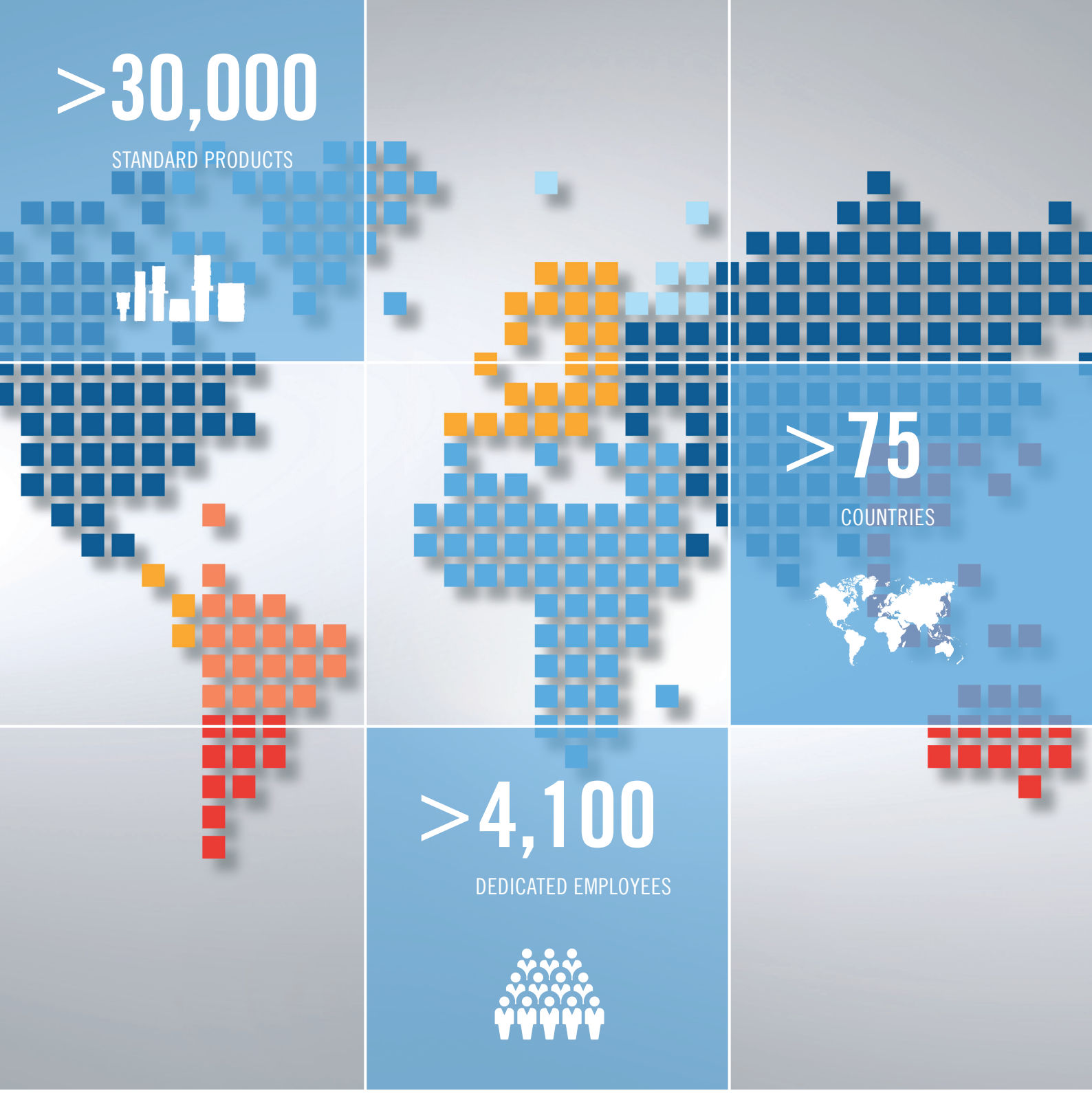
CATALOG & TECHNICAL GUIDE 2020.2

THREADING

SECO



Headquartered in Fagersta, Sweden and present in more than 75 countries, Seco Tools is a leading global provider of metal cutting solutions for milling, stationary tools, holemaking and tooling systems.

For more than 80 years, the company has provided the technologies, processes and support that manufacturers depend on for maximum productivity and profitability. For more information on how Seco's innovative products and expert services bring success to manufacturers across all industry segments, please visit www.secotools.com.

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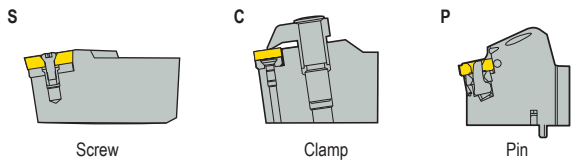
Code keys

Toolholders

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

1. Insert clamping



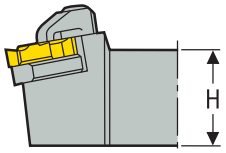
2. External/Internal

E = External
N = Internal

3. Cutting direction

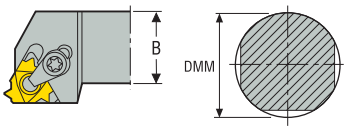
X = Special

4. Shank height



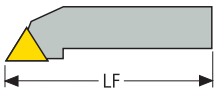
00 = Round toolholders S & C
25 = 25 mm (0.984")
32 = 32 mm (1.260")
etc.

