



# CATALOG & TECHNICAL GUIDE 2020.2



## THREADING



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# Code keys

## Toolholders



<b>C</b>	<b>E</b>	<b>R</b>	<b>25</b>	<b>25</b>	<b>M</b>	<b>16</b>	<b>Q</b>	<b>HD</b>
1	2	3	4	5	6	7	8	9

1. Insert clamping	2. External/Internal
<p>S Screw      C Clamp      P Pin</p>	<p>E = External N = Internal</p>

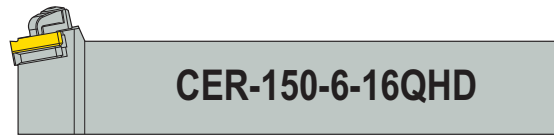
3. Cutting direction	4. Shank height
<p>L      R      X = Special</p>	<p>H</p> <p>00 = Round toolholders S &amp; C 25 = 25 mm (0.984") 32 = 32 mm (1.260") etc.</p>

5. Shank width/diameter	6. Tool length
<p>B      DMM</p> <p>20 = 20 mm (0.787") 25 = 25 mm (0.984") etc.</p>	<p>LF</p> <p>H = 100 mm (3.937")      Q = 180 mm (7.087") K = 125 mm (4.921")      R = 200 mm (7.874") L = 140 mm (5.512")      S = 250 mm (9.843") M = 150 mm (5.906")      T = 300 mm (11.811") P = 170 mm (6.693")      U = 350 mm (13.780") V = 400 mm (15.748")</p>

7. Cutting edge length	8. Other information
<p>L      IGL</p> <p>If the cutting edge length consists of only one digit, the designation should start with a 0.</p> <p>Example: Cutting edge length = 16,5 mm (0.650") Symbol = 16 Cutting edge length = 9,525 mm (0.375") Symbol = 09</p>	<p>A = Steel with coolant passage Q = Toolholder/cranked CQ = For mounting upside down</p> <p>HD = Heavy duty JET = Jetstream Tooling® JETI = Jetstream Tooling® Jeti</p>

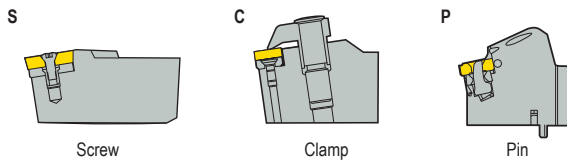
# Code keys

## Toolholders



<b>C</b>	<b>E</b>	<b>R</b>		<b>- 150 -</b>	<b>6</b>	<b>- 16</b>	<b>Q</b>	<b>HD</b>
1	2	3	4	5	6	7	8	9

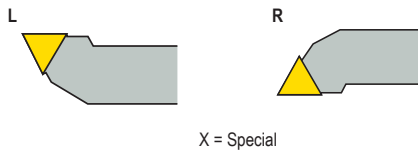
### 1. Insert clamping



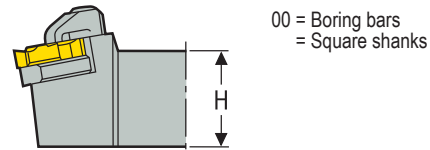
### 2. External/Internal

E = External  
N = Internal

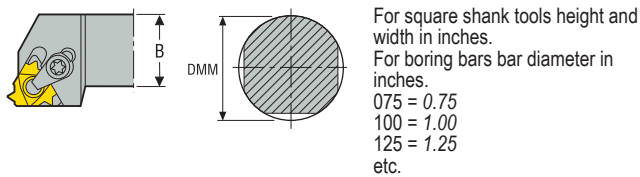
### 3. Cutting direction



### 4. Shank definition



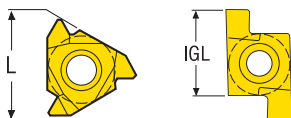
### 5. Square shank height/width and bar diameter



### 6. Tool length



### 7. Cutting edge length



If the cutting edge length consists of only one digit, the designation should start with a 0.

Example:  
Cutting edge length = 16,5 mm (0.650")  
Symbol = 16  
Cutting edge length = 9,525 mm (0.375")  
Symbol = 09

### 8. Other information

A = Steel with coolant passage  
Q = Qualified  
CQ = For mounting upside down

HD = Heavy duty  
JET = Jetstream Tooling®  
JETI = Jetstream Tooling® Jeti

Thread turning

Thread MDT

Thread Mini-Start™

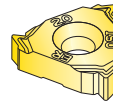
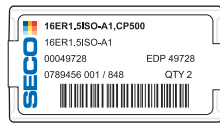
Rotating threading

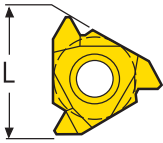

Annex



# Code keys

## Inserts



1. Cutting edge length	2. External/Internal																																																																																										
 <p>Example: Cutting edge length = 16,5 mm (0.650") Symbol = 16 Cutting edge length = 9,525 mm (0.375") Symbol = 09</p> <p>If the cutting edge length consists of only one digit, the designation should start with a 0.</p>	<p>E = External N = Internal</p>																																																																																										
3. Cutting direction	4. Pitch																																																																																										
 <p>X = Special</p>	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td><b>Full profile mm: (mm)</b></td> <td>0,50</td> <td>1,25</td> <td>3,00</td> <td>6,00</td> <td></td> </tr> <tr> <td></td> <td>0,70</td> <td>1,50</td> <td>4,00</td> <td>8,00</td> <td></td> </tr> <tr> <td></td> <td>0,75</td> <td>1,75</td> <td>4,50</td> <td>10,0</td> <td></td> </tr> <tr> <td></td> <td>0,80</td> <td>2,00</td> <td>5,00</td> <td>12,0</td> <td></td> </tr> <tr> <td></td> <td>1,00</td> <td>2,50</td> <td>5,50</td> <td>14,0</td> <td></td> </tr> <tr> <td><b>Full profile: (TPI)</b></td> <td>48</td> <td>18</td> <td>11</td> <td>6.0</td> <td>2.5</td> </tr> <tr> <td></td> <td>40</td> <td>16</td> <td>10</td> <td>5.0</td> <td>2.0</td> </tr> <tr> <td></td> <td>32</td> <td>14</td> <td>9</td> <td>4.5</td> <td></td> </tr> <tr> <td></td> <td>24</td> <td>13</td> <td>8</td> <td>4.0</td> <td></td> </tr> <tr> <td></td> <td>20</td> <td>12</td> <td>7</td> <td>3.0</td> <td></td> </tr> <tr> <td><b>Partial profile:</b></td> <td>A</td> <td>= 0,50-1,50 mm</td> <td colspan="3">48-16 TPI</td> </tr> <tr> <td></td> <td>AG</td> <td>= 0,50-3,00 mm</td> <td colspan="3">48-8 TPI</td> </tr> <tr> <td></td> <td>G</td> <td>= 1,75-3,00 mm</td> <td colspan="3">14-8 TPI</td> </tr> <tr> <td></td> <td>N</td> <td>= 3,50-5,00 mm</td> <td colspan="3">7-5 TPI</td> </tr> <tr> <td></td> <td>K</td> <td>= 5,50-10,00 mm</td> <td colspan="3">4.5-2.5 TPI</td> </tr> </table>	<b>Full profile mm: (mm)</b>	0,50	1,25	3,00	6,00			0,70	1,50	4,00	8,00			0,75	1,75	4,50	10,0			0,80	2,00	5,00	12,0			1,00	2,50	5,50	14,0		<b>Full profile: (TPI)</b>	48	18	11	6.0	2.5		40	16	10	5.0	2.0		32	14	9	4.5			24	13	8	4.0			20	12	7	3.0		<b>Partial profile:</b>	A	= 0,50-1,50 mm	48-16 TPI				AG	= 0,50-3,00 mm	48-8 TPI				G	= 1,75-3,00 mm	14-8 TPI				N	= 3,50-5,00 mm	7-5 TPI				K	= 5,50-10,00 mm	4.5-2.5 TPI		
<b>Full profile mm: (mm)</b>	0,50	1,25	3,00	6,00																																																																																							
	0,70	1,50	4,00	8,00																																																																																							
	0,75	1,75	4,50	10,0																																																																																							
	0,80	2,00	5,00	12,0																																																																																							
	1,00	2,50	5,50	14,0																																																																																							
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	K	= 5,50-10,00 mm	4.5-2.5 TPI																																																																																								
5. Thread	6. Number of teeth per cutting edge/ Type of chipbreaker																																																																																										
<p>2M = 2 teeth 3M = 3 teeth TT = TWIN THREADER</p> <p>A = Universal A1 = Chipbreaker designation A2 = Chipbreaker designation</p>	<p>Thread =</p> <table border="0"> <tr><td>60</td><td>= V profile, 60°</td></tr> <tr><td>55</td><td>= V profile, 55°</td></tr> <tr><td>ISO</td><td>= ISO, Metric</td></tr> <tr><td>UN</td><td>= Am. UN</td></tr> <tr><td>UNJ</td><td>= Am. Aerospace</td></tr> <tr><td>MJ</td><td>= Metr. Aerospace</td></tr> <tr><td>W</td><td>= Whitworth, BSW</td></tr> <tr><td>BSPT</td><td>= Whitworth, Taper</td></tr> <tr><td>NPT</td><td>= Am. NPT</td></tr> <tr><td>NPTF</td><td>= Am. NPTF (Dryseal)</td></tr> <tr><td>RD</td><td>= Round, DIN405</td></tr> <tr><td>TR</td><td>= Trapezoidal, DIN103</td></tr> <tr><td>ACME</td><td>= Am. ACME-G</td></tr> <tr><td>STACME</td><td>= Am. Stub-ACME</td></tr> <tr><td>API 384</td><td>= API V 038R 1:4</td></tr> <tr><td>API 386</td><td>= API V 038R 1:6</td></tr> <tr><td>API 404</td><td>= API V 040 1:4</td></tr> <tr><td>API 504</td><td>= API V 050 1:4</td></tr> <tr><td>API 506</td><td>= API V 050 1:6</td></tr> <tr><td>API RD</td><td>= API Round Casing</td></tr> <tr><td>BUT 2.5</td><td>= Buttress, 1°47'</td></tr> <tr><td>BUT 2.6</td><td>= Buttress, 2°23'</td></tr> <tr><td>VAM</td><td>= VAM Vallourec</td></tr> </table>	60	= V profile, 60°	55	= V profile, 55°	ISO	= ISO, Metric	UN	= Am. UN	UNJ	= Am. Aerospace	MJ	= Metr. Aerospace	W	= Whitworth, BSW	BSPT	= Whitworth, Taper	NPT	= Am. NPT	NPTF	= Am. NPTF (Dryseal)	RD	= Round, DIN405	TR	= Trapezoidal, DIN103	ACME	= Am. ACME-G	STACME	= Am. Stub-ACME	API 384	= API V 038R 1:4	API 386	= API V 038R 1:6	API 404	= API V 040 1:4	API 504	= API V 050 1:4	API 506	= API V 050 1:6	API RD	= API Round Casing	BUT 2.5	= Buttress, 1°47'	BUT 2.6	= Buttress, 2°23'	VAM	= VAM Vallourec																																												
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VAM	= VAM Vallourec																																																																																										

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

# Selection process

## Seco Suggest

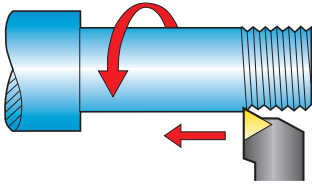
In order to simplify the selection of tools and cutting parameters Seco Tools introduce Suggest which eliminates complicated searching, programming and calculation. Suggest gives you the best suggestion of holder, insert and optimized parameters for your application and the possibility to download information to the CNC machine.

The application can be found at <https://www.secotools.com/dashboard/Suggest/Suggest>.

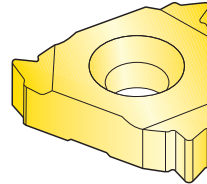
Use the selection process below to choose a suitable tool, insert, cutting data and production method.



### 1. Selection of production method, page 9.



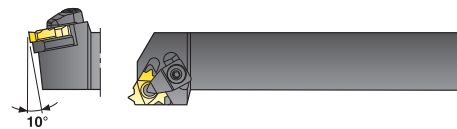
### 2. Selection of insert type, page 10.



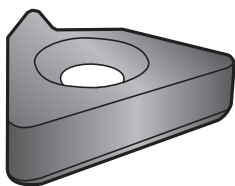
### 3. Selection of grade, page 11.

	ISO														
	P				M				K						
	P01	P10	P20	P30	P40	P50	M10	M20	M30	M40	K01	K10	K20	K30	K40
CP200	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
CP300	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
CP500	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
H15	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

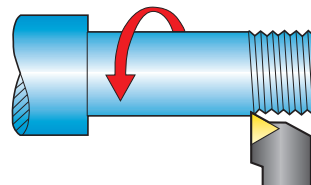
### 4. Selection of toolholder, page 13.



### 5. Selection of insert shim, pages 14-15.



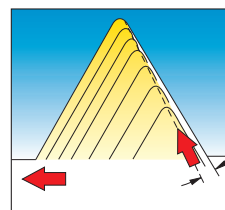
### 6. Selection of cutting speed, pages 16-20.



### 7. Selection of number of passes and infeed depths, pages 21-31.

Lead (mm)	6.0	5.5	5.0	4.5	4.0	3.5	3.0	2.5	2.0	1.75	1.5	1.25	1.0	0.75	0.50
1st. Infeed Depth (mm)	0.30	0.28	0.26	0.24	0.22	0.20	0.18	0.16	0.14	0.12	0.10	0.08	0.06	0.04	0.02
Pass 1 (mm)	0.40	0.43	0.47	0.51	0.55	0.59	0.63	0.67	0.71	0.75	0.79	0.83	0.87	0.91	0.95
2	0.43	0.46	0.50	0.54	0.58	0.62	0.66	0.70	0.74	0.78	0.82	0.86	0.90	0.94	0.98
3	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
4	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
5	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
6	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
7	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
8	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
9	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
10	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
11	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
12	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
13	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
14	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
15	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05
16	0.50	0.53	0.57	0.61	0.65	0.69	0.73	0.77	0.81	0.85	0.89	0.93	0.97	1.01	1.05

### 8. Selection of infeed method, page 32.



Thread turning

Thread MDT

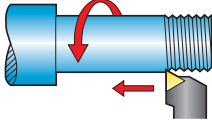
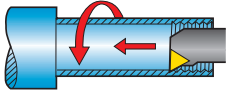
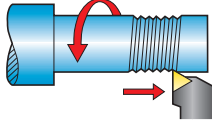
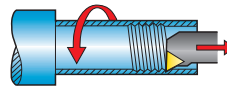
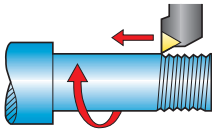
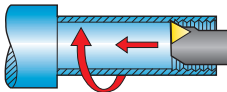
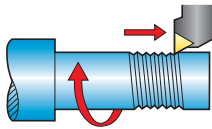
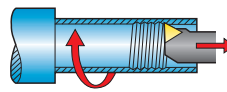
Thread Mini-Start™

Rotating threading

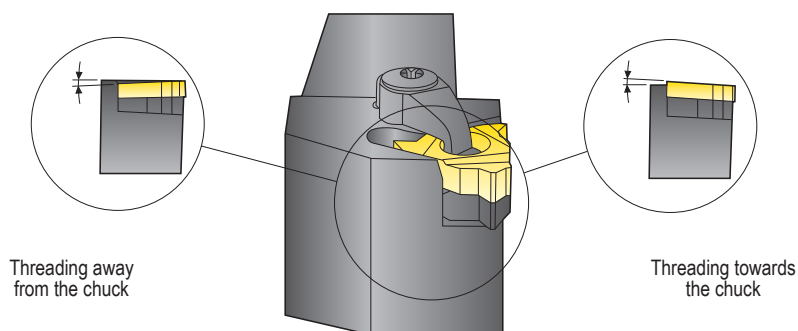
Annex

# Production methods

Workpiece  
-External or internal thread  
-Right or left hand thread  
Machine  
-Right or left hand tool

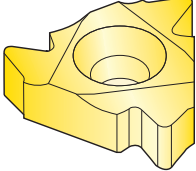
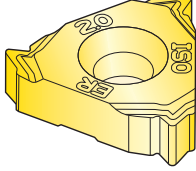
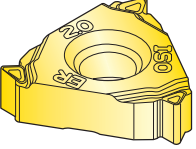
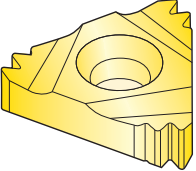
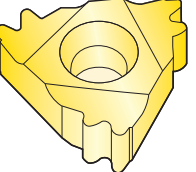
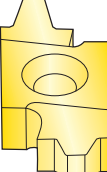

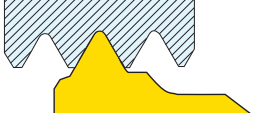
Threading towards the chuck		Threading away from the chuck*	
<p><b>Benefit:</b></p> <ul style="list-style-type: none"> <li>• Best stability</li> <li>• Originally fitted insert shims can be used for most operations</li> </ul> <p><b>Note:</b></p> <ul style="list-style-type: none"> <li>• Chip build-up may occur during internal threading, particularly if there is little space between the threading bar and bore of the hole</li> </ul>		<p><b>Benefit:</b></p> <ul style="list-style-type: none"> <li>• Chip flow is correctly directed during internal threading</li> </ul> <p><b>Note:</b></p> <ul style="list-style-type: none"> <li>• Secure clamping of the insert and mounting of the toolholder are necessary</li> </ul> <p><b>Internal threading:</b></p> <ul style="list-style-type: none"> <li>• Use only CNR/L toolholders</li> </ul>	
Right-hand thread – Right-hand tool		Left-hand thread – Right-hand tool	
 <p>ER</p>  <p>NR</p>		 <p>ER</p>  <p>NR</p>	
Left-hand thread – Left-hand tool		Right-hand thread – Left-hand tool	
 <p>EL</p>  <p>NL</p>		 <p>EL</p>  <p>NL</p>	

\*Notice that the insert shim must be changed when threading away from the chuck.



## Insert grades

For single tooth inserts choose a full profile or partial profile design

<p><b>Single-tooth insert (Type S) A or Original</b></p> <p>First choice, can be used for applications in a variety of materials. Low cutting forces.</p> 	<p><b>Single-tooth insert (Type S) A1 chipbreaker</b></p> <p>First choice for general applications in steel.</p> 
<p><b>Single-tooth insert (Type S) A2 chipbreaker</b></p> <p>First choice for general applications in stainless steel.</p> 	<p><b>Multi-tooth insert (Type M)</b></p> <p>First choice for mass production, since fewer passes are necessary. Only for radial infeed. 2M = 2 teeth version 3M = 3 teeth version</p> 
<p><b>Multi-tooth insert (TWIN THREADER, TT)</b></p> <p>Lower cutting forces than M type. Shorter undercut length than M type. Only for radial infeed. Use insert shim for 2M.</p> 	<p><b>K insert (Type K)</b></p> <p>First choice for large/coarse threads.</p> 
<p><b>Full profile</b></p> <p>By topping the thread, the workpiece need not be pre-machined to the exact diameter and may be a little oversized for external threads and undersize for internal threads. The threading operation is simplified since only one tool is needed for the entire thread (no subsequent deburring is needed).</p> 	<p><b>Partial profile</b></p> <p>Covers a wide range of thread pitches, which simplifies stock-keeping. Requires a correct workpiece diameter prior to threading. The nose radius of the insert is sized to suit the smallest profile within the pitch range of the insert.</p> 

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

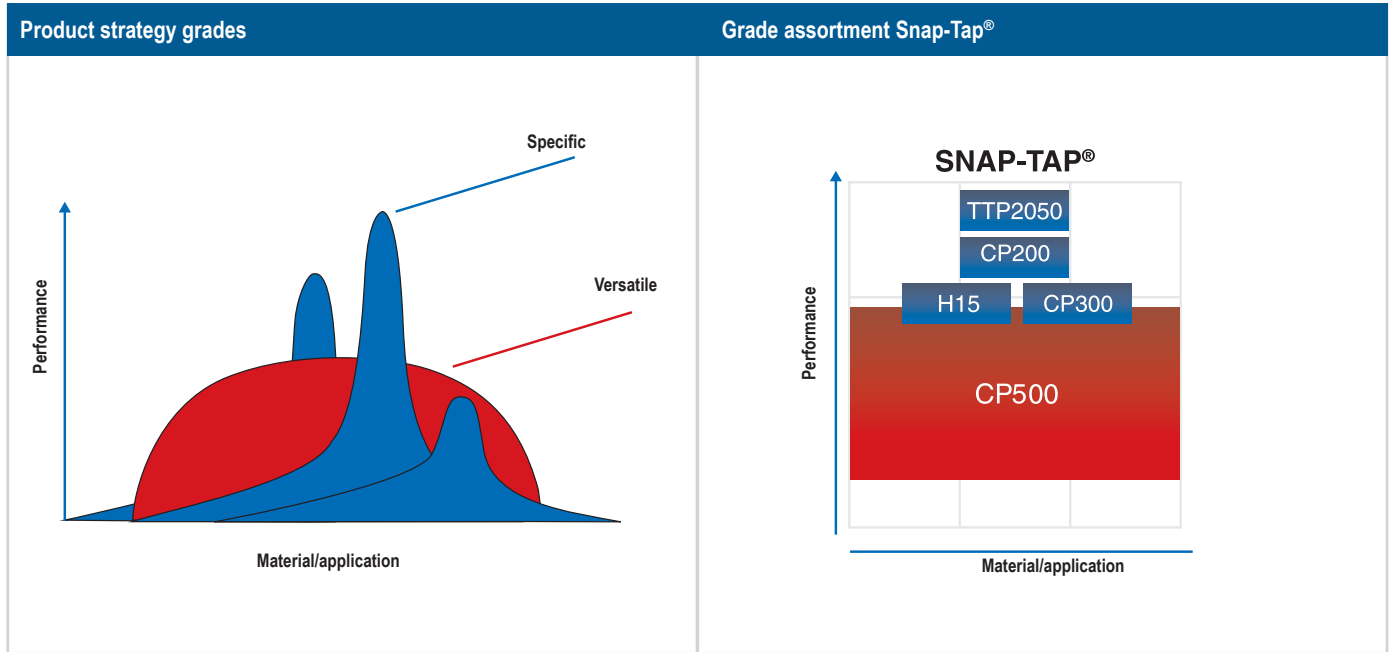
Annex

# Insert grades

## Thread turning – Insert grades

Continuous research and development of better materials, coatings and optimal geometries help fulfil customers requirements.

Our product strategy is to provide the market with versatile first choice tools and specific optimized solutions for threading.



## Insert grades

### Grades

The black areas in the chart indicate a grade's main ISO application groups and the white areas indicate other supplementary application groups.

	P					M				K				N				S				H						
	P01	P10	P20	P30	P40	P50	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	N01	N10	N20	N30	S01	S10	S20	S30	H01	H10	H20	H30
CP200																												
CP300																												
CP500																												
TTP2050																												
H15																												

### PVD Coated Grades

CP200		First choice for high-strength steel, martensitic stainless steel, cast iron with low hardness, superalloys and titanium alloys. First choice for high cutting speeds. Hard micrograin with sharp edge, highly resistant to plastic deformation.  (Ti,Al)N + TiN
CP300		Wear-resistant grade which is principally intended for high cutting speeds. Optimizing grade in steel and stainless steel.  (Ti,Al)N + TiN
CP500		Universal very tough micrograin grade for all types of threading in most materials. Excellent for stainless steel and difficult operations.  (Ti,Al)N + TiN
TTP2050		Peak performance, wear resistant micrograin grade to be used in steel, stainless steel and cast iron. The nano-laminated coating increases the wear resistance of the grade.  (TiAl)(TiSi)N

### CVD Coated Grades

H15		First choice for machining normal to hard cast iron. Also suitable for hard steel with a hardness in excess of 350 HB. Micrograin with excellent wear-resistance and sharp edge.
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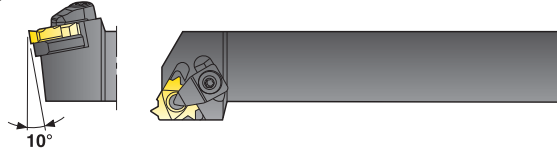
# Toolholders

Use the guidelines below to choose a suitable toolholder type.

## External threading

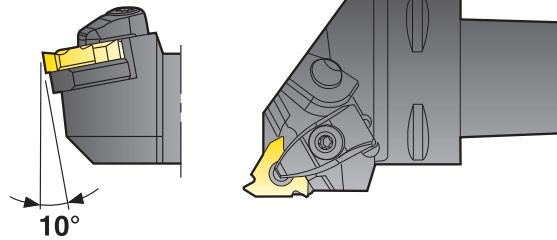
Basic choice  
Type C (clamp)  
Type P (Pin)

CER/L, PER/L



Insert size  
16, 20, 22, 26, 27  
With insert shim

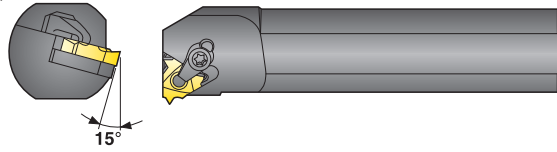
Cx-CER/L



## Internal threading

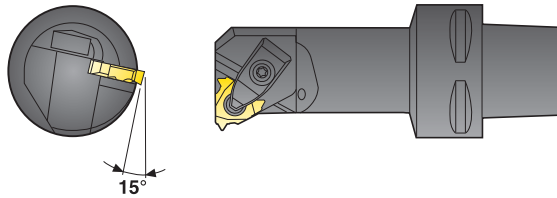
Basic choice  
Type C (clamp)  
Type P (Pin)

CNR/L, PNR/L



Insert size  
16, 20, 22, 26, 27  
With insert shim

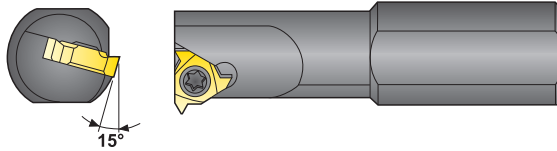
Cx-CNR/L



N.B. On 27 mm inserts this angle is 10°

For small holes  
Type-S (screw)

SNR/L



Insert sizes  
09, 11, 16, 22

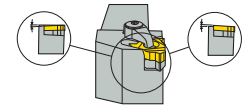
(No insert shim. To be used only when  
threading towards the chuck)

# Insert shim

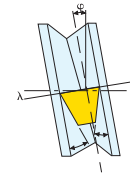
## Originally fitted insert shims

The table below shows the originally fitted insert shims. These insert shims are suitable for most operations when threading towards the chuck.

	Clamp		Screw	Jetstream Tooling®
<b>Toolholders</b>				
	External and internal threading		Internal threading	External and internal threading
<b>Insert type</b>	Single-tooth insert (Type S)		Single-tooth insert (Type S)	Single-tooth insert (Type S)
<b>Insert shim</b>			No insert shim ( $\lambda=2^\circ$ )	
<b>Insert size</b>	16 GX 16-1		20 KX 20-2	GXA16-1
	22 NX22-1		26 KX26-2	NXA22-1
	27 VX27-1			VXA27-1



The helix angle can be selected from +5 to -2 by changing the insert shim. The same insert shims are used for both right and left hand holders. The centre height remains constant.



To receive the correct shape on the thread and uniform wear on the insert the cutting edge helix angle ( $\lambda$ ) should be equal to the thread lead angle ( $\phi$ ).

The helix angle ( $\lambda$ ) can also be calculated. See page 33 for formula.

SNR/L toolholders have no exchangeable insert shim and can therefore only be used for threading towards the chuck. The table below shows the available insert shim range.

## Insert shim range

	Clamp					Jetstream Tooling® Thread turning		
<b>Toolholders</b>								
	External and internal threading					External and internal threading		
<b>Insert type</b>	Multi-tooth insert (Type M)	Single-tooth insert (Type S)		Single-tooth insert (Type K)		Multi-tooth insert (Type M)	Single-tooth insert (Type S)	
<b>Insert shim</b>								
	Threading towards the chuck	Threading towards the chuck	Threading away from the chuck	Threading towards the chuck	Threading away from the chuck	Threading towards the chuck	Threading towards the chuck	Threading away from the chuck
<b>Insert size</b>	16 MX16-1	GX16-0, -1, -2, -3, -4	GX16-0 -99 -98	KX20-0, -1, -2, -3, -4, -5	KX20-0, -99	MXA16-1	GXA16-0, -1, -2, -3, -4	GXA16-0, -99, -98
	22 MX22-1	NX22-0, -1, -2, -3, -4	NX22-0 -99 -98	KX26-0, -1, -2, -3, -4, -5	KX26-0, -99	MXA22-1	NXA22-0, -1, -2, -3, -4	NXA22-0, -99, -98
	26							
	27 MX27-1	VX27-0, -1, -2, -3, -4	VX27-0 -99 -98			MXA27-1	VXA22-0, -1, -2, -3, -4	VXA27-0, -99, -98

Thread turning

Thread MDT

Thread Mini-Shift™

Rotating threading

Annex





## SMG – Cutting data

In SMG classification of workpiece materials involves a specific material standard in a specific condition assigned as reference for easy and unambiguous adjustment of cutting data for any actual material compared to any Seco reference material. As examples the reference materials EN C45E for SMG P4 and EN 42 CrMo 4 for both SMG P5 and SMG H5 shown below in table 1 where the reference level material property is indicated. (A more complete extract can be found on page(s) 361-371.

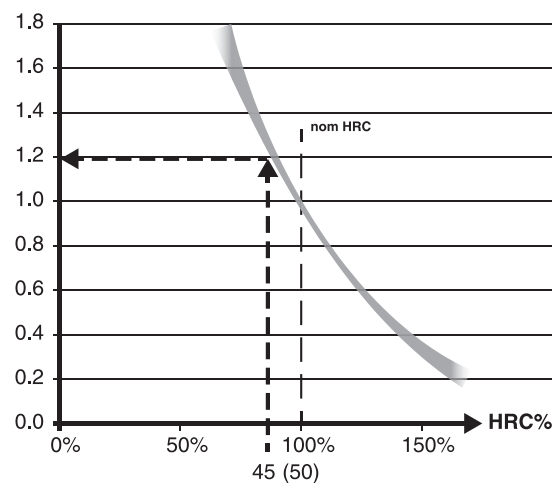
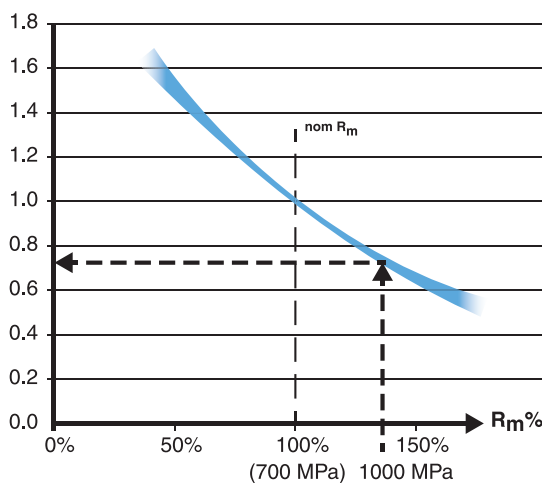
SMG	Description	Properties	Reference	SMG	Description	Properties	Reference
P4	Low-alloy general structural steels, 0.25% < C < 0.67%wt Low-alloy Quench & Temper steels	520 < R <sub>m</sub> < 1200	C 45E R <sub>m</sub> = 660 N/mm <sup>2</sup>	H5	Quenched & Tempered steels	38 < HRC < 56	42 CrMo 4 50 HRC
P5	Structural steels, 0.25% < C < 0.67%wt Quench & Temper steels	550 < R <sub>m</sub> < 1200	42 CrMo 4 R <sub>m</sub> = 700 N/mm <sup>2</sup>				

Focusing specifically on EN 42 CrMo 4 in annealed condition, the ultimate tensile strength R<sub>m</sub> may typically vary between R<sub>m</sub> = 630 N/mm<sup>2</sup> and R<sub>m</sub> = 780 N/mm<sup>2</sup>, which provide a reference level for SMG P5. In Quenched & Tempered condition, the ultimate tensile strength R<sub>m</sub> may typically be between R<sub>m</sub> = 900 N/mm<sup>2</sup> and R<sub>m</sub> = 1100 N/mm<sup>2</sup> thus still belongs to SMG P5. However, if hardened above R<sub>m</sub> = 1200 N/mm<sup>2</sup> it instead belongs to SMG H5.

SMG	EN	W.-Nr	AFNOR	BS	UNI	JIS	AISI / ASTM	GOST	Condition	R <sub>m</sub> nom	HRC <sub>nom</sub>
P5	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Annealed	700	
	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Quenched & Tempered	1000	
H5	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Quenched & Tempered		45
	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Quenched & Tempered		50

The EN 42CrMo4 quench & tempered steel could be used to illustrate the machinability dependence of materials' condition.

The graphs below indicate how speed recommendations for a nominal material conditions may be adjusted for relative R<sub>m</sub> (left diagram valid for ISO-P) and for relative HRC (valid for ISO-H).



To further illustrate how the SMG P5 nominal v<sub>c</sub> can be adjusted to a more accurate recommended v<sub>c</sub> we need ultimate tensile strength R<sub>m</sub> data and in this case we use the EN 42 CrMo 4 quenched & tempered to R<sub>m</sub> = 1000 N/mm<sup>2</sup> according to above table (bold blue arrows).

Assume that we find that the SMG P5 nominal v<sub>c</sub> = 280 m/min for a certain product and machining.

Then, actual recommended v<sub>c</sub> = 280 m/min × 0,75 = 210 m/min.

Consequently in the SMG H5 the nominal v<sub>c</sub> can be adjusted using the hardened EN 42 CrMo 4 at HRC 45 (smaller grey arrows).

Assume that the SMG H5 nominal v<sub>c</sub> = 50 m/min for a certain product and machining using a coated cemented carbide tools then, actual recommended v<sub>c</sub> = 50 m/min × 1,2 = 60 m/min.

For further workpiece material details please see page(s) 361-371 and suggested cutting data at applicable pages.

For more convenient cutting data handling we recommend applicable tools in My Pages – Suggest on [www.secotools.com](http://www.secotools.com)

Cutting speed

SMG	v <sub>c</sub> m/min SFM				
	CP200	CP300	CP500	H15	TTP2050
P1	—	275	205	—	205
	—	900	670	—	670
P2	—	270	200	—	200
	—	890	660	—	660
P3	—	230	170	—	170
	—	750	560	—	560
P4	—	205	150	—	150
	—	670	490	—	490
P5	—	195	145	—	145
	—	640	475	—	475
P6	—	220	165	—	165
	—	720	540	—	540
P7	—	205	155	—	155
	—	670	510	—	510
P8	—	195	145	—	145
	—	640	475	—	475
P11	—	200	150	—	150
	—	660	490	—	490
P12	—	120	90	—	90
	—	395	295	—	295
M1	150	—	135	100	135
	490	—	445	330	445
M2	120	—	110	80	110
	395	—	360	260	360
M3	90	—	85	60	85
	295	—	280	195	280
M4	70	—	65	—	65
	230	—	215	—	215
M5	55	—	50	—	50
	180	—	165	—	165
K1	130	—	120	105	120
	425	—	395	345	395
K2	110	—	105	95	105
	360	—	345	310	345
K3	95	—	90	80	90
	310	—	295	260	295
K4	90	—	85	75	85
	295	—	280	245	280
K5	55	—	50	—	50
	180	—	165	—	165
K6	80	—	75	—	75
	260	—	245	—	245
K7	70	—	65	—	65
	230	—	215	—	215
N1	—	—	—	255	—
	—	—	—	840	—
N2	—	—	—	165	—
	—	—	—	540	—
N3	—	—	—	110	—
	—	—	—	360	—
N11	—	—	100	150	100
	—	—	330	490	330
S1	20	—	20	—	20
	65	—	65	—	65
S2	15	—	15	—	15
	49	—	49	—	49
S3	15	—	15	—	15
	49	—	49	—	49
S11	45	—	39	—	39
	150	—	130	—	130
S12	35	—	30	—	30
	115	—	100	—	100
S13	27	—	23	—	23
	90	—	75	—	75

Use the SMG tables to classify the workpiece material. Use the table to choose cutting speed.

Cutting speeds (v<sub>c</sub>) in the table are recommendations for a start value.

Due to machine, material and setup condition it is advisable to optimize cutting data. Recommended ranges to use for each grade is CP200, CP300, CP500, TTP2050 and H15 +/-15%

SMG=Seco Material Group

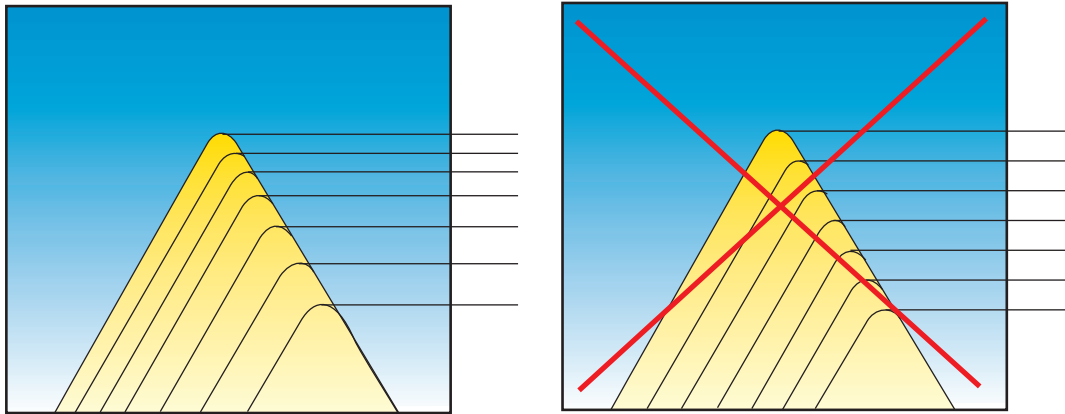
v<sub>c</sub> = Cutting speed (m/min)

Note that there is a fixed relationship between rotational speed and feed rate in threading. Check that the chosen cutting speed does not result in a too high feed speed.

## Number of passes and infeed depths

A thread cannot be made in one cut because of the relatively brittle cutting edge. The total cutting depth must be divided into several passes. Those passes should all have similar cutting forces (equal chip areas), see figures.

Use the tables on page 21-31 to find recommendations for number of passes and infeed depths. The tables give basic recommendations and are applicable on all geometries - Original, A, A1 and A2.



- The infeed series given is based on a good control of the OD/ID tolerances for the selected profile.
- If insert fracture should occur, the number of passes should be increased.
- The infeed depth should not be less than 0,05 mm (0.0020") /pass.
- On stainless steel, the infeed depth per pass should be greater than 0,08 mm (0.0031").
- The recommendations can also be used for part-profile inserts. The number of passes should then, in most cases, be increased.
- The threading insert nose radius is relatively small and can easily be damaged if it is overloaded.

Cutting speed – MDT

SMG	v <sub>c</sub> m/min SFM	
	CP500	
P1	155	510
P2	150	490
P3	130	425
P4	115	375
P5	110	360
P6	125	410
P7	115	375
P8	110	360
P11	115	375
P12	65	215
M1	135	445
M2	110	360
M3	85	280
M4	65	215
M5	50	165
K1	130	425
K2	110	360
K3	95	310
K4	90	295
K5	55	180
K6	80	260
K7	70	230
N1	—	—
N2	—	—
N3	—	—
N11	85	280
S1	21	70
S2	17	55
S3	15	49
S11	—	—
S12	—	—
S13	—	—

Use the SMG tables to classify the workpiece material. Use the table to choose cutting speed.

SMG = Seco Material Group

v<sub>c</sub> = m/min

Cutting speeds (v<sub>c</sub>) in the table are recommendations for a start value.

Due to machine, material and setup condition it is advisable to optimize cutting data. Recommended ranges to use for CP500 +/-15%

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Cutting speed – Mini Shaft

SMG	$v_c$ m/min SFM
P1	155 510
P2	150 490
P3	130 425
P4	115 375
P5	110 360
P6	125 410
P7	115 375
P8	110 360
P11	115 375
P12	65 215
M1	80 260
M2	65 215
M3	50 165
M4	37 120
M5	31 100
K1	150 490
K2	130 425
K3	110 360
K4	105 345
K5	65 215
K6	95 310
K7	80 260
N1	— —
N2	— —
N3	— —
N11	95 310
S1	19 60
S2	15 49
S3	13 43
S11	— —
S12	— —
S13	— —

Use the SMG tables to classify the workpiece material. Use the table to choose cutting speed.  
 SMG = Seco Material Group  
 $v_c$  = m/min  
 Cutting speeds ( $v_c$ ) in the table are recommendations for a start value.  
 Due to machine, material and setup condition it is advisable to optimize cutting data. Recommended ranges to use for CP500 +/-15%

# Number of passes and infeed depths

External ISO-metric threads, metric (inch)

Ph	6.0	5.5	5.0	4.5	4.0	3.5	3.0	2.5	2.0	1.75	1.5	1.25	1.0	0.80	0.75	0.50
$a_p$	3,82 (0.150)	3,52 (0.139)	3,19 (0.126)	2,87 (0.113)	2,53 (0.100)	2,23 (0.088)	1,92 (0.076)	1,60 (0.063)	1,25 (0.049)	1,13 (0.044)	0,93 (0.037)	0,81 (0.032)	0,65 (0.026)	0,52 (0.020)	0,48 (0.019)	0,33 (0.013)
1	0,46 (0.018)	0,43 (0.017)	0,41 (0.016)	0,37 (0.015)	0,34 (0.013)	0,34 (0.013)	0,28 (0.011)	0,27 (0.011)	0,24 (0.009)	0,22 (0.009)	0,22 (0.009)	0,21 (0.008)	0,18 (0.007)	0,17 (0.007)	0,16 (0.006)	0,11 (0.004)
2	0,43 (0.017)	0,40 (0.016)	0,39 (0.015)	0,34 (0.013)	0,32 (0.013)	0,31 (0.012)	0,26 (0.010)	0,24 (0.009)	0,22 (0.009)	0,20 (0.008)	0,20 (0.008)	0,17 (0.007)	0,16 (0.006)	0,15 (0.006)	0,14 (0.006)	0,09 (0.004)
3	0,35 (0.014)	0,32 (0.013)	0,32 (0.013)	0,28 (0.011)	0,25 (0.010)	0,25 (0.010)	0,21 (0.008)	0,20 (0.008)	0,18 (0.007)	0,17 (0.007)	0,17 (0.007)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,11 (0.004)	0,07 (0.003)
4	0,30 (0.012)	0,28 (0.011)	0,27 (0.011)	0,24 (0.009)	0,22 (0.009)	0,21 (0.008)	0,18 (0.007)	0,17 (0.007)	0,16 (0.006)	0,14 (0.006)	0,14 (0.006)	0,11 (0.004)	0,11 (0.004)	0,08 (0.003)	0,07 (0.003)	0,06 (0.002)
5	0,29 (0.011)	0,26 (0.010)	0,24 (0.009)	0,22 (0.009)	0,20 (0.008)	0,18 (0.007)	0,16 (0.006)	0,15 (0.006)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,10 (0.004)	0,08 (0.003)	-	-	-
6	0,26 (0.010)	0,24 (0.009)	0,24 (0.009)	0,22 (0.009)	0,18 (0.007)	0,18 (0.007)	0,15 (0.006)	0,15 (0.006)	0,12 (0.005)	0,10 (0.004)	0,08 (0.003)	0,08 (0.003)	-	-	-	-
7	0,24 (0.009)	0,21 (0.008)	0,22 (0.009)	0,20 (0.008)	0,17 (0.007)	0,16 (0.006)	0,14 (0.006)	0,12 (0.005)	0,11 (0.004)	0,10 (0.004)	-	-	-	-	-	-
8	0,23 (0.009)	0,20 (0.008)	0,20 (0.008)	0,18 (0.007)	0,15 (0.006)	0,15 (0.006)	0,13 (0.005)	0,11 (0.004)	0,08 (0.003)	0,08 (0.003)	-	-	-	-	-	-
9	0,22 (0.009)	0,19 (0.007)	0,19 (0.007)	0,17 (0.007)	0,14 (0.006)	0,14 (0.006)	0,12 (0.005)	0,11 (0.004)	-	-	-	-	-	-	-	-
10	0,19 (0.007)	0,18 (0.007)	0,18 (0.007)	0,16 (0.006)	0,13 (0.005)	0,12 (0.005)	0,11 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-
11	0,18 (0.007)	0,17 (0.007)	0,16 (0.006)	0,14 (0.006)	0,12 (0.005)	0,11 (0.004)	0,10 (0.004)	-	-	-	-	-	-	-	-	-
12	0,16 (0.006)	0,15 (0.006)	0,15 (0.006)	0,13 (0.005)	0,12 (0.005)	0,08 (0.003)	0,08 (0.003)	-	-	-	-	-	-	-	-	-
13	0,15 (0.006)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,11 (0.004)	-	-	-	-	-	-	-	-	-	-	-
14	0,13 (0.005)	0,13 (0.005)	0,10 (0.004)	0,10 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-	-	-	-
15	0,13 (0.005)	0,12 (0.005)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
16	0,10 (0.004)	0,10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Internal ISO-metric threads, metric (inch)

Ph	6.0	5.5	5.0	4.5	4.0	3.5	3.0	2.5	2.0	1.75	1.5	1.25	1.0	0.80	0.75	0.50
$a_p$	3.54 (0.139)	3.25 (0.128)	2.96 (0.117)	2.65 (0.104)	2.33 (0.092)	2.05 (0.081)	1.78 (0.070)	1.48 (0.058)	1.17 (0.046)	1.05 (0.041)	0.85 (0.033)	0.75 (0.030)	0.60 (0.024)	0.49 (0.019)	0.46 (0.018)	0.31 (0.012)
1	0.46 (0.018)	0.43 (0.017)	0.42 (0.017)	0.37 (0.015)	0.34 (0.013)	0.32 (0.013)	0.28 (0.011)	0.26 (0.010)	0.23 (0.009)	0.22 (0.009)	0.20 (0.008)	0.17 (0.007)	0.17 (0.007)	0.17 (0.007)	0.16 (0.006)	0.10 (0.004)
2	0.43 (0.017)	0.40 (0.016)	0.40 (0.016)	0.34 (0.013)	0.31 (0.012)	0.30 (0.012)	0.26 (0.010)	0.25 (0.010)	0.21 (0.008)	0.20 (0.008)	0.18 (0.007)	0.17 (0.007)	0.15 (0.006)	0.14 (0.006)	0.13 (0.005)	0.08 (0.003)
3	0.35 (0.014)	0.33 (0.013)	0.32 (0.013)	0.28 (0.011)	0.24 (0.009)	0.24 (0.009)	0.21 (0.008)	0.18 (0.007)	0.17 (0.007)	0.15 (0.006)	0.15 (0.006)	0.14 (0.006)	0.11 (0.004)	0.11 (0.004)	0.10 (0.004)	0.07 (0.003)
4	0.30 (0.012)	0.26 (0.010)	0.26 (0.010)	0.23 (0.009)	0.21 (0.008)	0.19 (0.007)	0.16 (0.006)	0.15 (0.006)	0.15 (0.006)	0.13 (0.005)	0.13 (0.005)	0.10 (0.004)	0.09 (0.004)	0.07 (0.003)	0.07 (0.003)	0.06 (0.002)
5	0.26 (0.010)	0.22 (0.009)	0.22 (0.009)	0.21 (0.008)	0.18 (0.007)	0.17 (0.007)	0.14 (0.006)	0.13 (0.005)	0.12 (0.005)	0.10 (0.004)	0.11 (0.004)	0.09 (0.004)	0.08 (0.003)	-	-	-
6	0.22 (0.009)	0.20 (0.008)	0.20 (0.008)	0.19 (0.007)	0.15 (0.006)	0.15 (0.006)	0.13 (0.005)	0.12 (0.005)	0.11 (0.004)	0.09 (0.004)	0.08 (0.003)	0.08 (0.003)	-	-	-	-
7	0.20 (0.008)	0.18 (0.007)	0.17 (0.007)	0.16 (0.006)	0.14 (0.006)	0.14 (0.006)	0.12 (0.005)	0.11 (0.004)	0.10 (0.004)	0.08 (0.003)	-	-	-	-	-	-
8	0.19 (0.007)	0.17 (0.007)	0.16 (0.006)	0.15 (0.006)	0.13 (0.005)	0.13 (0.005)	0.11 (0.004)	0.10 (0.004)	0.08 (0.003)	0.08 (0.003)	-	-	-	-	-	-
9	0.18 (0.007)	0.16 (0.006)	0.16 (0.006)	0.14 (0.006)	0.12 (0.005)	0.12 (0.005)	0.10 (0.004)	0.10 (0.004)	-	-	-	-	-	-	-	-
10	0.16 (0.006)	0.15 (0.006)	0.15 (0.006)	0.13 (0.005)	0.12 (0.005)	0.11 (0.004)	0.10 (0.004)	0.08 (0.003)	-	-	-	-	-	-	-	-
11	0.15 (0.006)	0.14 (0.006)	0.14 (0.006)	0.12 (0.005)	0.11 (0.004)	0.10 (0.004)	0.09 (0.004)	-	-	-	-	-	-	-	-	-
12	0.15 (0.006)	0.14 (0.006)	0.14 (0.006)	0.12 (0.005)	0.10 (0.004)	0.08 (0.003)	0.08 (0.003)	-	-	-	-	-	-	-	-	-
13	0.14 (0.006)	0.13 (0.005)	0.12 (0.005)	0.11 (0.004)	0.10 (0.004)	-	-	-	-	-	-	-	-	-	-	-
14	0.13 (0.005)	0.12 (0.005)	0.10 (0.004)	0.10 (0.004)	0.08 (0.003)	-	-	-	-	-	-	-	-	-	-	-
15	0.12 (0.005)	0.12 (0.005)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
16	0.10 (0.004)	0.10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex



External/Internal Whitworth threads, metric (inch)

TPI	4.0	4.5	5	6	7	8	9	10	11	12	14	16	18	19	20	26	28
a <sub>p</sub>	4.29 (0.169)	3.82 (0.150)	3.44 (0.135)	2.90 (0.114)	2.50 (0.098)	2.17 (0.085)	1.93 (0.076)	1.76 (0.069)	1.58 (0.062)	1.45 (0.057)	1.20 (0.047)	1.13 (0.044)	1.01 (0.040)	0.96 (0.038)	0.92 (0.036)	0.72 (0.028)	0.69 (0.027)
1	0.49 (0.019)	0.46 (0.018)	0.45 (0.018)	0.38 (0.015)	0.37 (0.015)	0.32 (0.013)	0.30 (0.012)	0.29 (0.069)	0.28 (0.011)	0.28 (0.011)	0.24 (0.009)	0.24 (0.009)	0.23 (0.009)	0.22 (0.0090)	0.21 (0.008)	0.19 (0.007)	0.18 (0.007)
2	0.46 (0.018)	0.43 (0.017)	0.43 (0.017)	0.36 (0.014)	0.35 (0.014)	0.30 (0.012)	0.28 (0.011)	0.27 (0.011)	0.26 (0.010)	0.26 (0.010)	0.22 (0.009)	0.22 (0.009)	0.22 (0.009)	0.22 (0.009)	0.21 (0.008)	0.18 (0.007)	0.17 (0.007)
3	0.38 (0.015)	0.38 (0.015)	0.38 (0.015)	0.30 (0.012)	0.29 (0.011)	0.24 (0.009)	0.23 (0.009)	0.22 (0.009)	0.22 (0.009)	0.22 (0.009)	0.18 (0.007)	0.19 (0.007)	0.19 (0.007)	0.18 (0.007)	0.17 (0.007)	0.15 (0.006)	0.14 (0.006)
4	0.36 (0.014)	0.33 (0.013)	0.32 (0.013)	0.26 (0.010)	0.25 (0.010)	0.21 (0.008)	0.20 (0.008)	0.19 (0.007)	0.19 (0.007)	0.18 (0.007)	0.15 (0.006)	0.16 (0.006)	0.16 (0.006)	0.14 (0.006)	0.14 (0.006)	0.12 (0.005)	0.12 (0.005)
5	0.34 (0.013)	0.29 (0.011)	0.28 (0.011)	0.22 (0.009)	0.22 (0.009)	0.19 (0.007)	0.18 (0.007)	0.17 (0.007)	0.16 (0.006)	0.16 (0.006)	0.13 (0.005)	0.13 (0.005)	0.13 (0.005)	0.12 (0.005)	0.11 (0.004)	0.08 (0.003)	0.08 (0.003)
6	0.31 (0.012)	0.25 (0.010)	0.25 (0.010)	0.21 (0.008)	0.19 (0.007)	0.17 (0.007)	0.15 (0.006)	0.15 (0.006)	0.14 (0.006)	0.14 (0.006)	0.11 (0.004)	0.11 (0.004)	0.08 (0.003)	0.08 (0.003)	0.08 (0.003)	-	-
7	0.29 (0.011)	0.24 (0.009)	0.22 (0.009)	0.19 (0.007)	0.18 (0.007)	0.15 (0.006)	0.14 (0.006)	0.14 (0.006)	0.13 (0.005)	0.13 (0.005)	0.09 (0.004)	0.08 (0.003)	-	-	-	-	-
8	0.27 (0.011)	0.22 (0.009)	0.20 (0.008)	0.17 (0.007)	0.16 (0.006)	0.14 (0.006)	0.13 (0.005)	0.13 (0.005)	0.12 (0.005)	0.08 (0.003)	0.08 (0.003)	-	-	-	-	-	-
9	0.24 (0.009)	0.20 (0.008)	0.19 (0.007)	0.16 (0.006)	0.15 (0.006)	0.13 (0.005)	0.12 (0.005)	0.12 (0.005)	0.08 (0.003)	-	-	-	-	-	-	-	-
10	0.22 (0.009)	0.18 (0.007)	0.18 (0.007)	0.15 (0.006)	0.14 (0.006)	0.12 (0.005)	0.12 (0.005)	0.08 (0.003)	-	-	-	-	-	-	-	-	-
11	0.20 (0.008)	0.17 (0.007)	0.17 (0.007)	0.14 (0.006)	0.12 (0.005)	0.12 (0.005)	0.08 (0.003)	-	-	-	-	-	-	-	-	-	-
12	0.19 (0.007)	0.16 (0.006)	0.15 (0.006)	0.14 (0.006)	0.08 (0.003)	0.08 (0.003)	-	-	-	-	-	-	-	-	-	-	-
13	0.17 (0.007)	0.15 (0.006)	0.12 (0.005)	0.12 (0.005)	-	-	-	-	-	-	-	-	-	-	-	-	-
14	0.15 (0.006)	0.14 (0.006)	0.10 (0.004)	0.10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-
15	0.12 (0.005)	0.12 (0.005)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
16	0.10 (0.004)	0.10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

External UN threads, metric (*inch*)

TPI	4.0	4.5	5	6	7	8	9	10	11	12	13	14	16	18	20	24	28	32
<b>a<sub>p</sub></b>	4,07 (0.160)	3,62 (0.143)	3,29 (0.130)	2,71 (0.107)	2,33 (0.092)	2,08 (0.082)	1,84 (0.072)	1,66 (0.065)	1,52 (0.060)	1,39 (0.055)	1,29 (0.051)	1,19 (0.047)	1,05 (0.041)	0,94 (0.037)	0,84 (0.033)	0,70 (0.028)	0,60 (0.024)	0,53 (0.021)
<b>1</b>	0,47 (0.019)	0,45 (0.018)	0,43 (0.017)	0,36 (0.014)	0,35 (0.014)	0,30 (0.012)	0,28 (0.011)	0,27 (0.011)	0,27 (0.011)	0,27 (0.011)	0,25 (0.010)	0,23 (0.009)	0,22 (0.009)	0,23 (0.009)	0,20 (0.008)	0,19 (0.007)	0,17 (0.007)	0,17 (0.007)
<b>2</b>	0,44 (0.017)	0,41 (0.016)	0,40 (0.016)	0,34 (0.013)	0,33 (0.013)	0,28 (0.011)	0,26 (0.010)	0,26 (0.010)	0,25 (0.010)	0,26 (0.010)	0,24 (0.009)	0,22 (0.009)	0,21 (0.008)	0,21 (0.008)	0,19 (0.007)	0,17 (0.007)	0,15 (0.006)	0,15 (0.006)
<b>3</b>	0,40 (0.016)	0,39 (0.015)	0,36 (0.014)	0,27 (0.011)	0,26 (0.010)	0,25 (0.010)	0,21 (0.008)	0,20 (0.008)	0,20 (0.008)	0,20 (0.008)	0,18 (0.007)	0,17 (0.007)	0,16 (0.006)	0,16 (0.006)	0,15 (0.006)	0,14 (0.006)	0,11 (0.004)	0,13 (0.005)
<b>4</b>	0,36 (0.014)	0,31 (0.012)	0,31 (0.012)	0,23 (0.009)	0,22 (0.009)	0,21 (0.008)	0,20 (0.008)	0,17 (0.007)	0,19 (0.007)	0,18 (0.007)	0,17 (0.007)	0,15 (0.006)	0,14 (0.006)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,09 (0.004)	0,08 (0.003)
<b>5</b>	0,32 (0.013)	0,26 (0.010)	0,26 (0.010)	0,22 (0.009)	0,21 (0.008)	0,18 (0.007)	0,17 (0.007)	0,16 (0.006)	0,16 (0.006)	0,15 (0.006)	0,14 (0.006)	0,13 (0.005)	0,13 (0.005)	0,12 (0.005)	0,10 (0.004)	0,08 (0.003)	0,08 (0.003)	-
<b>6</b>	0,27 (0.011)	0,23 (0.009)	0,23 (0.009)	0,20 (0.008)	0,19 (0.007)	0,16 (0.006)	0,15 (0.006)	0,15 (0.006)	0,14 (0.006)	0,13 (0.005)	0,12 (0.005)	0,11 (0.004)	0,11 (0.004)	0,08 (0.003)	0,08 (0.003)	-	-	-
<b>7</b>	0,25 (0.010)	0,21 (0.008)	0,20 (0.008)	0,18 (0.007)	0,17 (0.007)	0,14 (0.006)	0,14 (0.006)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,11 (0.004)	0,10 (0.004)	0,08 (0.003)	-	-	-	-	-
<b>8</b>	0,23 (0.009)	0,20 (0.008)	0,19 (0.007)	0,16 (0.006)	0,15 (0.006)	0,13 (0.005)	0,12 (0.005)	0,12 (0.005)	0,11 (0.004)	0,08 (0.003)	0,08 (0.003)	0,08 (0.003)	-	-	-	-	-	-
<b>9</b>	0,22 (0.009)	0,18 (0.007)	0,19 (0.007)	0,15 (0.006)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,11 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-	-
<b>10</b>	0,21 (0.008)	0,17 (0.007)	0,18 (0.007)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,11 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-	-	-
<b>11</b>	0,19 (0.007)	0,16 (0.006)	0,17 (0.007)	0,13 (0.005)	0,11 (0.004)	0,11 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-	-	-	-
<b>12</b>	0,18 (0.007)	0,15 (0.006)	0,15 (0.006)	0,12 (0.005)	0,08 (0.003)	0,08 (0.003)	-	-	-	-	-	-	-	-	-	-	-	-
<b>13</b>	0,16 (0.006)	0,14 (0.006)	0,12 (0.005)	0,11 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>14</b>	0,15 (0.006)	0,14 (0.006)	0,10 (0.004)	0,10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>15</b>	0,12 (0.005)	0,12 (0.005)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
<b>16</b>	0,10 (0.004)	0,10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Internal UN threads, metric (inch)

TPI	4	4.5	5	6	7	8	9	10	11	12	13	14	16	18	20	24	28	32
$a_p$	3,74 (0.147)	3,32 (0.131)	2,99 (0.118)	2,46 (0.097)	2,13 (0.084)	1,88 (0.074)	1,66 (0.065)	1,49 (0.059)	1,36 (0.054)	1,25 (0.049)	1,14 (0.045)	1,06 (0.042)	0,93 (0.037)	0,84 (0.033)	0,76 (0.030)	0,64 (0.025)	0,56 (0.022)	0,49 (0.019)
1	0,44 (0.017)	0,41 (0.016)	0,42 (0.017)	0,35 (0.014)	0,34 (0.013)	0,30 (0.012)	0,28 (0.011)	0,27 (0.011)	0,27 (0.011)	0,27 (0.011)	0,25 (0.010)	0,23 (0.009)	0,22 (0.009)	0,23 (0.009)	0,20 (0.008)	0,18 (0.007)	0,17 (0.007)	0,17 (0.007)
2	0,41 (0.016)	0,38 (0.015)	0,38 (0.015)	0,33 (0.013)	0,32 (0.013)	0,28 (0.011)	0,26 (0.010)	0,25 (0.010)	0,23 (0.009)	0,23 (0.009)	0,20 (0.008)	0,18 (0.007)	0,18 (0.007)	0,17 (0.007)	0,16 (0.006)	0,15 (0.006)	0,14 (0.006)	0,14 (0.006)
3	0,39 (0.015)	0,34 (0.013)	0,33 (0.013)	0,25 (0.010)	0,24 (0.009)	0,22 (0.009)	0,19 (0.007)	0,18 (0.007)	0,18 (0.007)	0,18 (0.007)	0,15 (0.006)	0,14 (0.006)	0,14 (0.006)	0,14 (0.006)	0,13 (0.005)	0,13 (0.005)	0,09 (0.004)	0,10 (0.004)
4	0,33 (0.013)	0,28 (0.011)	0,27 (0.011)	0,21 (0.008)	0,21 (0.008)	0,18 (0.007)	0,16 (0.006)	0,15 (0.006)	0,15 (0.006)	0,15 (0.006)	0,13 (0.005)	0,13 (0.005)	0,12 (0.005)	0,12 (0.005)	0,10 (0.004)	0,10 (0.004)	0,08 (0.003)	0,08 (0.003)
5	0,28 (0.011)	0,23 (0.009)	0,23 (0.009)	0,18 (0.007)	0,17 (0.007)	0,15 (0.006)	0,14 (0.006)	0,13 (0.005)	0,13 (0.005)	0,13 (0.005)	0,12 (0.005)	0,11 (0.004)	0,10 (0.004)	0,10 (0.004)	0,09 (0.004)	0,08 (0.003)	0,08 (0.003)	-
6	0,24 (0.009)	0,20 (0.008)	0,20 (0.008)	0,16 (0.006)	0,15 (0.006)	0,13 (0.005)	0,13 (0.005)	0,12 (0.005)	0,11 (0.004)	0,11 (0.004)	0,11 (0.004)	0,10 (0.004)	0,09 (0.004)	0,08 (0.003)	0,08 (0.003)	-	-	-
7	0,22 (0.009)	0,19 (0.007)	0,18 (0.007)	0,15 (0.006)	0,14 (0.006)	0,12 (0.005)	0,12 (0.005)	0,11 (0.004)	0,11 (0.004)	0,10 (0.004)	0,10 (0.004)	0,09 (0.004)	0,08 (0.003)	-	-	-	-	-
8	0,21 (0.008)	0,18 (0.007)	0,17 (0.007)	0,14 (0.006)	0,13 (0.005)	0,11 (0.004)	0,11 (0.004)	0,10 (0.004)	0,10 (0.004)	0,08 (0.003)	0,08 (0.003)	0,08 (0.003)	-	-	-	-	-	-
9	0,20 (0.008)	0,17 (0.007)	0,16 (0.006)	0,13 (0.005)	0,12 (0.005)	0,11 (0.004)	0,10 (0.004)	0,10 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-	-
10	0,18 (0.007)	0,16 (0.006)	0,15 (0.006)	0,12 (0.005)	0,12 (0.005)	0,10 (0.004)	0,09 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-	-	-
11	0,17 (0.007)	0,15 (0.006)	0,14 (0.006)	0,12 (0.005)	0,11 (0.004)	0,10 (0.004)	0,08 (0.003)	-	-	-	-	-	-	-	-	-	-	-
12	0,16 (0.006)	0,14 (0.006)	0,14 (0.006)	0,11 (0.004)	0,08 (0.003)	0,08 (0.003)	-	-	-	-	-	-	-	-	-	-	-	-
13	0,15 (0.006)	0,14 (0.006)	0,12 (0.005)	0,11 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
14	0,14 (0.006)	0,13 (0.005)	0,10 (0.004)	0,10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
15	0,12 (0.005)	0,12 (0.005)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
16	0,10 (0.004)	0,10 (0.004)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

External multi-tooth inserts, metric (inch)

Type	ISO Metric						UN					Whitworth	NPT		
	3M	2M	3M	2M	3M	2M	2M	3M	2M	3M	2M	2M	2M	3M	2M
Ph mm	1,0	1,5	1,5	2,0	2,0	3,0	-	-	-	-	-	-	-	-	-
TPI	-	-	-	-	-	-	16	16	12	12	8	11	11,5	11,5	8
$a_p$ mm (inch)	0,65 (0.026)	0,93 (0.037)	0,93 (0.037)	1,25 (0.049)	1,25 (0.049)	1,92 (0.076)	1,05 (0.041)	1,05 (0.041)	1,39 (0.055)	1,39 (0.055)	2,08 (0.082)	1,58 (0.062)	1,76 (0.069)	1,76 (0.069)	2,54 (0.100)
Pass 1 mm (inch)	0,36 (0.026)	0,43 (0.017)	0,56 (0.022)	0,57 (0.022)	0,75 (0.030)	0,65 (0.026)	0,49 (0.019)	0,64 (0.025)	0,64 (0.025)	0,84 (0.033)	0,70 (0.028)	0,73 (0.029)	0,59 (0.023)	0,81 (0.032)	0,88 (0.035)
2	0,29 (0.011)	0,30 (0.012)	0,37 (0.015)	0,40 (0.016)	0,50 (0.020)	0,53 (0.021)	0,33 (0.013)	0,41 (0.016)	0,44 (0.017)	0,55 (0.022)	0,57 (0.022)	0,50 (0.020)	0,50 (0.020)	0,57 (0.022)	0,64 (0.025)
3	-	0,20 (0.008)	-	0,28 (0.011)	-	0,42 (0.017)	0,23 (0.009)	-	0,31 (0.012)	-	0,46 (0.018)	0,35 (0.014)	0,37 (0.015)	0,38 (0.015)	0,57 (0.022)
4	-	-	-	-	-	0,32 (0.013)	-	-	-	-	0,35 (0.014)	-	0,30 (0.012)	-	0,45 (0.018)

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Internal multi-tooth inserts, metric (inch)

Type	ISO Metric						UN						Whitworth	NPT		
	3M	2M	3M	2M	3M	2M	2M	3M	2M	3M	2M	2M	2M	3M	2M	
Ph mm	1,0	1,5	1,5	2,0	2,0	3,0	-	-	-	-	-	-	-	-	-	
TPI	-	-	-	-	-	-	16	16	12	12	8	11	11,5	11,5	8	
a <sub>p</sub> (inch)	0,60 (0.024)	0,85 (0.033)	0,85 (0.033)	1,17 (0.046)	1,17 (0.046)	1,78 (0.070)	0,93 (0.037)	0,93 (0.037)	1,25 (0.049)	1,25 (0.049)	1,88 (0.074)	1,58 (0.062)	1,76 (0.069)	1,76 (0.069)	2,54 (0.100)	
Pass 1 mm (inch)	0,33 (0.013)	0,38 (0.015)	0,51 (0.020)	0,51 (0.020)	0,70 (0.028)	0,55 (0.022)	0,42 (0.017)	0,56 (0.022)	0,56 (0.022)	0,75 (0.030)	0,58 (0.023)	0,73 (0.029)	0,59 (0.023)	0,81 (0.032)	0,88 (0.035)	
2	0,27 (0.011)	0,27 (0.011)	0,34 (0.013)	0,38 (0.015)	0,47 (0.019)	0,49 (0.019)	0,30 (0.017)	0,37 (0.015)	0,40 (0.016)	0,50 (0.020)	0,51 (0.020)	0,50 (0.020)	0,50 (0.020)	0,57 (0.022)	0,64 (0.025)	
3	-	0,20 (0.008)	-	0,28 (0.011)	-	0,42 (0.017)	0,21 (0.008)	-	0,29 (0.011)	-	0,44 (0.017)	0,35 (0.014)	0,37 (0.015)	0,38 (0.015)	0,57 (0.022)	
4	-	-	-	-	-	0,32 (0.013)	-	-	-	-	0,35 (0.014)	-	0,30 (0.012)	-	0,45 (0.018)	

External/Internal NPT threads, metric (inch)

TPI	8	11,5	14	18	27
a <sub>p</sub>	2,54 (0.100)	1,76 (0.069)	1,45 (0.057)	1,12 (0.044)	0,75 (0.030)
1	0,28 (0.011)	0,25 (0.010)	0,24 (0.009)	0,22 (0.009)	0,19 (0.007)
2	0,25 (0.010)	0,22 (0.009)	0,22 (0.009)	0,18 (0.007)	0,15 (0.006)
3	0,22 (0.009)	0,18 (0.007)	0,17 (0.007)	0,15 (0.006)	0,13 (0.005)
4	0,19 (0.007)	0,16 (0.006)	0,15 (0.006)	0,14 (0.006)	0,11 (0.004)
5	0,18 (0.007)	0,16 (0.006)	0,14 (0.006)	0,13 (0.005)	0,09 (0.004)
6	0,18 (0.007)	0,14 (0.006)	0,13 (0.005)	0,12 (0.005)	0,08 (0.003)
7	0,17 (0.007)	0,14 (0.006)	0,12 (0.005)	0,10 (0.004)	-
8	0,17 (0.007)	0,12 (0.005)	0,10 (0.004)	0,08 (0.003)	-
9	0,16 (0.006)	0,12 (0.005)	0,10 (0.004)	-	-
10	0,16 (0.006)	0,10 (0.004)	0,08 (0.003)	-	-
11	0,14 (0.006)	0,09 (0.004)	-	-	-
12	0,13 (0.005)	0,08 (0.003)	-	-	-
13	0,12 (0.005)	-	-	-	-
14	0,11 (0.004)	-	-	-	-
15	0,08 (0.003)	-	-	-	-

Thread turning

Thread MDT

Thread Mini-Stat<sup>™</sup>

Rotating threading

Annex

External Round DIN 405, metric (*inch*)

TPI	4	6	8	10
$a_p$	3,43 (0.135)	2,23 (0.088)	1,73	1,40
1	0,44 (0.017)	0,33 (0.013)	0,29 (0.011)	0,26 (0.010)
2	0,40 (0.016)	0,29 (0.011)	0,26 (0.010)	0,25 (0.010)
3	0,34 (0.013)	0,25 (0.010)	0,21 (0.008)	0,23 (0.009)
4	0,32 (0.013)	0,23 (0.009)	0,19 (0.007)	0,20 (0.008)
5	0,28 (0.011)	0,20 (0.008)	0,18 (0.007)	0,16 (0.006)
6	0,26 (0.010)	0,18 (0.007)	0,16 (0.006)	0,12 (0.005)
7	0,24 (0.009)	0,16 (0.006)	0,14 (0.006)	0,10 (0.004)
8	0,22 (0.009)	0,15 (0.006)	0,12 (0.005)	0,08 (0.003)
9	0,20 (0.008)	0,14 (0.006)	0,10 (0.004)	–
10	0,19 (0.007)	0,12 (0.005)	0,08 (0.003)	–
11	0,17 (0.007)	0,10 (0.004)	–	–
12	0,15 (0.006)	0,08 (0.003)	–	–
13	0,12 (0.005)	–	–	–
14	0,10 (0.004)	–	–	–

Internal Round DIN 405, metric (*inch*)

TPI	4	6	8	10
$a_p$	3,59 (0.141)	2,44 (0.096)	1,66 (0.065)	1,49 (0.059)
1	0,46 (0.018)	0,38 (0.015)	0,26 (0.010)	0,27 (0.011)
2	0,43 (0.017)	0,34 (0.013)	0,22 (0.009)	0,26 (0.010)
3	0,40 (0.016)	0,30 (0.012)	0,21 (0.009)	0,25 (0.010)
4	0,35 (0.014)	0,25 (0.010)	0,19 (0.007)	0,22 (0.009)
5	0,30 (0.012)	0,21 (0.008)	0,18 (0.007)	0,18 (0.007)
6	0,26 (0.010)	0,19 (0.007)	0,16 (0.006)	0,13 (0.005)
7	0,24 (0.009)	0,17 (0.007)	0,14 (0.006)	0,10 (0.004)
8	0,22 (0.009)	0,16 (0.006)	0,12 (0.005)	0,08 (0.003)
9	0,20 (0.008)	0,14 (0.006)	0,10 (0.004)	–
10	0,19 (0.007)	0,12 (0.005)	0,08 (0.003)	–
11	0,17 (0.007)	0,10 (0.004)	–	–
12	0,15 (0.006)	0,08 (0.003)	–	–
13	0,12 (0.005)	–	–	–
14	0,10 (0.004)	–	–	–

External TR thread, metric

Ph	14.0	12.0	10.0	9.0	8.0	7.0	6.0	5.0	4.0	3.0	2.0	1.5
$a_p$	8,2	6,72	5,7	5,16	4,68	4,17	3,66	2,89	2,38	1,83	1,33	0,97
1	0,40	0,38	0,38	0,38	0,37	0,37	0,37	0,34	0,31	0,27	0,25	0,23
2	0,37	0,36	0,36	0,35	0,35	0,34	0,35	0,33	0,28	0,25	0,24	0,22
3	0,36	0,34	0,34	0,34	0,34	0,33	0,32	0,27	0,24	0,21	0,20	0,18
4	0,36	0,34	0,34	0,33	0,33	0,31	0,29	0,25	0,20	0,17	0,17	0,14
5	0,35	0,32	0,32	0,31	0,31	0,29	0,27	0,23	0,19	0,15	0,14	0,12
6	0,35	0,32	0,32	0,30	0,29	0,26	0,25	0,21	0,18	0,13	0,13	0,08
7	0,34	0,30	0,31	0,29	0,28	0,26	0,23	0,20	0,16	0,13	0,11	-
8	0,34	0,30	0,29	0,28	0,27	0,26	0,22	0,20	0,15	0,12	0,09	-
9	0,34	0,30	0,28	0,26	0,25	0,24	0,22	0,18	0,15	0,12	-	-
10	0,33	0,29	0,27	0,25	0,24	0,23	0,20	0,16	0,15	0,10	-	-
11	0,33	0,29	0,25	0,24	0,23	0,22	0,18	0,15	0,14	0,10	-	-
12	0,32	0,29	0,24	0,23	0,21	0,22	0,17	0,14	0,13	0,08	-	-
13	0,32	0,28	0,23	0,22	0,20	0,20	0,17	0,13	0,10	-	-	-
14	0,31	0,27	0,22	0,21	0,19	0,19	0,16	0,10	-	-	-	-
15	0,31	0,25	0,22	0,21	0,19	0,17	0,14	-	-	-	-	-
16	0,30	0,25	0,20	0,19	0,18	0,16	0,12	-	-	-	-	-
17	0,30	0,24	0,19	0,18	0,17	0,12	-	-	-	-	-	-
18	0,29	0,22	0,18	0,16	0,15	-	-	-	-	-	-	-
19	0,28	0,20	0,17	0,15	0,13	-	-	-	-	-	-	-
20	0,27	0,20	0,16	0,15	-	-	-	-	-	-	-	-
21	0,23	0,19	0,15	0,13	-	-	-	-	-	-	-	-
22	0,23	0,18	0,15	-	-	-	-	-	-	-	-	-
23	0,21	0,17	0,13	-	-	-	-	-	-	-	-	-
24	0,19	0,16	-	-	-	-	-	-	-	-	-	-
25	0,17	0,15	-	-	-	-	-	-	-	-	-	-
26	0,16	0,13	-	-	-	-	-	-	-	-	-	-
27	0,16	-	-	-	-	-	-	-	-	-	-	-
28	0,15	-	-	-	-	-	-	-	-	-	-	-
29	0,13	-	-	-	-	-	-	-	-	-	-	-

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex

Internal TR threads, metric

Ph	14.0	12.0	10.0	9.0	8.0	7.0	6.0	5.0	4.0	3.0	2.0	1.5
$a_p$	8,47	6,71	5,7	5,19	4,68	4,17	3,65	2,89	2,38	1,85	1,34	0,98
1	0,40	0,38	0,38	0,38	0,37	0,37	0,37	0,34	0,31	0,27	0,25	0,23
2	0,37	0,36	0,36	0,35	0,35	0,34	0,34	0,33	0,28	0,25	0,24	0,22
3	0,36	0,34	0,34	0,34	0,34	0,33	0,32	0,27	0,24	0,22	0,21	0,19
4	0,36	0,34	0,34	0,33	0,33	0,31	0,29	0,25	0,20	0,17	0,17	0,14
5	0,35	0,32	0,32	0,31	0,31	0,29	0,27	0,23	0,19	0,15	0,14	0,12
6	0,35	0,32	0,32	0,31	0,29	0,26	0,25	0,21	0,18	0,14	0,13	0,08
7	0,34	0,30	0,31	0,29	0,28	0,26	0,23	0,20	0,16	0,13	0,11	-
8	0,34	0,30	0,29	0,29	0,27	0,26	0,22	0,20	0,15	0,12	0,09	-
9	0,34	0,30	0,28	0,26	0,25	0,24	0,22	0,18	0,15	0,12	-	-
10	0,33	0,29	0,27	0,25	0,24	0,23	0,20	0,16	0,15	0,10	-	-
11	0,33	0,29	0,25	0,24	0,23	0,22	0,18	0,15	0,14	0,10	-	-
12	0,32	0,28	0,24	0,23	0,21	0,22	0,17	0,14	0,13	0,08	-	-
13	0,32	0,28	0,23	0,22	0,20	0,20	0,17	0,13	0,10	-	-	-
14	0,31	0,27	0,22	0,21	0,19	0,19	0,16	0,10	-	-	-	-
15	0,31	0,25	0,22	0,21	0,19	0,17	0,14	-	-	-	-	-
16	0,30	0,25	0,20	0,19	0,18	0,16	0,12	-	-	-	-	-
17	0,30	0,24	0,19	0,18	0,17	0,12	-	-	-	-	-	-
18	0,29	0,22	0,18	0,16	0,15	-	-	-	-	-	-	-
19	0,28	0,20	0,17	0,15	0,13	-	-	-	-	-	-	-
20	0,27	0,20	0,16	0,15	-	-	-	-	-	-	-	-
21	0,23	0,19	0,15	0,13	-	-	-	-	-	-	-	-
22	0,23	0,18	0,15	-	-	-	-	-	-	-	-	-
23	0,21	0,17	0,13	-	-	-	-	-	-	-	-	-
24	0,19	0,16	-	-	-	-	-	-	-	-	-	-
25	0,17	0,15	-	-	-	-	-	-	-	-	-	-
26	0,16	0,13	-	-	-	-	-	-	-	-	-	-
27	0,16	-	-	-	-	-	-	-	-	-	-	-
28	0,15	-	-	-	-	-	-	-	-	-	-	-
29	0,13	-	-	-	-	-	-	-	-	-	-	-
30	0,13	-	-	-	-	-	-	-	-	-	-	-

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

External ACME, *inch*

TPI	2	3	4	5	6	8	10	12	14	16
$a_p$	0.265	0.18	0.138	0.112	0.095	0.074	0.063	0.050	0.041	0.039
1	0.028	0.019	0.013	0.012	0.011	0.010	0.010	0.009	0.008	0.009
2	0.026	0.018	0.012	0.011	0.011	0.010	0.009	0.009	0.008	0.009
3	0.023	0.016	0.011	0.010	0.010	0.009	0.009	0.007	0.007	0.007
4	0.022	0.015	0.011	0.01	0.009	0.007	0.007	0.007	0.006	0.006
5	0.019	0.013	0.010	0.009	0.008	0.006	0.006	0.005	0.005	0.005
6	0.017	0.011	0.010	0.008	0.007	0.005	0.005	0.005	0.004	0.003
7	0.015	0.011	0.009	0.007	0.006	0.005	0.005	0.004	0.003	-
8	0.013	0.009	0.008	0.007	0.006	0.005	0.004	0.004	-	-
9	0.013	0.009	0.008	0.007	0.006	0.005	0.004	-	-	-
10	0.011	0.009	0.007	0.006	0.006	0.004	0.004	-	-	-
11	0.011	0.008	0.007	0.006	0.006	0.004	-	-	-	-
12	0.01	0.007	0.006	0.006	0.005	0.004	-	-	-	-
13	0.009	0.007	0.006	0.005	0.004	-	-	-	-	-
14	0.009	0.007	0.006	0.004	-	-	-	-	-	-
15	0.008	0.006	0.006	0.004	-	-	-	-	-	-
16	0.007	0.005	0.004	-	-	-	-	-	-	-
17	0.007	0.005	0.004	-	-	-	-	-	-	-
18	0.006	0.005	-	-	-	-	-	-	-	-
19	0.006	-	-	-	-	-	-	-	-	-
20	0.005	-	-	-	-	-	-	-	-	-

Internal ACME, *inch*

TPI	2	3	4	5	6	8	10	12	14	16
$a_p$	0.265	0.182	0.142	0.114	0.098	0.078	0.065	0.049	0.042	0.040
1	0.028	0.020	0.013	0.012	0.012	0.011	0.010	0.009	0.009	0.009
2	0.026	0.018	0.012	0.012	0.011	0.011	0.010	0.009	0.008	0.009
3	0.023	0.016	0.012	0.011	0.011	0.009	0.009	0.007	0.007	0.008
4	0.022	0.015	0.011	0.010	0.009	0.007	0.007	0.006	0.006	0.006
5	0.019	0.013	0.011	0.009	0.008	0.006	0.006	0.005	0.005	0.005
6	0.017	0.011	0.010	0.008	0.007	0.006	0.006	0.005	0.004	0.003
7	0.015	0.011	0.009	0.007	0.007	0.005	0.005	0.004	0.003	-
8	0.013	0.009	0.008	0.007	0.006	0.005	0.004	0.004	-	-
9	0.013	0.009	0.008	0.007	0.006	0.005	0.004	-	-	-
10	0.011	0.009	0.007	0.006	0.006	0.005	0.004	-	-	-
11	0.011	0.008	0.007	0.006	0.006	0.004	-	-	-	-
12	0.010	0.007	0.006	0.006	0.005	0.004	-	-	-	-
13	0.009	0.007	0.006	0.005	0.004	-	-	-	-	-
14	0.009	0.007	0.006	0.004	-	-	-	-	-	-
15	0.008	0.006	0.006	0.004	-	-	-	-	-	-
16	0.007	0.005	0.005	-	-	-	-	-	-	-
17	0.007	0.005	0.005	-	-	-	-	-	-	-
18	0.006	0.005	-	-	-	-	-	-	-	-
19	0.006	-	-	-	-	-	-	-	-	-
20	0.005	-	-	-	-	-	-	-	-	-



Multi-tooth insert TWIN THREADER, TT  
External 60° threads, metric (*inch*)

Ph (mm)	2.0	1.5	1.0
$a_p$ mm ( <i>inch</i> )	1,25 (0.049)	0,93 (0.037)	0,65 (0.026)
Pass mm ( <i>inch</i> )	0,25 (0.010)	0,22 (0.009)	0,22 (0.009)
2	0,36 (0.014)	0,31 (0.012)	0,25 (0.010)
3	0,25 (0.010)	0,22 (0.009)	0,18 (0.007)
4	0,21 (0.008)	0,18 (0.007)	-
5	0,18 (0.007)	-	-

Internal 60° threads, metric (*inch*)

Ph (mm)	2.0	1.5	1.0
$a_p$ mm ( <i>inch</i> )	1,17 (0.046)	0,85 (0.033)	0,60 (0.024)
Pass 1 mm ( <i>inch</i> )	0,23 (0.009)	0,20 (0.008)	0,19 (0.007)
2	0,34 (0.013)	0,27 (0.011)	0,23 (0.009)
3	0,23 (0.009)	0,20 (0.008)	0,18 (0.007)
4	0,19 (0.007)	0,18 (0.007)	-
5	0,18 (0.007)	-	-

External and internal Whitworth and BSPT threads, metric (*inch*)

TPI	11	14
$a_p$ mm ( <i>inch</i> )	1,58 (0.062)	1,20 (0.047)
Pass 1 mm ( <i>inch</i> )	0,26 (0.010)	0,22 (0.009)
2	0,38 (0.015)	0,35 (0.014)
3	0,27 (0.011)	0,24 (0.009)
4	0,25 (0.010)	0,21 (0.008)
5	0,22 (0.009)	0,18 (0.007)
6	0,20 (0.008)	-

External UN threads, metric (*inch*)

TPI	12	16
$a_p$ mm ( <i>inch</i> )	1,39 (0.055)	1,05 (0.041)
Pass 1 mm ( <i>inch</i> )	0,28 (0.011)	0,25 (0.010)
2	0,38 (0.015)	0,36 (0.014)
3	0,28 (0.011)	0,26 (0.010)
4	0,25 (0.010)	0,18 (0.007)
5	0,20 (0.008)	-

Internal UN threads, metric (*inch*)

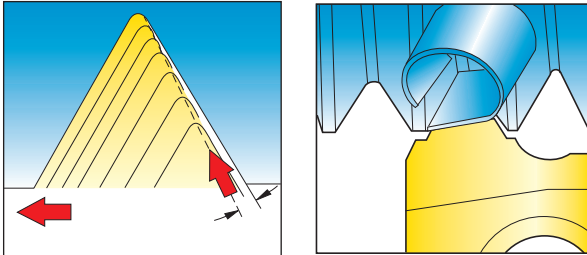
TPI	12	16
$a_p$ mm ( <i>inch</i> )	1,25 (0.049)	0,93 (0.037)
Pass 1 mm ( <i>inch</i> )	0,24 (0.009)	0,21 (0.008)
2	0,35 (0.014)	0,32 (0.013)
3	0,25 (0.010)	0,22 (0.009)
4	0,22 (0.009)	0,18 (0.007)
5	0,19 (0.007)	-

## Infeed method

The choice of infeed method is most important for long chipping materials to ensure good chip control.

### Modified flank infeed

For CNC machines and conventional machines

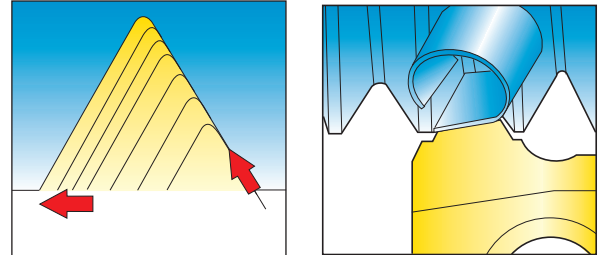


**First choice for CNC machines**  
The infeed angle should be 2,5–5% less than the flank angle

- Good chip control (important for internal threading)
- Good surface finish on thread
- Long tool life

### Flank infeed

For CNC machines and conventional machines

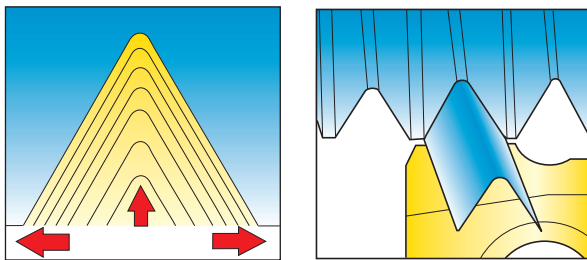


**Choose flank infeed when modified flank infeed cannot be used**

- Good chip control
- Can result in bad surface on thread
- Not suitable for work hardening materials

### Radial infeed

For conventional machines and multi-tooth inserts

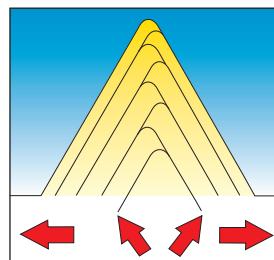


**Multitooth inserts demand radial infeed**  
**First choice for work hardening materials**

- Difficult to control the chip
- High cutting forces

### Alternate flank infeed

For CNC machines



**First choice for large coarse threads**

- Long tool life
- Chipbreaking problems can arise

## Nomenclature and formula

RPM	
$n = \frac{v_c \cdot 1000}{\pi \cdot D_c}$	(rev/min)
Cutting speed	
$v_c = \frac{n \cdot \pi \cdot D_c}{1000}$	(m/min)
Slide velocity/feed rate	
$v_f = \frac{n \cdot P_h}{1000}$	(mm/min)
Lead	
$P_h = P \cdot \text{numbers of starts}$	(mm)
Helix angle	
$\frac{P_h}{D_2 \cdot \pi}$	(°) $\lambda = \arctan$
Conversion of P to TPI	
$TPI = \frac{25,4}{P}$	

$D_c$	= Workpiece diameter (mm)
$D_2$	= Pitch diameter (mean diameter) (mm)
$n$	= RPM (rev/min)
$P$	= Pitch (mm)
$P_h$	= Lead (mm)
$v_f$	= Slide velocity (feed rate) (m/min)
TPI	= Number of threads per inch
$v_c$	= Cutting speed (m/min)
$\lambda$	= Helix angle (°)

RPM	
$n = \frac{v_c \cdot 3.82}{D_c}$	(rev/min)
Cutting speed	
$v_c = \frac{n \cdot D_c}{3.82}$	(sf/min)
Feed speed	
$v_f = n \cdot Z_n \cdot f_z$	(in/min)
$v_f = n \cdot Z_c \cdot f_z$	(in/min)
Feed per revolution	
$f = Z_n \cdot f_z$	(in/rev)
$f = Z_c \cdot f_z$	(in/rev)

$D_c$	= Cutter diameter (inch)
$f$	= Feed per revolution (inch)
$f_z$	= Feed per tooth (in/tooth)
$Z_c$	= Effective No. of teeth for calculation of feed speed or feed per rev
$n$	= RPM (rev/min)
$v_c$	= Cutting speed (sf/min)
$v_f$	= Feed speed (sf/min)
$Z_n$	= No. of teeth

## Toolholder modification to thread small ID

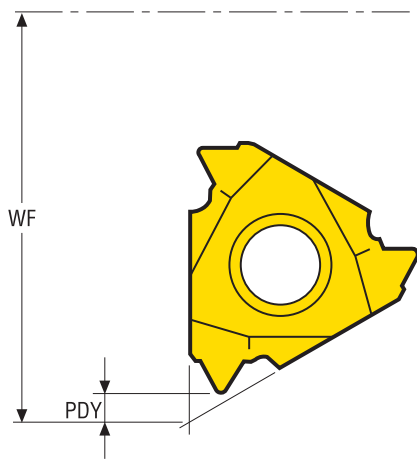
It is often necessary to cut internal threads which are too small to be made with a standard toolholder.

Several standard internal toolholders can be modified by a simple reworking so that threads can be cut in approximately 30% smaller bores. This modification work can be made on a lathe with a four-jaw chuck. In the dimension table  $D_m \text{ min}^*$  at pages 'Toolholders Internal' you will find the dimensions required for the alteration.

On demand, these internal toolholders can also be supplied as special design.

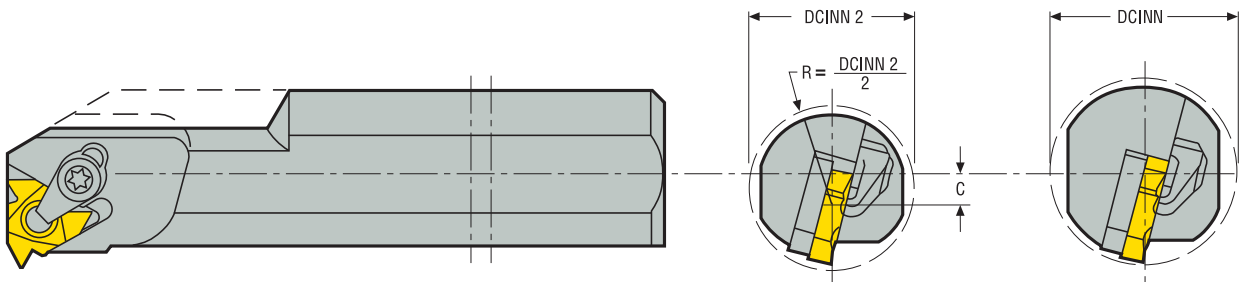
For some holders it is possible to work inside smaller bores than indicated by the  $D_m \text{ mod}$  dimension, here it is necessary "to back off" the bottom corner of the insert (possibly also the insert shim).

### Reference dimensions on insert



WF and PDY dimensions can be found on the pages for internal toolholders and threading inserts.

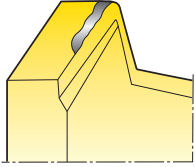
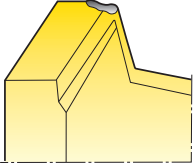
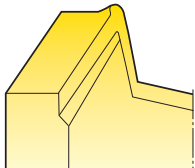
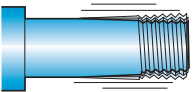
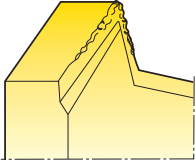
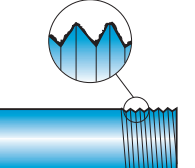
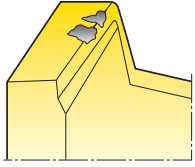
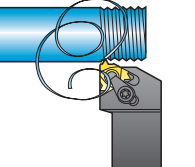
### Reference dimensions on bar



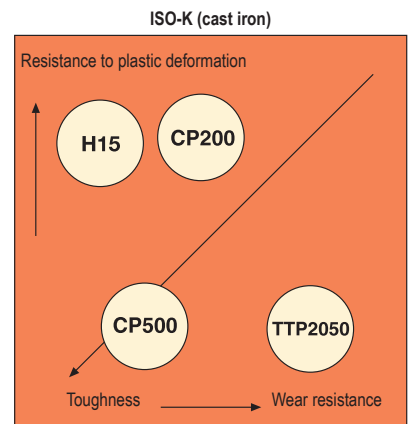
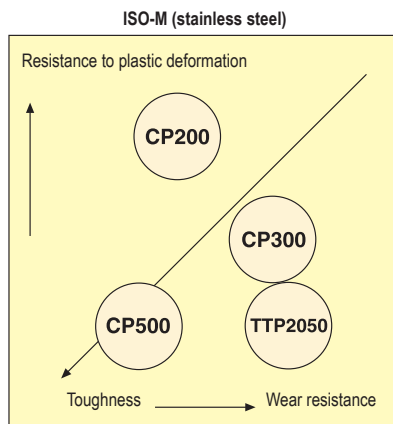
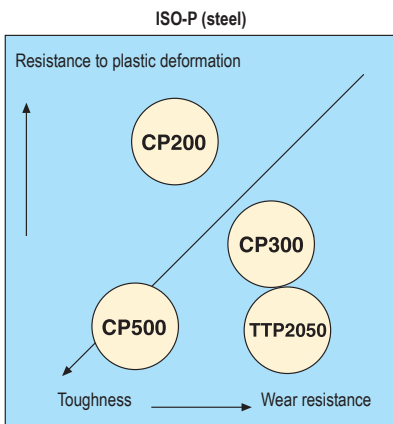
$$C = WF - PDY + R - DCINN2$$

C = Centre-point displacement when modifying the tool.  
DCINN = Minimum bore diameter of standard tool.  
DCINN2 = Minimum bore diameter with a modified tool.

