.597	0.032	0.276	1.75	0.500	3.00	3	0.125	0.3125-24 UNJF-3B	AS5202-02R-X3A	406509
0.508	0.3925	0.071	0.805	0.603	0.040	0.339	1.75	0.500	3.00	3	0.188	0.3750-24 UNJF-3B	AS5202-03R-X3A	406517
0.570	0.4565	0.083	0.888	0.676	0.040	0.393	1.88	0.500	3.12	3	0.250	0.4375-20 UNJF-3B	AS5202-04R-X3A	406525
0.633	0.5195	0.083	0.950	0.676	0.045	0.455	1.88	0.500	3.12	3	0.312	0.5000-20 UNJF-3B	AS5202-05R-X3A	406533
0.696	0.5825	0.091	1.012	0.729	0.060	0.513	1.88	0.500	3.38	3	0.375	0.5625-18 UNJF-3B	AS5202-06R-X3A	406541
0.883	0.7715	0.102	1.240	0.854	0.070	0.693	2.12	0.750	3.84	3	0.500	0.7500-16 UNJF-3B	AS5202-08R-X3A	406553



# AS5202 PORT KIT

This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AlTiN+ coated.



1. Roughing Step Drill
2. AS5202 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. AS5202 X-Series Port Tool
3. 15° Helical Thread Mill

## The SCT 1-2-3 Kit For AS5202

*Includes one drill, one port tool, and one thread mill for specific port size.*

### KIT WITH ROUGHING STEP DRILL, AS5202 PORT TOOL REAMER PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	RD-AS5202-02A	AS5202-02RA	TMI234-24HA	AS5202KIT02RA	410030
AS5202-3	RD-AS5202-03A	AS5202-03RA	TMI285-24HA	AS5202KIT03RA	410032
AS5202-4	RD-AS5202-04A	AS5202-04RA	TMI335-20HA	AS5202KIT04RA	410034
AS5202-5	RD-AS5202-05A	AS5202-05RA	TMI370-20HA	AS5202KIT05RA	410036
AS5202-6	RD-AS5202-06A	AS5202-06RA	TMI370-18HA	AS5202KIT06RA	410038
AS5202-8	RD-AS5202-08A	AS5202-08RA	TMI495-16HA	AS5202KIT08RA	410040

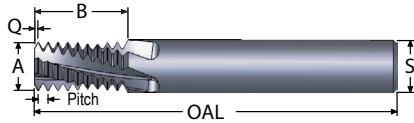
### KIT WITH DFX DRILL, AS5202 COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	DFX3-276A	AS5202-02XA	TMI234-24HA	AS5202KIT02XA	410042
AS5202-3	DFX3-338A	AS5202-03XA	TMI285-24HA	AS5202KIT03XA	410044
AS5202-4	DFX3-393A	AS5202-04XA	TMI335-20HA	AS5202KIT04XA	410046
AS5202-5	DFX3-455A	AS5202-05XA	TMI370-20HA	AS5202KIT05XA	410048
AS5202-6	DFX3-513A	AS5202-06XA	TMI370-18HA	AS5202KIT06XA	410050
AS5202-8	DFX3-693A	AS5202-08XA	TMI495-16HA	AS5202KIT08XA	410052

There are two kits available for completing an AS5202 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.

## UN THREAD MILLS

### 15° HELICAL FLUTE SOLID CARBIDE



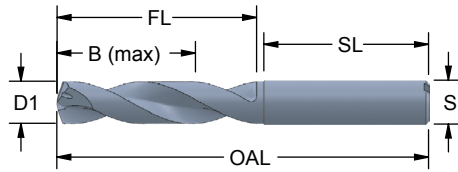
- Cuts UNC, UNF, UNEF, UNS and UNJ (internal only)
- Non-crest cutting allows maximum flexibility for plated and non-standard threads
- Long length-of-cut