5. Shank width/diameter



20 = 20 mm (0.787")
25 = 25 mm (0.984")
etc.

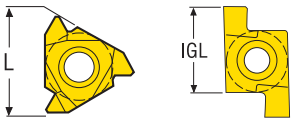
6. Tool length



H = 100 mm (3.937")
K = 125 mm (4.921")
L = 140 mm (5.512")
M = 150 mm (5.906")
P = 170 mm (6.693")

Q = 180 mm (7.087")
R = 200 mm (7.874")
S = 250 mm (9.843")
T = 300 mm (11.811")
U = 350 mm (13.780")
V = 400 mm (15.748")

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

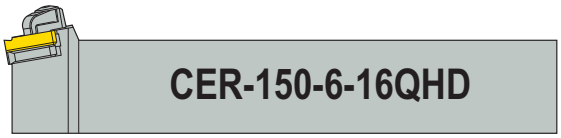
8. Other information

A = Steel with coolant passage
Q = Toolholder/cranked
CQ = For mounting upside down

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

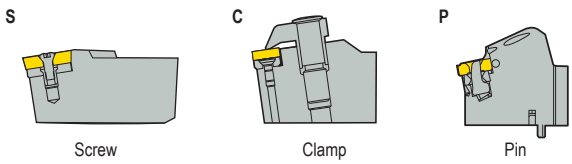
Code keys

Toolholders



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

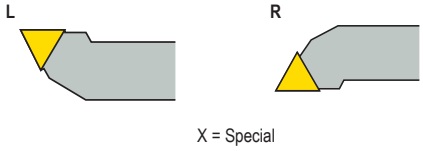
1. Insert clamping



2. External/Internal

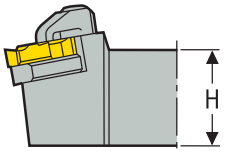
E = External
N = Internal

3. Cutting direction



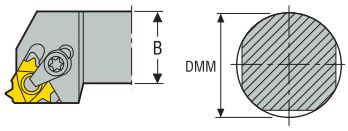
X = Special

4. Shank definition



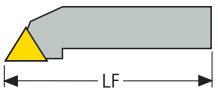
00 = Boring bars
= Square shanks

5. Square shank height/width and bar diameter



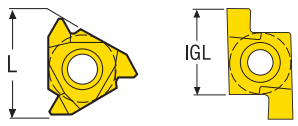
For square shank tools height and width in inches.
For boring bars bar diameter in inches.
075 = 0.75
100 = 1.00
125 = 1.25
etc.

6. Tool length



3 = 3 inches
4 = 4 inches
5 = 5 inches
6 = 6 inches

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

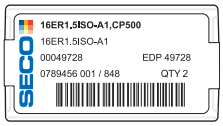
8. Other information

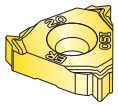
A = Steel with coolant passage
Q = Qualified
CQ = For mounting upside down

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

Code keys

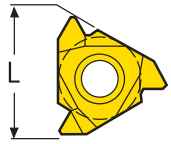
Inserts





16	E	R	1.5	ISO	-	A1
1	2	3	4	5		6

1. Cutting edge length



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

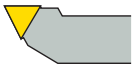
If the cutting edge length consists of only one digit, the designation should start with a 0.

2. External/Internal

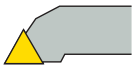
E = External
N = Internal

3. Cutting direction

L



R



X = Special

4. Pitch

Full profile mm: (mm)	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	
Full profile: (TPI)	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	

Partial profile:	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

5. Number of teeth per cutting edge/ Type of chipbreaker

2M = 2 teeth
3M = 3 teeth
TT = TWIN THREADER

A = Universal
A1 = Chipbreaker designation
A2 = Chipbreaker designation

6. Thread

Thread =	
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

Selection process

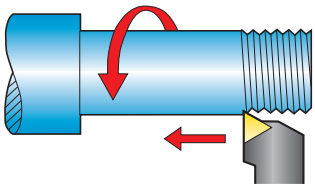
Seco Suggest

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.

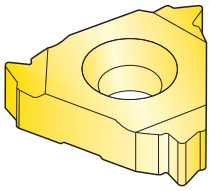
The application can be found at https://www.secotools.com/dashboard/Suggest/Suggest.

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

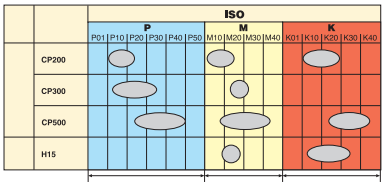
1. Selection of production method, page 9.



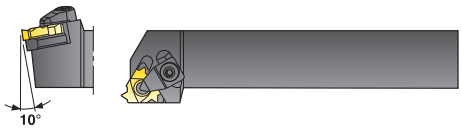
2. Selection of insert type, page 10.



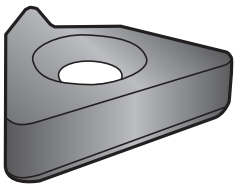
3. Selection of grade, page 11.



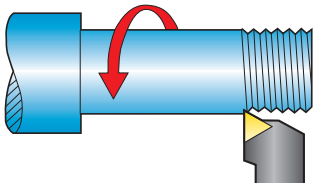
4. Selection of toolholder, page 13.



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



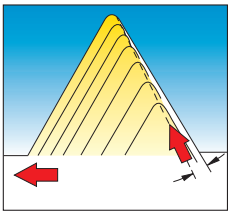
6. Selection of cutting speed, pages 16-20.