# Troubleshooting

<p><b>Rapid flank wear</b></p> <ul style="list-style-type: none"> <li>• Reduce the cutting speed</li> <li>• Increase the infeed per pass</li> <li>• Use modified flank infeed</li> <li>• Check that the correct insert shim has been selected</li> <li>• Select a more wear-resistant grade</li> </ul> 	<p><b>Insert fracture</b></p> <ul style="list-style-type: none"> <li>• Increase the number of passes</li> <li>• Check the workpiece mounting</li> <li>• Check the centre height of the cutting edge</li> <li>• Check for built-up edge</li> <li>• Select a tougher grade</li> </ul> 
<p><b>Plastic deformation</b></p> <ul style="list-style-type: none"> <li>• Select a grade with better resistance to plastic deformation</li> <li>• Reduce the cutting speed</li> <li>• Increase the number of passes</li> <li>• Increase the coolant supply</li> <li>• Check that the workpiece diameter is correct prior to cutting the thread</li> </ul> 	<p><b>Vibrations</b></p> <ul style="list-style-type: none"> <li>• Change the cutting speed</li> <li>• Reduce the overhang and use the most stable toolholder</li> <li>• Check the centre height of the cutting edge</li> <li>• Check that the workpiece diameter is correct</li> </ul> 
<p><b>Build-up edge</b></p> <ul style="list-style-type: none"> <li>• Increase the cutting speed</li> <li>• Do not use coolant</li> </ul> 	<p><b>Poor finish</b></p> <ul style="list-style-type: none"> <li>• Increase the cutting speed</li> <li>• Check that the correct insert shim has been selected</li> <li>• Use modified flank infeed or radial infeed</li> </ul> 
<p><b>Edge chipping</b></p> <ul style="list-style-type: none"> <li>• Check the workpiece mounting</li> <li>• Check the cutting speed</li> <li>• Use modified flank infeed</li> <li>• Select a tougher grade</li> </ul> 	<p><b>Poor chip control</b></p> <ul style="list-style-type: none"> <li>• Reduce the number of passes</li> <li>• Increase the cutting speed</li> <li>• Use modified flank infeed</li> <li>• Increase the coolant supply</li> </ul> 

## Optimisation



## Torque values for clamping screws

Maximum Torque value for each screw is shown below

Screw designation	Torque Nm	Torque key	Screw designation	Torque Nm	Torque key
110.26-655	10,0	H00T-60100	L84017-T09P	2,0	T00-09P20
117.26-655	5,0	H00T-3050	L85011-T15P	5,0	T00-15P50
117.26-657	3,0	H00-2530	L85012-T15P	5,0	T00-15P50
170.26-655	6,0	H00T-4060	L85017-T09P	2,0	T00-09P20
C02205-T07P	0,9	T00-07P09	L85020-T15P	3,5	T00-15P35
C02505-T07P	0,9	T00-07P09	L85021-T15P	3,5	T00-15P35
C02506-T07P	0,9	T00-07P09	L86015-T20P	6,0	T00T-20P60
C03007-T09P	2,0	T00-09P20	L86025-T20P	6,0	T00T-20P60
C03508-T15P	3,0	T00-15P30	LD1035-T25P	6,0	T00T-25P60
C03509-T15P	3,0	T00-15P30	LD5020-T09P	2,0	T00-09P20
C03510-T15P	3,0	T00-15P30	LD6020-T15P	3,0	T00-15P30
C03511-T09P	2,0	T00-09P20	LD6021-T09P	2,0	T00-09P20
C03512-T15P	3,0	T00-15P30	LD6024-T20P	3,0	T00-15P30
C04008-T15P	3,5	T00-15P35	LD6025-T15P	3,0	T00-15P30
C04010-T15P	3,5	T00-15P35	LD6026-T09P	2,0	T00-09P20
C04011-T15P	3,5	T00-15P35	LD8025-T25P	6,0	T00T-25P60
C04014-T15P	3,5	T00-15P35	LD8030-T25P	6,0	T00T-25P60
C04512-T15P	5,0	T00-15P50	LS0512	2,5	-
C04518-T15P	5,0	T00-15P50	LS0613	3,0	H00-2530
C05010-T20P	5,0	T00-20P50	LS0616	3,0	H00-2530
C05012-T15P	5,0	T00-15P50	LS0818	4,0	-
C05013-T20P	5,0	T00-20P50	LS0822	4,0	-
C05018-T20P	5,0	T00-20P50	MC6S4X14	3,5	-
C11804-T06P	0,5	T00-06P05	MC6S4X18	3,5	-
C46017-T20P	6,0	T00T-20P60	MC6S5X14	5,0	H00T-4050
C82204-T06P	0,5	T00-06P05	MC6S5X18	5,0	H00T-4050
CC05	0,9	H00-1509	MN0909L-T09P	2,0	T00-09P20
CC08P-V13	2,0	T00-09P20	MN1215L-T15P	3,0	T00-15P30
CC09P-D11	2,0	T00-09P20	MN1215R-T15P	3,0	T00-15P30
CC12P-S12	3,5	T00-15P35	MN1215S-T15P	3,0	T00-15P30
CC14	6,0	H00T-4060	MN1215T-T15P	3,0	T00-15P30
CC16	10,0	-	MN1515-T15P	3,0	T00-15P30
CC17P	10,0	-	MN1515SL-T15P	3,0	T00-15P30
CC17P-06	10,0	-	MN1520-T20P	6,0	T00T-20P60
CC17P-09	10,0	-	MN1920-T20P	6,0	T00T-20P60
CC20P	10,0	-	MN1925-T25P	5,0	T00T-25P50
CC20P-V13	10,0	-	MN2525-T25P	6,0	T00T-25P60
CD09-S09	2,0	T00-09P20	PL1403-T09P	2,5	T00-09P20
CD12-S12	3,5	T00-15P35	TCEI0409	3,5	-
CD16-S16	5,0	T00-20P50	TCEI0509	6,0	H00T-4060
CD19-S19	5,0	T00-20P50	TCEI0513	6,0	H00T-4060
CD19-V16	5,0	T00-20P50	TCEI0609	8,0	H00T-5080
CSC8015-T20P	5,0	T00-20P50	TCEI0613	8,0	H00T-5080
CSC1015-T20P	5,0	T00-20P50	TCEI0614	8,0	H00T-5080
CSP16-T15P	2,0	T00-15P20	TCEI0620	8,0	H00T-5080
CSP22-T15P	3,0	T00-15P30	TCEI0815	10,0	H00T-60100
CSP27-T25P	6,0	T00T-25P60	TCEI0825	10,0	H00T-60100
			TCEI1020	15,0	-
			WS1620-T20P	3,5	T00-20P35
			WS1920-T20P	3,5	T00-20P35
			WS2325-T25P	5,0	T00T-25P50

For the Seco range of torque keys, please see next page

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex



# Torque keys

The range of torque keys with fixed torque values are available, in combinations key grip/torque value for insert locking, for most of the Seco turning products. By using a torque key you always ensure the correct tightening force when mounting the insert. The torque value is given on page(s) 37 for each screw. Torque keys are calibrated according to ISO 6789.

**Code key:** T00-15P35

T00 = Torque screwdriver type for Torx Plus blade  
T00T = Torque T-handle type for Torx Plus blade  
H00 = Torque screwdriver for hexagonal blade  
H00T = Torque T-handle type for hexagonal blade



15P = Torx Plus size  
35 = Torque value 3,5 Nm

Torque key*	Replaceable blade	Torx Plus size	Torque value
			
T00-06P05	T00-06P	T06P	0,5 Nm
T00-07P05	T00-07P	T07P	0,5 Nm
T00-07P09	T00-07P	T07P	0,9 Nm
T00-08P12	T00-08P	T08P	1,2 Nm
T00-08P20	T00-08P	T08P	2,0 Nm
T00-09P09	T00-09P	T09P	0,9 Nm
T00-09P12	T00-09P	T09P	1,2 Nm
T00-09P20	T00-09P	T09P	2,0 Nm
T00-10P20	T00-10P	T10P	2,0 Nm
T00-10P30	T00-10P	T10P	3,0 Nm
T00-10P35	T00-10P	T10P	3,5 Nm
T00-15P20	T00-15P	T15P	2,0 Nm
T00-15P30	T00-15P	T15P	3,0 Nm
T00-15P35	T00-15P	T15P	3,5 Nm
T00-15P40	T00-15P	T15P	4,0 Nm
T00-15P50	T00-15P	T15P	5,0 Nm
T00-20P35	T00-20P	T20P	3,5 Nm
T00-20P50	T00-20P	T20P	5,0 Nm



\*Including blade

Torque key*	Replaceable blade	Hexagonal size	Torque value
			
H00-1305	H00-1.3	1,3 mm	0,5 Nm
H00-1505	H00-1.5	1,5 mm	0,5 Nm
H00-1509	H00-1.5	1,5 mm	0,9 Nm
H00-2009	H00-2.0	2,0 mm	0,9 Nm
H00-2016	H00-2.0	2,0 mm	1,6 Nm
H00-2020	H00-2.0	2,0 mm	2,0 Nm
H00-2512	H00-2.5	2,5 mm	1,2 Nm
H00-2530	H00-2.5	2,5 mm	3,0 Nm
H00-2535	H00-2.5	2,5 mm	3,5 Nm
H00-3020	H00-3.0	3,0 mm	2,0 Nm
H00-3030	H00-3.0	3,0 mm	3,0 Nm
H00-4030	H00-4.0	4,0 mm	3,0 Nm

\*Including blade

Torque key*	Replaceable blade	Torx Plus size	Torque value
			
T00T-15P50	T00T-15P	T15P	5,0 Nm
T00T-20P50	T00T-20P	T20P	5,0 Nm
T00T-20P60	T00T-20P	T20P	6,0 Nm
T00T-20P80	T00T-20P	T20P	8,0 Nm
T00T-25P50	T00T-25P	T25P	5,0 Nm
T00T-25P60	T00T-25P	T25P	6,0 Nm
T00T-25P80	T00T-25P	T25P	8,0 Nm
T00T-30P80	T00T-30P	T30P	8,0 Nm

\*Including blade

Torque key*	Replaceable blade	Hexagonal size	Torque value
			
H00T-3050	H00T-3.0	3 mm	5,0 Nm
H00T-4050	H00T-4.0	4 mm	5,0 Nm
H00T-4060	H00T-4.0	4 mm	6,0 Nm
H00T-5050	H00T-5.0	5 mm	5,0 Nm
H00T-5080	H00T-5.0	5 mm	8,0 Nm
H00T-50100	H00T-5.0	5 mm	10,0 Nm
H00T-60100	H00T-6.0	6 mm	10,0 Nm

\*Including blade

Please note that the blades are not interchangeable between screwdriver type and T-handle type. Torx Plus® is a registered trade mark belonging to Camcar-TeXtron (USA)

# Application overview, toolholders

## External toolholders

PER/L...QHDJET PER/L...QHDJET	CER/L CER/L...HD	CER/L...Q CER/L...QHD	CER...CQHD	CER...HD CER/L...QHD
Page(s) 52-53	Page(s) 57	Page(s) 58 - 59	Page(s) 60	Page(s) 61

## Internal toolholders

PNR/L...AHDJET	SNR/L	CNR/L...AHD CNR/L...APIHD	CNR/L...AHD
Page(s) 54 - 56	Page(s) 62	Page(s) 63 - 64	Page(s) 65

## Seco-Capto™

CER/L...HD...CHD Ext.	CER..HD Ext.	SNR Int.	CNR/L...HD Int.	CNR/L...CHD Int.
Page(s) 66 - 67	Page(s) 68	Page(s) 69 - , 70	Page(s) 71 - 75	Page(s) 76 - 78

## Seco-Capto™ for MTM

CER...HD	CEL...HD
Page(s) 79	Page(s) 80

Thread turning

Thread MDT

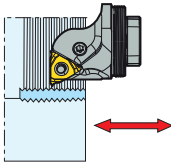
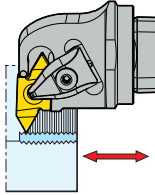
Thread Mini-Shaft™

Rotating threading

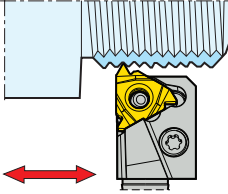
Annex



Steadyline® with GL connection

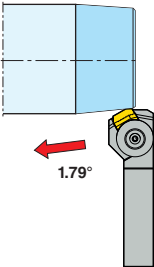
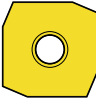
GL...-PNR/L...-AHDJET	GL50-CNR...26AHD
	
Page(s) 81, 82	Page(s) 83

Quick Change, Jetstream Tooling®, QC-heads, external

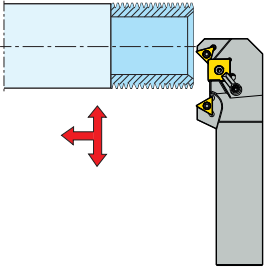
QC...-PER/L-HDJET

Page(s) 84

Toolholders for peeling

Inserts for peeling

CSXCR...	SCNN
	
Page(s) 85-86	Page(s) 103

Toolholders for pipe-facing

MSGNR...

Page(s) 87-88

Toolholders for inserts SNMA, SNMG, SNMM / CNMA, CNMG, CNMM

C.-DSKNR/L - CLNR/L 75°	C.-MSKNR/L - PCLNR/L 75°
Page(s) 89	Page(s) 90

Toolholders for chasers

External toolholders for chasers CER...X	Seco-Capto™ CER...X	Seco-Capto™ CNR/L...X	Seco-Capto™ CNL...C-X	Steadyline® GL... -CNR/L...-I/X
Page(s) 91-92	Page(s) 93	Page(s) 94 - 95	Page(s) 96 - 97	Page(s) 98

Toolholders for Precision Grooves

CEAR/L...	SNR/L...	CNR/L...	CER/L...
Page(s) 99	Page(s) 100	Page(s) 101	Page(s) 102

Thread turning

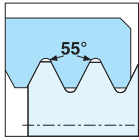
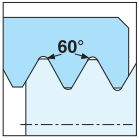
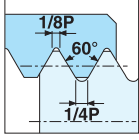
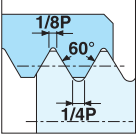
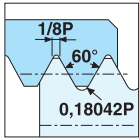
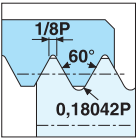
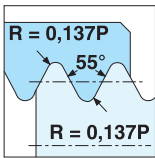
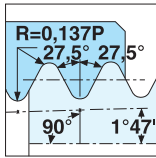
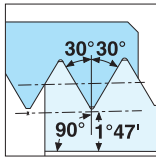
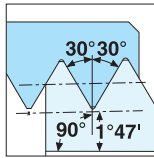
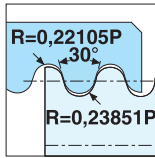
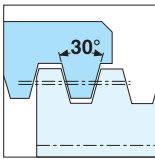
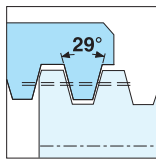
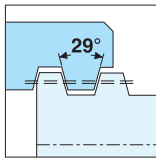
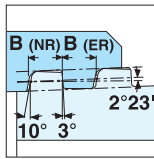
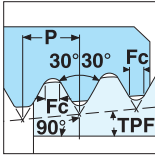
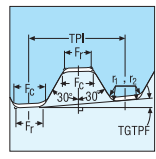
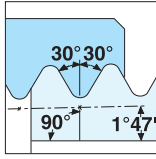
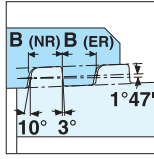
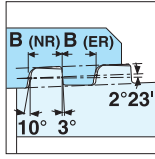
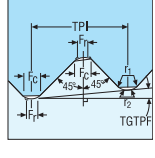
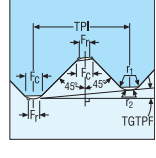
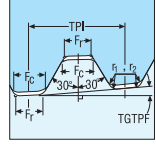
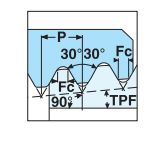
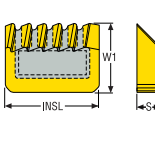
Thread MDT

Thread Mini-Start™

Rotating threading

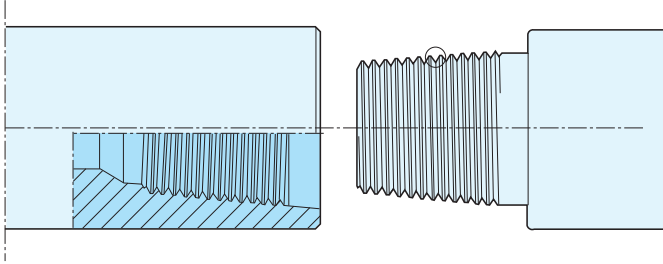
Annex

# Application overview, inserts

Partial profile inserts	55° V profile	60° V profile			
					
	Page(s) 104-105	Page(s) 105-107			
Full profile inserts	ISO metric	UN			
Reusable threaded joints					
	Page(s) 108-112	Page(s) 113-116			
Full profile inserts	UNJ	MJ			
Reusable threaded joints for the aerospace industry					
	Page(s) 117-118	Page(s) 119-120			
Full profile inserts	Whitworth, BSW	BSPT	NPT	NPTF	Round-DIN405
Permanent threaded joints for pipe mountings and couplings					
	Page(s) 121-124	Page(s) 125-126	Page(s) 127-128	Page(s) 129-130	Page(s) 131-132
Partial profile inserts	TR-DIN103	ACME	Stub-ACME	American Buttress	
Motion-transmitting threads					
	Page(s) 133-134	Page(s) 135-136	Page(s) 137-138	Page(s) 139-140	
Full profile inserts	API Rotary Drill Connection	Hughes Flush	API ROUND	API Buttress 1:16 VAM Buttress 1:16	API Buttress 1:12
Threads for the oil industry					
	Page(s) 141-142	Page(s) 143-144	Page(s) 145-146	Page(s) 147-148	Page(s) 149-150
Full profile inserts	Hughes H90	Hughes Slimline H90	P.A.C	Chasers API/Gost	Chipformers for chasers
Threads for the oil industry					
	Page(s) 143-144	Page(s) 143-144	Page(s) 143-144	Page(s) 151-152	Page(s) 153-155

## Rotary drilling connections

OCTG pipe and coupling illustration



Connections	Pitch TPI	TGTPF	API code	Snap-Tap® code
<b>API Number</b>				
NC10 - NC16	6.0	1.5	V055	6API558
NC23 - NC50	4.0	2.0	V038R	4API386
NC56 - NC77	4.0	3.0	V038R	4API384
<b>API Regular</b>				
1 - 1 1/2 REG	6.0	1.5	V055	6API558
2 3/8 REG - 4 1/2 REG	5.0	3.0	V040	5API404
5 1/2 REG, 7 5/8 REG, 8 5/8 REG	4.0	3.0	V050	4API504
6 5/8 REG	4.0	2.0	V050	4API506
<b>Internal Flush</b>				
2 3/8 IF - 6 5/8 IF	4.0	2.0	V038R	4API386
<b>Full Hole</b>				
3 1/2 FH, 4 1/2 FH	5.0	3.0	V040	5API404
4 FH	4.0	2.0	V038R	4API386
5 1/2 FH, 6 5/8 FH	4.0	2.0	V050	4API506
<b>Hughes External Flush</b>				
2 3/8, 2 7/8	6.0	2.0	-	6HEF
3 1/2, 4 1/2	4.0	2.0	V038R	4API386
<b>Hughes Xtra Hole</b>				
2 7/8 - 5	4.0	2.0	V038R	4API386
<b>Hughes Slim Hole</b>				
2 3/8 - 4 1/2	4.0	2.0	V038R	4API386
<b>Hughes Double Streamline</b>				
3 1/2 - 5 1/2	4.0	2.0	V038R	4API386
<b>Hughes H90</b>				
3 1/2 - 6 5/8	3.5	2.0	90V050	3.5H906
7 - 8 5/8	3.5	3.0	90V050	3.5H904
<b>Hughes Slimline H90</b>				
2 3/8 - 3 1/2	3.0	1.25	90V050	3H90
<b>Hughes ACME Regular</b>				
2 3/8 - 6 5/8	4.0	3.373	-	4HACME
<b>Hughes ACME Streamline</b>				
2 3/8 - 5 1/2	4.0	3.373	-	4HACME
<b>P.A.C.</b>				
2 3/8 PAC - 3 1/2 PAC	4.0	1.5	V076	4PAC
<b>Macaroni</b>				
MT, AMT, AMMT	6.0	1.5	V055	6API558

Thread turning

Thread MDT

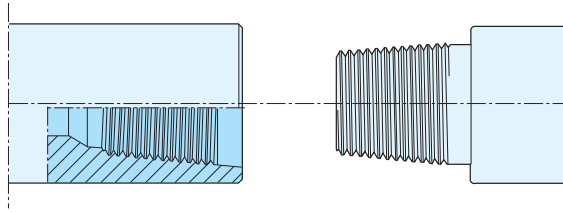
Thread Mini-Start™

Rotating threading

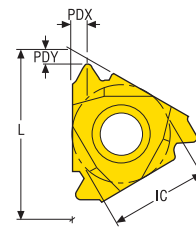
Annex

# Rotary drilling connections

Connections



Insert dimensions



Connections							
Snap-Tap® code	API code	Pitch TPI	TGTPF <i>inch</i>	L mm	IC mm	PDX mm	PDY mm
6API558	V055	6.0	1.5	22,0	12,700	2,5	2,0
5API404	V040	5.0	3.0	22,0	12,700	2,5	2,0
5API404	V040	5.0	3.0	27,5	15,875	3,2	2,2
4API386	V038R	4.0	2.0	22,0	12,700	2,5	1,9
4API386	V038R	4.0	2.0	27,5	15,875	3,2	2,2
4API384	V038R	4.0	3.0	27,5	15,875	3,2	2,2
4API506	V050	4.0	2.0	27,5	15,875	3,2	2,2
4API504	V050	4.0	3.0	27,5	15,875	3,2	2,2
6HEF	–	6.0	2.0	22,0	12,700	2,5	2,0
4PAC	V076	4.0	1.5	27,5	15,875	3,2	2,2
3,5H906	90V050	3.5	2.0	27,5	15,875	3,2	2,2
3,5H904	90V050	3.5	3.0	27,5	15,875	3,2	2,2
3H90	90V050	3.0	1.25	27,5	15,875	3,2	2,2
4HACME	–	4.0	3.373	27,5	15,875	3,2	2,2

## Thread profile

Profile	TPI	TGTPF	R/F, mm (Inch)	F <sub>c</sub> mm (Inch)	r <sub>1</sub> mm (Inch)	r <sub>2</sub> mm (Inch)	API code	Snap-Tap® code
	5.0	3.0	0,508 (0.200)	1,016 (0.0400)	0,381 (0.0150)	–	V040	5API404
	4.0	2.0	0,965 (0.0380)	1,651 (0.0650)	0,381 (0.0150)	–	V038R	4API386
	4.0	3.0	0,965 (0.0380)	1,651 (0.0650)	0,381 (0.0150)	–	V038R	4API384
	4.0	2.0	0,635 (0.0250)	1,270 (0.0500)	0,381 (0.0150)	–	V050	4API506
	4.0	3.0	0,635 (0.0250)	1,270 (0.0500)	0,381 (0.0150)	–	V050	4API504
	6.0	1.5	1,194 (0.0470)	1,397 (0.0550)	0,381 (0.0150)	0,381 (0.0150)	V055	6API558
	6.0	2.0	0,559 (0.0220)	0,813 (0.0320)	0,381 (0.0150)	0,381 (0.0150)	–	6HEF
	4.0	1.5	1,702 (0.0670)	1,930 (0.0760)	0,381 (0.0150)	0,381 (0.0150)	V076	4PAC
	3.5	2.0	0,864 (0.0340)	1,270 (0.0500)	0,381 (0.0150)	0,762	90V050	3,5H906
	3.5	3.0	0,864 (0.0340)	1,270 (0.0500)	0,381 (0.0150)	0,762	90V050	3,5H904
	3.0	1.25	1,727 (0.0680)	2,134 (0.0840)	0,381 (0.0150)	0,762	90V050	3H90
	4.0	3.373	2,253 (0.0887)	2,388 (0.0940)	0,787 (0.0310)	0,787 (0.0310)	–	4HACME

Thread turning

Thread MDT

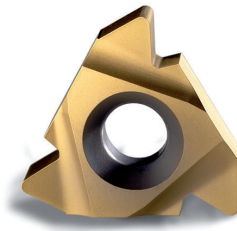
Thread Mini-Start™

Rotating threading

Annex

# Oil and gas threading

Seco Snap-Tap® Quality Assurance



## 1. Metallurgical control of substrate

Check of substrate regarding Hc, MM and porosity.  
Measured according to SPM.  
Values stored in a database.

## 4. Dimension control after grinding

Profile and radius.  
Measured according to SPM.

## 7. Final inspection

Visual Inspection.  
Sampling in accordance to AQL.

## 2. Dimension check after sintering

Measuring of IC and thickness.  
Measured according to SPM.  
Values stored in a database.

## 5. Edge measuring

Edge radius checked during honing.  
Measured according to SPM.  
Values stored in a database.

## 8. Production management System

SGS (SPM1) - Control specifications.  
LS - Production instructions.  
Seco Act - System for preventive and corrective actions.  
Approved to ISO 9001 and 14001 standard.

## 3. Dimension control after bottom grinding

Thickness and cutting edge height.  
Flatness.  
Measured according to SPM.

## 6. Measuring of coating

Coating, check of thickness and adhesion.  
Measured according to SPM.  
Values stored in a database.

## 9. Abbreviations

LS - Local management Systems - contains local process descriptions, routines, procedures and instructions.  
SGS - Seco Global Standards - consists of instructions common for all Seco companies.  
SPM - Seco Production Manual - Part of SGS is a collection of instructions and documents with the purpose to guide and maintain the quality level of Seco products.  
AQL - Accepted Quality Level (Mil-std).  
MM - Content of Tungsten in binder.  
Hc - Coercivity, describing grainsize.

# Oil and gas threading

Seco Chasers Quality Assurance



## 1. Metallurgical control of substrate

Check of substrate regarding Hc, MM and porosity.  
Measured according to SPM.  
Values stored in a database.

## 2. Dimension control after top and bottom grinding

Thickness.  
Roughness Ra.  
Flatness.  
Measured according to SPM.

## 3. Measuring after periphery Grinding

Optical measuring.  
Data stored in a database.

## 4. Dimension control after grinding

Profile and radius.  
Measured according to SPM.

## 5. Edge measuring

Edge radius checked during honing.  
Measured according to SPM.  
Values stored in a database.

## 6. Measuring of coating

Coating (PVD), check of thickness and adhesion.  
Measured according to SPM.  
Values stored in a database.

## 7. Height classification

Optical measuring of height.  
Graphic presentation of values.  
Sorted and labelled with height classification.

## 8. Final inspection

Edge inspection 100%.  
Profile check with tolerance drawing, sampling in accordance to AQL.

## 9. Traceability

Finished products from each order saved for future reference.  
Saved 5 years from production date.  
Finished product has full traceability.

## 10. Overlay drawings

Printer for overlays is calibrated with glass scale monthly.  
Scaled master printout is saved according to SPM.

## 11. Production management System

SGS (SPM1) - Control specifications.  
LS - Production instructions.  
Seco Act - System for preventive and corrective actions.  
Approved to ISO 9001 and 14001 standard.

## 12. Abbreviations

LS - Local management Systems - contains local process descriptions, routines, procedures and instructions.  
SGS - Seco Global Standards - consists of instructions common for all Seco companies.  
SPM - Seco Production Manual - Part of SGS is a collection of instructions and documents with the purpose to guide and maintain the quality level of Seco products.  
AQL - Accepted Quality Level (Mil-std).  
MM - Content of Tungsten in binder.  
Hc - Coercivity, describing grainsize.



## ISO Attribute information

ISO Attribute	Explanation
ALD	Active drill length
APMXS	Depth of cut maximum
B	Shank width
BAWS	Workpiece side body angle
BD	Body diameter
BSG	Basic standard group
C	Keyway depth
CDX	Cutting depth maximum
CF	Spot chamfer
CP	Coolant pressure
CW	Cutting width
CZC	Connection size code
DC	Cutting diameter
DCB	Connection bore diameter
DCINN	Minimum cutting diameter
DCSFMS	Contact surface diameter machine side
DCSFWS	Workpiece side contact surface diameter
DMM	Shank diameter
FHA	Flute helix angle
H	Shank height
HC	Thread height actual
HF	Functional height
IC	Inscribed circle diameter
INSL	Insert length
KWW	Keyway width
L	Cutting edge length
LF	Functional length
LH	Head length
LPR	Protruding length
LS	Shank length
LU	Usable length
LUX	Maximum usable length
NOF	Flute count
NT	Tooth count
OAL	Overall length
PDX	Profile distance ex
PDY	Profile distance ey
PHDR	Recommended pre machined hole diameter
PHDX	Maximum pre machined hole diameter
PNA	Profile included angle
RE	Corner radius
S	Insert thickness
SIG	Point angle
STA	Step included angle
TCTR	Thread tolerance class
TDZ	Thread diameter size
TGTPF	Taper gradient taper per foot
THCHT	Thread chamfer type
THFT	Thread form type
THLGTH	Thread length
TPI	Threads per inch
TPIN	Minimum threads per inch
TPIX	Maximum threads per inch
TPX	Maximum thread pitch
TTP	Thread type
ULDR	Usable length diameter ratio
W1	Insert width
WF	Functional width
ZEFP	Peripheral effective cutting edge count

## Jetstream Tooling® Introduction

Seco Jetstream Tooling® is a revolutionary solution to the problem of delivering coolant precisely to the cutting zone.

It works by delivering a concentrated high pressure jet of coolant at high velocity straight to the optimum position precisely to the cutting edge.

The jet lifts the chips away from the rake face, improving chip control and tool life, enabling increased cutting data.

It has been proven to show improvements in nearly all material groups with a wide choice of coolant pressures.

Seco Jetstream Tooling® Duo holders, yet another innovation introduced to the market, features both a rake face and a flank face jet, that may provide even better chip control and significantly longer tool life.

For many years, Seco has been supporting the market with Jetstream Tooling® solutions for ISO-turning and grooving applications. Now the Jetstream Tooling® technique will also be available on holders for thread turning (Snap-Tap®).

Coolant can either be supplied to the toolholder externally through a coolant hose, which is attached to one of the inlet positions of the toolholder, or by the new JETI connection.

When it comes to boring bars, the coolant is supplied internally from the back end.

For internal applications, holders for Steadyline® bars are also available, designated GL-. Please see more information regarding Steadyline® in catalog Turning.

Square shank holders for external applications are designed with the Duo technique. They also have the option for coolant supply through JETI connection.

The JETI is developed with a compact assembly in mind, the tooling eliminates the need for any external piping and connections that would otherwise obstruct machine movements in tight workspaces. Coolant hole underneath the square shank holder make it possible for coolant to reach the cutting edge directly from the tool block.

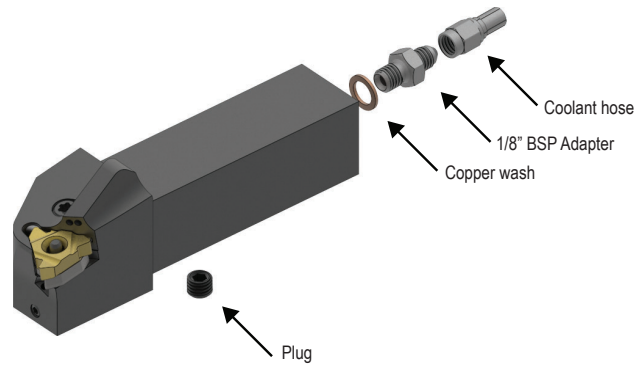


# Jetstream Tooling® Assembly instructions

## Description of parts

For personal safety, Jetstream Tooling® should only be used with the machine door in a fully closed position in accordance with general machine safety procedures.

Please ensure that the coolant hose is located correctly and fully tightened with all seals in position. The unused coolant hole should have a blanking plug fitted. Please note the maximum safe working pressures shown below.

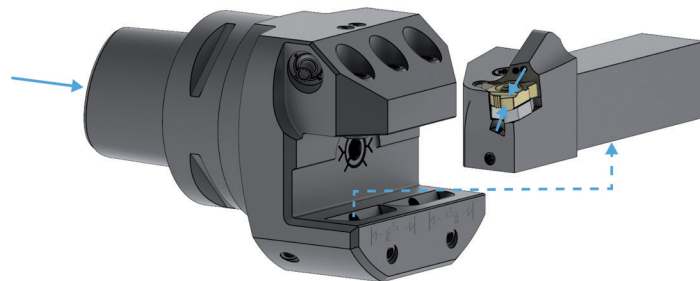


For accessories, see next page.

## JETI Assembly instructions

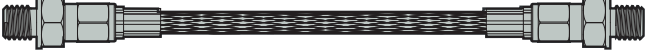


To use the benefits of a JETI-holder there is a need to use a basic holder designed for JETI-connections. Maximum coolant pressure when using this feature is 150 bar.

Note: The unused coolant hole (from the back) should have a blanking plug fitted.












## Accessories and spare parts

Hoses, Part No. ordering code includes spare parts

Connection type	Part No.	Length mm (inch)
<b>Straight fitting</b> 	JET-HOSE150SS	150 (5.906)
	JET-HOSE200SS	200 (7.874)
	JET-HOSE250SS	250 (9.843)
	JET-HOSE300SS	300 (11.811)
<b>Banjo fitting</b> 	JET-HOSE150BS	150 (5.906)
	JET-HOSE200BS	200 (7.874)
	JET-HOSE250BS	250 (9.843)
	JET-HOSE300BS	300 (11.811)
<b>Banjo-to-Banjo fitting</b> 	JET-HOSE150BB	150 (5.906)
	JET-HOSE200BB	200 (7.874)
	JET-HOSE250BB	250 (9.843)
	JET-HOSE300BB	300 (11.811)

All hoses are pressure rated to a maximum of 275 bar (3990 psi).

### Spare Parts, Parts included in delivery

Part No.	Image	...SS	...BS	...BB
JET-CFP1/8BSP		■	■	■
JET-CBP15		■	■	■
JET-AD1/8BSP		■	■	
JET-ADM10		■		
JET-BBM10			■	■
JET-BB1/8BSP			■	■
JET-C1/4-1/8BSP			■	■
JET-P1/8-5mm		■	■	■
JET-WM10*		■	■	■
JET-ORING10X1**		■	■	■

Pack of 2, except \*Pack of 20  
 \*\* Not suitable for use in inducer  
 For assembly instructions, see page(s) 49

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex



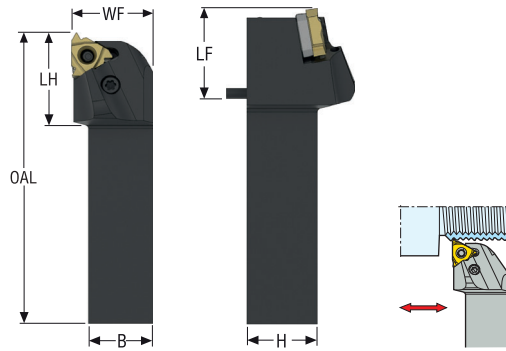
## Thread turning Toolholders

The innovative toolholders made for use with Snap-Tap® inserts offer the best possible holding power available for long tool life and high accuracy. They employ an Anti-Twist insert locking system that features a carbide pin in the back of the insert pocket that resists wear and prevents the insert from turning or twisting under pressure during machining.

- Anti-Twist Toolholders
- D-style clamp for securely pulls insert down and into the pocket

# Jetstream Tooling® – Toolholders, external

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 117, 119, 121, 122, 125, 127, 129, 131, 133, 135, 137, 139, 141, 143, 145, 147, 149
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	OAL	WF	LH	Weight	CP*	CTWS
		mm	mm	mm	mm	mm	mm	kg	bar	
PER2020X16QHDJETI	03007228	20,0	20,0	27,0	91,0	25,0	30,0	0,5	275,0	16
PEL2020X16QHDJETI	03007229	20,0	20,0	27,0	91,0	25,0	30,0	0,4	275,0	16
PER2525X16QHDJETI	03007230	25,0	25,0	27,0	111,0	32,0	30,0	0,6	275,0	16
PEL2525X16QHDJETI	03007231	25,0	25,0	27,0	111,0	32,0	30,0	0,7	275,0	16
PER2525X22QHDJETI	03007241	25,0	25,0	41,0	125,0	32,0	44,0	0,7	275,0	22
PER2525X27QHDJETI	03007246	25,0	25,0	41,0	125,0	32,0	44,0	0,7	275,0	27

## Spare Parts

For holders	Insert lever	Insert shim (S)	Lever screw	Locking key	Shim pin
...16QHD...					
...16QHD...	PP3712	GXA16-1	LS0612-T15P	T15P-7	AC4625
...22QHD...	PP4816	NXA22-1	LS0815-T25P	T25P-7	AC5035
...27QHD...	PP6019	VXA27-1	LS0820-T25P	T25P-7	AC6050

## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Plug
...16QHD...													
...16QHD...	MXA16-1	GXA16-0	-	-	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	-	-	-	P6SS4X8
...22QHD...	MXA22-1	NXA22-0	NXA22-98	NXA22-97.5	NXA22-0.5	NXA22-1.5	NXA22-2	NXA22-3	NXA22-4	NXA22-99.5	NXA22-99	NXA22-98.5	P6SS4X8
...27QHD...	MXA27-1	VXA27-0	VXA27-98	-	VXA27-0.5	VXA27-1.5	VXA27-2	VXA27-3	VXA27-4	VXA27-99.5	VXA27-99	VXA27-98.5	P6SS4X8

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

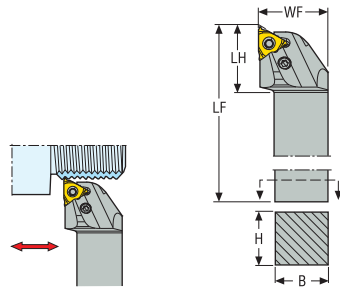
Thread Mini-Start™

Rotating threading

Annex

# Jetstream Tooling® – Toolholders, external

For S-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 117, 119, 121, 122, 125, 127, 129, 131, 133, 135, 137, 139, 141, 143, 145, 147, 149
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	WF	LH	Weight	CP	CTWS
		<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>lbs</i>	<i>psi</i>	
PER075516QHDJET	03007234	0.750	0.750	5.000	0.970	1.181	0.880	10.827	16
PEL075516QHDJET	03007235	0.750	0.750	5.000	0.970	1.181	1.540	10.827	16
PER100616QHDJET	03007236	1.000	1.000	6.000	1.250	1.181	1.980	10.827	16
PEL100616QHDJET	03007237	1.000	1.000	6.000	1.250	1.181	1.980	10.827	16
PER125616QHDJET	03007238	1.250	1.250	6.000	1.500	1.181	2.870	10.827	16
PEL125616QHDJET	03007240	1.250	1.250	6.000	1.500	1.181	2.870	10.827	16
PER100622QHDJET	03007244	1.000	1.000	6.000	1.250	1.732	1.980	10.827	22
PER125622QHDJET	03007245	1.250	1.250	6.000	1.500	1.732	2.870	10.827	22
PER100627QHDJET	03007249	1.000	1.000	6.000	1.250	1.732	1.980	10.827	27
PER125627QHDJET	03007250	1.250	1.250	6.000	1.500	1.732	1.980	10.827	27

## Spare Parts

For holders	Insert lever	Insert shim (S)	Lever screw	Locking key	Shim pin
..16QHJET	PP3712	GXA16-1	LS0612-T15P	T15P-7	AC4625
..22QHJET	PP4816	NXA22-1	LS0815-T25P	T25P-7	AC5035
..27QHJET	PP6019	VXA27-1	LS0820-T25P	T25P-7	AC6050

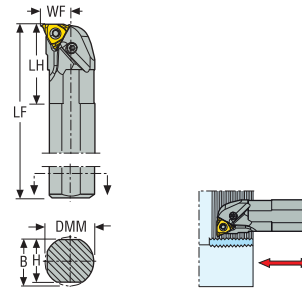
## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Plug
..16QHJET	MXA16-1	GXA16-0	-	-	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	-	-	-	P6SS4X8
..22QHJET	MXA22-1	NXA22-0	NXA22-98	NXA22-97.5	NXA22-0.5	NXA22-1.5	NXA22-2	NXA22-3	NXA22-4	NXA22-99.5	NXA22-99	NXA22-98.5	P6SS4X8
..27QHJET	MXA27-1	VXA27-0	VXA27-98	-	VXA27-0.5	VXA27-1.5	VXA27-2	VXA27-3	VXA27-4	VXA27-99.5	VXA27-99	VXA27-98.5	P6SS4X8

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## Jetstream Tooling® – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 146
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	WF	LH	DCINN	DMM	Weight	CP*	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	bar	
PNR0020P16AHDJET	03006930	19,0	18,0	171,0	13,8	42,0	24,0	20,0	0,5	275,0	16
PNL0020P16AHDJET	03006931	19,0	18,0	171,0	13,8	42,0	24,0	20,0	0,5	275,0	16
PNR0025R16AHDJET	03006932	24,0	23,0	200,0	16,3	42,0	29,0	25,0	0,7	275,0	16
PNL0025R16AHDJET	03006933	24,0	23,0	200,0	16,3	42,0	29,0	25,0	0,6	275,0	16
PNR0032S16AHDJET	03006934	30,0	31,0	250,0	19,8	42,0	36,0	32,0	1,2	275,0	16
PNL0032S16AHDJET	03006935	30,0	31,0	250,0	19,8	42,0	36,0	32,0	1,5	275,0	16
PNR0040T16AHDJET	03006936	38,5	37,0	300,0	23,8	45,0	44,0	40,0	2,2	275,0	16
PNR0050U16AHDJET	03006937	47,0	48,5	350,0	28,8	52,0	54,0	50,0	3,2	275,0	16
PNR0025R22AHDJET	03006945	23,0	24,0	200,0	17,8	42,0	30,0	25,0	0,7	275,0	22
PNL0025R22AHDJET	03006946	23,0	24,0	200,0	17,8	42,0	30,0	25,0	1,2	275,0	22
PNR0032S22AHDJET	03006947	30,0	31,0	250,0	21,3	42,0	38,0	32,0	1,5	275,0	22
PNL0032S22AHDJET	03006948	30,0	31,0	250,0	21,3	42,0	38,0	32,0	1,5	275,0	22
PNR0040T22AHDJET	03006949	37,0	38,5	300,0	25,3	42,0	46,0	40,0	2,9	275,0	22
PNL0040T22AHDJET	03006950	37,0	38,5	300,0	25,3	42,0	46,0	40,0	2,7	275,0	22
PNR0050U22AHDJET	03006951	47,0	48,5	350,0	30,3	48,0	56,0	50,0	3,3	275,0	22
PNR0040T27AHDJET	03006955	37,0	38,5	300,0	26,8	62,0	48,0	40,0	2,8	275,0	27
PNR0050U27AHDJET	03006956	47,0	48,5	350,0	31,8	62,0	58,0	50,0	4,3	275,0	27
PNR0063V27AHDJET	03006957	60,0	61,5	400,0	38,3	62,0	70,0	63,0	10,0	275,0	27

### Spare Parts

For holders	Insert lever	Insert shim (S)	Lever screw	Locking key	Shim pin
...20...	PP3712	GXA16-1	LS0610-T15P	T15P-7	AC4625
...25/32/40/50...	PP3712	GXA16-1	LS0612-T15P	T15P-7	AC4625
...22...	PP4816	NXA22-1	LS0815-T25P	T25P-7	AC5035
...27...	PP6019	VXA27-1	LS0820-T25P	T25P-7	AC6050



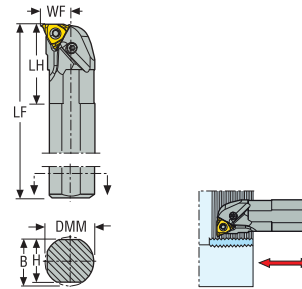
Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9
...20...	MXA16-1	GXA16-0	-	-	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	-	-	-
...25/32/40/50...	MXA16-1	GXA16-0	-	-	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	-	-	-
...22...	MXA22-1	NXA22-0	NXA22-98	NXA22-97.5	NXA22-0.5	NXA22-1.5	NXA22-2	NXA22-3	NXA22-4	NXA22-99.5	NXA22-99	NXA22-98.5
...27...	MXA27-1	VXA27-0	VXA27-98	-	VXA27-0.5	VXA27-1.5	VXA27-2	VXA27-3	VXA27-4	VXA27-99.5	VXA27-99	VXA27-98.5

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# Jetstream Tooling® – Toolholders, external

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 146
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	WF	LH	DCINN	DMM	Weight	CP	CTWS
		<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	lbs	psi	
PNR00075716AHDJET	03006939	0.700	0.650	7.000	0.520	1.654	0.953	0.750	1.540	10.827	16
PNL00075716AHDJET	03006940	0.700	0.650	7.000	0.520	1.654	0.950	0.750	1.100	10.827	16
PNR00100816AHDJET	03006941	0.951	0.902	8.000	0.650	1.654	1.150	1.000	1.320	10.827	16
PNL00100816AHDJET	03006942	0.951	0.902	8.000	0.650	1.654	1.142	1.000	1.540	10.827	16
PNR001251016AHDJET	03006943	1.200	1.150	10.000	0.780	1.654	1.404	1.250	1.540	10.827	16
PNR001501216AHDJET	03006944	1.339	1.419	12.000	0.900	1.654	1.700	1.500	5.290	10.827	16
PNR00100822AHDJET	03006952	0.902	0.951	8.000	0.710	1.654	1.181	1.000	1.980	10.827	22
PNR001251022AHDJET	03006953	1.200	1.150	10.000	0.840	1.654	1.500	1.250	1.320	10.827	22
PNR001501222AHDJET	03006954	1.339	1.419	12.000	0.970	1.654	1.800	1.500	5.290	10.827	22
PNR001501227AHDJET	03006958	1.339	1.419	12.000	1.020	2.441	1.890	1.500	5.290	10.827	27

## Spare Parts

For holders	Insert lever	Insert shim (S)	Lever screw	Locking key	Shim pin
PNR/L000757..	PP3712	GXA16-1	LS0610-T15P	T15P-7	AC4625
..16AHDJET	PP3712	GXA16-1	LS0612-T15P	T15P-7	AC4625
..22AHDJET	PP4816	NXA22-1	LS0815-T25P	T25P-7	AC5035
..27AHDJET	PP6019	VXA27-1	LS0820-T25P	T25P-7	AC6050

## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9
PNR/L000757..	MXA16-1	GXA16-0	-	-	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	-	-	-
..16AHDJET	MXA16-1	GXA16-0	-	-	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	-	-	-
..22AHDJET	MXA22-1	NXA22-0	NXA22-98	NXA22-97.5	NXA22-0.5	NXA22-1.5	NXA22-2	NXA22-3	NXA22-4	NXA22-99.5	NXA22-99	NXA22-98.5
..27AHDJET	MXA27-1	VXA27-0	VXA27-98	-	VXA27-0.5	VXA27-1.5	VXA27-2	VXA27-3	VXA27-4	VXA27-99.5	VXA27-99	VXA27-98.5

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Thread turning

Thread MDT

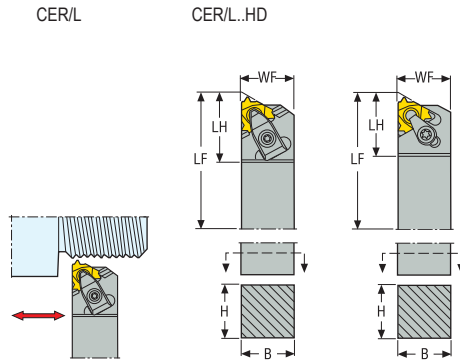
Thread Mini-Start™

Rotating threading

Annex

Toolholders, external

For S-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 117, 119, 121, 122, 125, 127, 129, 131, 133, 135, 137, 139, 143
- CP\* Max coolant pressure (bar) using hose connection

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		mm	mm	mm	mm	mm	kg	
CER1616H16	02454783	16,0	16,0	100,0	16,0	22,0	0,2	16
CER2020K16HD	02475454	20,0	20,0	125,0	20,0	32,0	0,4	16
CER2525M16HD	02457882	25,0	25,0	150,0	25,0	32,0	0,8	16
CER4040R16HD	02853574	40,0	40,0	200,0	40,0	37,0	2,5	16
CEL1616H16	02454781	16,0	16,0	100,0	16,0	22,0	0,2	16
CEL2020K16HD	02475482	20,0	20,0	125,0	20,0	32,0	0,4	16
CEL2525M16HD	02457885	25,0	25,0	150,0	25,0	32,0	0,8	16
CER2525M22HD	02457888	25,0	25,0	150,0	25,0	38,0	0,8	22
CER4040R22HD	02853575	40,0	40,0	200,0	40,0	42,0	2,5	22
CEL2525M22HD	02457890	25,0	25,0	150,0	25,0	38,0	0,8	22
CER4040R27HD	02853576	40,0	40,0	200,0	40,0	48,0	2,5	27

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
...16	–	T15P-2	CSP16-T15P	–	GX16-1	CS3507-T09P	–
...16HD	CHD16	T15P-7	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
...22HD	CHD22	T20P-7L	–	L86025-T20P	NX22-1	CS4009-T15P	S7616
...27HD	CHD27	T20P-7L	–	L86025-T20P	VX27-1	C05012-T15P	S7616

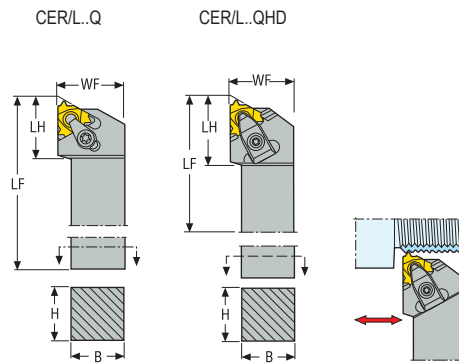
Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
...16	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
...16HD	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
...22HD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
...27HD	MX27-1	VX27-98.5	VX27-2	–	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

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## Toolholders, external

For S-inserts, Snap-Tap®



Right-hand version shown














- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 117, 119, 121, 122, 125, 127, 129, 131, 133, 135, 137, 139, 143
- CP\* Max coolant pressure (bar) using hose connection

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		mm	mm	mm	mm	mm	kg	
CER1212H16Q	75025274	12,0	12,0	100,0	16,0	22,0	0,2	16
CER1616H16Q	75025276	16,0	16,0	100,0	20,0	22,0	0,2	16
CER2020K16QHD	02475493	20,0	20,0	125,0	25,0	32,0	0,5	16
CER2525M16QHD	00016769	25,0	25,0	150,0	32,0	32,0	0,8	16
CER3225P16QHD	00016771	32,0	25,0	170,0	32,0	32,0	1,1	16
CER3232P16QHD	00016776	32,0	32,0	170,0	40,0	32,0	1,4	16
CEL1212H16Q	75025275	12,0	12,0	100,0	16,0	22,0	0,2	16
CEL1616H16Q	75025277	16,0	16,0	100,0	20,0	22,0	0,2	16
CEL2020K16QHD	02475514	20,0	20,0	125,0	25,0	32,0	0,5	16
CEL2525M16QHD	00016766	25,0	25,0	150,0	32,0	32,0	0,8	16
CEL3225P16QHD	00016770	32,0	25,0	170,0	32,0	32,0	1,1	16
CEL3232P16QHD	00016774	32,0	32,0	170,0	40,0	32,0	1,4	16
CER2525M22QHD	00016781	25,0	25,0	150,0	32,0	38,0	0,8	22
CER3225P22QHD	00016783	32,0	25,0	170,0	32,0	38,0	1,2	22
CER3232P22QHD	00016788	32,0	32,0	170,0	40,0	38,0	1,4	22
CEL2525M22QHD	00016777	25,0	25,0	150,0	32,0	38,0	0,8	22
CEL3225P22QHD	00016782	32,0	25,0	170,0	32,0	38,0	1,1	22
CEL3232P22QHD	00016785	32,0	32,0	170,0	40,0	38,0	1,4	22
CER2525M27QHD	00016800	25,0	25,0	150,0	32,0	46,0	0,8	27
CER3225P27QHD	00016857	32,0	25,0	170,0	32,0	46,0	1,2	27
CER3232P27QHD	00016878	32,0	32,0	170,0	40,0	46,0	1,5	27
CEL2525M27QHD	00016791	25,0	25,0	150,0	32,0	46,0	0,8	27
CEL3225P27QHD	00016830	32,0	25,0	170,0	32,0	46,0	1,2	27
CEL3232P27QHD	00016864	32,0	32,0	170,0	40,0	46,0	1,5	27

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
...16Q	–	T15P-2	CSP16-T15P	–	GX16-1	CS3507-T09P	–
...16QHD	CHD16	T15P-7	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
...22QHD	CHD22	T20P-7L	–	L86025-T20P	NX22-1	CS4009-T15P	S7616
...27QHD	CHD27	T20P-7L	–	L86025-T20P	VX27-1	C05012-T15P	S7616

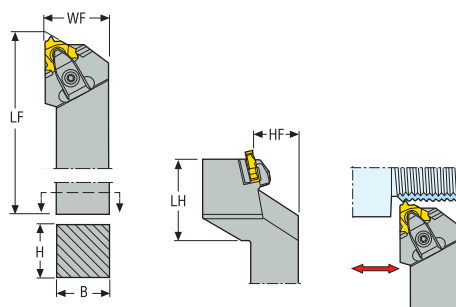
Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
													
...16Q	MX16-1	GX16-0	-	-	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	-	-	-	T09P-2
...16QHD	MX16-1	GX16-0	-	-	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	-	-	-	T09P-2
...22QHD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
...27QHD	MX27-1	VX27-98.5	VX27-2	-	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Toolholders, external

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 121, 122, 127, 129, 131, 133, 135, 137, 139, 141, 143, 145, 147, 149
- CP\* Max coolant pressure (bar) using hose connection

Designation	Item number	H	B	LF	HF	WF	LH	Weight	CTWS
		mm	mm	mm	mm	mm	mm	kg	
CER2525M16CQHD	02457892	25,0	25,0	150,0	25,0	32,0	45,0	0,9	16
CER3232P16CQHD	02457893	32,0	32,0	170,0	32,0	40,0	45,0	1,5	16
CER2525M22CQHD	02457895	25,0	25,0	150,0	25,0	32,0	50,0	0,9	22
CER3232P22CQHD	02457897	32,0	32,0	170,0	32,0	40,0	50,0	1,5	22

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Shim screw	Spring
..16CQHD	CHD16	T15P-7	L85020-T15P	GX16-1	CS3507-T09P	S6912
..22CQHD	CHD22	T20P-7L	L86025-T20P	NX22-1	CS4009-T15P	S7616

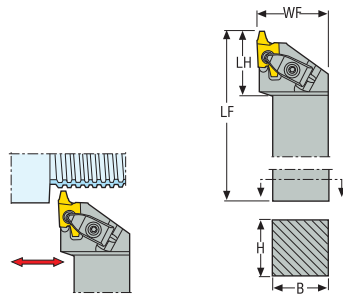
### Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Shim key
..16CQHD	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
..22CQHD	MX22-1	NX22-0	NX22-2	NX22-3	NX22-4	NX22-98	NX22-99	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Toolholders, external

For K-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 133, 135, 137
- CP\* Max coolant pressure (bar) using hose connection

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		mm	mm	mm	mm	mm	kg	
CER2525M20QHD	02528502	25,0	25,0	150,0	32,0	34,0	0,8	20
CER3225P20QHD	02528504	32,0	25,0	170,0	32,0	34,0	1,1	20
CER3232P20QHD	02528507	32,0	32,0	170,0	40,0	34,0	1,4	20
CER4040R20HD	02853577	40,0	40,0	200,0	42,0	35,0	2,6	20
CEL2525M20QHD	02528503	25,0	25,0	150,0	32,0	34,0	0,8	20
CEL3225P20QHD	02528505	32,0	25,0	170,0	32,0	34,0	1,1	20
CEL3232P20QHD	02528508	32,0	32,0	170,0	40,0	34,0	1,4	20
CER2525M26QHD	02528509	25,0	25,0	150,0	40,0	44,0	0,9	26
CER3225P26QHD	02528512	32,0	25,0	170,0	40,0	44,0	1,2	26
CER3232P26QHD	02528516	32,0	32,0	170,0	40,0	44,0	1,4	26
CER4040R26HD	02853578	40,0	40,0	200,0	42,0	45,0	2,5	26
CEL2525M26QHD	02528511	25,0	25,0	150,0	40,0	44,0	0,9	26
CEL3225P26QHD	02528513	32,0	25,0	170,0	40,0	44,0	1,2	26
CEL3232P26QHD	02528517	32,0	32,0	170,0	40,0	44,0	1,4	26

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (K)	Shim screw	Spring
...20	CHD22	T20P-7	L86025-T20P	KX20-2	CS4009-T15P	S7616
...20	CHD22	T20P-7	L86025-T20P	KX20-2	CS4009-T15P	S7616
...26	CHD27	T20P-7	L86025-T20P	KX26-2	C05012-T15P	S7616
...26	CHD27	T20P-7	L86025-T20P	KX26-2	C05012-T15P	S7616

### Accessories

For holders	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Insert shim (K) 6	Shim key
...20	KX20-99	KX20-0	KX20-1	KX20-3	KX20-4	KX20-5	T15P-2
...20	KX20-99	KX20-0	KX20-1	KX20-3	KX20-4	KX20-5	T15P-2
...26	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2
...26	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2

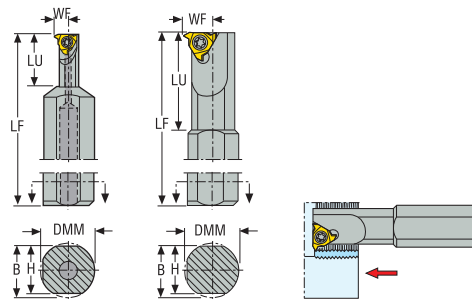
## Toolholders, internal

For S-inserts, Snap-Tap®



SNR..09A

SNR/L



Right-hand version shown

- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 140, 142, 144, 146, 148, 150
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	WF	LU	DCINN	DCINN2	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	
SNR0020L09A	75069222	18,0	19,0	140,0	5,1	20,0	10,2	–	0,3	09
SNR0010H11	75029184	–	9,5	100,0	7,5	–	13,0	11,0	0,1	11
SNR0010K11	75025251	14,0	15,5	125,0	6,5	30,0	12,0	11,0	0,2	11
SNR0013L11	75025249	14,0	15,5	140,0	8,0	32,0	15,0	13,0	0,2	11
SNL0010H11	75025415	–	9,5	100,0	7,5	–	13,0	11,0	0,1	11
SNL0010K11	75025250	14,0	15,5	125,0	6,5	30,0	12,0	11,0	0,2	11
SNL0013L11	75025248	14,0	15,5	140,0	8,0	32,0	15,0	13,0	0,2	11
SNR0016M16	75025244	14,0	15,5	150,0	10,3	40,0	19,0	16,0	0,3	16
SNL0016M16	75025243	14,0	15,5	150,0	10,3	40,0	19,0	16,0	0,3	16
SNR0020Q22	75025414	18,0	19,0	180,0	13,0	45,0	24,0	22,0	0,4	22
SNL0020Q22	75025416	18,0	19,0	180,0	13,0	45,0	24,0	22,0	0,4	22

### Spare Parts

For holders	Insert key	Insert screw
...09A	 T07P-2	 C02205-T07P
...11	T07P-2	C02506-T07P
...16	T15P-2	C03508-T15P
...22	T15P-2	C04011-T15P

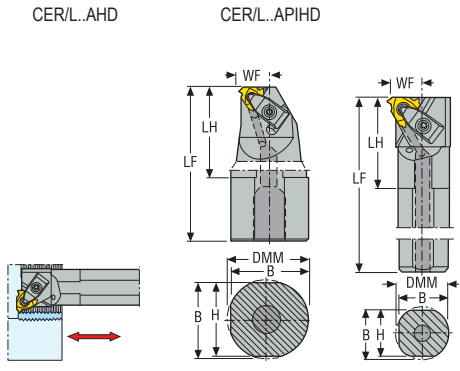
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DCINN2, modified. Please see page 34



Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 140, 142, 144, 146, 148, 150
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	WF	LH	DMM	DCINN	DCINN2	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	mm	kg	
CNR0020P16AHD	02555888	18,0	19,0	170,0	13,8	41,0	20,0	24,0	–	0,4	16..
CNR0025R16AHD	02555891	23,0	24,0	200,0	16,3	40,0	25,0	29,0	26,0	0,7	16..
CNR0032S16AHD	02555895	30,0	31,0	250,0	19,8	47,0	32,0	36,0	32,0	1,4	16..
CNR0040T16AHD	02555900	37,0	38,5	300,0	23,8	47,0	40,0	44,0	40,0	2,6	16..
CNR0050U16AHD	02555906	47,0	48,5	350,0	28,8	45,0	50,0	54,0	50,0	4,8	16..
CNL0020P16AHD	02555907	18,0	19,0	171,0	11,78	41,0	20,0	24,0	–	0,4	16..
CNL0025R16AHD	02555908	23,0	24,0	171,0	11,78	40,0	25,0	29,0	26,0	0,7	16..
CNL0032S16AHD	02555909	30,0	31,0	250,0	19,8	47,0	32,0	36,0	32,0	1,4	16..
CNL0040T16AHD	02555910	37,0	38,5	300,0	23,8	47,0	40,0	44,0	40,0	2,6	16..
CNR0025R22AHD	02555913	23,0	24,0	200,0	17,8	45,0	25,0	30,0	–	0,7	22..
CNR0032S22AHD	02555919	30,0	31,0	250,0	21,3	46,0	32,0	38,0	32,0	1,5	22..
CNR0040T22AHD	02556097	37,0	38,5	300,0	25,3	53,0	40,0	46,0	40,0	2,6	22..
CNR0050U22AHD	02556101	47,0	48,5	350,0	30,3	51,0	50,0	56,0	50,0	4,8	22..
CNR0063V22AHD	02556102	60,0	61,5	400,0	36,8	56,0	63,0	69,0	63,0	9,0	22..
CNL0025R22AHD	02556104	23,0	24,0	200,0	17,8	45,0	25,0	30,0	–	0,7	22..
CNL0032S22AHD	02556106	30,0	31,0	250,0	21,3	46,0	32,0	38,0	32,0	1,4	22..
CNL0040T22AHD	02556107	37,0	38,5	300,0	25,3	53,0	40,0	46,0	40,0	2,6	22..
CNL0050U22AHD	02556108	47,0	48,5	350,0	30,3	51,0	50,0	56,0	50,0	4,8	22..
CNR0050T22APIHD	02556244	47,0	48,5	300,0	20,5	114,0	50,0	49,0	–	3,7	22..
CNR0063T22APIHD	02817098	60,0	61,5	300,0	22,6	119,0	63,0	50,5	–	5,4	22..
CNL0063T22APIHD	02817100	60,0	61,5	300,0	22,6	119,0	63,0	50,5	–	5,4	22..
CNR0040T27AHD	02556109	37,0	38,5	300,0	26,8	62,0	40,0	48,0	44,0	2,6	27..
CNR0050U27AHD	02556110	47,0	48,5	350,0	31,8	61,0	50,0	58,0	50,0	4,8	27..
CNR0063V27AHD	02556120	60,0	61,5	400,0	38,3	70,0	63,0	70,0	63,0	8,9	27..
CNL0040T27AHD	02556122	37,0	38,5	300,0	26,8	62,0	40,0	48,0	44,0	2,6	27..
CNL0050U27AHD	02556130	47,0	48,5	350,0	31,8	61,0	50,0	58,0	50,0	4,8	27..
CNR0063T27APIHD	02817102	60,0	61,5	300,0	23,1	119,0	63,0	50,5	–	5,6	27..
CNL0063T27APIHD	02817105	60,0	61,5	300,0	23,1	119,0	63,0	50,5	–	5,4	27..

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
..P, ..R16AHD	–	T15P-2	CSP16HD-T15P	–	GX16-1	CS3507-T09P	–
..S, ..T, ..U16AHD	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
...R22, ...S22	–	T15P-2	CSP22HD-T15P	–	NX22-1	CS4009-T15P	–
...T22, ...U22, ...V22	CHD22	T20P-7L	–	L86025-T20P	NX22-1	CS4009-T15P	S7616
..27..	CHD27	T20P-7L	–	L86025-T20P	VX27-1	C05012-T15P	S7616

Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
..P, ..R16AHD	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
..S, ..T, ..U16AHD	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
...R22, ...S22	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	–
...T22, ...U22, ...V22	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
..27..	MX27-1	VX27-98.5	VX27-2	–	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

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DCINN2, modified. Please see page 34

Thread turning

Thread MDT

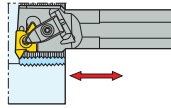
Thread Mini-Start™

Rotating threading

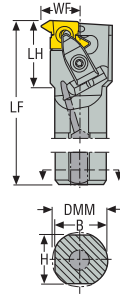
Annex

Toolholders, internal

For K-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 105, 107, 134, 136, 138
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	WF	LH	DMM	DCINN	DCINN2	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	mm	kg	
CNR0025R20AHD	02556131	23,0	24,0	200,0	20,5	50,0	25,0	38,0	–	0,7	20
CNR0032S20AHD	02556132	30,0	31,0	250,0	24,0	50,0	32,0	44,0	38,0	1,5	20
CNR0040T20AHD	02556133	37,0	38,5	300,0	28,0	50,0	40,0	51,0	40,0	2,6	20
CNL0025R20AHD	02556134	23,0	24,0	200,0	20,5	50,0	25,0	38,0	–	0,7	20
CNL0032S20AHD	02556135	30,0	31,0	250,0	24,0	50,0	32,0	44,0	38,0	1,4	20
CNR0032S26AHD	02556136	30,0	31,0	250,0	27,0	61,0	32,0	50,0	50,0	1,5	26
CNR0040T26AHD	02556137	37,0	38,5	300,0	31,0	60,0	40,0	55,0	50,0	2,6	26
CNR0050U26AHD	02556138	47,0	48,5	350,0	36,0	62,0	50,0	65,0	–	4,8	26
CNR0063V26AHD	02556139	60,0	61,5	400,0	42,5	64,0	63,0	80,0	63,0	8,9	26
CNL0040T26AHD	02556140	37,0	38,5	300,0	31,0	60,0	40,0	55,0	50,0	2,6	26

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (K)	Shim screw	Spring
.20	CHD22	T20P-7L	L86025-T20P	KX20-2	CS4009-T15P	S7616
.26	CHD27	T20P-7L	L86025-T20P	KX26-2	C05012-T15P	S7616

Accessories

For holders	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Insert shim (K) 6	Shim key
.20	KX20-99	KX20-0	KX20-1	KX20-3	KX20-4	KX20-5	T15P-2
.26	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

DCINN2, modified. Please see page 34

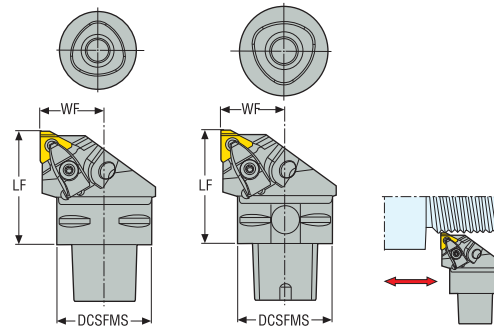
## Seco-Capto™ – Toolholders, external

For S-inserts, Snap-Tap®



CER/L.. HD

CER/L..CHD



Right-hand version shown

- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 117, 119, 121, 122, 125, 127, 129, 131, 133, 135, 137, 139, 141 (not CHD), 143 (not CHD), 145 (not CHD), 147 (not CHD), 149 (not CHD)
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	DCSFMS		LF		WF		Weight	CTWS	
		mm	Inch	mm	Inch	mm	Inch			kg
C4-CER-27050-16HD	02484547	40,0	1.575	50,0	1.063	27,0	1.063	0,5	1.100	16..
C4-CEL-27050-16HD	02484655	40,0	1.575	50,0	1.063	27,0	1.063	0,5	1.100	16..
C4-CER-27050-22HD	02484649	40,0	1.575	50,0	1.063	27,0	1.063	0,5	1.100	22..
C4-CEL-27050-22HD	02484656	40,0	1.575	50,0	1.063	27,0	1.063	0,5	1.100	22..
C5-CER-35060-16HD	02484650	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	16..
C5-CEL-35060-16HD	02484657	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	16..
C5-CER-35060-22HD	02484652	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	22..
C5-CEL-35060-22HD	02484658	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	22..
C5-CER-35060-27HD	02844418	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	27..
C5-CEL-35060-27HD	02844420	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	27..
C6-CER-45065-16HD	02484653	63,0	2.480	65,0	1.772	45,0	1.772	1,3	2.870	16..
C6-CEL-45065-16HD	02484661	63,0	2.480	65,0	1.772	45,0	1.772	1,3	2.870	16..
C6-CER-45065-22HD	02484654	63,0	2.480	65,0	1.772	45,0	1.772	1,3	2.870	22..
C6-CEL-45065-22HD	02484663	63,0	2.480	65,0	1.772	45,0	1.772	1,3	2.870	22..
C6-CER-45065-27HD	02484848	63,0	2.480	65,0	1.772	45,0	1.772	1,3	2.870	27..
C6-CEL-45065-27HD	02484860	63,0	2.480	65,0	1.772	45,0	1.772	1,3	2.870	27..
C4-CER-27050-16CHD	02484668	40,0	1.575	50,0	1.063	27,0	1.063	0,5	1.100	16
C4-CEL-27050-16CHD	02484795	40,0	1.575	50,0	1.063	27,0	1.063	0,5	1.100	16
C5-CER-35060-16CHD	02484784	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	16
C5-CEL-35060-16CHD	02484802	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	16

Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm Inch	mm Inch	mm Inch	kg lbs	
C6-CER-45065-16CHD	02484786	63,0 2.480	65,0 1.772	45,0 1.772	1,3 2.870	16
C6-CEL-45065-16CHD	02484843	63,0 2.480	65,0 1.772	45,0 1.772	1,3 2.870	16
C4-CER-27050-22CHD	02484775	40,0 1.575	50,0 1.063	27,0 1.063	0,5 1.100	22
C4-CEL-27050-22CHD	02484800	40,0 1.575	50,0 1.063	27,0 1.063	0,5 1.100	22
C5-CER-35060-22CHD	02484785	50,0 1.969	60,0 1.378	35,0 1.378	0,8 1.760	22
C5-CEL-35060-22CHD	02484804	50,0 1.969	60,0 1.378	35,0 1.378	0,8 1.760	22
C6-CER-45065-22CHD	02484790	63,0 2.480	65,0 1.772	45,0 1.772	1,3 2.870	22
C6-CEL-45065-22CHD	02484845	63,0 2.480	65,0 1.772	45,0 1.772	1,3 2.870	22
C6-CER-45065-27CHD	02484854	63,0 2.480	65,0 1.772	45,0 1.772	1,3 2.870	27
C6-CEL-45065-27CHD	02484862	63,0 2.480	65,0 1.772	45,0 1.772	1,3 2.870	27

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Coolant nozzle	Insert shim (S)	Shim screw	Spring
...16HD	CHD16	T15P-7	L85020-T15P	CN16	GX16-1	CS3507-T09P	S6912
...22HD	CHD22	T20P-7L	L86025-T20P	CN16	NX22-1	CS4009-T15P	S7616
...27HD	CHD27	T20P-7L	L86025-T20P	CN16	VX27-1	C05012-T15P	S7616
...45065-27HD	CHD27	T20P-7L	L86025-T20P	CN16	VX27-1	C05012-T15P	S7616
...16CHD	CHD16	T15P-7	L85020-T15P	CN16	GX16-1	CS3507-T09P	S6912
...22CHD	CHD22	T20P-7L	L86025-T20P	CN16	NX22-1	CS4009-T15P	S7616
...27CHD	CHD27	T20P-7L	L86025-T20P	CN16	VX27-1	C05012-T15P	S7616

Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
...16HD	MX16-1	GX16-0	-	-	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	-	-	-	T09P-2
...22HD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
...27HD	MX27-1	VX27-98.5	VX27-2	-	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-7
...45065-27HD	MX27-1	VX27-98.5	VX27-2	-	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2
...16CHD	MX16-1	GX16-0	-	-	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	-	-	-	T09P-2
...22CHD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
...27CHD	MX27-1	VX27-98.5	VX27-2	-	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

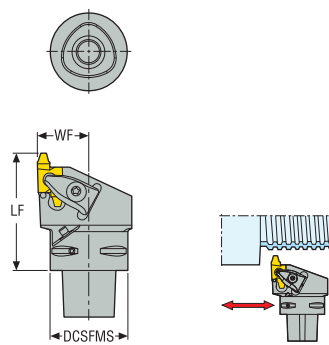
Thread Mini-Shaft™

Rotating threading

Annex

## Seco-Capto™ – Toolholders, external

For K-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 104-107, 133, 135, 137
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	DCSFMS		LF		WF		Weight	CTWS	
		mm	Inch	mm	Inch	mm	Inch			kg
C4-CER-27060-20HD	02853589	40,0	1.575	60,0	1.063	27,0	1.063	0,6	1.320	20..
C4-CER-27065-26HD	02853590	40,0	1.575	65,0	1.063	27,0	1.063	0,6	1.320	26..
C5-CER-35060-20HD	02853591	50,0	1.969	60,0	1.378	35,0	1.378	0,8	1.760	20..
C5-CER-35065-26HD	02790776	50,0	1.969	65,0	1.378	35,0	1.378	0,8	1.760	26..
C6-CER-45065-20HD	02853587	63,0	2.480	65,0	1.772	45,0	1.772	1,3	2.870	20..
C6-CER-45070-26HD	02853595	63,0	2.480	70,0	1.772	45,0	1.772	1,5	3.310	26..

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Coolant nozzle	Insert shim (K)	Shim screw	Spring
...20HD	CHD22	T20P-7	L86025-T20P	CN6	KX20-2	CS4009-T15P	S7616
...26HD	CHD27	T20P-7	L86025-T20P	CN6	KX26-2	C05012-T15P	S7616

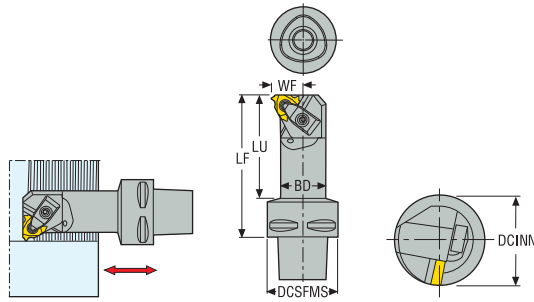
### Accessories

For holders	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Insert shim (K) 6	Shim key
...20HD	KX20-99	KX20-0	KX20-1	KX20-3	KX20-4	KX20-5	T15P-2
...26HD	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 140, 142, 144, 146, 148, 150
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	kg lbs	
C4-SNR-10060-16	00008610	16,0 0.630	40,0 1.575	60,0 2.362	10,0 0.394	19,0 0.748	37,0 1.457	0,3 0.660	16..
C4-CNR-14060-16HD	02555280	20,0 0.787	40,0 1.575	60,0 2.362	13,8 0.543	24,0 0.945	36,0 1.417	0,4 0.880	16..
C4-CNR-17070-16HD	02555284	25,0 0.984	40,0 1.575	70,0 2.756	16,3 0.642	29,0 1.142	48,0 1.890	0,5 1.100	16..
C4-CNR-20090-16HD	02555320	32,0 1.260	40,0 1.575	90,0 3.543	19,8 0.780	36,0 1.417	69,0 2.717	0,7 1.540	16..
C4-CNL-14060-16HD	02555337	20,0 0.787	40,0 1.575	60,0 2.362	13,8 0.543	24,0 0.945	36,0 1.417	0,4 0.880	16..
C4-CNL-17070-16HD	02555331	25,0 0.984	40,0 1.575	70,0 2.756	16,3 0.642	29,0 1.142	48,0 1.890	0,5 1.100	16..
C4-CNL-20090-16HD	02555371	32,0 1.260	40,0 1.575	90,0 3.543	19,8 0.780	36,0 1.417	69,0 2.717	0,7 1.540	16..
C4-CNR-22090-22HD	02555375	32,0 1.260	40,0 1.575	90,0 3.543	21,3 0.839	38,0 1.496	69,0 2.717	0,6 1.320	22..
C4-CNL-22090-22HD	02555384	32,0 1.260	40,0 1.575	90,0 3.543	21,3 0.839	38,0 1.496	69,0 2.717	0,6 1.320	22..

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert key	Insert screw	Insert shim (S)	Shim screw	Spring
...10060-16	-	-	-	-	T15P-2	C03508-T15P	-	-	-
...14060, 17070-16HD	-	T15P-2	CSP16HD-T15P	-	-	-	GX16-1	CS3507-T09P	-
...20090-16HD	CHD16	T15P-2	-	L85020-T15P	-	-	GX16-1	CS3507-T09P	S6912
...22090-22HD	-	T15P-2	CSP22HD-T15P	-	-	-	NX22-1	CS4009-T15P	-

Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
...10060-16	-	-	-	-	-	-	-	-	-	-	-	-	-
...14060, 17070-16HD	MX16-1	GX16-0	-	-	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	-	-	-	T09P-2
...20090-16HD	MX16-1	GX16-0	-	-	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	-	-	-	T09P-2
...22090-22HD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	-

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Thread turning

Thread MDT

Thread Mini-Shaft™

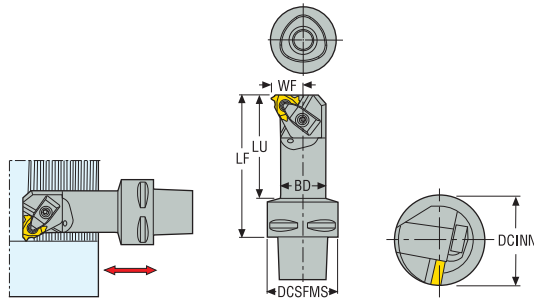
Rotating threading

Annex



# Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown
















- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 140, 142, 144, 146, 148, 150
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	kg lbs	
C5-CNR-14060-16HD	02555383	20,0 0.787	50,0 1.969	60,0 2.362	13,8 0.543	24,0 0.945	36,0 1.417	0,6 1.320	16..
C5-CNR-17070-16HD	02555388	25,0 0.984	50,0 1.969	70,0 2.756	16,3 0.642	29,0 1.142	47,0 1.850	0,6 1.320	16..
C5-CNR-20090-16HD	02555391	32,0 1.260	50,0 1.969	90,0 3.543	19,8 0.780	36,0 1.417	68,0 2.677	0,8 1.760	16..
C5-CNL-14060-16HD	02555739	20,0 0.787	50,0 1.969	60,0 2.362	13,8 0.543	24,0 0.945	36,0 1.417	0,6 1.320	16..
C5-CNL-17070-16HD	02555740	25,0 0.984	50,0 1.969	70,0 2.756	16,3 0.642	29,0 1.142	47,0 1.850	0,6 1.320	16..
C5-CNL-20090-16HD	02555741	32,0 1.260	50,0 1.969	90,0 3.543	19,8 0.780	36,0 1.417	68,0 2.677	0,8 1.760	16..
C5-CNR-18070-22HD	02555742	25,0 0.984	50,0 1.969	70,0 2.756	17,8 0.701	30,0 1.181	47,0 1.850	0,6 1.320	22..
C5-CNR-22090-22HD	02555743	32,0 1.260	50,0 1.969	90,0 3.543	21,3 0.839	38,0 1.496	68,0 2.677	0,8 1.760	22..
C5-CNL-18070-22HD	02555745	25,0 0.984	50,0 1.969	70,0 2.756	17,8 0.701	30,0 1.181	47,0 1.850	0,6 1.320	22..
C5-CNL-22090-22HD	02555747	32,0 1.260	50,0 1.969	90,0 3.543	21,3 0.839	38,0 1.496	68,0 2.677	0,8 1.760	22..
C5-CNR-26105-27HD	02823806	40,0 1.575	50,0 1.969	105,0 4.134	24,78 0.976	46,0 1.811	83,7 3.295	1,2 2.650	27..
C5-CNL-26105-27HD	02823807	40,0 1.575	50,0 1.969	105,0 4.134	24,78 0.976	46,0 1.811	83,7 3.295	1,2 2.650	27..

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
...14060, 17070-16HD	–	T15P-2	CSP16HD-T15P	–	GX16-1	CS3507-T09P	–
...20090-16HD	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
...22HD	–	T15P-2	CSP22HD-T15P	–	NX22-1	CS4009-T15P	–
...27HD	CHD27	T20P-7	–	L86025-T20P	VX27-1	C05012-T15P	S7616

Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
...14060, 17070-16HD													
...20090-16HD	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
...22HD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
...27HD	MX27-1	VX27-98.5	VX27-2	–	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

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Thread turning

Thread MDT

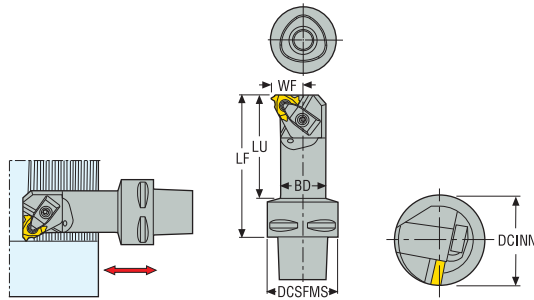
Thread Mini-Shaft™

Rotating threading

Annex

# Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 140, 146
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	kg lbs	
C6-CNR-17075-16HD	02555750	25,0 0.984	63,0 2.480	75,0 2.953	16,3 0.642	29,0 1.142	53,0 2.087	0,9 1.980	16
C6-CNR-20090-16HD	02555762	32,0 1.260	63,0 2.480	90,0 3.543	19,8 0.780	36,0 1.417	68,0 2.677	1,1 2.430	16
C6-CNR-24105-16HD	02555766	40,0 1.575	63,0 2.480	105,0 4.134	23,8 0.937	44,0 1.732	80,0 3.150	1,5 3.310	16
C6-CNL-17075-16HD	02555768	25,0 0.984	63,0 2.480	75,0 2.953	16,3 0.642	29,0 1.142	53,0 2.087	0,9 1.980	16
C6-CNL-20090-16HD	02555769	32,0 1.260	63,0 2.480	90,0 3.543	19,8 0.780	36,0 1.417	68,0 2.677	1,1 2.430	16
C6-CNL-24105-16HD	02555771	40,0 1.575	63,0 2.480	105,0 4.134	23,8 0.937	44,0 1.732	80,0 3.150	1,5 3.310	16

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
...17075-16HD	–	T15P-2	CSP16HD-T15P	–	GX16-1	CS3507-T09P	–
...20090, 24105-16HD	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912

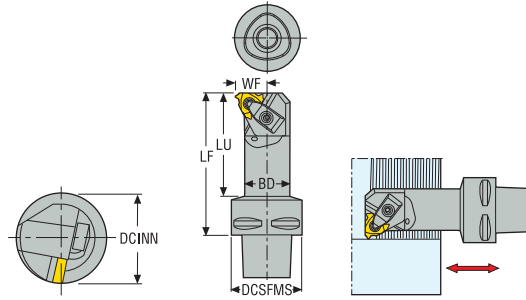
## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Shim key
...17075-16HD	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
...20090, 24105-16HD	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2

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# Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 128, 132, 134, 136, 138, 140, 142, 144, 148, 150
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		
C6-CNR-18075-22HD	02555772	25,0 <i>0.984</i>	63,0 <i>2.480</i>	75,0 <i>2.953</i>	17,8 <i>0.701</i>	30,0 <i>1.181</i>	53,0 <i>2.087</i>	0,9 <i>1.980</i>	22
C6-CNR-22090-22HD	02555773	32,0 <i>1.260</i>	63,0 <i>2.480</i>	90,0 <i>3.543</i>	21,3 <i>0.839</i>	38,0 <i>1.496</i>	68,0 <i>2.677</i>	1,1 <i>2.430</i>	22
C6-CNR-26105-22HD	02555776	40,0 <i>1.575</i>	63,0 <i>2.480</i>	105,0 <i>4.134</i>	25,3 <i>0.996</i>	46,0 <i>1.811</i>	80,0 <i>3.150</i>	1,5 <i>3.310</i>	22
C6-CNL-18075-22HD	02555777	25,0 <i>0.984</i>	63,0 <i>2.480</i>	75,0 <i>2.953</i>	17,8 <i>0.701</i>	30,0 <i>1.181</i>	53,0 <i>2.087</i>	0,9 <i>1.980</i>	22
C6-CNL-22090-22HD	02555832	32,0 <i>1.260</i>	63,0 <i>2.480</i>	90,0 <i>3.543</i>	21,3 <i>0.839</i>	38,0 <i>1.496</i>	68,0 <i>2.677</i>	1,1 <i>2.430</i>	22
C6-CNL-26105-22HD	02555833	40,0 <i>1.575</i>	63,0 <i>2.480</i>	105,0 <i>4.134</i>	25,3 <i>0.996</i>	46,0 <i>1.811</i>	80,0 <i>3.150</i>	1,5 <i>3.310</i>	22

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
..18075, 22090..	–	T15P-2	CSP22HD-T15P	–	NX22-1	CS4009-T15P	–
..26105..	CHD22	T20P-7L	–	L86025-T20P	NX22-1	CS4009-T15P	S7616

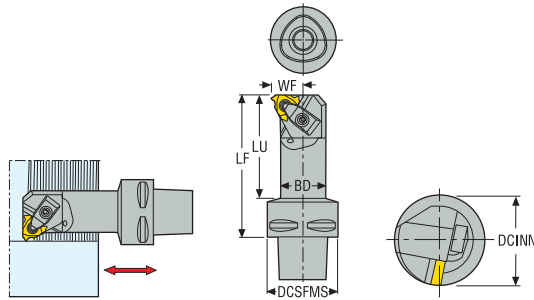
## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
..18075, 22090..	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
..26105..	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2

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# Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 110, 111, 112 115, 116, 132, 134, 136, 138, 140, 142, 144, 146
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	kg lbs	
C6-CNR-26105-27HD	02644670	40,0 1.575	63,0 2.480	105,0 4.134	25,3 0.996	46,0 1.811	77,0 3.031	1,6 3.530	27
C6-CNR-36182-27HD	02485584	63,0 2.480	63,0 2.480	182,0 7.165	36,0 1.417	70,0 2.756	–	4,1 9.040	27
C6-CNL-26105-27HD	02644672	40,0 1.575	63,0 2.480	105,0 4.134	25,3 0.996	46,0 1.811	77,0 3.031	1,6 3.530	27
C6-CNL-36182-27HD	02644681	63,0 2.480	63,0 2.480	182,0 7.165	36,0 1.417	70,0 2.756	–	4,1 9.040	27
C8-CNR-36190-27HD	02644684	54,0 2.126	80,0 3.150	190,0 7.480	36,0 1.417	70,0 2.756	160,0 6.299	4,2 9.260	27
C8-CNL-36190-27HD	02644685	54,0 2.126	80,0 3.150	190,0 7.480	36,0 1.417	70,0 2.756	160,0 6.299	4,2 9.260	27

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Coolant nozzle	Insert shim (S)	Shim screw	Spring
C6...	CHD27	T20P-7	L86025-T20P	–	VX27-1	C05012-T15P	S7616
C8...	CHD27	T20P-7	L86025-T20P	CN8	VX27-1	C05012-T15P	S7616

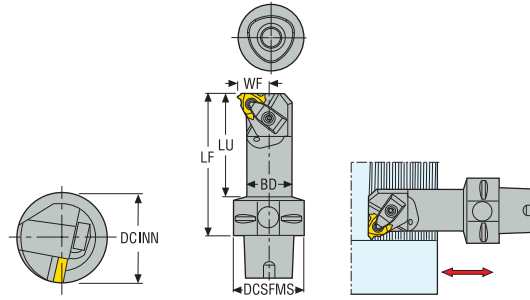
## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
C6...	MX27-1	VX27-98.5	VX27-2	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2
C8...	MX27-1	VX27-98.5	VX27-2	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 140, 142, 144, 146, 148, 150
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		
C4-CNR-14060-16CHD	02555834	20,0 <i>0.787</i>	40,0 <i>1.575</i>	60,0 <i>2.362</i>	13,8 <i>0.543</i>	24,0 <i>0.945</i>	36,0 <i>1.417</i>	0,4 <i>0.880</i>	16
C4-CNL-14060-16CHD	02555835	20,0 <i>0.787</i>	40,0 <i>1.575</i>	60,0 <i>2.362</i>	13,8 <i>0.543</i>	24,0 <i>0.945</i>	36,0 <i>1.417</i>	0,4 <i>0.880</i>	16
C5-CNR-17070-16CHD	02555836	25,0 <i>0.984</i>	50,0 <i>1.969</i>	70,0 <i>2.756</i>	16,3 <i>0.642</i>	29,0 <i>1.142</i>	47,0 <i>1.850</i>	0,6 <i>1.320</i>	16
C5-CNR-20090-16CHD	02555837	32,0 <i>1.260</i>	50,0 <i>1.969</i>	90,0 <i>3.543</i>	19,8 <i>0.780</i>	36,0 <i>1.417</i>	68,0 <i>2.677</i>	0,8 <i>1.760</i>	16
C5-CNL-17070-16CHD	02555839	25,0 <i>0.984</i>	50,0 <i>1.969</i>	70,0 <i>2.756</i>	16,3 <i>0.642</i>	29,0 <i>1.142</i>	47,0 <i>1.850</i>	0,6 <i>1.320</i>	16
C5-CNL-20090-16CHD	02555840	32,0 <i>1.260</i>	50,0 <i>1.969</i>	90,0 <i>3.543</i>	19,8 <i>0.780</i>	36,0 <i>1.417</i>	68,0 <i>2.677</i>	0,8 <i>1.760</i>	16
C5-CNR-18070-22CHD	02555841	25,0 <i>0.984</i>	50,0 <i>1.969</i>	70,0 <i>2.756</i>	17,8 <i>0.701</i>	30,0 <i>1.181</i>	47,0 <i>1.850</i>	0,6 <i>1.320</i>	22
C5-CNL-18070-22CHD	02555842	25,0 <i>0.984</i>	50,0 <i>1.969</i>	70,0 <i>2.756</i>	17,8 <i>0.701</i>	30,0 <i>1.181</i>	47,0 <i>1.850</i>	0,6 <i>1.320</i>	22

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
...14060, ...17070-16CHD							
	–	T15P-2	CSP16HD-T15P	–	GX16-1	CS3507-T09P	–
...20090-16CHD	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
...18070-22CHD	–	T15P-2	CSP22HD-T15P	–	NX22-1	CS4009-T15P	–

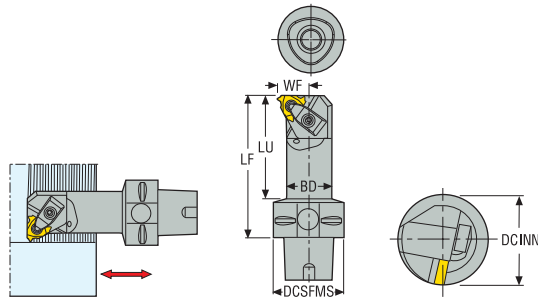
### Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
...14060, ...17070-16CHD													
	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
...20090-16CHD	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
...18070-22CHD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	–

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# Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown



- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 140, 142, 144, 146, 148, 150
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		
C6-CNR-20090-16CHD	02555843	32,0 1.260	63,0 2.480	90,0 3.543	19,8 0.780	36,0 1.417	68,0 2.677	1,1 2.430	16
C6-CNR-24105-16CHD	02555844	40,0 1.575	63,0 2.480	105,0 4.134	23,8 0.937	44,0 1.732	80,0 3.150	1,5 3.310	16
C6-CNL-20090-16CHD	02555845	32,0 1.260	63,0 2.480	90,0 3.543	19,8 0.780	36,0 1.417	68,0 2.677	1,1 2.430	16
C6-CNL-24105-16CHD	02555847	40,0 1.575	63,0 2.480	105,0 4.134	23,8 0.937	44,0 1.732	80,0 3.150	1,5 3.310	16
C6-CNR-22090-22CHD	02555848	32,0 1.260	63,0 2.480	90,0 3.543	21,3 0.839	38,0 1.496	68,0 2.677	1,1 2.430	22
C6-CNR-26105-22CHD	02555849	40,0 1.575	63,0 2.480	105,0 4.134	25,3 0.996	46,0 1.811	80,0 3.150	1,5 3.310	22
C6-CNL-22090-22CHD	02555850	32,0 1.260	63,0 2.480	90,0 3.543	21,3 0.839	38,0 1.496	68,0 2.677	1,1 2.430	22
C6-CNL-26105-22CHD	02555852	40,0 1.575	63,0 2.480	105,0 4.134	25,3 0.996	46,0 1.811	80,0 3.150	1,5 3.310	22

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
...16CHD	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
...22090-22CHD	–	T15P-2	CSP22HD-T15P	–	NX22-1	CS4009-T15P	–
...26105-22CHD	CHD22	T20P-7L	–	L86025-T20P	NX22-1	CS4009-T15P	S7616

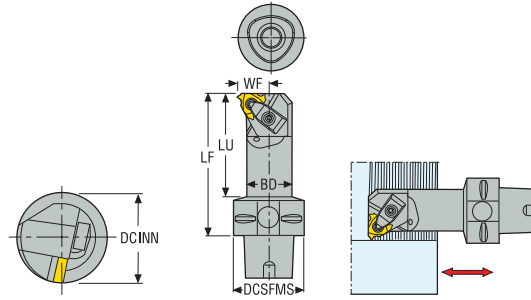
## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
...16CHD	MX16-1	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
...22090-22CHD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
...26105-22CHD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2

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# Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 110, 111, 112, 115, 116, 132, 134, 136, 138, 140, 142, 144, 146
- CP\* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	BD	DCSFMS	LF	WF	DCINN	LU	Weight	CTWS
		mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		
C6-CNR-26105-27CHD	02644674	40,0 1.575	63,0 2.480	105,0 4.134	25,3 0.996	46,0 1.811	80,0 3.150	1,5 3.310	27
C6-CNR-36182-27CHD	02644686	63,0 2.480	63,0 2.480	182,0 7.165	36,0 1.417	70,0 2.756	–	4,1 9.040	27
C6-CNL-26105-27CHD	02644677	40,0 1.575	63,0 2.480	105,0 4.134	25,3 0.996	46,0 1.811	80,0 3.150	1,5 3.310	27
C6-CNL-36182-27CHD	02644687	63,0 2.480	63,0 2.480	182,0 7.165	36,0 1.417	70,0 2.756	–	4,1 9.040	27

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Shim screw	Spring
C6...						
	CHD27	T20P-7	L86025-T20P	VX27-1	C05012-T15P	S7616

## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
C6...												
	MX27-1	VX27-98.5	VX27-2	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Start™

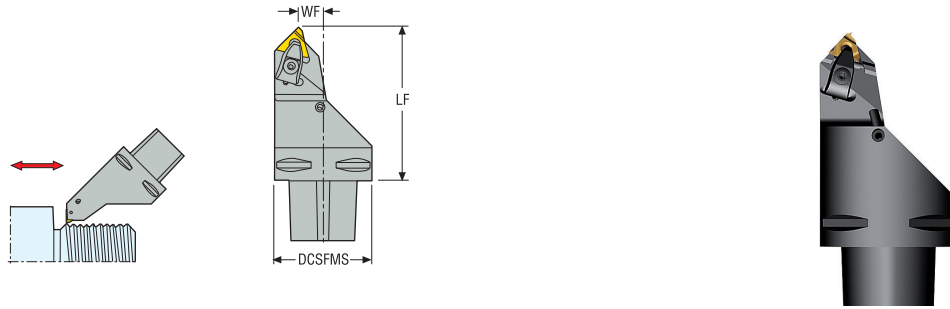
Rotating threading

Annex



# Seco-Capto™ – Toolholders for MTM

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 117, 119, 121, 122, 125, 127, 129, 131, 133, 135, 137, 139, 141, 143, 145, 147, 149

Designation	Item number	DCSFMS		LF		WF		Weight		CTWS
		mm	Inch	mm	Inch	mm	Inch	kg	lbs	
C6-CER-18100-16HD	02509302	63,0	2.480	100,0	3.937	18,0	0.709	1,6	3.530	16
C6-CER-16100-22HD	02509303	63,0	2.480	100,0	3.937	16,0	0.630	1,6	3.530	22
C6-CER-12100-27HD	02509304	63,0	2.480	100,0	3.937	12,0	0.472	1,6	3.530	27

## Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Coolant nozzle	Insert shim (S)	Shim screw	Spring
...16HD	CHD16	T15P-7	L85020-T15P	CN8	GX16-1	CS3507-T09P	S6912
...22HD	CHD22	T20P-7L	L86025-T20P	CN8	NX22-1	CS4009-T15P	S7616
...27HD	CHD27	T20P-7L	L86025-T20P	CN3	VX27-1	C05012-T15P	S7616

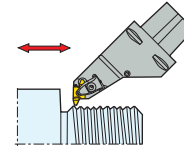
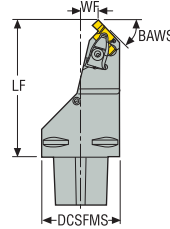
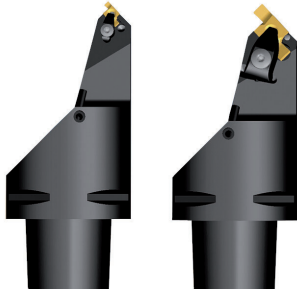
## Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Shim key
...16HD	MX16-1	GX16-0	-	-	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	-	-	-	T09P-2
...22HD	MX22-1	NX22-97.5	NX22-98	NX22-99	NX22-98.5	NX22-99.5	NX22-0.5	NX22-1.5	NX22-0	NX22-2	NX22-3	NX22-4	T15P-2
...27HD	MX27-1	VX27-98.5	VX27-2	-	VX27-99.5	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2

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## Seco-Capto™ – Toolholders for MTM

For K-inserts, Snap-Tap®



• For inserts program, see page(s) 104-107, 133, 135, 137

Left-hand version shown

Designation	Item number	DCSFMS	LF	WF	Weight	BAWS°	CTWS
		mm Inch	mm Inch	mm Inch	kg lbs		
C6-CEL-14110-20HD	02509308	63,0 2.480	110,0 4.331	14,0 0.551	1,7 3.750	45	20..
C6-CEL-07110-26HD	02509309	63,0 2.480	110,0 4.331	7,0 0.276	1,7 3.750	45	26..
C6-CEL-18110-14	02509306	63,0 2.480	110,0 4.331	18,0 0.709	1,7 3.750	45	14..