MIN ID THREAD / PITCH*	"A" TOOL DIA.	"B" LENGTH OF CUT	"Q" LENGTH	"S" SHANK DIA.	CORRESPONDING PORT SIZE	OAL	FLUTES	ORDER #	EDP #
								AITiN+	AITiN+
5/16-24	0.234	0.641	0.019	0.250	AS5202-2	2.50	3	TMI234-24HA	102964
3/8-24	0.285	0.766	0.019	0.3125	AS5202-3	3.00	4	TMI285-24HA	102994
7/16-20	0.335	0.870	0.023	0.375	AS5202-4	3.00	4	TMI335-20HA	103024
9/16-18	0.370	0.911	0.025	0.375	AS5202-5	3.00	4	TMI370-18HA	103033
1/2-20	0.370	0.870	0.023	0.375	AS5202-6	3.00	4	TMI370-20HA	103034
3/4-16	0.495	1.338	0.028	0.500	AS5202-8	4.00	4	TMI495-16HA	103075

Thread mills can cut any larger size internal thread of the same pitch

## DFX DRILLS FOR AS5202 PORT SIZES

### SOLID CARBIDE, 140 DEGREE POINT, SCREW MACHINE LENGTH (3xD)

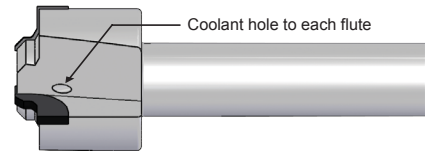
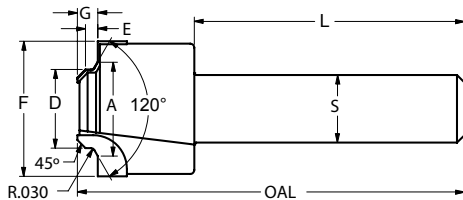


- Prepares hole for port tool by cutting minor thread diameter to size
- Coolant through for superior chip evacuation
- 140° self-centering point
- AITiN+ coating extends tool life and thermal stability

AS5202 SIZE	"S" SHANK DIA.	OAL	"D1" DRILL DIA. ± .0005	"FL" FLUTE LENGTH	"B" MAX DEPTH	"SL" SHANK LENGTH	ORDER #	EDP #
							AITiN+	AITiN+
2	8mm	79mm	0.276	1.34	0.92	1.42	DFX3-276A	407012
3	10mm	89mm	0.338	1.85	1.34	1.57	DFX3-338A	407014
4	10mm	89mm	0.393	1.85	1.26	1.57	DFX3-393A	407016
5	12mm	102mm	0.455	2.17	1.48	1.77	DFX3-455A	407018
6	14mm	107mm	0.513	2.36	1.59	1.77	DFX3-513A	407020
8	18mm	123mm	0.693	2.87	1.83	1.89	DFX3-693A	407022

## AS5202 (MS33649) PORT TOOL

### WITHOUT PILOT - CARBIDE TIPPED



- Ideal for non-standard minor diameter lengths
- Polished flute face for optimum performance
- Meets the requirements of AS5202/MS33649 and AND10050 ports
- AITiN+ coating for improved surface finish
- Polished flute face for optimum performance
- The AS5202/MS33649 require a UNJ, the AND10050 thread requires a UN thread

A	D	E	G	F	S	L	OAL	FLUTES	TUBE	THREAD	ORDER #	EDP #
											AITiN+	AITiN+
0.446	0.3305	0.071	0.121	0.742	0.500	2.00	2.75	3	0.125	0.3125-24 UNJF-3B	AS5202-02XA	406853
0.508	0.3925	0.071	0.121	0.805	0.500	2.00	2.75	3	0.188	0.3750-24 UNJF-3B	AS5202-03XA	406855
0.570	0.4565	0.083	0.133	0.888	0.500	2.00	2.75	3	0.250	0.4375-20 UNJF-3B	AS5202-04XA	406857
0.633	0.5195	0.083	0.133	0.950	0.500	2.00	2.75	3	0.312	0.5000-20 UNJF-3B	AS5202-05XA	406859
0.696	0.5825	0.091	0.151	1.012	0.500	2.00	2.75	3	0.375	0.5625-18 UNJF-3B	AS5202-06XA	406861
0.758	0.6455	0.102	0.162	1.105	0.500	2.00	2.88	3	0.438	0.6250-18 UNJF-3B	AS5202-07XA	406863
0.883	0.7715	0.102	0.172	1.240	0.750	2.13	3.13	3	0.500	0.7500-16 UNJF-3B	AS5202-08XA	406865

# AS5202 PORT KIT

This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AlTiN+ coated.