7. Selection of number of passes and infeed depths, pages 21-32.

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
Tot. inf. depth (mm)	3.83	3.52	3.19	2.87	2.53	2.23	1.92	1.60	1.25	1.13	0.93	0.81	0.65	0.48	0.33
Pass 1 (mm)	0.46	0.43	0.41	0.37	0.34	0.34	0.28	0.27	0.24	0.22	0.22	0.21	0.18	0.16	0.11
2	0.43	0.40	0.39	0.34	0.32	0.31	0.26	0.24	0.22	0.20	0.20	0.17	0.16	0.14	0.09
3	0.35	0.32	0.32	0.28	0.25	0.25	0.21	0.20	0.18	0.17	0.17	0.14	0.12	0.11	0.07
4	0.30	0.28	0.27	0.24	0.22	0.21	0.18	0.17	0.16	0.14	0.14	0.11	0.11	0.07	0.06
5	0.29	0.26	0.24	0.22	0.20	0.18	0.16	0.15	0.14	0.12	0.12	0.10	0.08		
6	0.26	0.24	0.24	0.22	0.18	0.18	0.15	0.15	0.12	0.10	0.08	0.08			
7	0.24	0.21	0.22	0.20	0.17	0.16	0.14	0.12	0.11	0.10					
8	0.23	0.20	0.20	0.18	0.15	0.15	0.13	0.11	0.08	0.08					
9	0.22	0.19	0.19	0.17	0.14	0.14	0.12	0.11							
10	0.19	0.18	0.18	0.16	0.13	0.12	0.11	0.08							
11	0.18	0.17	0.16	0.14	0.12	0.11	0.10								
12	0.16	0.15	0.15	0.13	0.12	0.08	0.08								
13	0.15	0.14	0.12	0.12	0.11										
14	0.13	0.13	0.10	0.10	0.08										
15	0.13	0.12													
16	0.10	0.10													

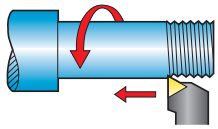
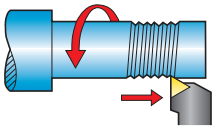
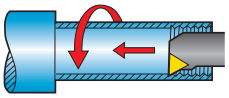
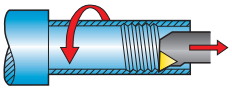
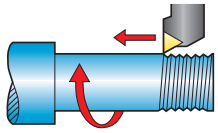
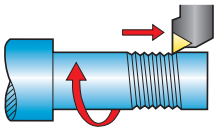
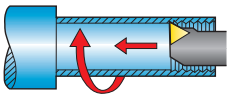
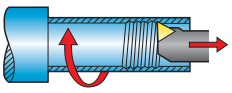
8. Selection of infeed method, page 33.



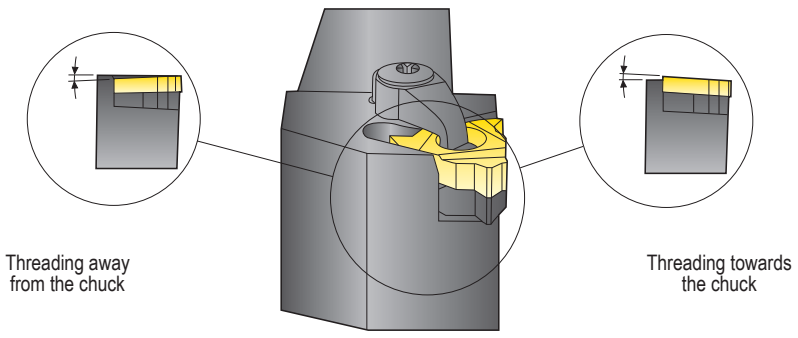
Production methods

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*	
Benefit:	• Best stability • Originally fitted insert shims can be used for most operations	**Benefit:**	• Chip flow is correctly directed during internal threading
Note:	• Chip build-up may occur during internal threading, particularly if there is little space between the threading bar and bore of the hole	**Note:**	• Secure clamping of the insert and mounting of the toolholder are necessary
		Internal threading:	• Use only CNR/L toolholders

Right-hand thread – Right-hand tool		Left-hand thread – Right-hand tool	
	ER		ER
	NR		NR
Left-hand thread – Left-hand tool		**Right-hand thread – Left-hand tool**	
	EL		EL
	NL		NL

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

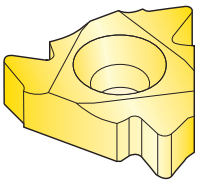


Insert grades

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

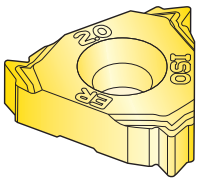
Single-tooth insert (Type S) A or Original

First choice, can be used for applications in a variety of materials.Low cutting forces.



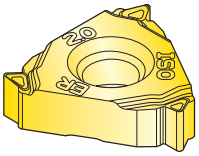
Single-tooth insert (Type S) A1 chipbreaker

First choice for general applications in steel.



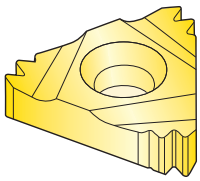
Single-tooth insert (Type S) A2 chipbreaker

First choice for general applications in stainless steel.