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Coolant nozzle	Insert shim (K)	Shim screw	Spring
-20	CHD22	T20P-7	–	L86025-T20P	CN8	KX20-2	CS4009-T15P	S7616
-26	CHD27	T20P-7	–	L86025-T20P	CN8	KX26-2	C05012-T15P	S7616
-14	–	T15P-2	CSP16-T15P	–	CN8	KX14-2	CS3507-T09P	–

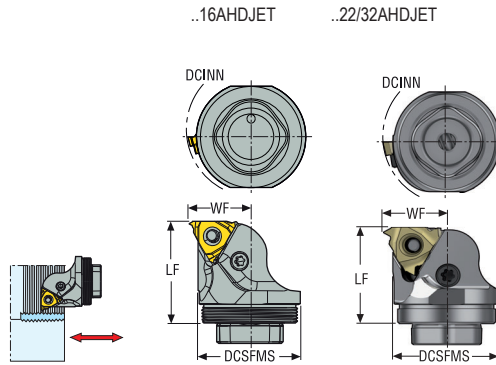
### Accessories

For holders	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Insert shim (K) 6	Shim key
-20	KX20-99	KX20-0	KX20-1	KX20-3	KX20-4	KX20-5	T15P-2
-26	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2
-14	KX14-0	KX14-1	KX14-3	KX14-4	KX14-5	–	T09P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Steadyline®, GL-heads, Jetstream Tooling®

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 105, 107, 110, 111, 112, 115, 116, 118, 120, 123, 124, 126, 128, 130, 132, 134, 136, 138, 146
- CP \* Max coolant pressure

Designation	Item number	DCSFMS	LF	WF	DCINN	CP*	Weight	CTWS
		mm Inch	mm Inch	mm Inch	mm Inch	bar psi	kg lbs	
GL25-PNR-17025-16AHDJET	03212499	25,0 0.984	25,0 0.984	16,3 0.642	29,0 1.142	200,0 2900.8	0,2 0.440	16
GL25-PNL-17025-16AHDJET	03212502	25,0 0.984	25,0 0.984	16,3 0.642	29,0 1.142	200,0 2900.8	0,1 0.220	16
GL32-PNR-20032-16AHDJET	03007255	32,0 1.260	32,0 1.260	19,8 0.780	36,0 1.417	200,0 2900.8	0,2 0.440	16
GL32-PNL-20032-16AHDJET	03007256	32,0 1.260	32,0 1.260	19,8 0.780	36,0 1.417	200,0 2900.8	0,2 0.440	16
GL40-PNR-24032-16AHDJET	03007261	40,0 1.575	32,0 1.260	23,8 0.937	44,0 1.732	200,0 2900.8	0,4 0.880	16
GL40-PNL-24032-16AHDJET	03007262	40,0 1.575	32,0 1.260	23,8 0.937	44,0 1.732	200,0 2900.8	0,3 0.660	16
GL50-PNR-29032-16AHDJET	03007264	50,0 1.969	32,0 1.260	28,8 1.134	54,0 2.126	200,0 2900.8	0,5 1.100	16
GL50-PNL-29032-16AHDJET	03007265	50,0 1.969	32,0 1.260	28,8 1.134	54,0 2.126	200,0 2900.8	0,5 1.100	16
GL32-PNR-22032-22AHDJET	03007257	32,0 1.260	32,0 1.260	21,3 0.839	38,0 1.496	200,0 2900.8	0,2 0.440	22
GL32-PNL-22032-22AHDJET	03007258	32,0 1.260	32,0 1.260	21,3 0.839	38,0 1.496	200,0 2900.8	0,1 0.220	22
GL40-PNR-26032-22AHDJET	03007263	40,0 1.575	32,0 1.260	25,3 0.996	46,0 1.811	200,0 2900.8	0,3 0.660	22
GL40-PNL-26032-22AHDJET	03007468	40,0 1.575	32,0 1.260	25,3 0.996	46,0 1.811	200,0 2900.8	0,3 0.660	22
GL50-PNR-31032-22AHDJET	03007266	50,0 1.969	32,0 1.260	30,3 1.193	56,0 2.205	200,0 2900.8	0,4 0.880	22
GL50-PNL-31032-22AHDJET	03007267	50,0 1.969	32,0 1.260	30,3 1.193	56,0 2.205	200,0 2900.8	0,5 1.100	22
GL40-PNR-27037-27AHDJET	03007260	40,0 1.575	37,0 1.457	26,8 1.055	48,0 1.890	200,0 2900.8	0,3 0.660	27
GL50-PNR-32037-27AHDJET	03007259	50,0 1.969	37,0 1.457	31,8 1.252	58,0 2.283	200,0 2900.8	0,3 0.660	27

Spare Parts

For holders	Insert lever	Insert shim (S)	Key (T-handle)	Lever screw	Locking key	Shim pin
..16..	PP3712	GXA16-1	DOUBLE-T	LS0612-T15P	H4B-T15P	AC4625
..22A..	PP4816	NXA22-1	DOUBLE-T	LS0815-T25P	H6B-T25P	AC5035
..27A..	PP6019	VXA27-1	DOUBLE-T	LS0820-T25P	H6B-T25P	AC6050

Accessories

For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9
..16..	MXA16-1	GXA16-0	-	-	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	-	-	-
..22A..	MXA22-1	NXA22-0	NXA22-98	NXA22-97.5	NXA22-0.5	NXA22-1.5	NXA22-2	NXA22-3	NXA22-4	NXA22-99.5	NXA22-99	NXA22-98.5
..27A..	MXA27-1	VXA27-0	VXA27-98	-	VXA27-0.5	VXA27-1.5	VXA27-2	VXA27-3	VXA27-4	VXA27-99.5	VXA27-99	VXA27-98.5

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

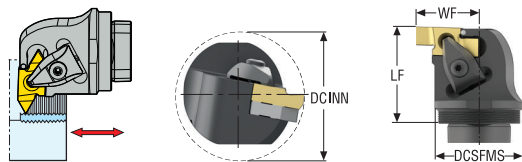
Thread Mini-Shaft™

Rotating threading

Annex

# Steadyline<sup>®</sup>, GL-heads

For K-inserts, Snap-Tap<sup>®</sup>








Right-hand version shown








- For inserts program, see page(s) 104-107, 134, 136, 138
- CP \* Max coolant pressure

Designation	Item number	DCSFMS	LF	WF	DCINN	CP*	Weight	CTWS
		mm Inch	mm Inch	mm Inch	mm Inch	bar psi	kg lbs	
GL50-CNR-36055-26AHD	03051391	50,0 1.969	55,0 2.165	36,0 1.417	65,0 2.559	200,0 2900.8	0,6 1.320	26 NR..

## Spare Parts

For holders	Cantilever clamp	Clamp screw	Insert shim (K)	Shim screw	Spring
GL50...	 CHD27	 L86025-T20P	 KX26-2	 C05012-T15P	 S7616

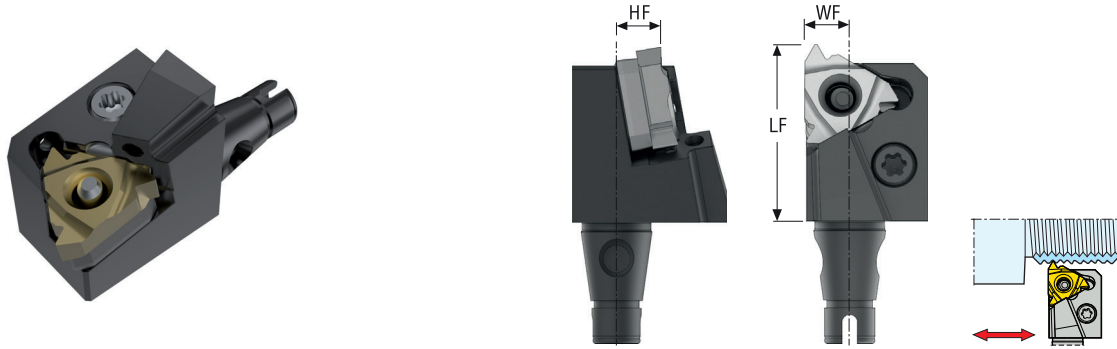
## Accessories

For holders	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Insert shim (K) 6	Shim key
GL50...	 KX26-99	 KX26-0	 KX26-1	 KX26-3	 KX26-4	 KX26-5	 T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Quick Change, Jetstream Tooling® QC-heads – External

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 104, 105, 106, 108, 109, 113, 114, 117, 119, 121, 122, 125, 127, 129, 131, 133, 135, 137, 139, 149
- CP \* Max coolant pressure
- For Technical Guide, see catalog Turning

Designation	Item number	LF		WF		HF		CP*	Weight	CTWS
		mm	Inch	mm	Inch	mm	Inch			
QC12-PER-16HDJET	03280772	25,0	0.984	6,0	0.236	5,975	0.235	200,0 7.9	0,3 0.660	16
QC12-PEL-16HDJET	03280773	25,0	0.984	6,0	0.236	5,975	0.235	200,0 7.9	0,3 0.660	16
QC16-PER-16HDJET	03280774	25,0	0.984	8,0	0.315	7,9	0.311	200,0 7.9	0,3 0.660	16
QC16-PEL-16HDJET	03280775	25,0	0.984	8,0	0.315	7,9	0.311	200,0 7.9	0,3 0.660	16

### Spare Parts

For holders	Insert lever	Insert shim (S)	Lever key	Lever screw	Shim pin
QC12/16	PP3712	GXA16-1	T15P-2	LS0612-T15P	AC4625

### Accessories

For holders	Fastening screw	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Mounting fixture	Torque key
QC12/16	–	MXA16-1	GXA16-0	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	SECO-MF7075-QC	T00-15P30
QC12/16	SECO-MF7075-QC	MXA16-1	GXA16-0	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	–	T00-15P30

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

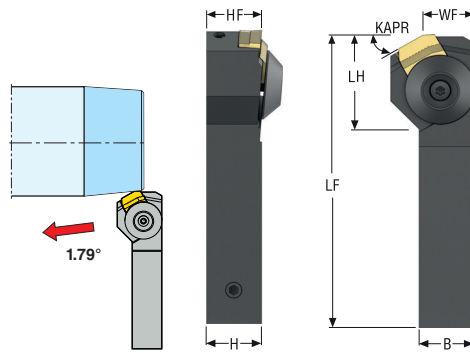
Thread MDT

Thread Mini-Start™

Rotating threading

Annex


## Toolholder for peeling




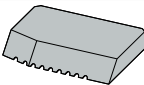





Right-hand version shown



• For inserts program, see page(s) 103

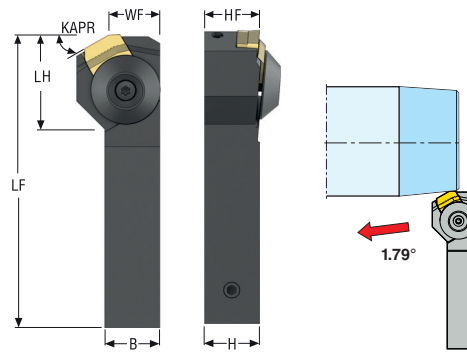
Designation	Item number	KAPR°	B	H	LF	LH	WF	HF	Weight	CTWS
		—	mm	mm	mm	mm	mm	mm	kg	
CSXCR3232P25-R30	03120990	30	32,0	32,0	170,0	64,61	29,53	32,0	0,5	SCNN-R30

### Spare Parts

For holders	Anvil screw	Chipbreaker	Insert screw	Key	Key (T-handle)	Plug	Shim
							
CSXCR...	CA4012	PS2518	W400820-T30P	H6B-T30PL	DOUBLE-T	JET-P1/8-5MM	SSN250630

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Toolholder for peeling



• For inserts program, see page(s) 103

Right-hand version shown

Designation	Item number	KAPR°	B	H	LF	LH	WF	HF	Weight	CTWS
			<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	lbs	
CSXCR20-8D-R30	03120991	30	1.250	1.250	6.693	2.545	1.163	1.250	3.530	SCNN-R30

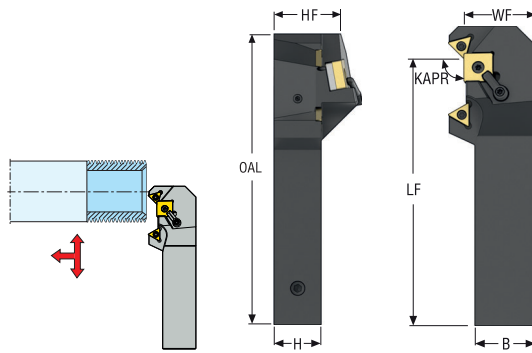
### Spare Parts

For holders	Anvil screw	Chipbreaker	Insert screw	Key	Key (T-handle)	Plug	Shim
CSXCR...	CA4012	PS2518	W400820-T30P	H6B-T30PL	DOUBLE-T	JET-P1/8-5MM	SSN250630

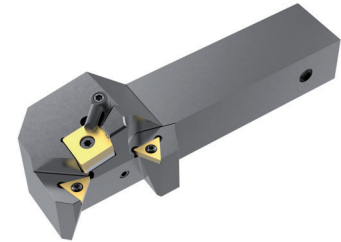
Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store



Toolholder for pipe-facing



Right-hand version shown



• For inserts programme, see catalog Turning

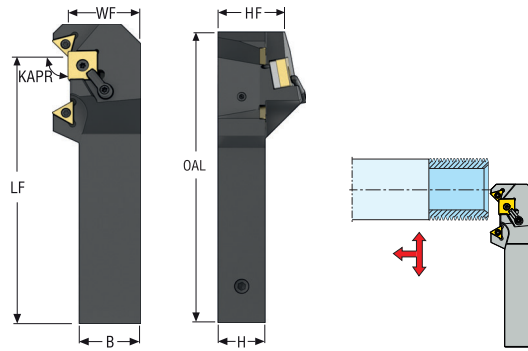
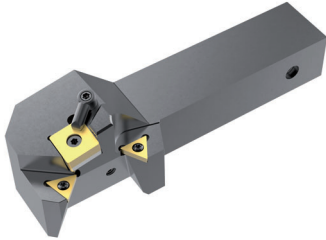
Designation	Item number	KAPR°	B	H	LF	WF	HF	OAL	Weight	CTWS	CTWS
		–	mm	mm	mm	mm	mm	mm	kg		
MSGNR3240R19-TC-45-60	03120992	90,0	40,0	32,0	174,0	47,0	32,0	195,6	0,7	SN...1906... TCMT16T3...	SN...1906... TCMT16T3...

Spare Parts

For holders	Cantilever clamp	Clamp screw	Insert key	Insert screw	Insert shim	Key	Key (T-handle)	Plug	Shim pin
MSGNR...									
	MC22	LD6024-T20P	H4B-T15P	C03508-T15P	SSN190412	H6B-T20P	DOUBLE-T	JET-P1/8-5MM	MN1920-T20P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Toolholder for pipe-facing



• For inserts programme, see catalog Turning

Right-hand version shown

Designation	Item number	KAPR°	B	H	LF	WF	HF	OAL	Weight	CTWS	CTWS
			<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	lbs		
MSGNR-125-6-TC-45-60	03120993	90	1.500	1.250	6.850	1.850	1.260	7.701	4.850	SN...1906... TCMT16T3...	SN...1906... TCMT16T3...

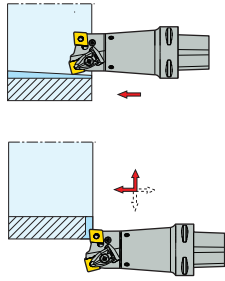
### Spare Parts

For holders	Cantilever clamp	Clamp screw	Insert key	Insert screw	Insert shim	Key	Key (T-handle)	Plug	Shim pin
MSGNR...									
	MC22	LD6024-T20P	H4B-T15P	C03508-T15P	SSN190412	H6B-T20P	DOUBLE-T	JET-P1/8-5MM	MN1920-T20P

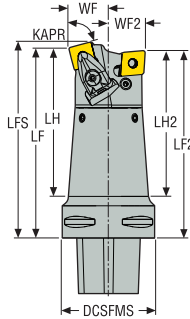
Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Seco-Capto™, Multi insert pocket tools, internal

Toolholders for inserts SNMA, SNMG, SNMM / CNMA, CNMG, CNMM



Right-hand (Internal) version shown  
KAPR = 75°



- For inserts program, see catalog Turning
- GAMO° = Rake angle, LAMS° = Inclination angle

Designation	Item number	Seco-Capto size	CTWS		GAMO°	LAMS°	DCSFMS	LF	LF2	LFS	LH	LH2	WF	WF2	Weight	CTWS	CTWS
C6-DSKNR2713015-PCLNL2512816	03031406	C6	15/16	15/16	-5,0°	-10,0°	63,0 2.480	130,0 5.118	128,0 5.039	134,0 5.276	101,5 3.996	99,5 3.917	27,0 1.063	25,0 0.984	0,9 1.980	SN..1506.. CN..1606..	SN..1506.. CN..1606..
C6-DSKNL2713015-PCLNR2512816C	03032390	C6	15/16	15/16	-5,0°	-10,0°	63,0 2.480	130,0 5.118	128,0 5.039	134,0 5.276	101,5 3.996	99,5 3.917	27,0 1.063	25,0 0.984	2,3 5.070	SN..1506.. CN..1606..	SN..1506.. CN..1606..

## Spare Parts

For holders	Clamp	Clamp pin	Clamp screw	Insert shim	Lever pin	Lever screw	Plug	Shim pin	Shim screw	Spring
C6										
	CD16-S	FP2012	L86026-T20P	PCN160412	PP6017	LS0820	P6SS6X5G	RP8286	C05010-T20P	S7010

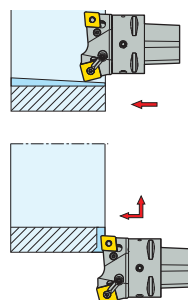
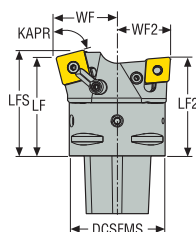
## Accessories

For holders	Clamp kit	Key	Lever key
C6			
	CD16-S16	T20P-7L	3SMS795

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Seco-Capto™, Multi insert pocket tools, internal

Toolholders for inserts SNMA, SNMG, SNMM / CNMA, CNMG, CNMM



Right-hand (Internal) version shown  
KAPR = 75°

- For inserts program, see catalog Turning
- GAMO° = Rake angle, LAMS° = Inclination angle

Designation	Item number	Seco-Capto size		CTWS	CTWS	GAMO°	LAMS°	DCSFMS	LF	LF2	LFS	WF	WF2	Weight	CTWS	CTWS
								mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	kg lbs		
C6-MSKNR4006519-PCLNL3506516	03032391	C6	19/16	19/16	-5,0 °	-10,0 °	63,0 2.480	65,0 2.559	65,0 2.559	69,8 2.748	40,0 1.575	35,0 1.378	0,7 1.540	SN..1906..SN..1906.. CN..1606..CN..1606..		
C6-MSKNL4006519-PCLNR3506516C	03032405	C6	19/16	19/16	-5,0 °	-10,0 °	63,0 2.480	65,0 2.559	65,0 2.559	69,8 2.748	40,0 1.575	35,0 1.378	1,5 3.310	SN..1906..SN..1906.. CN..1606..CN..1606..		
C8-MSKNR4508019-PCLNL4508016	03032403	C8	19/16	19/16	-5,0 °	-10,0 °	80,0 3.150	80,0 3.150	80,0 3.150	85,0 3.346	45,0 1.772	45,0 1.772	3,3 7.280	SN..1906..SN..1906.. CN..1606..CN..1606..		
C8-MSKNL4508019-PCLNR4508016C	03031407	C8	19/16	19/16	-5,0 °	-10,0 °	80,0 3.150	80,0 3.150	80,0 3.150	85,0 3.346	45,0 1.772	45,0 1.772	3,3 7.280	SN..1906..SN..1906.. CN..1606..CN..1606..		

## Spare Parts

For size	Clamp	Coolant nozzle	Insert shim	Lever pin	Lever screw	Pin	Plug	Screw	Shim pin
C6/C8	MC22	CN6	SSN190412	PP6017	LS0820	MN1920-T20P	P6SS6X5G	LD6024-T20P	RP8286

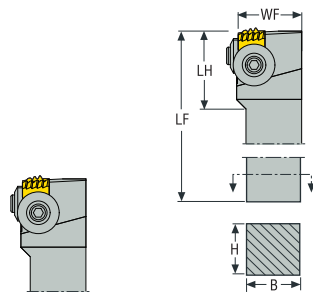
## Accessories

For holders	Key	Lever key
C6/C8	T20P-7L	3SMS795

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Toolholders for chasers, external


Snap-Tap®







Right-hand version shown



• For inserts program, see page(s) 151, 152

Designation	Item number	B	H	LF	WF	LH	Weight	CTWS
		mm	mm	mm	mm	mm	kg	
CER3232P1-X	03048363	32,0	32,0	170,24	37,25	47,54	1,4	15.875
CER3232P5-X	03048364	32,0	32,0	170,24	37,25	47,54	1,4	25.000

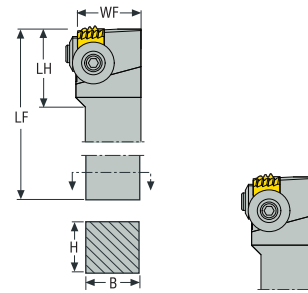
### Spare Parts

For holders	Clamp kit side	Clamp kit top	Key, side clamp	Key, top clamp
				
CER	W200613-T20P	W240618-T25P	T20P-7	T25P-7

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Toolholders for chasers, external

Snap-Tap®



Right-hand version shown

• For inserts program, see page(s) 151, 152

Designation	Item number	B	H	LF	WF	LH	Weight	CTWS
		<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	lbs	
CER1256-1-X	03048365	1.250	1.250	6.702	1.467	1.872	3.090	15.875
CER1256-5-X	03048366	1.250	1.250	6.702	1.467	1.872	3.090	25.000

### Spare Parts

For holders	Clamp kit	Clamp kit side	Key, side clamp	Key, top clamp
CER	 W200613-T20P	 W240618-T25P	 T25P-7	 T20P-7

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

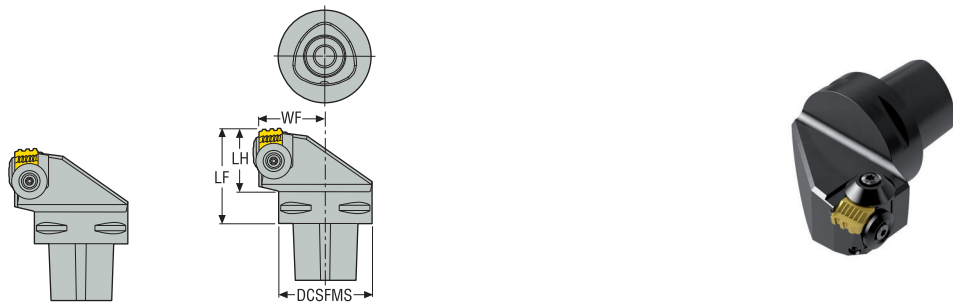
Thread MDT

Thread Mini-Start™

Rotating threading


Annex

# Seco-Capto™ – Toolholders for chasers, external Snap-Tap®







Right-hand version shown

• For inserts program, see page(s) 151, 152

Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm	mm	mm	kg	
C6-CER-45065-1-X	02995827	63,0	65,0	45,0	1,3	15.875
C6-CER-45065-5-X	02995828	63,0	65,0	45,0	1,4	25.000
C8-CER-55080-1-X	02995821	80,0	80,0	55,0	2,7	15.875
C8-CER-55080-5-X	02995822	80,0	80,0	55,0	2,8	25.000

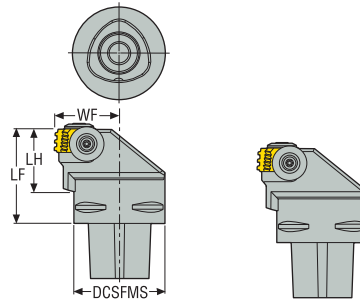
## Spare Parts

For holders	Clamp kit side	Clamp kit top	Key, side clamp	Key, top clamp
				
C6/C8-X	W240618-T25P	W200613-T20P	T25P-7	T20P-7

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Seco-Capto™ – Toolholders for chasers, internal

Snap-Tap®



• For inserts program, see page(s) 151, 152

Right-hand version shown

Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm	mm	mm	kg	
C6-CNR-45065-1-X	02995829	63,0	65,0	45,0	1,4	15.875
C6-CNR-45065-5-X	02995831	63,0	65,0	45,0	1,4	25.000
C8-CNR-55080-1-X	02995823	80,0	80,0	55,0	2,9	15.875
C8-CNR-55080-5-X	02995825	80,0	80,0	55,0	2,9	25.000
C8-CNL-55080-1-X	03118011	80,0	80,0	55,0	1,9	15.875
C8-CNL-55080-5-X	03118015	80,0	80,0	55,0	1,7	25.000

### Spare Parts

For holders	Clamp kit side	Clamp kit top	Coolant nozzle	Key, side clamp	Key, top clamp
...CNR...					
...CNR...	W240618-T25P	W200613-T20P	CN6	T25P-7	T20P-7
...CNL...	W240618-T25P	W200613-T20P	–	T25P-7	T20P-7

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

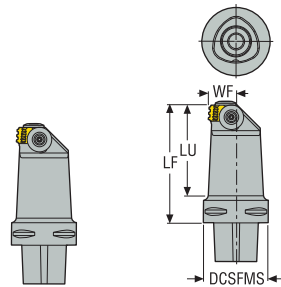
Thread Mini-Start™

Rotating threading

Annex




# Seco-Capto™ – Toolholders for chasers, internal Snap-Tap®








Right-hand version shown

• For inserts program, see page(s) 151, 152

Designation	Item number	DCSFMS	LF	WF	LU	Weight	CTWS
		mm	mm	mm	mm	kg	
C6-CNR-27115-1-X	03003765	63,0	115,0	27,0	88,0	1,9	15.875
C6-CNR-27115-5-X	03010914	63,0	115,0	27,0	88,0	1,9	25.000

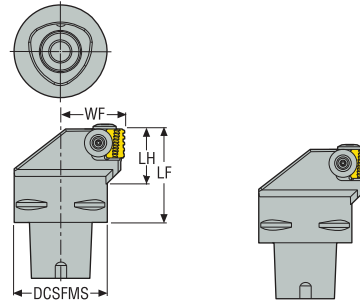
## Spare Parts

For holders	Clamp kit side	Clamp kit top	Coolant nozzle	Key, side clamp	Key, top clamp
C6...	 W240618-T25P	 W200613-T20P	 CN6	 T25P-7	 T20P-7

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Seco-Capto™ – Toolholders for chasers, internal

Snap-Tap®



• For inserts program, see page(s) 151, 152

Left-hand version shown

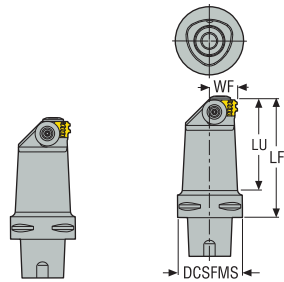
Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm	mm	mm	kg	
C6-CNL-45065-1C-X	02995830	63,0	65,0	45,0	1,4	15.875
C6-CNL-45065-5C-X	02995832	63,0	65,0	45,0	1,4	25.000
C8-CNL-55080-1C-X	02995824	80,0	80,0	55,0	2,9	15.875
C8-CNL-55080-5C-X	02995826	80,0	80,0	55,0	2,9	25.000

### Spare Parts

For holders	Clamp kit side	Clamp kit top	Coolant nozzle	Key, side clamp	Key, top clamp
C6/C8...	W240618-T25P	W200613-T20P	CN6	T25P-7	T20P-7


Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Seco-Capto™ – Toolholders for chasers, internal Snap-Tap®








Left-hand version shown

• For inserts program, see page(s) 151, 152

Designation	Item number	DCSFMS	LF	WF	LH	Weight	CTWS
		mm	mm	mm	mm	kg	
C6-CNLC-27115-1C-X	03003766	63,0	115,0	27,0	88,0	1,9	15.875
C6-CNLC-27115-5C-X	03010915	63,0	115,0	27,0	88,0	1,9	25.000

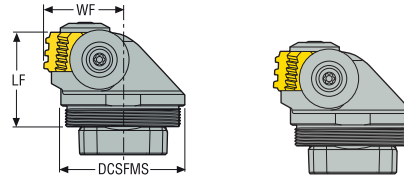
## Spare Parts

For holders	Clamp kit side	Clamp kit top	Coolant nozzle	Key, side clamp	Key, top clamp
C6...	 W240618-T25P	 W200613-T20P	 CN6	 T25P-7	 T20P-7

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Steadyline<sup>®</sup>, GL-heads – Toolholders for chasers, internal

Snap-Tap<sup>®</sup>



• For inserts program, see page(s) 151, 152

Right-hand version shown

Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm	mm	mm	kg	
GL50-CNR-32035-9-I	03011855	50,0	35,0	32,0	0,4	12.700
GL50-CNR-32038-1-X	03008525	50,0	38,0	32,0	0,4	15.875
GL50-CNR-32044-5-X	03008552	50,0	44,0	32,0	0,5	25.000
GL50-CNL-32035-9-I	03011856	50,0	35,0	32,0	0,5	12.700
GL50-CNL-32038-1-X	03008526	50,0	38,0	32,0	0,5	15.875
GL50-CNL-32044-5-X	03008553	50,0	44,0	32,0	0,5	25.000

### Spare Parts

For holders	Clamp kit side	Clamp kit top	Key, clamp	Key, side clamp	Key, top clamp	Key (T-handle)
...9-1						
...1-X, ...5-X	W200613-T20P	W240618-T25P	–	H6B-T20P	H6B-T25P	DOUBLE-T

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

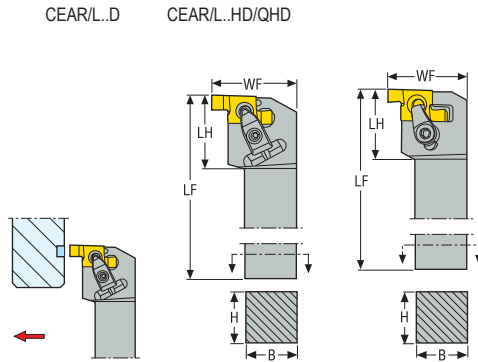
Thread Mini-Start™

Rotating threading

Annex

## Toolholders for Precision Axial Grooves

Snap-Tap®



Right-hand version shown  
WF (10../14../20..) = WF2 (12..)



• For inserts program and INPLM, see catalog Turning

Designation	Item number	H	B	LF	WF 10../14../20..	WF2 12	LH 10../14..	INPLM 10../14../20..	INPLM2 12..	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	mm	kg	
CEAR2525M10D	02411447	25,0	25,0	150,0	35,35	38,35	22,0	16,0	18,0	0,8	10../12..
CEAL2525M10D	02411448	25,0	25,0	150,0	35,35	38,35	22,0	16,0	18,0	0,8	10../12..
CEAR2525M14HD	02627517	25,0	25,0	150,0	36,85	–	31,0	22,0	–	0,8	14..
CEAL2525M14HD	02627516	25,0	25,0	150,0	36,85	–	31,0	22,0	–	0,8	14..
CEAR2525M20QHD	02528518	25,0	25,0	150,0	39,35	–	35,0	28,0	–	0,9	20..
CEAL2525M20QHD	02528519	25,0	25,0	150,0	39,35	–	35,0	28,0	–	0,9	20..

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (KL)	Insert shim (KR)	Shim screw	Spring
CEAR..10	–	T15P-2	CSP16-T15P	–	–	AKR10	CS2507-T07P	–
CEAL..10	–	T15P-2	CSP16-T15P	–	AKL10	–	CS2507-T07P	–
CEAR..14	CHD16	T15P-2	–	L85020-T15P	–	AKR14	CS3507-T09P	S6912
CEAL..14	CHD16	T15P-2	–	L85020-T15P	AKL14	–	CS3507-T09P	S6912
CEAR..20	CHD22	T20P-7	–	L86025-T20P	–	AKR20	CS4009-T15P	S7616
CEAL..20	CHD22	T20P-7	–	L86025-T20P	AKL20	–	CS4009-T15P	S7616

### Accessories

For holders	Insert shim (K)	Shim key
CEAR..10	KX12-2	T07P-2
CEAL..10	KX12-2	T07P-2
CEAR..14	–	T09P-2
CEAL..14	–	T09P-2
CEAR..20	–	T15P-2
CEAL..20	–	T15P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Shim KX12-2 for insert 12..

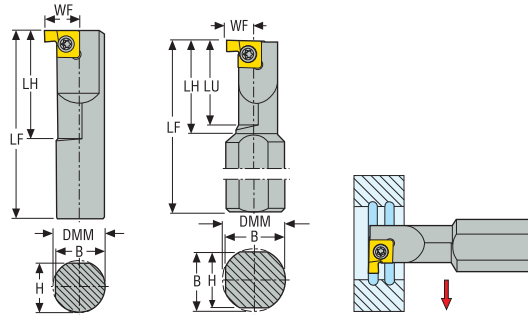
## Toolholders for Precision Grooves

Snap-Tap®



SNR/L..H09

SNR/L



Right-hand version shown

- For inserts program, see catalog Turning
- DCINN - minimum bore diameter

Designation	Item number	H	B	LF	WF	LH	LU	DMM	DCINN	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	mm	kg	
SNR0010H9	75025330	9,5	9,5	100,0	7,5	20,0	–	10,0	14,0	0,1	9..
SNR0010K9	75025332	15,5	15,5	125,0	6,5	25,0	23,0	16,0	14,0	0,2	9..
SNR0013L9	75025334	15,5	15,5	140,0	8,0	32,0	30,0	16,0	17,0	0,2	9..
SNR0016M9	75025336	15,5	15,5	150,0	9,5	40,0	38,0	16,0	20,0	0,3	9..
SNL0010H9	75025331	9,5	9,5	100,0	7,5	20,0	–	10,0	14,0	0,1	9..
SNL0010K9	75025333	15,5	15,5	125,0	6,5	25,0	23,0	16,0	14,0	0,2	9..
SNL0013L9	75025335	15,5	15,5	140,0	8,0	32,0	30,0	16,0	17,0	0,2	9..
SNL0016M9	75025337	15,5	15,5	150,0	9,5	40,0	38,0	16,0	20,0	0,3	9..

### Spare Parts

For holders	Insert key	Insert screw
..9	T07P-2	C02506-T07P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

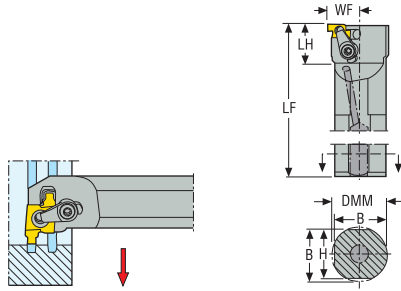
Thread Mini-Start™

Rotating threading

Annex

# Toolholders for Precision Grooves

Snap-Tap®



Right-hand version shown  
WF (10../14../20../26..) = WF2 (12..)

- For inserts program, see catalog Turning
- DCINN - minimum bore diameter

Designation	Item number	H	B	LF	WF	WF2 12	LH	DMM	DCINN	DCINN2	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	mm	mm	kg	
CNR0020P10DA	02411454	18,0	19,0	170,0	13,5	16,5	26,0	20,0	26,0	29,0	0,4	10../12..
CNR0025R10DA	02411459	23,0	24,0	200,0	16,0	19,0	28,0	25,0	31,0	34,0	0,7	10../12..
CNR0032S10DA	02411467	30,0	31,0	250,0	19,5	22,5	31,0	32,0	38,0	41,0	1,4	10../12..
CNL0020P10DA	02411456	18,0	19,0	170,0	13,5	16,5	26,0	20,0	26,0	29,0	0,4	10../12..
CNL0025R10DA	02411464	23,0	24,0	200,0	16,0	19,0	28,0	25,0	31,0	34,0	0,7	10../12..
CNL0032S10DA	02411468	30,0	31,0	250,0	19,5	22,5	31,0	32,0	38,0	41,0	1,4	10../12..
CNR0020P14A	00040041	18,0	19,0	170,0	15,0	-	32,0	20,0	30,0	-	0,4	14..
CNR0025R14A	00040042	23,0	24,0	200,0	17,5	-	45,0	25,0	34,0	-	0,7	14..
CNR0032S14A	00040043	30,0	31,0	250,0	21,0	-	48,0	32,0	40,0	-	1,4	14..
CNR0040T14A	00040044	37,0	38,5	300,0	25,0	-	50,0	40,0	48,0	-	2,6	14..
CNL0020P14A	00040045	18,0	19,0	170,0	15,0	-	32,0	20,0	30,0	-	0,4	14..
CNL0025R14A	00040046	23,0	24,0	200,0	17,5	-	45,0	25,0	34,0	-	0,7	14..
CNL0032S14A	00040047	30,0	31,0	250,0	21,0	-	48,0	32,0	40,0	-	1,4	14..

## Spare Parts

For holders	Clamp key	Clamp kit	Insert shim (K)	Shim screw
..10	 T15P-2	 CSP16-T15P	 KX10-2	 CS2507-T07P
..14	T15P-2	CSP16-T15P	KX14-2	CS3507-T09P

## Accessories

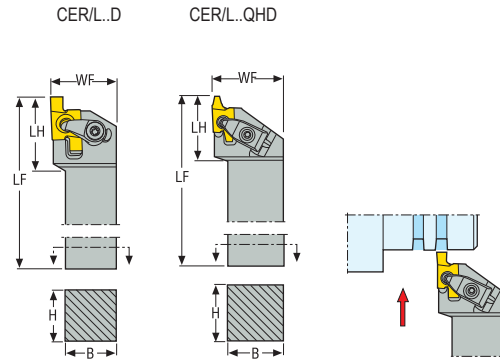
For holders	Insert shim (K)	Shim key
..10	 KX12-2	 T07P-2
..14	-	T09P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Shim KX12-2 for insert 12..

## Toolholders for Precision Grooves

Snap-Tap®



• For inserts program, see catalog Turning

Right-hand version shown  
LF (10../14..) = LF2 (12..)  
LH (10../14..) = LH2 (12..)

Designation	Item number	H	B	LF 10../14..	LF2 12	WF	LH 10../14..	LH2 12	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	
CER1212M10D	02435850	12,0	12,0	150,0	153,0	16,0	21,5	24,5	0,2	10../12..
CER1616H10D	02411427	16,0	16,0	100,0	103,0	16,0	21,5	24,5	0,2	10../12..
CER2020K10D	02411428	20,0	20,0	125,0	128,0	25,0	21,5	24,5	0,4	10../12..
CER2525M10D	02411430	25,0	25,0	150,0	153,0	32,0	21,5	24,5	0,8	10../12..
CER3225P10D	02411432	32,0	25,0	170,0	173,0	32,0	22,5	25,5	1,1	10../12..
CEL1212M10D	02435852	12,0	12,0	150,0	153,0	16,0	21,5	24,5	0,2	10../12..
CEL1616H10D	02411436	16,0	16,0	100,0	103,0	16,0	21,5	24,5	0,2	10../12..
CEL2020K10D	02411437	20,0	20,0	125,0	128,0	25,0	21,5	24,5	0,4	10../12..
CEL2525M10D	02411438	25,0	25,0	150,0	153,0	32,0	21,5	24,5	0,8	10../12..
CEL3225P10D	02411440	32,0	25,0	170,0	173,0	32,0	22,5	25,5	1,1	10../12..
CER2525M14QHD	02538606	25,0	25,0	150,0	-	32,0	26,0	-	0,8	14..
CER3225P14QHD	02627519	32,0	25,0	170,0	-	32,0	26,0	-	1,1	14..
CER3232P14QHD	02627520	32,0	32,0	170,0	-	32,0	26,0	-	1,4	14..
CEL2525M14QHD	02627518	25,0	25,0	150,0	-	32,0	26,0	-	0,8	14..

### Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (K)	Shim screw	Spring
..10	-	T15P-2	CSP16-T15P	-	KX10-2	CS2507-T07P	-
..14	CHD16	T15P-2	-	L85020-T15P	KX14-2	CS3507-T09P	S6912

### Accessories

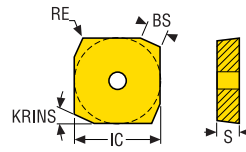
For holders	Insert shim (K)	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Shim key
..10	KX12-2	-	-	-	-	-	T07P-2
..14	-	KX14-0	KX14-1	KX14-3	KX14-4	KX14-5	T09P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

\* Shim KX12-2 for insert 12..



## SCNN for peeling



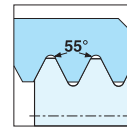
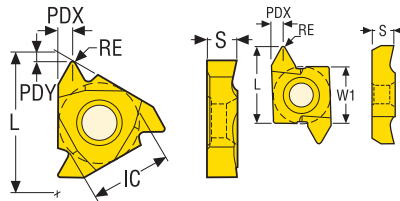
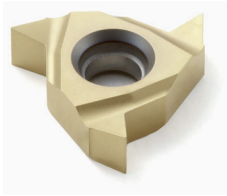
RE	BS	IC	S	KRINS°	Designation	Note	Grades
mm Inch	mm Inch	mm Inch	mm Inch				TP250T Coated
4,0 0.157	6,6 0.260	25,0 0.984	6,35 0.250	28.0	SCNN250640-R30		■
4,0 0.157	6,2 0.244	25,0 0.984	6,35 0.250	23.0	SCNN250640-R25	*	■

\* R25 for use in 25 degree pockets only - not the 30degree - R30

■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Partial Profile 55° – External Threading

Snap-Tap®



16ER..A



16ER..A1



16ER..A2



16Ex/22Ex



16V55\*



26ER/26NR..



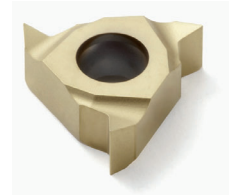
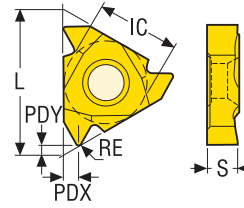
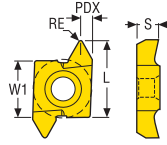
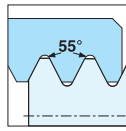
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP500 Coated
0,5-1,5	48,0-16,0	0,08 0.003	0,6 0.024	0,8 0.031	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERA55			■			16ELA55	■
0,5-3,0	48,0-8,0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERAG55	■		■		■	16ELAG55	■
1,75-3,0	14,0-8,0	0,2 0.008	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERG55	■		■			16ELG55	■
3,5-5,0	7,0-5,0	0,4 0.016	1,8 0.071	2,5 0.098	12,7 0.500	–	22,0 0.866	4,71 0.185	22ERN55			■		■	22ELN55	■
0,5-3,0	48,0-8,0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERAG55-A			■	■			
1,75-3,0	14,0-8,0	0,2 0.008	1,2 0.047	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERG55-A			■	■			
0,5-3,0	48,0-8,0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERAG55-A1			■				
1,75-3,0	14,0-8,0	0,2 0.008	1,2 0.047	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERG55-A1			■				
0,5-3,0	48,0-8,0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERAG55-A2			■				
1,75-3,0	14,0-8,0	0,2 0.008	1,2 0.047	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16ERG55-A2			■				
5,5-10,0	4,5-2,5	0,7 0.028	–	5,0 0.197	–	15,875 0.625	26,0 1.024	7,88 0.310	26ERK55		■	■			26NRK55	■
–	–	–	–	–	–	–	–	–	16V55			■				

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

\* Toolset contents: 3 pcs 16ERG55, CP500, 3 pcs 16NRG55, CP500, 2 pcs 16ERA55, CP500 and 2 pcs 16NRA55, CP500

## Partial Profile 55° – Internal Threading

Snap-Tap®



09NR/11Nx/16Nx/22Nx..



16NR..A



16NR..A1



16NR..A2



26ER/26NR..

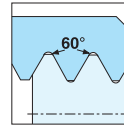
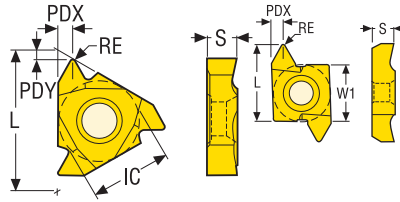
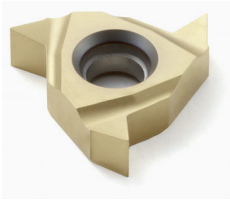


Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades				Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP300 Coated	CP500 Coated
0,5-1,5	48.0-16.0	0,08 0.003	0,7 0.028	0,8 0.031	5,56 0.219	-	9,6 0.378	2,4 0.094	09NRA55		■					
0,5-1,5	48.0-16.0	0,08 0.003	0,6 0.024	0,8 0.031	6,35 0.250	-	11,0 0.433	3,0 0.118	11NRA55		■		■	11NLA55		■
0,5-1,5	48.0-16.0	0,08 0.003	0,6 0.024	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRA55		■		■	16NLA55		■
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRAG55	■	■			16NLAG55		■
1,75-3,0	14.0-8.0	0,2 0.008	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRG55	■	■			16NLG55		■
3,5-5,0	7.0-5.0	0,4 0.016	1,8 0.071	2,5 0.098	12,7 0.500	-	22,0 0.866	4,71 0.185	22NRN55		■		■	22NLN55		■
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRAG55-A		■	■				
1,75-3,0	14.0-8.0	0,2 0.008	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRG55-A		■	■				
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRAG55-A1		■					
1,75-3,0	14.0-8.0	0,2 0.008	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRG55-A1		■					
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRAG55-A2		■					
1,75-3,0	14.0-8.0	0,2 0.008	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NRG55-A2		■					
5,5-10,0	4.5-2.5	0,7 0.028	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26NRK55		■			26ERK55	■	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Partial Profile 60° – External Threading

Snap-Tap®



16ER..A



16ER..A1



16ER..A2



16Ex/22Ex..



16V60\*



26ER/26NR..



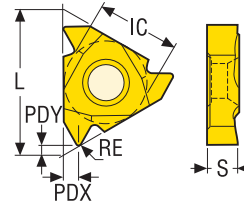
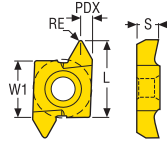
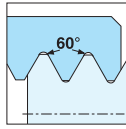
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP300 Coated	CP500 Coated
0,5-1,5	48.0-16.0	0,08 0.003	0,6 0.024	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERA60	■		■		■	16ELA60		■
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERAG60	■		■		■	16ELAG60		■
1,75-3,0	14.0-8.0	0,18 0.007	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERG60	■		■		■	16ELG60		■
3,5-5,0	7.0-5.0	0,4 0.016	1,8 0.071	2,5 0.098	12,7 0.500	-	22,0 0.866	4,71 0.185	22ERN60	■	■	■		■	22ELN60		■
0,5-1,5	48.0-16.0	0,08 0.003	0,6 0.024	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERA60-A			■	■				
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERAG60-A			■	■				
1,75-3,0	14.0-8.0	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERG60-A			■	■				
0,5-1,5	48.0-16.0	0,08 0.003	0,6 0.024	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERA60-A1			■					
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERAG60-A1			■					
1,75-3,0	14.0-8.0	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERG60-A1			■					
0,5-1,5	48.0-16.0	0,08 0.003	0,6 0.024	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERA60-A2			■					
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERAG60-A2			■					
1,75-3,0	14.0-8.0	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ERG60-A2			■					
5,5-10,0	4.5-2.5	0,4 0.016	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26ERK60		■	■			26NRK60	■	■
-	-	-	-	-	-	-	-	-	16V60			■					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

\* Toolset contents: 3 pcs 16ERG60, CP500, 3 pcs 16NRG60, CP500, 2 pcs 16ERA60, CP500 and 2 pcs 16NRA60, CP500

## Partial Profile 60° – Internal Threading

Snap-Tap®



09NR/11Nx/16Nx/22Nx



11NR/16NR..A



11NR/16NR..A1



11NR/16NR..A2



26ER/26NR..

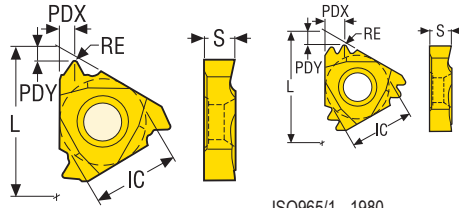
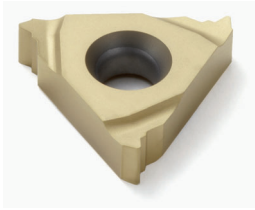


Pitch	RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
									CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP300 Coated	CP500 Coated
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch									
0,5-1,5	48.0-16.0	0,08 0.003	0,7 0.028	0,8 0.031	5,56 0.219	–	9,6 0.378	2,4 0.094	09NRA60			■				
0,5-1,5	48.0-16.0	0,08 0.003	0,7 0.028	0,8 0.031	6,35 0.250	–	11,0 0.433	3,0 0.118	11NRA60	■		■		■	11NLA60	■
0,5-1,5	48.0-16.0	0,08 0.003	0,7 0.028	0,8 0.031	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRA60			■		■	16NLA60	■
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRAG60	■		■		■	16NLAG60	■
1,75-3,0	14.0-8.0	0,12 0.005	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRG60	■		■		■	16NLG60	■
3,5-5,0	7.0-5.0	0,25 0.010	1,8 0.071	2,5 0.098	12,7 0.500	–	22,0 0.866	4,71 0.185	22NRN60	■	■	■		■	22NLN60	■
0,5-1,5	48.0-16.0	0,08 0.003	0,7 0.028	0,8 0.031	6,35 0.250	–	11,0 0.433	3,0 0.118	11NRA60-A			■	■			
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRAG60-A			■	■			
1,75-3,0	14.0-8.0	0,12 0.005	1,2 0.047	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRG60-A			■	■			
0,5-1,5	48.0-16.0	0,08 0.003	0,7 0.028	0,8 0.031	6,35 0.250	–	11,0 0.433	3,0 0.118	11NRA60-A1			■				
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRAG60-A1			■				
1,75-3,0	14.0-8.0	0,12 0.005	1,2 0.047	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRG60-A1			■				
0,5-1,5	48.0-16.0	0,08 0.003	0,7 0.028	0,8 0.031	6,35 0.250	–	11,0 0.433	3,0 0.118	11NRA60-A2			■				
0,5-3,0	48.0-8.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRAG60-A2			■				
1,75-3,0	14.0-8.0	0,12 0.005	1,2 0.047	1,5 0.059	9,525 0.375	–	16,5 0.650	3,47 0.137	16NRG60-A2			■				
5,5-10,0	4.5-2.5	0,4 0.016	–	5,0 0.197	–	15,875 0.625	26,0 1.024	7,88 0.310	26NRK60		■	■			26ERK60	■ ■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## ISO Metric – External Threading

Snap-Tap®



ISO965/1 - 1980  
3h/4h

16ER/22ER/27ER..M



16ER..A



16ER..A1



16ER..A2



16ER..TT



16Ex/22Ex/27ER



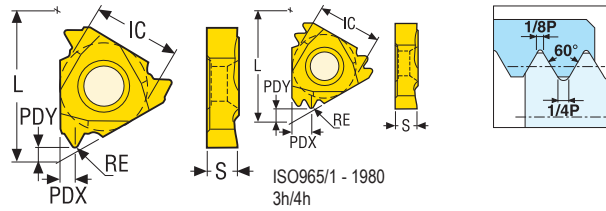
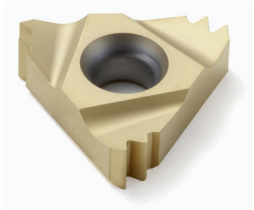
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP300 Coated	CP500 Coated
0,5-0,5	-	0,06 0.002	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER0.5ISO			■		■	16EL0.5ISO		■
0,75-0,75	-	0,11 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER0.75ISO			■		■	16EL0.75ISO		■
0,8-0,8	-	0,11 0.004	0,8 0.031	0,6 0.024	9,525 0.375	16,5 0.650	3,47 0.137	16ER0.8ISO			■			16EL0.8ISO		■
1,0-1,0	-	0,14 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.0ISO	■		■		■	16EL1.0ISO		■
1,25-1,25	-	0,17 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.25ISO	■		■		■	16EL1.25ISO		■
1,5-1,5	-	0,22 0.009	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.5ISO	■		■		■	16EL1.5ISO	■	■
1,75-1,75	-	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.75ISO	■		■		■	16EL1.75ISO		■
2,0-2,0	-	0,29 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.0ISO	■		■		■	16EL2.0ISO		■
2,5-2,5	-	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.5ISO	■		■		■	16EL2.5ISO		■
3,0-3,0	-	0,42 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER3.0ISO	■		■		■	16EL3.0ISO		■
3,5-3,5	-	0,47 0.019	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER3.5ISO	■	■	■		■	22EL3.5ISO		■
4,0-4,0	-	0,53 0.021	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER4.0ISO	■	■	■		■	22EL4.0ISO		■
4,5-4,5	-	0,59 0.023	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER4.5ISO			■		■	22EL4.5ISO		■
5,0-5,0	-	0,66 0.026	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER5.0ISO	■		■		■	22EL5.0ISO		■
5,5-5,5	-	0,72 0.028	2,2 0.087	3,2 0.126	15,875 0.625	27,0 1.063	6,15 0.242	27ER5.5ISO			■					
6,0-6,0	-	0,79 0.031	2,2 0.087	3,2 0.126	15,875 0.625	27,0 1.063	6,15 0.242	27ER6.0ISO		■	■					
1,0-1,0	-	0,14 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.0ISO-A			■	■				
1,25-1,25	-	0,17 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.25ISO-A			■	■				
1,5-1,5	-	0,22 0.009	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.5ISO-A			■	■				
1,75-1,75	-	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.75ISO-A			■	■				
2,0-2,0	-	0,29 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.0ISO-A			■	■				
2,5-2,5	-	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.5ISO-A			■	■				

Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP300 Coated	CP500 Coated
3,0-3,0	-	0,42 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER3.0ISO-A			■	■				
1,0-1,0	-	0,14 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.0ISO-A1			■					
1,25-1,25	-	0,17 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.25ISO-A1			■					
1,5-1,5	-	0,22 0.009	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.5ISO-A1			■					
1,75-1,75	-	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.75ISO-A1			■					
2,0-2,0	-	0,29 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.0ISO-A1			■					
2,5-2,5	-	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.5ISO-A1			■					
3,0-3,0	-	0,42 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER3.0ISO-A1			■					
1,0-1,0	-	0,14 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.0ISO-A2			■					
1,25-1,25	-	0,17 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.25ISO-A2			■					
1,5-1,5	-	0,22 0.009	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.5ISO-A2			■					
1,75-1,75	-	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.75ISO-A2			■					
2,0-2,0	-	0,29 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.0ISO-A2			■					
2,5-2,5	-	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.5ISO-A2			■					
3,0-3,0	-	0,42 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER3.0ISO-A2			■					
1,0-1,0	-	0,14 0.006	1,3 0.051	1,3 0.051	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.0ISO-TT			■					
1,5-1,5	-	0,22 0.009	1,3 0.051	1,8 0.071	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.5ISO-TT			■					
2,0-2,0	-	0,29 0.011	1,6 0.063	2,4 0.094	9,525 0.375	16,5 0.650	3,47 0.137	16ER2.0ISO-TT			■					
1,0-1,0	-	0,14 0.006	1,5 0.059	2,4 0.094	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.0ISO3M			■					
1,5-1,5	-	0,22 0.009	1,5 0.059	2,2 0.087	9,525 0.375	16,5 0.650	3,47 0.137	16ER1.5ISO2M			■					
1,5-1,5	-	0,22 0.009	2,3 0.091	3,6 0.142	12,7 0.500	22,0 0.866	4,71 0.185	22ER1.5ISO3M			■					
2,0-2,0	-	0,29 0.011	2,0 0.079	2,9 0.114	12,7 0.500	22,0 0.866	4,71 0.185	22ER2.0ISO2M			■					
2,0-2,0	-	0,29 0.011	3,0 0.118	4,8 0.189	12,7 0.500	22,0 0.866	4,71 0.185	22ER2.0ISO3M			■					
3,0-3,0	-	0,42 0.017	2,8 0.110	4,3 0.169	15,875 0.625	27,0 1.063	6,15 0.242	27ER3.0ISO2M			■					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## ISO Metric – Internal Threading

Snap-Tap®



09NR/11Nx/16Nx/22Nx/27NR



11NR/16NR..A



11NR/16NR..A1



11NR/16NR..A2



16NR/22NR..M



16NR..TT



Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
0,5-0,5	-	0,04 0.002	0,7 0.028	0,6 0.024	5,56 0.219	9,6 0.378	2,4 0.094	09NR0.5ISO			■					
0,8-0,8	-	0,07 0.003	0,7 0.028	0,6 0.024	5,56 0.219	9,6 0.378	2,4 0.094	09NR0.8ISO			■					
1,0-1,0	-	0,07 0.003	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR1.0ISO			■					
1,25-1,25	-	0,11 0.004	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR1.25ISO			■					
1,5-1,5	-	0,12 0.005	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR1.5ISO			■					
1,75-1,75	-	0,12 0.005	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR1.75ISO			■					
2,0-2,0	-	0,17 0.007	0,7 0.028	0,9 0.035	5,56 0.219	9,6 0.378	2,4 0.094	09NR2.0ISO			■					
0,5-0,5	-	0,03 0.001	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR0.5ISO			■		■	11NL0.5ISO		■
0,75-0,75	-	0,04 0.002	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR0.75ISO			■		■	11NL0.75ISO		■
1,0-1,0	-	0,08 0.003	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.0ISO	■		■		■	11NL1.0ISO		■
1,25-1,25	-	0,09 0.004	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.25ISO			■		■	11NL1.25ISO		■
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.5ISO	■		■		■	11NL1.5ISO		■
1,75-1,75	-	0,12 0.005	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.75ISO			■		■			
2,0-2,0	-	0,17 0.007	0,8 0.031	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR2.0ISO	■		■		■			
0,5-0,5	-	0,03 0.001	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR0.5ISO			■		■	16NL0.5ISO		■
0,75-0,75	-	0,04 0.002	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR0.75ISO			■		■	16NL0.75ISO		■
1,0-1,0	-	0,08 0.003	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.0ISO	■		■		■	16NL1.0ISO	■	■
1,25-1,25	-	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.25ISO	■		■		■	16NL1.25ISO		■
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.5ISO	■		■		■	16NL1.5ISO	■	■
1,75-1,75	-	0,12 0.005	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.75ISO			■		■	16NL1.75ISO		■
2,0-2,0	-	0,17 0.007	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.0ISO	■		■		■	16NL2.0ISO		■
2,5-2,5	-	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.5ISO	■		■		■	16NL2.5ISO		■



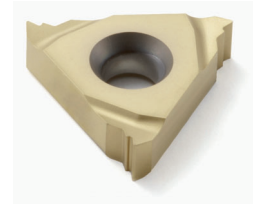
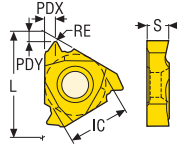
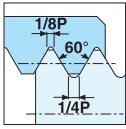
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
3,0-3,0	-	0,21 0.008	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR3.0ISO	■		■		■	16NL3.0ISO	■	
3,5-3,5	-	0,25 0.010	1,9 0.075	2,3 0.091	12,7 0.500	22,0 0.866	4,71 0.185	22NR3.5ISO	■		■		■	22NL3.5ISO	■	
4,0-4,0	-	0,28 0.011	2,0 0.079	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR4.0ISO	■	■	■		■	22NL4.0ISO	■	
4,5-4,5	-	0,32 0.013	2,1 0.083	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR4.5ISO			■		■	22NL4.5ISO	■	
5,0-5,0	-	0,35 0.014	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR5.0ISO	■		■		■	22NL5.0ISO	■	
5,5-5,5	-	0,38 0.015	2,2 0.087	3,2 0.126	15,875 0.625	27,0 1.063	6,15 0.242	27NR5.5ISO			■					
6,0-6,0	-	0,42 0.017	2,2 0.087	3,2 0.126	15,875 0.625	27,0 1.063	6,15 0.242	27NR6.0ISO		■	■					
1,0-1,0	-	0,08 0.003	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.0ISO-A			■	■				
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.5ISO-A			■	■				
2,0-2,0	-	0,17 0.007	0,8 0.031	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR2.0ISO-A			■	■				
1,0-1,0	-	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.0ISO-A			■	■				
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.5ISO-A			■	■				
2,0-2,0	-	0,16 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.0ISO-A			■	■				
2,5-2,5	-	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.5ISO-A			■	■				
3,0-3,0	-	0,21 0.008	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR3.0ISO-A			■	■				
1,0-1,0	-	0,08 0.003	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.0ISO-A1			■					
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.5ISO-A1			■					
2,0-2,0	-	0,17 0.007	0,8 0.031	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR2.0ISO-A1			■					
1,0-1,0	-	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.0ISO-A1			■					
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.5ISO-A1			■					
2,0-2,0	-	0,16 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.0ISO-A1			■					
2,5-2,5	-	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.5ISO-A1			■					
3,0-3,0	-	0,21 0.008	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR3.0ISO-A1			■					
1,0-1,0	-	0,08 0.003	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.0ISO-A2			■					
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR1.5ISO-A2			■					
2,0-2,0	-	0,17 0.007	0,8 0.031	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR2.0ISO-A2			■					
1,0-1,0	-	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.0ISO-A2			■					
1,5-1,5	-	0,12 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.5ISO-A2			■					
2,0-2,0	-	0,16 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.0ISO-A2			■					
2,5-2,5	-	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.5ISO-A2			■					

Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
3,0-3,0	-	0,21 0.008	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR3.0ISO-A2		■						
1,0-1,0	-	0,09 0.004	1,3 0.051	1,2 0.047	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.0ISO-TT		■						
1,5-1,5	-	0,12 0.005	1,3 0.051	1,8 0.071	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.5ISO-TT		■						
2,0-2,0	-	0,18 0.007	1,6 0.063	2,4 0.094	9,525 0.375	16,5 0.650	3,47 0.137	16NR2.0ISO-TT		■						
1,0-1,0	-	0,08 0.003	1,5 0.059	2,4 0.094	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.0ISO3M		■						
1,5-1,5	-	0,12 0.005	1,4 0.055	2,1 0.083	9,525 0.375	16,5 0.650	3,47 0.137	16NR1.5ISO2M		■						
1,5-1,5	-	0,12 0.005	2,3 0.091	3,6 0.142	12,7 0.500	22,0 0.866	4,71 0.185	22NR1.5ISO3M		■						
2,0-2,0	-	0,17 0.007	2,0 0.079	2,9 0.114	12,7 0.500	22,0 0.866	4,71 0.185	22NR2.0ISO2M		■						
2,0-2,0	-	0,17 0.007	3,0 0.118	4,8 0.189	12,7 0.500	22,0 0.866	4,71 0.185	22NR2.0ISO3M		■						
3,0-3,0	-	0,21 0.008	2,8 0.110	4,3 0.169	15,875 0.625	27,0 1.063	6,15 0.242	27NR3.0ISO2M		■						

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UN – External Threading

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ANSI B1.1 - 1983  
3A

16ER..A



16ER..A1



16ER..A2



16ER..TT



16Ex/22Ex/27ER



22ER..M



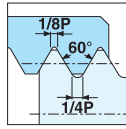
Pitch	RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
								CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch								
-	40.0-40.0	0,08 0.003	1,2 0.047	0,5 0.020	9,525 0.375	16,5 0.650	3,47 0.137	16ER40UN			■			
-	32.0-32.0	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER32UN			■		■	16EL32UN ■
-	28.0-28.0	0,11 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER28UN		■	■		■	16EL28UN ■
-	24.0-24.0	0,13 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER24UN		■	■		■	16EL24UN ■
-	20.0-20.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER20UN			■		■	16EL20UN ■
-	18.0-18.0	0,18 0.007	1,2 0.047	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER18UN			■		■	16EL18UN ■
-	16.0-16.0	0,22 0.009	1,2 0.047	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER16UN	■		■		■	16EL16UN ■
-	14.0-14.0	0,22 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14UN	■		■		■	16EL14UN ■
-	13.0-13.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER13UN			■			
-	12.0-12.0	0,26 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER12UN	■		■		■	16EL12UN ■
-	11.0-11.0	0,28 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11UN			■		■	16EL11UN ■
-	10.0-10.0	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER10UN			■		■	16EL10UN ■
-	9.0-9.0	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER9UN			■		■	16EL9UN ■
-	8.0-8.0	0,38 0.015	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER8UN	■		■		■	16EL8UN ■
-	7.0-7.0	0,47 0.019	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER7UN			■		■	22EL7UN ■
-	6.0-6.0	0,52 0.020	2,0 0.079	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER6UN			■		■	22EL6UN ■
-	5.0-5.0	0,6 0.024	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER5UN			■			22EL5UN ■
-	4.0-4.0	0,79 0.031	2,2 0.087	3,2 0.126	15,875 0.625	27,0 1.063	6,15 0.242	27ER4UN			■			
-	20.0-20.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER20UN-A			■	■		
-	18.0-18.0	0,18 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER18UN-A			■	■		
-	16.0-16.0	0,22 0.009	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER16UN-A			■	■		
-	14.0-14.0	0,22 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14UN-A			■	■		

Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP500 Coated
-	12.0-12.0	0,29 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER12UN-A			■	■			
-	8.0-8.0	0,43 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER8UN-A			■	■			
-	20.0-20.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER20UN-A1			■				
-	18.0-18.0	0,18 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER18UN-A1			■				
-	16.0-16.0	0,22 0.009	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER16UN-A1			■				
-	14.0-14.0	0,22 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14UN-A1			■				
-	12.0-12.0	0,29 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER12UN-A1			■				
-	8.0-8.0	0,43 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER8UN-A1			■				
-	20.0-20.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER20UN-A2			■				
-	18.0-18.0	0,18 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER18UN-A2			■				
-	16.0-16.0	0,22 0.009	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER16UN-A2			■				
-	14.0-14.0	0,22 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14UN-A2			■				
-	12.0-12.0	0,29 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER12UN-A2			■				
-	8.0-8.0	0,43 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER8UN-A2			■				
-	20.0-20.0	0,16 0.006	1,2 0.047	1,6 0.063	9,525 0.375	16,5 0.650	3,47 0.137	16ER20UN-TT			■				
-	16.0-16.0	0,21 0.008	1,4 0.055	1,9 0.075	9,525 0.375	16,5 0.650	3,47 0.137	16ER16UN-TT			■				
-	12.0-12.0	0,29 0.011	1,7 0.067	2,6 0.102	9,525 0.375	16,5 0.650	3,47 0.137	16ER12UN-TT			■				
-	16.0-16.0	0,21 0.008	2,5 0.098	4,0 0.157	12,7 0.500	22,0 0.866	4,71 0.185	22ER16UN3M			■				
-	12.0-12.0	0,26 0.010	2,0 0.079	3,1 0.122	12,7 0.500	22,0 0.866	4,71 0.185	22ER12UN2M			■				

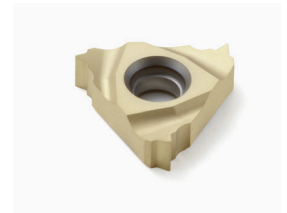
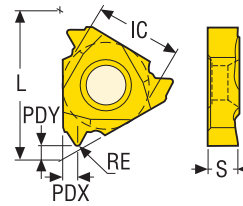
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3B



09NR/11Nx/16Nx/22Nx/27NR



16NR/22NR..M



16NR..A



16NR..A1



16NR..A2



16NR..TT



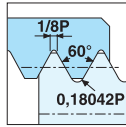
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	20.0-20.0	0,09 0.004	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR20UN			■					
-	18.0-18.0	0,1 0.004	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR18UN			■					
-	13.0-13.0	0,15 0.006	0,7 0.028	0,9 0.035	5,56 0.219	9,6 0.378	2,4 0.094	09NR13UN			■					
-	32.0-32.0	0,04 0.002	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR32UN			■		■			
-	28.0-28.0	0,05 0.002	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR28UN			■		■			
-	24.0-24.0	0,07 0.003	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR24UN			■		■	11NL24UN		■
-	20.0-20.0	0,09 0.004	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR20UN			■		■	11NL20UN		■
-	18.0-18.0	0,1 0.004	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR18UN			■		■	11NL18UN		■
-	16.0-16.0	0,13 0.005	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR16UN			■		■	11NL16UN		■
-	14.0-14.0	0,14 0.006	0,8 0.031	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR14UN			■		■	11NL14UN		■
-	40.0-40.0	0,04 0.002	1,2 0.047	0,5 0.020	9,525 0.375	16,5 0.650	3,47 0.137	16NR40UN			■					
-	32.0-32.0	0,04 0.002	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR32UN	■		■		■	16NL32UN		■
-	28.0-28.0	0,05 0.002	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR28UN	■		■		■	16NL28UN		■
-	24.0-24.0	0,07 0.003	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR24UN	■		■		■	16NL24UN		■
-	20.0-20.0	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR20UN	■		■		■	16NL20UN		■
-	18.0-18.0	0,1 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR18UN	■		■		■	16NL18UN		■
-	16.0-16.0	0,13 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR16UN	■		■		■	16NL16UN	■	■
-	14.0-14.0	0,14 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR14UN	■		■		■	16NL14UN	■	■
-	13.0-13.0	0,15 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR13UN			■					
-	12.0-12.0	0,15 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR12UN	■		■		■	16NL12UN		■
-	11.0-11.0	0,16 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11UN			■		■	16NL11UN		■
-	10.0-10.0	0,18 0.007	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR10UN	■		■		■	16NL10UN		■

Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	9.0-9.0	0,19 0.007	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR9UN			■					
-	8.0-8.0	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR8UN	■		■		■	16NL8UN		■
-	7.0-7.0	0,25 0.010	2,0 0.079	2,4 0.094	12,7 0.500	22,0 0.866	4,71 0.185	22NR7UN			■			22NL7UN		■
-	6.0-6.0	0,3 0.012	2,2 0.087	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR6UN			■		■	22NL6UN		■
-	5.0-5.0	0,36 0.014	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR5UN			■		■			
-	4.0-4.0	0,45 0.018	2,2 0.087	3,2 0.126	15,875 0.625	27,0 1.063	6,15 0.242	27NR4UN			■					
-	20.0-20.0	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR20UN-A			■	■				
-	18.0-18.0	0,1 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR18UN-A			■	■				
-	16.0-16.0	0,12 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR16UN-A			■	■				
-	14.0-14.0	0,14 0.006	1,2 0.047	1,3 0.051	9,525 0.375	16,5 0.650	3,47 0.137	16NR14UN-A			■	■				
-	12.0-12.0	0,15 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR12UN-A			■	■				
-	8.0-8.0	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR8UN-A			■	■				
-	20.0-20.0	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR20UN-A1			■					
-	18.0-18.0	0,1 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR18UN-A1			■					
-	16.0-16.0	0,12 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR16UN-A1			■					
-	14.0-14.0	0,14 0.006	1,2 0.047	1,3 0.051	9,525 0.375	16,5 0.650	3,47 0.137	16NR14UN-A1			■					
-	12.0-12.0	0,15 0.006	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR12UN-A1			■					
-	8.0-8.0	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR8UN-A1			■					
-	20.0-20.0	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR20UN-A2			■					
-	18.0-18.0	0,1 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR18UN-A2			■					
-	16.0-16.0	0,12 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR16UN-A2			■					
-	14.0-14.0	0,14 0.006	1,2 0.047	1,3 0.051	9,525 0.375	16,5 0.650	3,47 0.137	16NR14UN-A2			■					
-	12.0-12.0	0,15 0.006	1,5 0.059	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR12UN-A2			■					
-	8.0-8.0	0,25 0.010	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR8UN-A2			■					
-	16.0-16.0	0,13 0.005	1,4 0.055	1,9 0.075	9,525 0.375	16,5 0.650	3,47 0.137	16NR16UN-TT			■					
-	12.0-12.0	0,16 0.006	1,65 0.065	2,45 0.096	9,525 0.375	16,5 0.650	3,47 0.137	16NR12UN-TT			■					
-	16.0-16.0	0,13 0.005	1,5 0.059	2,3 0.091	9,525 0.375	16,5 0.650	3,47 0.137	16NR16UN2M			■					
-	16.0-16.0	0,13 0.005	2,4 0.094	3,8 0.150	12,7 0.500	22,0 0.866	4,71 0.185	22NR16UN3M			■					
-	12.0-12.0	0,15 0.006	2,0 0.079	3,0 0.118	12,7 0.500	22,0 0.866	4,71 0.185	22NR12UN2M			■					
-	12.0-12.0	0,15 0.006	3,0 0.118	5,0 0.197	12,7 0.500	22,0 0.866	4,71 0.185	22NR12UN3M			■					

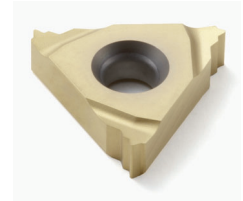
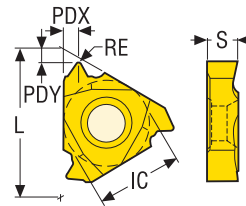
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

UNJ – External Threading®

Snap-Tap



BS4084 - 1996  
MIL-SPECS - 8879A  
3A



16Ex

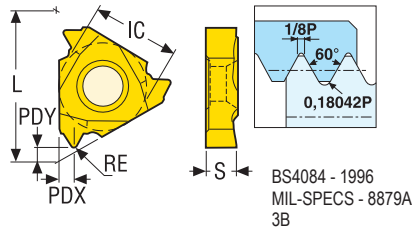
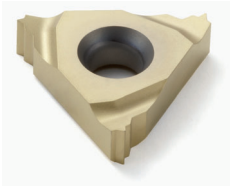


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades				
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated
-	32.0-32.0	0,13 0.005	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER32UNJ	■		■		
-	28.0-28.0	0,148 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER28UNJ	■		■		
-	24.0-24.0	0,175 0.007	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER24UNJ	■		■		
-	20.0-20.0	0,208 0.008	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER20UNJ	■		■		■
-	18.0-18.0	0,23 0.009	1,2 0.047	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER18UNJ	■		■		
-	16.0-16.0	0,255 0.010	1,2 0.047	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER16UNJ	■		■		■
-	14.0-14.0	0,295 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14UNJ	■		■		
-	12.0-12.0	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER12UNJ	■		■		■
-	10.0-10.0	0,405 0.016	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER10UNJ	■		■		
-	8.0-8.0	0,5 0.020	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER8UNJ	■		■		
-	12.0-12.0	0,34 0.013	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16EL12UNJ					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## UNJ – Internal Threading

Snap-Tap®



16Ex



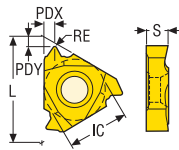
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades				
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated
-	32.0-32.0	0,03 0.001	1,2 0.047	0,4 0.016	9,525 0.375	16,5 0.650	3,47 0.137	16NR32UNJ	■				
-	28.0-28.0	0,04 0.002	1,2 0.047	0,4 0.016	9,525 0.375	16,5 0.650	3,47 0.137	16NR28UNJ	■				
-	24.0-24.0	0,06 0.002	1,2 0.047	0,5 0.020	9,525 0.375	16,5 0.650	3,47 0.137	16NR24UNJ	■				
-	20.0-20.2	0,08 0.003	1,2 0.047	0,5 0.020	9,525 0.375	16,5 0.650	3,47 0.137	16NR20UNJ	■				
-	18.0-18.0	0,09 0.004	1,2 0.047	0,6 0.024	9,525 0.375	16,5 0.650	3,47 0.137	16NR18UNJ	■				
-	16.0-16.0	0,1 0.004	1,2 0.047	0,6 0.024	9,525 0.375	16,5 0.650	3,47 0.137	16NR16UNJ	■				
-	14.0-14.0	0,11 0.004	1,2 0.047	0,7 0.028	9,525 0.375	16,5 0.650	3,47 0.137	16NR14UNJ	■				
-	12.0-12.0	0,12 0.005	1,2 0.047	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR12UNJ	■				
-	10.0-10.0	0,17 0.007	1,2 0.047	1,0 0.039	9,525 0.375	16,5 0.650	3,47 0.137	16NR10UNJ	■				
-	8.0-8.0	0,22 0.009	1,2 0.047	1,2 0.047	9,525 0.375	16,5 0.650	3,47 0.137	16NR8UNJ	■				

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

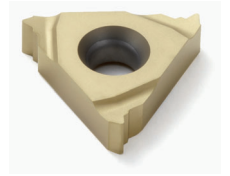
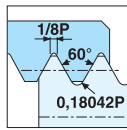


# MJ – External Threading

Snap-Tap®



ISO5855 - 1983  
4h/6h



16Ex

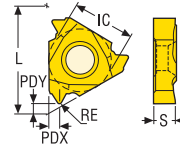
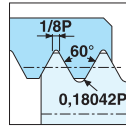
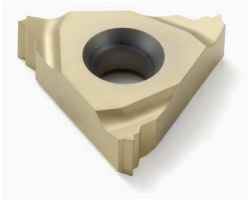


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
1,0-1,0	-	0,16 <i>0.006</i>	0,8 <i>0.031</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER1.0MJ	■		■		■	16EL1.0MJ	■	
1,25-1,25	-	0,21 <i>0.008</i>	0,8 <i>0.031</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER1.25MJ	■							
1,5-1,5	-	0,25 <i>0.010</i>	0,8 <i>0.031</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER1.5MJ	■		■		■	16EL1.5MJ	■	
2,0-2,0	-	0,32 <i>0.013</i>	1,2 <i>0.047</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER2.0MJ	■							

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MJ – Internal Threading

Snap-Tap®



ISO5855 - 1983  
4H/5H

16Ex

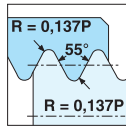


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated
1,0-1,0	–	0,06 <i>0.002</i>	1,2 <i>0.047</i>	0,4 <i>0.016</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR1.0MJ	■				
1,25-1,25	–	0,08 <i>0.003</i>	1,2 <i>0.047</i>	0,5 <i>0.020</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR1.25MJ	■				
1,5-1,5	–	0,09 <i>0.004</i>	1,2 <i>0.047</i>	0,6 <i>0.024</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR1.5MJ	■				
2,0-2,0	–	0,12 <i>0.005</i>	1,2 <i>0.047</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR2.0MJ	■				

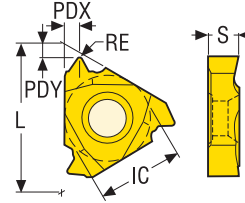
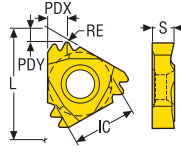
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# Whitworth, BSW – External Threading

Snap-Tap®



BS84 - 1956  
ISO228 - 1982  
BS2779 - 1973



16ER..A



16ER..A1



16ER..A2



16ER..TT



16Ex/22Ex



22ER..M



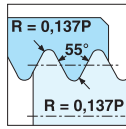
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	28.0-28.0	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER28W			■		■	16EL28W		■
-	20.0-20.0	0,14 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER20W			■		■	16EL20W		■
-	19.0-19.0	0,15 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER19W	■		■		■	16EL19W		■
-	18.0-18.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER18W			■					
-	16.0-16.0	0,2 0.008	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER16W			■		■	16EL16W		■
-	14.0-14.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14W	■		■		■	16EL14W		■
-	12.0-12.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER12W			■		■	16EL12W		■
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11W	■		■		■	16EL11W		■
-	10.0-10.0	0,27 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER10W			■		■	16EL10W		■
-	9.0-9.0	0,31 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER9W			■		■	16EL9W		■
-	8.0-8.0	0,42 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER8W			■		■	16EL8W		■
-	7.0-7.0	0,43 0.017	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER7W			■		■	22EL7W		■
-	6.0-6.0	0,5 0.020	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER6W			■		■	22EL6W		■
-	5.0-5.0	0,63 0.025	1,7 0.067	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22ER5W			■		■	22EL5W		■
-	19.0-19.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER19W-A			■	■				
-	14.0-14.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14W-A			■	■				
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11W-A			■	■				
-	19.0-19.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER19W-A1			■					
-	14.0-14.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14W-A1			■					
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11W-A1			■					
-	19.0-19.0	0,16 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER19W-A2			■					
-	14.0-14.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14W-A2			■					

Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11W-A2			■					
-	14.0-14.0	0,24 0.009	1,5 0.059	2,2 0.087	9,525 0.375	16,5 0.650	3,47 0.137	16ER14W-TT			■					
-	11.0-11.0	0,3 0.012	1,8 0.071	2,8 0.110	9,525 0.375	16,5 0.650	3,47 0.137	16ER11W-TT			■					
-	11.0-11.0	0,3 0.012	2,3 0.091	3,5 0.138	12,7 0.500	22,0 0.866	4,71 0.185	22ER11W2M			■					

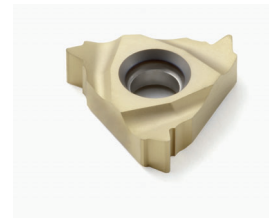
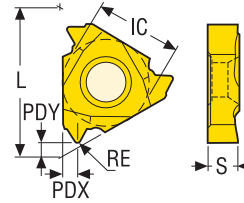
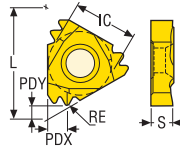
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Whitworth, BSW – Internal Threading

Snap-Tap®



BS84 -1956  
ISO228 - 1982  
BS2779 - 1973



09NR/11Nx/16Nx/22Nx



11NR/16NR..A



11NR/16NR..A1



11NR/16NR..A2



16NR..TT



22NR..M



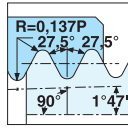
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	19.0-19.0	0,15 0.006	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR19W		■						
-	14.0-14.0	0,24 0.009	0,7 0.028	0,9 0.035	5,56 0.219	9,6 0.378	2,4 0.094	09NR14W		■						
-	19.0-19.0	0,15 0.006	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR19W	■		■		■		11NL19W	■
-	14.0-14.0	0,24 0.009	0,7 0.028	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR14W	■		■		■		11NL14W	■
-	28.0-28.0	0,09 0.004	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR28W			■				16NL28W	■
-	20.0-20.0	0,14 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR20W			■		■		16NL20W	■
-	19.0-19.0	0,15 0.006	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR19W	■		■		■		16NL19W	■
-	16.0-16.0	0,2 0.008	0,8 0.031	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16NR16W			■		■		16NL16W	■
-	14.0-14.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR14W	■		■		■		16NL14W	■
-	12.0-12.0	0,24 0.009	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR12W			■		■		16NL12W	■
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11W	■		■		■		16NL11W	■
-	10.0-10.0	0,27 0.011	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR10W	■		■		■		16NL10W	■
-	9.0-9.0	0,31 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR9W			■		■		16NL9W	■
-	8.0-8.0	0,42 0.017	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR8W			■		■		16NL8W	■
-	7.0-7.0	0,43 0.017	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR7W			■				22NL7W	■
-	6.0-6.0	0,5 0.020	1,8 0.071	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR6W			■		■		22NL6W	■
-	5.0-5.0	0,63 0.025	1,7 0.067	2,5 0.098	12,7 0.500	22,0 0.866	4,71 0.185	22NR5W			■		■		22NL5W	■
-	19.0-19.0	0,15 0.006	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR19W-A			■	■				
-	14.0-14.0	0,24 0.009	0,7 0.028	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR14W-A			■	■				
-	14.0-14.0	0,23 0.009	1,2 0.047	1,1 0.043	9,525 0.375	16,5 0.650	3,47 0.137	16NR14W-A			■	■				
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11W-A			■	■				
-	19.0-19.0	0,15 0.006	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR19W-A1			■					

Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	14.0-14.0	0,24 0.009	0,7 0.028	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR14W-A1			■					
-	14.0-14.0	0,23 0.009	1,2 0.047	1,1 0.043	9,525 0.375	16,5 0.650	3,47 0.137	16NR14W-A1			■					
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11W-A1			■					
-	19.0-19.0	0,15 0.006	0,8 0.031	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR19W-A2			■					
-	14.0-14.0	0,24 0.009	0,7 0.028	0,9 0.035	6,35 0.250	11,0 0.433	3,0 0.118	11NR14W-A2			■					
-	14.0-14.0	0,23 0.009	1,2 0.047	1,1 0.043	9,525 0.375	16,5 0.650	3,47 0.137	16NR14W-A2			■					
-	11.0-11.0	0,3 0.012	1,2 0.047	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11W-A2			■					
-	14.0-14.0	0,23 0.009	1,5 0.059	2,2 0.087	9,525 0.375	16,5 0.650	3,47 0.137	16NR14W-TT			■					
-	11.0-11.0	0,31 0.012	1,8 0.071	2,8 0.110	9,525 0.375	16,5 0.650	3,47 0.137	16NR11W-TT			■					
-	12.0-12.0	0,24 0.009	1,7 0.067	2,7 0.106	9,525 0.375	16,5 0.650	3,47 0.137	16NR12W-TT			■					
-	11.0-11.0	0,3 0.012	2,3 0.091	3,5 0.138	12,7 0.500	22,0 0.866	4,71 0.185	22NR11W2M			■					

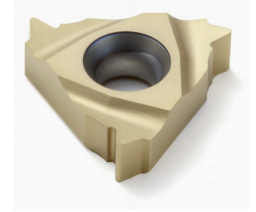
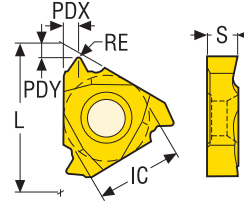
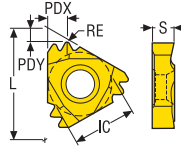
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# BSPT – External Threading

Snap-Tap®



ISO228/1 35 21 1959 ISO7/1



16ER..TT



16Ex..

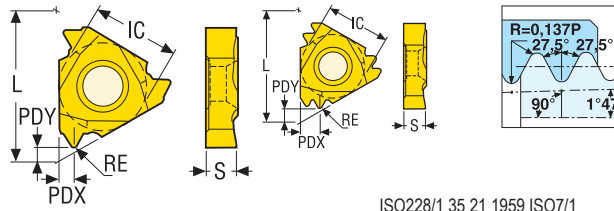
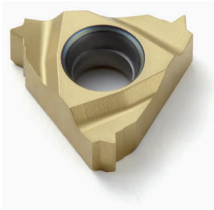


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	28.0-28.0	0,08 <i>0.003</i>	0,7 <i>0.028</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER28BSPT			■					
-	19.0-19.0	0,15 <i>0.006</i>	0,8 <i>0.031</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER19BSPT			■					
-	14.0-14.0	0,24 <i>0.009</i>	1,2 <i>0.047</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER14BSPT			■			16EL14BSPT		■
-	11.0-11.0	0,3 <i>0.012</i>	1,2 <i>0.047</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER11BSPT			■			16EL11BSPT		■
-	14.0-14.0	0,24 <i>0.009</i>	1,5 <i>0.059</i>	2,2 <i>0.087</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER14BSPT-TT			■					
-	11.0-11.0	0,3 <i>0.012</i>	1,8 <i>0.071</i>	2,8 <i>0.110</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER11BSPT-TT			■					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## BSPT – Internal Threading

Snap-Tap®



ISO228/1 35 21 1959 ISO7/1

09NR/16Nx..



16NR..TT



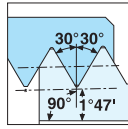
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	19.0-19.0	0,15 <i>0.006</i>	0,8 <i>0.031</i>	0,8 <i>0.031</i>	5,56 <i>0.219</i>	9,6 <i>0.378</i>	2,4 <i>0.094</i>	09NR19BSPT			■					
-	14.0-14.0	0,24 <i>0.009</i>	1,2 <i>0.047</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR14BSPT			■				16NL14BSPT	■
-	11.0-11.0	0,3 <i>0.012</i>	1,2 <i>0.047</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR11BSPT			■				16NL11BSPT	■
-	14.0-14.0	0,24 <i>0.009</i>	1,5 <i>0.059</i>	2,2 <i>0.087</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR14BSPT-TT			■					
-	11.0-11.0	0,3 <i>0.012</i>	1,8 <i>0.071</i>	2,8 <i>0.110</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR11BSPT-TT			■					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

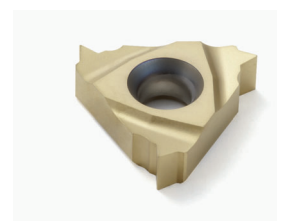
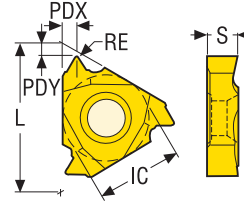
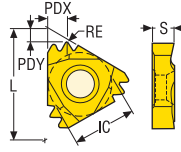


# NPT- External Threading

Snap-Tap®



ANSI B1.20.1 - 1983



16ER..A1



16ER..A2



16Ex..



22ER/27ER..M

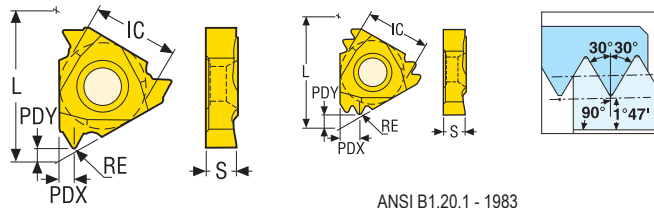


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	27.0-27.0	0,04 0.002	0,7 0.028	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER27NPT			■					
-	18.0-18.0	0,06 0.002	0,7 0.028	0,8 0.031	9,525 0.375	16,5 0.650	3,47 0.137	16ER18NPT			■		■	16EL18NPT		■
-	14.0-14.0	0,07 0.003	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER14NPT			■		■	16EL14NPT		■
-	11.5-11.5	0,07 0.003	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11.5NPT			■		■	16EL11.5NPT		■
-	8.0-8.0	0,07 0.003	1,1 0.043	1,6 0.063	9,525 0.375	16,5 0.650	3,47 0.137	16ER8NPT			■		■	16EL8NPT		■
-	11.5-11.5	0,09 0.004	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11.5NPT-A1			■					
-	11.5-11.5	0,09 0.004	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16ER11.5NPT-A2			■					
-	11.5-11.5	0,07 0.003	2,1 0.083	3,3 0.130	12,7 0.500	22,0 0.866	4,71 0.185	22ER11.5NPT2M			■					
-	8.0-8.0	0,07 0.003	3,0 0.118	4,8 0.189	15,875 0.625	27,0 1.063	6,15 0.242	27ER8NPT2M			■					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## NPT – Internal Threading

Snap-Tap®



ANSI B1.20.1 - 1983

09NR/11NR/16Nx



16NR..A1



16NR..A2



22NR..M

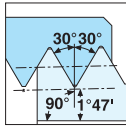


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	27.0-27.0	0,04 0.002	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR27NPT			■					
-	18.0-18.0	0,06 0.002	0,7 0.028	0,8 0.031	5,56 0.219	9,6 0.378	2,4 0.094	09NR18NPT			■					
-	18.0-18.0	0,06 0.002	0,7 0.028	0,8 0.031	6,35 0.250	11,0 0.433	3,0 0.118	11NR18NPT			■					
-	14.0-14.0	0,07 0.003	0,7 0.028	1,0 0.039	6,35 0.250	11,0 0.433	3,0 0.118	11NR14NPT			■					
-	14.0-14.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR14NPT			■		■		16NL14NPT	■
-	11.5-11.5	0,09 0.004	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11.5NPT			■		■		16NL11.5NPT	■
-	8.0-8.0	0,1 0.004	1,1 0.043	1,6 0.063	9,525 0.375	16,5 0.650	3,47 0.137	16NR8NPT			■		■		16NL8NPT	■
-	11.5-11.5	0,1 0.004	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11.5NPT-A1			■					
-	14.0-14.0	0,08 0.003	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR14NPT-A2			■					
-	11.5-11.5	0,1 0.004	1,1 0.043	1,5 0.059	9,525 0.375	16,5 0.650	3,47 0.137	16NR11.5NPT-A2			■					
-	8.0-8.0	0,12 0.005	1,1 0.043	1,6 0.063	9,525 0.375	16,5 0.650	3,47 0.137	16NR8NPT-A2			■					
-	11.5-11.5	0,05 0.002	2,1 0.083	3,3 0.130	12,7 0.500	22,0 0.866	4,71 0.185	22NR11.5NPT2M			■					

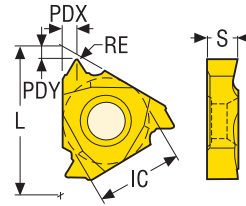
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# NPTF- External Threading

Snap-Tap®



ANSI B1.4 - 1976  
ANSI B1.20.3 - 1976



16ER..