1. Roughing Step Drill
2. AS5202 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. AS5202 X-Series Port Tool
3. 15° Helical Thread Mill

## The SCT 1-2-3 Kit For AS5202

*Includes one drill, one port tool, and one thread mill for specific port size.*

### KIT WITH ROUGHING STEP DRILL, AS5202 PORT TOOL REAMER PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	RD-AS5202-02A	AS5202-02RA	TMI234-24HA	AS5202KIT02RA	410030
AS5202-3	RD-AS5202-03A	AS5202-03RA	TMI285-24HA	AS5202KIT03RA	410032
AS5202-4	RD-AS5202-04A	AS5202-04RA	TMI335-20HA	AS5202KIT04RA	410034
AS5202-5	RD-AS5202-05A	AS5202-05RA	TMI370-20HA	AS5202KIT05RA	410036
AS5202-6	RD-AS5202-06A	AS5202-06RA	TMI370-18HA	AS5202KIT06RA	410038
AS5202-8	RD-AS5202-08A	AS5202-08RA	TMI495-16HA	AS5202KIT08RA	410040

### KIT WITH DFX DRILL, AS5202 COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	DFX3-276A	AS5202-02XA	TMI234-24HA	AS5202KIT02XA	410042
AS5202-3	DFX3-338A	AS5202-03XA	TMI285-24HA	AS5202KIT03XA	410044
AS5202-4	DFX3-393A	AS5202-04XA	TMI335-20HA	AS5202KIT04XA	410046
AS5202-5	DFX3-455A	AS5202-05XA	TMI370-20HA	AS5202KIT05XA	410048
AS5202-6	DFX3-513A	AS5202-06XA	TMI370-18HA	AS5202KIT06XA	410050
AS5202-8	DFX3-693A	AS5202-08XA	TMI495-16HA	AS5202KIT08XA	410052

There are two kits available for completing an AS5202 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.

# AS5202 PORT KIT

This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AlTiN+ coated.



1. Roughing Step Drill
2. AS5202 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. AS5202 X-Series Port Tool
3. 15° Helical Thread Mill

## The SCT 1-2-3 Kit For AS5202

*Includes one drill, one port tool, and one thread mill for specific port size.*

### KIT WITH ROUGHING STEP DRILL, AS5202 PORT TOOL REAMER PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	RD-AS5202-02A	AS5202-02RA	TMI234-24HA	AS5202KIT02RA	410030
AS5202-3	RD-AS5202-03A	AS5202-03RA	TMI285-24HA	AS5202KIT03RA	410032
AS5202-4	RD-AS5202-04A	AS5202-04RA	TMI335-20HA	AS5202KIT04RA	410034
AS5202-5	RD-AS5202-05A	AS5202-05RA	TMI370-20HA	AS5202KIT05RA	410036
AS5202-6	RD-AS5202-06A	AS5202-06RA	TMI370-18HA	AS5202KIT06RA	410038
AS5202-8	RD-AS5202-08A	AS5202-08RA	TMI495-16HA	AS5202KIT08RA	410040

### KIT WITH DFX DRILL, AS5202 COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	DFX3-276A	AS5202-02XA	TMI234-24HA	AS5202KIT02XA	410042
AS5202-3	DFX3-338A	AS5202-03XA	TMI285-24HA	AS5202KIT03XA	410044
AS5202-4	DFX3-393A	AS5202-04XA	TMI335-20HA	AS5202KIT04XA	410046
AS5202-5	DFX3-455A	AS5202-05XA	TMI370-20HA	AS5202KIT05XA	410048
AS5202-6	DFX3-513A	AS5202-06XA	TMI370-18HA	AS5202KIT06XA	410050
AS5202-8	DFX3-693A	AS5202-08XA	TMI495-16HA	AS5202KIT08XA	410052

There are two kits available for completing an AS5202 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.