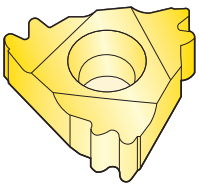
Multi-tooth insert (Type M)

First choice for mass production, since fewer passes are necessary.
Only for radial infeed.
2M = 2 teeth version
3M = 3 teeth version



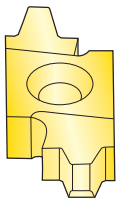
Multi-tooth insert (TWIN THREADER, TT)

Lower cutting forces than M type.
Shorter undercut length than M type.
Only for radial infeed.
Use insert shim for 2M.



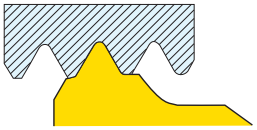
K insert (Type K)

First choice for large/coarse threads.



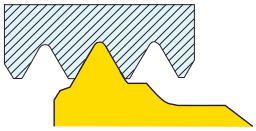
Full profile

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).



Partial profile

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.



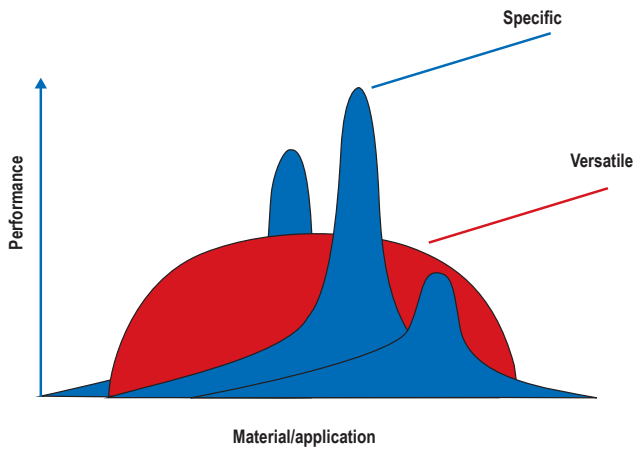
Insert grades

Thread turning – Insert grades

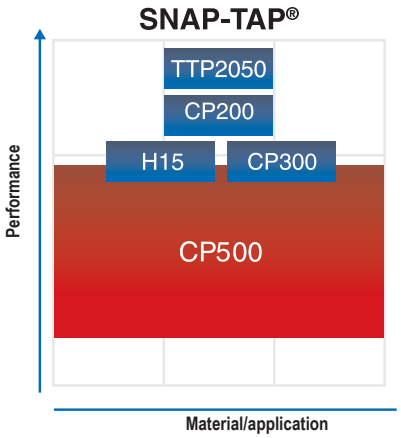
Continuous research and development of better materials, coatings and optimal geometries help fulfil customers requirements.

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

Product strategy grades

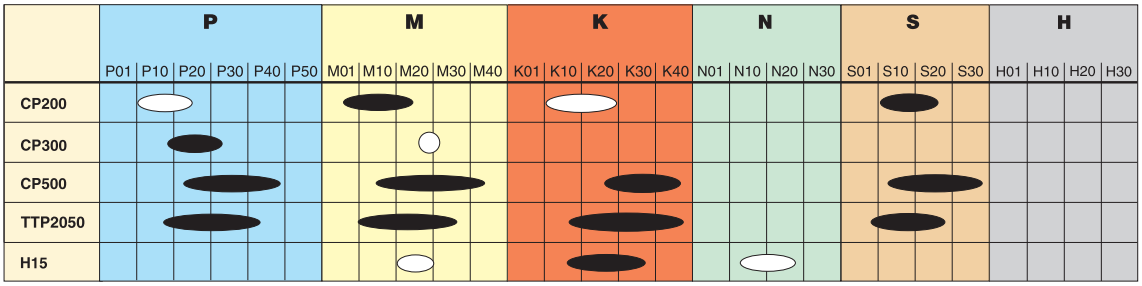


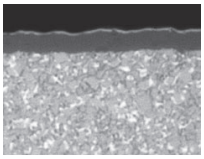
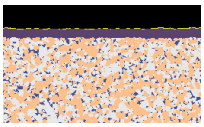
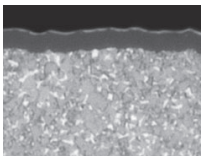
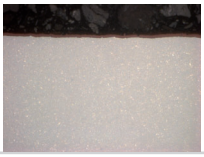
Grade assortment Snap-Tap®

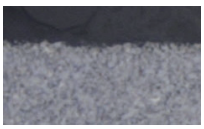


Insert grades

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



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)N/(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.

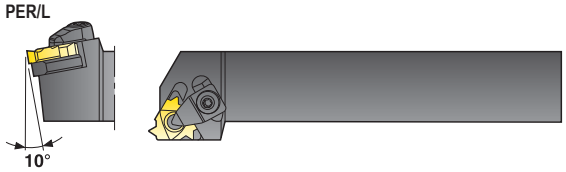
Toolholders

Use the guidelines below to choose a suitable toolholder type.