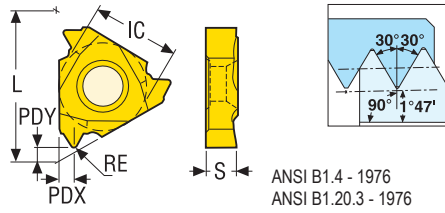
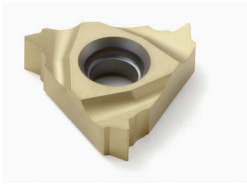


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	27.0-27.0	0,04 <i>0.002</i>	0,7 <i>0.028</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER27NPTF			■					
-	18.0-18.0	0,04 <i>0.002</i>	0,7 <i>0.028</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER18NPTF			■					
-	14.0-14.0	0,05 <i>0.002</i>	1,1 <i>0.043</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER14NPTF			■					
-	11.5-11.5	0,06 <i>0.002</i>	1,1 <i>0.043</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER11.5NPTF			■					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## NPTF – Internal Threading

Snap-Tap®



11NR/16Nx

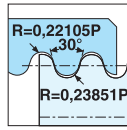


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	18.0-18.0	0,04 <i>0.002</i>	0,7 <i>0.028</i>	0,8 <i>0.031</i>	6,35 <i>0.250</i>	11,0 <i>0.433</i>	3,0 <i>0.118</i>	11NR18NPTF		■						
-	14.0-14.0	0,05 <i>0.002</i>	1,1 <i>0.043</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR14NPTF		■						
-	11.5-11.5	0,06 <i>0.002</i>	1,1 <i>0.043</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR11.5NPTF		■					16NL11.5NPTF	■

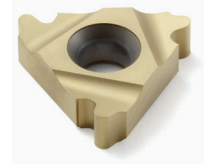
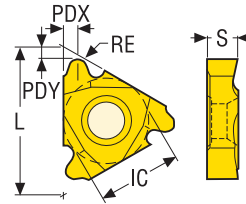
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Round-DIN405 – External Threading

Snap-Tap®



DIN405 - 1981  
7h/6h



16ER/22Ex/27ER

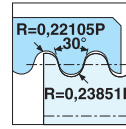
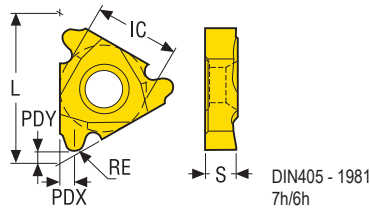


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	10.0-10.0	0,58 <i>0.023</i>	1,3 <i>0.051</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER10RD			■					
-	8.0-8.0	0,73 <i>0.029</i>	1,3 <i>0.051</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER8RD			■					
-	6.0-6.0	0,97 <i>0.038</i>	1,3 <i>0.051</i>	1,8 <i>0.071</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER6RD			■					
-	6.0-6.0	0,97 <i>0.038</i>	2,0 <i>0.079</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	22ER6RD			■			22EL6RD		■
-	4.0-4.0	1,46 <i>0.057</i>	2,2 <i>0.087</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	27ER4RD			■					

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Round-DIN405 – Internal Threading

Snap-Tap®



16NR/22Nx/27NR

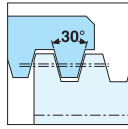


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
-	10.0-10.0	0,51 <i>0.020</i>	1,3 <i>0.051</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR10RD			■					
-	8.0-8.0	0,69 <i>0.027</i>	1,3 <i>0.051</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR8RD			■					
-	6.0-6.0	0,87 <i>0.034</i>	1,3 <i>0.051</i>	1,8 <i>0.071</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR6RD			■					
-	6.0-6.0	0,87 <i>0.034</i>	2,0 <i>0.079</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	22NR6RD			■			22NL6RD		■
-	4.0-4.0	1,31 <i>0.052</i>	2,2 <i>0.087</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	27NR4RD			■					

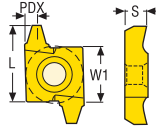
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

TR-DIN103 – External Threading

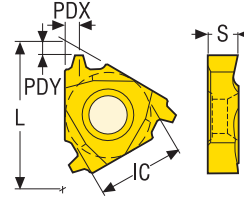
Snap-Tap®



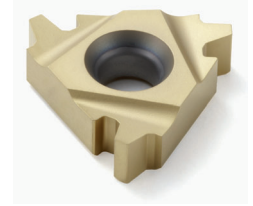
DIN103 - 1977  
ISO2901/3 - 1977  
7e



16Ex/22Ex27ER



20ER/26ER

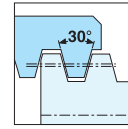
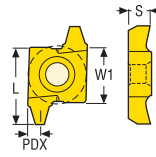
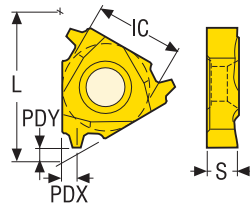
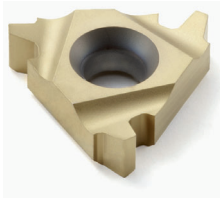


Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP500 Coated
1,5-1,5	-	-	0,9 0.035	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16ER1.5TR			■			16EL1.5TR	■
2,0-2,0	-	-	1,3 0.051	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ER2.0TR			■			16EL2.0TR	■
3,0-3,0	-	-	1,3 0.051	1,6 0.063	9,525 0.375	-	16,5 0.650	3,47 0.137	16ER3.0TR			■			16EL3.0TR	■
4,0-4,0	-	-	2,0 0.079	2,5 0.098	12,7 0.500	-	22,0 0.866	4,71 0.185	22ER4.0TR			■			22EL4.0TR	■
5,0-5,0	-	-	2,0 0.079	2,3 0.091	12,7 0.500	-	22,0 0.866	4,71 0.185	22ER5.0TR		■	■			22EL5.0TR	■
6,0-6,0	-	-	2,5 0.098	3,2 0.126	15,875 0.625	-	27,0 1.063	6,15 0.242	27ER6.0TR			■				
7,0-7,0	-	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20ER7.0TR		■	■				
8,0-8,0	-	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20ER8.0TR		■	■				
9,0-9,0	-	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26ER9.0TR			■				
10,0-10,0	-	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26ER10.0TR		■	■				
12,0-12,0	-	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26ER12.0TR		■	■				
14,0-14,0	-	-	-	5,1 0.201	-	15,875 0.625	26,0 1.024	7,88 0.310	26ER14.0TR			■				

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## TR-DIN103 – Internal Threading

Snap-Tap®



DIN103 - 1977  
ISO2901/3 - 1977  
7H

16Nx/22Nx/27NR



20NR/26NR



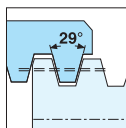
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		
1,5-1,5	-	-	0,9 0.035	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR1.5TR			■			16NL1.5TR	■
2,0-2,0	-	-	1,3 0.051	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR2.0TR			■			16NL2.0TR	■
3,0-3,0	-	-	1,3 0.051	1,6 0.063	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR3.0TR			■			16NL3.0TR	■
4,0-4,0	-	-	2,0 0.079	2,5 0.098	12,7 0.500	-	22,0 0.866	4,71 0.185	22NR4.0TR			■			22NL4.0TR	■
5,0-5,0	-	-	2,0 0.079	2,3 0.091	12,7 0.500	-	22,0 0.866	4,71 0.185	22NR5.0TR			■			22NL5.0TR	■
6,0-6,0	-	-	2,5 0.098	3,2 0.126	15,875 0.625	-	27,0 1.063	6,15 0.242	27NR6.0TR			■				
7,0-7,0	-	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20NR7.0TR		■	■				
8,0-8,0	-	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20NR8.0TR		■	■				
9,0-9,0	-	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26NR9.0TR			■				
10,0-10,0	-	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26NR10.0TR		■	■				
12,0-12,0	-	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26NR12.0TR		■	■				
14,0-14,0	-	-	-	5,1 0.201	-	15,875 0.625	26,0 1.024	7,88 0.310	26NR14.0TR			■				

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store



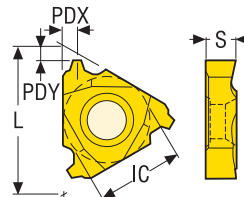
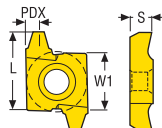
# ACME – External Threading

Snap-Tap®

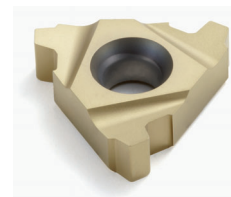


ANSI B1.5 - 1988  
3G

16Ex/22Ex/27Ex



20ER/26ER

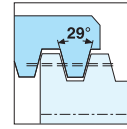
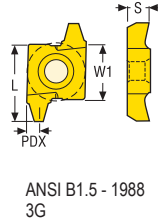
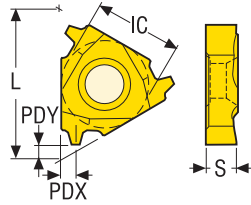
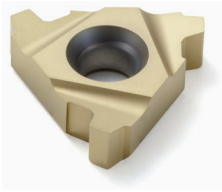


Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP500 Coated
-	16.0-16.0	-	0,9 <i>0.035</i>	0,8 <i>0.031</i>	9,525 <i>0.375</i>	-	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER16ACME			■				
-	14.0-14.0	-	1,3 <i>0.051</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	-	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER14ACME			■				
-	12.0-12.0	-	1,3 <i>0.051</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	-	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER12ACME			■				
-	10.0-10.0	-	1,4 <i>0.055</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	-	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER10ACME			■			16EL10ACME	■
-	8.0-8.0	-	1,3 <i>0.051</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	-	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER8ACME			■			16EL8ACME	■
-	6.0-6.0	-	2,0 <i>0.079</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	-	22,0 <i>0.866</i>	4,71 <i>0.185</i>	22ER6ACME			■			22EL6ACME	■
-	5.0-5.0	-	2,0 <i>0.079</i>	2,3 <i>0.091</i>	12,7 <i>0.500</i>	-	22,0 <i>0.866</i>	4,71 <i>0.185</i>	22ER5ACME			■			22EL5ACME	■
-	4.0-4.0	-	2,5 <i>0.098</i>	3,0 <i>0.118</i>	15,875 <i>0.625</i>	-	27,0 <i>1.063</i>	6,15 <i>0.242</i>	27ER4ACME			■			27EL4ACME	■
-	3.5-3.5	-	-	3,2 <i>0.126</i>	12,7 <i>0.500</i>	12,7 <i>0.500</i>	20,0 <i>0.787</i>	6,3 <i>0.248</i>	20ER3.5ACME			■				
-	3.0-3.0	-	-	3,2 <i>0.126</i>	-	12,7 <i>0.500</i>	20,0 <i>0.787</i>	6,3 <i>0.248</i>	20ER3ACME		■	■				
-	2.0-2.0	-	-	5,0 <i>0.197</i>	-	15,875 <i>0.625</i>	26,0 <i>1.024</i>	7,88 <i>0.310</i>	26ER2ACME		■	■				

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## ACME – Internal Threading

Snap-Tap®



ANSI B1.5 - 1988  
3G

16NR/22Nx/27NR



20NR/26NR

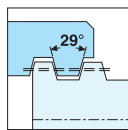


Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP500 Coated
-	16.0-16.0	-	0,9 0.035	0,8 0.031	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR16ACME			■				
-	12.0-12.0	-	1,3 0.051	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR12ACME			■				
-	10.0-10.0	-	1,3 0.051	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR10ACME			■				
-	8.0-8.0	-	1,3 0.051	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR8ACME			■				
-	6.0-6.0	-	2,0 0.079	2,5 0.098	12,7 0.500	-	22,0 0.866	4,71 0.185	22NR6ACME		■	■				
-	5.0-5.0	-	2,0 0.079	2,3 0.091	12,7 0.500	-	22,0 0.866	4,71 0.185	22NR5ACME			■			22NL5ACME	■
-	4.0-4.0	-	2,5 0.098	3,0 0.118	15,875 0.625	-	27,0 1.063	6,15 0.242	27NR4ACME		■	■				
-	3.5-3.5	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20NR3.5ACME		■	■				
-	3.0-3.0	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20NR3ACME		■	■				
-	2.0-2.0	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26NR2ACME		■					

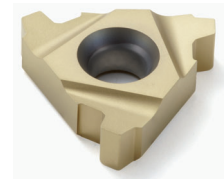
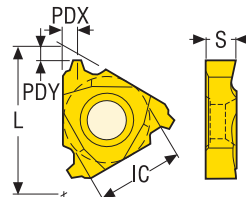
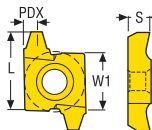
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# Stub-ACME – External Threading

Snap-Tap®



ANSI B1.8 - 1988  
2G



16ER



16ER/22Ex/27ER



20ER/26ER

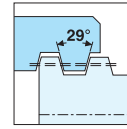
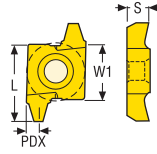
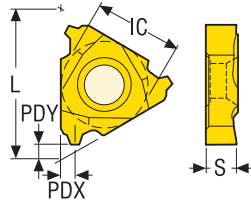
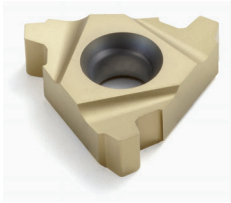


Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP500 Coated
-	14.0-14.0	-	1,3 0.051	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ER14STACME			■				
-	12.0-12.0	-	1,5 0.059	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ER12STACME			■				
-	10.0-10.0	-	1,5 0.059	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ER10STACME			■				
-	8.0-8.0	-	1,8 0.071	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16ER8STACME		■	■				
-	6.0-6.0	-	2,4 0.094	2,5 0.098	12,7 0.500	-	22,0 0.866	4,71 0.185	22ER6STACME			■			22EL6STACME	■
-	5.0-5.0	-	2,0 0.079	2,1 0.083	12,7 0.500	-	22,0 0.866	4,71 0.185	22ER5STACME			■				
-	4.0-4.0	-	2,6 0.102	2,8 0.110	15,875 0.625	-	27,0 1.063	6,15 0.242	27ER4STACME		■	■				
-	3.0-3.0	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20ER3STACME			■				
-	2.0-2.0	-	-	5,0 0.197	-	15,875 0.625	26,0 1.024	7,88 0.310	26ER2STACME			■				

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Stub-ACME – Internal Threading

Snap-Tap®



ANSI B1.8 - 1988  
2G

16NR



16NR/22NR/27NR



20NR

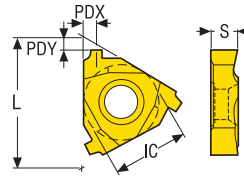
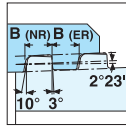


Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		
-	14.0-14.0	-	1,3 0.051	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR14STACME			■				
-	12.0-12.0	-	1,5 0.059	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR12STACME			■				
-	10.0-10.0	-	1,5 0.059	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR10STACME			■				
-	8.0-8.0	-	1,8 0.071	1,5 0.059	9,525 0.375	-	16,5 0.650	3,47 0.137	16NR8STACME		■	■				
-	6.0-6.0	-	2,4 0.094	2,5 0.098	12,7 0.500	-	22,0 0.866	4,71 0.185	22NR6STACME			■				
-	5.0-5.0	-	2,0 0.079	2,1 0.083	12,7 0.500	-	22,0 0.866	4,71 0.185	22NR5STACME			■				
-	4.0-4.0	-	2,6 0.102	2,8 0.110	15,875 0.625	-	27,0 1.063	6,15 0.242	27NR4STACME		■	■				
-	3.0-3.0	-	-	3,2 0.126	-	12,7 0.500	20,0 0.787	6,3 0.248	20NR3STACME			■				

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# AMERICAN API BUTTRESS 1:12 Taper - External Threading

Snap-Tap®



API spec. 5B - 1988

Crest and root are parallel to axis

16ER

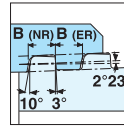
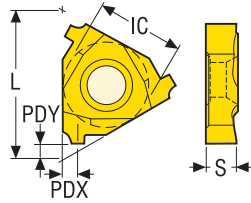
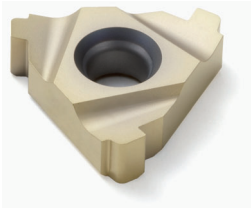


Pitch		PDY	PDX	IC	L	S	Designation	Grades			
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated
-	12.0	2,0 <i>0.079</i>	1,3 <i>0.051</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER12ASB45/7			■	

■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## AMERICAN API BUTTRESS 1:12 Taper - Internal Threading

Snap-Tap®



API spec. 5B - 1988

Crest and root are parallel to axis

16NR

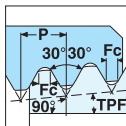


Pitch		PDY	PDX	IC	L	S	Designation	Grades			
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated
-	12.0	2,0 <i>0.079</i>	1,3 <i>0.051</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR12ASB45/7				■

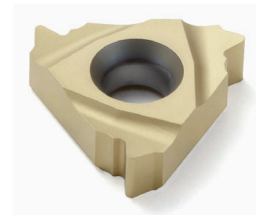
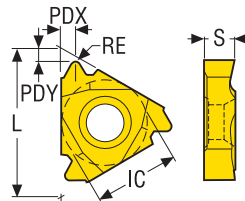
■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## API Rotary Drilling connection - External threading

Snap-Tap®



API spec. 7 - 1998



22ER/27ER

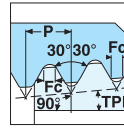
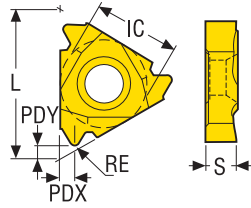


Pitch		RE	PDY	PDX	IC	L	S	API-CODE	TGTPF	Designation	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>				TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	5.0	0,508 <i>0.020</i>	2,0 <i>0.079</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	V040	3	22ER5API404		■	■		
-	4.0	0,965 <i>0.038</i>	1,95 <i>0.077</i>	2,55 <i>0.100</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	V038R	2	22ER4API386		■	■		
-	5.0	0,508 <i>0.020</i>	2,2 <i>0.087</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	V040	3	27ER5API404		■	■		
-	4.0	0,965 <i>0.038</i>	2,2 <i>0.087</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	V038R	3	27ER4API384	■			■	
-	4.0	0,965 <i>0.038</i>	2,2 <i>0.087</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	V038R	2	27ER4API386	■	■	■		
-	4.0	0,635 <i>0.025</i>	2,2 <i>0.087</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	V050	3	27ER4API504	■	■	■		
-	4.0	0,635 <i>0.025</i>	2,2 <i>0.087</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	V050	2	27ER4API506	■	■	■		

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## API Rotary Drilling connection - Internal threading

Snap-Tap®



API spec. 7 - 1998

22NR/27NR



Pitch		RE	PDY	PDX	IC	L	S	API-CODE	TGTPF	Designation	Grades				
mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch				TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	5.0	0.508 0.020	2.0 0.079	2.5 0.098	12.7 0.500	22.0 0.866	4.71 0.185	V040	3	22NR5API404		■	■		
-	4.0	0.965 0.038	1.9 0.075	2.5 0.098	12.7 0.500	22.0 0.866	4.71 0.185	V038R	2	22NR4API386		■	■		■
-	5.0	0.508 0.020	2.2 0.087	3.2 0.126	15.875 0.625	27.0 1.063	6.15 0.242	V040	3	27NR5API404		■			
-	4.0	0.965 0.038	2.2 0.087	3.2 0.126	15.875 0.625	27.0 1.063	6.15 0.242	V038R	3	27NR4API384	■		■		
-	4.0	0.965 0.038	2.2 0.087	3.2 0.126	15.875 0.625	27.0 1.063	6.15 0.242	V038R	2	27NR4API386	■	■	■		
-	4.0	0.635 0.025	2.2 0.087	3.2 0.126	15.875 0.625	27.0 1.063	6.15 0.242	V050	3	27NR4API504	■	■	■		
-	4.0	0.635 0.025	2.2 0.087	3.2 0.126	15.875 0.625	27.0 1.063	6.15 0.242	V050	2	27NR4API506	■	■	■		

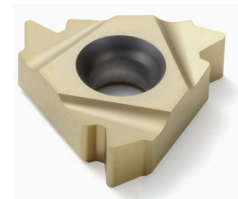
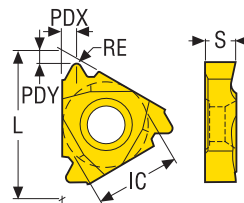
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store



## Rotary drill connection - External threading

Snap-Tap®

HEF = Hughes External Flush,  
904/906 = Hughes H90,  
H90 = Hughes Slimline H90,  
PAC = P.A.C.



904/906



H90



HEF



PAC

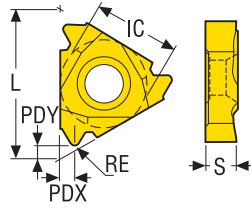
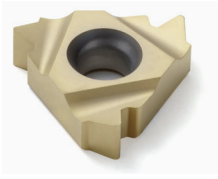


Pitch		PDY	PDX	IC	L	S	APICODE	TGTPF	Designation	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>				TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	6.0	2,0 <i>0.079</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>		2	22ER6HEF			■		
-	3.5	2,7 <i>0.106</i>	3,5 <i>0.138</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	90V050	3	27ER3.5H904			■		
-	3.5	2,7 <i>0.106</i>	3,5 <i>0.138</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	90V050	2	27ER3.5H906			■		
-	3.0	3,5 <i>0.138</i>	3,6 <i>0.142</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	90V050	1,25	27ER3H90			■		
-	4.0	2,4 <i>0.094</i>	2,63 <i>0.104</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	V076	1,5	22ER4PAC			■		
-	4.0	2,75 <i>0.108</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	V076	1,5	27ER4PAC			■		

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Rotary drill connection - Internal threading

Snap-Tap®



HEF = Hughes External Flush,  
904/906 = Hughes H90,  
H90 = Hughes Slimline H90,  
PAC = P.A.C.

904/906



H90



HEF



PAC

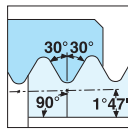


Pitch		PDY	PDX	IC	L	S	APICODE	TGTPF	Designation	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>				TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	6.0	2,0 <i>0.079</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>		2	22NR6HEF			■		
-	3.5	2,7 <i>0.106</i>	3,5 <i>0.138</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	90V050	3	27NR3.5H904			■		
-	3.5	2,7 <i>0.106</i>	3,5 <i>0.138</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	90V050	2	27NR3.5H906			■		
-	3.0	3,5 <i>0.138</i>	3,6 <i>0.142</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	90V050	1,25	27NR3H90			■		
-	4.0	2,4 <i>0.094</i>	2,6 <i>0.102</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	V076	1,5	22NR4PAC			■		
-	4.0	2,75 <i>0.108</i>	3,2 <i>0.126</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	V076	1,5	27NR4PAC			■		

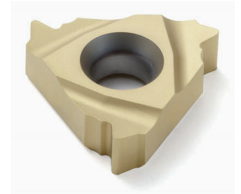
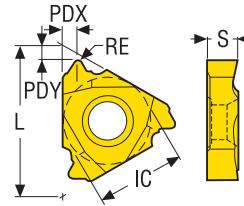
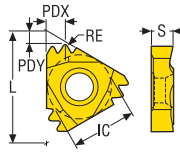
■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## API Spec. 5B ROUND - External Threading

Snap-Tap®



API spec. 5B - 1988



16ER



22ER/27ER.M

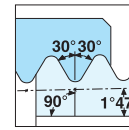
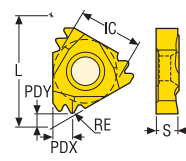
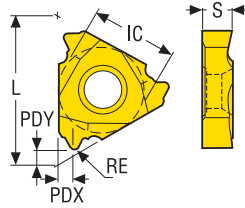
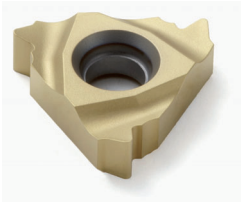


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated
-	10.0-10.0	0,38 <i>0.015</i>	1,5 <i>0.059</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER10APIRD			■		
-	8.0-8.0	0,46 <i>0.018</i>	1,5 <i>0.059</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16ER8APIRD			■		
-	10.0-10.0	0,38 <i>0.015</i>	2,4 <i>0.094</i>	3,7 <i>0.146</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	22ER10APIRD2M			■		
-	8.0-8.0	0,46 <i>0.018</i>	2,9 <i>0.114</i>	4,5 <i>0.177</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	27ER8APIRD2M		■			

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## API Spec. 5B ROUND - Internal Threading

Snap-Tap®



API spec. 5B - 1988

16NR



27NR..M

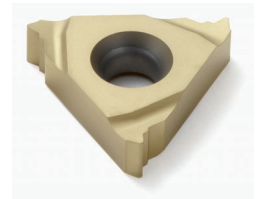
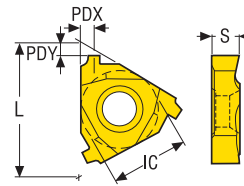
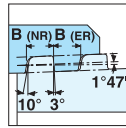


Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated
-	10.0-10.0	0,38 <i>0.015</i>	1,5 <i>0.059</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR10APIRD			■		
-	8.0-8.0	0,46 <i>0.018</i>	1,5 <i>0.059</i>	1,5 <i>0.059</i>	9,525 <i>0.375</i>	16,5 <i>0.650</i>	3,47 <i>0.137</i>	16NR8APIRD			■		
-	8.0-8.0	0,46 <i>0.018</i>	2,9 <i>0.114</i>	4,5 <i>0.177</i>	15,875 <i>0.625</i>	27,0 <i>1.063</i>	6,15 <i>0.242</i>	27NR8APIRD2M		■			

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# API 5B BUTTRESS, VAM BUTTRESS 1:16 Taper - External Threading

Snap-Tap®



Vallourec ST-D453.02  
API spec. 5B - 1988

Crest and root are parallel to taper

22ER

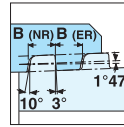
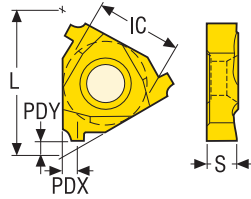
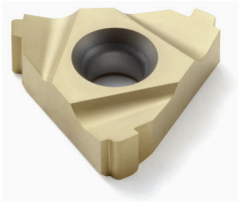


Pitch		PDY	PDX	IC	L	S	TGTPF	Designation	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>			TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	5.0	2,2 <i>0.087</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	3/4"	22ER5BUT2.5				■	
-	6.0	2,2 <i>0.087</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	3/4"	22ER6VAM				■	

■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## API 5B BUTTRESS, VAM BUTTRESS 1:16 Taper - Internal Threading

Snap-Tap®



Vallourec ST-D453.02  
API spec. 5B - 1988

Crest and root are parallel to taper

22NR

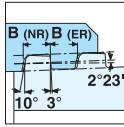


Pitch		PDY	PDX	IC	L	S	TGTPF	Designation	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>			TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	5.0	2,0 <i>0.079</i>	2,1 <i>0.083</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	3/4"	22NR5BUT2.5		■		■	
-	6.0	2,0 <i>0.079</i>	2,0 <i>0.079</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	3/4"	22NR6VAM		■		■	
-	5.0	2,0 <i>0.079</i>	2,0 <i>0.079</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	3/4"	22NR5VAM				■	

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

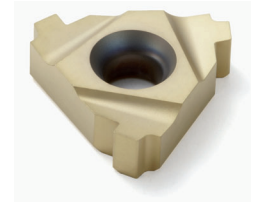
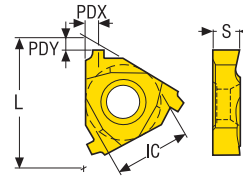
# API BUTTRESS 1:12 Taper - External Threading

Snap-Tap®



API spec. 5B - 1988

Crest and root are parallel to axis



22ER

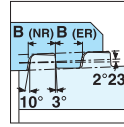
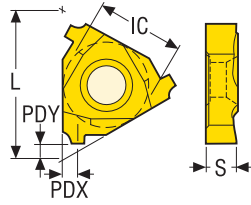
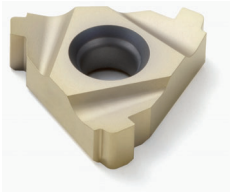


Pitch		PDY	PDX	IC	L	S	TGTPF	Designation	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>			TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	5.0	2,2 <i>0.087</i>	2,5 <i>0.098</i>	12,7 <i>0.500</i>	22,0 <i>0.866</i>	4,71 <i>0.185</i>	1	22ER5BUT2.6			■		

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## API BUTTRESS 1:12 Taper - Internal Threading

Snap-Tap®



API spec. 5B - 1988

Crest and root are parallel to axis

22NR

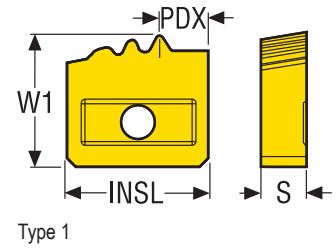
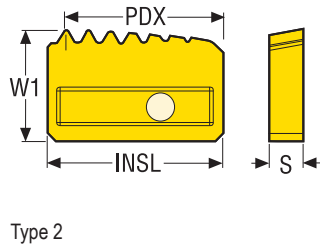
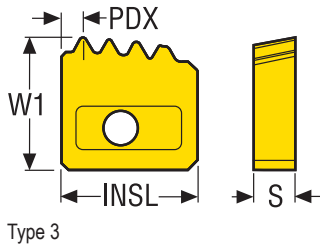


Pitch		PDY	PDX	IC	L	S	TGTPF	Designation	Grades				
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>			TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	TTP2050 Coated	H15 Uncoated
-	5.0	2.0 <i>0.079</i>	2.1 <i>0.083</i>	12.7 <i>0.500</i>	22.0 <i>0.866</i>	4.71 <i>0.185</i>	1	22NR5BUT2.6			■		

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store



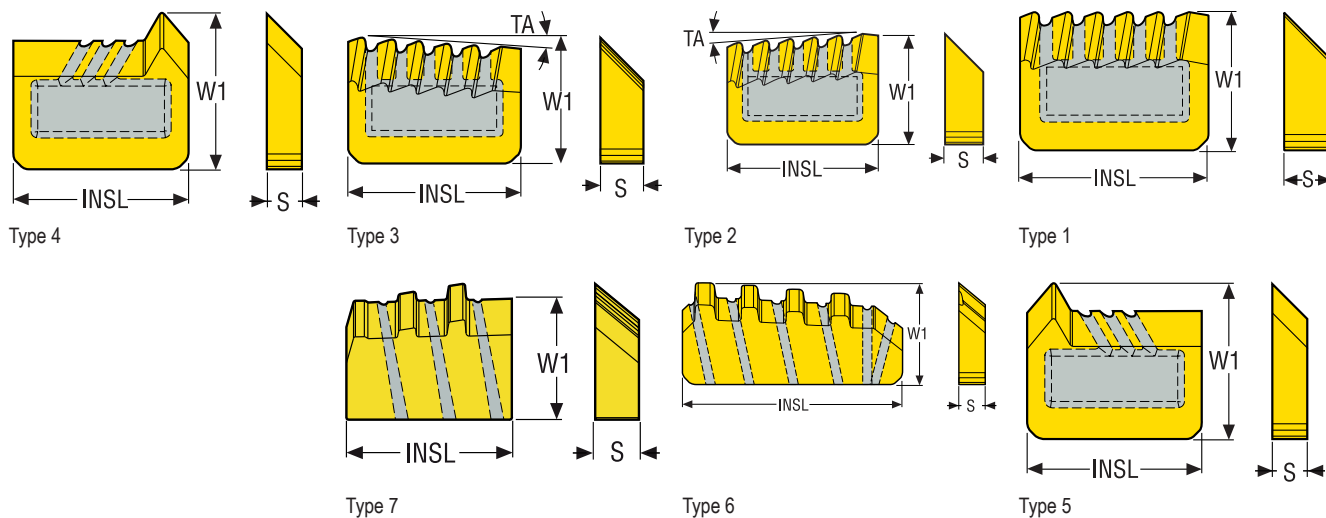
Chasers



Pitch	INSL	W1	PDX	S	NT	Int./Ext.	Type	Designation	Thread Form Product	CHF1	Grades		
											CP250T Coated	CP500T Coated	TP150T Coated
8.0	15,875 – Inch	15,875 0.625 Inch	5,6 0.220 Inch	4,76 0.187 Inch	3	External	1	8-1116	API_RD_CAS_8TPI_EXT,	C-1005-4	■		
8.0	15,875 – Inch	15,875 0.625 Inch	2,5 0.098 Inch	4,76 0.187 Inch	4	Internal	3	8-1128	API_RD_8TPI_INT,	C-1002-96	■		
8.0	25,0 – Inch	15,875 0.625 Inch	2,5 0.098 Inch	5,0 0.197 Inch	7	Internal	3	8-5111	API_RD_8TPI_INT	C-5002-96	■		
8.0	20,0 – Inch	15,875 0.625 Inch	10,19 0.401 Inch	4,76 0.187 Inch	3	External	1	8-4133-1	API_RD_8TPI_EXT_CASING_1	C-4003-4	■		
8.0	20,0 – Inch	15,875 0.625 Inch	8,6 0.339 Inch	4,76 0.187 Inch	3	External	1	8-4133-2	API_RD_8TPI_EXT_CASING_2	C-4003-4	■		
8.0	16,0 – Inch	14,62 0.576 Inch	7,697 0.303 Inch	5,2 0.205 Inch	3	External	1	8-2115-1	API_RD_8TPI_CAS_3/4_TPF_PMC_1	–	■		
8.0	16,0 – Inch	14,87 0.585 Inch	6,638 0.261 Inch	5,2 0.205 Inch	3	External	1	8-2115-2	API_RD_8TPI_CAS_3/4_TPF_PMC_2	–	■		
8.0	16,0 – Inch	15,0 0.591 Inch	5,58 0.220 Inch	5,2 0.205 Inch	3	External	1	8-2115-3	API_RD_8TPI_CAS_3/4_TPF_PMC_3	–	■		
8.0	15,875 – Inch	15,875 0.625 Inch	5,6 0.220 Inch	4,76 0.187 Inch	3	External	1	8-1117	API_RD_TUBING_8TPI_EXT,	C-1005-4	■		
8.0	16,0 – Inch	14,62 0.576 Inch	7,697 0.303 Inch	5,2 0.205 Inch	3	External	1	8-2118-1	API_RD_8TPI_TUB_3/4_TPF_PMC_1	–	■		
8.0	16,0 – Inch	14,87 0.585 Inch	6,638 0.261 Inch	5,2 0.205 Inch	3	External	1	8-2118-2	API_RD_8TPI_TUB_3/4_TPF_PMC_2	–	■		
8.0	16,0 – Inch	15,0 0.591 Inch	5,58 0.220 Inch	5,2 0.205 Inch	3	External	1	8-2118-3	API_RD_8TPI_TUB_3/4_TPF_PMC_3	–	■		
10.0	15,875 – Inch	15,875 0.625 Inch	5,0 0.197 Inch	4,76 0.187 Inch	4	Internal	3	10-1120	API_RD_10TPI_TUB_INT	C-1001-96	■		
10.0	15,875 – Inch	15,875 0.625 Inch	4,4 0.173 Inch	4,76 0.187 Inch	3	External	1	10-1133-2	API_RD_10TPI_TUB_EXT_2	C-1001-4	■		
5.0	15,875 – Inch	15,875 0.625 Inch	2,1 0.083 Inch	4,76 0.187 Inch	3	External	1	5-1102	API_BUTTRESS_5TPI_1/16_EXT	C-1004-4	■		
5.0	25,0 – Inch	15,875 0.625 Inch	2,0 0.079 Inch	5,0 0.197 Inch	5	External	1	5-5102	API_BUTRESS_5_TPI_1/16_EXT,	C-5003-4	■	■	■
5.0	15,875 – Inch	15,875 0.625 Inch	2,5 0.098 Inch	4,76 0.187 Inch	3	Internal	3	5-1113	API_BUTTRESS_5TPI_1/16_INT,	C-1018-96	■		
5.0	25,0 – Inch	15,875 0.625 Inch	1,964 0.077 Inch	5,0 0.197 Inch	5	Internal	3	5-5112-C	API_BUTTRESS_5TPI_1/16_INT	C-5003-96	■	■	
5.0	25,0 – Inch	15,875 0.625 Inch	2,5 0.098 Inch	5,0 0.197 Inch	5	Internal	3	5-5108	API_BUTTRESS_5TPI_1/16_INT	C-5003-96	■		
5.0	15,875 – Inch	15,875 0.625 Inch	13,375 0.527 Inch	4,76 0.187 Inch	3	Internal	2	5-1134	API_BUTT_5TPI_CAS_1/16_INTPUL	C-1018-96	■		
5.0	25,0 – Inch	15,875 0.625 Inch	22,5 0.886 Inch	5,0 0.197 Inch	5	Internal	2	5-5110	API_BUTT_5TPI_1/16_INTPULLING	C-5003-96	■		
5.0	20,0 – Inch	15,692 0.618 Inch	4,84 0.191 Inch	4,76 0.187 Inch	3	External	1	5-4131-1	API_BUTTRESS_1/16_5TPI_EXT_1	C-4001-4	■		
5.0	20,0 – Inch	15,875 0.625 Inch	2,3 0.091 Inch	4,76 0.187 Inch	4	External	1	5-4131-2	API_BUTTRESS_1/16_5TPI_EXT_2	C-4001-4	■		
5.0	17,0 – Inch	14,57 0.574 Inch	5,552 0.219 Inch	4,76 0.187 Inch	3	External	1	5-3105-1	API_BUTTRESS_5TPI_1/16_PMC_1	C-3901-1	■		

Pitch	INSL	W1	PDX	S	NT	Int./Ext.	Type	Designation	Thread Form Product	CHF1	Grades		
TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>							CP250T Coated	CP500T Coated	TP150T Coated
5.0	17,0 –	14,825 0.584	3,858 0.152	4,76 0.187	3	External	1	5-3105-2	API_BUTTRESS_5TPI_1/16_PMC_2	C-3901-2	■		
5.0	17,0 –	14,98 0.590	2,165 0.085	4,76 0.187	3	External	1	5-3105-3	API_BUTTRESS_5TPI_1/16_PMC_3	C-3901-3	■		
8.0	25,0 –	15,875 0.625	22,5 0.886	5,0 0.197	7	Internal	2	8-5114	API_RD_8TPI_INTPULLING	C-5002-96	■		

Chipformers



Designation	Type	INSL		W1		S	
		mm	Inch	mm	Inch	mm	Inch
C-1001	1	15,7	0.618	11,5	0.453	3,97	0.156
C-1001-4	2	15,7	0.618	11,5	0.453	3,97	0.156
C-1001-96	3	15,7	0.618	11,5	0.453	3,97	0.156
C-1002	1	15,7	0.618	11,5	0.453	3,97	0.156
C-1002-4	2	15,7	0.618	11,5	0.453	3,97	0.156
C-1002-96	3	15,7	0.618	11,5	0.453	3,97	0.156
C-1003	1	15,7	0.618	11,5	0.453	3,97	0.156
C-1004	1	15,7	0.618	11,5	0.453	3,97	0.156
C-1004-4	2	15,7	0.618	11,5	0.453	3,97	0.156
C-1004-96	3	15,7	0.618	11,5	0.453	3,97	0.156
C-1005-4	2	15,7	0.618	11,5	0.453	3,97	0.156
C-1005-96	3	15,7	0.618	11,5	0.453	3,97	0.156
C-1006-4	2	15,7	0.618	11,5	0.453	3,97	0.156
C-1009	1	15,7	0.618	11,5	0.453	3,97	0.156
C-1009-4	1	15,7	0.618	11,5	0.453	3,97	0.156
C-1009-96	3	15,7	0.618	11,5	0.453	3,97	0.156
C-1010	1	15,7	0.618	11,5	0.453	3,97	0.156
C-1010-4	2	15,7	0.618	11,5	0.453	3,97	0.156
C-1010-96	3	15,7	0.618	11,5	0.453	3,97	0.156
C-1013-96	3	15,7	0.618	11,5	0.453	3,97	0.156

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Designation	Type	INSL		W1		S	
		mm Inch		mm Inch		mm Inch	
C-1018	1	15,7 0.618		11,5 0.453		3,97 0.156	
C-1018-96	3	15,7 0.618		11,5 0.453		3,97 0.156	
C-1021-96	3	15,7 0.618		11,5 0.453		3,97 0.156	
C-1022	4	15,7 0.618		11,5 0.453		3,18 0.125	
C-1023	5	15,7 0.618		11,5 0.453		3,18 0.125	
C-1024	4	15,7 0.618		11,5 0.453		3,97 0.156	
C-1025	5	15,7 0.618		11,5 0.453		3,97 0.156	
C-1032	5	15,7 0.618		11,5 0.453		3,18 0.125	
C-1033	4	15,7 0.618		11,5 0.453		3,18 0.125	
C-1034	5	15,7 0.618		11,5 0.453		3,18 0.125	
C-1035	4	15,7 0.618		11,5 0.453		3,18 0.125	
C-1601-96	3	15,7 0.618		12,5 0.492		3,97 0.156	
C-1604-4	2	15,7 0.618		12,5 0.492		3,97 0.156	
C-1X37-I-145	4	15,7 0.618		14,5 0.571		3,18 0.125	
C-1X38-I-145	5	15,7 0.618		14,5 0.571		3,18 0.125	
C-1X39-I-145	4	15,7 0.618		14,5 0.571		3,18 0.125	
C-1X40-I-145	5	15,7 0.618		14,5 0.571		3,18 0.125	
C-1X41-I-145	4	15,7 0.618		14,5 0.571		3,18 0.125	
C-1X42-I-145	5	15,7 0.618		14,5 0.571		3,18 0.125	
C-3901-1	7	16,9 0.665		13,9 0.547		4,47 0.176	
C-3901-2	7	16,9 0.665		14,0 0.551		4,47 0.176	
C-3901-3	7	16,9 0.665		14,2 0.559		4,47 0.176	
C-4001-4	2	19,8 0.780		11,5 0.453		3,97 0.156	
C-4003-4	2	19,8 0.780		11,5 0.453		3,97 0.156	
C-5001-4	2	24,8 0.976		11,5 0.453		3,97 0.156	
C-5001-96	3	24,8 0.976		11,5 0.453		3,97 0.156	
C-5002-4	2	24,8 0.976		11,5 0.453		3,97 0.156	
C-5002-96	3	24,8 0.976		11,5 0.453		3,97 0.156	
C-5003	1	24,8 0.976		11,5 0.453		3,97 0.156	
C-5003-4	2	24,8 0.976		11,5 0.453		3,97 0.156	

Designation	Type	INSL		W1		S	
		mm <i>Inch</i>		mm <i>Inch</i>		mm <i>Inch</i>	
C-5003-96	3	24,8 <i>0.976</i>		11,5 <i>0.453</i>		3,97 <i>0.156</i>	
C-5005	1	24,8 <i>0.976</i>		11,5 <i>0.453</i>		3,0 <i>0.118</i>	
C-5006	1	24,8 <i>0.976</i>		11,5 <i>0.453</i>		3,0 <i>0.118</i>	
C-5705-G	6	24,8 <i>0.976</i>		13,0 <i>0.512</i>		3,0 <i>0.118</i>	
C-5803-4	6	24,8 <i>0.976</i>		13,5 <i>0.531</i>		3,97 <i>0.156</i>	
C-5805-G	6	24,8 <i>0.976</i>		13,5 <i>0.531</i>		3,0 <i>0.118</i>	
C-5905-G	6	24,8 <i>0.976</i>		14,0 <i>0.551</i>		3,0 <i>0.118</i>	
C-9001-I	4	12,6 <i>0.496</i>		11,5 <i>0.453</i>		3,18 <i>0.125</i>	

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex



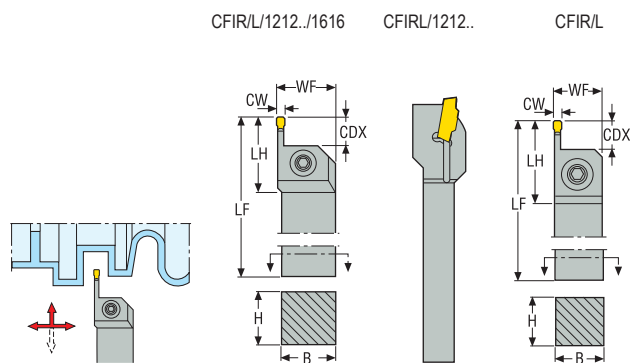
## Thread turning MDT

The highly stable and reliable Seco MDT (Multi-Directional Turning) system consists of holders and inserts that offers excellent performance in thread-turning operations. Products are available for both external and internal threads. Its unique clamping method is a combination of V-shaped top clamp and serrated contact surfaces between the underside of the insert and toolholder, resulting in superb stability.

- External and Internal threads
- Unique clamping method
- V-shaped top clamp secure stability

# Thread MDT – Toolholders, external

Toolholders for inserts LCGN



Right-hand version shown

- For inserts program, see catalog Turning
- $a_r = 3 \times a_p$



Designation	Item number	H	B	LF	WF	LH	CDX	Weight	CTWS
		mm	mm	mm	mm	mm	mm	kg	
CFIR1212M03	02435854	12,0	12,0	150,0	12,0	31,0	9,0	0,2	LC..1603..
CFIR1616H03	00091799	16,0	16,0	100,0	16,0	28,0	9,0	0,2	LC..1603..
CFIR2020K03	00068771	20,0	20,0	125,0	21,5	28,0	9,0	0,4	LC..1603..
CFIR2525M03	00068773	25,0	25,0	150,0	26,5	28,0	9,0	0,7	LC..1603..
CFIR3225P03	00013453	32,0	25,0	170,0	26,5	28,0	9,0	1,0	LC..1603..
CFIL1212M03	02435855	12,0	12,0	150,0	12,0	31,0	9,0	0,2	LC..1603..
CFIL1616H03	00091798	16,0	16,0	100,0	16,0	28,0	9,0	0,2	LC..1603..
CFIL2020K03	00068770	20,0	20,0	125,0	21,5	28,0	9,0	0,4	LC..1603..
CFIL2525M03	00068772	25,0	25,0	150,0	26,5	28,0	9,0	0,7	LC..1603..
CFIL3225P03	00013452	32,0	25,0	170,0	26,5	28,0	9,0	1,0	LC..1603..

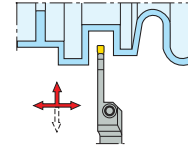
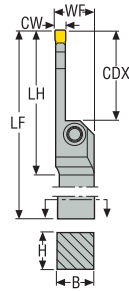
## Spare Parts

For holders	Clamp key	Clamp screw
..1212M03	3SMS795	TCEI0409
..1616H03	4SMS795	TCEI0509
..2020K03	4SMS795	TCEI0513
..2525M03	4SMS795	TCEI0513
..3225P03	4SMS795	TCEI0513

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MDT Toolholders, external

Toolholders for inserts LCGF, LCGN, LCMF and LCMR



- For inserts program, see catalog Turning
- DCINN3 - minimum bore diameter for internal application, see catalog Turning
- CDX – Max depth of cut for LCGF/LCMF16.. = 14 mm, LCGF/LCMF30.. = 28

Right-hand version shown  
CDX = 8 x CW

Designation	Item number	H	B	LF	WF	LH	CDX	DCINN3	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	
CFSR2525M03	02703367	25,0	25,0	150,0	26,5	46,0	24,0	195,0	0,7	LC..1603..
CFSR3225P03	02703375	32,0	25,0	170,0	26,1	46,0	24,0	195,0	1,0	LC..1603..
CFSL2525M03	02703363	25,0	25,0	150,0	26,5	46,0	24,0	195,0	0,7	LC..1603..
CFSL3225P03	02703371	32,0	25,0	170,0	26,1	46,0	24,0	195,0	1,0	LC..1603..

### Spare Parts

For holders	Clamp key	Clamp screw
CFSR/L..03	4SMS795	TCEI0513

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Start™

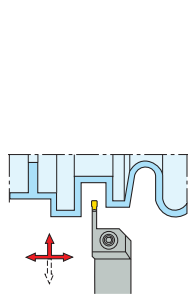
Rotating threading

Annex

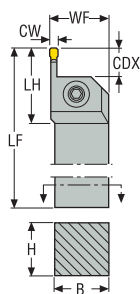


## MDT Toolholders, external

Toolholders for inserts LCGF, LCGN, LCMF and LCMR





Right-hand version shown  
CDX = 5 x CW



- For inserts program, see catalog Turning
- DCINN3 - minimum bore diameter for internal application, see catalog Turning
- CDX – Max depth of cut for LCGF/LCMF16.. = 14 mm

Designation	Item number	H	B	LF	WF	LH	CDX	DCINN3	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	
CFMR2020K03	00068777	20,0	20,0	125,0	21,5	36,0	15,0	-	0,4	LC..1603..
CFMR2525M03	00068779	25,0	25,0	150,0	26,5	36,0	15,0	195,0	0,7	LC..1603..
CFMR3225P03	00013460	32,0	25,0	170,0	26,5	36,0	15,0	195,0	1,0	LC..1603..
CFML2020K03	00068776	20,0	20,0	125,0	21,5	36,0	15,0	-	0,4	LC..1603..
CFML2525M03	00068778	25,0	25,0	150,0	26,5	36,0	15,0	195,0	0,7	LC..1603..
CFML3225P03	00013459	32,0	25,0	170,0	26,5	36,0	15,0	195,0	1,0	LC..1603..

### Spare Parts

For holders	Clamp key	Clamp screw
		
CFMR/L...03	4SMS795	TCEI0513

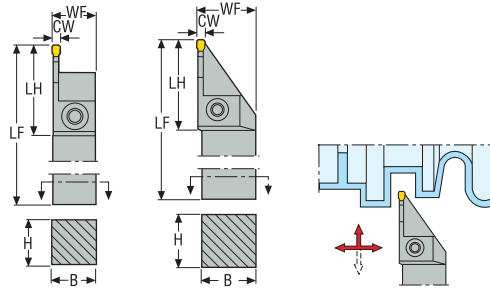
Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MDT Toolholders, external

Toolholders for inserts LCGN and LCMR

CF..1212, 1616

CF..2020, 2525



Right-hand version shown

- For inserts program, see catalog Turning
- CUTDIA – Due to the design, grooving depth is limited, see catalog Turning

Designation	Item number	H	B	LF	WF	LH	CW	CUTDIA	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	
CFOR1212M03	00053367	12,0	12,0	150,0	12,0	32,1	3,0	37,0	0,2	LC..1603..
CFOL1212M03	00053357	12,0	12,0	150,0	12,0	32,1	3,0	37,0	0,2	LC..1603..
CFTR1616M03	00054058	16,0	16,0	150,0	16,0	42,0	3,0	50,0	0,3	LC..1603..
CFTR2020K03	00054060	20,0	20,0	125,0	21,5	43,0	3,0	50,0	0,4	LC..1603..
CFTR2525M03	00054066	25,0	25,0	150,0	26,5	42,5	3,0	50,0	0,7	LC..1603..
CFTL1616M03	00054057	16,0	16,0	150,0	16,0	42,0	3,0	50,0	0,3	LC..1603..
CFTL2020K03	00054059	20,0	20,0	125,0	21,5	43,0	3,0	50,0	0,4	LC..1603..
CFTL2525M03	00054063	25,0	25,0	150,0	26,5	42,5	3,0	50,0	0,7	LC..1603..

### Spare Parts

For holders	Clamp key	Clamp screw
CFOR/L..-03	3SMS795	TCEI0409
CFTR/L..-03	4SMS795	TCEI0513

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Start™

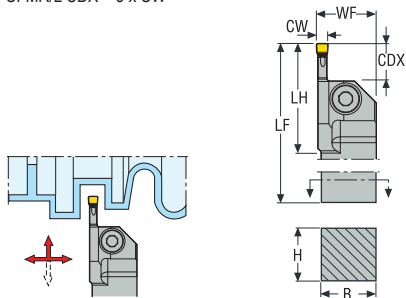
Rotating threading

Annex

## MDT Toolholders, external

Toolholders for inserts LCGF, LCGN, LCMF and LCMR


Right-hand version shown  
CFIR/L CDX = 3 x CW  
CFMR/L CDX = 5 x CW






Right-hand version shown



- For inserts program, see catalog Turning
- CDX – Max depth of cut for LCGF/LCMF16.. = 14 mm, LCGF/LCMF30.. = 28
- CP – Max coolant pressure (bar) using hose connection

Designation	Item number	H	B	LF	WF	LH	CDX	CW	CP	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	mm	kg	
CFIR3225P03JET	02599873	32,0	25,0	170,0	26,5	33,0	9,0	3,0	275,0	1,0	LC..1603..
CFIL3225P03JET	02599874	32,0	25,0	170,0	26,5	33,0	9,0	3,0	275,0	1,0	LC..1603..
CFMR3225P03JET	02702825	32,0	25,0	170,0	26,5	41,0	15,0	3,0	275,0	1,0	LC..1603..
CFML3225P03JET	02702829	32,0	25,0	170,0	26,5	41,0	15,0	3,0	275,0	1,0	LC..1603..

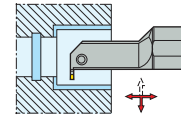
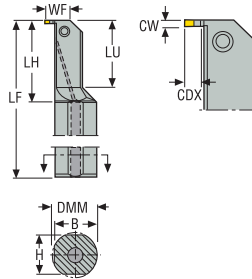
### Spare Parts

For holders	Clamp key	Clamp screw	Plug
			
CFIR/L...03	4SMS795	TCEI0513	JET-P1/8-5MM
CFMR/L...03	4SMS795	TCEI0513	JET-P1/8-5MM

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MDT Toolholders, internal

Toolholders for inserts LCGF, LCGN, LCMF and LCMR



- For inserts program, see catalog Turning
- DCINN - minimum bore diameter, see catalog Turning

Right-hand version shown

Designation	Item number	H	B	LF	WF	LH	CDX	DCINN	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	
A32T-CGIR1603	02717661	30,0	31,0	300,0	24,0	60,0	9,0	32,0	1,6	LC..1603..
A32T-CGIL1603	02718385	30,0	31,0	300,0	24,0	60,0	9,0	32,0	1,6	LC..1603..

### Spare Parts

For holders	Clamp key	Clamp screw
CG.R/L..03	 T15P-7	 L85011-T15P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

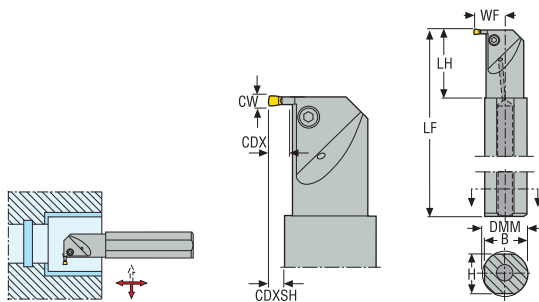
Thread Mini-Start™

Rotating threading

Annex

## MDT Toolholders, internal

Toolholders for inserts LCGF, LCGN, LCMF and LCMR



Right-hand version shown  
CDX = 2 x CW



- For inserts program, see catalog Turning
- DCINN - minimum bore diameter, see catalog Turning
- CDXSH – If toolholder enters bore more than LH

Designation	Item number	H	B	LF	WF	LH	CDX	DCINN	CDXSH	DMM	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	mm	mm	kg	
A40T-CGGR03	00093896	37,0	38,5	300,0	26,0	60,0	6,0	45,0	5,5	40,0	2,5	LC..1603..
A40T-CGGL03	00093897	37,0	38,5	300,0	26,0	60,0	6,0	45,0	5,5	40,0	2,5	LC..1603..

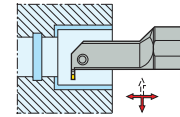
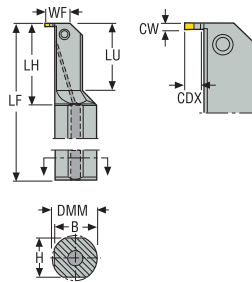
### Spare Parts

For holders	Clamp key	Clamp screw
-.03	3SMS795	MC6S4X14

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MDT Toolholders, internal

Toolholders for inserts LCGF, LCGN, LCMF and LCMR



- For inserts program, see catalog Turning
- DCINN - minimum bore diameter, see catalog Turning

Right-hand version shown

Designation	Item number	B	H	LF	LH	WF	LU	DCINN	CW	CDX	Weight	CTWS
		<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>lbs</i>	
A20-CGIR03	02717401	1.211	1.171	12.000	2.362	0.929	1.969	1.260	0.118	0.354	3.530	LC..1603..
A20-CGIL03	02718392	1.211	1.171	12.000	2.362	0.929	1.969	1.260	0.118	0.354	3.530	LC..1603..

### Spare Parts

For holders	Clamp key	Clamp screw
.03	 T15P-7	 L85011-T15P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

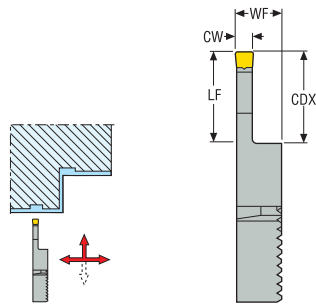
Thread Mini-Start™

Rotating threading

Annex

## MDT Blades modular


Blades for inserts LCGF, LCGN, LCMF and LCMR



Right-hand version shown



- For holders and inserts program, see catalog Turning
- CDX – Max depth of cut for LCGF/LCMF13.. = 11 mm, LCGF/LCMF16.. = 14 mm

Designation	Item number	LF	WF	CW	CDX	Weight	CTWS
		mm	mm	mm	mm	kg	
V21-CMR1603	00030310	16,2	9,2	3,0	15,0	0,1	LC..1603..
V21-CML1603	02719038	16,2	9,2	3,0	15,0	0,1	LC..1603..

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store



## Thread turning Mini-Shaft™

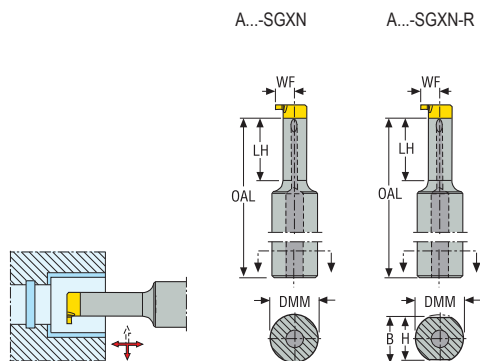
The highly versatile Mini-Shaft™ consists of inserts and holders providing stable, high-precision internal threading operations. Mini-Shaft™ features a special double-serrated joint that creates a secure connection point for its exchangeable inserts and toolholders, resulting in a repeatability of +/- 0.02 mm ( +/- .0008 inch).

- All toolholders can accommodate R- and L-handed inserts
- Through coolant possibility
- Use in holes as small as 8 mm (0.315 inch)



# Mini-Shaft™ Holders

Toolholders for inserts LCEX



Right-hand version shown



• For inserts programme, see page(s) 170-176

Designation	Item number	H	B	LF	WF	LH	DMM	DCINN	Weight	CTWS
		mm	mm	mm	mm	mm	mm	mm	kg	
A12G-SGXN08-20	02411140	11	12	16,5	4,8	16,5	12,0	8,0	0,1	LCEX08..
A12G-SGXN08-20-R	02511871	–	–	16,5	4,8	16,5	12,0	8,0	0,1	LCEX08..
A16H-SGXN11-25	02411142	15	16	21,0	6,7	21,0	16,0	11,0	0,2	LCEX11..
A16H-SGXN11-25-R	02511872	–	–	21,0	6,7	21,0	16,0	11,0	0,2	LCEX11..

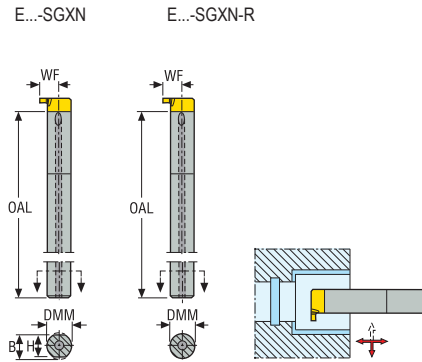
## Spare Parts

For holders	Insert key	Insert screw
A12G-..	T08P-2	C02506-T08P
A16H-..	T10P-2	C03509-T10P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Mini-Shaft™ Holders

Toolholders for inserts LCEX



• For inserts programme, see page(s) 170-176

Right-hand version shown

Designation	Item number	H	B	LF	WF	DMM	DCINN	Weight	CTWS
		mm	mm	mm	mm	mm	mm	kg	
E06G-SGXN08	02411141	6	6	36,0	4,8	6,0	8,0	0,1	LCEX08..
E06G-SGXN08-R	02513692	–	–	36,0	4,8	6,0	8,0	0,1	LCEX08..
E08H-SGXN11	02411143	7	8	48,0	6,7	8,0	11,0	0,1	LCEX11..
E08H-SGXN11-R	02513696	–	–	48,0	6,7	8,0	11,0	0,1	LCEX11..

### Spare Parts

For holders	Insert key	Insert screw
E06G-..	T08P-2	C02506-T08P
E08H-..	T10P-2	C03509-T10P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

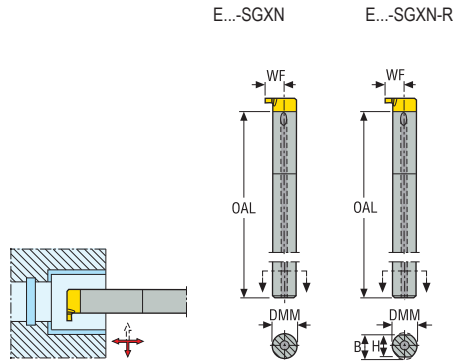
Thread Mini-Shaft™

Rotating threading

Annex

Mini-Shaft™ Holders

Toolholders for inserts LCEX



Right-hand version shown



• For inserts programme, see page(s) 170-176

Designation	Item number	B	H	LF	LH	WF	DCINN	DMM	Weight	CTWS
		<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>lbs</i>	
A10G-SGXN08-078	02450441	0.605	0.586	0.650	0.650	0.188	0.315	0.625	0.220	LCEX08..
E04G-SGXN08	02450442	0.233	0.217	1.417	-	0.189	0.315	0.250	0.220	LCEX08..
A10H-SGXN11-098	02450443	0.605	0.586	0.827	0.827	0.264	0.433	0.625	0.440	LCEX11..
E05H-SGXN11	02450445	0.300	0.287	1.890	-	0.264	0.433	0.312	0.220	LCEX11..
A10G-SGXN08-078-R	02511873	-	-	0.650	0.650	0.188	0.315	0.625	0.220	LCEX08..
A10H-SGXN11-098-R	02511874	-	-	0.827	0.827	0.264	0.433	0.625	0.440	LCEX11..
E04G-SGXN08-R	02513700	-	-	1.417	-	0.189	0.315	0.250	0.220	LCEX08..
E05H-SGXN11-R	02513704	-	-	1.890	-	0.264	0.433	0.312	0.220	LCEX11..

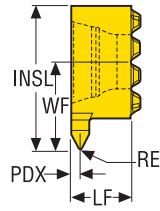
Spare Parts

For holders	Insert key	Insert screw
A10G-../E04G-..	 T08P-2	 C02506-T08P
A10H-../E05H-..	 T10P-2	 C03509-T10P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## Mini-Shaft™ Inserts

Partial profile 60°



Pitch		RE	PDX	WF	INSL	LF	Designation	Coated
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP500 Coated
0,5-0,75	48.0-36.0	0,03 <i>0.001</i>	0,48 <i>0.019</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-A60R	■
0,5-0,75	48.0-36.0	0,03 <i>0.001</i>	0,48 <i>0.019</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-A60L	■
0,75-1,25	36.0-20.0	0,07 <i>0.003</i>	0,73 <i>0.029</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-AG60R	■
0,75-1,25	36.0-20.0	0,07 <i>0.003</i>	0,73 <i>0.029</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-AG60L	■
1,25-1,75	20.0-16.0	0,12 <i>0.005</i>	0,98 <i>0.039</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-G60R	■
1,25-1,75	20.0-16.0	0,12 <i>0.005</i>	0,98 <i>0.039</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-G60L	■
0,5-0,75	48.0-36.0	0,03 <i>0.001</i>	0,48 <i>0.019</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-A60R	■
0,5-0,75	48.0-36.0	0,03 <i>0.001</i>	0,48 <i>0.019</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-A60L	■
0,75-1,25	36.0-20.0	0,07 <i>0.003</i>	0,73 <i>0.029</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-AG60R	■
0,75-1,25	36.0-20.0	0,07 <i>0.003</i>	0,73 <i>0.029</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-AG60L	■
1,25-1,75	16.0-20.0	0,12 <i>0.005</i>	0,98 <i>0.039</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-G60R	■
1,25-1,75	20.0-16.0	0,12 <i>0.005</i>	0,98 <i>0.039</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-G60L	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

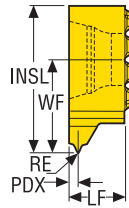
Thread Mini-Shaft™

Rotating threading

Annex

# Mini-Shaft™ Inserts

ISO Metric



Pitch		RE	PDX	WF	INSL	LF	Designation	Grades
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP500 Coated
1,0	-	0,07 <i>0.003</i>	0,6 <i>0.024</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-1.0ISOR	■
1,0	-	0,07 <i>0.003</i>	0,6 <i>0.024</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-1.0ISOL	■
1,5	-	0,12 <i>0.005</i>	0,85 <i>0.033</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-1.5ISOR	■
1,5	-	0,12 <i>0.005</i>	0,8 <i>0.031</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-1.5ISOL	■
2,0	-	0,17 <i>0.007</i>	1,1 <i>0.043</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-2.0ISOR	■
2,0	-	0,17 <i>0.007</i>	1,1 <i>0.043</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-2.0ISOL	■
2,5	-	0,18 <i>0.007</i>	1,35 <i>0.053</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-2.5ISOR	■
2,5	-	0,18 <i>0.007</i>	1,35 <i>0.053</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-2.5ISOL	■
3,0	-	0,21 <i>0.008</i>	1,6 <i>0.063</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-3.0ISOR	■
3,0	-	0,21 <i>0.008</i>	1,6 <i>0.063</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-3.0ISOL	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

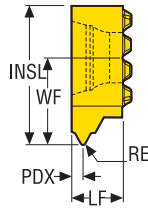
Thread Mini-Shaft™

Rotating threading

Annex

## Mini-Shaft™ Inserts

Whitworth, BSW



Pitch		RE	PDX	WF	INSL	LF	Designation	Grades
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP500 Coated
-	19.0	0,15 <i>0.006</i>	0,77 <i>0.030</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-19WR	■
-	19.0	0,15 <i>0.006</i>	0,77 <i>0.030</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-19WL	■
-	14.0	0,24 <i>0.009</i>	1,0 <i>0.039</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-14WR	■
-	14.0	0,24 <i>0.009</i>	1,0 <i>0.039</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-14WL	■

■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

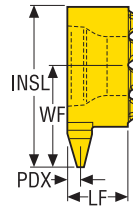
Thread Mini-Shaft™

Rotating threading

Annex

Mini-Shaft™ Inserts

TR-DIN103



Pitch		RE	PDX	WF	INSL	LF	Designation	Grades
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP500 Coated
1,5	-	0,1 <i>0.004</i>	0,8 <i>0.031</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-1.5TRR	■
1,5	-	0,1 <i>0.004</i>	0,8 <i>0.031</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-1.5TRL	■
2,0	-	0,15 <i>0.006</i>	1,1 <i>0.043</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-2.0TRR	■
2,0	-	0,15 <i>0.006</i>	1,1 <i>0.043</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-2.0TRL	■
3,0	-	0,15 <i>0.006</i>	1,6 <i>0.063</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-3.0TRR	■
3,0	-	0,15 <i>0.006</i>	1,6 <i>0.063</i>	6,7 <i>0.264</i>	10,7 <i>0.421</i>	4,0 <i>0.157</i>	LCEX1105-3.0TRL	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

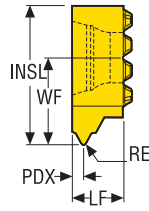
Thread Mini-Shaft™

Rotating threading

Annex

## Mini-Shaft™ Inserts

UN



Pitch		RE	PDX	WF	INSL	LF	Designation	Grades
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP500 Coated
-	32.0	0,04 <i>0.002</i>	0,5 <i>0.020</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-32UNR	■
-	32.0	0,04 <i>0.002</i>	0,5 <i>0.020</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-32UNL	■
-	24.0	0,07 <i>0.003</i>	0,6 <i>0.024</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-24UNR	■
-	24.0	0,07 <i>0.003</i>	0,6 <i>0.024</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-24UNL	■
-	20.0	0,09 <i>0.004</i>	0,7 <i>0.028</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-20UNR	■
-	20.0	0,09 <i>0.004</i>	0,7 <i>0.028</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-20UNL	■
-	16.0	0,13 <i>0.005</i>	0,9 <i>0.035</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-16UNR	■
-	16.0	0,13 <i>0.005</i>	0,9 <i>0.035</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-16UNL	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Shaft™

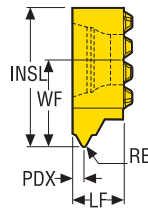
Rotating threading

Annex



# Mini-Shaft™ Inserts

NPT



Pitch		RE	PDX	WF	INSL	LF	Designation	Grades
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP500 Coated
-	27.0	0,03 <i>0.001</i>	0,57 <i>0.022</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-27NPTR	■
-	27.0	0,03 <i>0.001</i>	0,57 <i>0.022</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-27NPTL	■

■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

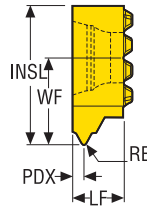
Thread Mini-Shaft™

Rotating threading

Annex

## Mini-Shaft™ Inserts

NPTF



Pitch		RE	PDX	WF	INSL	LF	Designation	Grades
mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		CP500 Coated
-	27.0	0,04 <i>0.002</i>	0,57 <i>0.022</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-27NPTFR	■
-	27.0	0,04 <i>0.002</i>	0,57 <i>0.022</i>	4,78 <i>0.188</i>	7,78 <i>0.306</i>	3,3 <i>0.130</i>	LCEX0804-27NPTFL	■

■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning





Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

## Range overview

Threading	Ø Range	Length
<p>Threadmaster™</p>  <p>Page(s) 186, 187-190, 191</p>	<p>M1-M20</p>	<p>~ 1,5-2 x D</p>
<p>R396.18/19/20</p>  <p>Page(s) 200-204</p>	<p>14 ≤</p>	<p>~ 2 - 3.5 x D</p>
<p>R335.14</p>  <p>Page(s) 211-213</p>	<p>12 &lt;</p>	<p>~1xD &lt;</p>
<p>Threadmaster™ Taps</p>  <p>Page(s) 241-360</p>	<p>M1-M64</p>	<p>~ 1,5-3,5 x D</p>

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

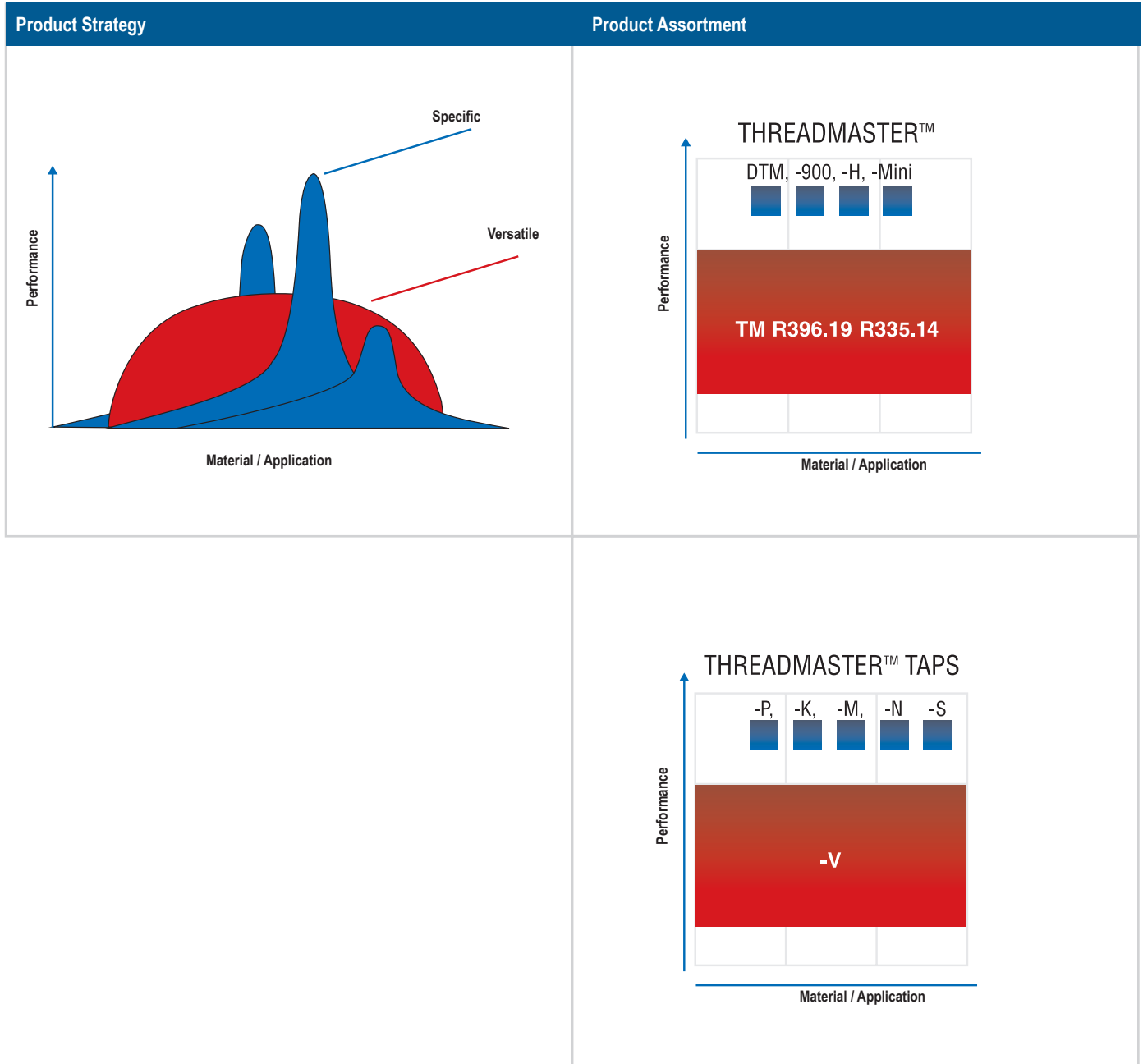
Annex

## Versatile & Specific

### Thread milling and Tapping – Choice of tool

Continuous research and development of better materials, coatings and optimal geometries help fulfil customer's requirements.

Our product strategy is to provide the market with versatile first choice tools and specific optimized solutions for threading.



Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

# Thread milling – Choice of cutter, inserts and cutting data

## Solid carbide cutter – Threadmaster™

### 1. General

The same cutter can be used for machining both right and left hand threads. Metric and UN versions are only for internal threading. The remaining of the range can be used for both external and internal threading.

- The cutters are regrindable

### 2. Select cutter diameter

- Look up the pages with the Threadmaster programmes
- Look up the column for the required thread type
- Look up the required pitch
- When more alternatives are available note that:
  - Smaller cutter diameter allows smaller threading diameter (minimum thread diameter is found in the designation).
  - Larger cutter diameter allows larger threading depth (maximum threading depth is 2 x cutter diameter,  $D_c$ ).

### 3. Selection of cutter

- TM: Basic choice
- TM...-900: Choice for steel and stainless steel with tensile strength > 900 N/mm<sup>2</sup>
- TM...-H: Choice for hardened steel with hardness 45-60 HRC
- DTM: Drill, thread and chamfer with same tool. To be used in aluminium and cast iron

### 4. Select cutting data

- Use the tables beginning on page 361 to classify the workpiece material into a SMG (Seco Material Group)
- Cutting speed recommendations are found on the cutting data page for Threadmaster
- Feed per tooth (= flute) recommendations are found on the cutting data page for Threadmaster
- Formulae for cutting data calculation are on page 181
- For best suggestion and performance use Seco Suggest <https://www.secotools.com/dashboard/Suggest/Suggest>.

### 5. Machining methods

- Helical interpolation must be used to create the pitch
- Clockwise or counterclockwise feed direction can be used depending on thread type and machining method (right or left hand), external or internal thread
- Climb milling is recommended
- Coolant supply is recommended. Except when threading hardened material
- Special machining recommendations for certain workpiece materials are found on the cutting data page for Threadmaster

## Feed recommendations

### Threadmaster™

- Feed recommendations for TM-M4X0.7ISO-6R1 except for TM-Mini, that recommendation is for TM-M1.0X0.25ISO-3R1-H and only a start value
- For best suggestion and performance use Seco Suggest <https://www.secotools.com/dashboard/Suggest/Suggest>
- All feed are related to the centre of the cutter and not the periphery
- In the entrance loop reduce feed by 50%. In the exit loop increase feed by 50%
- In the entrance and exit loop feed the cutter 15% of the pitch axially
- For free cutting steel, low alloy and ferritic steel, quench & temper steel, low to medium alloy stainless steels and austenitic cast irons, leave 0,05 mm in  $a_e$  for a finishing cut
- For high strength steels, martensitic and high alloy stainless steels, Ni-based superalloys and titanium alloys remove 2/3 of  $a_e$  in the first cut and the remaining 1/3 in the second cut
- For hardened steels remove 1/3 of  $a_e$  in the first cut, 1/3 of  $a_e$  in the second cut and the remaining 1/3 in the third cut
- For NPT and NPTF threads take the whole  $a_e$  in one cut
- Coolant is recommended (except when using -H in hardened materials)
- The Metric and UN thread mills are only for internal threads

### TM-Mini:

- Left-hand cutting (M4)
- Do the entrance loop before entering into the workpiece

### DTM:

- Use peck drilling

# Choice of cutter, inserts and cutting data

## 1. General

- The same cutter can be used for machining external and internal, right-hand and left-hand threads

## 2. Select cutter diameter

- Look up the pages for thread milling cutters and choose a suitable diameter in the tool data table
- The insert size varies with the cutter diameters. Check the available insert programme for the different sizes before deciding cutter diameter
- For internal thread milling check the 'minimum thread diameter' table before deciding cutter diameter. This table shows the relation between the cutter diameter and the smallest thread diameter to be machined

## 3. Select insert

- Look up the thread milling inserts pages and choose the required thread type in the correct insert size for the cutter. Choose the grade F30M/CP500 for general machining

## 4. Select cutting data

### Radial cutting depth

- Use the formulae to calculate the radial cutting depth ( $a_e$ ). See figures.

### Feed rate

- Divide the radial cutting depth with the cutter diameter to get the actual cutter engagement percentage ( $a_e/D_c\%$ ). Use the cutting data table to get a feed per tooth recommendation, see page(s) 192 - 196.

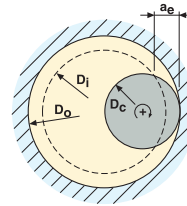
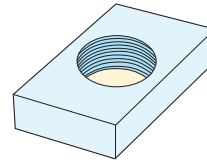
### Cutting speed

- Use the tables beginning at page 361 to classify the workpiece material into a Seco Material Group.
- Cutting speed recommendations (for 10% engagement) are in the basic cutting speed table in the catalogue
- For safety reasons, maximum rpm that should never be exceeded
- Formulae for cutting data calculation are found on page 181

## 5. Machining methods

- Helical interpolation must be used to create the pitch
- Clockwise or counterclockwise feed direction can be used depending on thread type and machining method (right or left hand, external or internal thread)
- Climb milling and coolant is recommended. Coolant supply is recommended except when threading hardened material

## Internal



$$D_i = D_o - 2h$$

Thread	h
ISO	0,60 x p
UN	0,60 x p
W	0,69 x p
BSPT	0,69 x p
NPT	0,78 x p

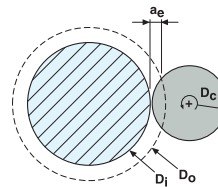
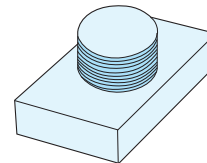
Radial infeed value  $a_e$ :

$$a_e = \frac{D_o^2 - D_i^2}{4 (D_o - D_c)}$$

p = pitch (mm)  
h = depth of thread

$D_c$  = Cutter dia  
 $D_o$  = Major dia  
 $D_i$  = Minor dia

## External



$$D_i = D_o - 2h$$

Thread	h
ISO	0,65 x p
UN	0,65 x p
W	0,69 x p
BSPT	0,69 x p
NPT	0,78 x p

Radial infeed value  $a_e$ :

$$a_e = \frac{D_o^2 - D_i^2}{4 (D_i + D_c)}$$

p = pitch (mm)  
h = depth of thread

$D_c$  = Cutter dia  
 $D_o$  = Major dia  
 $D_i$  = Minor dia

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex

## Choice of cutter, inserts and cutting data

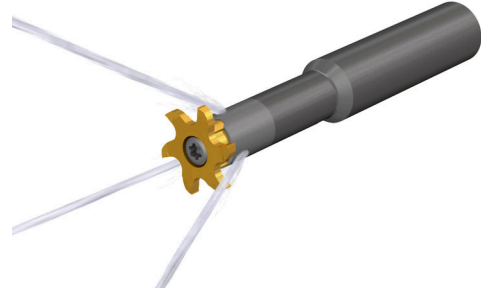
RPM	
$n = \frac{v_c \cdot 1000}{\pi \cdot D_c}$	(rev/min)
Cutting speed	
$v_c = \frac{n \cdot \pi \cdot D_c}{1000}$	(m/min)
$v_c = \frac{n \cdot D_c}{3.82}$	(sf/min)
Feed speed	
$v_f = n \cdot Z_n \cdot f_z$	(in/min)
$v_f = n \cdot Z_c \cdot f_z$	(in/min)
Feed per revolution	
$f = Z_n \cdot f_z$	(in/rev)
$f = Z_c \cdot f_z$	(in/rev)

- $D_c$  = Cutter diameter (inch)
- $f$  = Feed per revolution (inch)
- $f_z$  = Feed per tooth (in/tooth)
- $Z_c$  = Effective No. of teeth for calculation of feed speed or feed per rev
- $n$  = RPM (rev/min)
- $v_c$  = Cutting speed (sf/min)
- $v_f$  = Feed speed (sf/min)
- $Z_n$  = No. of teeth

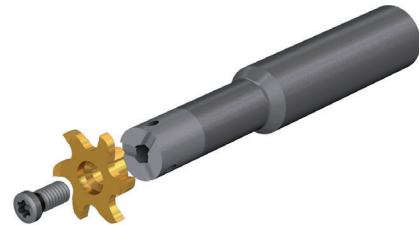
## Disc Milling cutter 335.14

Disc milling cutter with exchangeable carbide head from diameter 9,7 mm (0.382 in)

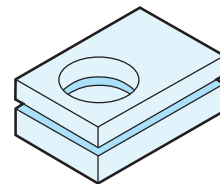
A broad range of heads and shanks available for all your disc milling operation by circular interpolation or linear slotting.



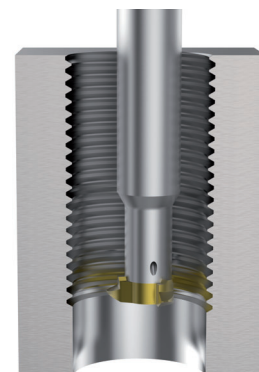
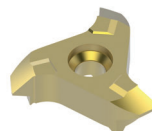
Strong, reliable and precise connection between the head and the cutter body.



Cover all type of material with universal M geometry and F32M grade.

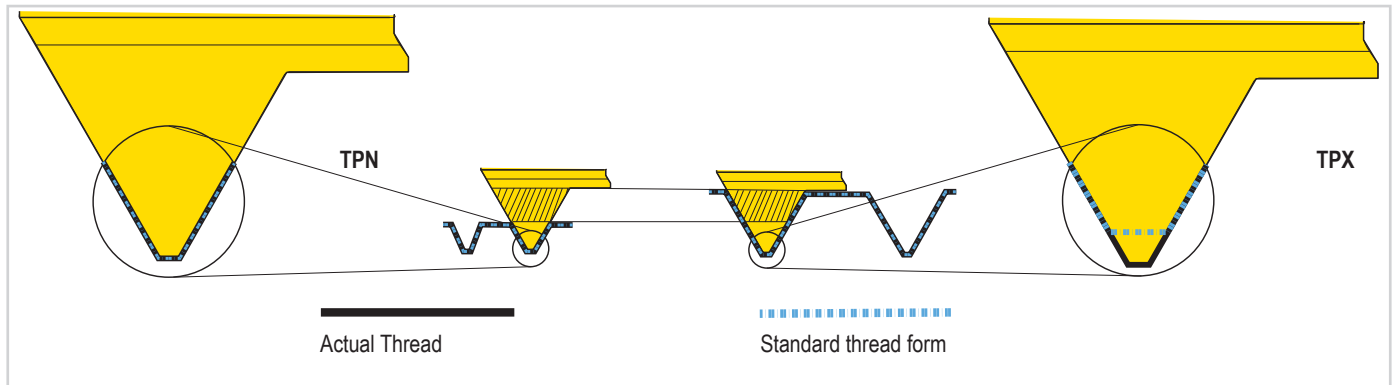


**Threading:**  
Head from dia 11,7 to 27,7 mm (0.461 to 1.091 in) for partial metric threads with pitch 1-6 mm (0.039-0.236 in) and full profile whitworth threads with pitch 19 to 11 tpi and UN threads with pitch 24 to 6 tpi.





## Deviation from standard thread profile



Thread milling by circular interpolation can cause thread profile violation when using insert designed for partial thread. Keep this in mind while selecting a tool. The tool diameter needs to be small enough compared to the hole diameter. The pitch also needs to be considered.

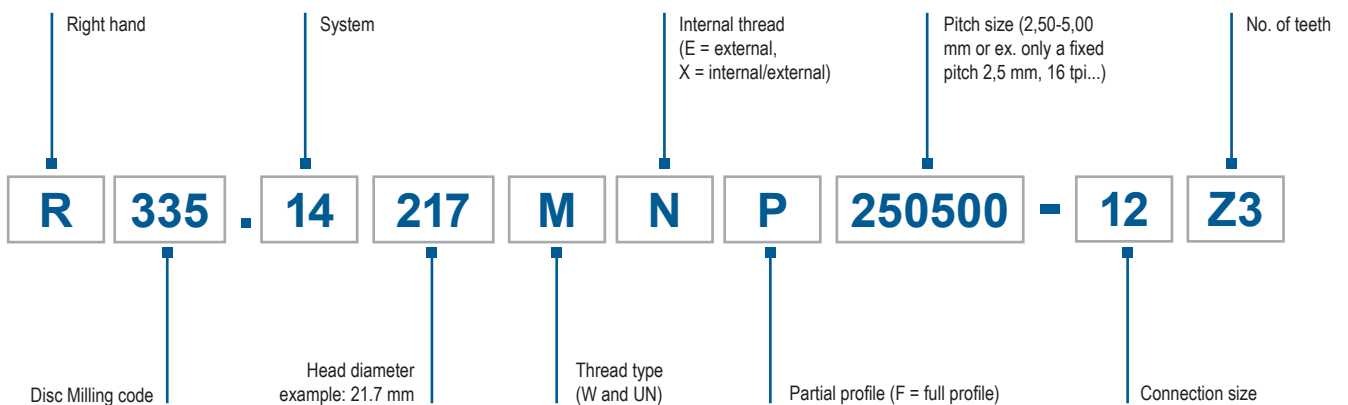
Insert with partial profile for Metric ISO-Threads are multi tools. That means that each insert could machine different pitches. The insert is designed to meet the minimum pitch size (TPN); Machining this pitch will result in a thread form that conforms to the standard.

The recommended maximum pitch size (TPX) can also be machined with this insert at the expense of standard conformity: The result will be a slightly deeper thread than the standard. The deeper thread is normally accepted, but the application and use needs to be evaluated.

Following table is a recommendation over maximum tool diameter in relation to the thread size and pitch:

ISO-Thread, partial profile											
Pitch	M12	M16	M20	M24	M27	M30	M36	M42	M48	M56	M60
1	10	14	18	22	25	28	34	40	45	53	57
1,5	8	12	16	20	24	26	32	37	43	51	55
2	7	10	14	18	22	24	30	35	40	48	52
2,5	6	8	12	16	20	22	28	32	37	45	48
3		6	10	14	18	20	26	30	36	43	47
3,5				12	16	18	24	29	35	42	46
4							22	27	32	39	43
4,5								24	30	37	40
5								22	27	34	37
5,5								20	25	31	35
6								19	23	29	32


### Code key



# Application overview milling cutters

## Solid carbide

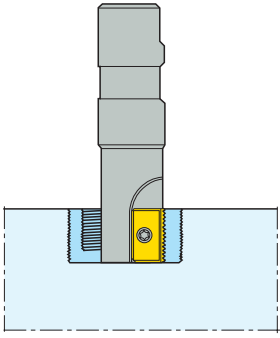
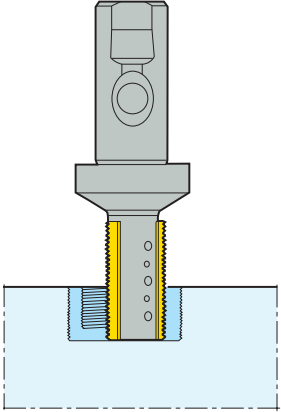
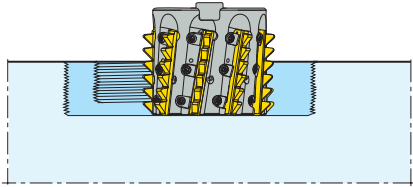
Threadmaster™



TM - Thread size M1-M20  
Solid carbide thread milling cutters

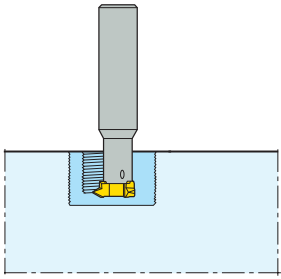
Page(s) 186-191

## Cutter with inserts

396.18	396.19	396.20
 <p>Ø 12 mm (0.472 in) Thread milling cutters with indexable insert</p> <p>Page(s) 200-201</p>	 <p>Ø 17-58 mm (0.669-2.283 in) Thread milling cutters with indexable inserts</p> <p>Page(s) 200-203</p>	 <p>Ø 63 mm (2.480 in) Thread milling cutters with indexable inserts</p> <p>Page(s) 204</p>

## Cutter with changeable head

335.14



Ø 11,7-27,7 mm (0.461-1.091 in)  
Thread milling cutters with changeable head

Page(s) 211

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex



## Threadmaster™

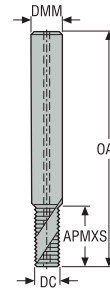
Threadmaster™ thread mills provide high thread quality at low cost per hole. Machining up to 100 percent depth, Threadmasters have high helix angles that reduce cutting forces and eliminate chatter. They feature an excellent carbide substrate and TiCN-coating (TM and TM-900) or TiAlN-coating (TM-H and DTM) for high toughness and wear resistance milling aluminum, steel, stainless steel and cast iron.

Drilling Threadmaster is a multi-tool producing a thread by drilling and chamfering in a single pass for high thread quality at a low cost per hole.

- Some versions with through-coolant holes
- Threads range from M4 to M20
- Mini thread mills for thread sizes from M1 - M2.5

## Threadmaster™

Solid carbide thread milling cutters



- For cutting data see page(s) 192, 193
- TM; 2 x D
- Chamfer angle STA = 45°

- \* = Metric coarse, for Internal Threading
- \*\* = Metric fine, for Internal Threading
- \*\*\* = UNC, for Internal Threading

Designation	Item number	TDZ	Pitch		Thread profile	DC	DMM	OAL	APMXS	NOF	Through coolant
			TPX	TPIX							
TM-M4X0.7ISO-6R1	02827408	M4	0,7	–	*	3,15 0.124	6,0 0.236	49,0 1.929	8,0 0.315	3	–
TM-M4X0.7ISO-6R1-900	02827358	M4	0,7	–	*	3,15 0.124	6,0 0.236	49,0 1.929	8,0 0.315	3	–
TM-M4X0.7ISO-6R1-H	02827349	M4	0,7	–	*	3,15 0.124	6,0 0.236	46,0 1.811	6,3 0.248	4	–
TM-M5X0.8ISO-6R1	02827407	M5	0,8	–	*	3,95 0.156	6,0 0.236	49,0 1.929	10,0 0.394	3	–
TM-M5X0.8ISO-6R1-900	02827359	M5	0,8	–	*	3,95 0.156	6,0 0.236	49,0 1.929	10,0 0.394	3	–
TM-M5X0.8ISO-6R1-H	02827350	M5	0,8	–	*	3,95 0.156	6,0 0.236	47,0 1.850	7,2 0.283	4	–
TM-M6X1.0ISO-6R1	02827406	M6	1,0	–	*	4,7 0.185	6,0 0.236	55,0 2.165	12,5 0.492	3	–
TM-M6X1.0ISO-6R1-900	02827360	M6	1,0	–	*	4,7 0.185	6,0 0.236	55,0 2.165	12,5 0.492	3	–
TM-M6X1.0ISO-6R1-H	02827351	M6	1,0	–	*	4,7 0.185	6,0 0.236	52,0 2.047	8,5 0.335	4	–
TM-M8X1.25ISO-8R1	02827405	M8	1,25	–	*	6,2 0.244	8,0 0.315	62,0 2.441	16,9 0.665	3	✓
TM-M8X1.25ISO-8R1-900	02827361	M8	1,25	–	*	6,2 0.244	8,0 0.315	62,0 2.441	16,9 0.665	3	✓
TM-M8X1.25ISO-8R1-H	02827352	M8	1,25	–	*	6,2 0.244	8,0 0.315	57,0 2.244	12,5 0.492	4	–
TM-M10X1.5ISO-10R1	02827404	M10	1,5	–	*	7,8 0.307	10,0 0.394	74,0 2.913	20,3 0.799	3	✓
TM-M10X1.5ISO-10R1-900	02827362	M10	1,5	–	*	7,8 0.307	10,0 0.394	74,0 2.913	20,3 0.799	3	✓
TM-M10X1.5ISO-10R1-H	02827353	M10	1,5	–	*	7,8 0.307	10,0 0.394	66,0 2.598	15,0 0.591	5	–
TM-M12X1.75ISO-12R1	02827403	M12	1,75	–	*	9,4 0.370	12,0 0.472	79,0 3.110	25,4 1.000	3	✓
TM-M12X1.75ISO-12R1-900	02827363	M12	1,75	–	*	9,4 0.370	12,0 0.472	79,0 3.110	25,4 1.000	3	✓
TM-M12X1.75ISO-12R1-H	02827354	M12	1,75	–	*	9,4 0.370	12,0 0.472	76,0 2.992	17,5 0.689	5	–
TM-M14X2.0ISO-14R1	02827402	M14	2,0	–	*	10,9 0.429	14,0 0.551	89,0 3.504	29,0 1.142	4	✓
TM-M14X2.0ISO-14R1-900	02827364	M14	2,0	–	*	10,9 0.429	14,0 0.551	89,0 3.504	29,0 1.142	4	✓
TM-M20X2.5ISO-20R1	02827348	M20	2,5	–	*	15,83 0.623	20,0 0.787	108,0 4.252	40,0 1.575	4	✓

Thread turning

Thread MDT

Thread Mini-Shaft™

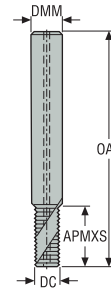
Rotating threading

Annex

Designation	Item number	TDZ	Pitch		Thread profile	DC	DMM	OAL	APMXS	NOF	Through coolant
			TPX	TPIX							
						mm Inch	mm Inch	mm Inch	mm Inch		
TM-MF4X0.5ISO-6R1	02827392	M4	0,5	–	**	3,15 0.124	6,0 0.236	49,0 1.929	8,3 0.327	3	–
TM-MF5X0.5ISO-6R1	02827430	M5	0,5	–	**	3,95 0.156	6,0 0.236	49,0 1.929	10,3 0.406	3	–
TM-MF6X0.75ISO-6R1	02827429	M6	0,75	–	**	4,7 0.185	6,0 0.236	55,0 2.165	12,4 0.488	3	–
TM-MF10X1.0ISO-10R1	02827401	M10	1,0	–	**	7,8 0.307	10,0 0.394	74,0 2.913	20,5 0.807	3	✓
TM-MF12X1.5ISO-12R1	02827400	M12	1,5	–	**	9,4 0.370	12,0 0.472	79,0 3.110	24,8 0.976	3	✓
TM-MF12X1.5ISO-12R1-900	02827365	M12	1,5	–	**	9,4 0.370	12,0 0.472	79,0 3.110	24,8 0.976	3	✓
TM-MF12X1.5ISO-12R1-H	02827355	M12	1,5	–	**	9,4 0.370	12,0 0.472	76,0 2.992	17,9 0.705	5	–
TM-MF14X1.5ISO-14R1-H	02827356	M14	1,5	–	**	10,92 0.430	14,0 0.551	82,0 3.228	21,4 0.843	5	–
TM-MF16X1.5ISO-16R1-H	02827357	M16	1,5	–	**	12,82 0.505	16,0 0.630	94,0 3.701	23,9 0.941	5	–
TM-NR.10X24UNC-6R1	02827491	No.10	–	24.0	***	3,7 0.146	6,0 0.236	49,0 1.929	10,1 0.398	3	–
TM-1/4X20UNC-6R1	02827511	1/4	–	20.0	***	4,7 0.185	6,0 0.236	55,0 2.165	14,6 0.575	3	–
TM-5/16X18UNC-8R1	02827495	5/16	–	18.0	***	6,2 0.244	8,0 0.315	62,0 2.441	16,2 0.638	3	✓
TM-3/8X16UNC-10R1	02827399	3/8	–	16.0	***	7,35 0.289	10,0 0.394	74,0 2.913	19,8 0.780	3	✓
TM-7/16X14UNC-12R1	02827398	7/16	–	14.0	***	8,55 0.337	12,0 0.472	79,0 3.110	22,7 0.894	3	✓
TM-1/2X13UNC-12R1	02827494	1/2	–	13.0	***	9,4 0.370	12,0 0.472	79,0 3.110	26,4 1.039	3	✓
TM-9/16X12UNC-14R1	02827493	9/16	–	12.0	***	10,9 0.429	14,0 0.551	89,0 3.504	30,7 1.209	4	✓

## Threadmaster™

Solid carbide thread milling cutters



- For cutting data see page(s) 192, 193
- TM; 2 x D
- Chamfer angle = 45°

- \* = UNF, for Internal Threading
- \*\* = NPT, for Internal and External Threading
- \*\*\* = NPTF, for Internal and External Threading
- \*\*\*\* = BSP, for Internal and External Threading

Designation	Item number	TDZ	Pitch		Thread profile	DC	DMM	OAL	APMXS	NOF	Through coolant
			TPX	TPIX							
TM-NR.10X32UNF-6R1	02827397	No.10	-	32.0	*	3,95 0.156	6,0 0.236	49,0 1.929	9,9 0.390	3	-
TM-1/4X28UNF-6R1	02827396	1/4	-	28.0	*	4,7 0.185	6,0 0.236	55,0 2.165	14,1 0.555	3	-
TM-5/16X24UNF-8R1	02765298	5/16	-	24.0	*	6,2 0.244	8,0 0.315	62,0 2.441	16,4 0.646	3	✓
TM-3/8X24UNF-10R1	02827395	3/8	-	24.0	*	7,8 0.307	10,0 0.394	74,0 2.913	19,6 0.772	3	✓
TM-7/16X20UNF-12R1	02827394	7/16	-	20.0	*	9,32 0.367	12,0 0.472	79,0 3.110	22,2 0.874	3	✓
TM-1/2X20UNF-12R1	02827393	1/2	-	20.0	*	9,4 0.370	12,0 0.472	79,0 3.110	26,0 1.024	3	✓
TM-9/16X18UNF-14R1	02827492	9/16	-	18.0	*	10,9 0.429	14,0 0.551	89,0 3.504	28,9 1.138	4	✓
TM-1/8X27NPT-12R1	02827435	1/8	-	27.0	**	7,8 0.307	12,0 0.472	70,0 2.756	8,9 0.350	3	✓
TM-1/4X18NPT-16R1	02827434	1/4	-	18.0	**	10,05 0.396	16,0 0.630	81,0 3.189	13,4 0.528	4	✓
TM-3/8X18NPT-18R1	02827409	3/8	-	18.0	**	13,45 0.530	18,0 0.709	81,0 3.189	13,4 0.528	4	✓
TM-1/8X27NPTF-12R1	02827433	1/8	-	27.0	***	7,7 0.303	12,0 0.472	70,0 2.756	8,9 0.350	3	✓
TM-1/4X18NPTF-16R1	02827432	1/4	-	18.0	***	10,0 0.394	16,0 0.630	81,0 3.189	13,4 0.528	4	✓
TM-3/8X18NPTF-18R1	02827410	3/8	-	18.0	***	13,4 0.528	18,0 0.709	81,0 3.189	13,4 0.528	4	✓
TM-1/8X28W-10R1	02827431	1/8	-	28.0	****	7,8 0.307	10,0 0.394	74,0 2.913	20,4 0.803	3	✓
TM-1/4X19W-14R1	02543519	1/4	-	19.0	****	10,9 0.429	14,0 0.551	89,0 3.504	27,4 1.079	4	✓
TM-3/8X19W-18R1	02765294	3/8	-	19.0	****	13,9 0.547	18,0 0.709	102,0 4.016	35,4 1.394	4	✓

Thread turning

Thread MDT

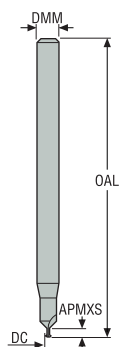
Thread Mini-Shaft™

Rotating threading

Annex

## Threadmaster™ – TM-Mini

Solid carbide thread milling cutters



\* = Metric coarse, for Internal Threading

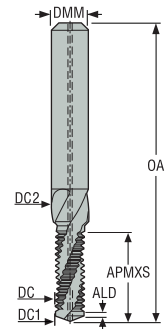


- Left-hand cutter
- For cutting data see page(s) 192, 193
- TM ; 1.5 x D
- Chamfer angle = 90°

Designation	Item number	TDZ	Pitch		Thread profile	DC	DMM	OAL	APMXS	NOF	Through coolant
			TPX	TPIX							
TM-M1.0X0.25ISO-3R1-H	02807939	M1.0	0,25	–	*	0,7 0.028	3,0 0.118	40,0 1.575	2,05 0.081	2	–
TM-M1.4X0.30ISO-3R1-H	02807940	M1.4	0,3	–	*	0,97 0.038	3,0 0.118	40,0 1.575	2,63 0.104	2	–
TM-M1.6X0.35ISO-3R1-H	02807941	M1.6	0,35	–	*	1,15 0.045	3,0 0.118	40,0 1.575	3,07 0.121	2	–
TM-M2.0X0.40ISO-3R1-H	02807942	M2.0	0,4	–	*	1,56 0.061	3,0 0.118	40,0 1.575	3,74 0.147	2	–
TM-M2.2X0.45ISO-3R1-H	02807943	M2.2	0,45	–	*	1,71 0.067	3,0 0.118	40,0 1.575	3,9 0.154	2	–
TM-M2.5X0.45ISO-3R1-H	02807944	M2.5	0,45	–	*	2,01 0.079	3,0 0.118	40,0 1.575	4,45 0.175	3	–

## Drilling Threadmaster™

Solid carbide thread milling cutters



- For cutting data see page(s) 194
- DTM; 2 x D
- Chamfer angle = 90°
- Drill Point = 140°

- \* = Metric coarse
- \*\* = Metric fine
- \*\*\* = UNC
- \*\*\*\* = UNF
- \*\*\*\*\* = BSP

Designation	Item number	TDZ	Pitch		Thread profile	DC	DC1	DC2	DMM	ALD	OAL	APMXS	NOF	Through coolant
			TPX	TPIX										
DTM-M4X0.7ISO-6R1	02827366	M4	0,7	-	*	3,24 0.128	3,3 0.130	4,3 0.169	6,0 0.236	0,7 0.028	49,0 1.929	9,42 0.371	2	✓
DTM-M5X0.8ISO-6R1	02827367	M5	0,8	-	*	4,1 0.161	4,2 0.165	5,3 0.209	6,0 0.236	0,8 0.031	55,0 2.165	11,65 0.459	2	✓
DTM-M6X1.0ISO-8R1	02827368	M6	1,0	-	*	4,85 0.191	5,0 0.197	6,3 0.248	8,0 0.315	1,0 0.039	62,0 2.441	14,49 0.570	2	✓
DTM-M8X1.25ISO-10R1	02827369	M8	1,25	-	*	6,45 0.254	6,75 0.266	8,3 0.327	10,0 0.394	1,2 0.047	74,0 2.913	18,17 0.715	2	✓
DTM-M10X1.5ISO-12R1	02827370	M10	1,5	-	*	8,08 0.318	8,5 0.335	10,3 0.406	12,0 0.472	1,5 0.059	79,0 3.110	23,37 0.920	2	✓
DTM-M12X1.75ISO-14R1	02827371	M12	1,75	-	*	9,74 0.383	10,25 0.404	12,3 0.484	14,0 0.551	1,5 0.059	89,0 3.504	27,06 1.065	2	✓
DTM-M14X2.0ISO-16R1	02827372	M14	2,0	-	*	11,36 0.447	12,0 0.472	14,3 0.563	16,0 0.630	1,5 0.059	102,0 4.016	32,77 1.290	2	✓
DTM-M16X2.0ISO-18R1	02827373	M16	2,0	-	*	13,28 0.523	14,0 0.551	16,3 0.642	18,0 0.709	1,5 0.059	102,0 4.016	37,12 1.461	2	✓
DTM-MF8X1.0ISO-10R1	02827374	M8	1,0	-	**	6,79 0.267	7,0 0.276	8,3 0.327	10,0 0.394	1,0 0.039	74,0 2.913	18,8 0.740	2	✓
DTM-MF10X1.0ISO-12R1	02827375	M10	1,0	-	**	8,75 0.344	9,0 0.354	10,3 0.406	12,0 0.472	1,5 0.059	79,0 3.110	23,18 0.913	2	✓
DTM-MF12X1.5ISO-14R1	02827376	M12	1,5	-	**	10,06 0.396	10,5 0.413	12,3 0.484	14,0 0.551	1,5 0.059	89,0 3.504	28,19 1.110	2	✓
DTM-1/4X20UNC-8R1	02827377	1/4	-	20.0	***	4,7 0.185	5,08 0.200	6,65 0.262	8,0 0.315	1,2 0.047	62,0 2.441	15,71 0.619	2	✓
DTM-5/16X18UNC-10R1	02827378	5/16	-	18.0	***	6,01 0.237	6,53 0.257	8,24 0.324	10,0 0.394	1,4 0.055	74,0 2.913	19,0 0.748	2	✓
DTM-3/8X16UNC-12R1	02827379	3/8	-	16.0	***	7,36 0.290	7,94 0.313	9,83 0.387	12,0 0.472	1,5 0.059	79,0 3.110	22,97 0.904	2	✓
DTM-1/2X13UNC-14R1	02827380	1/2	-	13.0	***	9,87 0.389	10,75 0.423	13,0 0.512	14,0 0.551	1,5 0.059	89,0 3.504	30,07 1.184	2	✓
DTM-1/4X28UNF-8R1	02827381	1/4	-	28.0	****	5,17 0.204	5,44 0.214	6,65 0.262	8,0 0.315	0,9 0.035	62,0 2.441	15,16 0.597	2	✓
DTM-5/16X24UNF-10R1	02827382	5/16	-	24.0	****	6,51 0.256	6,88 0.271	8,24 0.324	10,0 0.394	1,1 0.043	74,0 2.913	18,83 0.741	2	✓
DTM-3/8X24UNF-12R1	02827383	3/8	-	24.0	****	8,07 0.318	8,47 0.333	9,83 0.387	12,0 0.472	1,1 0.043	79,0 3.110	21,2 0.835	2	✓
DTM-1/2X20UNF-14R1	02827384	1/2	-	20.0	****	10,88 0.428	11,43 0.450	13,0 0.512	14,0 0.551	1,3 0.051	89,0 3.504	28,19 1.110	2	✓

Thread turning  
Thread MDT  
Thread Mini-Shaft™  
Rotating threading  
Annex



Designation	Item number	TDZ	Pitch		Thread profile	DC	DC1	DC2	DMM	ALD	OAL	APMXS	NOF	Through coolant
			TPX	TPIX		mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>		
DTM-1/8X28W-12R1	02827385	1/8	-	28.0	*****	8,4 0.331	8,71 0.343	10,03 0.395	12,0 0.472	0,9 0.035	79,0 3.110	22,03 0.867	2	✓
DTM-1/4X19W-16R1	02827386	1/4	-	19.0	*****	11,44 0.450	11,67 0.459	13,46 0.530	16,0 0.630	1,3 0.051	102,0 4.016	29,45 1.159	2	✓

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Threadmaster™ – Cutting data

SMG	TM		TM-900		TM-H		TM-MINI	
	f <sub>z</sub>	v <sub>c</sub>	f <sub>z</sub>	v <sub>c</sub>	f <sub>z</sub>	v <sub>c</sub>	f <sub>z</sub>	v <sub>c</sub>
P1	0,010	145	—	—	—	—	—	—
	0.00040	475	—	—	—	—	—	—
P2	0,010	140	—	—	—	—	—	—
	0.00040	460	—	—	—	—	—	—
P3	0,0095	120	—	—	—	—	—	—
	0.00038	395	—	—	—	—	—	—
P4	0,0095	105	0,0040	105	—	—	—	—
	0.00038	345	0.00016	345	—	—	—	—
P5	0,0090	100	0,0040	100	—	—	—	—
	0.00036	330	0.00016	330	—	—	—	—
P6	0,0090	115	0,0040	115	—	—	—	—
	0.00036	375	0.00016	375	—	—	—	—
P7	0,0090	110	0,0040	110	—	—	—	—
	0.00036	360	0.00016	360	—	—	—	—
P8	0,0095	100	0,0042	100	—	—	—	—
	0.00038	330	0.00017	330	—	—	—	—
P11	0,0090	105	0,0040	105	—	—	—	—
	0.00036	345	0.00016	345	—	—	—	—
P12	0,0060	60	0,0028	60	—	—	—	—
	0.00024	195	0.00011	195	—	—	—	—
M1	0,010	100	0,0044	100	—	—	—	—
	0.00040	330	0.00017	330	—	—	—	—
M2	0,0090	80	0,0040	80	—	—	—	—
	0.00036	260	0.00016	260	—	—	—	—
M3	0,0075	60	0,0032	60	—	—	—	—
	0.00030	195	0.00013	195	—	—	—	—
M4	0,0065	47	0,0028	47	—	—	—	—
	0.00026	155	0.00011	155	—	—	—	—
M5	0,0065	39	0,0028	39	—	—	—	—
	0.00026	130	0.00011	130	—	—	—	—
K1	0,010	145	0,0044	100	—	—	—	—
	0.00040	475	0.00017	330	—	—	—	—
K2	0,0090	125	0,0040	90	—	—	—	—
	0.00036	410	0.00016	295	—	—	—	—
K3	0,0090	105	0,0040	75	—	—	—	—
	0.00036	345	0.00016	245	—	—	—	—
K4	0,0090	100	0,0040	70	—	—	—	—
	0.00036	330	0.00016	230	—	—	—	—
K5	0,0080	60	0,0036	42	—	—	—	—
	0.00032	195	0.00014	140	—	—	—	—
K6	0,0090	90	0,0040	65	—	—	—	—
	0.00036	295	0.00016	215	—	—	—	—
K7	0,0080	80	0,0036	55	—	—	—	—
	0.00032	260	0.00014	180	—	—	—	—
N1	0,013	395	0,0055	335	—	—	—	—
	0.00050	1300	0.00022	1100	—	—	—	—
N2	0,013	255	0,0055	215	—	—	—	—
	0.00050	840	0.00022	710	—	—	—	—
N3	0,013	170	0,0055	145	—	—	—	—
	0.00050	560	0.00022	475	—	—	—	—
N11	0,013	225	0,0055	195	—	—	—	—
	0.00050	740	0.00022	640	—	—	—	—
S1	0,0065	50	0,0028	20	—	—	—	—
	0.00026	165	0.00011	65	—	—	—	—
S2	0,0065	41	0,0028	15	—	—	—	—
	0.00026	135	0.00011	49	—	—	—	—
S3	0,0060	20	0,0026	10	—	—	—	—
	0.00024	65	0.00010	33	—	—	—	—
S11	0,0075	105	0,0032	40	—	—	—	—
	0.00030	345	0.00013	130	—	—	—	—
S12	0,0075	80	0,0032	31	—	—	—	—
	0.00030	260	0.00013	100	—	—	—	—
S13	0,0065	65	0,0028	24	—	—	—	—
	0.00026	215	0.00011	80	—	—	—	—
H3	—	—	—	—	0,0016	19	0,0022	11
	—	—	—	—	0.000065	60	0.000085	36
H5	—	—	—	—	0,0025	36	0,0032	21
	—	—	—	—	0.00010	120	0.00013	70
H7	—	—	—	—	0,0016	19	0,0022	11
	—	—	—	—	0.000065	60	0.000085	36
H8	—	—	—	—	0,0019	36	0,0025	21
	—	—	—	—	0.000075	120	0.00010	70
H11	—	—	—	—	0,0025	45	0,0032	26
	—	—	—	—	0.00010	150	0.00013	85

SMG	TM		TM-900		TM-H		TM-MINI	
	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$
H12	—	—	—	—	0,0019	41	0,0025	24
	—	—	—	—	0,000075	135	0,00010	80
H21	—	—	—	—	0,0019	36	0,0025	21
	—	—	—	—	0,000075	120	0,00010	70

SMG = Seco Material Group  
 $f_z$  = mm/tooth (mm/flute)  
 $v_c$  = m/min  
 All cutting data are start values

All feed are related to the centre of the cutter and not the periphery.

Drilling Threadmaster™ – Cutting data, threadmilling

SMG	DTM	
	$f_z$	$v_c$
K1	0,0065	175
	0.00026	570
K2	0,0060	155
	0.00024	510
K3	0,0060	130
	0.00024	425
K4	0,0060	125
	0.00024	410
K5	0,0055	75
	0.00022	245
K6	0,0060	110
	0.00024	360
K7	0,0055	95
	0.00022	310
N1	0,0085	400
	0.00034	1300
N2	0,0085	255
	0.00034	840
N3	0,0085	170
	0.00034	560
N11	0,0085	225
	0.00034	740

Drilling Threadmaster™ – Cutting data, drilling

SMG	f						$v_c$
	$\varnothing$ 3.01-5.0	$\varnothing$ 5.01-7.0	$\varnothing$ 7.01-9.0	$\varnothing$ 9.01-11.0	$\varnothing$ 11.01-13.0	$\varnothing$ 13.01-15.0	
	$\varnothing$ 0.118-0.196	$\varnothing$ 0.197-0.275	$\varnothing$ 0.276-0.354	$\varnothing$ 0.355-0.433	$\varnothing$ 0.434-0.511	$\varnothing$ 0.512-0.590	
K1	0,12	0,15	0,18	0,19	0,22	0,25	170
	0.0048	0.0060	0.0070	0.0075	0.0085	0.010	560
K2	0,11	0,13	0,16	0,17	0,20	0,22	150
	0.0044	0.0050	0.0065	0.0065	0.0080	0.0085	490
K3	0,11	0,13	0,16	0,17	0,20	0,22	125
	0.0044	0.0050	0.0065	0.0065	0.0080	0.0085	410
K4	0,11	0,13	0,16	0,17	0,20	0,22	120
	0.0044	0.0050	0.0065	0.0065	0.0080	0.0085	395
K5	0,095	0,12	0,14	0,16	0,18	0,20	70
	0.0038	0.0048	0.0055	0.0065	0.0070	0.0080	230
K6	0,11	0,13	0,16	0,17	0,20	0,22	105
	0.0044	0.0050	0.0065	0.0065	0.0080	0.0085	345
K7	0,095	0,12	0,14	0,16	0,18	0,20	90
	0.0038	0.0048	0.0055	0.0065	0.0070	0.0080	295
N1	0,15	0,19	0,22	0,24	0,28	0,32	390
	0.0060	0.0075	0.0085	0.0095	0.011	0.013	1275
N2	0,15	0,19	0,22	0,24	0,28	0,32	250
	0.0060	0.0075	0.0085	0.0095	0.011	0.013	820
N3	0,15	0,19	0,22	0,24	0,28	0,32	165
	0.0060	0.0075	0.0085	0.0095	0.011	0.013	540
N11	0,15	0,19	0,22	0,24	0,28	0,32	220
	0.0060	0.0075	0.0085	0.0095	0.011	0.013	720

SMG = Seco Material Group  
 $f_z$  = mm/tooth (mm/flute)  
 $f$  = mm/rev  
 $v_c$  = m/min  
 All cutting data are start values

Feed are related to the centre of the cutter and not the periphery.

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

## Thread Milling 396.18/19/20 Cutting data

SMG	CP500		F30M		H15	
	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$
P1	0,050	385	0,050	385	—	—
	0.0020	1275	0.0020	1275	—	—
P2	0,055	375	0,055	375	—	—
	0.0022	1225	0.0022	1225	—	—
P3	0,050	325	0,050	325	—	—
	0.0020	1075	0.0020	1075	—	—
P4	0,050	285	0,050	285	—	—
	0.0020	940	0.0020	940	—	—
P5	0,048	275	0,048	275	—	—
	0.0019	900	0.0019	900	—	—
P6	0,048	305	0,048	305	—	—
	0.0019	1000	0.0019	1000	—	—
P7	0,048	290	0,048	290	—	—
	0.0019	950	0.0019	950	—	—
P8	0,050	275	0,050	275	—	—
	0.0020	900	0.0020	900	—	—
P11	0,048	280	0,048	280	—	—
	0.0019	920	0.0019	920	—	—
P12	0,032	165	0,032	165	—	—
	0.0013	540	0.0013	540	—	—
M1	0,055	285	0,055	285	—	—
	0.0022	940	0.0022	940	—	—
M2	0,048	230	0,048	230	—	—
	0.0019	750	0.0019	750	—	—
M3	0,038	175	0,038	175	—	—
	0.0015	570	0.0015	570	—	—
M4	0,034	130	0,034	130	—	—
	0.0013	425	0.0013	425	—	—
M5	0,034	110	0,034	110	—	—
	0.0013	360	0.0013	360	—	—
K1	0,055	300	0,055	300	0,040	270
	0.0022	980	0.0022	980	0.0016	890
K2	0,048	260	0,048	260	0,038	235
	0.0019	850	0.0019	850	0.0015	770
K3	0,048	220	0,048	220	0,038	200
	0.0019	720	0.0019	720	0.0015	660
K4	0,048	210	0,048	210	0,038	190
	0.0019	690	0.0019	690	0.0015	620
K5	0,044	125	0,044	125	0,034	115
	0.0017	410	0.0017	410	0.0013	375
K6	0,048	185	0,048	185	0,038	170
	0.0019	610	0.0019	610	0.0015	560
K7	0,044	160	0,044	160	0,034	145
	0.0017	520	0.0017	520	0.0013	475
N1	0,070	1375	0,070	1375	0,050	1375
	0.0028	4500	0.0028	4500	0.0020	4500
N2	0,070	890	0,070	890	0,050	890
	0.0028	2925	0.0028	2925	0.0020	2925
N3	0,070	590	0,070	590	0,050	590
	0.0028	1925	0.0028	1925	0.0020	1925
N11	0,070	780	0,070	780	—	—
	0.0028	2550	0.0028	2550	—	—

SMG = Seco Material Group

 $f_z$  = mm/tooth (mm/flute)

 $v_c$  = m/min (for holder types -065AM, -079AM and -080AM use factor 0,75 on  $v_c$ )

All cutting data are start values

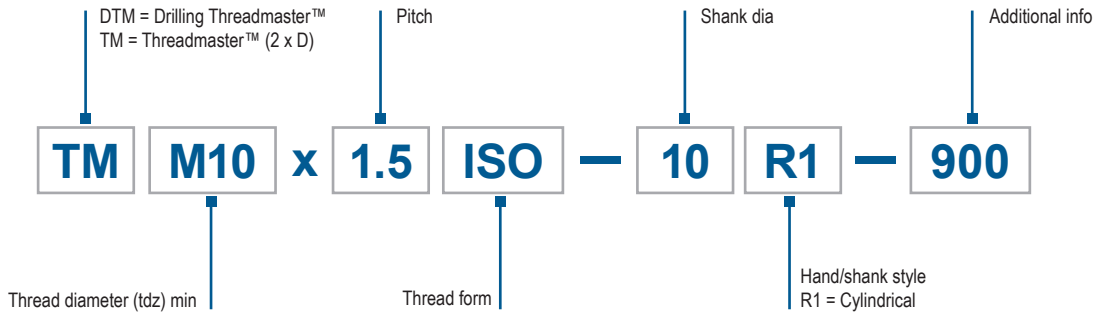
All feed are related to the centre of the cutter and not the periphery.

Cutting speed Thread milling 335.14

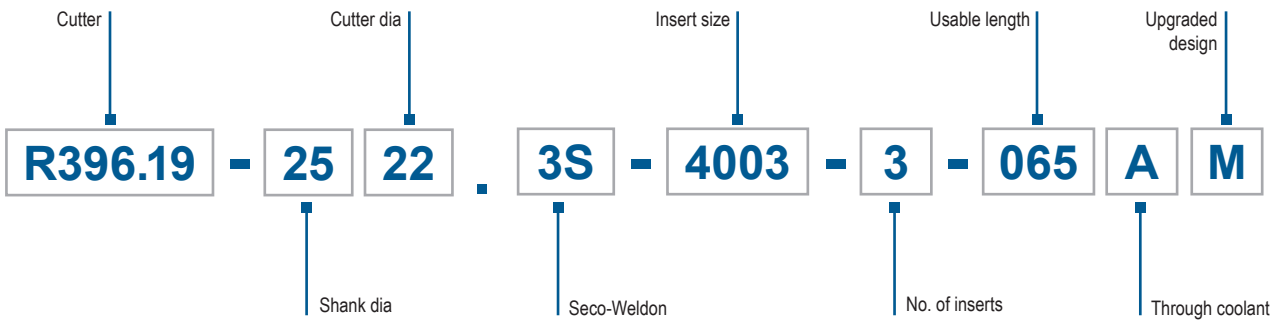
SMG	R335.14	
	$f_z$	$V_c$
P1	0,070	275
	0.0028	900
P2	0,070	270
	0.0028	890
P3	0,070	230
	0.0028	750
P4	0,065	205
	0.0026	670
P5	0,065	195
	0.0026	640
P6	0,065	215
	0.0026	710
P7	0,065	205
	0.0026	670
P8	0,070	195
	0.0028	640
P11	0,065	200
	0.0026	660
P12	0,044	120
	0.0017	395
M1	0,070	215
	0.0028	710
M2	0,065	175
	0.0026	570
M3	0,050	130
	0.0020	425
M4	0,046	100
	0.0018	330
M5	0,046	80
	0.0018	260
K1	0,070	210
	0.0028	690
K2	0,065	185
	0.0026	610
K3	0,065	180
	0.0026	590
K4	0,065	150
	0.0026	490
K5	0,060	90
	0.0024	295
K6	0,065	130
	0.0026	425
K7	0,060	115
	0.0024	375
N1	0,090	970
	0.0036	3175
N2	0,090	620
	0.0036	2025
N3	0,090	415
	0.0036	1350
N11	0,090	475
	0.0036	1550
S1	0,046	50
	0.0018	165
S2	0,046	41
	0.0018	135
S3	0,042	35
	0.0017	115
S11	0,050	65
	0.0020	215
S12	0,050	50
	0.0020	165
S13	0,046	39
	0.0018	130
H5	0,044	43
	0.0017	140
H8	0,034	45
	0.0013	150
H11	0,044	60
	0.0017	195
H12	0,034	55
	0.0013	180
H21	0,034	45
	0.0013	150

# Code keys

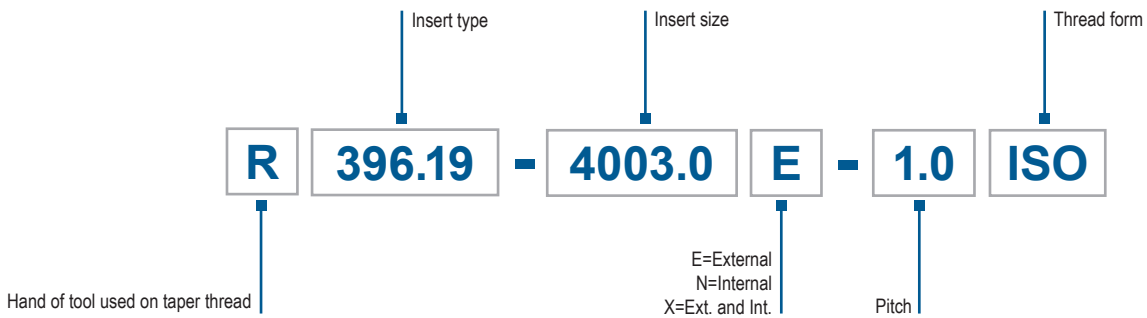
## Threadmaster™



## R396.18/19/20



## Insert 396.19/20



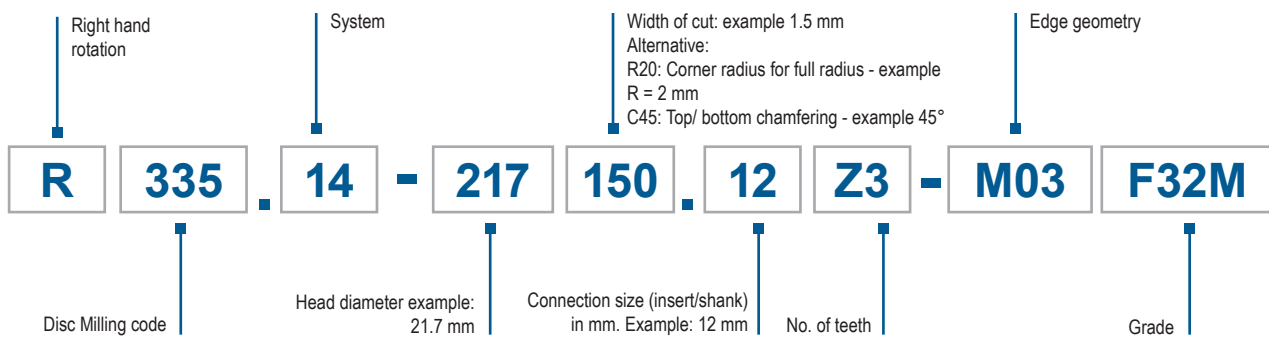
## Code keys

Disc Milling cutter 335.14

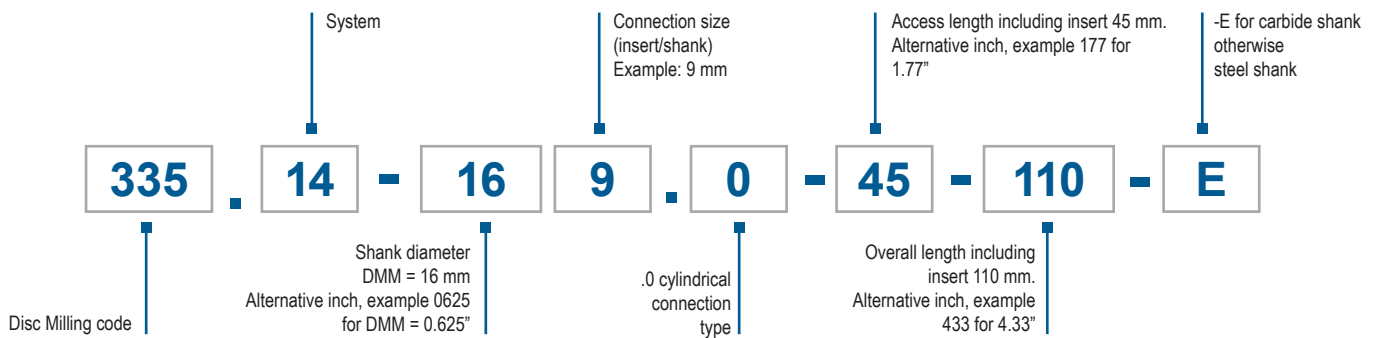


2 types of shanks available: cylindrical available both in steel and carbide, or ER collet chuck system

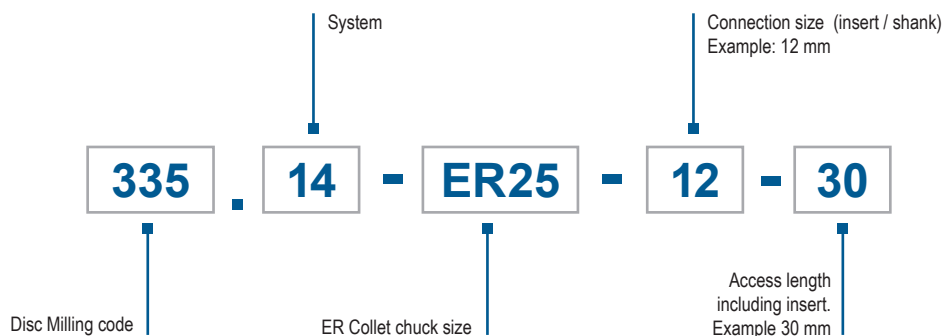
### Threading insert



### Cylindrical shank



### Collet chuck





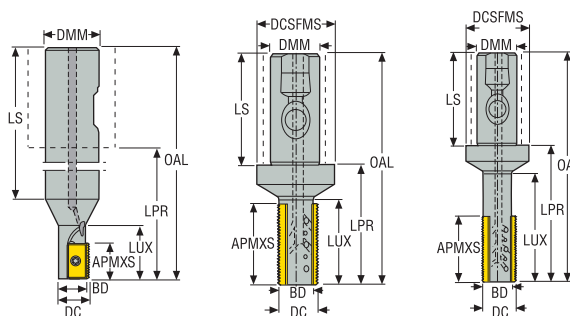


## Thread milling Indexable

Seco 396.18/19/20 thread mills are versatile, cost-effective process tools for anyone facing a variety of threads, parts and workpiece materials on the same machine. Multi-tooth indexable insert cutters use a double sided multi-tooth insert usable above  $\text{Ø}14$  mm for both internal and external threads.

- Inserts available with different thread profiles and pitches
- Multi-tooth cutters for high productivity
- Arbor, Weldon and SecoWeldon shanktypes

# R396.18/R396.19



**Tool angle:**  
GAMO= -15°  
GAMP= 0°  
GAMF= -15°

- For cutting data see page(s) 195
- For insert information see page(s) 206-208
- Min thread diameter, see page(s) 205
- Note: Type of mounting \* = Weldon
- Note: Type of mounting \*\* = Seco-Weldon

Designation	Item number	DC	DMM	OAL	APMXS	BD	DCSFMS	LPR	LUX	LS	Weight	NOF	RPMX	Note	Insert
		mm	mm	mm	mm	mm	mm	mm	mm	mm	kg				
R396.18-2012.3-13A	75036662	12,0	20,0	105,0	13,0	10,0	-	38,0	20,0	67,0	0,2	1	30000	*	13.MS
R396.19-2517.3S-4003-2AM	02534461	17,0	25,0	116,0	25,0	13,0	40,0	60,0	26,0	56,0	0,5	2	22400	**	396.19-4003
R396.19-2522.3S-4003-3AM	02514532	22,0	25,0	116,0	40,0	17,6	40,0	60,0	43,0	56,0	0,4	3	20000	**	396.19-4003
R396.19-2522.3S-4003-3-065AM	02546918	22,0	25,0	140,0	40,0	17,6	40,0	84,0	65,0	56,0	0,5	3	20000	**	396.19-4003
R396.19-2525.3S-4005-2AM	02544660	25,0	25,0	116,0	40,0	19,0	40,0	60,0	43,0	56,0	0,4	2	13600	**	396.19-4005
R396.19-2530.3S-4005-3AM	02546916	30,0	25,0	116,0	40,0	23,0	40,0	60,0	43,0	56,0	0,5	3	12000	**	396.19-4005
R396.19-2530.3S-4005-3-080AM	02544662	30,0	25,0	154,0	40,0	22,2	40,0	98,0	80,0	56,0	0,6	3	12000	**	396.19-4005
R396.19-3232.3S-4003-6AM	02546915	32,0	32,0	120,0	40,0	27,4	50,0	60,0	43,0	60,0	0,7	6	16800	**	396.19-4003
R396.19-3236.3S-4005-6AM	02546917	36,0	32,0	120,0	40,0	28,2	50,0	60,0	42,0	60,0	0,7	6	11200	**	396.19-4005

## Spare Parts

For holders	Fastening screw	Insert key	Insert screw	Key (T-handle)
R396.18	-	H4B-T07P	C02506-T07P	DOUBLE-T
R396.19	P6SS4X4-T09P	T09P-2	-	-

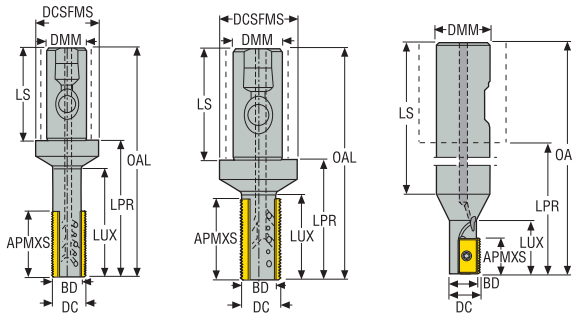
Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

**Note!** When milling threads to smaller diameters than indicated for a certain pitch/cutter combination, an incorrect thread form will result.

**Note!** R396.19-2525.3S-4005-2AM Max pitch size 4,5 ISO/6 TPI can be used.

\*Torque key T00-07P09, T00-09P20.

R396.18/R396.19



**Tool angle:**  
GAMO= -15°  
GAMP= 0°  
GAMF= -15°

- For cutting data see page(s) 195
- For insert information see page(s) 206-208
- Min thread diameter, see page(s) 205
- Note: Type of mounting \* = Weldon
- Note: Type of mounting \*\* = Seco-Weldon

Designation	Item number	DC	DMM	OAL	APMXS	BD	DCSFMS	LPR	LUX	LS	Weight	NOF	RPMX	Note
		<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>lbs</i>			
R396.18-00.39-3-13AT	00087568	0.390	0.750	4.140	0.510	0.310	-	-	0.530	3.610	0.440	1	30000	* 13..
R396.18-00.50-3-13AT	00074293	0.390	0.750	4.134	0.512	0.310	-	-	0.746	2.997	0.440	1	30000	* 13..
R396.18-00.50-3-13A	75054862	0.470	0.750	4.140	0.510	0.390	-	-	0.780	3.360	0.660	1	30000	* 13..
R396.19-00.58-3S-1AM	02546957	0.591	1.000	4.803	1.102	0.450	1.575	2.362	1.024	2.441	1.100	1	22400	** 396.19-4003
R396.19-00.67-3S-4003-2AM	02546937	0.669	1.000	4.547	0.984	0.512	1.575	2.362	1.024	2.185	1.100	2	22000	** 396.19-4003
R396.19-00.87-3S-4003-3AM	02546938	0.866	1.000	4.547	1.575	0.709	1.575	2.362	1.693	2.185	1.100	3	20000	** 396.19-4003
R396.19-00.87-3S-4003-LAM	02546950	0.866	1.000	5.512	1.575	0.709	1.575	3.307	2.559	2.185	1.100	3	20000	** 396.19-4003
R396.19-01.00-3S-4005-2AM	02546944	0.984	1.000	4.547	1.575	0.748	1.575	2.362	1.693	2.185	1.100	2	13600	** 396.19-4005
R396.19-01.18-3S-4005-3AM	02546946	1.181	1.000	4.547	1.575	0.906	1.575	2.362	1.693	2.185	1.100	3	12000	** 396.19-4005
R396.19-01.18-3S-4005-LAM	02546954	1.181	1.000	6.043	1.575	0.906	1.575	3.858	3.150	2.185	1.320	3	12000	** 396.19-4005
R396.19-01.25-3S-4003-6AM	02546941	1.260	1.250	4.547	1.575	1.102	1.969	2.362	1.654	2.343	1.540	6	16800	** 396.19-4003
R396.19-01.42-3S-4005-6AM	02546947	1.417	1.250	4.705	1.575	1.142	1.969	2.362	1.654	2.343	1.540	6	11200	** 396.19-4005

Spare Parts

For holders	Fastening screw	Inducer key	Insert key	Insert screw	Key (T-handle)	Screw
..18-00.39..		-	H4B-T07P	-	DOUBLE-T	C02505-T07P
..18-00.50..A	-	H4B-T07P	-	C02506-T07P	DOUBLE-T	-
..18-00.50..AT	-	-	H4B-T07P	C02506-T07P	DOUBLE-T	-
..19-00.58...19-01.42..	P6SS4X4-T09P	-	T09P-2	-	-	-

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

**Note!** When milling threads to smaller diameters than indicated for a certain pitch/cutter combination, an incorrect thread form will result.

**Note!** R396.19-2525.3S-4005-2AM Max pitch size 4,5 ISO/6 TPI can be used.

\*Torque key T00-07P09, T00-09P20.

Thread turning

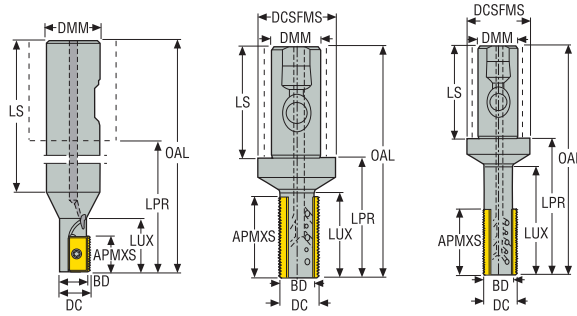
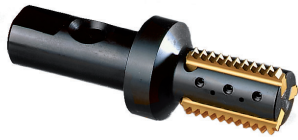
Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

# R396.19



- For cutting data see page(s) 195
- For insert information see page(s) 206-208
- Min thread diameter, see page(s) 205
- Note: Type of mounting \*\* = Seco-Weldon

**Tool angle:**  
GAMO= -15°  
GAMP= 0°  
GAMF= -15°

Designation	Item number	DC	DMM	OAL	APMXS	BD	DCSFMS	LPR	LUX	LS	Weight	NOF	RPMX	Note	Insert
		mm	mm	mm	mm	mm	mm	mm	mm	mm	kg				
R396.19-3232.3S-4003-3-079AM	02963138	32,0	32,0	156,0	40,0	27,4	50,0	96,0	79,57	60,0	0,9	3	20000	**	396.19-4003
R396.19-3232.3S-4005-3-079AM	02963139	32,0	32,0	156,0	40,0	24,2	50,0	96,0	79,0	60,0	0,9	3	11200	**	396.19-4005

## Spare Parts

For holders	Fastening screw	Insert key
R396.19	P6SS4X4-T09P	T09P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

**Note!** When milling threads to smaller diameters than indicated for a certain pitch/cutter combination, an incorrect thread form will result.

**Note!** R396.19-2525.3S-4005-2AM Max pitch size 4,5 ISO/6 TPI can be used.

\*Torque key T00-07P09, T00-09P20.

Thread turning

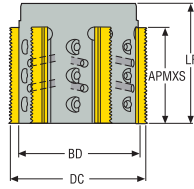
Thread MDT

Thread Mini-Start™

Rotating threading

Annex

R396.19



**Tool angle:**  
GAMO= -15°  
GAMP= 0°  
GAMF= -15°

- For cutting data see page(s) 195
- For insert information see page(s) 206-208
- Min thread diameter, see page(s) 205

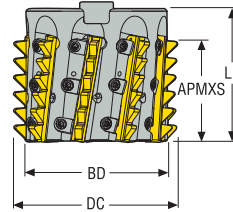
Designation	Item number	DC	APMXS	BD	LF	Weight	NOF	RPMX	Insert
		mm	mm	mm	mm	kg			
R396.19-0058-4003-6AM	02546921	58,0	40,0	53,0	50,0	0,7	6	8600	396.19-4003
R396.19-0058-4005-6AM	02546920	58,0	40,0	50,0	50,0	0,6	6	8600	396.19-4005

Spare Parts

For holders	Arbor screw	Fastening screw	Insert key
...6AM	MC6S12X40	P6SS4X4-T09P	T09P-2

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store  
\*Torque values 2 Nm. Torque key, T00-09P20.

# R396.20



- For cutting data see page(s) 195
- For insert information see page(s) 209
- Min thread diameter, see page(s) 205

**Tool angle:**  
GAMO= -15°  
GAMP= -15°  
GAMF= -15°

Designation	Item number	DC	APMXS	BD	LF	Weight	NOF	RPMX	Insert
		<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>Inch</i>	<i>lbs</i>			
R396.20-02.478-4005-9AW	03013869	2.480	1.575	2.106	1.969	1.320	9	8600	396.20-4005

## Spare Parts

For holders	Arbor screw	Key	Key (T-handle)	Wedge clamp	Wedge screw
R396.20	UC6S1/2UNFX1-1/2	H4B-T08P	DOUBLE-T	CW0405M	LD4012-T08P

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store  
\*Torque values 2 Nm. Torque key, T00-09P20.

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex

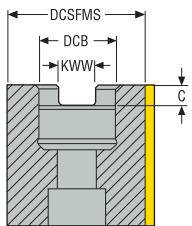
## Min thread diameter (major dia), for different pitch and cutter combinations

R396.18/R396.19/R396.20

For cutter	Pitch mm TPI										
	1 24	1,5 16	2 12	2,5 10	3 8	3,5 7	4 6	4,5	5 5	5,5	6 4
R396.18-2012.3-13A	14	15	16	-	-	-	-	-	-	-	-
R396.19-2517.3S-4003-2AM	19	20	21	22	24	-	-	-	-	-	-
R396.19-2522.3S-4003-3AM	24	25	26	27	27	-	-	-	-	-	-
R396.19-2522.3S-4003-3-065AM	24	25	26	27	27	-	-	-	-	-	-
R396.19-3232.3S-4003-6AM	34	35	36	39	40	-	-	-	-	-	-
R396.19-2525.3S-4005-2AM	-	-	-	-	30	33	35	37	-	-	-
R396.19-2530.3S-4005-3AM	-	-	-	-	38	40	42	44	45	47	48
R396.19-2530.3S-4005-3-080AM	-	-	-	-	38	40	42	44	45	47	48
R396.19-3236.3S-4005-6AM	-	-	-	-	43	45	47	47	48	50	53
R396.19-0058-4003-6AM	62	63	65	66	67	-	-	-	-	-	-
R396.19-0058-4005-6AM	-	-	-	-	67	69	70	71	72	73	74
R396.19-3232.3S-4003-3-079AM	34	35	36	39	40	-	-	-	-	-	-
R396.19-3232.3S-4005-3-079AM	-	-	-	-	39	41	43	45	46	48	49
R396.20-02.478-4005-9AW	-	-	-	-	80	-	84	-	-	-	89

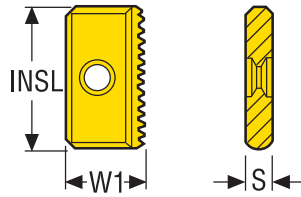
**Note!** When milling threads to smaller diameters than indicated for a certain pitch/cutter combination, an incorrect thread form will result.

### Dimensions of mounting



For cutter	Item number	DCB	DCSFMS	KWW	C	For arbor
		mm	mm	mm	mm	
R396.19-0058-4003-6AM	02546921	27,0	53,0	12,4	7,0	27
R396.19-0058-4005-6AM	02546920	27,0	50,0	12,4	7,0	27
R396.20-02.478-4005-9AW	03013869	25,4	53,5	9,7	5,7	25,4

# 13NMS/XMS



Tolerances:  
INSL = ± 0,012 mm  
HC = ± 0,012 mm  
S = ± 0,025 mm

Designation	Insert	INSL	S	Grades
		mm <i>Inch</i>	mm <i>Inch</i>	CP500
13NMS1.0ISO	For internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■
13NMS1.5ISO	For internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■
13NMS2.0ISO	For internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■
13NMS24UN	For internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■
13NMS20UN	For internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■
13NMS16UN	For internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■
13XMS19W	For external and internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■
13XMS14W	For external and internal threading	13,0 <i>0.512</i>	2,5 <i>0.098</i>	■

■ **Stock standard.** Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Start™

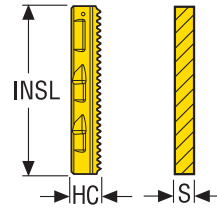
Rotating threading

Annex



396.19-4003

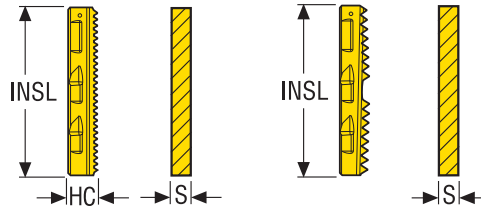
Tolerances:  
INSL = ± 0,007 mm,  
HC = ± 0,012 mm,  
S = ± 0,05 mm



Designation	Insert	INSL		S		Grades	
		mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	F30M	H15
396.19-4003.0E1.0ISO	For external threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0E1.5ISO	For external threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0E2.0ISO	For external threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0E18UN	For external threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0E16UN	For external threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0E14UN	For external threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0E12UN	For external threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0N1.0ISO	For internal threading	40,0 1.575	3,5 0.138			■	■
396.19-4003.0N1.5ISO	For internal threading	40,0 1.575	3,5 0.138			■	■
396.19-4003.0N2.0ISO	For internal threading	40,0 1.575	3,5 0.138			■	■
396.19-4003.0N2.5ISO	For internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0N3.0ISO	For internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0N20UN	For internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0N18UN	For internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0N16UN	For internal threading	40,0 1.575	3,5 0.138			■	■
396.19-4003.0N14UN	For internal threading	40,0 1.575	3,5 0.138			■	■
396.19-4003.0N12UN	For internal threading	40,0 1.575	3,5 0.138			■	■
396.19-4003.0N10UN	For internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0N9UN	For internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0N8UN	For internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0X16W	For external and internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0X14W	For external and internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0X12W	For external and internal threading	40,0 1.575	3,5 0.138			■	
396.19-4003.0X11W	For external and internal threading	40,0 1.575	3,5 0.138			■	

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

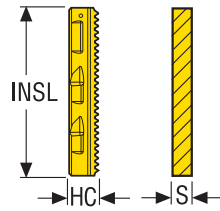
## 396.19-4003/4005



Designation	Insert	INSL		S		Grades	
		mm Inch	mm Inch	mm Inch	F30M	H15	
396.19-4005.0N3.5ISO	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N4.0ISO	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N4.5ISO	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N5.0ISO	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N5.5ISO	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N6.0ISO	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N7UN	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N6UN	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N5UN	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N4.5UN	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0N4UN	For internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
396.19-4005.0X8W	For external and internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
R396.19-4003.0X14NPT	For external and internal threading	40,0 1.575	3,5 0.138	3,5 0.138	■		
R396.19-4003.0X11.5NPT	For external and internal threading	40,0 1.575	3,5 0.138	3,5 0.138	■		
R396.19-4005.0X8NPT	For external and internal threading	40,0 1.575	4,85 0.191	4,85 0.191	■		
R396.19-4003.0X14NPTF	For external and internal threading	40,0 1.575	3,5 0.138	3,5 0.138	■		
R396.19-4003.0X11.5NPTF	For external and internal threading	40,0 1.575	3,5 0.138	3,5 0.138	■		
R396.19-4003.0X14BSPT	For external and internal threading	40,0 1.575	3,5 0.138	3,5 0.138	■		
R396.19-4003.0X11BSPT	For external and internal threading	40,0 1.575	3,5 0.138	3,5 0.138	■		
396.19-4003XX	Non cutting blank	40,0 1.575	3,5 0.138			■	
396.19-4005XX	Non cutting blank	40,0 1.575	4,85 0.191			■	

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

396.20-4005



Designation	Insert	INSL	S	Grades
		mm Inch	mm Inch	F30M
396.20-4005.0N3ACME	For internal threading	40,0 1.575	4,9 0.193	■
396.20-4005.0N4ACME	For internal threading	40,0 1.575	4,9 0.193	■
396.20-4005.0N8ACME	For internal threading	40,0 1.575	4,9 0.193	■
396.20-4005.0N4BUT	For internal threading	40,0 1.575	4,85 0.191	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

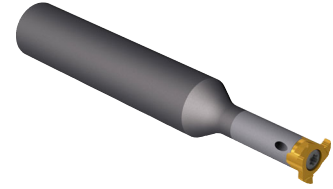
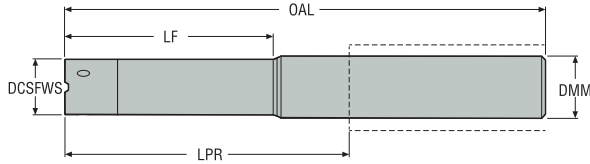


## Thread milling Shanks

Generate precision threads in holes as deep as 106 mm with Seco's new single raw Disc Mill 335.14 interchangeable threading heads and matching holder shanks. You will also be able to boost processing speed and versatility, as each head performs both chamfering and threading operations. Additionally, performing two operations with the same tool helps reduce required tooling inventories.

- Both carbide and steel shank types
- Internal coolant capability
- Over 31 different carbide-coated heads

## 335.14 Shank - Cylindrical version



- For cutting data see page(s) 196
- Technical information, see page 183
- -E = Carbide shank with DMM tolerance = h6
- Steel shank: DMM tolerance = g6
- Max RPM = 30 000 rev/min

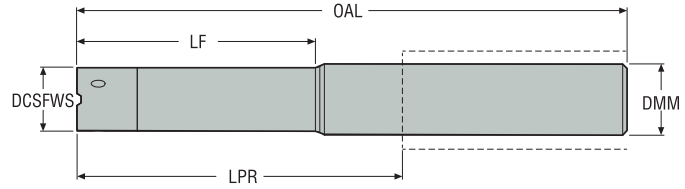
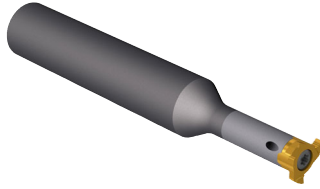
Designation	Item number	DCSFWS	DMM	LF	OAL	LPR	Weight	Through coolant	Insert
		mm	mm	mm	mm	mm	kg		
335.14-1006.0-015-060	03042024	6,0	10,0	11,5	56,5	16,5	0,1	–	R335.14...06Z..
335.14-1206.0-021-080-E	03042025	6,0	12,0	17,5	76,5	31,5	0,1	✓	R335.14...06Z..
335.14-1206.0-030-090-E	03042026	6,0	12,0	26,5	86,5	41,5	0,1	✓	R335.14...06Z..
335.14-1206.0-042-100-E	03042027	6,0	12,0	38,5	96,5	51,5	0,1	✓	R335.14...06Z..
335.14-1008.0-017-060	03042040	8,0	10,0	12,5	55,5	15,5	0,1	–	R335.14...08Z..
335.14-1208.0-029-095-E	03042041	8,0	12,0	24,5	90,5	45,5	0,2	✓	R335.14...08Z..
335.14-1208.0-042-110-E	03042042	8,0	12,0	37,5	105,5	60,5	0,2	✓	R335.14...08Z..
335.14-1208.0-056-120-E	03042043	8,0	12,0	51,5	115,5	70,5	0,2	✓	R335.14...08Z..
335.14-1609.0-018-080	03042028	9,0	16,0	12,2	74,2	26,2	0,1	✓	R335.14...09Z..
335.14-1609.0-032-100-E	03042029	9,0	16,0	26,2	94,2	46,2	0,2	✓	R335.14...09Z..
335.14-1609.0-045-110-E	03042030	9,0	16,0	39,2	104,2	56,2	0,2	✓	R335.14...09Z..
335.14-1609.0-064-130-E	03042031	9,0	16,0	58,2	124,2	76,2	0,3	✓	R335.14...09Z..
335.14-1612.0-024-080	03042032	12,0	16,0	18,3	74,3	26,3	0,1	✓	R335.14...12Z..
335.14-1612.0-042-100-E	03042033	12,0	16,0	36,3	94,3	46,3	0,2	✓	R335.14...12Z..
335.14-1612.0-060-130-E	03042034	12,0	16,0	54,3	124,3	76,3	0,3	✓	R335.14...12Z..
335.14-1612.0-085-160-E	03042035	12,0	16,0	76,3	154,3	106,3	0,3	✓	R335.14...12Z..
335.14-1614.0-042-100-E	03042036	14,3	16,0	35,5	93,5	45,5	0,3	✓	R335.14...14Z..
335.14-1614.0-060-130-E	03042037	14,3	16,0	53,5	123,5	75,5	0,3	✓	R335.14...14Z..
335.14-1614.0-085-160-E	03042038	14,3	16,0	78,5	153,5	105,5	0,4	✓	R335.14...14Z..
335.14-2014.0-036-100	03042039	14,0	20,0	29,2	93,5	43,5	0,2	✓	R335.14...14Z..

### Spare Parts

For cutter	Insert key	Insert screw	Key (T-handle)
335.14...06	H4B-T08P	C92608-T08P	DOUBLE-T
335.14...08	H4B-T10P	C93510-T10P	DOUBLE-T
335.14...09	H4B-T15P	C94012-T15P	DOUBLE-T
335.14...12/14	H6B-T20P	C95012-T20P	DOUBLE-T

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## 335.14 Shank - Cylindrical version



- For cutting data see page(s) 196
- Technical information, see page 183
- -E = Carbide shank with DMM tolerance = h6
- Steel shank: DMM tolerance = g6
- Max RPM = 30 000 rev/min

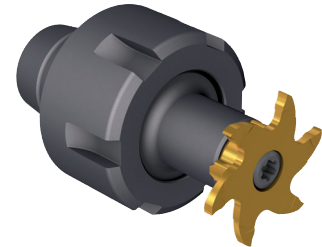
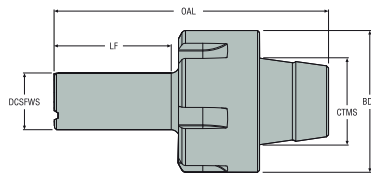
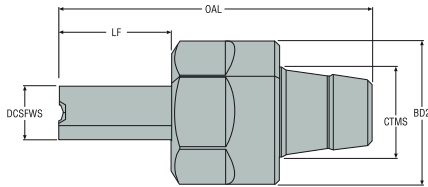
Designation	Item number	DCSFWS	DMM	LF	OAL	LPR	Weight	Through coolant	Insert
		Inch	Inch	Inch	Inch	Inch	lbs		
335.14-050006.0-083-315-E	03042121	0.236	0.500	0.689	3.012	1.240	0.220	✓	R334.14...06Z..
335.14-050006.0-118-354-E	03042122	0.236	0.500	1.043	3.406	1.634	0.440	✓	R334.14...06Z..
335.14-050006.0-165-394-E	03042107	0.236	0.500	1.516	3.799	2.028	0.440	✓	R334.14...06Z..
335.14-050008.0-114-374-E	03042123	0.315	0.500	0.965	3.563	1.791	0.440	✓	R334.14...08Z..
335.14-050008.0-165-433-E	03042124	0.315	0.500	1.476	4.154	2.382	0.440	✓	R334.14...08Z..
335.14-050008.0-220-472-E	03042119	0.315	0.500	2.028	4.547	2.776	0.440	✓	R334.14...08Z..
335.14-062509.0-071-315	03042108	0.354	0.625	0.480	2.921	1.031	0.220	✓	R334.14...09Z..
335.14-062509.0-126-394-E	03042109	0.354	0.625	1.031	3.709	1.819	0.440	✓	R334.14...09Z..
335.14-062509.0-177-433-E	03042110	0.354	0.625	1.543	4.102	2.213	0.440	✓	R334.14...09Z..
335.14-062509.0-252-512-E	03042111	0.354	0.625	2.291	4.890	3.000	0.660	✓	R334.14...09Z..
335.14-062512.0-094-315	03042112	0.472	0.625	0.720	2.925	1.035	0.220	✓	R334.14...12Z..
335.14-062512.0-165-394-E	03042113	0.472	0.625	1.429	3.713	1.823	0.440	✓	R334.14...12Z..
335.14-062512.0-236-512-E	03042114	0.472	0.625	2.138	4.894	3.004	0.660	✓	R334.14...12Z..
335.14-062512.0-335-630-E	03042115	0.472	0.625	3.122	6.075	4.185	0.660	✓	R334.14...12Z..
335.14-062514.0-165-394-E	03042116	0.551	0.625	1.398	3.681	1.791	0.440	✓	R334.14...14Z..
335.14-062514.0-236-512-E	03042117	0.551	0.625	2.106	4.862	2.972	0.660	✓	R334.14...14Z..
335.14-062514.0-335-630-E	03042118	0.551	0.625	3.091	6.043	4.154	0.880	✓	R334.14...14Z..

### Spare Parts

For cutter	Insert key	Insert screw	Key (T-handle)
335.14-..06	H4B-T08P	C92608-T08P	DOUBLE-T
335.14-..08	H4B-T10P	C93510-T10P	DOUBLE-T
335.14-..09	H4B-T15P	C94012-T15P	DOUBLE-T
335.14-..12/14	H6B-T20P	C95012-T20P	DOUBLE-T

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store




## 335.14 Shank with ER collet



- For cutting data see page(s) 196
- Technical information, see page 183

Designation	Item number	DCSFWS	BD2	LF	OAL	CTMS	Weight	Through coolant	Insert
		mm	mm	mm	mm	mm	kg		
335.14-ER11-06-016	03042072	6,0	16,0	12,5	34,9	ER 11	0,1	–	R335.14...06Z..
335.14-ER11-08-016	03042085	8,0	16,0	11,5	33,8	ER 11	0,1	–	R335.14...08Z..
335.14-ER16-08-022	03042086	8,0	32,0	17,5	49,6	ER 16	0,2	–	R335.14...08Z..
335.14-ER11-09-022	03042073	9,0	16,0	16,2	38,5	ER 11	0,1	–	R335.14...09Z..
335.14-ER16-09-022	03042074	9,0	32,0	16,2	48,3	ER 16	0,2	–	R335.14...09Z..
335.14-ER25-09-022	03042075	9,0	35,0	16,2	55,3	ER 25	0,2	–	R335.14...09Z..
335.14-ER16-12-030	03042076	12,0	32,0	24,3	56,4	ER 16	0,2	–	R335.14...12Z..
335.14-ER25-12-030	03042078	12,0	35,0	24,3	63,4	ER 25	0,2	–	R335.14...12Z..
335.14-ER32-12-030	03042079	12,0	50,0	24,3	69,4	ER 32	0,4	–	R335.14...12Z..
335.14-ER25-14-019	03042080	14,0	35,0	12,5	52,3	ER 25	0,2	–	R335.14...14Z..
335.14-ER25-14-035	03042081	14,0	35,0	28,5	67,6	ER 25	0,2	–	R335.14...14Z..
335.14-ER32-14-019	03042082	14,0	50,0	12,5	58,3	ER 32	0,4	–	R335.14...14Z..
335.14-ER32-14-035	03042083	14,0	50,0	28,5	73,6	ER 32	0,4	–	R335.14...14Z..

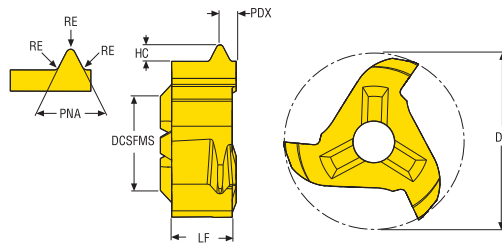
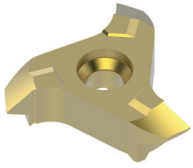
### Spare Parts

For cutter	Insert key	Insert screw	Key (T-handle)
			
335.14-ER...06	H4B-T08P	C92608-T08P	DOUBLE-T
335.14-ER...08	H4B-T10P	C93510-T10P	DOUBLE-T
335.14-ER...09	H4B-T15P	C94012-T15P	DOUBLE-T
335.14-ER...12/14	H6B-T20P	C95012-T20P	DOUBLE-T

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## 335.14 Insert

Thread profile Whitworth - Metric



- For cutting data see page(s) 196
- Technical information, see page 183

Designation	Pitch	RE	DC	DCSFMS	HC	LF	PDX	PNA	ZEFP	Grades
	mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		
R335.14-117WXF11.06Z3	– 11.000	0,31 0.012	11,7 0.461	6,0 0.236	1,48 0.058	3,6 0.142	1,6 0.063	55,0 2.165	3	■
R335.14-117WXF14.06Z3	– 14.000	0,24 0.009	11,7 0.461	6,0 0.236	1,16 0.046	3,6 0.142	1,3 0.051	55,0 2.165	3	■
R335.14-117WXF19.06Z3	– 19.000	0,18 0.007	11,7 0.461	6,0 0.236	0,86 0.034	3,6 0.142	1,1 0.043	55,0 2.165	3	■
R335.14-157WXF14.08Z3	– 14.000	0,24 0.009	15,7 0.618	8,0 0.315	1,17 0.046	4,6 0.181	1,5 0.059	55,0 2.165	3	■
R335.14-177WXF11.09Z3	– 11.000	0,31 0.012	17,7 0.697	9,0 0.354	1,48 0.058	5,85 0.230	1,45 0.057	55,0 2.165	3	■
R335.14-177WXF14.09Z3	– 14.000	0,24 0.009	17,7 0.697	9,0 0.354	1,16 0.046	5,85 0.230	1,25 0.049	55,0 2.165	3	■
R335.14-177WXF19.09Z3	– 19.000	0,18 0.007	17,7 0.697	9,0 0.354	0,856 0.034	5,85 0.230	0,95 0.037	55,0 2.165	3	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Start™

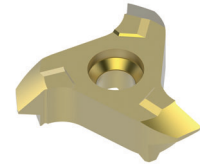
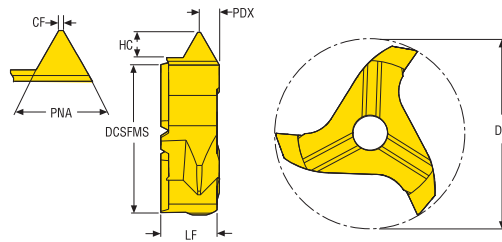
Rotating threading

Annex



# 335.14 Insert

Thread profile Partial Metric



- For cutting data see page(s) 196
- Technical information, see page 183

Designation	Pitch		DC mm Inch	DCSFMS mm Inch	HC mm Inch	LF mm Inch	PDX mm Inch	PNA mm Inch	ZEFP	Grades
	mm TPN Inch TPN	mm TPX Inch TPX								
R335.14-117MNP100200.06Z3	1,0 0.039	2,0 0.079	11,7 0.461	6,0 0.236	1,25 0.049	3,6 0.142	0,8 0.031	60,0 2.362	3	■
R335.14-117MNP200300.06Z3	2,0 0.079	3,0 0.118	11,7 0.461	6,0 0.236	1,78 0.070	3,6 0.142	1,2 0.047	60,0 2.362	3	■
R335.14-157MNP150275.08Z3	1,5 0.059	2,75 0.108	15,7 0.618	8,0 0.315	1,67 0.066	4,6 0.181	1,1 0.043	60,0 2.362	3	■
R335.14-157MNP250300.08Z3	2,5 0.098	3,0 0.118	15,7 0.618	8,0 0.315	1,78 0.070	4,6 0.181	1,2 0.047	60,0 2.362	3	■
R335.14-177MNP100200.09Z3	1,0 0.039	2,0 0.079	17,7 0.697	9,0 0.354	1,19 0.047	5,85 0.230	1,15 0.045	60,0 2.362	3	■
R335.14-177MNP150275.09Z3	1,5 0.059	2,75 0.108	17,7 0.697	9,0 0.354	1,62 0.064	5,85 0.230	1,25 0.049	60,0 2.362	3	■
R335.14-177MNP200375.09Z3	2,0 0.079	3,75 0.148	17,7 0.697	9,0 0.354	2,22 0.087	5,85 0.230	1,65 0.065	60,0 2.362	3	■
R335.14-177MNP300550.09Z3	3,0 0.118	5,5 0.217	17,7 0.697	9,0 0.354	3,25 0.128	5,85 0.230	2,25 0.089	60,0 2.362	3	■
R335.14-217MNP100200.12Z3	1,0 0.039	2,0 0.079	21,7 0.854	12,0 0.472	1,19 0.047	5,85 0.230	1,25 0.049	60,0 2.362	3	■
R335.14-217MNP200375.12Z3	2,0 0.079	3,75 0.148	21,7 0.854	12,0 0.472	2,22 0.087	5,85 0.230	1,65 0.065	60,0 2.362	3	■
R335.14-217MNP250450.12Z3	2,5 0.098	4,5 0.177	21,7 0.854	12,0 0.472	2,7 0.106	5,85 0.230	2,15 0.085	60,0 2.362	3	■
R335.14-217MNP350600.12Z3	3,5 0.138	6,0 0.236	21,7 0.854	12,0 0.472	3,84 0.151	5,85 0.230	2,65 0.104	60,0 2.362	3	■
R335.14-277MNP250500.14Z3	2,5 0.098	5,0 0.197	27,7 1.091	14,0 0.551	2,93 0.115	6,6 0.260	2,6 0.102	60,0 2.362	3	■
R335.14-277MNP400600.14Z3	4,0 0.157	6,0 0.236	27,7 1.091	14,0 0.551	4,6 0.181	6,6 0.260	3,0 0.118	60,0 2.362	3	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

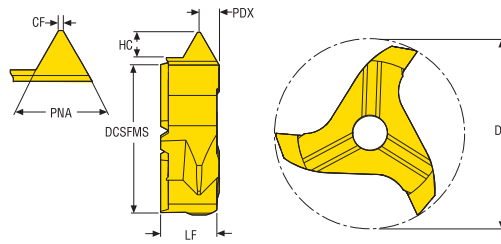
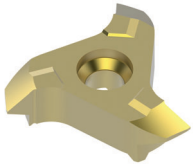
Thread Mini-Shaft™

Rotating threading

Annex

## 335.14 Insert

Thread profile UN - Metric



- For cutting data see page(s) 196
- Technical information, see page 183

Designation	Pitch	DC	DCSFMS	HC	LF	PDX	PNA	ZEFP	Grades
	mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch		
R335.14-177UNNF10.09Z3	– 10.000	17,7 0.697	9,0 0.354	1,375 0.054	5,85 0.230	1,25 0.049	60,0 2.362	3	■
R335.14-177UNNF11.09Z3	– 11.000	17,7 0.697	9,0 0.354	1,249 0.049	5,85 0.230	1,05 0.041	60,0 2.362	3	■
R335.14-177UNNF12.09Z3	– 12.000	17,7 0.697	9,0 0.354	1,146 0.045	5,85 0.230	1,05 0.041	60,0 2.362	3	■
R335.14-177UNNF14.09Z3	– 14.000	17,7 0.697	9,0 0.354	0,982 0.039	5,85 0.230	0,85 0.033	60,0 2.362	3	■
R335.14-177UNNF16.09Z3	– 16.000	17,7 0.697	9,0 0.354	0,859 0.034	5,85 0.230	0,85 0.033	60,0 2.362	3	■
R335.14-177UNNF18.09Z3	– 18.000	17,7 0.697	9,0 0.354	0,763 0.030	5,85 0.230	0,85 0.033	60,0 2.362	3	■
R335.14-177UNNF20.09Z3	– 20.000	17,7 0.697	9,0 0.354	0,687 0.027	5,85 0.230	0,65 0.026	60,0 2.362	3	■
R335.14-177UNNF24.09Z3	– 24.000	17,7 0.697	9,0 0.354	0,572 0.023	5,85 0.230	0,65 0.026	60,0 2.362	3	■
R335.14-177UNNF6.09Z3	– 6.000	17,7 0.697	9,0 0.354	2,291 0.090	5,85 0.230	1,65 0.065	60,0 2.362	3	■
R335.14-177UNNF8.09Z3	– 8.000	17,7 0.697	9,0 0.354	1,718 0.068	5,85 0.230	1,45 0.057	60,0 2.362	3	■

■ Stock standard. Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store



## Threadmaster™ Taps

Designed to be universal in application, the high-speed steel Threadmaster Tap effectively threads holes in a wide range of workpiece types and materials. The tool features an advanced coating technology that enables it to achieve higher cutting data and output in steel up to 350 HB, stainless steels and cast irons when compared to the uncoated solutions typically found in this product area.

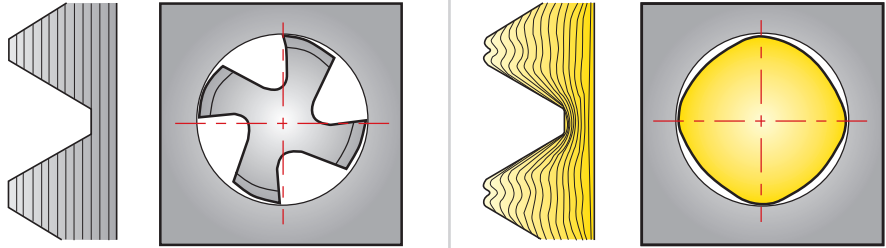
- Features spiral helixes for blind holes and spiral points for through holes.
- Straight flutes accommodate for short chipping materials
- Advanced coatings for faster tapping

# Introduction to taps

## What are you looking for in a thread?

### Cutting a thread vs forming a thread

There are two way of making a thread, cutting or forming. Cutting is to be used in most materials, while forming is to be used in steel, stainless steel and aluminium.



### Through hole, blind hole

Taps have different designs. Depending on application (through or blind hole).



### Hole size

Dimension of the hole differs between cutting and forming the thread.

Cutting tap  
 $D = TD - PTH$

Forming tap  
 $D = TD - PTH/2$   
 $(D = D_{nom} - 0.0068 \times PTH \times 65)$

D = Hole diameter  
 TD = Major thread diameter  
 PTH = Thread pitch



Thread turning

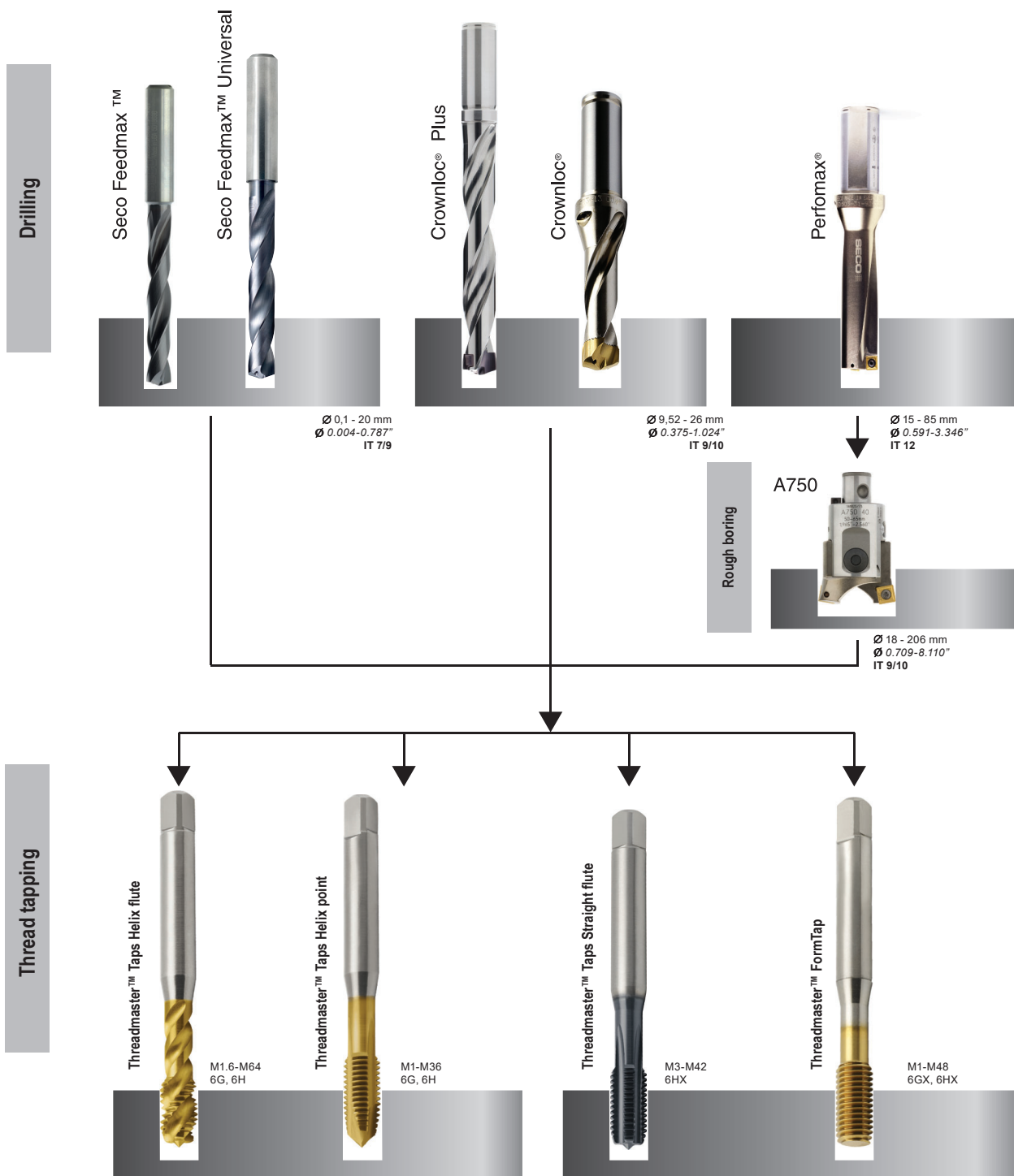
Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

# Introduction to taps – Tool guide



Also other threading profiles are available.

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

## Taps – Choice of Tap tolerance

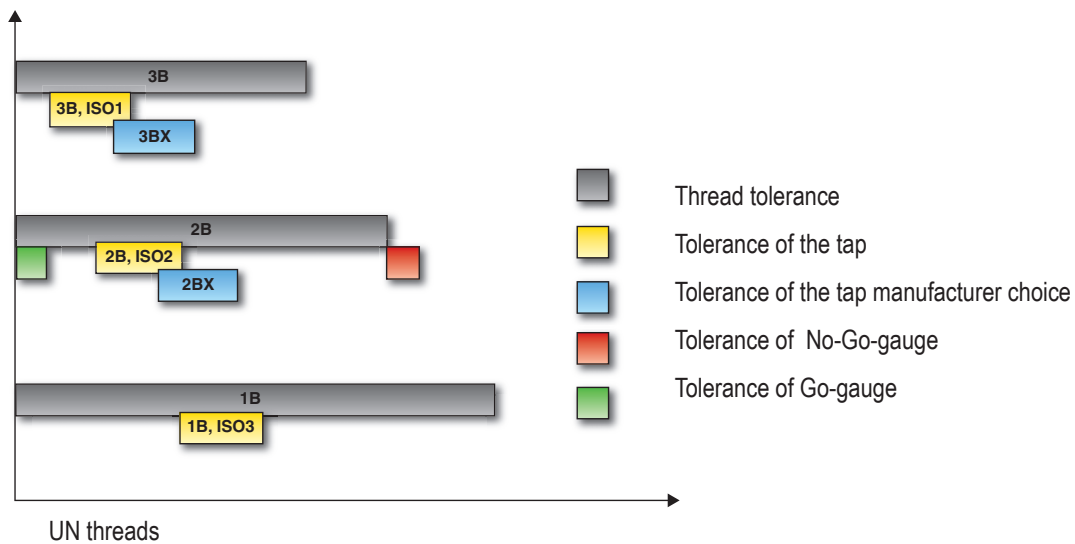
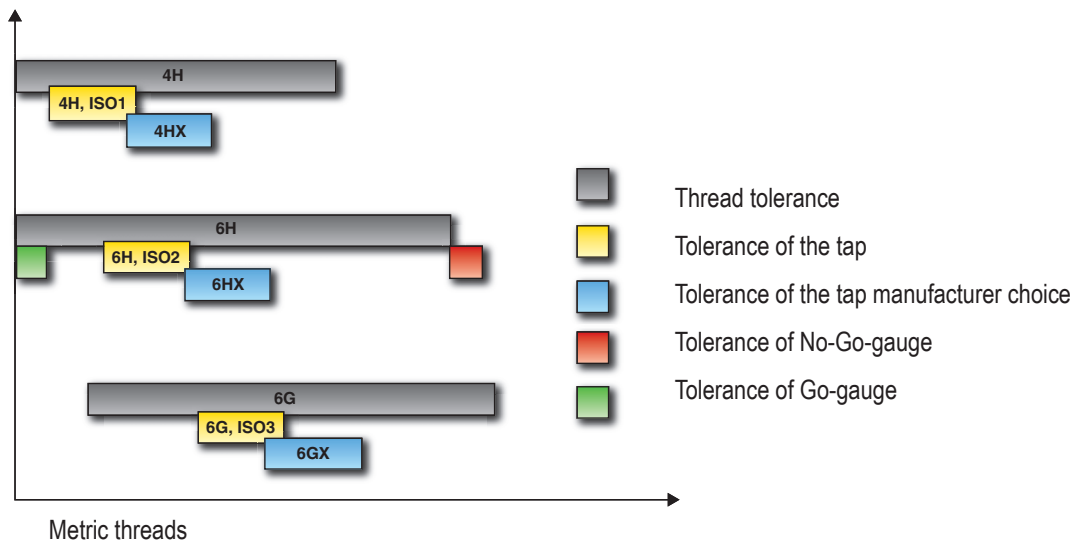
The Threadmaster™ Taps from Seco are available for threads with different tolerances 6H and 6G, as well in 6HX and 6GX.

Normal standard tolerance is H.

Tolerance GX/HX and BX is to be used when risk of oversize is limited, this also increases tool life of the tap.

Taps for UNC/UNF are designed for tolerance 2B.

Tolerance class for G and NPT/NPTF is normal.



Thread turning

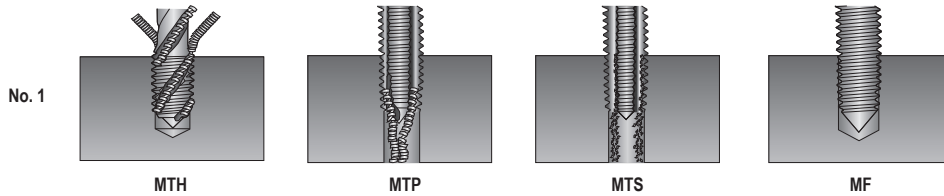
Thread MDT

Thread Mini-Start™

Rotating threading

Annex

## Code key – Taps

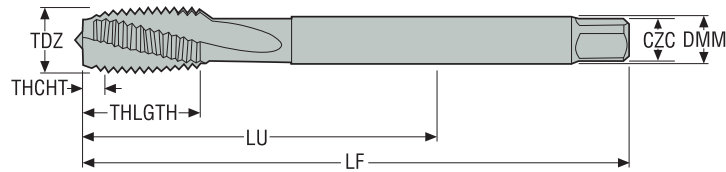


Description	
1	MTH = Threadmaster™ Tap Helix flute MTP = Threadmaster™ Tap Helix point MTS = Threadmaster™ Tap Straight flute tap MF = Threadmaster™ FormTap
2	Thread type and size
3	Pitch and thread form
4	Tolerance (tctr) 4H, 6H, 6HX, 6G, 6GX metric and 2B, 2BX, 3B, 3BX, Normal, NormalX inch
5	Operation,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

### Taps – Entering chamfer THCHT

B-type	
<p>Length 3.5 – 5 threads High torque Best surface finish Thin chip thickness Low pressure at the chamfer Long tool life Most common for through holes (Helix point)</p>	
C-type	
<p>Length 2 - 3 threads Medium torque Good surface finish Normal chip thickness Normal pressure at the chamfer Normal tool life Most common design Standard for blind holes Most common for blind holes (Helix flute)</p>	
E-type	
<p>Length 1.5 – 2 threads Low torque Good surface finish Thick chip thickness High pressure at the chamfer Shorter tool life When limited space in the bottom of a hole</p>	

## Definitions



### Definitions Seco Threadmaster™

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



## Taps - Choice of toolholder

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

Modern CNC machine with synchronization:

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

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

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

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

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



TCER

# Troubleshooting



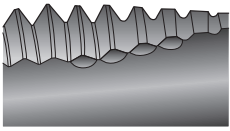
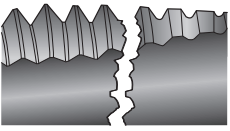
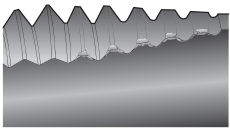
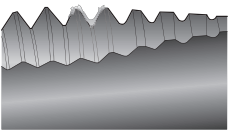
Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex

Oversized thread	Undersized thread
<p><b>Wrong tap for application</b>                      - Refer to application charts</p> <p><b>Incorrect axial feed</b>                      - Ensure feed rate is controlled                      - If possible, use tool holder for synchronized tapping</p> <p><b>Wrong cutting speed</b>                      - Refer to recommendations</p> <p><b>Wrong tolerance</b>                      - Choose tap with lower tolerance</p> 	<p><b>Tap worn out</b>                      - Replace tap</p> <p><b>Tap drill hole too small</b>                      - Check drilling recommendations</p> <p><b>Material closing after tapping</b>                      - Increase drill diameter</p> <p><b>Wrong tolerance on tap</b>                      - Choose tap with higher tolerance</p> 
Chipping	Breakage
<p><b>Wrong tap for the application</b>                      - Check for tool selection</p> <p><b>Incorrect or lack of lubricant</b>                      - Use appropriate emulsion or oil</p> <p><b>Tap hitting bottom of hole</b>                      - Increase drill depth or reduce thread depth</p> <p><b>Trapped chip</b>                      - Check tool selection</p> <p><b>Surface hardening in drilled hole</b>                      - Check drilling recommendations</p> 	<p><b>Too high torque</b>                      - Use tap holder with torque settings</p> <p><b>Tap worn out</b>                      - Replace tap</p> <p><b>Incorrect or lack of lubricant</b>                      - Use appropriate emulsion or oil</p> <p><b>Tap hitting bottom of hole</b>                      - Increase drill depth or reduce thread depth</p> <p><b>Wrong cutting speed</b>                      - Refer to recommendations</p> <p><b>“Birdnest” around tool</b>                      - Check tool selection</p> <p><b>Tap drill hole too small</b>                      - Check drilling recommendations</p> 
Rapid wear	Built-up edge
<p><b>Wrong type of tap for application</b>                      - Refer to tap choice</p> <p><b>Incorrect or lack of lubricant</b>                      - Use appropriate emulsion or oil</p> <p><b>Too high cutting speed</b>                      - Refer to recommendations</p> <p><b>Work (surface) hardening in drilled hole</b>                      - Check drilling recommendations                      - Drill worn out</p> <p><b>Tap drill hole too small</b>                      - Check drilling recommendations</p> 	<p><b>Incorrect or lack of lubricant</b>                      - Use appropriate emulsion or oil</p> <p><b>Tap worn out</b>                      - Replace tap</p> <p><b>Wrong cutting speed</b>                      - Refer to recommendations</p> <p><b>Wrong type of tap for application</b>                      - Refer to tap choice</p> 

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

Tool type	MTH-P001 30-48 HRC	MTH-P001-A 30-48 HRC	MTH-P002 30-48 HRC	MTH-P002-A 30-48 HRC	MTH-P003	MTH-P003-A	MTH-P004	MTH-P004-A	MTH-P011
Thread type	M	M	M	M	M	M	M	M	MF
TCTR	6H	6H	6H	6H	6HX	6HX	6HX	6HX	6HX
ULDR	1.5	1.5	1.5	1.5	3	3	3	3	3
THCHT	C	C	C	C	C	C	C	C	C
BSG	SECO-DIN	SECO-DIN	DIN376	DIN376	DIN371	DIN371	DIN376	DIN376	DIN374
Thread size	M3 - M10	M4 - M10	M12 - M20	M12 - M20	M1.6 - M10	M4 - M10	M5 - M30	M12 - M30	MF 4X0.5 - MF 30X2.0
FHA	15°	15°	15°	15°	48°	48°	48°	48°	48°
									
Coolant	No	Yes	No	Yes	No	Yes	No	Yes	No
Page(s)	290	291	292	293	294	295	296	297	298, 299

For cutting data, see next page

Cutting data MTH-P001 (-A) – P011

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

SMG = Seco material group  
v<sub>c</sub> = m/min (sf/min)

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

## Taps Selection MTP-P001 – MTP-P011

Tool type	MTP-P001 30-48 HRC	MTP-P002 30-48 HRC	MTP-P003	MTP-P003-A	MTP-P004	MTP-P004-A	MTP-P011
Thread type	M	M	M	M	M	M	MF
TCTR	6H	6H	5HX/6HX	6HX	6HX	6HX	6HX
ULDR	2.5	2.5	3	3	3	3	3
THCHT	B	B	B	B	B	B	B
BSG	SECO-DIN	DIN376	DIN371	DIN371	DIN376	DIN376	DIN374
Thread size	M3 - M10	M12 - M20	M1 - M10	M4 - M10	M4 - M30	M12 - M30	MF 4X0.5 - MF 30X2.0
							
Coolant	No	No	No	Yes	No	Yes	No
Page(s)	253	254	255	256	257	258	259, 260

For cutting data, see next page

Cutting data MTP-P001 – P011

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

SMG = Seco material group  
V<sub>c</sub> = m/min (sf/min)

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

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

Tool type	MTH-M003	MTH-M003-A	MTH-M004	MTH-M004-A	MTP-M003	MTP-M003-A	MTP-M004	MTP-M004-A
Thread type	M	M	M	M	M	M	M	M
TCTR	6H	6H	6H	6H	5HX/6H	6H	6H	6H
ULDR	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
THCHT	C	C	C	C	B	B	B	B
BSG	DIN371	DIN371	DIN376	DIN376	DIN371	DIN371	DIN376	DIN376
Thread size	M1.6 - M10	M4 - M10	M12 - M20	M12 - M20	M1 - M10	M4 - M10	M12 - M20	M12 - M24
FHA	48°	48°	48°	48°	-	-	-	-
								
Coolant	No	Yes	No	Yes	No	Yes	No	Yes
Page(s)	300	301	302	303	261	262	263	264

For cutting data, see next page

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

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

SMG = Seco material group  
V<sub>c</sub> = m/min (sf/min)

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex



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

Tool type	MTH-N001	MTH-N002	MTP-N001	MTP-N001-A	MTP-N002	MTP-N002-A
Thread type	M	M	M	M	M	M
TCTR	6H	6H	6H	6H	6H	6H
ULDR	1.5	1.5	3	3	3	3
THCHT	C	C	B	B	B	B
BSG	DIN371	DIN376	DIN371	DIN371	DIN376	DIN376
Thread size	M3 - M10	M12 - M16	M3 - M10	M4 - M10	M12 - M16	M12 - M16
FHA	15°	15°	-	-	-	-
						
Coolant	No	No	No	Yes	No	Yes
Page(s)	304	305	265	266	267	268

For cutting data, see next page

Cutting data MTH-N001 – N002 (-A)

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

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









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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

## Taps Selection MTH-S001 – MTH-S032

Tool type	MTH-S001	MTH-S002	MTH-S003	MTH-S004	MTH-S011	MTH-S012	MTH-S031	MTH-S032
Thread type	M	M	M	M	MF	MJ	UNC	UNJC
TCTR	6HX	6HX	6HX	6HX	6HX	4H	2B	3B
ULDR	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
THCHT	C	C	C	C	C	C	C	C
BSG	DIN371	DIN371	DIN371	DIN371	DIN371	DIN371	DIN2184-1	DIN2184-1
Thread size	M3-M10	M12-M16	M3-M10	M12-M16	MF8X1-MF12X1,5	MJ3-MJ6	UNC2-56-UNC3/8-16	UNJC4-40-UNJC3/8-16
FHA	10°	10°	10°	10°	10°	10°	25°	10°
								
Coolant	No	No	No	No	No	No	No	No
Page(s)	306	307	308	309	310	311	312	313










For cutting data, see next page

Cutting data MTH-S001 – S032

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

SMG = Seco material group.  $v_c$  = m/min (sf/min)  
 Cutting speeds ( $v_c$ ) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD. When running in 1,5xD increase speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%. Due to machine, material and setup condition it is advisable also to optimize cutting data.  
 Recommended ranges to use for each type of tap:  
 K001-K002: +25% / -25%    V015-V016: +15% / -15%  
 V001-V045: +15% / -15%    V048-V050: +35% / -35%  
 V053-V063: +15% / -15%

## Taps Selection MTH-S041 – MTH-S142

Tool type	MTH-S041	MTH-S042	MTH-S043	MTH-S044	MTH-S101	MTH-S102	MTH-S111	MTH-S112	MTH-S142
Thread type	UNF	UNJF	EGUNF	EGUNF	M	M	MF	MJ	UNJF
TCTR	3B	3B	3B	3B	6HX	6HX	6HX	4H	3B
ULDR	1.5	1.5	2.0	1.5	2.0	2.0	2.0	2.0	2.0
THCHT	C	C	C	C	C	C	C	C	C
BSG	DIN2184-1	DIN2184-1	DIN2184-1	DIN2184-1	DIN371	DIN376	DIN376	DIN371	DIN2184-1
Thread size	UNF6-40- UNF3/8-24	UNJF6-40-UN- JF3/8-24	EGUNF6-40- EGUNF3/8-24	EGUNF6-40- EGUNF3/8-24	M2-M10	M12-M20	MF6X0,75- MF14X1,5	MJ3-MJ10	UNJF10-32-UN- JF3/8-24
FHA	25°	10°	15°	10°	15°	15°	15°	15°	15°
									
Coolant	No	No	No	No	No	No	No	No	No
Page(s)	314	315	316	317	318	319	320	321	322








For cutting data, see next page

Cutting data MTH-S041 – S142

SMG	$v_c$								
	MTH-S041	MTH-S042	MTH-S043	MTH-S044	MTH-S101	MTH-S102	MTH-S111	MTH-S012	MTH-S142
P1	—	—	—	—	—	—	—	—	—
P2	—	—	—	—	—	—	—	—	—
P3	—	—	—	—	—	—	—	—	—
P4	—	—	—	—	—	—	—	—	—
P5	—	—	—	—	—	—	—	—	—
P6	3 10	3 10	7 23	3 10	7 23	7 23	7 23	3 10	7 23
P7	3 10	3 10	7 23	3 10	7 23	7 23	7 23	3 10	7 23
P8	—	—	—	—	—	—	—	—	—
P11	3 10	3 10	6 20	3 10	6 20	6 20	6 20	3 10	6 20
P12	2 7	2 7	4 13	2 7	4 13	4 13	4 13	2 7	4 13
M1	—	—	—	—	—	—	—	—	—
M2	—	—	—	—	—	—	—	—	—
M3	—	—	—	—	—	—	—	—	—
M4	2 7	—	6 20	—	6 20	6 20	6 20	—	6 20
M5	2 7	—	5 16	—	5 16	5 16	5 16	—	5 16
K1	—	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—
N3	—	16 50	25 80	16 50	25 80	25 80	25 80	16 50	25 80
N11	—	—	—	—	—	—	—	—	—
S1	2 7	2 7	—	2 7	—	—	—	2 7	—
S2	2 7	2 7	—	2 7	—	—	—	2 7	—
S3	2 7	2 7	—	2 7	—	—	—	2 7	—
S11	—	—	5 16	—	5 16	5 16	5 16	—	5 16
S12	—	—	4 13	—	4 13	4 13	4 13	—	4 13
S13	—	—	3 10	—	3 10	3 10	3 10	—	3 10
H5	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—

SMG = Seco material group.  $v_c$  = m/min (sf/min)  
 Cutting speeds ( $v_c$ ) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD. When running in 1,5xD increase speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%. Due to machine, material and setup condition it is advisable also to optimize cutting data.  
 Recommended ranges to use for each type of tap:  
 K001-K002: +25% / -25% V015-V016: +15% / -15%  
 V001-V045: +15% / -15% V048-V050: +35% / -35%  
 V053-V063: +15% / -15%

## Taps Selection MTP-S001 – MTP-S043

Tool type	MTP-S001	MTP-S002	MTP-S011	MTP-S012	MTP-S013	MTP-S042	MTP-S043
Thread type	M	M	MF	MJ	EGM	UNFJ	EGUNF
TCTR	6HX	6HX	6HX	4H	4H	3B	3B
ULDR	2.0	2.0	2.0	2.0	2.0	2.0	2.0
THCHT	B	B	B	B	B	B	B
BSG	DIN371	DIN376	DIN371	DIN371	DIN40435	DIN2184-1	DIN2184-1
Thread size	M2-M10	M12-M20	MF6X0,75-MF14X1,5	MJ4-MJ8	EGM4-EGM8	UNJF10-32-UNJF3/8-24	EGUNJF10-32-EGUNF3/8-24
FHA	-	-	-	-	-	-	-
							
Coolant	No	No	No	No	No	No	No
Page(s)	269	270	271	272	273	274	275

For cutting data, see next page

Cutting data MTP-S001 – S043

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

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

Cutting speeds ( $v_c$ ) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD. When running in 1,5xD increase speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%. Due to machine, material and setup condition it is advisable also to optimize cutting data.