External threading

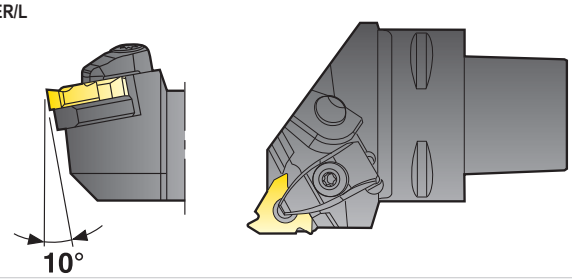
Basic choice
Type C (clamp)
Type P (Pin)

CER/L, PER/L



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

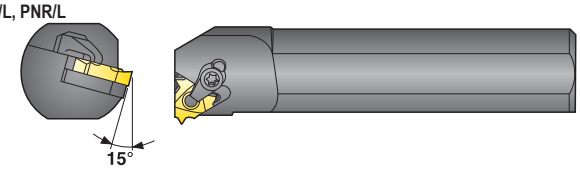
Cx-CER/L



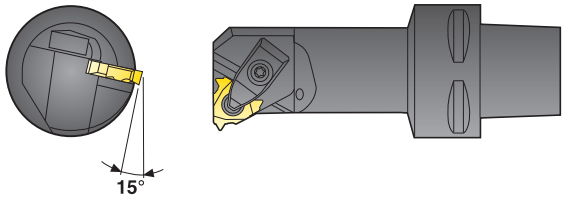
Internal threading

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

CNR/L, PNR/L



Cx-CNR/L

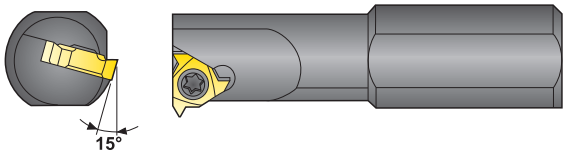


Insert size
16, 20, 22, 26, 27
With insert shim

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

For small holes
Type-S (screw)

SNR/L



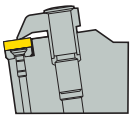
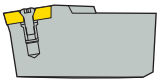
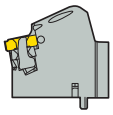
Insert sizes
09,11,16, 22

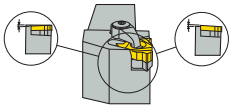
(No insert shim. To be used only when threading towards the chuck)

Insert shim

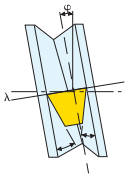
Originally fitted insert shims

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®
Toolholders		 External and internal threading		 Internal threading	 External and internal threading
Insert type		Single-tooth insert (Type S)	Single-tooth insert (Type K)	Single-tooth insert (Type S)	Single-tooth insert (Type S)
Insert shim				No insert shim (λ=2°)	
Insert size	16	GX 16-1			GXA16-1
	20		KX 20-2		
	22	NX22-1			NXA22-1
	26		KX26-2		
	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.

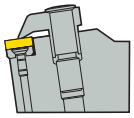
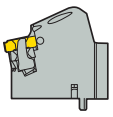


To receive the correct shape on the thread and uniform wear on the insert the cutting edge helix angle (λ) should be equal to the thread lead angle (φ).

The helix angle (λ) can also be calculated. See page 34 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		
Toolholders		 External and internal threading					 External and internal threading		
Insert type		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)	
Insert shim		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
Insert size	16	MX16-1	GX16-0, -1, -2, -3, -4	GX16-0 -99 -98			MXA16-1	GXA16-0, -1, -2, -3, -4	GXA16-0, -99, -98
	20				KX20-0, -1, -2, -3, -4, -5	KX20-0, -99			
	22	MX22-1	NX22-0, -1, -2, -3, -4	NX22-0 -99 -98			MXA22-1	NXA22-0, -1, -2, -3, -4	NXA22-0, -99, -98
	26				KX26-0, -1, -2, -3, -4, -5	KX26-0, -99			
	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

Insert shim

Choice of insert shim

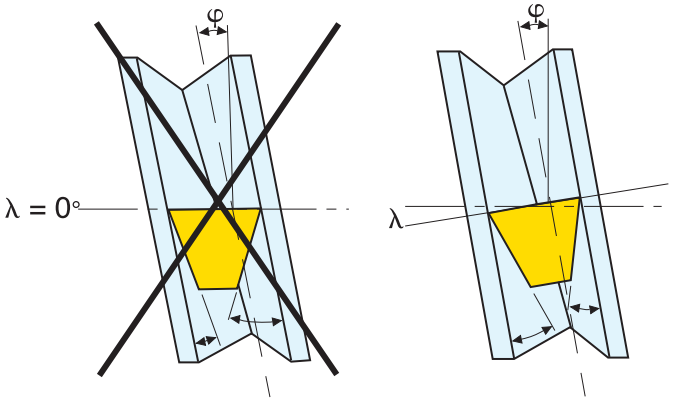
Use the graph below to choose the correct insert shim.
The graph gives the last digit in the insert shim code.
Example: GX16-1

Production method

Threading towards the chuck, use right side of the graph.
Threading away from the chuck, use left side of the graph.

Vertical column - lead

Thread with one start, Lead (Ph) = pitch (P).
Thread with several starts, Lead (Ph) = pitch (P) x number of starts.



Horizontal column = pitch diameter (D_2)

Pitch diameter D_2 – threading away from the chuck

| mm | 5 | 15 | 20 | 25 | 30 | 40 | 45 | 50 | 60 | 65 | 70 | 75 | 85 | 90 | 95 | 100 | 110 | 115 | 120 | 130 | 135 | 140 | 150 | 155 | 160 | 165 | 170 | 180 | 190 | 200 | 225 | 250 | 300 | | |

SMG – Cutting data

In SMG classification of workpiece materials involves a specific material standard in a specific condition assigned as reference for easy and unabiguous 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) 380-389, 390.