Recommended ranges to use for each type of tap:

K001-K002: +25% / -25%    V015-V016: +15% / -15%

V001-V045: +15% / -15%    V048-V050: +35% / -35%

V053-V063: +15% / -15%



## Taps Selection MTS-K001 (-A) – MTS-K041

Tool type	MTS-K001	MTS-K001-A	MTS-K002	MTS-K002-A	MTS-K011	MTS-K021	MTS-K031	MTS-K041
Thread type	M	M	M	M	MF	G	UNC	UNF
TCTR	6HX	6HX	6HX	6HX	6HX	NORMAL	2BX	2BX
ULDR	2	2.5	2	2.5	2 - 2.5	2	2	2
THCHT	C	C/E	C	C/E	C	C	C	C
BSG	DIN371	DIN371	DIN376	DIN376	DIN374	DIN5156	DIN2184-1	DIN2184-1
Thread size	M3 - M10	M4 - M10	M8 - M42	M12 - M42	MF 10X1.0 - MF 20X1.5	G 1/8-28 - G 1-11	UNC 1/4-20 - UNC 7/8-9	UNF 1/4-28 - UNF 7/8-14
FHA	-	-	-	-	-	-	-	-
								
Coolant	No	Yes	No	Yes	No	No	No	No
Page(s)	343	344	345	346	347	348	349	350

For cutting data, see next page

Cutting data MTS-K001 (-A) – K041

SMG	$v_c$							
	MTS- K001	MTS- K001-A	MTS- K002	MTS- K002-A	MTS- K011	MTS- K021	MTS- K031	MTS- K041
P1	—	—	—	—	—	—	—	—
P2	—	—	—	—	—	—	—	—
P3	—	—	—	—	—	—	—	—
P4	—	—	—	—	—	—	—	—
P5	—	—	—	—	—	—	—	—
P6	—	—	—	—	—	—	—	—
P7	—	—	—	—	—	—	—	—
P8	—	—	—	—	—	—	—	—
P11	—	—	—	—	—	—	—	—
P12	—	—	—	—	—	—	—	—
M1	—	—	—	—	—	—	—	—
M2	—	—	—	—	—	—	—	—
M3	—	—	—	—	—	—	—	—
M4	—	—	—	—	—	—	—	—
M5	—	—	—	—	—	—	—	—
K1	36 120	36 120	36 120	36 120	36 120	36 120	36 120	36 120
K2	31 100	31 100	31 100	31 100	31 100	31 100	31 100	31 100
K3	26 85	26 85	26 85	26 85	26 85	26 85	26 85	26 85
K4	25 80	25 80	25 80	25 80	25 80	25 80	25 80	25 80
K5	15 49	15 49	15 49	15 49	15 49	15 49	15 49	15 49
K6	22 70	22 70	22 70	22 70	22 70	22 70	22 70	22 70
K7	19 60	19 60	19 60	19 60	19 60	19 60	19 60	19 60
N1	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—
H5	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—

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

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

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

Tool type	MTH-V011	MTH-V015	MTH-V016	MTH-V025	MTH-V026	MTH-V028	MTH-V029	MTH-V030	MTH-V030-A
Thread type	MF	M	M	M	M	M	M	M	M
TCTR	6HX	6H	6H	6H	6H	6G	6G	6H	6H
ULDR	2	2	2	3	3	3	3	2.5	2.5
THCHT	C	C	C	C	C	C	C	C	C
BSG	DIN374	DIN371	DIN376	DIN371	DIN376	DIN371	DIN376	DIN371	DIN371
Thread size	MF 8X0.75 - MF 24X2.0	M3 - M10	M12 - M36	M3 - M10	M12 - M20	M3 - M10	M12 - M20	M2 - M10	M4 - M10
FHA	15°	15°	15°	45°	45°	45°	45°	45°	45°
									
Coolant	No	No	No	No	No	No	No	No	Yes
Page(s)	323	324	325	326	327	328	329	330	331

For cutting data, see next page

Cutting data MTH-V011 – V030 (-A)

SMG	V <sub>c</sub>								
	MTH- V011	MTH- V015	MTH- V016	MTH- V025	MTH- V026	MTH- V028	MTH- V029	MTH- V030	MTH- V030-A
P1	40	40	40	40	40	40	40	40	40
	130	130	130	130	130	130	130	130	130
P2	39	39	39	39	39	39	39	39	39
	130	130	130	130	130	130	130	130	130
P3	33	33	33	33	33	33	33	33	33
	110	110	110	110	110	110	110	110	110
P4	29	29	29	29	29	29	29	29	29
	95	95	95	95	95	95	95	95	95
P5	28	28	28	28	28	28	28	28	28
	90	90	90	90	90	90	90	90	90
P6	31	31	31	31	31	31	31	31	31
	100	100	100	100	100	100	100	100	100
P7	30	30	30	30	30	30	30	30	30
	100	100	100	100	100	100	100	100	100
P8	28	28	28	28	28	28	28	28	28
	90	90	90	90	90	90	90	90	90
P11	29	29	29	29	29	29	29	29	29
	95	95	95	95	95	95	95	95	95
P12	17	17	17	17	17	17	17	17	17
	55	55	55	55	55	55	55	55	55
M1	9	9	9	9	9	9	9	9	9
	30	30	30	30	30	30	30	30	30
M2	7	7	7	7	7	7	7	7	7
	23	23	23	23	23	23	23	23	23
M3	5	5	5	5	5	5	5	5	5
	16	16	16	16	16	16	16	16	16
M4	4	4	4	4	4	4	4	4	4
	13	13	13	13	13	13	13	13	13
M5	3	3	3	3	3	3	3	3	3
	10	10	10	10	10	10	10	10	10
K1	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N1	37	37	37	37	37	37	37	37	37
	120	120	120	120	120	120	120	120	120
N2	24	24	24	24	24	24	24	24	24
	80	80	80	80	80	80	80	80	80
N3	16	16	16	16	16	16	16	16	16
	50	50	50	50	50	50	50	50	50
N11	21	21	21	21	21	21	21	21	21
	70	70	70	70	70	70	70	70	70
H5	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—

SMG = Seco material group  
V<sub>c</sub> = m/min (sf/min)

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

Thread turning








Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

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

Tool type	MTH-V033	MTH-V033-A	MTH-V038	MTH-V038-A	MTH-V040	MTH-V043	MTH-V045
Thread type	M	M	MF	MF	UNC	UNF	G
TCTR	6H	6H	6H	6H	2B	2B	NORMAL
ULDR	2.5	2.5	2.5	2.5	2.5	2.5	2.5
THCHT	C	C	C	C	C	C	C
BSG	DIN376	DIN376	DIN374	DIN374	DIN2184-1	DIN2184-1	DIN5156
Thread size	M6 - M64	M12 - M64	MF 4X0.5 - MF 30X2.0	MF 6X0.75 - MF 30X2.0	UNC 4-40 - UNC 5/8-11	UNF 8-36 - UNF 1-12	G 1/8-28 - G11/2-11
FHA	45°	45°	45°	45°	45°	45°	45°
							
Coolant	No	No	No	No	No	No	Yes
Page(s)	332	333	334, 335	336, 337	338	339	340

For cutting data, see next page

Cutting data MTH-V033 (-A) – V045

SMG	V <sub>c</sub>						
	MTH- V033	MTH- V033-A	MTH- V038	MTH- V038-A	MTH- V040	MTH- V043	MTH- V045
P1	40	40	40	40	40	40	40
	130	130	130	130	130	130	130
P2	39	39	39	39	39	39	39
	130	130	130	130	130	130	130
P3	33	33	33	33	33	33	33
	110	110	110	110	110	110	110
P4	29	29	29	29	29	29	29
	95	95	95	95	95	95	95
P5	28	28	28	28	28	28	28
	90	90	90	90	90	90	90
P6	31	31	31	31	31	31	31
	100	100	100	100	100	100	100
P7	30	30	30	30	30	30	30
	100	100	100	100	100	100	100
P8	28	28	28	28	28	28	28
	90	90	90	90	90	90	90
P11	29	29	29	29	29	29	29
	95	95	95	95	95	95	95
P12	17	17	17	17	17	17	17
	55	55	55	55	55	55	55
M1	9	9	9	9	9	9	9
	30	30	30	30	30	30	30
M2	7	7	7	7	7	7	7
	23	23	23	23	23	23	23
M3	5	5	5	5	5	5	5
	16	16	16	16	16	16	16
M4	4	4	4	4	4	4	4
	13	13	13	13	13	13	13
M5	3	3	3	3	3	3	3
	10	10	10	10	10	10	10
K1	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
N1	37	37	37	37	37	37	37
	120	120	120	120	120	120	120
N2	24	24	24	24	24	24	24
	80	80	80	80	80	80	80
N3	16	16	16	16	16	16	16
	50	50	50	50	50	50	50
N11	21	21	21	21	21	21	21
	70	70	70	70	70	70	70
H5	—	—	—	—	—	—	—
	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—
	—	—	—	—	—	—	—

SMG = Seco material group  
V<sub>c</sub> = m/min (sf/min)

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

Thread turning


Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

## Taps Selection MTP-V001 – MTP-V008 (-A)

Tool type	MTP-V001	MTP-V002	MTP-V005	MTP-V006	MTP-V007	MTP-V007-A	MTP-V008	MTP-V008-A
Thread type	M	M	M	M	M	M	M	M
TCTR	6H	6H	6G	6G	6H	6H	6H	6H
ULDR	3	3	2.5	2.5	2.5	2.5	2.5	2.5
THCHT	B	B	B	B	B	B	B	B
BSG	DIN371	DIN376	DIN371	DIN376	DIN371	DIN371	DIN376	DIN376
Thread size	M3 - M10	M12 - M20	M3 - M10	M12 - M20	M2 - M10	M4 - M10	M3 - M36	M12 - M36
FHA	-	-	-	-	-	-	-	-
								
Coolant	No	No	No	No	No	Yes	No	Yes
Page(s)	276	277	278	279	280	281	282	283

For cutting data, see next page

Cutting data MTP-V001 – V008 (-A)

SMG	v <sub>c</sub>							
	MTP- V001	MTP- V002	MTP- V005	MTP- V006	MTP- V007	MTP- V007-A	MTP- V008	MTP- V008-A
P1	40	40	40	40	40	40	40	40
	130	130	130	130	130	130	130	130
P2	39	39	39	39	39	39	39	39
	130	130	130	130	130	130	130	130
P3	33	33	33	33	33	33	33	33
	110	110	110	110	110	110	110	110
P4	29	29	29	29	29	29	29	29
	95	95	95	95	95	95	95	95
P5	28	28	28	28	28	28	28	28
	90	90	90	90	90	90	90	90
P6	31	31	31	31	31	31	31	31
	100	100	100	100	100	100	100	100
P7	30	30	30	30	30	30	30	30
	100	100	100	100	100	100	100	100
P8	28	28	28	28	28	28	28	28
	90	90	90	90	90	90	90	90
P11	29	29	29	29	29	29	29	29
	95	95	95	95	95	95	95	95
P12	17	17	17	17	17	17	17	17
	55	55	55	55	55	55	55	55
M1	9	9	9	9	9	9	9	9
	30	30	30	30	30	30	30	30
M2	7	7	7	7	7	7	7	7
	23	23	23	23	23	23	23	23
M3	5	5	5	5	5	5	5	5
	16	16	16	16	16	16	16	16
M4	4	4	4	4	4	4	4	4
	13	13	13	13	13	13	13	13
M5	3	3	3	3	3	3	3	3
	10	10	10	10	10	10	10	10
K1	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
N1	37	37	37	37	37	37	37	37
	120	120	120	120	120	120	120	120
N2	24	24	24	24	24	24	24	24
	80	80	80	80	80	80	80	80
N3	16	16	16	16	16	16	16	16
	50	50	50	50	50	50	50	50
N11	21	21	21	21	21	21	21	21
	70	70	70	70	70	70	70	70
H5	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—

SMG = Seco material group  
v<sub>c</sub> = m/min (sf/min)

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

Thread turning

Thread MDT


Thread Mini-Shaft™

Rotating threading

Annex



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

Tool type	MTP-V014	MTP-V014-A	MTP-V017	MTP-V020	MTP-V023
Thread type	MF	MF	UNC	UNF	G
TCTR	6H	6H	2B	2B	NORMAL
ULDR	2.5	2.5	2.5	2.5	2.5
THCHT	B	B	B	B	B
BSG	DIN374	DIN374	DIN2184-1	DIN2184-1	DIN5156
Thread size	MF 4X0.5 - MF 30X2.0	MF 6X0.75 - MF 24X2.0	UNC 4-40 - UNC 5/8-11	UNF 8-36 - UNF 5/8-18	G 1/8-28 - G 5/8-14
FHA	-	-	-	-	-
					
Coolant	No	Yes	No	No	No
Page(s)	284, 285	286	287	288	289

For cutting data, see next page

Cutting data MTP-V014 (-A) – V023

SMG	V <sub>c</sub>				
	MTP- V014	MTP- V014-A	MTP- V017	MTP- V020	MTP- V023
P1	40	40	40	40	40
	130	130	130	130	130
P2	39	39	39	39	39
	130	130	130	130	130
P3	33	33	33	33	33
	110	110	110	110	110
P4	29	29	29	29	29
	95	95	95	95	95
P5	28	28	28	28	28
	90	90	90	90	90
P6	31	31	31	31	31
	100	100	100	100	100
P7	30	30	30	30	30
	100	100	100	100	100
P8	28	28	28	28	28
	90	90	90	90	90
P11	29	29	29	29	29
	95	95	95	95	95
P12	17	17	17	17	17
	55	55	55	55	55
M1	9	9	9	9	9
	30	30	30	30	30
M2	7	7	7	7	7
	23	23	23	23	23
M3	5	5	5	5	5
	16	16	16	16	16
M4	4	4	4	4	4
	13	13	13	13	13
M5	3	3	3	3	3
	10	10	10	10	10
K1	—	—	—	—	—
	—	—	—	—	—
K2	—	—	—	—	—
	—	—	—	—	—
K3	—	—	—	—	—
	—	—	—	—	—
K4	—	—	—	—	—
	—	—	—	—	—
K5	—	—	—	—	—
	—	—	—	—	—
K6	—	—	—	—	—
	—	—	—	—	—
K7	—	—	—	—	—
	—	—	—	—	—
N1	37	37	37	37	37
	120	120	120	120	120
N2	24	24	24	24	24
	80	80	80	80	80
N3	16	16	16	16	16
	50	50	50	50	50
N11	21	21	21	21	21
	70	70	70	70	70
H5	—	—	—	—	—
	—	—	—	—	—
H8	—	—	—	—	—
	—	—	—	—	—

SMG = Seco material group  
V<sub>c</sub> = m/min (sf/min)

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

## Taps Selection MTH-V048 – MTH-V050

Tool type	MTH-V048	MTH-V050
Thread type	NPT	NPTF
TCTR	NORMAL	NORMAL
ULDR	1.5	1.5
THCHT	C	C
BSG	DIN/ANSI	DIN/ANSI
Thread size	NPT 1/16-27 NPT 1-11.5	NPTF 1/16-27 NPTF 3/4-14
FHA	15°	15°
		
Coolant	No	No
Page(s)	341	342

For cutting data, see next page

Cutting data MTH-V048 – V050

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

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

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

## Taps Selection MF-V053 – MF-V063 (-A)

Tool type	MF-V053	MF-V054	MF-V055	MF-V056	MF-V057	MF-V058	MF-V059	MF-V060-A	MF-V063	MF-V063-A
Thread type	M	M	M	UNC	UNF	M	G	M	MF	MF
TCTR	6HX	5HX/6HX	6HX	2BX	2BX	6GX	NORMAL-X	6HX	6HX	6HX
ULDR	3	3	3	3	3	3	3	3	3	3
THCHT	E	C	C	C	C	C	C	C	C	C
BSG	DIN2174	DIN2174	DIN2174	DIN2184-1	DIN2184-1	DIN2174	DIN2189	DIN2174	DIN2174	DIN2174
Thread size	M3 - M10	M1 - M2.6	M3 - M48	UNC 4-40 - UNC 1-8	UNF 10-32 - UNF 1-12	M3 - M12	G 1/8-28 - G 5/8-14	M5 - M48	MF 5X0.5 - MF 16X1.5	MF 5X0.5 - MF 16X1.5
FHA	-	-	-	-	-	-	-	-	-	-
										
Coolant	No	No	No	No	No	No	No	Yes	No	Yes
Page(s)	351	352	353	354	355	356	357	358	359	360

For cutting data, see next page

Cutting data MF-V053 – V063 (-A)

SMG	$v_c$									
	MF- V053	MF- V054	MF- V055	MF- V056	MF- V057	MF- V058	MF- V059	MF- V060	MF- V063	MF- V063-A
P1	55	55	55	55	55	55	55	55	55	55
	180	180	180	180	180	180	180	180	180	180
P2	55	55	55	55	55	55	55	55	55	55
	180	180	180	180	180	180	180	180	180	180
P3	48	48	48	48	48	48	48	48	48	48
	155	155	155	155	155	155	155	155	155	155
P4	42	42	42	42	42	42	42	42	42	42
	140	140	140	140	140	140	140	140	140	140
P5	40	40	40	40	40	40	40	40	40	40
	130	130	130	130	130	130	130	130	130	130
P6	45	45	45	45	45	45	45	45	45	45
	150	150	150	150	150	150	150	150	150	150
P7	42	42	42	42	42	42	42	42	42	42
	140	140	140	140	140	140	140	140	140	140
P8	40	40	40	40	40	40	40	40	40	40
	130	130	130	130	130	130	130	130	130	130
P11	41	41	41	41	41	41	41	41	41	41
	135	135	135	135	135	135	135	135	135	135
P12	24	24	24	24	24	24	24	24	24	24
	80	80	80	80	80	80	80	80	80	80
M1	17	17	17	17	17	17	17	17	17	17
	55	55	55	55	55	55	55	55	55	55
M2	14	14	14	14	14	14	14	14	14	14
	46	46	46	46	46	46	46	46	46	46
M3	11	11	11	11	11	11	11	11	11	11
	36	36	36	36	36	36	36	36	36	36
M4	8	8	8	8	8	8	8	8	8	8
	26	26	26	26	26	26	26	26	26	26
M5	7	7	7	7	7	7	7	7	7	7
	23	23	23	23	23	23	23	23	23	23
K1	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
N1	50	55	55	55	55	55	55	55	55	55
	165	180	180	180	180	180	180	180	180	180
N2	32	35	35	35	35	35	35	35	35	35
	105	115	115	115	115	115	115	115	115	115
N3	21	23	23	23	23	23	23	23	23	23
	70	75	75	75	75	75	75	75	75	75
N11	28	31	31	31	31	31	31	31	31	31
	90	100	100	100	100	100	100	100	100	100
H5	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—

SMG = Seco material group  
 $v_c = \text{m/min (sf/min)}$

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

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

Recommended ranges to use for each type of tap:

- K001-K002: +25% / -25%
- V015-V016: +15% / -15%
- V001-V045: +15% / -15%
- V048-V050: +35% / -35%
- V053-V063: +15% / -15%

Thread turning

Thread MDT

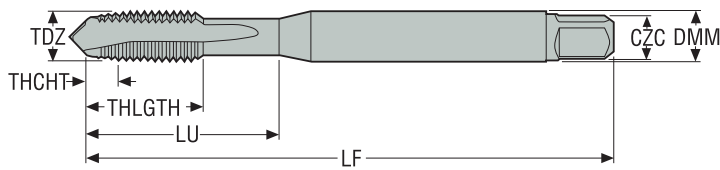
Thread Mini-Shaft™

Rotating threading

Annex

# MTP-P001

Through holes



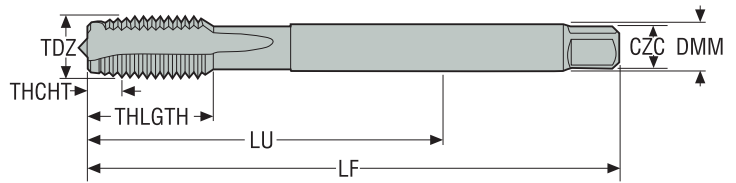
- For cutting data see page(s) 228
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M3X0.50ISO6H-TB-P001	02999886	M3	0,5	–	4,5 <i>0.177</i>	12,0 <i>0.472</i>	12,0 <i>0.472</i>	63,0 <i>2.480</i>	2,5 <i>0.098</i>	4.50X3.40	3	SECO-DIN	6H	B
MTP-M4X0.70ISO6H-TB-P001	02999887	M4	0,7	–	6,0 <i>0.236</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	3,4 <i>0.134</i>	6.00X4.90	3	SECO-DIN	6H	B
MTP-M5X0.80ISO6H-TB-P001	02999888	M5	0,8	–	6,0 <i>0.236</i>	15,0 <i>0.591</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	4,3 <i>0.169</i>	6.00X4.90	3	SECO-DIN	6H	B
MTP-M6X1.00ISO6H-TB-P001	02999889	M6	1,0	–	8,0 <i>0.315</i>	18,0 <i>0.709</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	5,1 <i>0.201</i>	8.00X6.20	3	SECO-DIN	6H	B
MTP-M8X1.25ISO6H-TB-P001	02999890	M8	1,25	–	10,0 <i>0.394</i>	20,0 <i>0.787</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	6,8 <i>0.268</i>	10.00X8.00	3	SECO-DIN	6H	B
MTP-M10X1.50ISO6H-TB-P001	02999891	M10	1,5	–	10,0 <i>0.394</i>	39,0 <i>1.535</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	SECO-DIN	6H	B

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## MTP-P002

Through holes



- For cutting data see page(s) 228
- Coating: TiAIN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>				6H	B
MTP-M12X1.75ISO6H-TB-P002	02999892	M12	1,75	–	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-P002	02999893	M14	2,0	–	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-P002	02999894	M16	2,0	–	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-P002	02999895	M18	2,5	–	14,0 <i>0.551</i>	81,0 <i>3.189</i>	30,0 <i>1.181</i>	125,0 <i>4.921</i>	15,7 <i>0.618</i>	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-P002	02999896	M20	2,5	–	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	4	DIN376	6H	B

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Thread turning

Thread MDT

Thread Mini-Shaft™

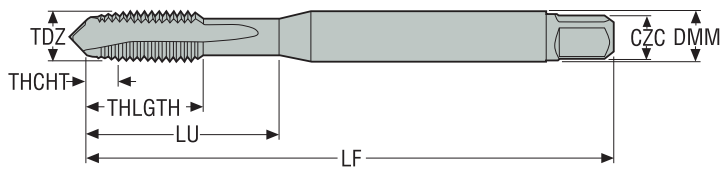
Rotating threading

Annex



MTP-P003

Through holes



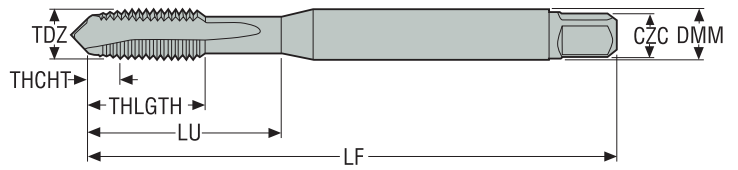
- For cutting data see page(s) 228
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M1X0.25ISO5HX-TB-P003	02999897	M1	0,25	–	2,5 0.098	20,0 0.787	5,0 0.197	40,0 1.575	0,75 0.030	2.50X2.10	2	DIN371	5HX	B
MTP-M1.2X0.25ISO5HX-TB-P003	02999898	M1.2	0,25	–	2,5 0.098	20,0 0.787	5,0 0.197	40,0 1.575	0,95 0.037	2.50X2.10	2	DIN371	5HX	B
MTP-M1.4X0.30ISO5HX-TB-P003	02999899	M1.4	0,3	–	2,5 0.098	20,0 0.787	6,5 0.256	40,0 1.575	1,1 0.043	2.50X2.10	2	DIN371	5HX	B
MTP-M1.6X0.35ISO6HX-TB-P003	02999900	M1.6	0,35	–	2,5 0.098	20,0 0.787	7,0 0.276	40,0 1.575	1,3 0.051	2.50X2.10	2	DIN371	6HX	B
MTP-M1.8X0.35ISO6HX-TB-P003	02999901	M1.8	0,35	–	2,5 0.098	20,0 0.787	7,0 0.276	40,0 1.575	1,5 0.059	2.50X2.10	2	DIN371	6HX	B
MTP-M2X0.40ISO6HX-TB-P003	02999902	M2	0,4	–	2,8 0.110	9,0 0.354	6,0 0.236	45,0 1.772	1,6 0.063	2.80X2.10	2	DIN371	6HX	B
MTP-M2.2X0.45ISO6HX-TB-P003	02999903	M2.2	0,45	–	2,8 0.110	12,0 0.472	7,0 0.276	45,0 1.772	1,8 0.071	2.80X2.10	2	DIN371	6HX	B
MTP-M2.3X0.40ISO6HX-TB-P003	02999904	M2.3	0,4	–	2,8 0.110	12,0 0.472	7,0 0.276	45,0 1.772	1,9 0.075	2.80X2.10	2	DIN371	6HX	B
MTP-M2.5X0.45ISO6HX-TB-P003	02999905	M2.5	0,45	–	2,8 0.110	12,5 0.492	8,0 0.315	50,0 1.969	2,1 0.083	2.80X2.10	2	DIN371	6HX	B
MTP-M2.6X0.45ISO6HX-TB-P003	02999906	M2.6	0,45	–	2,8 0.110	12,5 0.492	8,0 0.315	50,0 1.969	2,15 0.085	2.80X2.10	2	DIN371	6HX	B
MTP-M3X0.50ISO6HX-TB-P003	02999907	M3	0,5	–	3,5 0.138	18,0 0.709	8,9 0.350	56,0 2.205	2,5 0.098	3.50X2.70	3	DIN371	6HX	B
MTP-M3.5X0.60ISO6HX-TB-P003	02999908	M3.5	0,6	–	4,0 0.157	20,0 0.787	10,8 0.425	56,0 2.205	2,9 0.114	4.00X3.00	3	DIN371	6HX	B
MTP-M4X0.70ISO6HX-TB-P003	02999909	M4	0,7	–	4,5 0.177	21,0 0.827	11,7 0.461	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6HX	B
MTP-M5X0.80ISO6HX-TB-P003	02999910	M5	0,8	–	6,0 0.236	25,0 0.984	12,6 0.496	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6HX	B
MTP-M6X1.00ISO6HX-TB-P003	02999911	M6	1,0	–	6,0 0.236	30,0 1.181	14,5 0.571	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6HX	B
MTP-M7X1.00ISO6HX-TB-P003	02999912	M7	1,0	–	7,0 0.276	30,0 1.181	14,5 0.571	80,0 3.150	6,1 0.240	7.00X5.50	3	DIN371	6HX	B
MTP-M8X1.25ISO6HX-TB-P003	02999913	M8	1,25	–	8,0 0.315	35,0 1.378	17,4 0.685	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.50ISO6HX-TB-P003	02999914	M10	1,5	–	10,0 0.394	39,0 1.535	19,2 0.756	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6HX	B

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## MTP-P003-A

Through holes



- For cutting data see page(s) 228
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCR	THCHT
			mm	TPI										
MTP-M4X0.70ISO6HX-TB-P003-A	02999929	M4	0,7	–	4,5 0.177	21,0 0.827	11,7 0.461	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6HX	B
MTP-M5X0.80ISO6HX-TB-P003-A	02999930	M5	0,8	–	6,0 0.236	25,0 0.984	12,6 0.496	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6HX	B
MTP-M6X1.00ISO6HX-TB-P003-A	02999931	M6	1,0	–	6,0 0.236	30,0 1.181	14,5 0.571	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6HX	B
MTP-M7X1.00ISO6HX-TB-P003-A	02999932	M7	1,0	–	7,0 0.276	30,0 1.181	14,5 0.571	80,0 3.150	6,1 0.240	7.00X5.50	3	DIN371	6HX	B
MTP-M8X1.25ISO6HX-TB-P003-A	02999933	M8	1,25	–	8,0 0.315	35,0 1.378	17,4 0.685	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.50ISO6HX-TB-P003-A	02999934	M10	1,5	–	10,0 0.394	39,0 1.535	19,2 0.756	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6HX	B

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Thread turning

Thread MDT

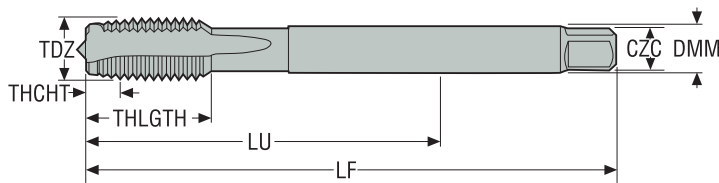
Thread Mini-Start™

Rotating threading

Annex

# MTP-P004

Through holes



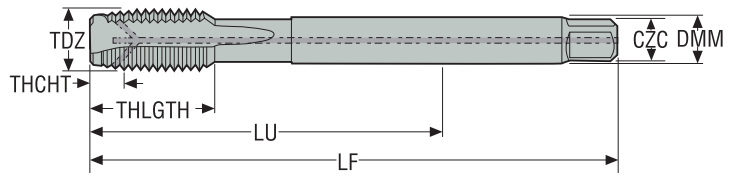
- For cutting data see page(s) 228
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M4X0.70ISO6HX-TB-P004	02999915	M4	0,7	–	2,8 <i>0.110</i>	43,0 <i>1.693</i>	12,0 <i>0.472</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	2.80X2.10	3	DIN376	6HX	B
MTP-M5X0.80ISO6HX-TB-P004	02999916	M5	0,8	–	3,5 <i>0.138</i>	49,0 <i>1.929</i>	13,2 <i>0.520</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	3.50X2.70	3	DIN376	6HX	B
MTP-M6X1.00ISO6HX-TB-P004	02999917	M6	1,0	–	4,5 <i>0.177</i>	59,0 <i>2.323</i>	15,1 <i>0.594</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	4.50X3.40	3	DIN376	6HX	B
MTP-M8X1.25ISO6HX-TB-P004	02999918	M8	1,25	–	6,0 <i>0.236</i>	67,0 <i>2.638</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	6.00X4.90	3	DIN376	6HX	B
MTP-M10X1.50ISO6HX-TB-P004	02999919	M10	1,5	–	7,0 <i>0.276</i>	77,0 <i>3.031</i>	19,8 <i>0.780</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	7.00X5.50	3	DIN376	6HX	B
MTP-M12X1.75ISO6HX-TB-P004	02999920	M12	1,75	–	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	4	DIN376	6HX	B
MTP-M14X2.00ISO6HX-TB-P004	02999921	M14	2,0	–	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	4	DIN376	6HX	B
MTP-M16X2.00ISO6HX-TB-P004	02999922	M16	2,0	–	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	4	DIN376	6HX	B
MTP-M18X2.50ISO6HX-TB-P004	02999923	M18	2,5	–	14,0 <i>0.551</i>	81,0 <i>3.189</i>	30,0 <i>1.181</i>	125,0 <i>4.921</i>	15,7 <i>0.618</i>	14.00X11.00	4	DIN376	6HX	B
MTP-M20X2.50ISO6HX-TB-P004	02999924	M20	2,5	–	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	4	DIN376	6HX	B
MTP-M22X2.50ISO6HX-TB-P004	02999925	M22	2,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	34,0 <i>1.339</i>	140,0 <i>5.512</i>	19,7 <i>0.776</i>	18.00X14.50	4	DIN376	6HX	B
MTP-M24X3.00ISO6HX-TB-P004	02999926	M24	3,0	–	18,0 <i>0.709</i>	113,0 <i>4.449</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	21,0 <i>0.827</i>	18.00X14.50	4	DIN376	6HX	B
MTP-M27X3.00ISO6HX-TB-P004	02999927	M27	3,0	–	20,0 <i>0.787</i>	97,0 <i>3.819</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	24,0 <i>0.945</i>	20.00X16.00	4	DIN376	6HX	B
MTP-M30X3.50ISO6HX-TB-P004	02999928	M30	3,5	–	22,0 <i>0.866</i>	115,0 <i>4.528</i>	45,0 <i>1.772</i>	180,0 <i>7.087</i>	26,5 <i>1.043</i>	22.00X18.00	4	DIN376	6HX	B

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## MTP-P004-A

Through holes



- For cutting data see page(s) 228
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M12X1.75ISO6HX-TB-P004-A	02999935	M12	1,75 -	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,4 0.409	9.00X7.00	4	DIN376	6HX	B
MTP-M14X2.00ISO6HX-TB-P004-A	02999936	M14	2,0 -	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	4	DIN376	6HX	B
MTP-M16X2.00ISO6HX-TB-P004-A	02999937	M16	2,0 -	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6HX	B
MTP-M18X2.50ISO6HX-TB-P004-A	02999938	M18	2,5 -	14,0 0.551	81,0 3.189	30,0 1.181	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6HX	B
MTP-M20X2.50ISO6HX-TB-P004-A	02999939	M20	2,5 -	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6HX	B
MTP-M22X2.50ISO6HX-TB-P004-A	02999940	M22	2,5 -	18,0 0.709	93,0 3.661	34,0 1.339	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6HX	B
MTP-M24X3.00ISO6HX-TB-P004-A	02999941	M24	3,0 -	18,0 0.709	113,0 4.449	38,0 1.496	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6HX	B
MTP-M27X3.00ISO6HX-TB-P004-A	02999942	M27	3,0 -	20,0 0.787	97,0 3.819	38,0 1.496	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6HX	B
MTP-M30X3.50ISO6HX-TB-P004-A	02999943	M30	3,5 -	22,0 0.866	115,0 4.528	45,0 1.772	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6HX	B

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Thread turning

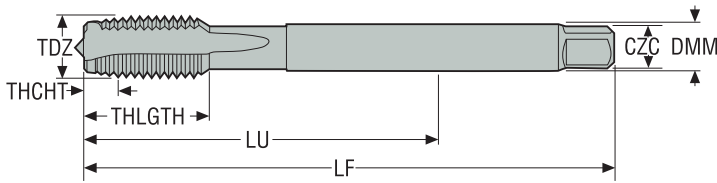
Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

MTP-P011  
Through holes



- For cutting data see page(s) 228
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M4X0.50ISO6HX-TB-P011	02999944	MF4X0.5	0,5	-	2,8 <i>0.110</i>	43,0 <i>1.693</i>	12,0 <i>0.472</i>	63,0 <i>2.480</i>	3,5 <i>0.138</i>	2.80X2.10	3	DIN374	6HX	B
MTP-M5X0.50ISO6HX-TB-P011	02999945	MF5X0.5	0,5	-	3,5 <i>0.138</i>	49,0 <i>1.929</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	4,5 <i>0.177</i>	3.50X2.70	3	DIN374	6HX	B
MTP-M6X0.75ISO6HX-TB-P011	02999946	MF6X0.75	0,75	-	4,5 <i>0.177</i>	59,0 <i>2.323</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,3 <i>0.209</i>	4.50X3.40	3	DIN374	6HX	B
MTP-M8X0.75ISO6HX-TB-P011	02999947	MF8X0.75	0,75	-	6,0 <i>0.236</i>	57,0 <i>2.244</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	7,3 <i>0.287</i>	6.00X4.90	3	DIN374	6HX	B
MTP-M8X1.00ISO6HX-TB-P011	02999948	MF8X1.0	1,0	-	6,0 <i>0.236</i>	67,0 <i>2.638</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	7,1 <i>0.280</i>	6.00X4.90	3	DIN374	6HX	B
MTP-M10X0.75ISO6HX-TB-P011	02999949	MF10X0.75	0,75	-	7,0 <i>0.276</i>	67,0 <i>2.638</i>	17,6 <i>0.693</i>	90,0 <i>3.543</i>	9,3 <i>0.366</i>	7.00X5.50	3	DIN374	6HX	B
MTP-M10X1.00ISO6HX-TB-P011	02999950	MF10X1.0	1,0	-	7,0 <i>0.276</i>	67,0 <i>2.638</i>	17,6 <i>0.693</i>	90,0 <i>3.543</i>	9,1 <i>0.358</i>	7.00X5.50	3	DIN374	6HX	B
MTP-M10X1.25ISO6HX-TB-P011	02999951	MF10X1.25	1,25	-	7,0 <i>0.276</i>	77,0 <i>3.031</i>	19,8 <i>0.780</i>	100,0 <i>3.937</i>	8,8 <i>0.346</i>	7.00X5.50	3	DIN374	6HX	B
MTP-M12X1.00ISO6HX-TB-P011	02999952	MF12X1.0	1,0	-	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	11,1 <i>0.437</i>	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.25ISO6HX-TB-P011	02999953	MF12X1.25	1,25	-	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	10,8 <i>0.425</i>	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.50ISO6HX-TB-P011	02999954	MF12X1.5	1,5	-	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	10,6 <i>0.417</i>	9.00X7.00	4	DIN374	6HX	B
MTP-M14X1.00ISO6HX-TB-P011	02999955	MF14X1.0	1,0	-	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	13,1 <i>0.516</i>	11.00X9.00	4	DIN374	6HX	B
MTP-M14X1.25ISO6HX-TB-P011	02999956	MF14X1.25	1,25	-	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	12,8 <i>0.504</i>	11.00X9.00	4	DIN374	6HX	B
MTP-M14X1.50ISO6HX-TB-P011	02999957	MF14X1.5	1,5	-	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	12,6 <i>0.496</i>	11.00X9.00	4	DIN374	6HX	B
MTP-M16X1.00ISO6HX-TB-P011	02999958	MF16X1.0	1,0	-	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	15,1 <i>0.594</i>	12.00X9.00	4	DIN374	6HX	B
MTP-M16X1.50ISO6HX-TB-P011	02999959	MF16X1.5	1,5	-	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	14,6 <i>0.575</i>	12.00X9.00	4	DIN374	6HX	B
MTP-M18X1.00ISO6HX-TB-P011	02999960	MF18X1.0	1,0	-	14,0 <i>0.551</i>	66,0 <i>2.598</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	17,1 <i>0.673</i>	14.00X11.00	4	DIN374	6HX	B
MTP-M18X1.50ISO6HX-TB-P011	02999961	MF18X1.5	1,5	-	14,0 <i>0.551</i>	66,0 <i>2.598</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	16,6 <i>0.654</i>	14.00X11.00	4	DIN374	6HX	B
MTP-M20X1.00ISO6HX-TB-P011	02999962	MF20X1.0	1,0	-	16,0 <i>0.630</i>	80,0 <i>3.150</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	19,1 <i>0.752</i>	16.00X12.00	4	DIN374	6HX	B
MTP-M20X1.50ISO6HX-TB-P011	02999963	MF20X1.5	1,5	-	16,0 <i>0.630</i>	80,0 <i>3.150</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	18,6 <i>0.732</i>	16.00X12.00	4	DIN374	6HX	B
MTP-M22X1.50ISO6HX-TB-P011	02999964	MF22X1.5	1,5	-	18,0 <i>0.709</i>	78,0 <i>3.071</i>	25,0 <i>0.984</i>	125,0 <i>4.921</i>	20,5 <i>0.807</i>	18.00X14.50	4	DIN374	6HX	B

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-M24X1.50ISO6HX-TB-P011	02999965	MF24X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	22,5 <i>0.886</i>	18.00X14.50	4	DIN374	6HX	B
MTP-M24X2.00ISO6HX-TB-P011	02999966	MF24X2.0	2,0	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	22,0 <i>0.866</i>	18.00X14.50	4	DIN374	6HX	B
MTP-M25X1.50ISO6HX-TB-P011	02999967	MF25X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	23,5 <i>0.925</i>	18.00X14.50	4	DIN374	6HX	B
MTP-M26X1.50ISO6HX-TB-P011	02999968	MF26X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	24,5 <i>0.965</i>	18.00X14.50	4	DIN374	6HX	B
MTP-M27X1.50ISO6HX-TB-P011	02999969	MF27X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	25,5 <i>1.004</i>	20.00X16.00	4	DIN374	6HX	B
MTP-M27X2.00ISO6HX-TB-P011	02999970	MF27X2.0	2,0	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	25,0 <i>0.984</i>	20.00X16.00	4	DIN374	6HX	B
MTP-M28X1.50ISO6HX-TB-P011	02999971	MF28X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	26,5 <i>1.043</i>	20.00X16.00	4	DIN374	6HX	B
MTP-M30X1.50ISO6HX-TB-P011	02999972	MF30X1.5	1,5	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	28,0 <i>1.102</i>	150,0 <i>5.906</i>	28,5 <i>1.122</i>	22.00X18.00	4	DIN374	6HX	B
MTP-M30X2.00ISO6HX-TB-P011	02999973	MF30X2.0	2,0	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	28,0 <i>1.102</i>	150,0 <i>5.906</i>	28,0 <i>1.102</i>	22.00X18.00	4	DIN374	6HX	B

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

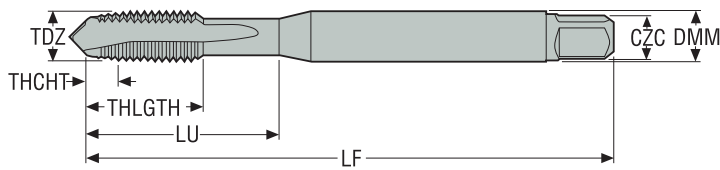
Thread Mini-Shaft™

Rotating threading

Annex

# MTP-M003

Through holes



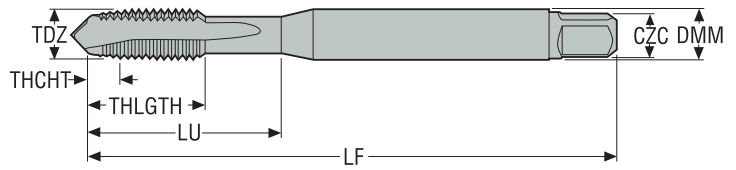
- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M1X0.25ISO5HX-TB-M003	03000070	M1	0,25	–	2,5 0.098	20,0 0.787	5,0 0.197	40,0 1.575	0,75 0.030	2.50X2.10	2	DIN371	5HX	B
MTP-M1.2X0.25ISO5HX-TB-M003	03000071	M1.2	0,25	–	2,5 0.098	20,0 0.787	5,0 0.197	40,0 1.575	0,95 0.037	2.50X2.10	2	DIN371	5HX	B
MTP-M1.4X0.30ISO5HX-TB-M003	03000072	M1.4	0,3	–	2,5 0.098	20,0 0.787	6,5 0.256	40,0 1.575	1,1 0.043	2.50X2.10	2	DIN371	5HX	B
MTP-M1.6X0.35ISO6H-TB-M003	03000073	M1.6	0,35	–	2,5 0.098	20,0 0.787	7,0 0.276	40,0 1.575	1,3 0.051	2.50X2.10	2	DIN371	6H	B
MTP-M1.8X0.35ISO6H-TB-M003	03000074	M1.8	0,35	–	2,5 0.098	20,0 0.787	7,0 0.276	40,0 1.575	1,5 0.059	2.50X2.10	2	DIN371	6H	B
MTP-M2X0.40ISO6H-TB-M003	03000075	M2	0,4	–	2,8 0.110	9,0 0.354	6,0 0.236	45,0 1.772	1,6 0.063	2.80X2.10	2	DIN371	6H	B
MTP-M2.2X0.45ISO6H-TB-M003	03000076	M2.2	0,45	–	2,8 0.110	12,0 0.472	7,0 0.276	45,0 1.772	1,8 0.071	2.80X2.10	2	DIN371	6H	B
MTP-M2.3X0.40ISO6H-TB-M003	03000077	M2.3	0,4	–	2,8 0.110	12,0 0.472	7,0 0.276	45,0 1.772	1,9 0.075	2.80X2.10	2	DIN371	6H	B
MTP-M2.5X0.45ISO6H-TB-M003	03000078	M2.5	0,45	–	2,8 0.110	12,5 0.492	8,0 0.315	50,0 1.969	2,1 0.083	2.80X2.10	2	DIN371	6H	B
MTP-M2.6X0.45ISO6H-TB-M003	03000079	M2.6	0,45	–	2,8 0.110	12,5 0.492	8,0 0.315	50,0 1.969	2,15 0.085	2.80X2.10	2	DIN371	6H	B
MTP-M3X0.50ISO6H-TB-M003	03000080	M3	0,5	–	3,5 0.138	18,0 0.709	8,9 0.350	56,0 2.205	2,5 0.098	3.50X2.70	3	DIN371	6H	B
MTP-M3.5X0.60ISO6H-TB-M003	03000081	M3.5	0,6	–	4,0 0.157	20,0 0.787	10,8 0.425	56,0 2.205	2,9 0.114	4.00X3.00	3	DIN371	6H	B
MTP-M4X0.70ISO6H-TB-M003	03000082	M4	0,7	–	4,5 0.177	21,0 0.827	11,7 0.461	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-M003	03000083	M5	0,8	–	6,0 0.236	25,0 0.984	12,6 0.496	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-M003	03000084	M6	1,0	–	6,0 0.236	30,0 1.181	14,5 0.571	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-M003	03000085	M8	1,25	–	8,0 0.315	35,0 1.378	17,4 0.685	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-M003	03000086	M10	1,5	–	10,0 0.394	39,0 1.535	19,2 0.756	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	B

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## MTP-M003-A

Through holes



- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M4X0.70ISO6H-TB-M003-A	03000094	M4	0,7 -	4,5 0.177	21,0 0.827	11,7 0.461	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-M003-A	03000095	M5	0,8 -	6,0 0.236	25,0 0.984	12,6 0.496	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-M003-A	03000096	M6	1,0 -	6,0 0.236	30,0 1.181	14,5 0.571	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-M003-A	03000097	M8	1,25 -	8,0 0.315	35,0 1.378	17,4 0.685	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-M003-A	03000098	M10	1,5 -	10,0 0.394	39,0 1.535	19,2 0.756	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	B

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Thread turning

Thread MDT

Thread Mini-Shaft™

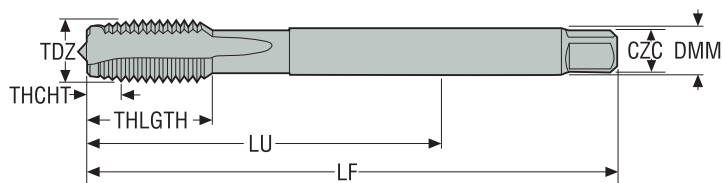
Rotating threading

Annex



# MTP-M004

Through holes



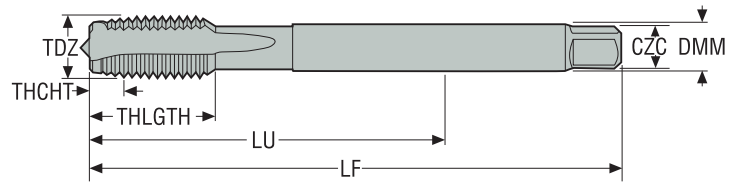
- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CXC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M12X1.75ISO6H-TB-M004	03000087	M12	1,75	–	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,4 0.409	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-M004	03000088	M14	2,0	–	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-M004	03000090	M16	2,0	–	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-M004	03000091	M18	2,5	–	14,0 0.551	81,0 3.189	30,0 1.181	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-M004	03000092	M20	2,5	–	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6H	B

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## MTP-M004-A

Through holes



- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCR	THCHT
			mm	TPI										
MTP-M12X1.75ISO6H-TB-M004-A	03000099	M12	1,75	–	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-M004-A	03000100	M14	2,0	–	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-M004-A	03000101	M16	2,0	–	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-M004-A	03000102	M18	2,5	–	14,0 <i>0.551</i>	81,0 <i>3.189</i>	30,0 <i>1.181</i>	125,0 <i>4.921</i>	15,7 <i>0.618</i>	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-M004-A	03000103	M20	2,5	–	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	4	DIN376	6H	B
MTP-M22X2.50ISO6H-TB-M004-A	03000104	M22	2,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	34,0 <i>1.339</i>	140,0 <i>5.512</i>	19,7 <i>0.776</i>	18.00X14.50	4	DIN376	6H	B
MTP-M24X3.00ISO6H-TB-M004-A	03000105	M24	3,0	–	18,0 <i>0.709</i>	113,0 <i>4.449</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	21,0 <i>0.827</i>	18.00X14.50	4	DIN376	6H	B

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Thread turning

Thread MDT

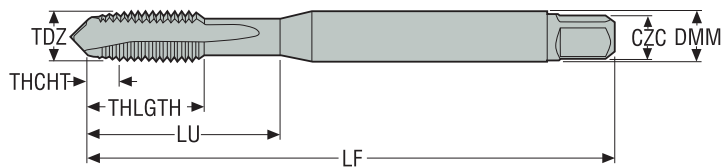
Thread Mini-Start™

Rotating threading

Annex

# MTP-N001

Through holes



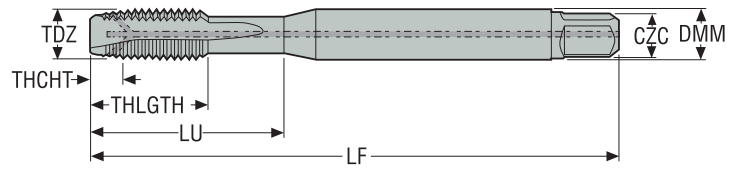
- For cutting data see page(s) 232
- Coating: BRIGHT
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M3X0.50ISO6H-TB-N001	03000136	M3	0,5	–	3,5 <i>0.138</i>	16,0 <i>0.630</i>	9,0 <i>0.354</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	2	DIN371	6H	B
MTP-M4X0.70ISO6H-TB-N001	03000137	M4	0,7	–	4,5 <i>0.177</i>	19,0 <i>0.748</i>	12,0 <i>0.472</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	2	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-N001	03000138	M5	0,8	–	6,0 <i>0.236</i>	23,0 <i>0.906</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	2	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-N001	03000139	M6	1,0	–	6,0 <i>0.236</i>	27,0 <i>1.063</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-N001	03000140	M8	1,25	–	8,0 <i>0.315</i>	28,0 <i>1.102</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-N001	03000141	M10	1,5	–	10,0 <i>0.394</i>	30,0 <i>1.181</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN371	6H	B

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## MTP-N001-A

Through holes



- For cutting data see page(s) 232
- Coating: BRIGHT
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M4X0.70ISO6H-TB-N001-A	03000145	M4	0,7 -	4,5 0.177	19,0 0.748	12,0 0.472	63,0 2.480	3,4 0.134	4.50X3.40	2	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-N001-A	03000146	M5	0,8 -	6,0 0.236	23,0 0.906	13,0 0.512	70,0 2.756	4,3 0.169	6.00X4.90	2	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-N001-A	03000147	M6	1,0 -	6,0 0.236	27,0 1.063	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-N001-A	03000148	M8	1,25 -	8,0 0.315	28,0 1.102	18,0 0.709	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-N001-A	03000149	M10	1,5 -	10,0 0.394	30,0 1.181	20,0 0.787	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	B

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Thread turning

Thread MDT

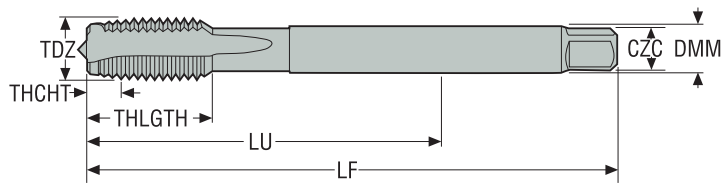
Thread Mini-Start™

Rotating threading

Annex

# MTP-N002

Through holes



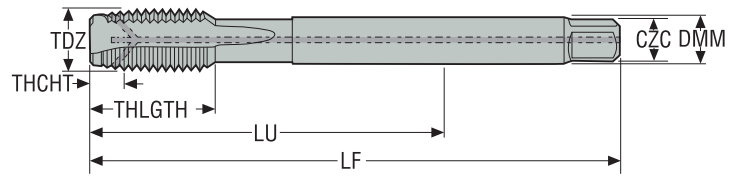
- For cutting data see page(s) 232
- Coating: BRIGHT
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M12X1.75ISO6H-TB-N002	03000142	M12	1,75	-	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-N002	03000143	M14	2,0	-	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-N002	03000144	M16	2,0	-	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	4	DIN376	6H	B

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## MTP-N002-A

Through holes



- For cutting data see page(s) 232
- Coating: BRIGHT
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M12X1.75ISO6H-TB-N002-A	03000150	M12	1,75 -	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-N002-A	03000151	M14	2,0 -	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-N002-A	03000152	M16	2,0 -	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6H	B

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Thread turning

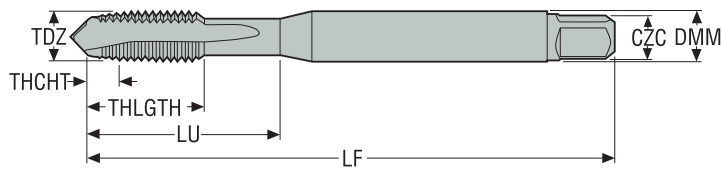
Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

MTP-S001  
Through holes



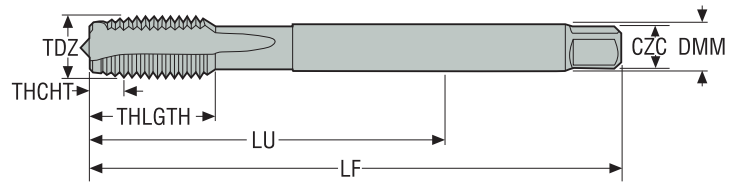
- For cutting data see page(s) 238
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M2X0.40ISO6HX-TB-S001	10001159	M2	0,4	-	2,8 <i>0.110</i>	8,0 <i>0.315</i>	8,0 <i>0.315</i>	45,0 <i>1.772</i>	1,6 <i>0.063</i>	2.80X2.10	2	DIN371	6HX	B
MTP-M2.5X0.45ISO6HX-TB-S001	10001161	M2.5	0,45	-	2,8 <i>0.110</i>	9,0 <i>0.354</i>	9,0 <i>0.354</i>	50,0 <i>1.969</i>	2,05 <i>0.081</i>	2.80X2.10	2	DIN371	6HX	B
MTP-M3X0.50ISO6HX-TB-S001	10001162	M3	0,5	-	3,5 <i>0.138</i>	10,0 <i>0.394</i>	10,0 <i>0.394</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	2	DIN371	6HX	B
MTP-M3.5X0.60ISO6HX-TB-S001	10001163	M3.5	0,6	-	4,0 <i>0.157</i>	12,0 <i>0.472</i>	12,0 <i>0.472</i>	56,0 <i>2.205</i>	2,9 <i>0.114</i>	4.00X3.00	3	DIN371	6HX	B
MTP-M4X0.70ISO6HX-TB-S001	10001164	M4	0,7	-	4,5 <i>0.177</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	63,0 <i>2.480</i>	3,3 <i>0.130</i>	4.50X3.40	3	DIN371	6HX	B
MTP-M5X0.80ISO6HX-TB-S001	10001165	M5	0,8	-	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	4,2 <i>0.165</i>	6.00X4.90	3	DIN371	6HX	B
MTP-M6X1.00ISO6HX-TB-S001	10001166	M6	1,0	-	6,0 <i>0.236</i>	23,0 <i>0.906</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,0 <i>0.197</i>	6.00X4.90	3	DIN371	6HX	B
MTP-M8X1.25ISO6HX-TB-S001	10001167	M8	1,25	-	8,0 <i>0.315</i>	29,5 <i>1.161</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.50ISO6HX-TB-S001	10001168	M10	1,5	-	10,0 <i>0.394</i>	33,5 <i>1.319</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,5 <i>0.335</i>	10.00X8.00	3	DIN371	6HX	B

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## MTP-S002

Through holes



- For cutting data see page(s) 238
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M12X1.75ISO6HX-TB-S002	10001169	M12	1,75	–	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,2 0.402	9.00X7.00	4	DIN376	6HX	B
MTP-M16X2.00ISO6HX-TB-S002	10001170	M16	2,0	–	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,0 0.551	12.00X9.00	4	DIN376	6HX	B
MTP-M20X2.50ISO6HX-TB-S002	10001171	M20	2,5	–	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	17,5 0.689	16.00X12.00	4	DIN376	6HX	B

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Thread turning

Thread MDT

Thread Mini-Shaft™

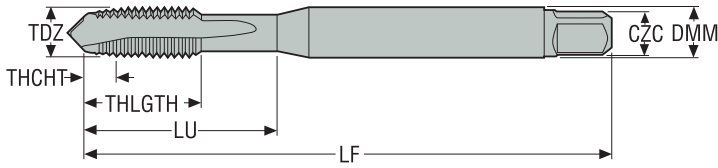
Rotating threading

Annex



# MTP-S011

Through holes



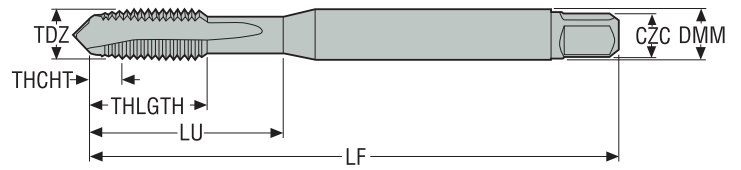
- For cutting data see page(s) 238
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M6X0.75ISO6HX-TB-S011	10001176	MF6X0.75	0,75	-	6,0 0.236	23,0 0.906	15,0 0.591	80,0 3.150	5,25 0.207	6.00X4.90	3	DIN371	6HX	B
MTP-M8X0.75ISO6HX-TB-S011	10001177	MF8X0.75	0,75	-	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	7,25 0.285	8.00X6.20	3	DIN371	6HX	B
MTP-M8X1.00ISO6HX-TB-S011	10001178	MF8X1	1,0	-	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	7,0 0.276	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.00ISO6HX-TB-S011	10001179	MF10X1	1,0	-	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	9,0 0.354	10.00X8.00	3	DIN371	6HX	B
MTP-M12X1.00ISO6HX-TB-S011	10001180	MF12X1	1,0	-	9,0 0.354	73,0 2.874	21,0 0.827	100,0 3.937	11,0 0.433	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.50ISO6HX-TB-S011	10001181	MF12X1.5	1,5	-	9,0 0.354	73,0 2.874	21,0 0.827	100,0 3.937	10,5 0.413	9.00X7.00	4	DIN374	6HX	B
MTP-M14X1.50ISO6HX-TB-S011	10001182	MF14X1.5	1,5	-	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	12,5 0.492	11.00X9.00	4	DIN374	6HX	B

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## MTP-S012

Through holes



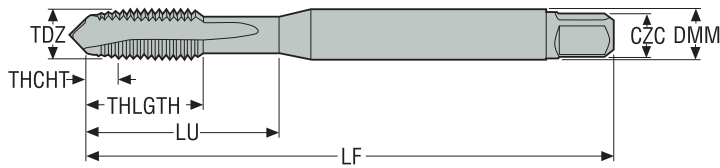
- For cutting data see page(s) 238
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-MJ4X0.70ISO4H-TB-S012	10001172	MJ4X0.7	0,7	–	4,5 <i>0.177</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	3	DIN371	4H	B
MTP-MJ5X0.80ISO4H-TB-S012	10001173	MJ5X0.8	0,8	–	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	3	DIN371	4H	B
MTP-MJ6X1.00ISO4H-TB-S012	10001174	MJ6X1	1,0	–	6,0 <i>0.236</i>	23,0 <i>0.906</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	4H	B
MTP-MJ8X1.25ISO4H-TB-S012	10001175	MJ8X1.25	1,25	–	8,0 <i>0.315</i>	29,5 <i>1.161</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,9 <i>0.272</i>	8.00X6.20	3	DIN371	4H	B

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# MTP-S013

Through holes



- For cutting data see page(s) 238
- Substrate: HSS-E-PM

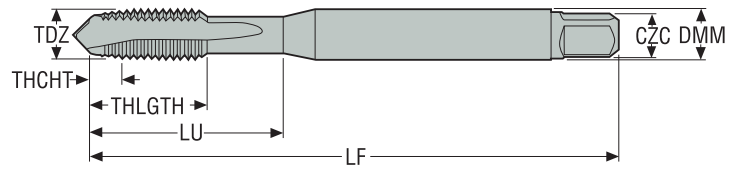
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-EGM4X0.7ISO4H-TB-S013	10001218	EGM4	0,7	–	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	4,2 <i>0.165</i>	6.00X4.90	3	DIN40435	4H	B
MTP-EGM5X0.8ISO4H-TB-S013	10001219	EGM5	0,8	–	6,0 <i>0.236</i>	23,0 <i>0.906</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,25 <i>0.207</i>	6.00X4.90	3	DIN40435	4H	B
MTP-EGM6X1.0ISO4H-TB-S013	10001220	EGM6	1,0	–	8,0 <i>0.315</i>	35,0 <i>1.378</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,3 <i>0.248</i>	8.00X6.20	3	DIN40435	4H	B
MTP-EGM8X1.25ISO4H-TB-S013	10001221	EGM8	1,25	–	10,0 <i>0.394</i>	33,5 <i>1.319</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,4 <i>0.331</i>	10.00X8.00	3	DIN40435	4H	B

Designation Ansi	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-STIM4X0.7ISO4H-TB-S013	10001218	EGM4	0,7	–	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	4,2 <i>0.165</i>	6.00X4.90	3	DIN40435	4H	B
MTP-STIM5X0.8ISO4H-TB-S013	10001219	EGM5	0,8	–	6,0 <i>0.236</i>	23,0 <i>0.906</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,25 <i>0.207</i>	6.00X4.90	3	DIN40435	4H	B
MTP-STIM6X1.0ISO4H-TB-S013	10001220	EGM6	1,0	–	8,0 <i>0.315</i>	35,0 <i>1.378</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,3 <i>0.248</i>	8.00X6.20	3	DIN40435	4H	B
MTP-STIM8X1.25ISO4H-TB-S013	10001221	EGM8	1,25	–	10,0 <i>0.394</i>	33,5 <i>1.319</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,4 <i>0.331</i>	10.00X8.00	3	DIN40435	4H	B

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## MTP-S042

Through holes



- For cutting data see page(s) 238
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-10-32UNJF3B-TB-S042	10001183	UNJF10-32	-	32.0	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	4,15 <i>0.163</i>	6.00X4.90	3	DIN2184-1	3B	B
MTP-1/4-28UNJF3B-TB-S042	10001184	UNJF1/4-28	-	28.0	7,0 <i>0.276</i>	25,0 <i>0.984</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,6 <i>0.220</i>	7.00X5.50	3	DIN2184-1	3B	B
MTP-5/16-24UNJF3B-TB-S042	10001186	UNJF5/16-24	-	24.0	8,0 <i>0.315</i>	29,5 <i>1.161</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	7,0 <i>0.276</i>	8.00X6.20	3	DIN2184-1	3B	B
MTP-3/8-24UNJF3B-TB-S042	10001185	UNJF3/8-24	-	24.0	10,0 <i>0.394</i>	33,5 <i>1.319</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN2184-1	3B	B

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Thread turning

Thread MDT

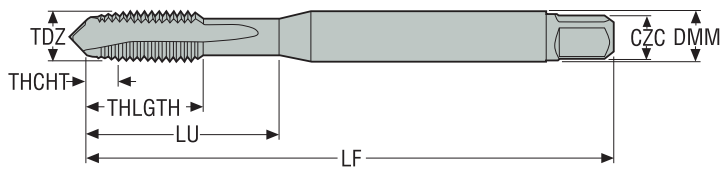
Thread Mini-Start™

Rotating threading

Annex

# MTP-S043

Through holes



- For cutting data see page(s) 238
- Substrate: HSS-E-PM

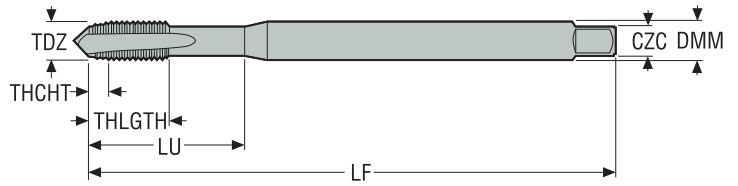
Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-10-32EGUNF3B-TB-S043	10001214	EGUN10-32	– 32.0	6,0 0.236	23,0 0.906	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN2184-1	3B	B
MTP-1/4-28EGUNF3B-TB-S043	10001215	EGUNF1/4-28	– 28.0	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	6,6 0.260	8.00X6.20	3	DIN2184-1	3B	B
MTP-5/16-24EGUNF3B-TB-S043	10001216	EGUNF5/16-24	– 24.0	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	8,2 0.323	10.00X8.00	3	DIN2184-1	3B	B
MTP-3/8-24EGUNF3B-TB-S043	10001217	EGUNF3/8-24	– 24.0	8,0 0.315	76,0 2.992	20,0 0.787	100,0 3.937	9,8 0.386	8.00X6.20	3	DIN2184-1	3B	B

Designation Ansi	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-10-32STIUNF3B-TB-S043	10001214	EGUN10-32	– 32.0	6,0 0.236	23,0 0.906	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN2184-1	3B	B
MTP-1/4-28STIUNF3B-TB-S043	10001215	EGUNF1/4-28	– 28.0	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	6,6 0.260	8.00X6.20	3	DIN2184-1	3B	B
MTP-5/16-24STIUNF3B-TB-S043	10001216	EGUNF5/16-24	– 24.0	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	8,2 0.323	10.00X8.00	3	DIN2184-1	3B	B
MTP-3/8-24STIUNF3B-TB-S043	10001217	EGUNF3/8-24	– 24.0	8,0 0.315	76,0 2.992	20,0 0.787	100,0 3.937	9,8 0.386	8.00X6.20	3	DIN2184-1	3B	B

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# MTP-V001

Through holes



- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-E
- Long version

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M3X0.50ISO6H-TB-V001	03019083	M3	0,5 -	3,5 0.138	18,0 0.709	9,0 0.354	112,0 4.409	2,5 0.098	3.50X2.70	3	DIN371	6H	B
MTP-M4X0.70ISO6H-TB-V001	03019084	M4	0,7 -	4,5 0.177	21,0 0.827	12,0 0.472	112,0 4.409	3,4 0.134	4.50X3.40	3	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-V001	03019085	M5	0,8 -	6,0 0.236	25,0 0.984	13,0 0.512	125,0 4.921	4,3 0.169	6.00X4.90	3	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-V001	03019086	M6	1,0 -	6,0 0.236	30,0 1.181	15,0 0.591	125,0 4.921	5,1 0.201	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-V001	03019087	M8	1,25 -	8,0 0.315	40,0 1.575	18,0 0.709	140,0 5.512	6,8 0.268	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-V001	03019088	M10	1,5 -	10,0 0.394	50,0 1.969	20,0 0.787	160,0 6.299	8,6 0.339	10.00X8.00	3	DIN371	6H	B

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Thread turning

Thread MDT

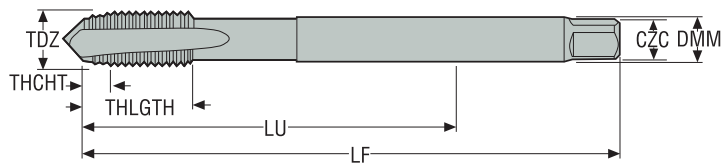
Thread Mini-Shaft™

Rotating threading

Annex

# MTP-V002

Through holes



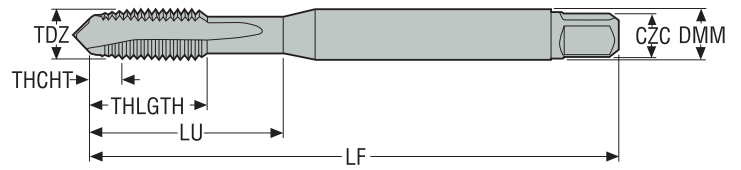
- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-E
- Long version

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M12X1.75ISO6H-TB-V002	03019090	M12	1,75	–	9,0 0.354	153,0 6.024	23,0 0.906	180,0 7.087	10,4 0.409	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-V002	03019091	M14	2,0	–	11,0 0.433	151,0 5.945	25,0 0.984	180,0 7.087	12,1 0.476	11.00X9.00	3	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-V002	03019092	M16	2,0	–	12,0 0.472	158,0 6.220	25,0 0.984	200,0 7.874	14,1 0.555	12.00X9.00	3	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-V002	03019093	M20	2,5	–	16,0 0.630	179,0 7.047	30,0 1.181	224,0 8.819	17,7 0.697	16.00X12.00	4	DIN376	6H	B

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## MTP-V005

Through holes



- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-PM

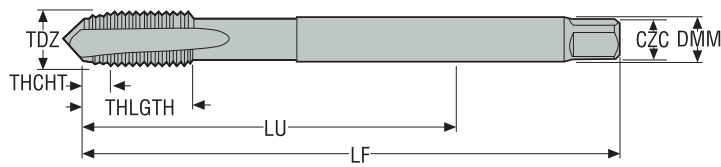
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-M3X0.50ISO6G-TB-V005	03019094	M3	0,5	–	3,5 <i>0.138</i>	18,0 <i>0.709</i>	8,9 <i>0.350</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6G	B
MTP-M4X0.70ISO6G-TB-V005	03019095	M4	0,7	–	4,5 <i>0.177</i>	21,0 <i>0.827</i>	11,7 <i>0.461</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	3	DIN371	6G	B
MTP-M5X0.80ISO6G-TB-V005	03019096	M5	0,8	–	6,0 <i>0.236</i>	25,0 <i>0.984</i>	12,6 <i>0.496</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	3	DIN371	6G	B
MTP-M6X1.00ISO6G-TB-V005	03019097	M6	1,0	–	6,0 <i>0.236</i>	30,0 <i>1.181</i>	14,5 <i>0.571</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	6G	B
MTP-M8X1.25ISO6G-TB-V005	03019098	M8	1,25	–	8,0 <i>0.315</i>	35,0 <i>1.378</i>	17,4 <i>0.685</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6G	B
MTP-M10X1.50ISO6G-TB-V005	03019099	M10	1,5	–	10,0 <i>0.394</i>	39,0 <i>1.535</i>	19,2 <i>0.756</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN371	6G	B

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# MTP-V006

Through holes



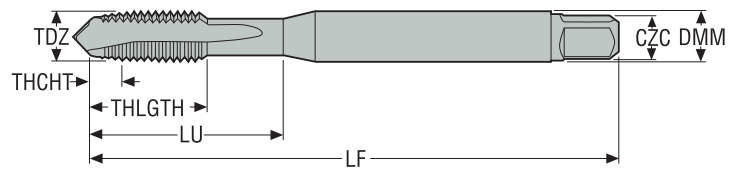
- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGH	LF	PHDR	CXC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M12X1.75ISO6G-TB-V006	03019100	M12	1,75	-	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	3	DIN376	6G	B
MTP-M16X2.00ISO6G-TB-V006	03019101	M16	2,0	-	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	3	DIN376	6G	B
MTP-M20X2.50ISO6G-TB-V006	03019102	M20	2,5	-	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	4	DIN376	6G	B

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## MTP-V007

Through holes



- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-E ≤ M2,5; HSS-PM > M2,5

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>				
MTP-M2X0.40ISO6H-TB-V007	03019103	M2	0,4 –	2,8 <i>0.110</i>	9,0 <i>0.354</i>	6,0 <i>0.236</i>	45,0 <i>1.772</i>	1,6 <i>0.063</i>	2.80X2.10	2	DIN371	6H	B
MTP-M2.5X0.45ISO6H-TB-V007	03019104	M2.5	0,45 –	2,8 <i>0.110</i>	12,5 <i>0.492</i>	8,0 <i>0.315</i>	50,0 <i>1.969</i>	2,1 <i>0.083</i>	2.80X2.10	2	DIN371	6H	B
MTP-M3X0.50ISO6H-TB-V007	03019105	M3	0,5 –	3,5 <i>0.138</i>	18,0 <i>0.709</i>	8,9 <i>0.350</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6H	B
MTP-M3.5X0.60ISO6H-TB-V007	03019106	M3.5	0,6 –	4,0 <i>0.157</i>	20,0 <i>0.787</i>	10,8 <i>0.425</i>	56,0 <i>2.205</i>	2,9 <i>0.114</i>	4.00X3.00	3	DIN371	6H	B
MTP-M4X0.70ISO6H-TB-V007	03019107	M4	0,7 –	4,5 <i>0.177</i>	21,0 <i>0.827</i>	11,7 <i>0.461</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	3	DIN371	6H	B
MTP-M4.5X0.75ISO6H-TB-V007	03019108	M4.5	0,75 –	6,0 <i>0.236</i>	25,0 <i>0.984</i>	12,6 <i>0.496</i>	70,0 <i>2.756</i>	3,8 <i>0.150</i>	6.00X4.90	3	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-V007	03019109	M5	0,8 –	6,0 <i>0.236</i>	25,0 <i>0.984</i>	12,6 <i>0.496</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	3	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-V007	03019110	M6	1,0 –	6,0 <i>0.236</i>	30,0 <i>1.181</i>	14,5 <i>0.571</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	6H	B
MTP-M7X1.00ISO6H-TB-V007	03019111	M7	1,0 –	7,0 <i>0.276</i>	30,0 <i>1.181</i>	14,5 <i>0.571</i>	80,0 <i>3.150</i>	6,1 <i>0.240</i>	7.00X5.50	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-V007	03019112	M8	1,25 –	8,0 <i>0.315</i>	35,0 <i>1.378</i>	17,4 <i>0.685</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-V007	03019113	M10	1,5 –	10,0 <i>0.394</i>	39,0 <i>1.535</i>	19,2 <i>0.756</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN371	6H	B

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Thread turning

Thread MDT

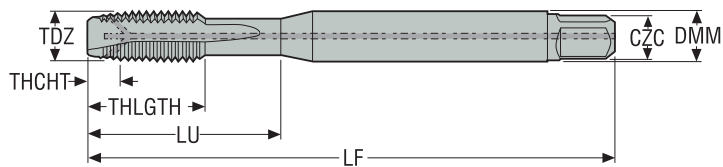
Thread Mini-Shaft™

Rotating threading

Annex

# MTP-V007-A

Through holes



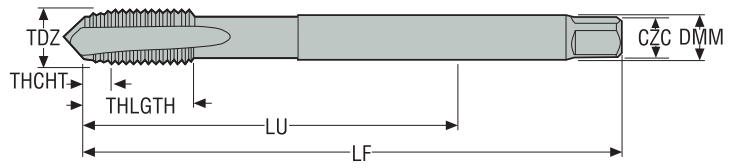
- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M4X0.70ISO6H-TB-V007-A	03000184	M4	0,7	–	4,5 0.177	21,0 0.827	6,7 0.264	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-V007-A	03000185	M5	0,8	–	6,0 0.236	25,0 0.984	7,7 0.303	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-V007-A	03000186	M6	1,0	–	6,0 0.236	30,0 1.181	10,0 0.394	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-V007-A	03000187	M8	1,25	–	8,0 0.315	35,0 1.378	11,6 0.457	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-V007-A	03000188	M10	1,5	–	10,0 0.394	39,0 1.535	15,1 0.594	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	B

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## MTP-V008

Through holes



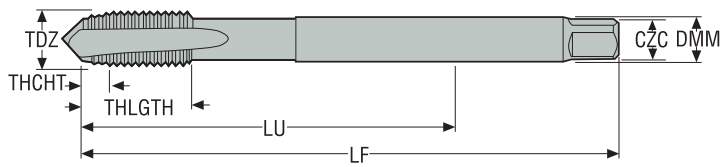
- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M3X0.50ISO6H-TB-V008	03019124	M3	0,5 -	2,2 0.087	37,0 1.457	9,5 0.374	56,0 2.205	2,5 0.098	2.20X1.80	3	DIN376	6H	B
MTP-M4X0.70ISO6H-TB-V008	03019125	M4	0,7 -	2,8 0.110	43,0 1.693	11,9 0.469	63,0 2.480	3,4 0.134	2.80X2.10	3	DIN376	6H	B
MTP-M5X0.80ISO6H-TB-V008	03019126	M5	0,8 -	3,5 0.138	49,0 1.929	13,2 0.520	70,0 2.756	4,3 0.169	3.50X2.70	3	DIN376	6H	B
MTP-M6X1.00ISO6H-TB-V008	03019127	M6	1,0 -	4,5 0.177	59,0 2.323	15,1 0.594	80,0 3.150	5,1 0.201	4.50X3.40	3	DIN376	6H	B
MTP-M8X1.25ISO6H-TB-V008	03019128	M8	1,25 -	6,0 0.236	67,0 2.638	18,0 0.709	90,0 3.543	6,8 0.268	6.00X4.90	3	DIN376	6H	B
MTP-M10X1.50ISO6H-TB-V008	03019129	M10	1,5 -	7,0 0.276	77,0 3.031	19,8 0.780	100,0 3.937	8,6 0.339	7.00X5.50	3	DIN376	6H	B
MTP-M12X1.75ISO6H-TB-V008	03019115	M12	1,75 -	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-V008	03019116	M14	2,0 -	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	3	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-V008	03019117	M16	2,0 -	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,1 0.555	12.00X9.00	3	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-V008	03019118	M18	2,5 -	14,0 0.551	81,0 3.189	30,0 1.181	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-V008	03019119	M20	2,5 -	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6H	B
MTP-M22X2.50ISO6H-TB-V008	03019120	M22	2,5 -	18,0 0.709	93,0 3.661	34,0 1.339	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6H	B
MTP-M24X3.00ISO6H-TB-V008	03019121	M24	3,0 -	18,0 0.709	113,0 4.449	38,0 1.496	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6H	B
MTP-M27X3.00ISO6H-TB-V008	03019122	M27	3,0 -	20,0 0.787	97,0 3.819	38,0 1.496	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6H	B
MTP-M30X3.50ISO6H-TB-V008	03019123	M30	3,5 -	22,0 0.866	115,0 4.528	45,0 1.772	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6H	B
MTP-M33X3.50ISO6H-TB-V008	03000182	M33	3,5 -	25,0 0.984	113,0 4.449	50,0 1.969	180,0 7.087	29,5 1.161	25.00X20.00	4	DIN376	6H	B
MTP-M36X4.00ISO6H-TB-V008	03000183	M36	4,0 -	28,0 1.102	131,0 5.157	55,0 2.165	200,0 7.874	32,0 1.260	28.00X22.00	4	DIN376	6H	B

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# MTP-V008-A

Through holes



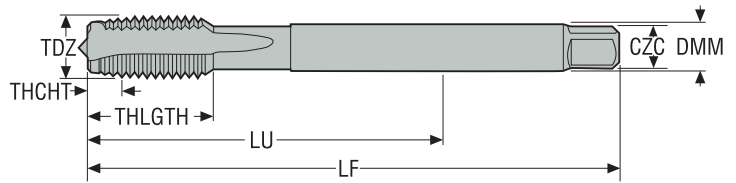
- For cutting data see page(s) 246
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-M12X1.75ISO6H-TB-V008-A	03000189	M12	1,75 -	9,0 0.354	83,0 3.268	16,0 0.630	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-V008-A	03000190	M14	2,0 -	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	3	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-V008-A	03000191	M16	2,0 -	12,0 0.472	68,0 2.677	20,0 0.787	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-V008-A	03000192	M18	2,5 -	14,0 0.551	81,0 3.189	25,0 0.984	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-V008-A	03000193	M20	2,5 -	16,0 0.630	95,0 3.740	25,0 0.984	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6H	B
MTP-M22X2.50ISO6H-TB-V008-A	03000194	M22	2,5 -	18,0 0.709	93,0 3.661	25,0 0.984	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6H	B
MTP-M24X3.00ISO6H-TB-V008-A	03000195	M24	3,0 -	18,0 0.709	113,0 4.449	30,0 1.181	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6H	B
MTP-M27X3.00ISO6H-TB-V008-A	03000196	M27	3,0 -	20,0 0.787	97,0 3.819	30,0 1.181	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6H	B
MTP-M30X3.50ISO6H-TB-V008-A	03000197	M30	3,5 -	22,0 0.866	115,0 4.528	36,0 1.417	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6H	B
MTP-M33X3.50ISO6H-TB-V008-A	03000198	M33	3,5 -	25,0 0.984	113,0 4.449	50,0 1.969	180,0 7.087	29,5 1.161	25.00X20.00	4	DIN376	6H	B
MTP-M36X4.00ISO6H-TB-V008-A	03000199	M36	4,0 -	28,0 1.102	131,0 5.157	55,0 2.165	200,0 7.874	32,0 1.260	28.00X22.00	4	DIN376	6H	B

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## MTP-V014

Through holes



- For cutting data see page(s) 248
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-M4X0.50ISO6H-TB-V014	03019130	MF4X0.5	0,5	–	2,8 <i>0.110</i>	43,0 <i>1.693</i>	11,9 <i>0.469</i>	63,0 <i>2.480</i>	3,5 <i>0.138</i>	2.80X2.10	3	DIN374	6H	B
MTP-M5X0.50ISO6H-TB-V014	03019131	MF5X0.5	0,5	–	3,5 <i>0.138</i>	49,0 <i>1.929</i>	13,2 <i>0.520</i>	70,0 <i>2.756</i>	4,5 <i>0.177</i>	3.50X2.70	3	DIN374	6H	B
MTP-M6X0.75ISO6H-TB-V014	03019210	MF6X0.75	0,75	–	4,5 <i>0.177</i>	59,0 <i>2.323</i>	15,1 <i>0.594</i>	80,0 <i>3.150</i>	5,3 <i>0.209</i>	4.50X3.40	3	DIN374	6H	B
MTP-M8X0.75ISO6H-TB-V014	03019132	MF8X0.75	0,75	–	6,0 <i>0.236</i>	57,0 <i>2.244</i>	14,9 <i>0.587</i>	80,0 <i>3.150</i>	7,3 <i>0.287</i>	6.00X4.90	3	DIN374	6H	B
MTP-M8X1.00ISO6H-TB-V014	03019133	MF8X1.0	1,0	–	6,0 <i>0.236</i>	67,0 <i>2.638</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	7,1 <i>0.280</i>	6.00X4.90	3	DIN374	6H	B
MTP-M9X1.00ISO6H-TB-V014	03000358	MF9X1.0	1,0	–	7,0 <i>0.276</i>	67,0 <i>2.638</i>	17,0 <i>0.669</i>	90,0 <i>3.543</i>	8,1 <i>0.319</i>	7.00X5.50	3	DIN374	6H	B
MTP-M10X0.75ISO6H-TB-V014	03019134	MF10X0.75	0,75	–	7,0 <i>0.276</i>	67,0 <i>2.638</i>	17,6 <i>0.693</i>	90,0 <i>3.543</i>	9,3 <i>0.366</i>	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.00ISO6H-TB-V014	03019135	MF10X1.0	1,0	–	7,0 <i>0.276</i>	67,0 <i>2.638</i>	17,6 <i>0.693</i>	90,0 <i>3.543</i>	9,1 <i>0.358</i>	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.25ISO6H-TB-V014	03019136	MF10X1.25	1,25	–	7,0 <i>0.276</i>	77,0 <i>3.031</i>	19,8 <i>0.780</i>	100,0 <i>3.937</i>	8,8 <i>0.346</i>	7.00X5.50	3	DIN374	6H	B
MTP-M11X1.00ISO6H-TB-V014	03000359	MF11X1.0	1,0	–	8,0 <i>0.315</i>	63,0 <i>2.480</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	10,1 <i>0.398</i>	8.00X6.20	3	DIN374	6H	B
MTP-M11X1.25ISO6H-TB-V014	03000360	MF11X1.25	1,25	–	8,0 <i>0.315</i>	63,0 <i>2.480</i>	22,0 <i>0.866</i>	90,0 <i>3.543</i>	9,8 <i>0.386</i>	8.00X6.20	3	DIN374	6H	B
MTP-M12X1.00ISO6H-TB-V014	03019137	MF12X1.0	1,0	–	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	11,1 <i>0.437</i>	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.25ISO6H-TB-V014	03019138	MF12X1.25	1,25	–	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	10,8 <i>0.425</i>	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.50ISO6H-TB-V014	03019139	MF12X1.5	1,5	–	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	10,6 <i>0.417</i>	9.00X7.00	3	DIN374	6H	B
MTP-M14X1.00ISO6H-TB-V014	03019140	MF14X1.0	1,0	–	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	13,1 <i>0.516</i>	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.25ISO6H-TB-V014	03019141	MF14X1.25	1,25	–	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	12,8 <i>0.504</i>	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.50ISO6H-TB-V014	03019142	MF14X1.5	1,5	–	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	12,6 <i>0.496</i>	11.00X9.00	3	DIN374	6H	B
MTP-M16X1.00ISO6H-TB-V014	03019143	MF16X1.0	1,0	–	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	15,1 <i>0.594</i>	12.00X9.00	3	DIN374	6H	B
MTP-M16X1.50ISO6H-TB-V014	03019144	MF16X1.5	1,5	–	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	14,6 <i>0.575</i>	12.00X9.00	3	DIN374	6H	B
MTP-M18X1.00ISO6H-TB-V014	03019145	MF18X1.0	1,0	–	14,0 <i>0.551</i>	66,0 <i>2.598</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	17,1 <i>0.673</i>	14.00X11.00	4	DIN374	6H	B
MTP-M18X1.50ISO6H-TB-V014	03019146	MF18X1.5	1,5	–	14,0 <i>0.551</i>	66,0 <i>2.598</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	16,6 <i>0.654</i>	14.00X11.00	4	DIN374	6H	B
MTP-M20X1.00ISO6H-TB-V014	03019147	MF20X1.0	1,0	–	16,0 <i>0.630</i>	80,0 <i>3.150</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	19,1 <i>0.752</i>	16.00X12.00	4	DIN374	6H	B

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

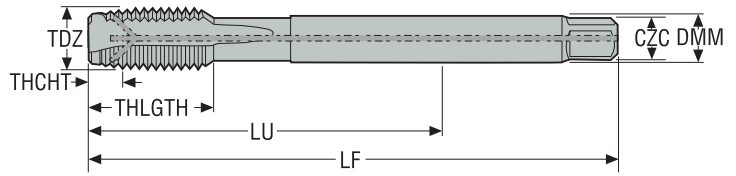
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-M20X1.50ISO6H-TB-V014	03019148	MF20X1.5	1,5	–	16,0 <i>0.630</i>	80,0 <i>3.150</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	18,6 <i>0.732</i>	16.00X12.00	4	DIN374	6H	B
MTP-M22X1.50ISO6H-TB-V014	03019149	MF22X1.5	1,5	–	18,0 <i>0.709</i>	78,0 <i>3.071</i>	25,0 <i>0.984</i>	125,0 <i>4.921</i>	20,5 <i>0.807</i>	18.00X14.50	4	DIN374	6H	B
MTP-M24X1.50ISO6H-TB-V014	03019151	MF24X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	22,5 <i>0.886</i>	18.00X14.50	4	DIN374	6H	B
MTP-M24X2.00ISO6H-TB-V014	03019152	MF24X2.0	2,0	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	22,0 <i>0.866</i>	18.00X14.50	4	DIN374	6H	B
MTP-M25X1.50ISO6H-TB-V014	03019153	MF25X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	23,5 <i>0.925</i>	18.00X14.50	4	DIN374	6H	B
MTP-M26X1.50ISO6H-TB-V014	03019155	MF26X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	24,5 <i>0.965</i>	18.00X14.50	4	DIN374	6H	B
MTP-M27X1.50ISO6H-TB-V014	03019156	MF27X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	25,5 <i>1.004</i>	20.00X16.00	4	DIN374	6H	B
MTP-M27X2.00ISO6H-TB-V014	03019157	MF27X2.0	2,0	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	25,0 <i>0.984</i>	20.00X16.00	4	DIN374	6H	B
MTP-M28X1.50ISO6H-TB-V014	03019158	MF28X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	26,5 <i>1.043</i>	20.00X16.00	4	DIN374	6H	B
MTP-M30X1.50ISO6H-TB-V014	03019159	MF30X1.5	1,5	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	28,0 <i>1.102</i>	150,0 <i>5.906</i>	28,5 <i>1.122</i>	22.00X18.00	4	DIN374	6H	B
MTP-M30X2.00ISO6H-TB-V014	03019160	MF30X2.0	2,0	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	28,0 <i>1.102</i>	150,0 <i>5.906</i>	28,0 <i>1.102</i>	22.00X18.00	4	DIN374	6H	B

Designation Ansi	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTP-M6X0.75ISO6H-TB.V014	03019210	MF6X0.75	0,75	–	4,5 <i>0.177</i>	59,0 <i>2.323</i>	15,1 <i>0.594</i>	80,0 <i>3.150</i>	5,3 <i>0.209</i>	4.50X3.40	3	DIN374	6H	B

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## MTP-V014-A

Through holes



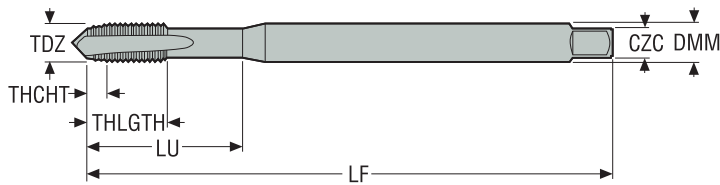
- For cutting data see page(s) 248
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-M6X0.75ISO6H-TB-V014-A	03000200	MF6X0.75	0,75	-	4,5 <i>0.177</i>	59,0 <i>2.323</i>	15,1 <i>0.594</i>	80,0 <i>3.150</i>	5,3 <i>0.209</i>	4.50X3.40	3	DIN374	6H	B
MTP-M8X0.75ISO6H-TB-V014-A	03000201	MF8X0.75	0,75	-	6,0 <i>0.236</i>	57,0 <i>2.244</i>	14,9 <i>0.587</i>	80,0 <i>3.150</i>	7,3 <i>0.287</i>	6.00X4.90	3	DIN374	6H	B
MTP-M8X1.00ISO6H-TB-V014-A	03000202	MF8X1.0	1,0	-	6,0 <i>0.236</i>	67,0 <i>2.638</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	7,1 <i>0.280</i>	6.00X4.90	3	DIN374	6H	B
MTP-M10X0.75ISO6H-TB-V014-A	03000203	MF10X0.75	0,75	-	7,0 <i>0.276</i>	67,0 <i>2.638</i>	17,6 <i>0.693</i>	90,0 <i>3.543</i>	9,3 <i>0.366</i>	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.00ISO6H-TB-V014-A	03000204	MF10X1.0	1,0	-	7,0 <i>0.276</i>	67,0 <i>2.638</i>	17,6 <i>0.693</i>	90,0 <i>3.543</i>	9,1 <i>0.358</i>	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.25ISO6H-TB-V014-A	03000205	MF10X1.25	1,25	-	7,0 <i>0.276</i>	77,0 <i>3.031</i>	19,8 <i>0.780</i>	100,0 <i>3.937</i>	8,8 <i>0.346</i>	7.00X5.50	3	DIN374	6H	B
MTP-M12X1.00ISO6H-TB-V014-A	03000206	MF12X1.0	1,0	-	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	11,1 <i>0.437</i>	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.25ISO6H-TB-V014-A	03000207	MF12X1.25	1,25	-	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	10,8 <i>0.425</i>	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.50ISO6H-TB-V014-A	03000208	MF12X1.5	1,5	-	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	10,6 <i>0.417</i>	9.00X7.00	3	DIN374	6H	B
MTP-M14X1.00ISO6H-TB-V014-A	03000209	MF14X1.0	1,0	-	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	13,1 <i>0.516</i>	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.25ISO6H-TB-V014-A	03000210	MF14X1.25	1,25	-	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	12,8 <i>0.504</i>	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.50ISO6H-TB-V014-A	03000211	MF14X1.5	1,5	-	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	12,6 <i>0.496</i>	11.00X9.00	3	DIN374	6H	B
MTP-M16X1.00ISO6H-TB-V014-A	03000212	MF16X1.0	1,0	-	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	15,1 <i>0.594</i>	12.00X9.00	3	DIN374	6H	B
MTP-M16X1.50ISO6H-TB-V014-A	03000213	MF16X1.5	1,5	-	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	14,6 <i>0.575</i>	12.00X9.00	3	DIN374	6H	B
MTP-M18X1.00ISO6H-TB-V014-A	03000214	MF18X1.0	1,0	-	14,0 <i>0.551</i>	66,0 <i>2.598</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	17,1 <i>0.673</i>	14.00X11.00	4	DIN374	6H	B
MTP-M18X1.50ISO6H-TB-V014-A	03000215	MF18X1.5	1,5	-	14,0 <i>0.551</i>	66,0 <i>2.598</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	16,6 <i>0.654</i>	14.00X11.00	4	DIN374	6H	B
MTP-M20X1.00ISO6H-TB-V014-A	03000216	MF20X1.0	1,0	-	16,0 <i>0.630</i>	80,0 <i>3.150</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	19,1 <i>0.752</i>	16.00X12.00	4	DIN374	6H	B
MTP-M20X1.50ISO6H-TB-V014-A	03000217	MF20X1.5	1,5	-	16,0 <i>0.630</i>	80,0 <i>3.150</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	18,6 <i>0.732</i>	16.00X12.00	4	DIN374	6H	B
MTP-M22X1.50ISO6H-TB-V014-A	03000218	MF22X1.5	1,5	-	18,0 <i>0.709</i>	78,0 <i>3.071</i>	25,0 <i>0.984</i>	125,0 <i>4.921</i>	20,5 <i>0.807</i>	18.00X14.50	4	DIN374	6H	B
MTP-M24X1.50ISO6H-TB-V014-A	03000219	MF24X1.5	1,5	-	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	22,5 <i>0.886</i>	18.00X14.50	4	DIN374	6H	B
MTP-M24X2.00ISO6H-TB-V014-A	03000220	MF24X2.0	2,0	-	18,0 <i>0.709</i>	93,0 <i>3.661</i>	28,0 <i>1.102</i>	140,0 <i>5.512</i>	22,0 <i>0.866</i>	18.00X14.50	4	DIN374	6H	B



# MTP-V017

Through holes



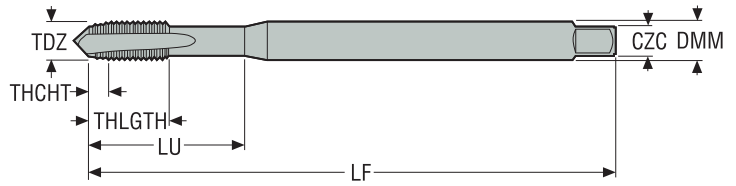
- For cutting data see page(s) 248
- Coating: TiN
- Substrate: HSS-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CXC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-4-40UNC-TB-V017	03019161	UNC4-40	-	40.0	3,5 0.138	18,0 0.709	8,5 0.335	56,0 2.205	2,35 0.093	3.50X2.70	3	DIN2184-1	2B	B
MTP-5-40UNC-TB-V017	03019162	UNC5-40	-	40.0	3,5 0.138	18,0 0.709	9,5 0.374	56,0 2.205	2,65 0.104	3.50X2.70	3	DIN2184-1	2B	B
MTP-6-32UNC-TB-V017	03019164	UNC6-32	-	32.0	4,0 0.157	20,0 0.787	10,4 0.409	56,0 2.205	2,85 0.112	4.00X3.00	3	DIN2184-1	2B	B
MTP-8-32UNC-TB-V017	03019165	UNC8-32	-	32.0	4,5 0.177	21,0 0.827	11,4 0.449	63,0 2.480	3,5 0.138	4.50X3.40	3	DIN2184-1	2B	B
MTP-10-24UNC-TB-V017	03019166	UNC10-24	-	24.0	6,0 0.236	25,0 0.984	12,2 0.480	70,0 2.756	3,9 0.154	6.00X4.90	3	DIN2184-1	2B	B
MTP-12-24UNC-TB-V017	03019167	UNC12-24	-	24.0	6,0 0.236	30,0 1.181	14,2 0.559	80,0 3.150	4,5 0.177	6.00X4.90	3	DIN2184-1	2B	B
MTP-1/4-20UNC-TB-V017	03019168	UNC1/4-20	-	20.0	7,0 0.276	30,0 1.181	14,1 0.555	80,0 3.150	5,2 0.205	7.00X5.50	3	DIN2184-1	2B	B
MTP-5/16-18UNC-TB-V017	03019169	UNC5/16-18	-	18.0	8,0 0.315	35,0 1.378	17,4 0.685	90,0 3.543	6,7 0.264	8.00X6.20	3	DIN2184-1	2B	B
MTP-3/8-16UNC-TB-V017	03019170	UNC3/8-16	-	16.0	10,0 0.394	39,0 1.535	18,9 0.744	100,0 3.937	8,1 0.319	10.00X8.00	3	DIN2184-1	2B	B
MTP-7/16-14UNC-TB-V017	03019171	UNC7/16-14	-	14.0	8,0 0.315	76,0 2.992	20,0 0.787	100,0 3.937	9,5 0.374	8.00X6.20	3	DIN2184-1	2B	B
MTP-1/2-13UNC-TB-V017	03019172	UNC1/2-13	-	13.0	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,9 0.429	9.00X7.00	3	DIN2184-1	2B	B
MTP-5/8-11UNC-TB-V017	03019173	UNC5/8-11	-	11.0	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	13,8 0.543	12.00X9.00	3	DIN2184-1	2B	B

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## MTP-V020

Through holes



- For cutting data see page(s) 248
- Coating: TiN
- Substrate: HSS-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTP-8-36UNF-TB-V020	03019175	UNF8-36	- 36.0	4,5 0.177	21,0 0.827	11,4 0.449	63,0 2.480	3,5 0.138	4.50X3.40	3	DIN2184-1	2B	B
MTP-10-32UNF-TB-V020	03019176	UNF10-32	- 32.0	6,0 0.236	25,0 0.984	12,2 0.480	70,0 2.756	4,1 0.161	6.00X4.90	3	DIN2184-1	2B	B
MTP-1/4-28UNF-TB-V020	03019177	UNF1/4-28	- 28.0	7,0 0.276	30,0 1.181	14,1 0.555	80,0 3.150	5,5 0.217	7.00X5.50	3	DIN2184-1	2B	B
MTP-5/16-24UNF-TB-V020	03019178	UNF5/16-24	- 24.0	8,0 0.315	35,0 1.378	17,4 0.685	90,0 3.543	7,0 0.276	8.00X6.20	3	DIN2184-1	2B	B
MTP-7/16-20UNF-TB-V020	03019179	UNF7/16-20	- 20.0	8,0 0.315	76,0 2.992	20,0 0.787	100,0 3.937	10,0 0.394	8.00X6.20	3	DIN2184-1	2B	B
MTP-1/2-20UNF-TB-V020	03019180	UNF1/2-20	- 20.0	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	11,5 0.453	9.00X7.00	3	DIN2184-1	2B	B
MTP-5/8-18UNF-TB-V020	03019181	UNF5/8-18	- 18.0	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,6 0.575	12.00X9.00	3	DIN2184-1	2B	B

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Thread turning

Thread MDT

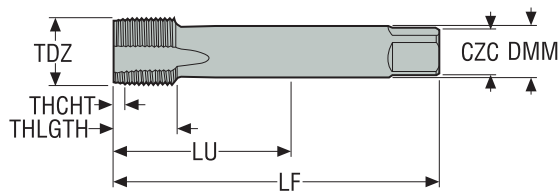
Thread Mini-Start™

Rotating threading

Annex

# MTP-V023

Through holes



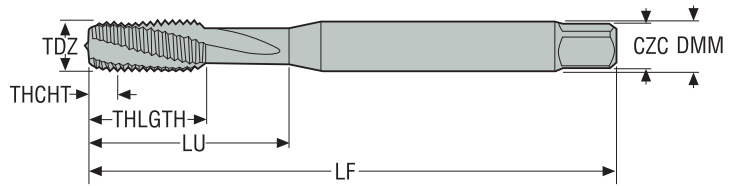
- For cutting data see page(s) 248
- Coating: TiN
- Substrate: HSS-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTP-1/8-28G-TB-V023	03019182	G1/8-28	-	28.0	7,0 0.276	67,0 2.638	17,6 0.693	90,0 3.543	8,8 0.346	7.00X5.50	3	DIN5156	NORMAL	B
MTP-1/4-19G-TB-V023	03019211	G1/4-19	-	19.0	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	11,8 0.465	11.00X9.00	3	DIN5156	NORMAL	B
MTP-3/8-19G-TB-V023	03019185	G3/8-19	-	19.0	12,0 0.472	58,0 2.283	21,0 0.827	100,0 3.937	15,3 0.602	12.00X9.00	4	DIN5156	NORMAL	B
MTP-1/2-14G-TB-V023	03019186	G1/2-14	-	14.0	16,0 0.630	80,0 3.150	24,0 0.945	125,0 4.921	19,1 0.752	16.00X12.00	4	DIN5156	NORMAL	B
MTP-5/8-14G-TB-V023	03019187	G5/8-14	-	14.0	18,0 0.709	78,0 3.071	24,0 0.945	125,0 4.921	21,1 0.831	18.00X14.50	4	DIN5156	NORMAL	B

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# MTH-P001

Blind holes



- For cutting data see page(s) 226
- Coating: TiAIN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTH-M3X0.50ISO6H-BC-P001	02999974	M3	0,5	–	4,5 <i>0.177</i>	12,0 <i>0.472</i>	12,0 <i>0.472</i>	63,0 <i>2.480</i>	2,5 <i>0.098</i>	4.50X3.40	3	SECO-DIN	6H	C
MTH-M4X0.70ISO6H-BC-P001	02999975	M4	0,7	–	6,0 <i>0.236</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	3,4 <i>0.134</i>	6.00X4.90	3	SECO-DIN	6H	C
MTH-M5X0.80ISO6H-BC-P001	02999976	M5	0,8	–	6,0 <i>0.236</i>	15,0 <i>0.591</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	4,3 <i>0.169</i>	6.00X4.90	3	SECO-DIN	6H	C
MTH-M6X1.00ISO6H-BC-P001	02999977	M6	1,0	–	8,0 <i>0.315</i>	18,0 <i>0.709</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	5,1 <i>0.201</i>	8.00X6.20	3	SECO-DIN	6H	C
MTH-M8X1.25ISO6H-BC-P001	02999978	M8	1,25	–	10,0 <i>0.394</i>	20,0 <i>0.787</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	6,8 <i>0.268</i>	10.00X8.00	3	SECO-DIN	6H	C
MTH-M10X1.50ISO6H-BC-P001	02999979	M10	1,5	–	10,0 <i>0.394</i>	39,0 <i>1.535</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	SECO-DIN	6H	C

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Thread turning

Thread MDT

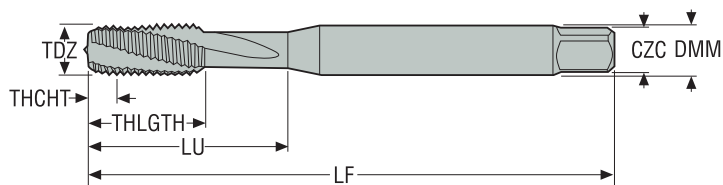
Thread Mini-Start™

Rotating threading

Annex

# MTH-P001-A

Blind holes



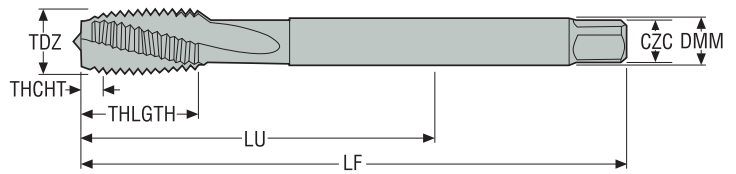
- For cutting data see page(s) 226
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M4X0.70ISO6H-BC-P001-A	02999985	M4	0,7	–	6,0 0.236	13,0 0.512	13,0 0.512	70,0 2.756	3,4 0.134	6.00X4.90	3	SECO-DIN	6H	C
MTH-M5X0.80ISO6H-BC-P001-A	02999986	M5	0,8	–	6,0 0.236	15,0 0.591	15,0 0.591	80,0 3.150	4,3 0.169	6.00X4.90	3	SECO-DIN	6H	C
MTH-M6X1.00ISO6H-BC-P001-A	02999987	M6	1,0	–	8,0 0.315	18,0 0.709	18,0 0.709	90,0 3.543	5,1 0.201	8.00X6.20	3	SECO-DIN	6H	C
MTH-M8X1.25ISO6H-BC-P001-A	02999988	M8	1,25	–	10,0 0.394	20,0 0.787	20,0 0.787	100,0 3.937	6,8 0.268	10.00X8.00	3	SECO-DIN	6H	C
MTH-M10X1.50ISO6H-BC-P001-A	02999989	M10	1,5	–	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	8,6 0.339	10.00X8.00	3	SECO-DIN	6H	C

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## MTH-P002

Blind holes



- For cutting data see page(s) 226
- Coating: TiAIN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTH-M12X1.75ISO6H-BC-P002	02999980	M12	1,75	–	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	4	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-P002	02999981	M14	2,0	–	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	4	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-P002	02999982	M16	2,0	–	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-P002	02999983	M18	2,5	–	14,0 <i>0.551</i>	81,0 <i>3.189</i>	30,0 <i>1.181</i>	125,0 <i>4.921</i>	15,7 <i>0.618</i>	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-P002	02999984	M20	2,5	–	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	4	DIN376	6H	C

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Thread turning

Thread MDT

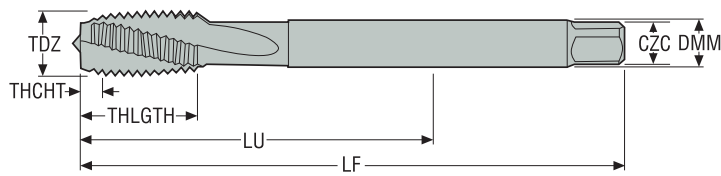
Thread Mini-Start™

Rotating threading

Annex

# MTH-P002-A

Blind holes



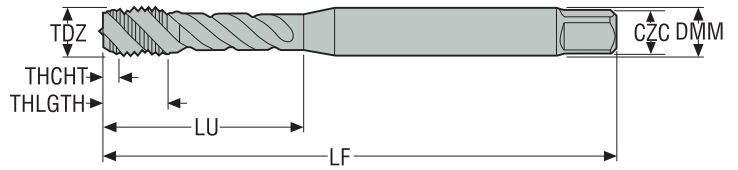
- For cutting data see page(s) 226
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6H-BC-P002-A	02999990	M12	1,75	–	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,4 0.409	9.00X7.00	4	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-P002-A	02999991	M14	2,0	–	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	4	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-P002-A	02999992	M16	2,0	–	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-P002-A	02999993	M18	2,5	–	14,0 0.551	81,0 3.189	30,0 1.181	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-P002-A	02999994	M20	2,5	–	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6H	C

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# MTH-P003

Blind holes



- For cutting data see page(s) 226
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M1.6X0.35ISO6HX-BC-P003	02999995	M1.6	0,35 -	2,5 0.098	6,0 0.236	4,0 0.157	40,0 1.575	1,3 0.051	2.50X2.10	2	DIN371	6HX	C
MTH-M2X0.40ISO6HX-BC-P003	02999996	M2	0,4 -	2,8 0.110	9,0 0.354	4,0 0.157	45,0 1.772	1,6 0.063	2.80X2.10	2	DIN371	6HX	C
MTH-M2.2X0.45ISO6HX-BC-P003	02999997	M2.2	0,45 -	2,8 0.110	12,0 0.472	4,0 0.157	45,0 1.772	1,8 0.071	2.80X2.10	2	DIN371	6HX	C
MTH-M2.3X0.40ISO6HX-BC-P003	02999998	M2.3	0,4 -	2,8 0.110	12,0 0.472	4,0 0.157	45,0 1.772	1,9 0.075	2.80X2.10	2	DIN371	6HX	C
MTH-M2.5X0.45ISO6HX-BC-P003	02999999	M2.5	0,45 -	2,8 0.110	12,5 0.492	4,0 0.157	50,0 1.969	2,1 0.083	2.80X2.10	2	DIN371	6HX	C
MTH-M2.6X0.45ISO6HX-BC-P003	03000000	M2.6	0,45 -	2,8 0.110	12,5 0.492	4,0 0.157	50,0 1.969	2,15 0.085	2.80X2.10	2	DIN371	6HX	C
MTH-M3X0.50ISO6HX-BC-P003	03000001	M3	0,5 -	3,5 0.138	18,0 0.709	5,9 0.232	56,0 2.205	2,5 0.098	3.50X2.70	3	DIN371	6HX	C
MTH-M3.5X0.60ISO6HX-BC-P003	03000002	M3.5	0,6 -	4,0 0.157	20,0 0.787	7,0 0.276	56,0 2.205	2,9 0.114	4.00X3.00	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-P003	03000003	M4	0,7 -	4,5 0.177	21,0 0.827	6,7 0.264	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-P003	03000004	M5	0,8 -	6,0 0.236	25,0 0.984	7,7 0.303	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-P003	03000006	M6	1,0 -	6,0 0.236	30,0 1.181	10,0 0.394	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6HX	C
MTH-M7X1.00ISO6HX-BC-P003	03000007	M7	1,0 -	7,0 0.276	30,0 1.181	10,0 0.394	80,0 3.150	6,1 0.240	7.00X5.50	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-P003	03000008	M8	1,25 -	8,0 0.315	35,0 1.378	11,6 0.457	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-P003	03000009	M10	1,5 -	10,0 0.394	39,0 1.535	15,1 0.594	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Shaft™

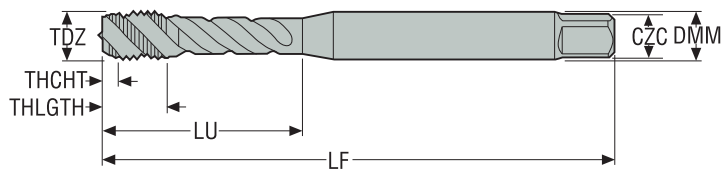
Rotating threading

Annex



# MTH-P003-A

Blind holes



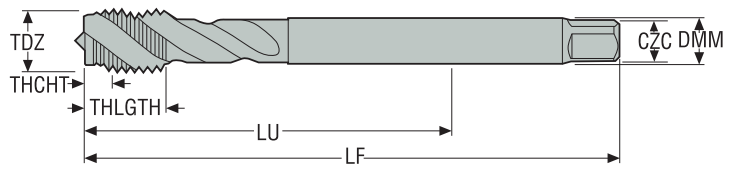
- For cutting data see page(s) 226
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M4X0.70ISO6HX-BC-P003-A	03000024	M4	0,7	–	4,5 0.177	21,0 0.827	6,7 0.264	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-P003-A	03000025	M5	0,8	–	6,0 0.236	25,0 0.984	7,7 0.303	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-P003-A	03000026	M6	1,0	–	6,0 0.236	30,0 1.181	10,0 0.394	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6HX	C
MTH-M7X1.00ISO6HX-BC-P003-A	03000027	M7	1,0	–	7,0 0.276	30,0 1.181	10,0 0.394	80,0 3.150	6,1 0.240	7.00X5.50	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-P003-A	03000028	M8	1,25	–	8,0 0.315	35,0 1.378	11,6 0.457	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-P003-A	03000029	M10	1,5	–	10,0 0.394	39,0 1.535	15,1 0.594	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MTH-P004

Blind holes



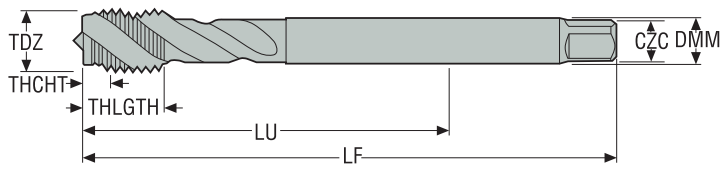
- For cutting data see page(s) 226
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M5X0.80ISO6HX-BC-P004	03000010	M5	0,8 -	3,5 0.138	49,0 1.929	8,0 0.315	70,0 2.756	4,3 0.169	3.50X2.70	3	DIN376	6HX	C
MTH-M6X1.00ISO6HX-BC-P004	03000011	M6	1,0 -	4,5 0.177	59,0 2.323	10,0 0.394	80,0 3.150	5,1 0.201	4.50X3.40	3	DIN376	6HX	C
MTH-M7X1.00ISO6HX-BC-P004	03000012	M7	1,0 -	5,5 0.217	59,0 2.323	10,0 0.394	80,0 3.150	6,1 0.240	5.50X4.30	3	DIN376	6HX	C
MTH-M8X1.25ISO6HX-BC-P004	03000013	M8	1,25 -	6,0 0.236	67,0 2.638	13,0 0.512	90,0 3.543	6,8 0.268	6.00X4.90	3	DIN376	6HX	C
MTH-M10X1.50ISO6HX-BC-P004	03000014	M10	1,5 -	7,0 0.276	77,0 3.031	20,0 0.787	100,0 3.937	8,6 0.339	7.00X5.50	3	DIN376	6HX	C
MTH-M12X1.75ISO6HX-BC-P004	03000015	M12	1,75 -	9,0 0.354	83,0 3.268	16,0 0.630	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6HX	C
MTH-M14X2.00ISO6HX-BC-P004	03000016	M14	2,0 -	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	3	DIN376	6HX	C
MTH-M16X2.00ISO6HX-BC-P004	03000017	M16	2,0 -	12,0 0.472	68,0 2.677	20,0 0.787	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6HX	C
MTH-M18X2.50ISO6HX-BC-P004	03000018	M18	2,5 -	14,0 0.551	81,0 3.189	25,0 0.984	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6HX	C
MTH-M20X2.50ISO6HX-BC-P004	03000019	M20	2,5 -	16,0 0.630	95,0 3.740	25,0 0.984	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6HX	C
MTH-M22X2.50ISO6HX-BC-P004	03000020	M22	2,5 -	18,0 0.709	93,0 3.661	25,0 0.984	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6HX	C
MTH-M24X3.00ISO6HX-BC-P004	03000021	M24	3,0 -	18,0 0.709	113,0 4.449	30,0 1.181	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6HX	C
MTH-M27X3.00ISO6HX-BC-P004	03000022	M27	3,0 -	20,0 0.787	97,0 3.819	30,0 1.181	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6HX	C
MTH-M30X3.50ISO6HX-BC-P004	03000023	M30	3,5 -	22,0 0.866	115,0 4.528	36,0 1.417	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# MTH-P004-A

Blind holes



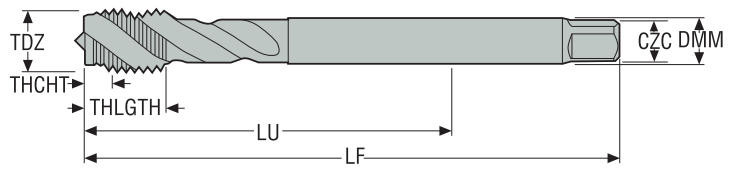
- For cutting data see page(s) 226
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6HX-BC-P004-A	03000030	M12	1,75	–	9,0 0.354	83,0 3.268	16,0 0.630	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6HX	C
MTH-M14X2.00ISO6HX-BC-P004-A	03000031	M14	2,0	–	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	3	DIN376	6HX	C
MTH-M16X2.00ISO6HX-BC-P004-A	03000032	M16	2,0	–	12,0 0.472	68,0 2.677	20,0 0.787	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6HX	C
MTH-M18X2.50ISO6HX-BC-P004-A	03000033	M18	2,5	–	14,0 0.551	81,0 3.189	25,0 0.984	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6HX	C
MTH-M20X2.50ISO6HX-BC-P004-A	03000034	M20	2,5	–	16,0 0.630	95,0 3.740	25,0 0.984	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6HX	C
MTH-M22X2.50ISO6HX-BC-P004-A	03000036	M22	2,5	–	18,0 0.709	93,0 3.661	25,0 0.984	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6HX	C
MTH-M24X3.00ISO6HX-BC-P004-A	03000037	M24	3,0	–	18,0 0.709	113,0 4.449	30,0 1.181	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6HX	C
MTH-M27X3.00ISO6HX-BC-P004-A	03000038	M27	3,0	–	20,0 0.787	97,0 3.819	30,0 1.181	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6HX	C
MTH-M30X3.50ISO6HX-BC-P004-A	03000039	M30	3,5	–	22,0 0.866	115,0 4.528	36,0 1.417	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# MTH-P011

Blind holes



- For cutting data see page(s) 226
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M4X0.50ISO6HX-BC-P011	03000040	MF4X0.5	0,5	–	2,8 0.110	43,0 1.693	7,0 0.276	63,0 2.480	3,5 0.138	2.80X2.10	3	DIN374	6HX	C
MTH-M5X0.50ISO6HX-BC-P011	03000041	MF5X0.5	0,5	–	3,5 0.138	49,0 1.929	8,0 0.315	70,0 2.756	4,5 0.177	3.50X2.70	3	DIN374	6HX	C
MTH-M6X0.75ISO6HX-BC-P011	03000042	MF6X0.75	0,75	–	4,5 0.177	59,0 2.323	10,0 0.394	80,0 3.150	5,3 0.209	4.50X3.40	3	DIN374	6HX	C
MTH-M8X0.75ISO6HX-BC-P011	03000043	MF8X0.75	0,75	–	6,0 0.236	57,0 2.244	13,0 0.512	80,0 3.150	7,3 0.287	6.00X4.90	3	DIN374	6HX	C
MTH-M8X1.00ISO6HX-BC-P011	03000044	MF8X1.0	1,0	–	6,0 0.236	67,0 2.638	13,0 0.512	90,0 3.543	7,1 0.280	6.00X4.90	3	DIN374	6HX	C
MTH-M10X0.75ISO6HX-BC-P011	03000045	MF10X0.75	0,75	–	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	9,3 0.366	7.00X5.50	3	DIN374	6HX	C
MTH-M10X1.00ISO6HX-BC-P011	03000046	MF10X1.0	1,0	–	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	9,1 0.358	7.00X5.50	3	DIN374	6HX	C
MTH-M10X1.25ISO6HX-BC-P011	03000047	MF10X1.25	1,25	–	7,0 0.276	77,0 3.031	15,0 0.591	100,0 3.937	8,8 0.346	7.00X5.50	3	DIN374	6HX	C
MTH-M12X1.00ISO6HX-BC-P011	03000048	MF12X1.0	1,0	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	11,1 0.437	9.00X7.00	3	DIN374	6HX	C
MTH-M12X1.25ISO6HX-BC-P011	03000049	MF12X1.25	1,25	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,8 0.425	9.00X7.00	3	DIN374	6HX	C
MTH-M12X1.50ISO6HX-BC-P011	03000050	MF12X1.5	1,5	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,6 0.417	9.00X7.00	3	DIN374	6HX	C
MTH-M14X1.00ISO6HX-BC-P011	03000051	MF14X1.0	1,0	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	13,1 0.516	11.00X9.00	3	DIN374	6HX	C
MTH-M14X1.25ISO6HX-BC-P011	03000052	MF14X1.25	1,25	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,8 0.504	11.00X9.00	3	DIN374	6HX	C
MTH-M14X1.50ISO6HX-BC-P011	03000053	MF14X1.5	1,5	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,6 0.496	11.00X9.00	3	DIN374	6HX	C
MTH-M16X1.00ISO6HX-BC-P011	03000054	MF16X1.0	1,0	–	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	15,1 0.594	12.00X9.00	4	DIN374	6HX	C
MTH-M16X1.50ISO6HX-BC-P011	03000055	MF16X1.5	1,5	–	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	14,6 0.575	12.00X9.00	4	DIN374	6HX	C
MTH-M18X1.00ISO6HX-BC-P011	03000056	MF18X1.0	1,0	–	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	17,1 0.673	14.00X11.00	4	DIN374	6HX	C
MTH-M18X1.50ISO6HX-BC-P011	03000057	MF18X1.5	1,5	–	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	16,6 0.654	14.00X11.00	4	DIN374	6HX	C
MTH-M20X1.00ISO6HX-BC-P011	03000058	MF20X1.0	1,0	–	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	19,1 0.752	16.00X12.00	4	DIN374	6HX	C
MTH-M20X1.50ISO6HX-BC-P011	03000059	MF20X1.5	1,5	–	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	18,6 0.732	16.00X12.00	4	DIN374	6HX	C
MTH-M22X1.50ISO6HX-BC-P011	03000060	MF22X1.5	1,5	–	18,0 0.709	78,0 3.071	17,0 0.669	125,0 4.921	20,5 0.807	18.00X14.50	4	DIN374	6HX	C
MTH-M24X1.50ISO6HX-BC-P011	03000061	MF24X1.5	1,5	–	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	22,5 0.886	18.00X14.50	4	DIN374	6HX	C

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M24X2.00ISO6HX-BC-P011	03000062	MF24X2.0	2,0	–	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	22,0 0.866	18.00X14.50	4	DIN374	6HX	C
MTH-M25X1.50ISO6HX-BC-P011	03000063	MF25X1.5	1,5	–	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	23,5 0.925	18.00X14.50	4	DIN374	6HX	C
MTH-M26X1.50ISO6HX-BC-P011	03000064	MF26X1.5	1,5	–	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	24,5 0.965	18.00X14.50	4	DIN374	6HX	C
MTH-M27X1.50ISO6HX-BC-P011	03000065	MF27X1.5	1,5	–	20,0 0.787	77,0 3.031	20,0 0.787	140,0 5.512	25,5 1.004	20.00X16.00	4	DIN374	6HX	C
MTH-M27X2.00ISO6HX-BC-P011	03000066	MF27X2.0	2,0	–	20,0 0.787	77,0 3.031	20,0 0.787	140,0 5.512	25,0 0.984	20.00X16.00	4	DIN374	6HX	C
MTH-M28X1.50ISO6HX-BC-P011	03000067	MF28X1.5	1,5	–	20,0 0.787	77,0 3.031	20,0 0.787	140,0 5.512	26,5 1.043	20.00X16.00	4	DIN374	6HX	C
MTH-M30X1.50ISO6HX-BC-P011	03000068	MF30X1.5	1,5	–	22,0 0.866	85,0 3.346	20,0 0.787	150,0 5.906	28,5 1.122	22.00X18.00	4	DIN374	6HX	C
MTH-M30X2.00ISO6HX-BC-P011	03000069	MF30X2.0	2,0	–	22,0 0.866	85,0 3.346	20,0 0.787	150,0 5.906	28,0 1.102	22.00X18.00	4	DIN374	6HX	C

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Thread turning

Thread MDT

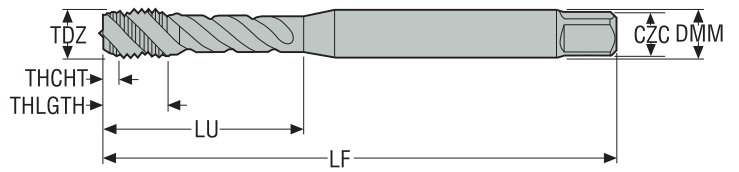
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-M003

Blind holes



- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M1.6X0.35ISO6H-BC-M003	03000106	M1.6	0,35 -	2,5 0.098	6,0 0.236	4,0 0.157	40,0 1.575	1,3 0.051	2.50X2.10	2	DIN371	6H	C
MTH-M2X0.40ISO6H-BC-M003	03000107	M2	0,4 -	2,8 0.110	9,0 0.354	4,0 0.157	45,0 1.772	1,6 0.063	2.80X2.10	3	DIN371	6H	C
MTH-M2.2X0.45ISO6H-BC-M003	03000108	M2.2	0,45 -	2,8 0.110	12,0 0.472	4,0 0.157	45,0 1.772	1,8 0.071	2.80X2.10	3	DIN371	6H	C
MTH-M2.3X0.40ISO6H-BC-M003	03000109	M2.3	0,4 -	2,8 0.110	12,0 0.472	4,0 0.157	45,0 1.772	1,9 0.075	2.80X2.10	3	DIN371	6H	C
MTH-M2.5X0.45ISO6H-BC-M003	03000110	M2.5	0,45 -	2,8 0.110	12,5 0.492	4,0 0.157	50,0 1.969	2,1 0.083	2.80X2.10	3	DIN371	6H	C
MTH-M2.6X0.45ISO6H-BC-M003	03000111	M2.6	0,45 -	2,8 0.110	12,5 0.492	4,0 0.157	50,0 1.969	2,15 0.085	2.80X2.10	3	DIN371	6H	C
MTH-M3X0.50ISO6H-BC-M003	03000112	M3	0,5 -	3,5 0.138	18,0 0.709	5,9 0.232	56,0 2.205	2,5 0.098	3.50X2.70	3	DIN371	6H	C
MTH-M3.5X0.60ISO6H-BC-M003	03000113	M3.5	0,6 -	4,0 0.157	20,0 0.787	7,0 0.276	56,0 2.205	2,9 0.114	4.00X3.00	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-M003	03000114	M4	0,7 -	4,5 0.177	21,0 0.827	6,7 0.264	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-M003	03000115	M5	0,8 -	6,0 0.236	25,0 0.984	7,7 0.303	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-M003	03000116	M6	1,0 -	6,0 0.236	30,0 1.181	10,0 0.394	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	C
MTH-M7X1.00ISO6H-BC-M003	03000117	M7	1,0 -	7,0 0.276	30,0 1.181	10,0 0.394	80,0 3.150	6,1 0.240	7.00X5.50	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-M003	03000118	M8	1,25 -	8,0 0.315	35,0 1.378	11,6 0.457	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-M003	03000119	M10	1,5 -	10,0 0.394	39,0 1.535	15,1 0.594	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	C

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Thread turning

Thread MDT

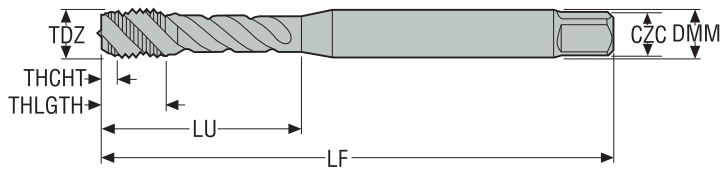
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-M003-A

Blind holes



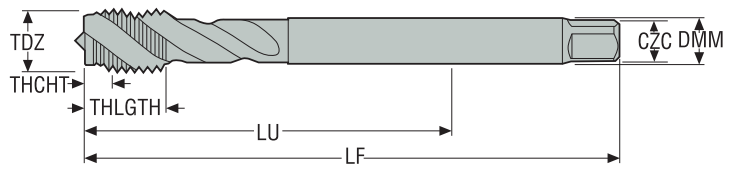
- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CXC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M4X0.70ISO6H-BC-M003-A	03000125	M4	0,7	–	4,5 0.177	21,0 0.827	6,7 0.264	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-M003-A	03000126	M5	0,8	–	6,0 0.236	25,0 0.984	7,7 0.303	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-M003-A	03000127	M6	1,0	–	6,0 0.236	30,0 1.181	10,0 0.394	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	C
MTH-M7X1.00ISO6H-BC-M003-A	03000128	M7	1,0	–	7,0 0.276	30,0 1.181	10,0 0.394	80,0 3.150	6,1 0.240	7.00X5.50	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-M003-A	03000129	M8	1,25	–	8,0 0.315	35,0 1.378	11,6 0.457	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-M003-A	03000130	M10	1,5	–	10,0 0.394	39,0 1.535	15,1 0.594	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	C

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## MTH-M004

Blind holes



- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E

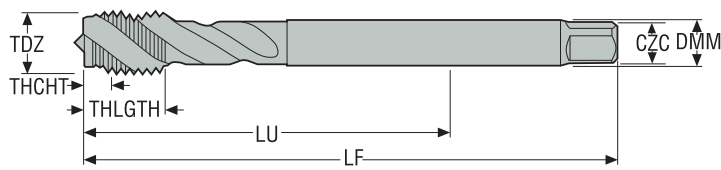
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTH-M12X1.75ISO6H-BC-M004	03000120	M12	1,75	–	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-M004	03000121	M14	2,0	–	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-M004	03000122	M16	2,0	–	12,0 <i>0.472</i>	68,0 <i>2.677</i>	20,0 <i>0.787</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-M004	03000123	M18	2,5	–	14,0 <i>0.551</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	125,0 <i>4.921</i>	15,7 <i>0.618</i>	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-M004	03000124	M20	2,5	–	16,0 <i>0.630</i>	95,0 <i>3.740</i>	25,0 <i>0.984</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	4	DIN376	6H	C

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# MTH-M004-A

Blind holes



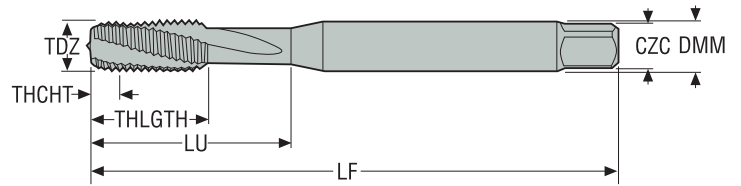
- For cutting data see page(s) 230
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6H-BC-M004-A	03000131	M12	1,75	–	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-M004-A	03000132	M14	2,0	–	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-M004-A	03000133	M16	2,0	–	12,0 0.472	68,0 2.677	20,0 0.787	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-M004-A	03000134	M18	2,5	–	14,0 0.551	81,0 3.189	25,0 0.984	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-M004-A	03000135	M20	2,5	–	16,0 0.630	95,0 3.740	25,0 0.984	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6H	C

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## MTH-N001

Blind holes



- For cutting data see page(s) 232
- Coating: BRIGHT
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M3X0.50ISO6H-BC-N001	03000153	M3	0,5	–	3,5 <i>0.138</i>	18,0 <i>0.709</i>	9,0 <i>0.354</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-N001	03000154	M4	0,7	–	4,5 <i>0.177</i>	21,0 <i>0.827</i>	12,0 <i>0.472</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-N001	03000155	M5	0,8	–	6,0 <i>0.236</i>	25,0 <i>0.984</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-N001	03000156	M6	1,0	–	6,0 <i>0.236</i>	30,0 <i>1.181</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-N001	03000157	M8	1,25	–	8,0 <i>0.315</i>	35,0 <i>1.378</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-N001	03000158	M10	1,5	–	10,0 <i>0.394</i>	39,0 <i>1.535</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN371	6H	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

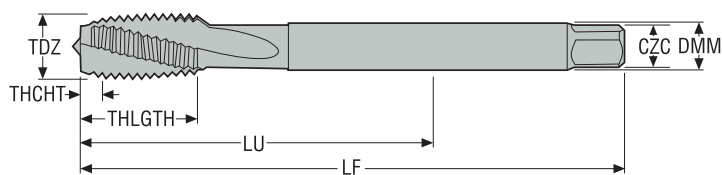
Thread Mini-Start™

Rotating threading

Annex

# MTH-N002

Blind holes



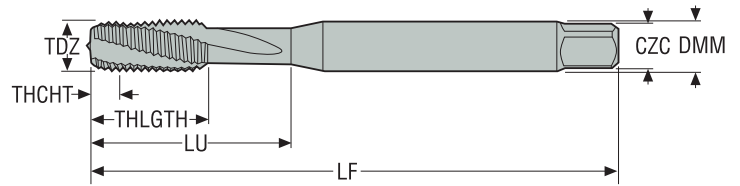
- For cutting data see page(s) 232
- Coating: BRIGHT
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6H-BC-N002	03000159	M12	1,75	-	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-N002	03000160	M14	2,0	-	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-N002	03000161	M16	2,0	-	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	3	DIN376	6H	C

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# MTH-S001

Blind holes



- For cutting data see page(s) 234
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M3X0.50ISO6HX-BC-S001	10001105	M3	0,5	-	3,5 <i>0.138</i>	8,0 <i>0.315</i>	8,0 <i>0.315</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S001	10001106	M4	0,7	-	4,5 <i>0.177</i>	10,5 <i>0.413</i>	10,5 <i>0.413</i>	63,0 <i>2.480</i>	3,3 <i>0.130</i>	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S001	10001107	M5	0,8	-	6,0 <i>0.236</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	4,2 <i>0.165</i>	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S001	10001108	M6	1,0	-	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	80,0 <i>3.150</i>	5,0 <i>0.197</i>	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S001	10001109	M8	1,25	-	8,0 <i>0.315</i>	20,5 <i>0.807</i>	20,5 <i>0.807</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S001	10001110	M10	1,5	-	10,0 <i>0.394</i>	25,5 <i>1.004</i>	25,5 <i>1.004</i>	100,0 <i>3.937</i>	8,5 <i>0.335</i>	10.00X8.00	3	DIN371	6HX	C

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Thread turning

Thread MDT

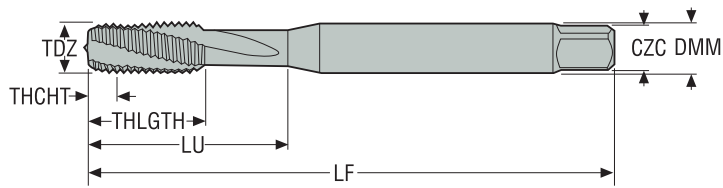
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-S002

Blind holes



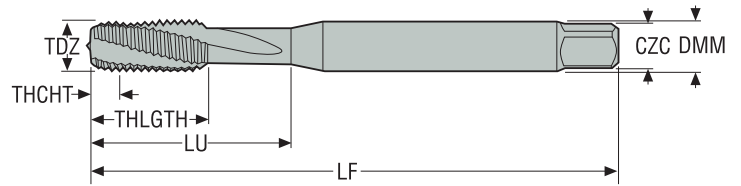
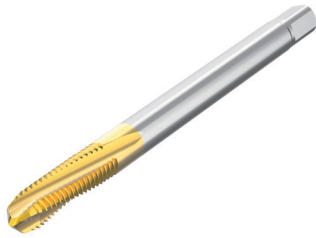
- For cutting data see page(s) 234
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CXC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M12X1.75ISO6HX-BC-S002	10001111	M12	1,75 -	12,0 0.472	30,5 1.201	30,5 1.201	110,0 4.331	10,2 0.402	12.00X9.00	4	DIN371	6HX	C
MTH-M16X2.00ISO6HX-BC-S002	10001112	M16	2,0 -	16,0 0.630	39,5 1.555	39,5 1.555	110,0 4.331	14,0 0.551	16.00X12.00	4	DIN371	6HX	C

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## MTH-S003

Blind holes



- For cutting data see page(s) 234
- Coating: TiN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTH-M3X0.50ISO6HX-BC-S003	10001073	M3	0,5	–	3,5 <i>0.138</i>	8,0 <i>0.315</i>	8,0 <i>0.315</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S003	10001074	M4	0,7	–	4,5 <i>0.177</i>	10,5 <i>0.413</i>	10,5 <i>0.413</i>	63,0 <i>2.480</i>	3,3 <i>0.130</i>	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S003	10001075	M5	0,8	–	6,0 <i>0.236</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	4,2 <i>0.165</i>	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S003	10001076	M6	1,0	–	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	80,0 <i>3.150</i>	5,0 <i>0.197</i>	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S003	10001077	M8	1,25	–	8,0 <i>0.315</i>	20,5 <i>0.807</i>	20,5 <i>0.807</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S003	10001078	M10	1,5	–	10,0 <i>0.394</i>	25,5 <i>1.004</i>	25,5 <i>1.004</i>	100,0 <i>3.937</i>	8,5 <i>0.335</i>	10.00X8.00	3	DIN371	6HX	C

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Thread turning

Thread MDT

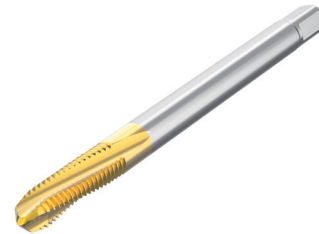
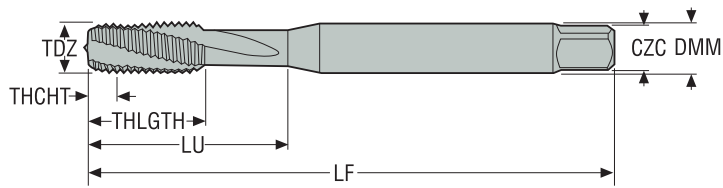
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-S004

Blind holes



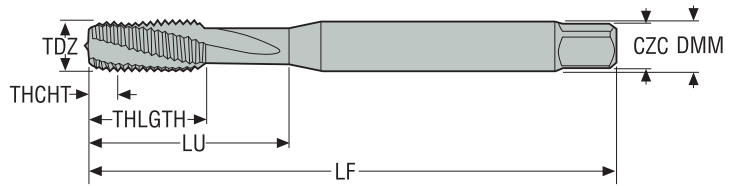
- For cutting data see page(s) 234
- Coating: TiN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6HX-BC-S004	10001079	M12	1,75	-	12,0 <i>0.472</i>	30,5 <i>1.201</i>	30,5 <i>1.201</i>	110,0 <i>4.331</i>	10,2 <i>0.402</i>	12.00X9.00	4	DIN371	6HX	C
MTH-M16X2.00ISO6HX-BC-S004	10001080	M16	2,0	-	16,0 <i>0.630</i>	39,5 <i>1.555</i>	39,5 <i>1.555</i>	110,0 <i>4.331</i>	14,0 <i>0.551</i>	16.00X12.00	4	DIN371	6HX	C

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# MTH-S011

Blind holes



- For cutting data see page(s) 234
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M8X1.00ISO6HX-BC-S011	10001082	MF8X1	1,0	–	8,0 <i>0.315</i>	20,0 <i>0.787</i>	20,0 <i>0.787</i>	90,0 <i>3.543</i>	7,0 <i>0.276</i>	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.00ISO6HX-BC-S011	10001083	MF10X1	1,0	–	10,0 <i>0.394</i>	24,0 <i>0.945</i>	24,0 <i>0.945</i>	90,0 <i>3.543</i>	9,0 <i>0.354</i>	10.00X8.00	3	DIN371	6HX	C
MTH-M10X1.25ISO6HX-BC-S011	10001084	MF10X1.25	1,25	–	10,0 <i>0.394</i>	24,5 <i>0.965</i>	24,5 <i>0.965</i>	100,0 <i>3.937</i>	8,75 <i>0.344</i>	10.00X8.00	3	DIN371	6HX	C
MTH-M12X1.25ISO6HX-BC-S011	10001085	MF12X1.25	1,25	–	12,0 <i>0.472</i>	28,5 <i>1.122</i>	28,5 <i>1.122</i>	100,0 <i>3.937</i>	10,75 <i>0.423</i>	12.00X9.00	4	DIN371	6HX	C
MTH-M12X1.50ISO6HX-BC-S011	10001086	MF12X1.5	1,5	–	12,0 <i>0.472</i>	29,5 <i>1.161</i>	29,5 <i>1.161</i>	100,0 <i>3.937</i>	10,5 <i>0.413</i>	12.00X9.00	4	DIN371	6HX	C

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Thread turning

Thread MDT

Thread Mini-Shaft™

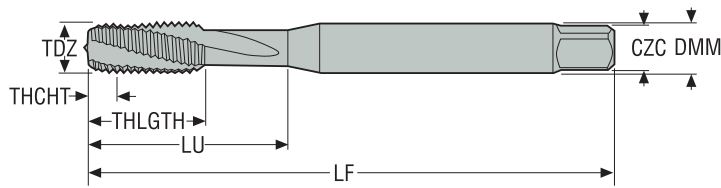
Rotating threading

Annex



# MTH-S012

Blind holes



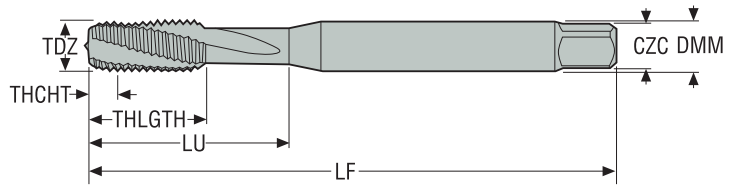
- For cutting data see page(s) 234
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-MJ3X0.50ISO4H-BC-S012	10001069	MJ3X0.5	0,5 -	3,5 0.138	8,0 0.315	8,0 0.315	56,0 2.205	2,6 0.102	3.50X2.70	3	DIN371	4H	C
MTH-MJ4X0.70ISO4H-BC-S012	10001070	MJ4X0.7	0,7 -	4,5 0.177	10,5 0.413	10,5 0.413	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	4H	C
MTH-MJ5X0.80ISO4H-BC-S012	10001071	MJ5X0.8	0,8 -	6,0 0.236	13,0 0.512	13,0 0.512	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	4H	C
MTH-MJ6X1.00ISO4H-BC-S012	10001072	MJ6X1	1,0 -	6,0 0.236	15,5 0.610	15,5 0.610	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	4H	C

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# MTH-S031

Blind holes



- For cutting data see page(s) 234
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-2-56UNC2B-BC-S031	10001113	UNC2-56	-	56.0	2,8 <i>0.110</i>	9,0 <i>0.354</i>	9,0 <i>0.354</i>	45,0 <i>1.772</i>	1,85 <i>0.073</i>	2.80X2.10	3	DIN2184-1	2B	C
MTH-3-48UNC2B-BC-S031	10001114	UNC3-48	-	48.0	2,8 <i>0.110</i>	9,0 <i>0.354</i>	9,0 <i>0.354</i>	50,0 <i>1.969</i>	2,1 <i>0.083</i>	2.80X2.10	3	DIN2184-1	2B	C
MTH-4-40UNC2B-BC-S031	10001115	UNC4-40	-	40.0	3,5 <i>0.138</i>	10,0 <i>0.394</i>	10,0 <i>0.394</i>	56,0 <i>2.205</i>	2,35 <i>0.093</i>	3.50X2.70	3	DIN2184-1	2B	C
MTH-6-32UNC2B-BC-S031	10001116	UNC6-32	-	32.0	4,0 <i>0.157</i>	12,0 <i>0.472</i>	12,0 <i>0.472</i>	56,0 <i>2.205</i>	2,85 <i>0.112</i>	4.00X3.00	3	DIN2184-1	2B	C
MTH-8-32UNC2B-BC-S031	10001117	UNC8-32	-	32.0	4,5 <i>0.177</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	63,0 <i>2.480</i>	3,5 <i>0.138</i>	4.50X3.40	3	DIN2184-1	2B	C
MTH-10-24UNC2B-BC-S031	10001119	UNC10-24	-	24.0	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	3,9 <i>0.154</i>	6.00X4.90	3	DIN2184-1	2B	C
MTH-1/4-20UNC2B-BC-S031	10001120	UNC1/4-20	-	20.0	7,0 <i>0.276</i>	15,0 <i>0.591</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	7.00X5.50	3	DIN2184-1	2B	C
MTH-5/16-18UNC2B-BC-S031	10001122	UNC5/16-18	-	18.0	8,0 <i>0.315</i>	18,0 <i>0.709</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,6 <i>0.260</i>	8.00X6.20	3	DIN2184-1	2B	C
MTH-3/8-16UNC2B-BC-S031	10001121	UNC3/8-16	-	16.0	10,0 <i>0.394</i>	20,0 <i>0.787</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,0 <i>0.315</i>	10.00X8.00	4	DIN2184-1	2B	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

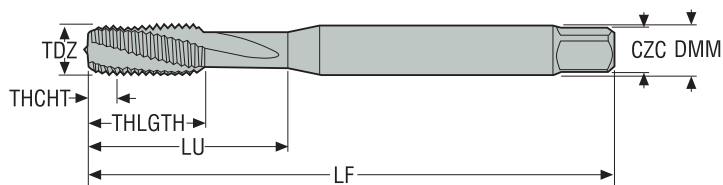
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-S032

Blind holes



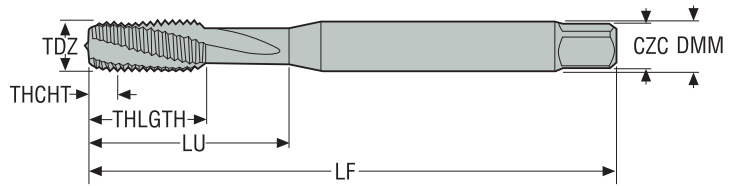
- For cutting data see page(s) 234
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-4-40UNJC3B-BC-S032	10001087	UNJC4-40	–	40.0	3,5 0.138	8,0 0.315	8,0 0.315	56,0 2.205	2,3 0.091	3.50X2.70	3	DIN2184-1	3B	C
MTH-6-32UNJC3B-BC-S032	10001088	UNJC6-32	–	32.0	4,0 0.157	10,0 0.394	10,0 0.394	56,0 2.205	2,8 0.110	4.00X3.00	3	DIN2184-1	3B	C
MTH-8-32UNJC3B-BC-S032	10001089	UNJC8-32	–	32.0	4,5 0.177	11,0 0.433	11,0 0.433	63,0 2.480	3,5 0.138	4.50X3.40	3	DIN2184-1	3B	C
MTH-10-24UNJC3B-BC-S032	10001090	UNJC10-24	–	24.0	6,0 0.236	13,5 0.531	13,5 0.531	70,0 2.756	3,9 0.154	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-20UNJC3B-BC-S032	10001091	UNJC1/4-20	–	20.0	7,0 0.276	17,5 0.689	17,5 0.689	80,0 3.150	5,2 0.205	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-18UNJC3B-BC-S032	10001093	UNJC5/16-18	–	18.0	8,0 0.315	21,0 0.827	21,0 0.827	90,0 3.543	6,7 0.264	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-16UNJC3B-BC-S032	10001092	UNJC3/8-16	–	16.0	10,0 0.394	25,0 0.984	25,0 0.984	100,0 3.937	8,1 0.319	10.00X8.00	3	DIN2184-1	3B	C

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# MTH-S041

Blind holes



- For cutting data see page(s) 236
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-6-40UNF3B-BC-S041	10001123	UNF6-40	-	40.0	4,0 0.157	12,0 0.472	12,0 0.472	56,0 2.205	2,95 0.116	4.00X3.00	3	DIN2184-1	3B	C
MTH-8-36UNF3B-BC-S041	10001126	UNF8-36	-	36.0	4,5 0.177	13,0 0.512	13,0 0.512	63,0 2.480	3,5 0.138	4.50X3.40	3	DIN2184-1	3B	C
MTH-10-32UNF3B-BC-S041	10001127	UNF10-32	-	32.0	6,0 0.236	16,0 0.630	16,0 0.630	70,0 2.756	4,1 0.161	6.00X4.90	3	DIN2184-1	3B	C
MTH-12-28UNF3B-BC-S041	10001129	UNF12-28	-	28.0	6,0 0.236	15,0 0.591	15,0 0.591	80,0 3.150	4,6 0.181	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNF3B-BC-S041	10001130	UNF1/4-28	-	28.0	7,0 0.276	25,0 0.984	15,0 0.591	80,0 3.150	5,5 0.217	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNF3B-BC-S041	10001133	UNF5/16-24	-	24.0	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	6,9 0.272	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNF3B-BC-S041	10001131	UNF3/8-24	-	24.0	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	8,5 0.335	10.00X8.00	4	DIN2184-1	3B	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

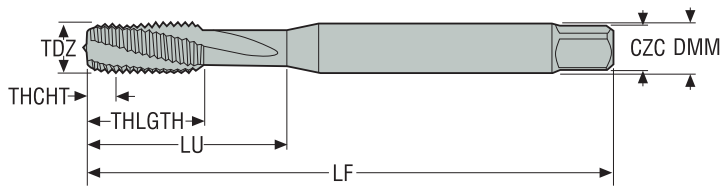
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-S042

Blind holes



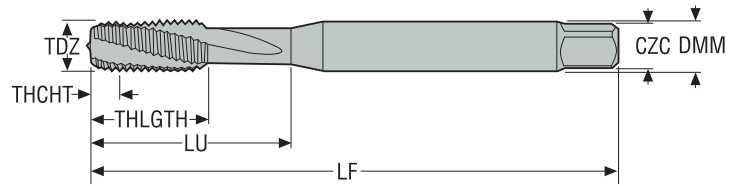
- For cutting data see page(s) 236
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-6-40UNJF3B-BC-S042	10001094	UNJF6-40	–	40.0	4,0 <i>0.157</i>	9,5 <i>0.374</i>	9,5 <i>0.374</i>	56,0 <i>2.205</i>	2,95 <i>0.116</i>	4.00X3.00	3	DIN2184-1	3B	C
MTH-8-36UNJF3B-BC-S042	10001095	UNJF8-36	–	36.0	4,5 <i>0.177</i>	11,0 <i>0.433</i>	11,0 <i>0.433</i>	63,0 <i>2.480</i>	3,6 <i>0.142</i>	4.50X3.40	3	DIN2184-1	3B	C
MTH-10-32UNJF3B-BC-S042	10001097	UNJF10-32	–	32.0	6,0 <i>0.236</i>	12,5 <i>0.492</i>	12,5 <i>0.492</i>	70,0 <i>2.756</i>	4,15 <i>0.163</i>	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNJF3B-BC-S042	10001098	UNJF1/4-28	–	28.0	7,0 <i>0.276</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	80,0 <i>3.150</i>	5,6 <i>0.220</i>	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNJF3B-BC-S042	10001100	UNJF5/16-24	–	24.0	8,0 <i>0.315</i>	20,0 <i>0.787</i>	20,0 <i>0.787</i>	90,0 <i>3.543</i>	7,0 <i>0.276</i>	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNJF3B-BC-S042	10001099	UNJF3/8-24	–	24.0	10,0 <i>0.394</i>	23,0 <i>0.906</i>	23,0 <i>0.906</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN2184-1	3B	C

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## MTH-S043

Blind and through holes



- For cutting data see page(s) 236
- Coating: AlCrN
- Substrate: HSS-E-PM

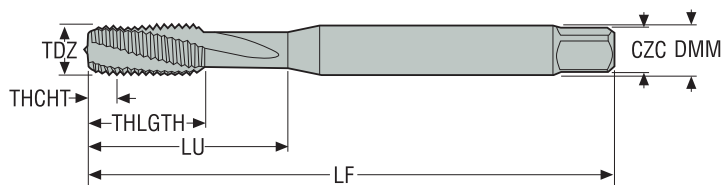
Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-10-32EGUNF3B-BC-S043	10001199	EGUN10-32	– 32.0	6,0 0.236	23,0 0.906	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28EGUNF3B-BC-S043	10001200	EGUNF1/4-28	– 28.0	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	6,6 0.260	8.00X6.20	3	DIN2184-1	3B	C
MTH-5/16-24EGUNF3B-BC-S043	10001201	EGUNF5/16-24	– 24.0	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	8,2 0.323	10.00X8.00	3	DIN2184-1	3B	C
MTH-3/8-24EGUNF3B-BC-S043	10001202	EGUNF3/8-24	– 24.0	8,0 0.315	76,0 2.992	20,0 0.787	100,0 3.937	9,8 0.386	8.00X6.20	4	DIN2184-1	3B	C

Designation Ansi	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-10-32STIUNF3B-BC-S043	10001199	EGUN10-32	– 32.0	6,0 0.236	23,0 0.906	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28STIUNF3B-BC-S043	10001200	EGUNF1/4-28	– 28.0	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	6,6 0.260	8.00X6.20	3	DIN2184-1	3B	C
MTH-5/16-24STIUNF3B-BC-S043	10001201	EGUNF5/16-24	– 24.0	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	8,2 0.323	10.00X8.00	3	DIN2184-1	3B	C
MTH-3/8-24STIUNF3B-BC-S043	10001202	EGUNF3/8-24	– 24.0	8,0 0.315	76,0 2.992	20,0 0.787	100,0 3.937	9,8 0.386	8.00X6.20	4	DIN2184-1	3B	C

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# MTH-S044

Blind holes



- For cutting data see page(s) 236
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-10-32EGUNF3B-BC-S044	10001101	EGUNF10-32	– 32.0	6,0 0.236	15,0 0.591	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28EGUNF3B-BC-S044	10001102	EGUNF1/4-28	– 28.0	8,0 0.315	18,0 0.709	18,0 0.709	90,0 3.543	6,6 0.260	8.00X6.20	3	DIN2184-1	3B	C
MTH-5/16-24EGUNF3B-BC-S044	10001104	EGUNF5/16-24	– 24.0	10,0 0.394	20,0 0.787	20,0 0.787	90,0 3.543	8,2 0.323	10.00X8.00	3	DIN2184-1	3B	C
MTH-3/8-24EGUNF3B-BC-S044	10001103	EGUNF3/8-24	– 24.0	11,0 0.433	20,0 0.787	20,0 0.787	90,0 3.543	9,8 0.386	11.00X9.00	4	DIN2184-1	3B	C

Designation Ansi	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-10-32STIUNF3B-BC-S044	10001101	EGUNF10-32	– 32.0	6,0 0.236	15,0 0.591	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28STIUNF3B-BC-S044	10001102	EGUNF1/4-28	– 28.0	8,0 0.315	18,0 0.709	18,0 0.709	90,0 3.543	6,6 0.260	8.00X6.20	3	DIN2184-1	3B	C
MTH-5/16-24STIUNF3B-BC-S044	10001104	EGUNF5/16-24	– 24.0	10,0 0.394	20,0 0.787	20,0 0.787	90,0 3.543	8,2 0.323	10.00X8.00	3	DIN2184-1	3B	C
MTH-3/8-24STIUNF3B-BC-S044	10001103	EGUNF3/8-24	– 24.0	11,0 0.433	20,0 0.787	20,0 0.787	90,0 3.543	9,8 0.386	11.00X9.00	4	DIN2184-1	3B	C

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Thread turning

Thread MDT

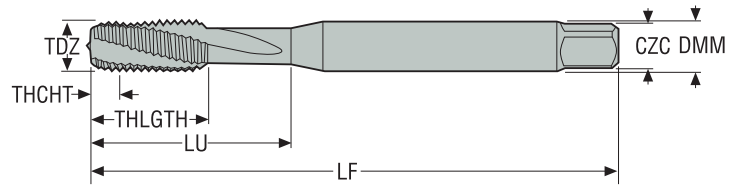
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-S101

Blind holes



- For cutting data see page(s) 236
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M2X0.40ISO6HX-BC-S101	10001134	M2	0,4 -	2,8 0.110	8,0 0.315	8,0 0.315	45,0 1.772	1,6 0.063	2.80X2.10	3	DIN371	6HX	C
MTH-M2.5X0.45ISO6HX-BC-S101	10001135	M2.5	0,45 -	2,8 0.110	9,0 0.354	9,0 0.354	50,0 1.969	2,05 0.081	2.80X2.10	3	DIN371	6HX	C
MTH-M3X0.50ISO6HX-BC-S101	10001136	M3	0,5 -	3,5 0.138	10,0 0.394	10,0 0.394	56,0 2.205	2,5 0.098	3.50X2.70	3	DIN371	6HX	C
MTH-M3.5X0.60ISO6HX-BC-S101	10001137	M3.5	0,6 -	4,0 0.157	12,0 0.472	12,0 0.472	56,0 2.205	2,9 0.114	4.00X3.00	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S101	10001138	M4	0,7 -	4,5 0.177	13,0 0.512	13,0 0.512	63,0 2.480	3,3 0.130	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S101	10001139	M5	0,8 -	6,0 0.236	16,0 0.630	16,0 0.630	70,0 2.756	4,2 0.165	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S101	10001140	M6	1,0 -	6,0 0.236	23,0 0.906	15,0 0.591	80,0 3.150	5,0 0.197	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S101	10001141	M8	1,25 -	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S101	10001142	M10	1,5 -	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	8,5 0.335	10.00X8.00	3	DIN371	6HX	C

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Thread turning

Thread MDT

Thread Mini-Start™

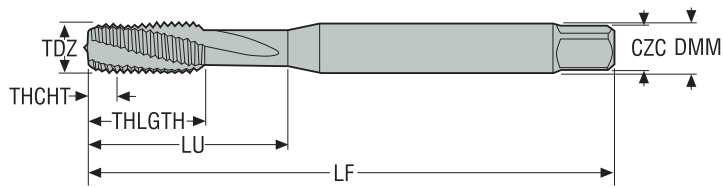
Rotating threading

Annex



# MTH-S102

Blind holes



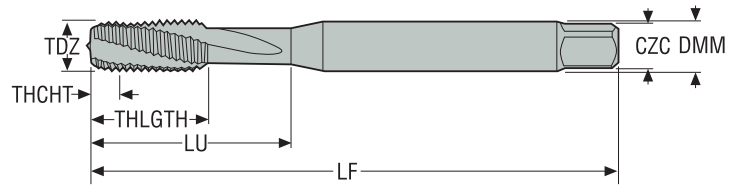
- For cutting data see page(s) 236
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6HX-BC-S102	10001143	M12	1,75	-	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,2 <i>0.402</i>	9.00X7.00	4	DIN376	6HX	C
MTH-M16X2.00ISO6HX-BC-S102	10001145	M16	2,0	-	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,0 <i>0.551</i>	12.00X9.00	4	DIN376	6HX	C
MTH-M20X2.50ISO6HX-BC-S102	10001146	M20	2,5	-	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,5 <i>0.689</i>	16.00X12.00	4	DIN376	6HX	C

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# MTH-S111

Blind holes



- For cutting data see page(s) 236
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M6X0.75ISO6HX-BC-S111	10001147	MF6X0.75	0,75 -	6,0 0.236	23,0 0.906	15,0 0.591	80,0 3.150	5,25 0.207	6.00X4.90	3	DIN371	6HX	C
MTH-M8X0.75ISO6HX-BC-S111	10001148	MF8X0.75	0,75 -	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	7,25 0.285	8.00X6.20	3	DIN371	6HX	C
MTH-M8X1.00ISO6HX-BC-S111	10001149	MF8X1	1,0 -	8,0 0.315	29,5 1.161	18,0 0.709	90,0 3.543	7,0 0.276	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.00ISO6HX-BC-S111	10001150	MF10X1	1,0 -	10,0 0.394	33,5 1.319	20,0 0.787	100,0 3.937	9,0 0.354	10.00X8.00	3	DIN371	6HX	C
MTH-M12X1.50ISO6HX-BC-S111	10001151	MF12X1.5	1,5 -	9,0 0.354	73,0 2.874	21,0 0.827	100,0 3.937	10,5 0.413	9.00X7.00	4	DIN374	6HX	C
MTH-M14X1.50ISO6HX-BC-S111	10001152	MF14X1.5	1,5 -	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	12,5 0.492	11.00X9.00	4	DIN374	6HX	C

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Thread turning

Thread MDT

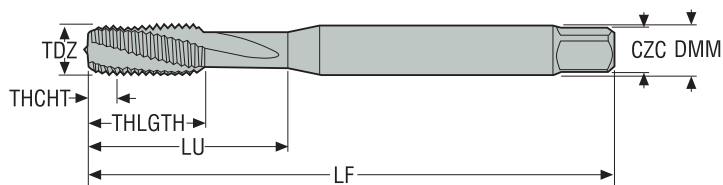
Thread Mini-Start™

Rotating threading

Annex

# MTH-S112

Blind holes



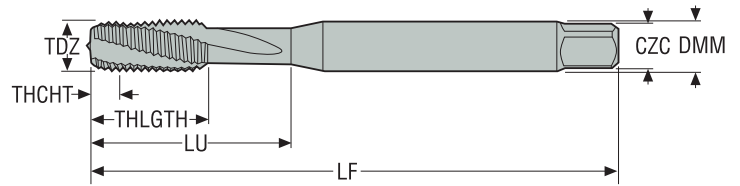
- For cutting data see page(s) 236
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-MJ3X0.50ISO4H-BC-S112	10001203	MJ3X0.5	0,5	–	3,5 <i>0.138</i>	10,0 <i>0.394</i>	10,0 <i>0.394</i>	56,0 <i>2.205</i>	2,6 <i>0.102</i>	3.50X2.70	3	DIN371	4H	C
MTH-MJ4X0.70ISO4H-BC-S112	10001204	MJ4X0.7	0,7	–	4,5 <i>0.177</i>	13,0 <i>0.512</i>	13,0 <i>0.512</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	3	DIN371	4H	C
MTH-MJ5X0.80ISO4H-BC-S112	10001205	MJ5X0.8	0,8	–	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	3	DIN371	4H	C
MTH-MJ6X1.00ISO4H-BC-S112	10001206	MJ6X1	1,0	–	6,0 <i>0.236</i>	23,0 <i>0.906</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	4H	C
MTH-MJ8X1.25ISO4H-BC-S112	10001207	MJ8X1.25	1,25	–	8,0 <i>0.315</i>	29,5 <i>1.161</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	6,9 <i>0.272</i>	8.00X6.20	3	DIN371	4H	C
MTH-MJ10X1.5ISO4H-BC-S112	10001208	MJ10X1.5	1,5	–	10,0 <i>0.394</i>	33,5 <i>1.319</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,7 <i>0.343</i>	10.00X8.00	3	DIN371	4H	C

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# MTH-S142

Blind holes



- For cutting data see page(s) 236
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTH-10-32UNJF3B-BC-S142	10001153	UNJF10-32	-	32.0	6,0 <i>0.236</i>	16,0 <i>0.630</i>	16,0 <i>0.630</i>	70,0 <i>2.756</i>	4,15 <i>0.163</i>	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNJF3B-BC-S142	10001154	UNJF1/4-28	-	28.0	7,0 <i>0.276</i>	25,0 <i>0.984</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,6 <i>0.220</i>	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNJF3B-BC-S142	10001155	UNJF5/16-24	-	24.0	8,0 <i>0.315</i>	29,5 <i>1.161</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	7,0 <i>0.276</i>	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNJF3B-BC-S142	10001156	UNJF3/8-24	-	24.0	10,0 <i>0.394</i>	33,5 <i>1.319</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN2184-1	3B	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

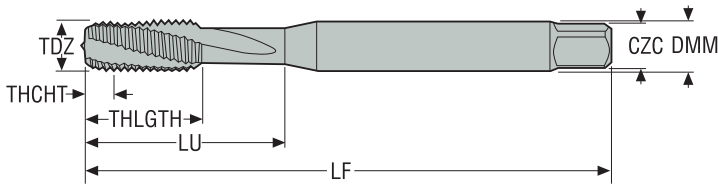
Thread MDT

Thread Mini-Start™

Rotating threading

Annex

MTH-V011  
Blind holes



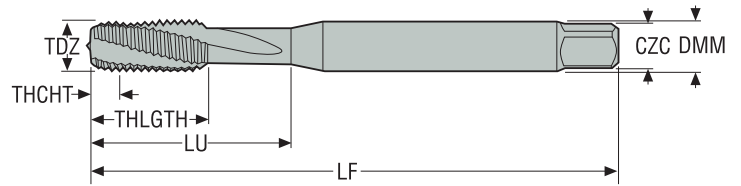
- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M8X0.75ISO6HX-BC-V011	03000162	MF8X0.75	0,75	-	6,0 0.236	57,0 2.244	13,0 0.512	80,0 3.150	7,3 0.287	6.00X4.90	3	DIN374	6HX	C
MTH-M8X1.00ISO6HX-BC-V011	03000163	MF8X1.0	1,0	-	6,0 0.236	67,0 2.638	13,0 0.512	90,0 3.543	7,1 0.280	6.00X4.90	3	DIN374	6HX	C
MTH-M10X1.00ISO6HX-BC-V011	03000164	MF10X1.0	1,0	-	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	9,1 0.358	7.00X5.50	3	DIN374	6HX	C
MTH-M10X1.25ISO6HX-BC-V011	03000165	MF10X1.25	1,25	-	7,0 0.276	77,0 3.031	15,0 0.591	100,0 3.937	8,8 0.346	7.00X5.50	3	DIN374	6HX	C
MTH-M12X1.00ISO6HX-BC-V011	03000166	MF12X1.0	1,0	-	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	11,1 0.437	9.00X7.00	3	DIN374	6HX	C
MTH-M12X1.25ISO6HX-BC-V011	03000167	MF12X1.25	1,25	-	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,8 0.425	9.00X7.00	3	DIN374	6HX	C
MTH-M12X1.50ISO6HX-BC-V011	03000168	MF12X1.5	1,5	-	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,6 0.417	9.00X7.00	3	DIN374	6HX	C
MTH-M14X1.00ISO6HX-BC-V011	03000169	MF14X1.0	1,0	-	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	13,1 0.516	11.00X9.00	3	DIN374	6HX	C
MTH-M14X1.25ISO6HX-BC-V011	03000170	MF14X1.25	1,25	-	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,8 0.504	11.00X9.00	3	DIN374	6HX	C
MTH-M14X1.50ISO6HX-BC-V011	03000171	MF14X1.5	1,5	-	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,6 0.496	11.00X9.00	3	DIN374	6HX	C
MTH-M16X1.00ISO6HX-BC-V011	03000172	MF16X1.0	1,0	-	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	15,1 0.594	12.00X9.00	3	DIN374	6HX	C
MTH-M16X1.50ISO6HX-BC-V011	03000173	MF16X1.5	1,5	-	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	14,6 0.575	12.00X9.00	3	DIN374	6HX	C
MTH-M18X1.00ISO6HX-BC-V011	03000174	MF18X1.0	1,0	-	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	17,1 0.673	14.00X11.00	3	DIN374	6HX	C
MTH-M18X1.50ISO6HX-BC-V011	03000175	MF18X1.5	1,5	-	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	16,6 0.654	14.00X11.00	3	DIN374	6HX	C
MTH-M20X1.00ISO6HX-BC-V011	03000176	MF20X1.0	1,0	-	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	19,1 0.752	16.00X12.00	3	DIN374	6HX	C
MTH-M20X1.50ISO6HX-BC-V011	03000177	MF20X1.5	1,5	-	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	18,6 0.732	16.00X12.00	3	DIN374	6HX	C
MTH-M20X2.00ISO6HX-BC-V011	03000178	MF20X2.0	2,0	-	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	18,1 0.713	16.00X12.00	3	DIN374	6HX	C
MTH-M22X1.50ISO6HX-BC-V011	03000179	MF22X1.5	1,5	-	18,0 0.709	78,0 3.071	17,0 0.669	125,0 4.921	20,5 0.807	18.00X14.50	4	DIN374	6HX	C
MTH-M24X1.50ISO6HX-BC-V011	03000180	MF24X1.5	1,5	-	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	22,5 0.886	18.00X14.50	4	DIN374	6HX	C
MTH-M24X2.00ISO6HX-BC-V011	03000181	MF24X2.0	2,0	-	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	22,0 0.866	18.00X14.50	4	DIN374	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MTH-V015

Blind holes



- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M3X0.50ISO6H-BC-V015	03019188	M3	0,5 -	3,5 0.138	18,0 0.709	9,0 0.354	56,0 2.205	2,5 0.098	3.50X2.70	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-V015	03019189	M4	0,7 -	4,5 0.177	21,0 0.827	11,0 0.433	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-V015	03019190	M5	0,8 -	6,0 0.236	25,0 0.984	13,0 0.512	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-V015	03019191	M6	1,0 -	6,0 0.236	30,0 1.181	15,0 0.591	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-V015	03019193	M8	1,25 -	8,0 0.315	35,0 1.378	18,0 0.709	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-V015	03019194	M10	1,5 -	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

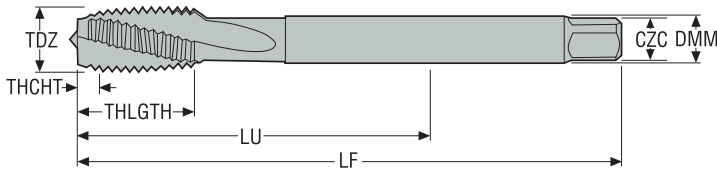
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-V016

Blind holes



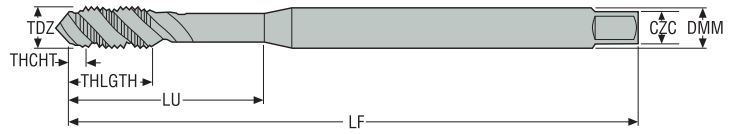
- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6H-BC-V016	03019195	M12	1,75	-	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-V016	03019196	M14	2,0	-	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-V016	03019197	M16	2,0	-	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	3	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-V016	03019198	M18	2,5	-	14,0 <i>0.551</i>	81,0 <i>3.189</i>	30,0 <i>1.181</i>	125,0 <i>4.921</i>	15,7 <i>0.618</i>	14.00X11.00	3	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V016	03019199	M20	2,5	-	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	3	DIN376	6H	C
MTH-M22X2.50ISO6H-BC-V016	03019200	M22	2,5	-	18,0 <i>0.709</i>	93,0 <i>3.661</i>	34,0 <i>1.339</i>	140,0 <i>5.512</i>	19,7 <i>0.776</i>	18.00X14.50	4	DIN376	6H	C
MTH-M24X3.00ISO6H-BC-V016	03019201	M24	3,0	-	18,0 <i>0.709</i>	113,0 <i>4.449</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	21,0 <i>0.827</i>	18.00X14.50	4	DIN376	6H	C
MTH-M27X3.00ISO6H-BC-V016	03019202	M27	3,0	-	20,0 <i>0.787</i>	97,0 <i>3.819</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	24,0 <i>0.945</i>	20.00X16.00	4	DIN376	6H	C
MTH-M30X3.50ISO6H-BC-V016	03019203	M30	3,5	-	22,0 <i>0.866</i>	115,0 <i>4.528</i>	45,0 <i>1.772</i>	180,0 <i>7.087</i>	26,5 <i>1.043</i>	22.00X18.00	4	DIN376	6H	C
MTH-M33X3.50ISO6H-BC-V016	03019204	M33	3,5	-	25,0 <i>0.984</i>	113,0 <i>4.449</i>	50,0 <i>1.969</i>	180,0 <i>7.087</i>	29,5 <i>1.161</i>	25.00X20.00	4	DIN376	6H	C
MTH-M36X4.00ISO6H-BC-V016	03019205	M36	4,0	-	28,0 <i>1.102</i>	131,0 <i>5.157</i>	55,0 <i>2.165</i>	200,0 <i>7.874</i>	32,0 <i>1.260</i>	28.00X22.00	4	DIN376	6H	C

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## MTH-V025

Blind holes



- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-E
- Long version

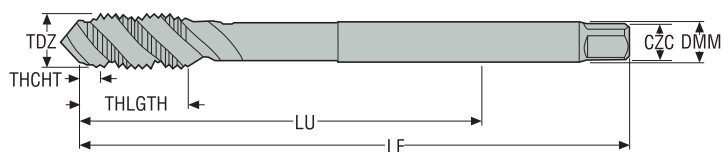
Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M3X0.50ISO6H-BC-V025	02880641	M3	0,5 -	3,5 0.138	18,0 0.709	6,0 0.236	112,0 4.409	2,5 0.098	3.50X2.70	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-V025	02880642	M4	0,7 -	4,5 0.177	21,0 0.827	7,0 0.276	112,0 4.409	3,4 0.134	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-V025	02880643	M5	0,8 -	6,0 0.236	25,0 0.984	8,0 0.315	125,0 4.921	4,3 0.169	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-V025	02880644	M6	1,0 -	6,0 0.236	30,0 1.181	10,0 0.394	125,0 4.921	5,1 0.201	6.00X4.90	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-V025	02880645	M8	1,25 -	8,0 0.315	40,0 1.575	13,0 0.512	140,0 5.512	6,8 0.268	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-V025	02880646	M10	1,5 -	10,0 0.394	50,0 1.969	15,0 0.591	160,0 6.299	8,6 0.339	10.00X8.00	3	DIN371	6H	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store



# MTH-V026

Blind holes



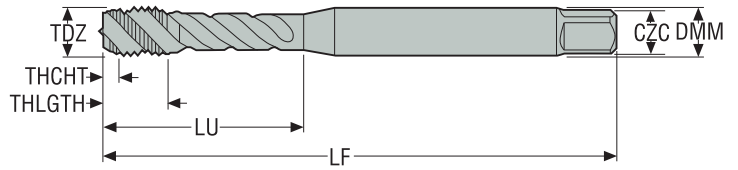
- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-E
- Long version

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M12X1.75ISO6H-BC-V026	02880647	M12	1,75	–	9,0 0.354	153,0 6.024	16,0 0.630	180,0 7.087	10,4 0.409	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-V026	02880648	M14	2,0	–	11,0 0.433	151,0 5.945	20,0 0.787	180,0 7.087	12,1 0.476	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-V026	02880649	M16	2,0	–	12,0 0.472	158,0 6.220	20,0 0.787	200,0 7.874	14,1 0.555	12.00X9.00	3	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V026	02880651	M20	2,5	–	16,0 0.630	179,0 7.047	25,0 0.984	224,0 8.819	17,7 0.697	16.00X12.00	4	DIN376	6H	C

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# MTH-V028

Blind holes



- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTH-M3X0.50ISO6G-BC-V028	02880652	M3	0,5 –	3,5 <i>0.138</i>	18,0 <i>0.709</i>	5,9 <i>0.232</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6G	C
MTH-M4X0.70ISO6G-BC-V028	02880653	M4	0,7 –	4,5 <i>0.177</i>	21,0 <i>0.827</i>	6,7 <i>0.264</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	3	DIN371	6G	C
MTH-M5X0.80ISO6G-BC-V028	02880654	M5	0,8 –	6,0 <i>0.236</i>	25,0 <i>0.984</i>	7,7 <i>0.303</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	3	DIN371	6G	C
MTH-M6X1.00ISO6G-BC-V028	02880655	M6	1,0 –	6,0 <i>0.236</i>	31,0 <i>1.220</i>	10,0 <i>0.394</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	6G	C
MTH-M8X1.25ISO6G-BC-V028	02880656	M8	1,25 –	8,0 <i>0.315</i>	35,0 <i>1.378</i>	11,6 <i>0.457</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6G	C
MTH-M10X1.50ISO6G-BC-V028	02880657	M10	1,5 –	10,0 <i>0.394</i>	39,0 <i>1.535</i>	15,1 <i>0.594</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN371	6G	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

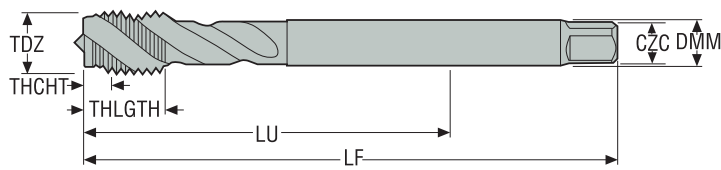
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-V029

Blind holes



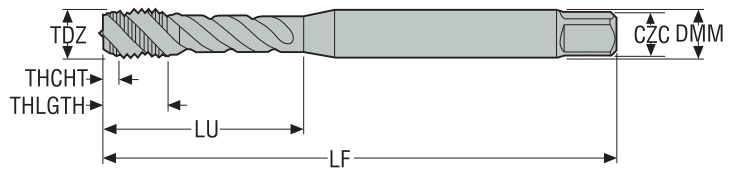
- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

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

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# MTH-V030

Blind holes



- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-E ≤ M2,5; HSS-PM > M2,5

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MTH-M2X0.40ISO6H-BC-V030	02880662	M2	0,4	–	2,8 <i>0.110</i>	9,0 <i>0.354</i>	4,0 <i>0.157</i>	45,0 <i>1.772</i>	1,6 <i>0.063</i>	2.80X2.10	3	DIN371	6H	C
MTH-M2.5X0.45ISO6H-BC-V030	02880663	M2.5	0,45	–	2,8 <i>0.110</i>	12,5 <i>0.492</i>	4,0 <i>0.157</i>	50,0 <i>1.969</i>	2,1 <i>0.083</i>	2.80X2.10	3	DIN371	6H	C
MTH-M3X0.50ISO6H-BC-V030	02880664	M3	0,5	–	3,5 <i>0.138</i>	18,0 <i>0.709</i>	5,9 <i>0.232</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6H	C
MTH-M3.5X0.60ISO6H-BC-V030	02880665	M3.5	0,6	–	4,0 <i>0.157</i>	20,0 <i>0.787</i>	6,3 <i>0.248</i>	56,0 <i>2.205</i>	2,9 <i>0.114</i>	4.00X3.00	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-V030	02880666	M4	0,7	–	4,5 <i>0.177</i>	21,0 <i>0.827</i>	6,7 <i>0.264</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-V030	02880667	M5	0,8	–	6,0 <i>0.236</i>	21,0 <i>0.827</i>	7,7 <i>0.303</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-V030	02880668	M6	1,0	–	6,0 <i>0.236</i>	31,0 <i>1.220</i>	10,0 <i>0.394</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	3	DIN371	6H	C
MTH-M7X1.00ISO6H-BC-V030	02880669	M7	1,0	–	7,0 <i>0.276</i>	31,0 <i>1.220</i>	10,0 <i>0.394</i>	80,0 <i>3.150</i>	6,1 <i>0.240</i>	7.00X5.50	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-V030	02880670	M8	1,25	–	8,0 <i>0.315</i>	35,0 <i>1.378</i>	11,6 <i>0.457</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-V030	02880671	M10	1,5	–	10,0 <i>0.394</i>	39,0 <i>1.535</i>	15,1 <i>0.594</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN371	6H	C

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Thread turning

Thread MDT

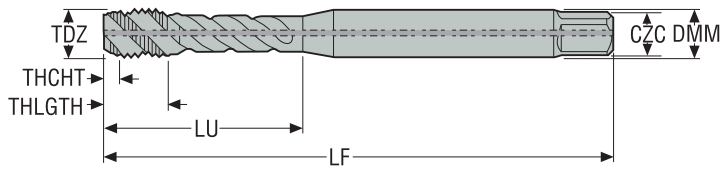
Thread Mini-Start™

Rotating threading

Annex

# MTH-V030-A

Blind holes



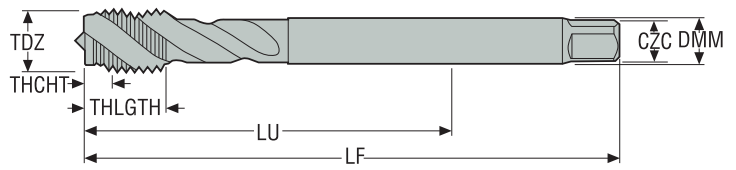
- For cutting data see page(s) 242
- Coating: TiN
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M4X0.70ISO6H-BC-V030-A	03000228	M4	0,7	–	4,5 0.177	21,0 0.827	6,7 0.264	63,0 2.480	3,4 0.134	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-V030-A	03000229	M5	0,8	–	6,0 0.236	25,0 0.984	7,7 0.303	70,0 2.756	4,3 0.169	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-V030-A	03000230	M6	1,0	–	6,0 0.236	30,0 1.181	10,0 0.394	80,0 3.150	5,1 0.201	6.00X4.90	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-V030-A	03000231	M8	1,25	–	8,0 0.315	35,0 1.378	11,6 0.457	90,0 3.543	6,8 0.268	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-V030-A	03000232	M10	1,5	–	10,0 0.394	39,0 1.535	15,1 0.594	100,0 3.937	8,6 0.339	10.00X8.00	3	DIN371	6H	C

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# MTH-V033

Blind holes



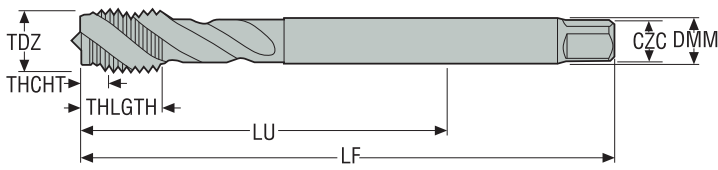
- For cutting data see page(s) 244
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-M6X1.00ISO6H-BC-V033	02880683	M6	1,0 -	4,5 0.177	59,0 2.323	10,0 0.394	80,0 3.150	5,1 0.201	4.50X3.40	3	DIN376	6H	C
MTH-M8X1.25ISO6H-BC-V033	02880684	M8	1,25 -	6,0 0.236	67,0 2.638	13,0 0.512	90,0 3.543	6,8 0.268	6.00X4.90	3	DIN376	6H	C
MTH-M10X1.50ISO6H-BC-V033	02880686	M10	1,5 -	7,0 0.276	77,0 3.031	15,0 0.591	100,0 3.937	8,6 0.339	7.00X5.50	3	DIN376	6H	C
MTH-M12X1.75ISO6H-BC-V033	02880672	M12	1,75 -	9,0 0.354	83,0 3.268	16,0 0.630	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-V033	02880673	M14	2,0 -	11,0 0.433	81,0 3.189	20,0 0.787	110,0 4.331	12,1 0.476	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-V033	02880674	M16	2,0 -	12,0 0.472	68,0 2.677	20,0 0.787	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-V033	02880675	M18	2,5 -	14,0 0.551	81,0 3.189	25,0 0.984	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V033	02880676	M20	2,5 -	16,0 0.630	95,0 3.740	25,0 0.984	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6H	C
MTH-M22X2.50ISO6H-BC-V033	02880677	M22	2,5 -	18,0 0.709	93,0 3.661	25,0 0.984	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6H	C
MTH-M24X3.00ISO6H-BC-V033	02880678	M24	3,0 -	18,0 0.709	113,0 4.449	30,0 1.181	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6H	C
MTH-M27X3.00ISO6H-BC-V033	02880679	M27	3,0 -	20,0 0.787	97,0 3.819	30,0 1.181	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6H	C
MTH-M30X3.50ISO6H-BC-V033	02880680	M30	3,5 -	22,0 0.866	115,0 4.528	36,0 1.417	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6H	C
MTH-M33X3.50ISO6H-BC-V033	02880681	M33	3,5 -	25,0 0.984	113,0 4.449	36,0 1.417	180,0 7.087	29,5 1.161	25.00X20.00	4	DIN376	6H	C
MTH-M36X4.00ISO6H-BC-V033	02880682	M36	4,0 -	28,0 1.102	131,0 5.157	40,0 1.575	200,0 7.874	32,0 1.260	28.00X22.00	4	DIN376	6H	C
MTH-M39X4.00ISO6H-BC-V033	03000221	M39	4,0 -	32,0 1.260	102,0 4.016	40,0 1.575	200,0 7.874	35,0 1.378	32.00X24.00	4	DIN376	6H	C
MTH-M42X4.50ISO6H-BC-V033	03000223	M42	4,5 -	32,0 1.260	102,0 4.016	45,0 1.772	200,0 7.874	37,5 1.476	32.00X24.00	4	DIN376	6H	C
MTH-M48X5.00ISO6H-BC-V033	03000224	M48	5,0 -	36,0 1.417	147,0 5.787	50,0 1.969	250,0 9.843	43,0 1.693	36.00X29.00	4	DIN376	6H	C
MTH-M52X5.00ISO6H-BC-V033	03000225	M52	5,0 -	40,0 1.575	120,0 4.724	50,0 1.969	250,0 9.843	47,0 1.850	40.00X32.00	5	DIN376	6H	C
MTH-M56X5.50ISO6H-BC-V033	03000226	M56	5,5 -	40,0 1.575	120,0 4.724	55,0 2.165	250,0 9.843	50,5 1.988	40.00X32.00	5	DIN376	6H	C
MTH-M64X6.00ISO6H-BC-V033	03000227	M64	6,0 -	50,0 1.969	178,0 7.008	60,0 2.362	315,0 12.402	58,0 2.283	50.00X39.00	6	DIN376	6H	C

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# MTH-V033-A

Blind holes



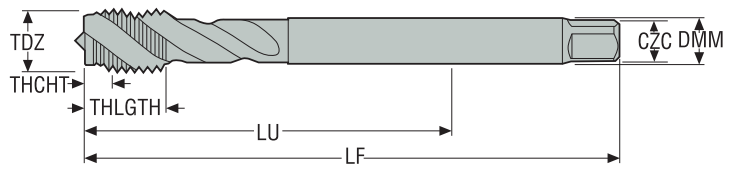
- For cutting data see page(s) 244
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M12X1.75ISO6H-BC-V033-A	03000233	M12	1,75	–	9,0 0.354	83,0 3.268	16,0 0.630	110,0 4.331	10,4 0.409	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-V033-A	03000234	M14	2,0	–	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-V033-A	03000235	M16	2,0	–	12,0 0.472	68,0 2.677	20,0 0.787	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-V033-A	03000236	M18	2,5	–	14,0 0.551	81,0 3.189	25,0 0.984	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V033-A	03000237	M20	2,5	–	16,0 0.630	95,0 3.740	25,0 0.984	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6H	C
MTH-M22X2.50ISO6H-BC-V033-A	03000238	M22	2,5	–	18,0 0.709	93,0 3.661	25,0 0.984	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6H	C
MTH-M24X3.00ISO6H-BC-V033-A	03000239	M24	3,0	–	18,0 0.709	113,0 4.449	30,0 1.181	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6H	C
MTH-M27X3.00ISO6H-BC-V033-A	03000240	M27	3,0	–	20,0 0.787	97,0 3.819	30,0 1.181	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6H	C
MTH-M30X3.50ISO6H-BC-V033-A	03000241	M30	3,5	–	22,0 0.866	115,0 4.528	36,0 1.417	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6H	C
MTH-M33X3.50ISO6H-BC-V033-A	03000242	M33	3,5	–	25,0 0.984	113,0 4.449	50,0 1.969	180,0 7.087	29,5 1.161	25.00X20.00	4	DIN376	6H	C
MTH-M36X4.00ISO6H-BC-V033-A	03000243	M36	4,0	–	28,0 1.102	131,0 5.157	55,0 2.165	200,0 7.874	32,0 1.260	28.00X22.00	4	DIN376	6H	C
MTH-M39X4.00ISO6H-BC-V033-A	03000244	M39	4,0	–	32,0 1.260	102,0 4.016	40,0 1.575	200,0 7.874	35,0 1.378	32.00X24.00	4	DIN376	6H	C
MTH-M42X4.50ISO6H-BC-V033-A	03000245	M42	4,5	–	32,0 1.260	102,0 4.016	45,0 1.772	200,0 7.874	37,5 1.476	32.00X24.00	4	DIN376	6H	C
MTH-M48X5.00ISO6H-BC-V033-A	03000246	M48	5,0	–	36,0 1.417	147,0 5.787	50,0 1.969	250,0 9.843	43,0 1.693	36.00X29.00	4	DIN376	6H	C
MTH-M52X5.00ISO6H-BC-V033-A	03000247	M52	5,0	–	40,0 1.575	120,0 4.724	50,0 1.969	250,0 9.843	47,0 1.850	40.00X32.00	5	DIN376	6H	C
MTH-M56X5.50ISO6H-BC-V033-A	03000248	M56	5,5	–	40,0 1.575	120,0 4.724	55,0 2.165	250,0 9.843	50,5 1.988	40.00X32.00	5	DIN376	6H	C
MTH-M64X6.00ISO6H-BC-V033-A	03000249	M64	6,0	–	50,0 1.969	178,0 7.008	60,0 2.362	315,0 12.402	58,0 2.283	50.00X39.00	6	DIN376	6H	C

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# MTH-V038

Blind holes



- For cutting data see page(s) 244
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M4X0.50ISO6H-BC-V038	02880687	MF4X0.5	0,5	–	2,8 0.110	43,0 1.693	6,8 0.268	63,0 2.480	3,5 0.138	2.80X2.10	3	DIN374	6H	C
MTH-M5X0.50ISO6H-BC-V038	02880688	MF5X0.5	0,5	–	3,5 0.138	49,0 1.929	8,2 0.323	70,0 2.756	4,5 0.177	3.50X2.70	3	DIN374	6H	C
MTH-M6X0.75ISO6H-BC-V038	02880689	MF6X0.75	0,75	–	4,5 0.177	59,0 2.323	10,0 0.394	80,0 3.150	5,3 0.209	4.50X3.40	3	DIN374	6H	C
MTH-M8X0.75ISO6H-BC-V038	02880690	MF8X0.75	0,75	–	6,0 0.236	57,0 2.244	13,0 0.512	80,0 3.150	7,3 0.287	6.00X4.90	3	DIN374	6H	C
MTH-M8X1.00ISO6H-BC-V038	02880691	MF8X1.0	1,0	–	6,0 0.236	67,0 2.638	13,0 0.512	90,0 3.543	7,1 0.280	6.00X4.90	3	DIN374	6H	C
MTH-M9X1.00ISO6H-BC-V038	03000361	MF9X1.0	1,0	–	7,0 0.276	67,0 2.638	17,0 0.669	90,0 3.543	8,1 0.319	7.00X5.50	3	DIN374	6H	C
MTH-M10X0.75ISO6H-BC-V038	02880692	MF10X0.75	0,75	–	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	9,3 0.366	7.00X5.50	3	DIN374	6H	C
MTH-M10X1.00ISO6H-BC-V038	02880693	MF10X1.0	1,0	–	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	9,1 0.358	7.00X5.50	3	DIN374	6H	C
MTH-M10X1.25ISO6H-BC-V038	02880694	MF10X1.25	1,25	–	7,0 0.276	77,0 3.031	15,0 0.591	100,0 3.937	8,8 0.346	7.00X5.50	3	DIN374	6H	C
MTH-M11X1.00ISO6H-BC-V038	03000362	MF11X1.0	1,0	–	8,0 0.315	63,0 2.480	18,0 0.709	90,0 3.543	10,1 0.398	8.00X6.20	3	DIN374	6H	C
MTH-M11X1.25ISO6H-BC-V038	03000363	MF11X1.25	1,25	–	8,0 0.315	63,0 2.480	22,0 0.866	90,0 3.543	9,8 0.386	8.00X6.20	3	DIN374	6H	C
MTH-M12X1.00ISO6H-BC-V038	02880695	MF12X1.0	1,0	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	11,1 0.437	9.00X7.00	3	DIN374	6H	C
MTH-M12X1.25ISO6H-BC-V038	02880696	MF12X1.25	1,25	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,8 0.425	9.00X7.00	3	DIN374	6H	C
MTH-M12X1.50ISO6H-BC-V038	02880697	MF12X1.5	1,5	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,6 0.417	9.00X7.00	3	DIN374	6H	C
MTH-M14X1.00ISO6H-BC-V038	02880698	MF14X1.0	1,0	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	13,1 0.516	11.00X9.00	3	DIN374	6H	C
MTH-M14X1.25ISO6H-BC-V038	02880699	MF14X1.25	1,25	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,8 0.504	11.00X9.00	3	DIN374	6H	C
MTH-M14X1.50ISO6H-BC-V038	02880701	MF14X1.5	1,5	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,6 0.496	11.00X9.00	3	DIN374	6H	C
MTH-M16X1.00ISO6H-BC-V038	02880702	MF16X1.0	1,0	–	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	15,1 0.594	12.00X9.00	4	DIN374	6H	C
MTH-M16X1.50ISO6H-BC-V038	02880703	MF16X1.5	1,5	–	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	14,6 0.575	12.00X9.00	4	DIN374	6H	C
MTH-M18X1.00ISO6H-BC-V038	02880704	MF18X1.0	1,0	–	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	17,1 0.673	14.00X11.00	4	DIN374	6H	C
MTH-M18X1.50ISO6H-BC-V038	02880705	MF18X1.5	1,5	–	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	16,6 0.654	14.00X11.00	4	DIN374	6H	C
MTH-M20X1.00ISO6H-BC-V038	02880706	MF20X1.0	1,0	–	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	19,1 0.752	16.00X12.00	4	DIN374	6H	C

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex



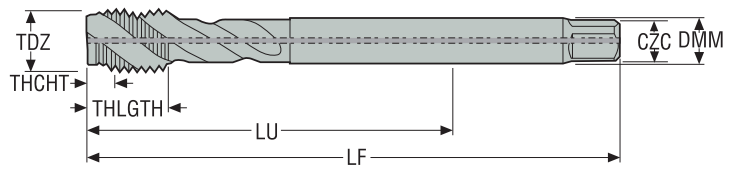
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M20X1.50ISO6H-BC-V038	02880707	MF20X1.5	1,5	–	16,0 <i>0.630</i>	80,0 <i>3.150</i>	17,0 <i>0.669</i>	125,0 <i>4.921</i>	18,6 <i>0.732</i>	16.00X12.00	4	DIN374	6H	C
MTH-M22X1.50ISO6H-BC-V038	02880708	MF22X1.5	1,5	–	18,0 <i>0.709</i>	78,0 <i>3.071</i>	17,0 <i>0.669</i>	125,0 <i>4.921</i>	20,5 <i>0.807</i>	18.00X14.50	4	DIN374	6H	C
MTH-M24X1.50ISO6H-BC-V038	02880709	MF24X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	22,5 <i>0.886</i>	18.00X14.50	4	DIN374	6H	C
MTH-M24X2.00ISO6H-BC-V038	02880710	MF24X2.0	2,0	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	22,0 <i>0.866</i>	18.00X14.50	4	DIN374	6H	C
MTH-M25X1.50ISO6H-BC-V038	02880711	MF25X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	23,5 <i>0.925</i>	18.00X14.50	4	DIN374	6H	C
MTH-M26X1.50ISO6H-BC-V038	02880712	MF26X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	24,5 <i>0.965</i>	18.00X14.50	4	DIN374	6H	C
MTH-M27X1.50ISO6H-BC-V038	02880713	MF27X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	25,5 <i>1.004</i>	20.00X16.00	4	DIN374	6H	C
MTH-M27X2.00ISO6H-BC-V038	02880714	MF27X2.0	2,0	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	25,0 <i>0.984</i>	20.00X16.00	4	DIN374	6H	C
MTH-M28X1.50ISO6H-BC-V038	02880715	MF28X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	26,5 <i>1.043</i>	20.00X16.00	4	DIN374	6H	C
MTH-M30X1.50ISO6H-BC-V038	02880717	MF30X1.5	1,5	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	20,0 <i>0.787</i>	150,0 <i>5.906</i>	28,5 <i>1.122</i>	22.00X18.00	4	DIN374	6H	C
MTH-M30X2.00ISO6H-BC-V038	02880718	MF30X2.0	2,0	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	20,0 <i>0.787</i>	150,0 <i>5.906</i>	28,0 <i>1.102</i>	22.00X18.00	4	DIN374	6H	C

Designation Ansi	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M16X1.00ISO6H-V038	02880702	MF16X1.0	1,0	–	12,0 <i>0.472</i>	58,0 <i>2.283</i>	15,0 <i>0.591</i>	100,0 <i>3.937</i>	15,1 <i>0.594</i>	12.00X9.00	4	DIN374	6H	C

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# MTH-V038-A

Blind holes



- For cutting data see page(s) 244
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M6X0.75ISO6H-BC-V038-A	03000250	MF6X0.75	0,75	–	4,5 0.177	59,0 2.323	10,0 0.394	80,0 3.150	5,3 0.209	4.50X3.40	3	DIN374	6H	C
MTH-M8X0.75ISO6H-BC-V038-A	03000251	MF8X0.75	0,75	–	6,0 0.236	57,0 2.244	13,0 0.512	80,0 3.150	7,3 0.287	6.00X4.90	3	DIN374	6H	C
MTH-M8X1.00ISO6H-BC-V038-A	03000252	MF8X1.0	1,0	–	6,0 0.236	67,0 2.638	13,0 0.512	90,0 3.543	7,1 0.280	6.00X4.90	3	DIN374	6H	C
MTH-M10X0.75ISO6H-BC-V038-A	03000253	MF10X0.75	0,75	–	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	9,3 0.366	7.00X5.50	3	DIN374	6H	C
MTH-M10X1.00ISO6H-BC-V038-A	03000254	MF10X1.0	1,0	–	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	9,1 0.358	7.00X5.50	3	DIN374	6H	C
MTH-M10X1.25ISO6H-BC-V038-A	03000255	MF10X1.25	1,25	–	7,0 0.276	77,0 3.031	15,0 0.591	100,0 3.937	8,8 0.346	7.00X5.50	3	DIN374	6H	C
MTH-M12X1.00ISO6H-BC-V038-A	03000256	MF12X1.0	1,0	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	11,1 0.437	9.00X7.00	3	DIN374	6H	C
MTH-M12X1.25ISO6H-BC-V038-A	03000257	MF12X1.25	1,25	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,8 0.425	9.00X7.00	3	DIN374	6H	C
MTH-M12X1.50ISO6H-BC-V038-A	03000258	MF12X1.5	1,5	–	9,0 0.354	73,0 2.874	15,0 0.591	100,0 3.937	10,6 0.417	9.00X7.00	3	DIN374	6H	C
MTH-M14X1.00ISO6H-BC-V038-A	03000259	MF14X1.0	1,0	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	13,1 0.516	11.00X9.00	3	DIN374	6H	C
MTH-M14X1.25ISO6H-BC-V038-A	03000260	MF14X1.25	1,25	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,8 0.504	11.00X9.00	3	DIN374	6H	C
MTH-M14X1.50ISO6H-BC-V038-A	03000261	MF14X1.5	1,5	–	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	12,6 0.496	11.00X9.00	3	DIN374	6H	C
MTH-M16X1.00ISO6H-BC-V038-A	03000262	MF16X1.0	1,0	–	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	15,1 0.594	12.00X9.00	4	DIN374	6H	C
MTH-M16X1.50ISO6H-BC-V038-A	03000263	MF16X1.5	1,5	–	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	14,6 0.575	12.00X9.00	4	DIN374	6H	C
MTH-M18X1.00ISO6H-BC-V038-A	03000264	MF18X1.0	1,0	–	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	17,1 0.673	14.00X11.00	4	DIN374	6H	C
MTH-M18X1.50ISO6H-BC-V038-A	03000265	MF18X1.5	1,5	–	14,0 0.551	66,0 2.598	17,0 0.669	110,0 4.331	16,6 0.654	14.00X11.00	4	DIN374	6H	C
MTH-M20X1.00ISO6H-BC-V038-A	03000266	MF20X1.0	1,0	–	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	19,1 0.752	16.00X12.00	4	DIN374	6H	C
MTH-M20X1.50ISO6H-BC-V038-A	03000267	MF20X1.5	1,5	–	16,0 0.630	80,0 3.150	17,0 0.669	125,0 4.921	18,6 0.732	16.00X12.00	4	DIN374	6H	C
MTH-M22X1.50ISO6H-BC-V038-A	03000268	MF22X1.5	1,5	–	18,0 0.709	78,0 3.071	17,0 0.669	125,0 4.921	20,5 0.807	18.00X14.50	4	DIN374	6H	C
MTH-M24X1.50ISO6H-BC-V038-A	03000269	MF24X1.5	1,5	–	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	22,5 0.886	18.00X14.50	4	DIN374	6H	C
MTH-M24X2.00ISO6H-BC-V038-A	03000270	MF24X2.0	2,0	–	18,0 0.709	93,0 3.661	20,0 0.787	140,0 5.512	22,0 0.866	18.00X14.50	4	DIN374	6H	C