SMG	Description	Properties	Reference
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 N/mm²
P5	Structural steels, 0.25% < C < 0.67%wt Quench & Temper steels	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²

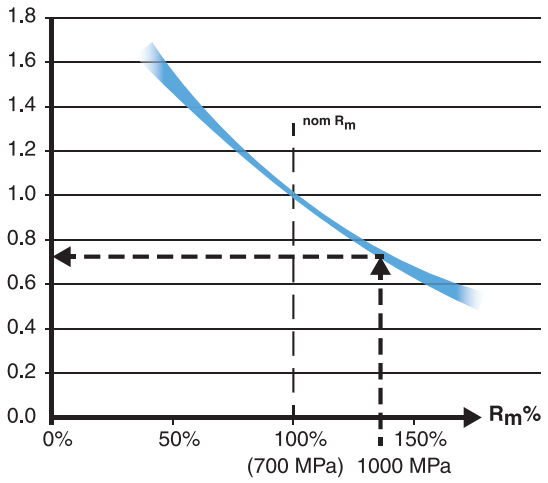
SMG	Description	Properties	Reference
H5	Quenched & Tempered steels	38 < HRC < 56	42 CrMo 4 50 HRC

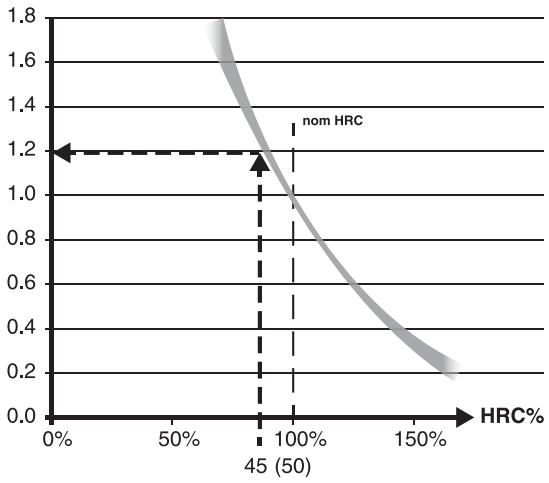
Focusing specifically on EN 42 CrMo 4 in annealed condition, the ultimate tensile strength R_m may typically vary between Rm = 630 N/mm² and R_m = 780 N/mm², which provide a reference level for SMG P5. In Quenched & Tempered condition, the ultimate tensile strength R_m may typically be between R_m = 900 N/mm² and R_m = 1100 N/mm² thus still belongs to SMG P5. However, if hardened above R_m = 1200 N/mm² it instead belongs to SMG H5.

SMG	EN	W.-Nr	AFNOR	BS	UNI	JIS	AISI / ASTM	GOST	Condition	$R_{m\ nom}$	HRC_{nom}
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_m (left diagram valid for ISO-P) and for relative HRC (valid for ISO-H).





To further illustrate how the SMG P5 nominal v_c can be adjusted to a more accurate recommended v_c we need ultimate tensile strength R_m data and in this case we use the EN 42 CrMo 4 quenched & tempered to R_m = 1000 N/mm² according to above table (bold blue arrows).

Assume that we find that the SMG P5 nominal v_c = 280 m/min for a certain product and machining.

Then, actual recommended v_c = 280 m/min x 0,75 = 210 m/min.

Consequently in the SMG H5 the nominal v_c can be adjusted using the hardened EN 42 CrMo 4 at HRC 45 (smaller grey arrows).

Assume that the SMG H5 nominal v_c = 50 m/min for a certain product and machining using a coated cemented carbide tools then, actual recommended v_c = 50 m/min x 1,2 = 60 m/min.

For further workpiece material details please see page(s) 380-389, 390 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

Cutting speed

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

Use the SMG tables to classify the workpiece material. Use the table to choose cutting speed.
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 each grade is CP200, CP300, CP500, TTP2050 and H15 +/-15%

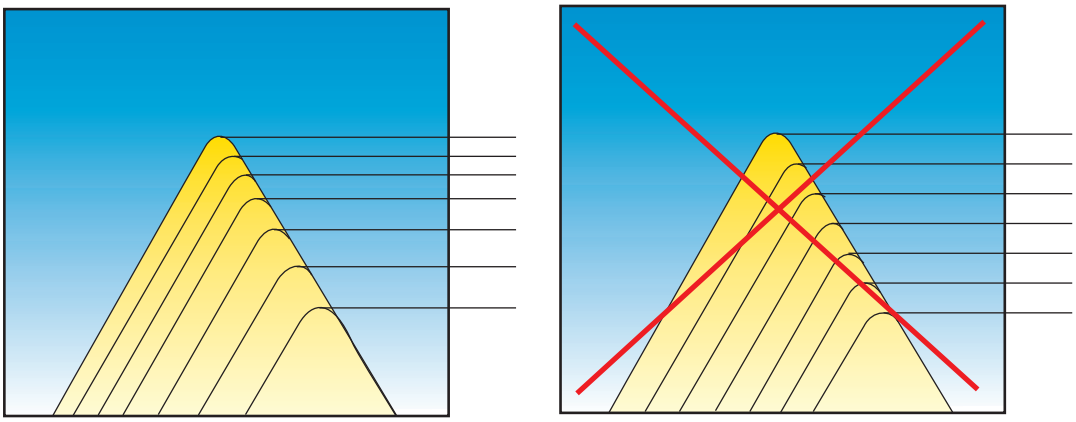
SMG=Seco Material Group
v_c = Cutting speed (m/min)