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-M25X1.50ISO6H-BC-V038-A	03000271	MF25X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	23,5 <i>0.925</i>	18.00X14.50	4	DIN374	6H	C
MTH-M26X1.50ISO6H-BC-V038-A	03000272	MF26X1.5	1,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	24,5 <i>0.965</i>	18.00X14.50	4	DIN374	6H	C
MTH-M27X1.50ISO6H-BC-V038-A	03000273	MF27X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	25,5 <i>1.004</i>	20.00X16.00	4	DIN374	6H	C
MTH-M27X2.00ISO6H-BC-V038-A	03000274	MF27X2.0	2,0	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	25,0 <i>0.984</i>	20.00X16.00	4	DIN374	6H	C
MTH-M28X1.50ISO6H-BC-V038-A	03000275	MF28X1.5	1,5	–	20,0 <i>0.787</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	140,0 <i>5.512</i>	26,5 <i>1.043</i>	20.00X16.00	4	DIN374	6H	C
MTH-M30X1.50ISO6H-BC-V038-A	03000276	MF30X1.5	1,5	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	20,0 <i>0.787</i>	150,0 <i>5.906</i>	28,5 <i>1.122</i>	22.00X18.00	4	DIN374	6H	C
MTH-M30X2.00ISO6H-BC-V038-A	03000277	MF30X2.0	2,0	–	22,0 <i>0.866</i>	85,0 <i>3.346</i>	20,0 <i>0.787</i>	150,0 <i>5.906</i>	28,0 <i>1.102</i>	22.00X18.00	4	DIN374	6H	C

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Thread turning

Thread MDT

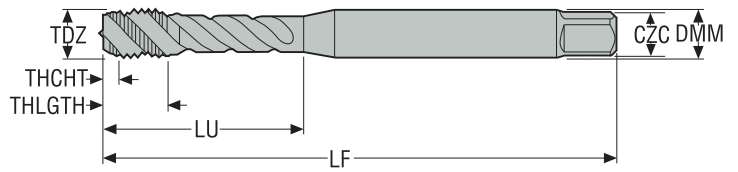
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-V040

Blind holes



- For cutting data see page(s) 244
- Coating: TiN
- Substrate: HSS-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-4-40UNC-BC-V040	02880719	UNC4-40	- 40.0	3,5 0.138	18,0 0.709	5,6 0.220	56,0 2.205	2,35 0.093	3.50X2.70	3	DIN2184-1	2B	C
MTH-5-40UNC-BC-V040	02880720	UNC5-40	- 40.0	3,5 0.138	18,0 0.709	5,6 0.220	56,0 2.205	2,65 0.104	3.50X2.70	3	DIN2184-1	2B	C
MTH-6-32UNC-BC-V040	02880721	UNC6-32	- 32.0	4,0 0.157	20,0 0.787	6,5 0.256	56,0 2.205	2,85 0.112	4.00X3.00	3	DIN2184-1	2B	C
MTH-8-32UNC-BC-V040	02880722	UNC8-32	- 32.0	4,5 0.177	21,0 0.827	6,5 0.256	63,0 2.480	3,5 0.138	4.50X3.40	3	DIN2184-1	2B	C
MTH-10-24UNC-BC-V040	02880723	UNC10-24	- 24.0	6,0 0.236	25,0 0.984	7,3 0.287	70,0 2.756	3,9 0.154	6.00X4.90	3	DIN2184-1	2B	C
MTH-12-24UNC-BC-V040	02880724	UNC12-24	- 24.0	6,0 0.236	30,0 1.181	10,0 0.394	80,0 3.150	4,5 0.177	6.00X4.90	3	DIN2184-1	2B	C
MTH-1/4-20UNC-BC-V040	02880725	UNC1/4-20	- 20.0	7,0 0.276	30,0 1.181	10,0 0.394	80,0 3.150	5,2 0.205	7.00X5.50	3	DIN2184-1	2B	C
MTH-5/16-18UNC-BC-V040	02880726	UNC5/16-18	- 18.0	8,0 0.315	35,0 1.378	12,0 0.472	90,0 3.543	6,7 0.264	8.00X6.20	3	DIN2184-1	2B	C
MTH-3/8-16UNC-BC-V040	02880727	UNC3/8-16	- 16.0	10,0 0.394	39,0 1.535	15,0 0.591	100,0 3.937	8,1 0.319	10.00X8.00	3	DIN2184-1	2B	C
MTH-7/16-14UNC-BC-V040	02880728	UNC7/16-14	- 14.0	8,0 0.315	75,75 2.982	15,0 0.591	100,0 3.937	9,5 0.374	8.00X6.20	3	DIN2184-1	2B	C
MTH-1/2-13UNC-BC-V040	02880729	UNC1/2-13	- 13.0	9,0 0.354	82,75 3.258	18,0 0.709	110,0 4.331	10,9 0.429	9.00X7.00	3	DIN2184-1	2B	C
MTH-5/8-11UNC-BC-V040	02880730	UNC5/8-11	- 11.0	12,0 0.472	67,75 2.667	20,0 0.787	110,0 4.331	13,8 0.543	12.00X9.00	4	DIN2184-1	2B	C

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Thread turning

Thread MDT

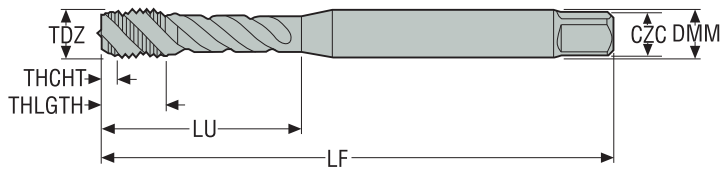
Thread Mini-Shaft™

Rotating threading

Annex

# MTH-V043

Blind holes



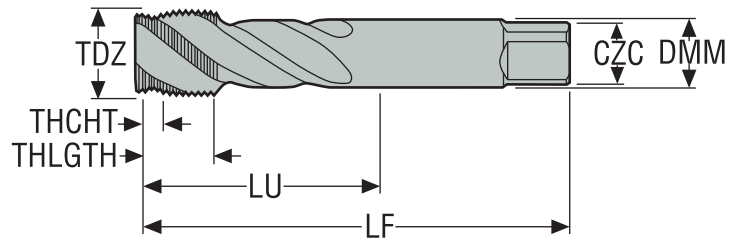
- For cutting data see page(s) 244
- Coating: TiN
- Substrate: HSS-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTH-8-36UNF-BC-V043	02880731	UNF8-36	-	36.0	4,5 <i>0.177</i>	21,0 <i>0.827</i>	6,5 <i>0.256</i>	63,0 <i>2.480</i>	3,5 <i>0.138</i>	4.50X3.40	3	DIN2184-1	2B	C
MTH-10-32UNF-BC-V043	02880732	UNF10-32	-	32.0	6,0 <i>0.236</i>	25,0 <i>0.984</i>	7,3 <i>0.287</i>	70,0 <i>2.756</i>	4,1 <i>0.161</i>	6.00X4.90	3	DIN2184-1	2B	C
MTH-1/4-28UNF-BC-V043	02880733	UNF1/4-28	-	28.0	7,0 <i>0.276</i>	30,0 <i>1.181</i>	10,0 <i>0.394</i>	80,0 <i>3.150</i>	5,5 <i>0.217</i>	7.00X5.50	3	DIN2184-1	2B	C
MTH-5/16-24UNF-BC-V043	02880734	UNF5/16-24	-	24.0	8,0 <i>0.315</i>	35,0 <i>1.378</i>	12,0 <i>0.472</i>	90,0 <i>3.543</i>	7,0 <i>0.276</i>	8.00X6.20	3	DIN2184-1	2B	C
MTH-3/8-24UNF-BC-V043	02880735	UNF3/8-24	-	24.0	10,0 <i>0.394</i>	39,0 <i>1.535</i>	15,0 <i>0.591</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	3	DIN2184-1	2B	C
MTH-7/16-20UNF-BC-V043	02880736	UNF7/16-20	-	20.0	8,0 <i>0.315</i>	75,75 <i>2.982</i>	15,0 <i>0.591</i>	100,0 <i>3.937</i>	10,0 <i>0.394</i>	8.00X6.20	3	DIN2184-1	2B	C
MTH-1/2-20UNF-BC-V043	02880737	UNF1/2-20	-	20.0	9,0 <i>0.354</i>	83,0 <i>3.268</i>	18,0 <i>0.709</i>	110,0 <i>4.331</i>	11,5 <i>0.453</i>	9.00X7.00	3	DIN2184-1	2B	C
MTH-9/16-18UNF-BC-V043	03000278	UNF9/16-18	-	18.0	11,0 <i>0.433</i>	71,0 <i>2.795</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	13,0 <i>0.512</i>	11.00X9.00	4	DIN2184-1	2B	C
MTH-5/8-18UNF-BC-V043	02880738	UNF5/8-18	-	18.0	12,0 <i>0.472</i>	67,75 <i>2.667</i>	20,0 <i>0.787</i>	110,0 <i>4.331</i>	14,6 <i>0.575</i>	12.00X9.00	4	DIN2184-1	2B	C
MTH-3/4-16UNF-BC-V043	03000279	UNF3/4-16	-	16.0	14,0 <i>0.551</i>	77,5 <i>3.051</i>	25,0 <i>0.984</i>	125,0 <i>4.921</i>	17,6 <i>0.693</i>	14.00X11.00	4	DIN2184-1	2B	C
MTH-7/8-14UNF-BC-V043	03000280	UNF7/8-14	-	14.0	18,0 <i>0.709</i>	93,0 <i>3.661</i>	25,0 <i>0.984</i>	140,0 <i>5.512</i>	20,6 <i>0.811</i>	18.00X14.50	4	DIN2184-1	2B	C
MTH-1-12UNF-BC-V043	03000281	UNF1-12	-	12.0	18,0 <i>0.709</i>	113,0 <i>4.449</i>	30,0 <i>1.181</i>	160,0 <i>6.299</i>	23,5 <i>0.925</i>	18.00X14.50	4	DIN2184-1	2B	C

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## MTH-V045

Blind holes



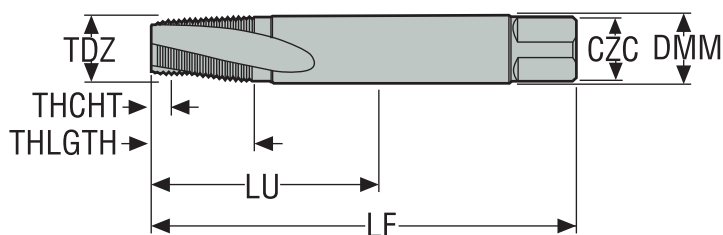
- For cutting data see page(s) 244
- Coating: TiN
- Substrate: HSS-PM ≤ G3/8, HSS-E > G3/8

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTH-1/8-28G-BC-V045	02880739	G1/8-28	–	28.0	7,0 0.276	67,0 2.638	13,0 0.512	90,0 3.543	8,8 0.346	7.00X5.50	3	DIN5156	NORMAL	C
MTH-1/4-19G-BC-V045	02880740	G1/4-19	–	19.0	11,0 0.433	71,0 2.795	15,0 0.591	100,0 3.937	11,8 0.465	11.00X9.00	3	DIN5156	NORMAL	C
MTH-3/8-19G-BC-V045	02880741	G3/8-19	–	19.0	12,0 0.472	58,0 2.283	15,0 0.591	100,0 3.937	15,3 0.602	12.00X9.00	4	DIN5156	NORMAL	C
MTH-1/2-14G-BC-V045	02880742	G1/2-14	–	14.0	16,0 0.630	80,0 3.150	18,0 0.709	125,0 4.921	19,1 0.752	16.00X12.00	4	DIN5156	NORMAL	C
MTH-5/8-14G-BC-V045	02880743	G5/8-14	–	14.0	18,0 0.709	78,0 3.071	18,0 0.709	125,0 4.921	21,1 0.831	18.00X14.50	4	DIN5156	NORMAL	C
MTH-3/4-14G-BC-V045	02880744	G3/4-14	–	14.0	20,0 0.787	77,0 3.031	20,0 0.787	140,0 5.512	24,6 0.969	20.00X16.00	4	DIN5156	NORMAL	C
MTH-7/8-14G-BC-V045	02880745	G7/8-14	–	14.0	22,0 0.866	85,0 3.346	20,0 0.787	150,0 5.906	28,3 1.114	22.00X18.00	4	DIN5156	NORMAL	C
MTH-1-11G-BC-V045	02880746	G1-11	–	11.0	25,0 0.984	93,0 3.661	22,0 0.866	160,0 6.299	30,9 1.217	25.00X20.00	4	DIN5156	NORMAL	C
MTH-1.1/8-11G-BC-V045	02880747	G1.1/8-11	–	11.0	28,0 1.102	101,0 3.976	22,0 0.866	170,0 6.693	35,5 1.398	28.00X22.00	4	DIN5156	NORMAL	C
MTH-1.1/4-11G-BC-V045	02880748	G1.1/4-11	–	11.0	32,0 1.260	72,0 2.835	22,0 0.866	170,0 6.693	39,5 1.555	32.00X24.00	4	DIN5156	NORMAL	C
MTH-1.1/2-11G-BC-V045	02880749	G1.1/2-11	–	11.0	36,0 1.417	87,0 3.425	23,0 0.906	190,0 7.480	45,4 1.787	36.00X29.00	4	DIN5156	NORMAL	C

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# MTH-V048

Blind holes



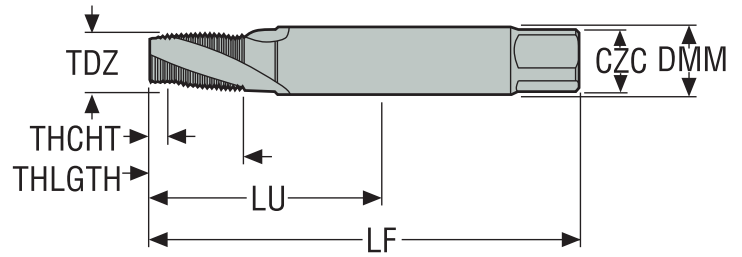
- For cutting data see page(s) 250
- Vaporised
- Substrate: HSS-E

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

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## MTH-V050

Blind holes



- For cutting data see page(s) 250
- Vaporised
- Substrate: HSS-E

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

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Thread turning

Thread MDT

Thread Mini-Start™

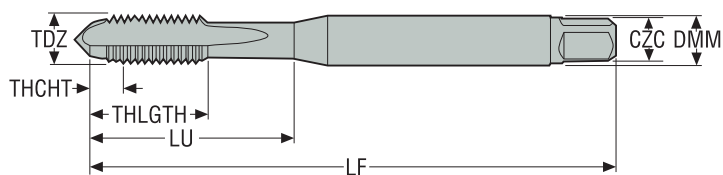
Rotating threading

Annex



# MTS-K001

Blind and through holes



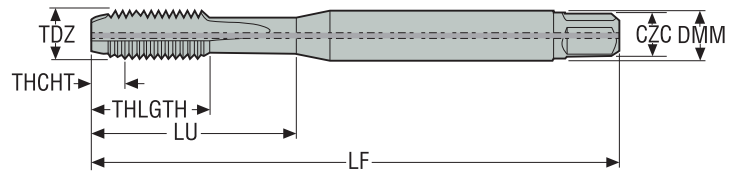
- For cutting data see page(s) 240
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTS-M3X0.50ISO6HX-XC-K001	03019067	M3	0,5	–	3,5 <i>0.138</i>	18,0 <i>0.709</i>	8,9 <i>0.350</i>	56,0 <i>2.205</i>	2,5 <i>0.098</i>	3.50X2.70	3	DIN371	6HX	C
MTS-M4X0.70ISO6HX-XC-K001	03019068	M4	0,7	–	4,5 <i>0.177</i>	21,0 <i>0.827</i>	11,7 <i>0.461</i>	63,0 <i>2.480</i>	3,4 <i>0.134</i>	4.50X3.40	4	DIN371	6HX	C
MTS-M5X0.80ISO6HX-XC-K001	03019069	M5	0,8	–	6,0 <i>0.236</i>	25,0 <i>0.984</i>	12,6 <i>0.496</i>	70,0 <i>2.756</i>	4,3 <i>0.169</i>	6.00X4.90	4	DIN371	6HX	C
MTS-M6X1.00ISO6HX-XC-K001	03019070	M6	1,0	–	6,0 <i>0.236</i>	30,0 <i>1.181</i>	14,5 <i>0.571</i>	80,0 <i>3.150</i>	5,1 <i>0.201</i>	6.00X4.90	4	DIN371	6HX	C
MTS-M8X1.25ISO6HX-XC-K001	03019071	M8	1,25	–	8,0 <i>0.315</i>	35,0 <i>1.378</i>	18,1 <i>0.713</i>	90,0 <i>3.543</i>	6,8 <i>0.268</i>	8.00X6.20	4	DIN371	6HX	C
MTS-M10X1.50ISO6HX-XC-K001	03019072	M10	1,5	–	10,0 <i>0.394</i>	39,0 <i>1.535</i>	20,1 <i>0.791</i>	100,0 <i>3.937</i>	8,6 <i>0.339</i>	10.00X8.00	4	DIN371	6HX	C

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## MTS-K001-A

Blind and through holes



- For cutting data see page(s) 240
- Coating: TiAIN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch				
MTS-M4X0.70ISO6HX-XC-K001-A	02999827	M4	0,7 –	4,5 0.177	21,0 0.827	11,7 0.461	63,0 2.480	3,4 0.134	4.50X3.40	4	DIN371	6HX	C
MTS-M5X0.80ISO6HX-XC-K001-A	02999828	M5	0,8 –	6,0 0.236	25,0 0.984	12,6 0.496	70,0 2.756	4,3 0.169	6.00X4.90	4	DIN371	6HX	C
MTS-M5X0.80ISO6HX-XE-K001-A	02999844	M5	0,8 –	6,0 0.236	25,0 0.984	12,6 0.496	70,0 2.756	4,3 0.169	6.00X4.90	4	DIN371	6HX	E
MTS-M6X1.00ISO6HX-XC-K001-A	02999829	M6	1,0 –	6,0 0.236	30,0 1.181	14,5 0.571	80,0 3.150	5,1 0.201	6.00X4.90	4	DIN371	6HX	C
MTS-M6X1.00ISO6HX-XE-K001-A	02999845	M6	1,0 –	6,0 0.236	30,0 1.181	14,5 0.571	80,0 3.150	5,1 0.201	6.00X4.90	4	DIN371	6HX	E
MTS-M8X1.25ISO6HX-XC-K001-A	02999830	M8	1,25 –	8,0 0.315	35,0 1.378	18,1 0.713	90,0 3.543	6,8 0.268	8.00X6.20	4	DIN371	6HX	C
MTS-M8X1.25ISO6HX-XE-K001-A	02999846	M8	1,25 –	8,0 0.315	35,0 1.378	18,1 0.713	90,0 3.543	6,8 0.268	8.00X6.20	4	DIN371	6HX	E
MTS-M10X1.50ISO6HX-XC-K001-A	02999831	M10	1,5 –	10,0 0.394	39,0 1.535	20,1 0.791	100,0 3.937	8,6 0.339	10.00X8.00	4	DIN371	6HX	C
MTS-M10X1.50ISO6HX-XE-K001-A	02999847	M10	1,5 –	10,0 0.394	39,0 1.535	20,1 0.791	100,0 3.937	8,6 0.339	10.00X8.00	4	DIN371	6HX	E

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Thread turning

Thread MDT

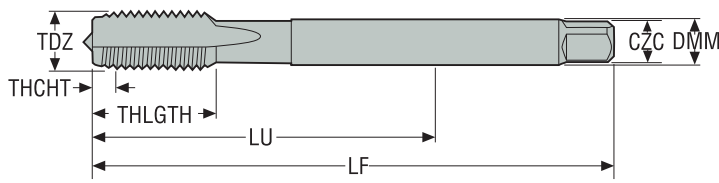
Thread Mini-Start™

Rotating threading

Annex

# MTS-K002

Blind and through holes



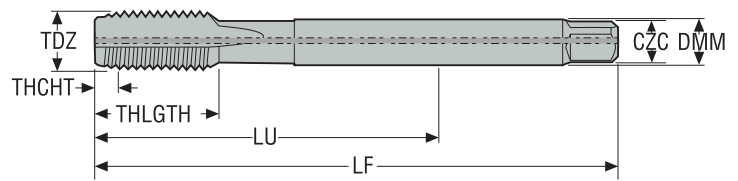
- For cutting data see page(s) 240
- Coating: TiCN<=M24, TiAlN>M24
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTS-M8X1.25ISO6HX-XC-K002	03019073	M8	1,25	-	6,0 0.236	67,0 2.638	18,0 0.709	90,0 3.543	6,8 0.268	6.00X4.90	4	DIN376	6HX	C
MTS-M10X1.50ISO6HX-XC-K002	03019075	M10	1,5	-	7,0 0.276	77,0 3.031	20,0 0.787	100,0 3.937	8,6 0.339	7.00X5.50	4	DIN376	6HX	C
MTS-M12X1.75ISO6HX-XC-K002	03019076	M12	1,75	-	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	10,4 0.409	9.00X7.00	4	DIN376	6HX	C
MTS-M14X2.00ISO6HX-XC-K002	03019077	M14	2,0	-	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	12,1 0.476	11.00X9.00	4	DIN376	6HX	C
MTS-M16X2.00ISO6HX-XC-K002	03019078	M16	2,0	-	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	14,1 0.555	12.00X9.00	4	DIN376	6HX	C
MTS-M18X2.50ISO6HX-XC-K002	03019079	M18	2,5	-	14,0 0.551	81,0 3.189	30,0 1.181	125,0 4.921	15,7 0.618	14.00X11.00	4	DIN376	6HX	C
MTS-M20X2.50ISO6HX-XC-K002	03019080	M20	2,5	-	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	17,7 0.697	16.00X12.00	4	DIN376	6HX	C
MTS-M22X2.50ISO6HX-XC-K002	03019081	M22	2,5	-	18,0 0.709	93,0 3.661	34,0 1.339	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN376	6HX	C
MTS-M24X3.00ISO6HX-XC-K002	03019082	M24	3,0	-	18,0 0.709	113,0 4.449	38,0 1.496	160,0 6.299	21,0 0.827	18.00X14.50	4	DIN376	6HX	C
MTS-M27X3.00ISO6HX-XC-K002	02999880	M27	3,0	-	20,0 0.787	97,0 3.819	38,0 1.496	160,0 6.299	24,0 0.945	20.00X16.00	4	DIN376	6HX	C
MTS-M30X3.50ISO6HX-XC-K002	02999881	M30	3,5	-	22,0 0.866	115,0 4.528	45,0 1.772	180,0 7.087	26,5 1.043	22.00X18.00	4	DIN376	6HX	C
MTS-M33X3.50ISO6HX-XC-K002	02999882	M33	3,5	-	25,0 0.984	113,0 4.449	50,0 1.969	180,0 7.087	29,5 1.161	25.00X20.00	4	DIN376	6HX	C
MTS-M36X4.00ISO6HX-XC-K002	02999883	M36	4,0	-	28,0 1.102	131,0 5.157	55,0 2.165	200,0 7.874	32,0 1.260	28.00X22.00	4	DIN376	6HX	C
MTS-M39X4.00ISO6HX-XC-K002	02999884	M39	4,0	-	32,0 1.260	102,0 4.016	60,0 2.362	200,0 7.874	35,0 1.378	32.00X24.00	4	DIN376	6HX	C
MTS-M42X4.50ISO6HX-XC-K002	02999885	M42	4,5	-	32,0 1.260	102,0 4.016	60,0 2.362	200,0 7.874	37,5 1.476	32.00X24.00	4	DIN376	6HX	C

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## MTS-K002-A

Blind and through holes



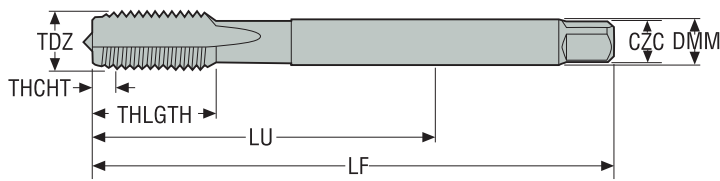
- For cutting data see page(s) 240
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCR	THCHT
			mm	TPI										
MTS-M12X1.75ISO6HX-XC-K002-A	02999832	M12	1,75	–	9,0 <i>0.354</i>	83,0 <i>3.268</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	4	DIN376	6HX	C
MTS-M12X1.75ISO6HX-XE-K002-A	02999848	M12	1,75	–	9,0 <i>0.354</i>	83,0 <i>3.268</i>	24,0 <i>0.945</i>	110,0 <i>4.331</i>	10,4 <i>0.409</i>	9.00X7.00	4	DIN376	6HX	E
MTS-M14X2.00ISO6HX-XC-K002-A	02999833	M14	2,0	–	11,0 <i>0.433</i>	81,0 <i>3.189</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	12,1 <i>0.476</i>	11.00X9.00	4	DIN376	6HX	C
MTS-M16X2.00ISO6HX-XC-K002-A	02999834	M16	2,0	–	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,1 <i>0.555</i>	12.00X9.00	4	DIN376	6HX	C
MTS-M20X2.50ISO6HX-XC-K002-A	02999835	M20	2,5	–	16,0 <i>0.630</i>	95,0 <i>3.740</i>	30,0 <i>1.181</i>	140,0 <i>5.512</i>	17,7 <i>0.697</i>	16.00X12.00	4	DIN376	6HX	C
MTS-M22X2.50ISO6HX-XC-K002-A	02999836	M22	2,5	–	18,0 <i>0.709</i>	93,0 <i>3.661</i>	34,0 <i>1.339</i>	140,0 <i>5.512</i>	19,7 <i>0.776</i>	18.00X14.50	4	DIN376	6HX	C
MTS-M24X3.00ISO6HX-XC-K002-A	02999837	M24	3,0	–	18,0 <i>0.709</i>	113,0 <i>4.449</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	21,0 <i>0.827</i>	18.00X14.50	4	DIN376	6HX	C
MTS-M27X3.00ISO6HX-XC-K002-A	02999838	M27	3,0	–	20,0 <i>0.787</i>	97,0 <i>3.819</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	24,0 <i>0.945</i>	20.00X16.00	4	DIN376	6HX	C
MTS-M30X3.50ISO6HX-XC-K002-A	02999839	M30	3,5	–	22,0 <i>0.866</i>	115,0 <i>4.528</i>	45,0 <i>1.772</i>	180,0 <i>7.087</i>	26,5 <i>1.043</i>	22.00X18.00	4	DIN376	6HX	C
MTS-M33X3.50ISO6HX-XC-K002-A	02999840	M33	3,5	–	25,0 <i>0.984</i>	113,0 <i>4.449</i>	50,0 <i>1.969</i>	180,0 <i>7.087</i>	29,5 <i>1.161</i>	25.00X20.00	4	DIN376	6HX	C
MTS-M36X4.00ISO6HX-XC-K002-A	02999841	M36	4,0	–	28,0 <i>1.102</i>	131,0 <i>5.157</i>	55,0 <i>2.165</i>	200,0 <i>7.874</i>	32,0 <i>1.260</i>	28.00X22.00	4	DIN376	6HX	C
MTS-M39X4.00ISO6HX-XC-K002-A	02999842	M39	4,0	–	32,0 <i>1.260</i>	102,0 <i>4.016</i>	60,0 <i>2.362</i>	200,0 <i>7.874</i>	35,0 <i>1.378</i>	32.00X24.00	4	DIN376	6HX	C
MTS-M42X4.50ISO6HX-XC-K002-A	02999843	M42	4,5	–	32,0 <i>1.260</i>	102,0 <i>4.016</i>	60,0 <i>2.362</i>	200,0 <i>7.874</i>	37,5 <i>1.476</i>	32.00X24.00	4	DIN376	6HX	C

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# MTS-K011

Blind and through holes



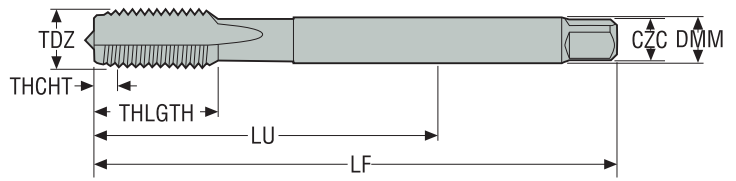
- For cutting data see page(s) 240
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CXC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTS-M10X1.00ISO6HX-XC-K011	02999849	MF10X1.0	1,0	-	7,0 0.276	67,0 2.638	20,0 0.787	90,0 3.543	9,1 0.358	7.00X5.50	4	DIN374	6HX	C
MTS-M10X1.25ISO6HX-XC-K011	02999850	MF10X1.25	1,25	-	7,0 0.276	77,0 3.031	20,0 0.787	100,0 3.937	8,8 0.346	7.00X5.50	4	DIN374	6HX	C
MTS-M12X1.25ISO6HX-XC-K011	02999851	MF12X1.25	1,25	-	9,0 0.354	73,0 2.874	21,0 0.827	100,0 3.937	10,8 0.425	9.00X7.00	4	DIN374	6HX	C
MTS-M12X1.50ISO6HX-XC-K011	02999852	MF12X1.5	1,5	-	9,0 0.354	73,0 2.874	21,0 0.827	100,0 3.937	10,6 0.417	9.00X7.00	4	DIN374	6HX	C
MTS-M14X1.50ISO6HX-XC-K011	02999853	MF14X1.5	1,5	-	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	12,6 0.496	11.00X9.00	4	DIN374	6HX	C
MTS-M16X1.50ISO6HX-XC-K011	02999854	MF16X1.5	1,5	-	12,0 0.472	58,0 2.283	21,0 0.827	100,0 3.937	14,6 0.575	12.00X9.00	4	DIN374	6HX	C
MTS-M18X1.50ISO6HX-XC-K011	02999855	MF18X1.5	1,5	-	14,0 0.551	66,0 2.598	24,0 0.945	110,0 4.331	16,6 0.654	14.00X11.00	4	DIN374	6HX	C
MTS-M20X1.50ISO6HX-XC-K011	02999856	MF20X1.5	1,5	-	16,0 0.630	80,0 3.150	24,0 0.945	125,0 4.921	18,6 0.732	16.00X12.00	4	DIN374	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MTS-K021

Blind and through holes



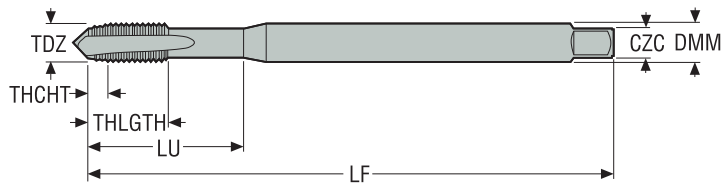
- For cutting data see page(s) 240
- Coating: TiAIN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTS-1/8-28G-XC-K021	02999857	G1/8-28	- 28.0	7,0 0.276	67,0 2.638	20,0 0.787	90,0 3.543	8,8 0.346	7.00X5.50	4	DIN5156	NORMAL	C
MTS-1/4-19G-XC-K021	02999858	G1/4-19	- 19.0	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	11,8 0.465	11.00X9.00	4	DIN5156	NORMAL	C
MTS-3/8-19G-XC-K021	02999859	G3/8-19	- 19.0	12,0 0.472	58,0 2.283	21,0 0.827	100,0 3.937	15,3 0.602	12.00X9.00	5	DIN5156	NORMAL	C
MTS-1/2-14G-XC-K021	02999860	G1/2-14	- 14.0	16,0 0.630	80,0 3.150	24,0 0.945	125,0 4.921	19,1 0.752	16.00X12.00	5	DIN5156	NORMAL	C
MTS-3/4-14G-XC-K021	02999861	G3/4-14	- 14.0	20,0 0.787	77,0 3.031	28,0 1.102	140,0 5.512	24,6 0.969	20.00X16.00	6	DIN5156	NORMAL	C
MTS-1-11G-XC-K021	02999862	G1-11	- 11.0	25,0 0.984	93,0 3.661	30,0 1.181	160,0 6.299	30,9 1.217	25.00X20.00	6	DIN5156	NORMAL	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# MTS-K031

Blind and through holes



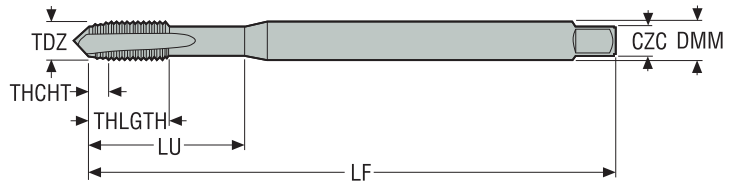
- For cutting data see page(s) 240
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MTS-1/4-20UNC-XC-K031	02999863	UNC1/4-20	-	20.0	7,0 0.276	30,0 1.181	15,0 0.591	80,0 3.150	5,2 0.205	7.00X5.50	4	DIN2184-1	2BX	C
MTS-5/16-18UNC-XC-K031	02999864	UNC5/16-18	-	18.0	8,0 0.315	35,0 1.378	18,0 0.709	90,0 3.543	6,7 0.264	8.00X6.20	4	DIN2184-1	2BX	C
MTS-3/8-16UNC-XC-K031	02999865	UNC3/8-16	-	16.0	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	8,1 0.319	10.00X8.00	4	DIN2184-1	2BX	C
MTS-7/16-14UNC-XC-K031	02999866	UNC7/16-14	-	14.0	8,0 0.315	83,0 3.268	20,0 0.787	100,0 3.937	9,5 0.374	8.00X6.20	4	DIN2184-1	2BX	C
MTS-1/2-13UNC-XC-K031	02999867	UNC1/2-13	-	13.0	9,0 0.354	81,0 3.189	23,0 0.906	110,0 4.331	10,9 0.429	9.00X7.00	4	DIN2184-1	2BX	C
MTS-5/8-11UNC-XC-K031	02999868	UNC5/8-11	-	11.0	12,0 0.472	68,0 2.677	23,0 0.906	110,0 4.331	13,8 0.543	12.00X9.00	4	DIN2184-1	2BX	C
MTS-3/4-10UNC-XC-K031	02999869	UNC3/4-10	-	10.0	14,0 0.551	80,0 3.150	30,0 1.181	125,0 4.921	16,8 0.661	14.00X11.00	4	DIN2184-1	2BX	C
MTS-7/8-9UNC-XC-K031	02999870	UNC7/8-9	-	9.0	18,0 0.709	93,0 3.661	34,0 1.339	140,0 5.512	19,7 0.776	18.00X14.50	4	DIN2184-1	2BX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# MTS-K041

Blind and through holes



- For cutting data see page(s) 240
- Coating: TiAIN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MTS-1/4-28UNF-XC-K041	02999871	UNF1/4-28	- 28.0	7,0 0.276	30,0 1.181	15,0 0.591	80,0 3.150	5,5 0.217	7.00X5.50	4	DIN2184-1	2BX	C
MTS-5/16-24UNF-XC-K041	02999872	UNF5/16-24	- 24.0	8,0 0.315	35,0 1.378	18,0 0.709	90,0 3.543	7,0 0.276	8.00X6.20	4	DIN2184-1	2BX	C
MTS-3/8-24UNF-XC-K041	02999873	UNF3/8-24	- 24.0	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	8,6 0.339	10.00X8.00	4	DIN2184-1	2BX	C
MTS-7/16-20UNF-XC-K041	02999874	UNF7/16-20	- 20.0	8,0 0.315	83,0 3.268	20,0 0.787	100,0 3.937	10,0 0.394	8.00X6.20	4	DIN2184-1	2BX	C
MTS-1/2-20UNF-XC-K041	02999875	UNF1/2-20	- 20.0	9,0 0.354	81,0 3.189	23,0 0.906	110,0 4.331	11,5 0.453	9.00X7.00	4	DIN2184-1	2BX	C
MTS-5/8-18UNF-XC-K041	02999876	UNF5/8-18	- 18.0	12,0 0.472	68,0 2.677	23,0 0.906	110,0 4.331	14,6 0.575	12.00X9.00	4	DIN2184-1	2BX	C
MTS-3/4-16UNF-XC-K041	02999878	UNF3/4-16	- 16.0	14,0 0.551	80,0 3.150	30,0 1.181	125,0 4.921	17,6 0.693	14.00X11.00	4	DIN2184-1	2BX	C
MTS-7/8-14UNF-XC-K041	02999879	UNF7/8-14	- 14.0	18,0 0.709	93,0 3.661	34,0 1.339	140,0 5.512	20,6 0.811	18.00X14.50	4	DIN2184-1	2BX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Shaft™

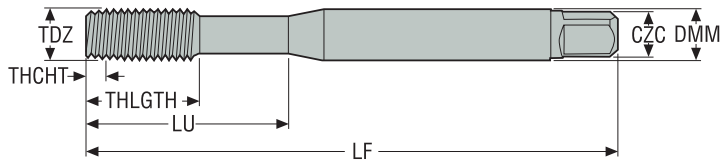
Rotating threading

Annex



MF-V053

Forming holes



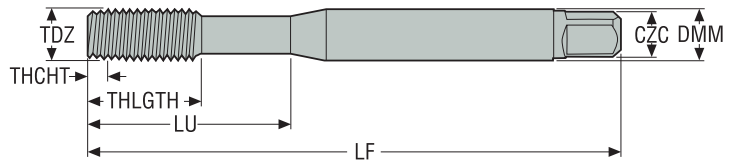
- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- \* With tip shape. More information: Suggest at secotools.com

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MF-M3X0.50ISO6HX-XE-V053	02880457	M3	0,5	–	3,5 0.138	18,0 0.709	9,0 0.354	56,0 2.205	2,8 0.110	3.50X2.70	4	DIN2174	6HX	E
MF-M4X0.70ISO6HX-XE-V053	02880458	M4	0,7	–	4,5 0.177	21,0 0.827	12,0 0.472	63,0 2.480	3,7 0.146	4.50X3.40	5	DIN2174	6HX	E
MF-M5X0.80ISO6HX-XE-V053	02880459	M5	0,8	–	6,0 0.236	25,0 0.984	13,0 0.512	70,0 2.756	4,65 0.183	6.00X4.90	5	DIN2174	6HX	E
MF-M6X1.00ISO6HX-XE-V053	02880460	M6	1,0	–	6,0 0.236	30,0 1.181	15,0 0.591	80,0 3.150	5,55 0.219	6.00X4.90	5	DIN2174	6HX	E
MF-M8X1.25ISO6HX-XE-V053	02880461	M8	1,25	–	8,0 0.315	35,0 1.378	18,0 0.709	90,0 3.543	7,45 0.293	8.00X6.20	5	DIN2174	6HX	E
MF-M10X1.50ISO6HX-XE-V053	02880462	M10	1,5	–	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	9,35 0.368	10.00X8.00	5	DIN2174	6HX	E

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

# MF-V054

Forming holes



- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- \* With tip shape. More information: Suggest at [secotools.com](http://secotools.com)

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MF-M1X0.25ISO5HX-XC-V054	03000282	*	M1	0,25	-	2,5 0.098	20,0 0.787	5,5 0.217	40,0 1.575	0,89 0.035	2.50X2.10	3	DIN2174	5HX	C
MF-M1.1X0.25ISO5HX-XC-V054	03000283	*	M1.1	0,25	-	2,5 0.098	20,0 0.787	5,5 0.217	40,0 1.575	0,99 0.039	2.50X2.10	3	DIN2174	5HX	C
MF-M1.2X0.25ISO5HX-XC-V054	03000284	*	M1.2	0,25	-	2,5 0.098	20,0 0.787	5,5 0.217	40,0 1.575	1,09 0.043	2.50X2.10	3	DIN2174	5HX	C
MF-M1.4X0.30ISO5HX-XC-V054	03000285	*	M1.4	0,3	-	2,5 0.098	20,0 0.787	7,0 0.276	40,0 1.575	1,27 0.050	2.50X2.10	3	DIN2174	5HX	C
MF-M1.6X0.35ISO6HX-XC-V054	03000286	*	M1.6	0,35	-	2,5 0.098	20,0 0.787	8,0 0.315	40,0 1.575	1,45 0.057	2.50X2.10	3	DIN2174	6HX	C
MF-M1.7X0.35ISO6HX-XC-V054	03000287	*	M1.7	0,35	-	2,5 0.098	20,0 0.787	8,0 0.315	40,0 1.575	1,55 0.061	2.50X2.10	3	DIN2174	6HX	C
MF-M1.8X0.35ISO6HX-XC-V054	03000288	*	M1.8	0,35	-	2,5 0.098	20,0 0.787	8,0 0.315	40,0 1.575	1,65 0.065	2.50X2.10	3	DIN2174	6HX	C
MF-M2X0.40ISO6HX-XC-V054	03000289	*	M2	0,4	-	2,8 0.110	11,0 0.433	6,0 0.236	45,0 1.772	1,82 0.072	2.80X2.10	3	DIN2174	6HX	C
MF-M2.2X0.45ISO6HX-XC-V054	03000290	*	M2.2	0,45	-	2,8 0.110	12,0 0.472	7,0 0.276	45,0 1.772	2,0 0.079	2.80X2.10	3	DIN2174	6HX	C
MF-M2.3X0.40ISO6HX-XC-V054	03000291	*	M2.3	0,4	-	2,8 0.110	12,0 0.472	7,0 0.276	45,0 1.772	2,12 0.083	2.80X2.10	3	DIN2174	6HX	C
MF-M2.5X0.45ISO6HX-XC-V054	03000292	*	M2.5	0,45	-	2,8 0.110	14,0 0.551	8,0 0.315	50,0 1.969	2,3 0.091	2.80X2.10	3	DIN2174	6HX	C
MF-M2.6X0.45ISO6HX-XC-V054	03000293	*	M2.6	0,45	-	2,8 0.110	14,0 0.551	8,0 0.315	50,0 1.969	2,4 0.094	2.80X2.10	3	DIN2174	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

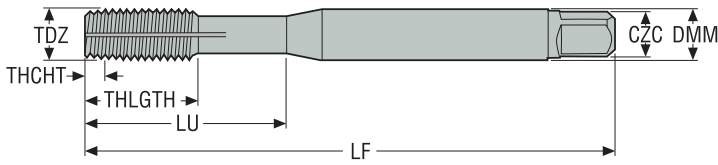
Thread Mini-Start™

Rotating threading

Annex

MF-V055

Forming holes



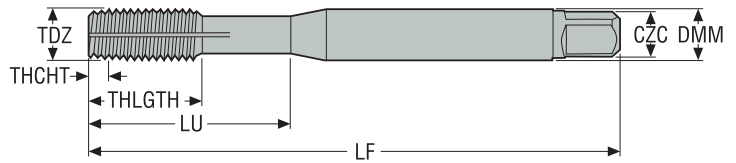
- With channels for lubrication
- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- \* With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI										
MF-M3X0.50ISO6HX-XC-V055	02880463	*	M3	0,5	-	3,5 0.138	18,0 0.709	9,0 0.354	56,0 2.205	2,8 0.110	3.50X2.70	4	DIN2174	6HX	C
MF-M4X0.70ISO6HX-XC-V055	02880464	*	M4	0,7	-	4,5 0.177	21,0 0.827	12,0 0.472	63,0 2.480	3,7 0.146	4.50X3.40	5	DIN2174	6HX	C
MF-M5X0.80ISO6HX-XC-V055	02880465	*	M5	0,8	-	6,0 0.236	25,0 0.984	13,0 0.512	70,0 2.756	4,65 0.183	6.00X4.90	5	DIN2174	6HX	C
MF-M6X1.00ISO6HX-XC-V055	02880466	*	M6	1,0	-	6,0 0.236	30,0 1.181	15,0 0.591	80,0 3.150	5,55 0.219	6.00X4.90	5	DIN2174	6HX	C
MF-M7X1.00ISO6HX-XC-V055	02880467	*	M7	1,0	-	7,0 0.276	30,0 1.181	15,0 0.591	80,0 3.150	6,55 0.258	7.00X5.50	5	DIN2174	6HX	C
MF-M8X1.25ISO6HX-XC-V055	02880468		M8	1,25	-	8,0 0.315	35,0 1.378	18,0 0.709	90,0 3.543	7,45 0.293	8.00X6.20	5	DIN2174	6HX	C
MF-M10X1.50ISO6HX-XC-V055	02880469		M10	1,5	-	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	9,35 0.368	10.00X8.00	5	DIN2174	6HX	C
MF-M12X1.75ISO6HX-XC-V055	02880470	*	M12	1,75	-	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	11,2 0.441	9.00X7.00	5	DIN2174	6HX	C
MF-M14X2.00ISO6HX-XC-V055	02880471		M14	2,0	-	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	13,1 0.516	11.00X9.00	6	DIN2174	6HX	C
MF-M16X2.00ISO6HX-XC-V055	02880472		M16	2,0	-	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	15,1 0.594	12.00X9.00	6	DIN2174	6HX	C
MF-M20X2.50ISO6HX-XC-V055	02880473		M20	2,5	-	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	18,9 0.744	16.00X12.00	7	DIN2174	6HX	C
MF-M24X3.00ISO6HX-XC-V055	02880474		M24	3,0	-	18,0 0.709	113,0 4.449	36,0 1.417	160,0 6.299	22,65 0.892	18.00X14.50	8	DIN2174	6HX	C
MF-M27X3.00ISO6HX-XC-V055	03000294		M27	3,0	-	20,0 0.787	97,0 3.819	36,0 1.417	160,0 6.299	25,65 1.010	20.00X16.00	8	DIN2174	6HX	C
MF-M30X3.50ISO6HX-XC-V055	03000295		M30	3,5	-	22,0 0.866	115,0 4.528	40,0 1.575	180,0 7.087	28,45 1.120	22.00X18.00	10	DIN2174	6HX	C
MF-M33X3.50ISO6HX-XC-V055	03000296		M33	3,5	-	25,0 0.984	113,0 4.449	40,0 1.575	180,0 7.087	31,45 1.238	25.00X20.00	10	DIN2174	6HX	C
MF-M36X4.00ISO6HX-XC-V055	03000297		M36	4,0	-	28,0 1.102	131,0 5.157	50,0 1.969	200,0 7.874	34,23 1.348	28.00X22.00	10	DIN2174	6HX	C
MF-M39X4.00ISO6HX-XC-V055	03000298		M39	4,0	-	32,0 1.260	102,0 4.016	50,0 1.969	200,0 7.874	37,23 1.466	32.00X24.00	10	DIN2174	6HX	C
MF-M42X4.50ISO6HX-XC-V055	03000299		M42	4,5	-	32,0 1.260	102,0 4.016	50,0 1.969	200,0 7.874	40,0 1.575	32.00X24.00	10	DIN2174	6HX	C
MF-M48X5.00ISO6HX-XC-V055	03000300		M48	5,0	-	36,0 1.417	147,0 5.787	60,0 2.362	250,0 9.843	45,8 1.803	36.00X29.00	12	DIN2174	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

## MF-V056

Forming holes



- With channels for lubrication
- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- \* With tip shape. More information: Suggest at [secotools.com](http://secotools.com)

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI										
MF-4-40UNC-XC-V056	03000306	*	UNC4-40	–	40.0	3,5 <i>0.138</i>	18,0 <i>0.709</i>	9,0 <i>0.354</i>	56,0 <i>2.205</i>	2,6 <i>0.102</i>	3.50X2.70	4	DIN2184-1	2BX	C
MF-6-32UNC-XC-V056	03000307	*	UNC6-32	–	32.0	4,0 <i>0.157</i>	20,0 <i>0.787</i>	11,0 <i>0.433</i>	56,0 <i>2.205</i>	3,2 <i>0.126</i>	4.00X3.00	4	DIN2184-1	2BX	C
MF-8-32UNC-XC-V056	03000308	*	UNC8-32	–	32.0	4,5 <i>0.177</i>	21,0 <i>0.827</i>	12,0 <i>0.472</i>	63,0 <i>2.480</i>	3,8 <i>0.150</i>	4.50X3.40	5	DIN2184-1	2BX	C
MF-10-24UNC-XC-V056	03000309	*	UNC10-24	–	24.0	6,0 <i>0.236</i>	25,0 <i>0.984</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	4,4 <i>0.173</i>	6.00X4.90	5	DIN2184-1	2BX	C
MF-12-24UNC-XC-V056	03000310	*	UNC12-24	–	24.0	6,0 <i>0.236</i>	30,0 <i>1.181</i>	14,0 <i>0.551</i>	80,0 <i>3.150</i>	5,0 <i>0.197</i>	6.00X4.90	5	DIN2184-1	2BX	C
MF-1/4-20UNC-XC-V056	03000311	*	UNC1/4-20	–	20.0	7,0 <i>0.276</i>	30,0 <i>1.181</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,8 <i>0.228</i>	7.00X5.50	5	DIN2184-1	2BX	C
MF-5/16-18UNC-XC-V056	03000312	*	UNC5/16-18	–	18.0	8,0 <i>0.315</i>	35,0 <i>1.378</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	7,3 <i>0.287</i>	8.00X6.20	5	DIN2184-1	2BX	C
MF-3/8-16UNC-XC-V056	03000313	*	UNC3/8-16	–	16.0	10,0 <i>0.394</i>	39,0 <i>1.535</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	8,8 <i>0.346</i>	10.00X8.00	5	DIN2184-1	2BX	C
MF-7/16-14UNC-XC-V056	03000314		UNC7/16-14	–	14.0	8,0 <i>0.315</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	10,3 <i>0.406</i>	8.00X6.20	5	DIN2184-1	2BX	C
MF-1/2-13UNC-XC-V056	03000315		UNC1/2-13	–	13.0	9,0 <i>0.354</i>	83,0 <i>3.268</i>	23,0 <i>0.906</i>	110,0 <i>4.331</i>	11,9 <i>0.469</i>	9.00X7.00	6	DIN2184-1	2BX	C
MF-5/8-11UNC-XC-V056	03000316		UNC5/8-11	–	11.0	12,0 <i>0.472</i>	68,0 <i>2.677</i>	25,0 <i>0.984</i>	110,0 <i>4.331</i>	14,85 <i>0.585</i>	12.00X9.00	6	DIN2184-1	2BX	C
MF-3/4-10UNC-XC-V056	03000317		UNC3/4-10	–	10.0	14,0 <i>0.551</i>	81,0 <i>3.189</i>	30,0 <i>1.181</i>	125,0 <i>4.921</i>	17,93 <i>0.706</i>	14.00X11.00	7	DIN2184-1	2BX	C
MF-7/8-9UNC-XC-V056	03000318		UNC7/8-9	–	9.0	18,0 <i>0.709</i>	93,0 <i>3.661</i>	34,0 <i>1.339</i>	140,0 <i>5.512</i>	20,98 <i>0.826</i>	18.00X14.50	7	DIN2184-1	2BX	C
MF-1-8UNC-XC-V056	03000319		UNC1-8	–	8.0	18,0 <i>0.709</i>	113,0 <i>4.449</i>	38,0 <i>1.496</i>	160,0 <i>6.299</i>	24,0 <i>0.945</i>	18.00X14.50	8	DIN2184-1	2BX	C

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Thread turning

Thread MDT

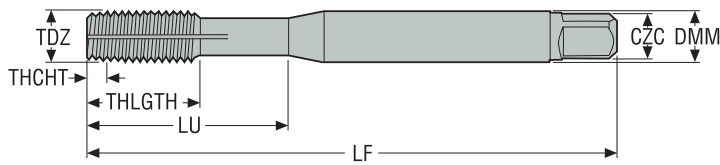
Thread Mini-Shaft™

Rotating threading

Annex

# MF-V057

Forming holes



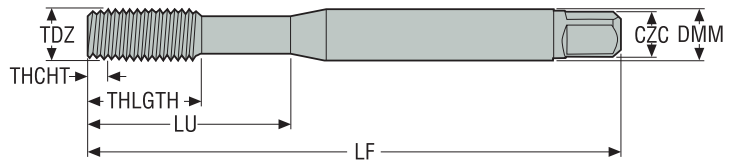
- With channels for lubrication
- For cutting data see page(s) 252
- Coating: TiN
- \* With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI										
MF-10-32UNF-XC-V057	03000320	*	UNF10-32	–	32.0	6,0 0.236	25,0 0.984	13,0 0.512	70,0 2.756	4,5 0.177	6.00X4.90	5	DIN2184-1	2BX	C
MF-1/4-28UNF-XC-V057	03000321	*	UNF1/4-28	–	28.0	7,0 0.276	30,0 1.181	15,0 0.591	80,0 3.150	6,0 0.236	7.00X5.50	5	DIN2184-1	2BX	C
MF-5/16-24UNF-XC-V057	03000322	*	UNF5/16-24	–	24.0	8,0 0.315	35,0 1.378	18,0 0.709	90,0 3.543	7,5 0.295	8.00X6.20	5	DIN2184-1	2BX	C
MF-3/8-24UNF-XC-V057	03000323	*	UNF3/8-24	–	24.0	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	9,1 0.358	10.00X8.00	5	DIN2184-1	2BX	C
MF-7/16-20UNF-XC-V057	03000324		UNF7/16-20	–	20.0	8,0 0.315	77,0 3.031	20,0 0.787	100,0 3.937	10,6 0.417	8.00X6.20	5	DIN2184-1	2BX	C
MF-1/2-20UNF-XC-V057	03000325		UNF1/2-20	–	20.0	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	12,1 0.476	9.00X7.00	6	DIN2184-1	2BX	C
MF-5/8-18UNF-XC-V057	03000326		UNF5/8-18	–	18.0	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	15,25 0.600	12.00X9.00	6	DIN2184-1	2BX	C
MF-3/4-16UNF-XC-V057	03000327		UNF3/4-16	–	16.0	14,0 0.551	81,0 3.189	30,0 1.181	125,0 4.921	18,35 0.722	14.00X11.00	7	DIN2184-1	2BX	C
MF-1-12UNF-XC-V057	03000328		UNF1-12	–	12.0	18,0 0.709	113,0 4.449	38,0 1.496	160,0 6.299	24,46 0.963	18.00X14.50	8	DIN2184-1	2BX	C

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## MF-V058

Forming holes



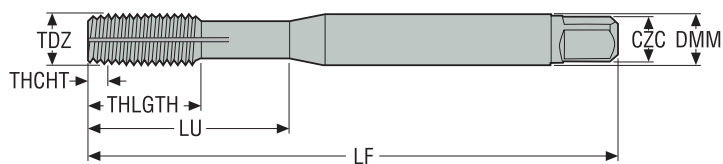
- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- \* With tip shape. More information: Suggest at [secotools.com](http://secotools.com)

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MF-M3X0.50ISO6GX-XC-V058	02880475	*	M3	0,5	–	3,5 0.138	18,0 0.709	9,0 0.354	56,0 2.205	2,8 0.110	3.50X2.70	4	DIN2174	6GX	C
MF-M3.5X0.60ISO6GX-XC-V058	02880476	*	M3.5	0,6	–	4,0 0.157	20,0 0.787	11,0 0.433	56,0 2.205	3,2 0.126	4.00X3.00	4	DIN2174	6GX	C
MF-M4X0.70ISO6GX-XC-V058	02880477	*	M4	0,7	–	4,5 0.177	21,0 0.827	12,0 0.472	63,0 2.480	3,7 0.146	4.50X3.40	5	DIN2174	6GX	C
MF-M5X0.80ISO6GX-XC-V058	02880478	*	M5	0,8	–	6,0 0.236	25,0 0.984	13,0 0.512	70,0 2.756	4,65 0.183	6.00X4.90	5	DIN2174	6GX	C
MF-M6X1.00ISO6GX-XC-V058	02880479	*	M6	1,0	–	6,0 0.236	30,0 1.181	15,0 0.591	80,0 3.150	5,55 0.219	6.00X4.90	5	DIN2174	6GX	C
MF-M8X1.25ISO6GX-XC-V058	02880480		M8	1,25	–	8,0 0.315	35,0 1.378	18,0 0.709	90,0 3.543	7,45 0.293	8.00X6.20	5	DIN2174	6GX	C
MF-M10X1.50ISO6GX-XC-V058	02880481		M10	1,5	–	10,0 0.394	39,0 1.535	20,0 0.787	100,0 3.937	9,35 0.368	10.00X8.00	5	DIN2174	6GX	C
MF-M12X1.75ISO6GX-XC-V058	02880482	*	M12	1,75	–	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	11,2 0.441	9.00X7.00	5	DIN2174	6GX	C

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# MF-V059

Forming holes



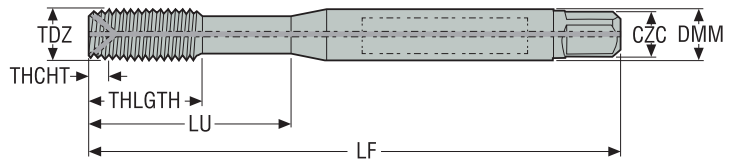
- With channels for lubrication
- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- \* With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>	mm <i>Inch</i>					
MF-1/8-28G-XC-V059	03000301	*	G1/8-28	-	28.0	7,0 <i>0.276</i>	67,0 <i>2.638</i>	20,0 <i>0.787</i>	90,0 <i>3.543</i>	9,3 <i>0.366</i>	7.00X5.50	5	DIN2189	NOR-MAL-X	C
MF-1/4-19G-XC-V059	03000302		G1/4-19	-	19.0	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	12,5 <i>0.492</i>	11.00X9.00	6	DIN2189	NOR-MAL-X	C
MF-3/8-19G-XC-V059	03000303		G3/8-19	-	19.0	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	16,0 <i>0.630</i>	12.00X9.00	6	DIN2189	NOR-MAL-X	C
MF-1/2-14G-XC-V059	03000304		G1/2-14	-	14.0	16,0 <i>0.630</i>	80,0 <i>3.150</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	20,0 <i>0.787</i>	16.00X12.00	7	DIN2189	NOR-MAL-X	C
MF-5/8-14G-XC-V059	03000305		G5/8-14	-	14.0	18,0 <i>0.709</i>	78,0 <i>3.071</i>	24,0 <i>0.945</i>	125,0 <i>4.921</i>	22,0 <i>0.866</i>	18.00X14.50	7	DIN2189	NOR-MAL-X	C

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## MF-V060-A

Forming holes



- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- Internal coolant

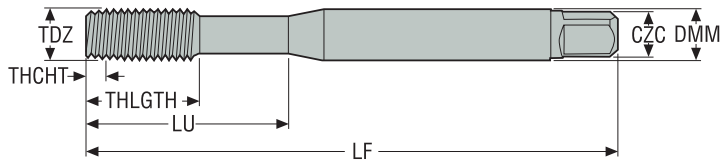
Designation	Item number	TDZ	Pitch	DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm TPI	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch					
MF-M5X0.80ISO6HX-XC-V060-A	02880483	M5	0,8 –	6,0 0.236	21,0 0.827	13,0 0.512	70,0 2.756	4,65 0.183	6.00X4.90	5	DIN2174	6HX	C
MF-M6X1.00ISO6HX-XC-V060-A	02880484	M6	1,0 –	6,0 0.236	26,0 1.024	15,0 0.591	80,0 3.150	5,55 0.219	6.00X4.90	5	DIN2174	6HX	C
MF-M8X1.25ISO6HX-XC-V060-A	02880485	M8	1,25 –	8,0 0.315	30,0 1.181	18,0 0.709	90,0 3.543	7,45 0.293	8.00X6.20	5	DIN2174	6HX	C
MF-M10X1.50ISO6HX-XC-V060-A	02880486	M10	1,5 –	10,0 0.394	33,0 1.299	20,0 0.787	100,0 3.937	9,35 0.368	10.00X8.00	5	DIN2174	6HX	C
MF-M12X1.75ISO6HX-XC-V060-A	02880487	M12	1,75 –	9,0 0.354	83,0 3.268	23,0 0.906	110,0 4.331	11,2 0.441	9.00X7.00	5	DIN2174	6HX	C
MF-M14X2.00ISO6HX-XC-V060-A	03000329	M14	2,0 –	11,0 0.433	81,0 3.189	25,0 0.984	110,0 4.331	13,1 0.516	11.00X9.00	6	DIN2174	6HX	C
MF-M16X2.00ISO6HX-XC-V060-A	03000330	M16	2,0 –	12,0 0.472	68,0 2.677	25,0 0.984	110,0 4.331	15,1 0.594	12.00X9.00	6	DIN2174	6HX	C
MF-M18X2.50ISO6HX-XC-V060-A	03000331	M18	2,5 –	14,0 0.551	81,0 3.189	30,0 1.181	125,0 4.921	16,9 0.665	14.00X11.00	7	DIN2174	6HX	C
MF-M20X2.50ISO6HX-XC-V060-A	03000332	M20	2,5 –	16,0 0.630	95,0 3.740	30,0 1.181	140,0 5.512	18,9 0.744	16.00X12.00	7	DIN2174	6HX	C
MF-M22X2.50ISO6HX-XC-V060-A	03000333	M22	2,5 –	18,0 0.709	93,0 3.661	34,0 1.339	140,0 5.512	20,9 0.823	18.00X14.50	7	DIN2174	6HX	C
MF-M24X3.00ISO6HX-XC-V060-A	03000334	M24	3,0 –	18,0 0.709	113,0 4.449	38,0 1.496	160,0 6.299	22,65 0.892	18.00X14.50	8	DIN2174	6HX	C
MF-M27X3.00ISO6HX-XC-V060-A	03000335	M27	3,0 –	20,0 0.787	97,0 3.819	38,0 1.496	160,0 6.299	25,65 1.010	20.00X16.00	8	DIN2174	6HX	C
MF-M30X3.50ISO6HX-XC-V060-A	03000336	M30	3,5 –	22,0 0.866	115,0 4.528	45,0 1.772	180,0 7.087	28,45 1.120	22.00X18.00	10	DIN2174	6HX	C
MF-M33X3.50ISO6HX-XC-V060-A	03000337	M33	3,5 –	25,0 0.984	113,0 4.449	50,0 1.969	180,0 7.087	31,45 1.238	25.00X20.00	10	DIN2174	6HX	C
MF-M36X4.00ISO6HX-XC-V060-A	03000338	M36	4,0 –	28,0 1.102	131,0 5.157	55,0 2.165	200,0 7.874	34,23 1.348	28.00X22.00	10	DIN2174	6HX	C
MF-M39X4.00ISO6HX-XC-V060-A	03000339	M39	4,0 –	32,0 1.260	102,0 4.016	60,0 2.362	200,0 7.874	37,23 1.466	32.00X24.00	10	DIN2174	6HX	C
MF-M42X4.50ISO6HX-XC-V060-A	03000340	M42	4,5 –	32,0 1.260	102,0 4.016	60,0 2.362	200,0 7.874	40,0 1.575	32.00X24.00	10	DIN2174	6HX	C
MF-M48X5.00ISO6HX-XC-V060-A	03000341	M48	5,0 –	36,0 1.417	147,0 5.787	60,0 2.362	250,0 9.843	45,8 1.803	36.00X29.00	12	DIN2174	6HX	C

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MF-V063

Forming holes



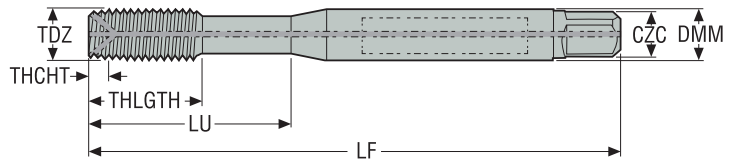
- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- \* With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI										
MF-M5X0.50ISO6HX-XC-V063	02880488	*	MF5X0.5	0,5	-	6,0 0.236	25,0 0.984	13,0 0.512	70,0 2.756	4,8 0.189	6.00X4.90	5	DIN2174	6HX	C
MF-M6X0.75ISO6HX-XC-V063	02880489	*	MF6X0.75	0,75	-	6,0 0.236	30,0 1.181	15,0 0.591	80,0 3.150	5,65 0.222	6.00X4.90	5	DIN2174	6HX	C
MF-M7X0.75ISO6HX-XC-V063	02880490	*	MF7X0.75	0,75	-	7,0 0.276	30,0 1.181	15,0 0.591	80,0 3.150	6,65 0.262	7.00X5.50	5	DIN2174	6HX	C
MF-M8X0.75ISO6HX-XC-V063	02880491		MF8X0.75	0,75	-	6,0 0.236	57,0 2.244	18,0 0.709	80,0 3.150	7,65 0.301	6.00X4.90	5	DIN2174	6HX	C
MF-M8X1.00ISO6HX-XC-V063	02880492		MF8X1.0	1,0	-	6,0 0.236	67,0 2.638	18,0 0.709	90,0 3.543	7,55 0.297	6.00X4.90	5	DIN2174	6HX	C
MF-M10X1.00ISO6HX-XC-V063	02880493		MF10X1.0	1,0	-	7,0 0.276	75,0 2.953	20,0 0.787	100,0 3.937	9,55 0.376	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.25ISO6HX-XC-V063	02880494		MF10X1.25	1,25	-	7,0 0.276	75,0 2.953	20,0 0.787	100,0 3.937	9,45 0.372	7.00X5.50	5	DIN2174	6HX	C
MF-M12X1.00ISO6HX-XC-V063	02880495	*	MF12X1.0	1,0	-	9,0 0.354	73,0 2.874	23,0 0.906	100,0 3.937	11,55 0.455	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.25ISO6HX-XC-V063	02880496	*	MF12X1.25	1,25	-	9,0 0.354	73,0 2.874	23,0 0.906	100,0 3.937	11,45 0.451	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.50ISO6HX-XC-V063	02880497	*	MF12X1.5	1,5	-	9,0 0.354	73,0 2.874	23,0 0.906	100,0 3.937	11,35 0.447	9.00X7.00	5	DIN2174	6HX	C
MF-M14X1.00ISO6HX-XC-V063	02880498		MF14X1.0	1,0	-	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	13,55 0.533	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.25ISO6HX-XC-V063	02880499		MF14X1.25	1,25	-	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	13,45 0.530	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.50ISO6HX-XC-V063	02880500		MF14X1.5	1,5	-	11,0 0.433	71,0 2.795	21,0 0.827	100,0 3.937	13,35 0.526	11.00X9.00	6	DIN2174	6HX	C
MF-M16X1.50ISO6HX-XC-V063	02880501		MF16X1.5	1,5	-	12,0 0.472	58,0 2.283	21,0 0.827	100,0 3.937	15,35 0.604	12.00X9.00	6	DIN2174	6HX	C

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## MF-V063-A

Forming holes



- For cutting data see page(s) 252
- Coating: TiN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI										
MF-M5X0.50ISO6HX-XC-V063-A	03000342	MF5X0.5	0,5	–	6,0 <i>0.236</i>	25,0 <i>0.984</i>	13,0 <i>0.512</i>	70,0 <i>2.756</i>	4,8 <i>0.189</i>	6.00X4.90	5	DIN2174	6HX	C
MF-M6X0.75ISO6HX-XC-V063-A	03000343	MF6X0.75	0,75	–	6,0 <i>0.236</i>	30,0 <i>1.181</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	5,65 <i>0.222</i>	6.00X4.90	5	DIN2174	6HX	C
MF-M8X0.75ISO6HX-XC-V063-A	03000344	MF8X0.75	0,75	–	6,0 <i>0.236</i>	57,0 <i>2.244</i>	15,0 <i>0.591</i>	80,0 <i>3.150</i>	7,65 <i>0.301</i>	6.00X4.90	5	DIN2174	6HX	C
MF-M8X1.00ISO6HX-XC-V063-A	03000345	MF8X1.0	1,0	–	6,0 <i>0.236</i>	67,0 <i>2.638</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	7,55 <i>0.297</i>	6.00X4.90	5	DIN2174	6HX	C
MF-M10X0.75ISO6HX-XC-V063-A	03000346	MF10X0.75	0,75	–	7,0 <i>0.276</i>	67,0 <i>2.638</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	9,65 <i>0.380</i>	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.00ISO6HX-XC-V063-A	03000347	MF10X1.0	1,0	–	7,0 <i>0.276</i>	67,0 <i>2.638</i>	18,0 <i>0.709</i>	90,0 <i>3.543</i>	9,55 <i>0.376</i>	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.25ISO6HX-XC-V063-A	03000349	MF10X1.25	1,25	–	7,0 <i>0.276</i>	77,0 <i>3.031</i>	20,0 <i>0.787</i>	100,0 <i>3.937</i>	9,45 <i>0.372</i>	7.00X5.50	5	DIN2174	6HX	C
MF-M12X1.00ISO6HX-XC-V063-A	03000350	MF12X1.0	1,0	–	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	11,55 <i>0.455</i>	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.25ISO6HX-XC-V063-A	03000351	MF12X1.25	1,25	–	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	11,45 <i>0.451</i>	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.50ISO6HX-XC-V063-A	03000352	MF12X1.5	1,5	–	9,0 <i>0.354</i>	73,0 <i>2.874</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	11,35 <i>0.447</i>	9.00X7.00	5	DIN2174	6HX	C
MF-M14X1.00ISO6HX-XC-V063-A	03000353	MF14X1.0	1,0	–	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	13,55 <i>0.533</i>	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.25ISO6HX-XC-V063-A	03000354	MF14X1.25	1,25	–	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	13,45 <i>0.530</i>	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.50ISO6HX-XC-V063-A	03000355	MF14X1.5	1,5	–	11,0 <i>0.433</i>	71,0 <i>2.795</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	13,35 <i>0.526</i>	11.00X9.00	6	DIN2174	6HX	C
MF-M16X1.00ISO6HX-XC-V063-A	03000356	MF16X1.0	1,0	–	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	15,55 <i>0.612</i>	12.00X9.00	6	DIN2174	6HX	C
MF-M16X1.50ISO6HX-XC-V063-A	03000357	MF16X1.5	1,5	–	12,0 <i>0.472</i>	58,0 <i>2.283</i>	21,0 <i>0.827</i>	100,0 <i>3.937</i>	15,35 <i>0.604</i>	12.00X9.00	6	DIN2174	6HX	C

Please check availability at [www.secotools.com](http://www.secotools.com) / Seco Online Store

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

## Steels, ferritic and martensitic stainless steels

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
P1	Free-cutting steels	$360 < R_m < 880$	11 SMn30 $R_m = 385 \text{ N/mm}^2$	1500	0,14
P2	Low-alloy ferritic steels, C < 0.25%wt Low-alloy weldable general structural steels	$320 < R_m < 600$	S235JRG2 $R_m = 420 \text{ N/mm}^2$	1600	0,23
P3	Ferritic & ferritic/pearlitic steels, C < 0.25%wt Weldable general structural steels Case-hardening steels	$430 < R_m < 610$	16 MnCr 5 $R_m = 550 \text{ N/mm}^2$	1800	0,14
P4	Low-alloy general structural steels, $0.25\% < C < 0.67\%$ wt Low-alloy Quench & Temper steels	$520 < R_m < 1200$	C 45E $R_m = 660 \text{ N/mm}^2$	2000	0,15
P5	Structural steels, $0.25\% < C < 0.67\%$ wt Quench & Temper steels	$550 < R_m < 1200$	42 CrMo 4 $R_m = 700 \text{ N/mm}^2$	2020	0,18
P6	Low-alloy through-hardening steels, C > 0.67%wt Low-alloy spring and bearing steels	$520 < R_m < 1200$	C 100S $R_m = 600 \text{ N/mm}^2$	2100	0,17
P7	Through-hardening steels, C > 0.67%wt Spring and bearing steels	$600 < R_m < 1200$	100 Cr 6 $R_m = 650 \text{ N/mm}^2$	2160	0,17
P8	Tool steels High Speed Steels (HSS)	$600 < R_m < 1200$	X 40 CrMoV 5 1 $R_m = 700 \text{ N/mm}^2$	2400	0,20
P11	Ferritic & martensitic stainless steels	$415 < R_m < 1200$	X 20 Cr 13 $R_m = 675 \text{ N/mm}^2$	2000	0,15
P12	Maraging and precipitation-hardening stainless steels	$500 < R_m < 1200$	X 5 CrNiCuNb 16 4 $R_m = 1100 \text{ N/mm}^2$	2100	0,17

## Free-cutting, austenitic and duplex stainless steels

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
M1	Free-cutting austenitic stainless steels		X 10 CrNiS 18 9	1700	0,14
M2	Low-alloy austenitic stainless steels		X 5 CrNi 18 10	1920	0,18
M3	Medium-alloy austenitic stainless steels		X 2 CrNiMo 18 14 3	2070	0,17
M4	High-alloy austenitic and duplex stainless steels		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Difficult high-alloy austenitic and duplex stainless steels		X 2 CrNiMoN 25 7 4	2510	0,13

## Cast irons

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
K1	Grey cast irons (GCI)		EN-GJL-250	930	0,32
K2	Compacted graphite irons (CGI)		EN-GJV-400	1000	0,35
K3	Malleable cast irons (MCI)		EN-GJMB-550-4	1050	0,37
K4	Nodular cast irons (SGI)		EN-GJS-500-7	1160	0,37
K5	Austempered ductile irons (ADI)		EN-GJS-1000-5		
K6	Austenitic lamellar cast irons		EN-GJLA-XNiCuCr15-6-2		
K7	Austenitic nodular cast irons		EN-GJSA-XNiMn23-4		

## Non-ferrous metals

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
N1	Aluminium alloys, Si < 9%		AW-7075		
N2	Aluminium alloys, 9% < Si < 16%		AC-44200 Si = 12%		
N3	Aluminium alloys, Si > 16%		AISI17Cu5		
N11	Copper alloys		CW614N	740	0,26

## Superalloys and titanium

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
S1	Iron-based superalloys		Discalloy		
S2	Cobalt-based superalloys		Stellite 21		
S3	Nickel-based superalloys		Inconel 718	2530	0,21
S11	Titanium, low alloyed, ( $\alpha$ )		Ti		
S12	Titanium, medium alloyed, ( $\alpha$ + $\beta$ )		TiAl6V4	1500	0,24
S13	Titanium, high alloyed, (near $\beta$ and $\beta$ )		Ti10V2Fe3Al		

## Hard materials

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
H3	Case-hardened steels	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Quenched & Tempered steels	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Quenched & Tempered steels Bearing steels	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Tool steels High Speed Steels (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Martensitic stainless steels	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Maraged and precipitation- hardened stainless steels	1200 < $R_m$ < 1650	X 5 CrNiCuNb 16 4 $R_m = 1450 \text{ N/mm}^2$	2410	0,17
H21	Manganese steels	23 < HRC < 64	X 120 Mn 12 50 HRC		
H31	White cast irons	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC		

## Other difficult materials

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
PM1	Low-alloy PM-materials		F-0008 Fe-0.7C		
PM2	Medium-alloy PM-materials		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C		
PM3	High-alloy PM-materials Exhaust valve seat materials, etc.				
HF1	Hardfacing alloys Welded or plasma-deposited iron-based alloys				
HF2	Hardfacing alloys Welded or plasma-deposited cobalt- and nickel-based alloys				
CC1	Sintered tungsten carbide		G50		

## Plastics and Composites

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
TS1	Thermosetting polymers		Urea formaldehyde (UF)		
TS2	Thermosetting carbon-fibre composites		T300 T700 T800 HTA-S IMA - Epoxy (M21)...		
TS3	Thermosetting glass-fibre composites		Epoxy - HX..(42..)E glass (7781...)...		
TS4	Thermosetting aramide-fibre composites		Kevlar 49		
TP1	Thermoplastic polymers		Polycarbonate (PC)		
TP2	Thermoplastic carbon-fibre composites		PPS/PEEK - T300..		
TP3	Thermoplastic glass-fibre composites		PPS/PEEK - E glass or A glass...		
TP4	Thermoplastic aramide-fibre composites				

## Graphite

SMG	Description	Properties	Reference	$k_{c1.1}$	$m_c$
GR1	Graphite		R 8500		

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P1	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
P2	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
			1.0401	C 15	37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22		050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
P3			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
P4	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
P5	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
P6			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCR 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCR 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
P6	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
		1.1663	C 125 W	Y2 120			SK 2			

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex



## SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
	1213				Annealed	
	12 L 13				Annealed	
	1108				Annealed	
	11 L 08				Annealed	
					Annealed	
	1140	40			Annealed	
	1146				Annealed	
	1215				Annealed	
	12 L 14				Annealed	
		16D			Annealed	
	A573 Grade 58	18kp	11 378		Annealed	
	A573 Grade 70	S14kP	11 448		Annealed	
	1010	10			Annealed	
F.1110	1015	15			Annealed	
	1020, 1023	20	12 024		Annealed	
		17G1S	11 523		Annealed	
F.1511	1015	15			Annealed	
F.1120	1025	25			Annealed	
					Annealed	
	A204 Grade A		15 020		Annealed	
	4520				Annealed	
	3310, 9314	20X2H4A	16 420		Annealed	
	4320		16 220		Annealed	
					Annealed	
F.1516	5115	12KHN2	14 220		Annealed	
		18HG			Annealed	
	5120	20KH	14 221		Annealed	
	5120 H	20KH			Annealed	
	A182-F11, A182-F12	12KHM	15 121		Annealed	
	A387 Grade 12 Cl. 2				Annealed	
F.155	A182-F22	12KH8	15 313		Annealed	
F.1130	1035	35	12 040		Annealed	
F.5110	1045	45	12 050		Annealed	
	1040	40	12 041		Annealed	
F.1150	1055	55			Annealed	
	1060	60	12 061		Annealed	
	1039	40G			Annealed	
	1330	30G2			Annealed	
F.1135	1035	35			Annealed	
F.1140	1045	45	12 050		Annealed	
F.1150	1064	60			Annealed	
	1060	60			Annealed	
F.144	9255	55S2			Annealed	
F.1250	4135	35KHM			Annealed	
F.5241	S1	5KHV2S			Annealed	
	L6	5KHNV			Annealed	
	5045				Annealed	
	3135				Quenched & Tempered	
	3435				Annealed	
	9840				Quenched & Tempered	
F.1280	4340	38H2N2MA	16 343		Annealed	
	5132	35KH			Quenched & Tempered	
	5140	40H	14 140		Quenched & Tempered	
F.1251	4130	20KHM	15 130		Quenched & Tempered	
F.1252	4142, 4140	38HM	15 142		Annealed	
F.1252	4142, 4140	38HM	15 142		Quenched & Tempered	
					Quenched & Tempered	
F.143	6150	50KHFA	15 260		Quenched & Tempered	
F.1740	A355 Cl. A				Annealed	
F.5103	1070	70			Annealed	
F.5117	1095				Annealed	
F.5118	W1	U10A			Annealed	
		U10			Annealed	
	W1	U13			Annealed	

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS	
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202	
			1.2510	100 MnCrW 4	90 MNCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501	
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502	
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986	
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403	
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811	
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813	
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T31012	
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810	
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2		2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU			2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4			T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55		2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWW 09-08-04	BM 42	HS 2-9-1-8	SKH 51			T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3			T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51		2722	T11302
HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWW 09-04-02-02		HS 2-9-2	SKH 58		2782	T11307	
HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2			T12001	
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008	
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000	
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000	
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000	
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280	
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002	
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003	
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004	
	X 3 CrNiMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5		2385	S41500
	X 18 CrNi 28	1.4749	1.4749	X 18 CrNi 28	Z 18 C 25					2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800	
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500	
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CUNb 16.4 M						S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500	
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400	
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400	
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700	
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4							K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09						K93120
	X 2 NiCoMo 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09						K93120
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162					K92890
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162					K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300	
	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403	
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400	
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600	
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CENN 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700	
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100	
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200	
	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603	
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653	
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453	
M3	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700	
	X 9 CrNiSiN 21 11 2	1.4835	1.4893	X 9 CrNiSiN 21 11 2		310 S 31			2368	S30815	
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008	
	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803	
M4	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500	
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904	
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900	
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286	
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254	
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654	
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800	
X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750		

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex

## SMG

U.N.E./I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
F.520L	L2	11KHF			Annealed	
F.5220	O1	9KHVG			Annealed	
	O2	9G2F			Annealed	
F.5230	52100	SHKH15	14 109		Annealed	
F.5212	D3	KH12			Annealed	
	H11	4KH5MFS			Annealed	
F.5318	H13	4KH5MF1S			Annealed	
F.5227	A2	9KH5VF			Annealed	
	H10	3KH3M3F			Annealed	
F.5213		KH12			Annealed	
		KH12MF			Annealed	
F.520.S	L6	5KHNM			Annealed	
F.5613	M35	R6M5K5			Annealed	
	M42	R2AM9K5			Annealed	
	T4	R18K5F2			Annealed	
F.5603	M2	R6M5			Annealed	
	M7				Annealed	
	T1	R18			Annealed	
	403	08KH13			Annealed	Ferritic
F.3401	410, CA-15	12KH13, 08KH13			Annealed	Martensitic
F.3113	430	12KH17			Annealed	Ferritic
F.5261	420	20KH13	17 022		Annealed	Martensitic
F.3404	420	40KH13			Annealed	Martensitic
	440 A				Annealed	Martensitic
	440 B	95KH18			Annealed	Martensitic
	440 C	95KH18			Annealed	Martensitic
	A182 F6NM			F6NM	Annealed	Martensitic
	446	15KH28			Annealed	Ferritic
	XM-13			PH 13-8 Mo	Solution annealed	Austenitic
	XM-12			15-5 PH	H1150	Martensitic
	XM-12			15-5 PH	Solution annealed	Martensitic
	XM-12			15-5 PH	H1025	Martensitic
	SAE 630			17-4 PH	H1150	Martensitic
	630			17-4 PH	Solution annealed	Martensitic
	631	09KH17N7YU1		17-7 PH	Solution annealed	Austenitic/Ferritic
	AMS 6515			Marage 350	Solution annealed	Martensitic
	AMS 6521			Marage 300	Solution annealed	Martensitic
	AMS 6514			Marage 300, Vascomax C300	Solution annealed	Martensitic
	AMS 6512			Marage 250	Solution annealed	Martensitic
	AMS 6512			Marage 250, Vascomax C250	Solution annealed	Martensitic
F.3508	303	12KH19N9			Annealed	Austenitic
F.3504	304 L	03KH18N11			Annealed	Austenitic
F.3504	304	08KH18N10	17 240		Annealed	Austenitic
F.3534	316	08KH17H13M2T	17 346		Annealed	Austenitic
F.3524	347	08KH18N12B			Annealed	Austenitic
F.3517	301	07KH16N6			Annealed	Austenitic
	302	12KH18N9			Annealed	Austenitic
F.3533	(316 L)	03KH17N14M3	17 349		Annealed	Austenitic
	316 LN	03KH16N15M3			Annealed	Austenitic
F.3541	304 LN	03KH18N11			Annealed	Austenitic
	317	08KH17H15M3T			Annealed	Austenitic
				253 MA	Annealed	Austenitic
	310 S	12KH25N20			Annealed	Austenitic
	329 LN			SAF 2205	Annealed	Duplex
				3RE60	Annealed	Duplex
	904L				Annealed	Super austenitic
	329				Annealed	Duplex
	660			A286	Solution annealed	Austenitic
				254 SMO	Annealed	Super austenitic
				654 SMO	Annealed	Super austenitic
				Alloy 800	Annealed	Austenitic
	F 53			SAF 2507	Annealed	Super duplex

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS	
K1	EN-GJL-150	0.6150	0.6150	GG-15	Fl 15 D	Grade 150	G15	FC 150	01 15-00	F11601	
	EN-GJL-200	0.6200	0.6200	GG-20	Fl 20 D	Grade 220	G20	FC 200	01 20-00	F12101	
	EN-GJL-250	0.6250	0.6250	GG-25	Fl 25 D	Grade 260	G25	FC 250	01 25-00	F12401	
	EN-GJL-350	0.6350	0.6350	GG-35	Fl 35 D	Grade 350	G35	FC 350	01 35-00	F13502	
K2	EN-GJL-215			GG-220 HB					02 19		
	EN-GJV-300			GJV-300							
	EN-GJV-350			GJV-350							
	EN-GJV-400			GJV-400							
	EN-GJV-450			GJV-450							
	EN-GJV-500			GJV-500							
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130	
K4	EN-GJS-350-22	0.7033	0.7033	GGG-35.3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15		
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800	
	EN-GJS-400-18	0.7043	0.7043	GGG-40.3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800	
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800	
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100	
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800	
K5	EN-GJS-1000-5			GJS-1000-5						ADI grade 5	
	EN-GJS-1200-2			GJS-1200-2						ADI grade 2	
	EN-GJS-1400-1			GJS-1400-1						ADI grade 3	
	EN-GJS-800-8			GJS-800-8						ADI grade 4	
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002	
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004	
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000	
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00		
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000	
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010	
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003	
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006	
N1	AW-1050A	Al99.5	3.0255	Al99.5	A-5/1050A	1B		(A1050)	4007	AA1050A	
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011	
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014	
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005	
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060	
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005	
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103	
	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003	
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020	
	AW-7075	AlZnMgCu1.5	3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075	
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244		
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800	
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600	
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)						
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE					M12330
	N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
AC-44200		AlSi12	3.2382	GD-AlSi12							
AW-6082		AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082	
N3	AlSi17Cu5						ADC14				
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200	
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500	
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600	
				CuNi10Zn45							
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1						C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700	
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700	
			2.1087	CuSn10Zn					5458	C90500	
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900	
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000	
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn28Sn1				5220	C44300	
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200	
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400	
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500	
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800	
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700	

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex



SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS	
S1											
S2											
S3	NiMo30		2.4810							N10002	
	NiMo16Cr15W		2.4819							N10276	
	NiCr19Fe19Nb5Mo3		2.4668							N07718	
			2.4669							N07750	
	NiCr20TiAl		2.4631							N07080	
	NiCr19Co18Mo4Ti3Al3									N07500	
	NiCr20Co13Mo4Ti3Al		2.4654							N07001	
S11			3.7024							R54620	
S12										R56320	
	TiAl6V4		3.7164							R56400	
S13				TiV10Fe2Al3							
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170	
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700	
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780	
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950	
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880		
			1.2550	60 WCv 7	55 WC 20		55 WCv 8 KU				
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550	
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400	
	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202	
H7			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501	
		1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502	
		1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986	
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813	
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102	
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402	
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2		2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoV 12 KU			2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4			T61206
		HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCVV 09-08-	BM 42	HS 2-9-1-8	SKH 51		T11342	
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001	
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000	
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002	
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003	
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004	
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500	
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400	
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400	
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700	
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700	
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286	
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890	
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120	
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120	
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160	
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183		
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001	
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000	
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003	

Thread turning

Thread MDT

Thread Mini-Start™

Rotating threading

Annex

## SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
				Discalloy	Precipitation hardened	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel X-750	Solution annealed	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	Commercially pure	Ti (α)
	AMS 4919			Ti 6-2-4-2	Annealed	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	Annealed	Ti (α+β)
	AMS 4920, Grade 5	VT6		Ti 6Al-4V	Annealed	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	Annealed	Ti (β)
F.1516	5115	12KHN2	14 220		Case hardened	
F.5103	1070	70			Quenched & Tempered	
F.5107	1078, 1080	75			Quenched & Tempered	
F.5117	1095				Quenched & Tempered	
F.5118	W1	U10A			Quenched & Tempered	
	S1	5KHV2SF			Quenched & Tempered	
	5155				Quenched & Tempered	
F.1252	4142, 4140	38HM	15 142		Quenched & Tempered	
F.520L	L2	11KHF			Quenched & Tempered	
F.5220	O1	9KHVG			Quenched & Tempered	
	O2	9G2F			Quenched & Tempered	
F.5230	52100	SHKH15	14 109		Quenched & Tempered	
F.5318	H13	4KH5MF1S			Quenched & Tempered	
F.5227	A2	9KH5VF			Quenched & Tempered	
F.5211	D2	KH12MF			Quenched & Tempered	
F.5213		KH12			Quenched & Tempered	
		KH12MF			Quenched & Tempered	
F.520.S	L6	5KHNM			Quenched & Tempered	
F.5613	M35	R6M5K5			Quenched & Tempered	
	M42	R2AM9K5			Quenched & Tempered	
	T1	R18			Quenched & Tempered	
F.5261	420	20KH13	17 022		Quenched & Tempered	Martensitic
	440 A				Quenched & Tempered	Martensitic
	440 B	95KH18			Quenched & Tempered	Martensitic
	440 C	95KH18			Quenched & Tempered	Martensitic
	XM-12			15-5 PH	H900	Martensitic
	SAE 630			17-4 PH	H1025	Martensitic
	SAE 630			17-4 PH	H900	Martensitic
	AMS 5528	09KH17N7YU1		17-7 PH	TH1050	Martensitic
	632			PH 15-7 Mo	TH1050	Martensitic
	660			A286	Precipitation hardened	Austenitic
	AMS 6512			Marage 250	Precipitation hardened	Martensitic
	AMS 6521			Marage 300	Precipitation hardened	Martensitic
	AMS 6521			Marage 300	Precipitation hardened	Martensitic
	AMS 6515			Marage 350	Precipitation hardened	Martensitic
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC)			Ni-Hard 2		White cast iron
	A532 IA (NiCr-HC)			Ni-Hard 1		White cast iron
	A532 ID (Ni-HiCr)			Ni-Hard 4		White cast iron

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

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### Cemented carbide inserts and insert carriers

Cemented carbide inserts and cemented carbide insert carriers from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.

These products meet all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.

Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations.

**Regrinding:**

Wet or dry grinding can produce potentially hazardous dusts or mists that can irritate skin, eyes, nose, throat and result in lung damage or disease. To avoid injury use proper safety precautions and protective equipment.

**Disposal:**

Seco Tools will buy back used inserts and solid carbide tools for recycling. Inserts and solid carbide tools should be separated from other metal waste (steel, aluminium, copper etc).

All packing material is fully recyclable.

### CBN and PCD inserts

Inserts from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.

This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.

Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations.

**Regrinding:**

Wet or dry grinding can produce potentially hazardous dusts or mists that can irritate skin, eyes, nose, throat and result in lung damage or disease. To avoid injury use proper safety precautions and protective equipment.

**Disposal:**

Seco Tools will buy back used CBN- or PCD-tipped inserts for recycling. Inserts should be separated from other metal waste (steel, aluminium, copper etc). Solid CBN-inserts may be discarded as landfill waste.

All packing material is fully recyclable.

### Black oxide insert carriers

Insert carriers from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.

This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.

Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations.

**Disposal:**

Used insert carriers may be sent for recycling together with ordinary steel waste (swarf and discarded steel scrap) for recycling.

All packing material is fully recyclable.



## Cermet inserts

Inserts from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.

This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.

Cermet grade C15M inserts do contain nickel and will leach nickel when in contact with the skin. Amount of leaching is higher than specified in norm SS-EN 1811 Reference test method for release of nickel from products intended to come into direct and prolonged contact with the skin. These norms are intended for products that are in direct and prolonged contact with the skin and are therefore not directly applicable for cermet inserts. Persons with known allergic reactions to nickel are advised to wear protective gloves when handling cermet inserts.

### Regrinding:

Wet or dry grinding can produce potentially hazardous dusts or mists that can irritate skin, eyes, nose, throat and result in lung damage or disease. To avoid injury use proper safety precautions and protective equipment.

### Disposal:

Used inserts may be recycled. Inserts should be separated from other metal waste (steel, aluminium, copper, etc) including cemented carbide inserts. All packing material is fully recyclable.

## Nickel coated insert carriers

Insert carriers from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.

This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.

Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations. Insert carriers do contain nickel and will leach nickel when in contact with the skin. Amount of leaching is not higher than norm SS-EN 1811 Reference test method for release of nickel from products intended to come into direct and prolonged contact with the skin.

These norms are intended for products that are in direct and prolonged contact with the skin and are therefore not directly applicable for insert carriers. Persons with known allergic reactions to nickel are advised to wear protective gloves when handling nickel coated insert carriers.

### Disposal:

Used tools maybe sent for recycling together with ordinary steel waste (swarf and discarded steel scrap) for recycling. All packing material is fully recyclable.

## Intentionally added alloying elements

Grade	Cemented carbide											Coating						
	W	Ti	Ta	Nb	Co	Cr	Ni	Mo	C	N	Ru	Ti	Al	C	N	O	Si	Nb
CP20	■				■				■			■			■			
CP200	■				■	■			■			■	■		■			
CP300	■	■	■	■	■				■			■	■		■			
CP500	■				■	■			■			■	■		■			
CP600	■				■	■			■			■	■		■			
C15M	■	■	■	■	■		■	■	■									
CF	■				■		■		■									
CM	■				■		■		■									
DP2000	■				■				■			■		■	■	■		
DP3000	■	■	■	■	■				■			■		■	■	■		
DS2050	■				■	■			■			■		■	■			
DS4050	■				■	■			■			■		■	■			■
F15M	■				■	■			■			■		■	■			
F25M	■	■	■	■	■	■			■			■		■	■			
F30M	■				■	■			■			■		■	■			
F40M	■				■	■			■			■		■	■			
HX	■		■		■				■			■		■	■			
H02	■		■		■				■			■		■	■			
H15	■				■				■			■		■	■			
H25	■				■				■			■		■	■			
KX	■				■				■			■		■	■			
MH1000	■				■				■			■	■		■			
MK1500	■		■		■				■			■	■	■	■	■		
MK2050	■		■		■				■			■	■	■	■		■	
MM4500	■				■				■			■	■	■	■	■		
MP1501	■		■	■	■				■		■	■	■	■	■	■	■	
MP2050	■				■				■			■	■	■	■	■	■	
MP2501	■		■	■	■				■			■	■	■	■	■	■	
MP3000	■				■	■			■			■	■	■	■	■	■	
MS2500	■		■	■	■				■			■	■	■	■	■	■	
MS2050	■				■				■			■	■	■	■	■	■	
RX1500	■		■		■		■	■	■			■	■	■	■	■	■	■
RX2000	■		■		■				■			■	■	■	■	■	■	
RM2020	■				■				■			■	■	■	■	■	■	
RM2090	■				■				■			■	■	■	■	■	■	
RN2010	■				■				■			■	■	■	■	■	■	
RS2090	■				■				■			■	■	■	■	■	■	
T350M	■		■	■	■				■			■	■	■	■	■	■	
T25M	■		■	■	■				■			■	■	■	■	■	■	
TGH1050	■				■	■			■			■	■	■	■	■	■	
TGK1500	■				■				■			■	■	■	■	■	■	
TGP25	■	■	■	■	■				■			■	■	■	■	■	■	
TGP35	■		■	■	■				■			■	■	■	■	■	■	
TGP45	■		■	■	■				■			■	■	■	■	■	■	
TH1000	■				■				■			■	■	■	■	■	■	
TH1500	■				■				■			■	■	■	■	■	■	
TK0501	■				■				■			■	■	■	■	■	■	
TK1501	■				■				■			■	■	■	■	■	■	
TM1501	■	■	■	■	■				■			■	■	■	■	■	■	
TM2000	■	■	■	■	■				■			■	■	■	■	■	■	
TM2501	■	■	■	■	■				■			■	■	■	■	■	■	
TM3501	■				■				■			■	■	■	■	■	■	
TM4000	■				■				■			■	■	■	■	■	■	
TP0501	■	■	■	■	■				■			■	■	■	■	■	■	
TP1020	■	■	■	■	■				■			■	■	■	■	■	■	
TP1030	■	■	■	■	■				■			■	■	■	■	■	■	
TP1501	■	■	■	■	■				■			■	■	■	■	■	■	
TP25	■	■	■	■	■				■			■	■	■	■	■	■	
TP200	■	■	■	■	■				■			■	■	■	■	■	■	
TP2501	■	■	■	■	■				■			■	■	■	■	■	■	
TP3501	■	■	■	■	■				■			■	■	■	■	■	■	
TP40	■		■	■	■				■			■	■	■	■	■	■	
TS2000	■				■				■			■	■	■	■	■	■	
TS2050	■				■				■			■	■	■	■	■	■	
TS2500	■		■		■				■			■	■	■	■	■	■	
T250D	■				■				■			■	■	■	■	■	■	
T400D	■				■				■			■	■	■	■	■	■	
T100R	■		■		■				■			■	■	■	■	■	■	
T60M	■	■	■	■	■				■			■	■	■	■	■	■	
883	■		■		■				■			■	■	■	■	■	■	
890	■				■	■			■			■	■	■	■	■	■	

Thread turning

Thread MDT

Thread Mini-Shaft™

Rotating threading

Annex

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