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 21-32 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_c 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_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%

Cutting speed – Mini Shaft

SMG	v_c 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	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)*	–	–	–	–	–	–	–	–	–	–	–	–	–	–

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)*	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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_p	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)*	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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
a_p	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)*
1	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)*
2	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)*
3	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)*
4	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)*
5	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)*	-
6	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)*	-	-	-
7	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)*	-	-	-	-	-
8	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)*	-	-	-	-	-	-
9	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)*	-	-	-	-	-	-	-	-	-
10	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)*	-	-	-	-	-	-	-	-	-	-
11	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)*	-	-	-	-	-	-	-	-	-	-	-
12	0,18 *(0.007)*	0,15 *(0.006)*	0,15 *(0.006)*	0,12 *(0.005)*	0,08 *(0.003)*	0,08 *(0.003)*	-	-	-	-	-	-	-	-	-	-	-	-
13	0,16 *(0.006)*	0,14 *(0.006)*	0,12 *(0.005)*	0,11 *(0.004)*	-	-	-	-	-	-	-	-	-	-	-	-	-	-
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)*	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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)*

	ISO Metric						UN					Whitworth	NPT		
Type	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)*

Internal multi-tooth inserts, metric *(inch)*

	ISO Metric						UN					Whitworth	NPT		
Type	**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 *(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_p	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)*	-	-	-	-

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*)	027 (*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	013	–	–	–	–	–	–	–	–	–	–	–

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	–	–	–	–	–	–	–	–	–	–	–

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 *(inch)*	1,25 *(0.049)*	0,93 *(0.037)*	0,65 *(0.026)*
Pass mm *(inch)*	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 *(inch)*	1,17 *(0.046)*	0,85 *(0.033)*	0,60 *(0.024)*
Pass 1 mm *(inch)*	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 *(inch)*	1,58 *(0.062)*	1,20 *(0.047)*
Pass 1 mm *(inch)*	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 *(inch)*	1,39 *(0.055)*	1,05 *(0.041)*
Pass 1 mm *(inch)*	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)*

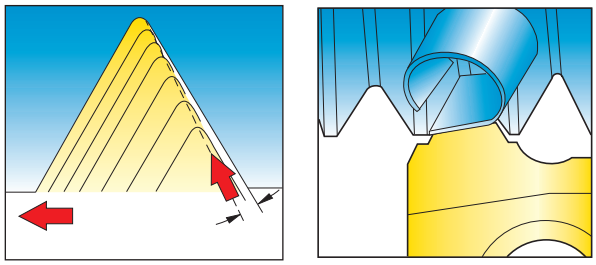
TPI	12	16
a_p mm *(inch)*	1,25 *(0.049)*	0,93 *(0.037)*
Pass 1 mm *(inch)*	0,24 *(0.009)*	0,21 *(0.008)*
2	0,35 *(0.014)*	0,32 *(0.013)*
3	0,25 *(0.010)*	0,22 *(0.009)*
4	0,22 *(0.009)*	0,18 *(0.007)*
5	0,19 *(0.007)*	–

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

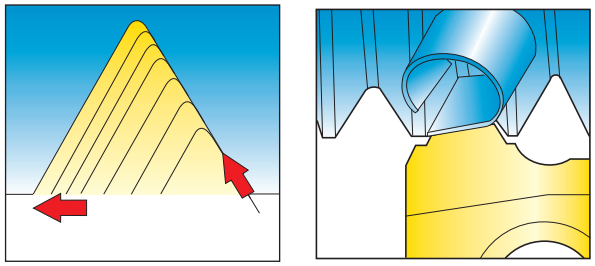


First choice for CNC machines
The infeed angle should be 2,5–5% less than the flank angle

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

Flank infeed

For CNC machines and conventional machines

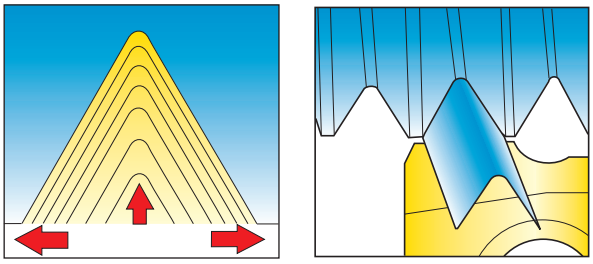


Choose flank infeed when modified flank infeed cannot be used

- 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

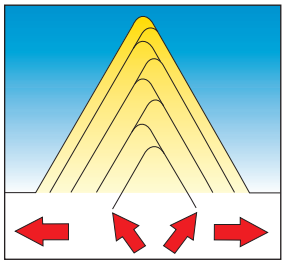


Multitooth inserts demand radial infeed
First choice for work hardening materials

- 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

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

Cutting speed

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

Slide velocity/feed rate

$$v_f = \frac{n \cdot P_h}{1000} \quad \text{(mm/min)}$$

Lead

$P_h = P \cdot$ numbers of starts (mm)

Helix angle

$$\frac{P_h}{D_2 \cdot \pi} \quad (°)$$

$\lambda = \arctan$

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)
λ = Helix angle (°)

RPM

$$n = \frac{v_c \cdot 3.82}{D_c} \quad \text{(rev/min)}$$

Cutting speed

$$v_c = \frac{n \cdot D_c}{3.82} \quad \text{(sf/min)}$$

Feed speed

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

$$v_f = n \cdot z_c \cdot f_z \quad \text{(in/min)}$$

Feed per revolution

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

$$f = z_c \cdot f_z \quad \text{(in/rev)}$$

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

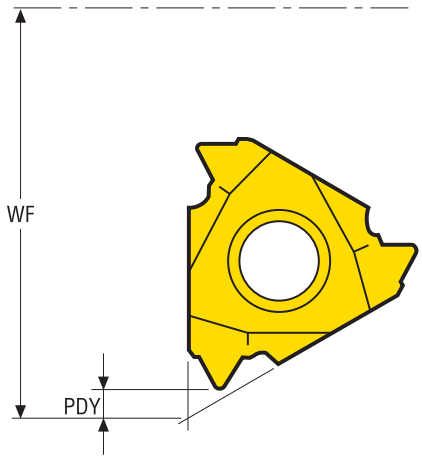
It is often necessary to cut internal threads which are too small to be made with a standard toolholder.

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 an lathe with a four-jaw chuck. In the dimension table D_m 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.

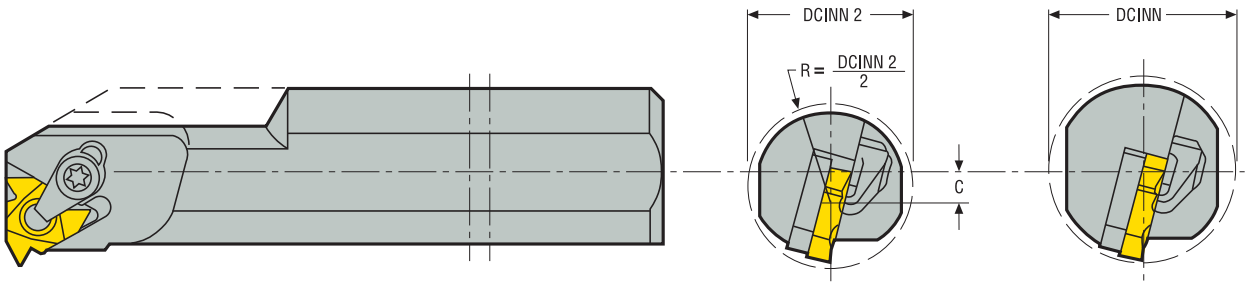
For some holders it is possible to work inside smaller bores than indicated by the Dm mod dimension, here it is necessary "to back off" the bottom corner of the insert (possibly also the insert shim).

Reference dimensions on insert



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

Reference dimensions on bar



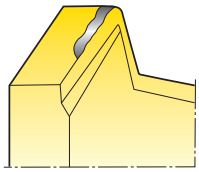
C = WF – PDY + R – DCINN2

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

Troubleshooting

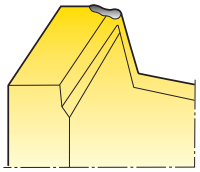
Rapid flank wear

- Reduce the cutting speed
- Increase the infeed per pass
- Use modified flank infeed
- Check that the correct insert shim has been selected
- Select a more wear-resistant grade



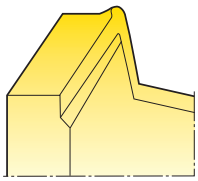
Insert fracture

- Increase the number of passes
- Check the workpiece mounting
- Check the centre height of the cutting edge
- Check for built-up edge
- Select a tougher grade



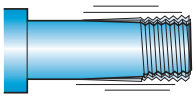
Plastic deformation

- Select a grade with better resistance to plastic deformation
- Reduce the cutting speed
- Increase the number of passes
- Increase the coolant supply
- Check that the workpiece diameter is correct prior to cutting the thread



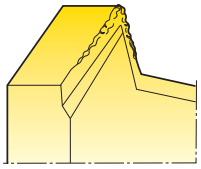
Vibrations

- Change the cutting speed
- Reduce the overhang and use the most stable toolholder
- Check the centre height of the cutting edge
- Check that the workpiece diameter is correct



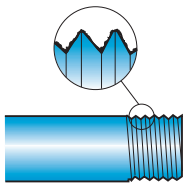
Build-up edge

- Increase the cutting speed
- Do not use coolant



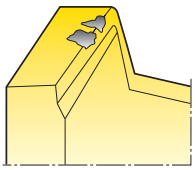
Poor finish

- Increase the cutting speed
- Check that the correct insert shim has been selected
- Use modified flank infeed or radial infeed



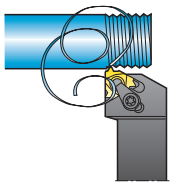
Edge chipping

- Check the workpiece mounting
- Check the cutting speed
- Use modified flank infeed
- Select a tougher grade



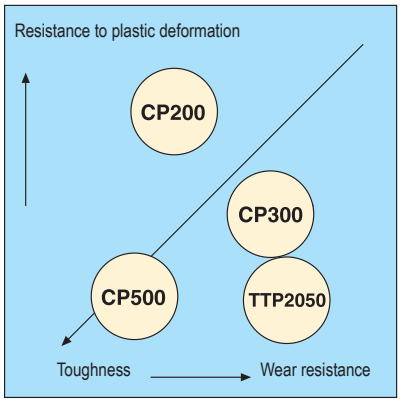
Poor chip control

- Reduce the number of passes
- Increase the cutting speed
- Use modified flank infeed
- Increase the coolant supply

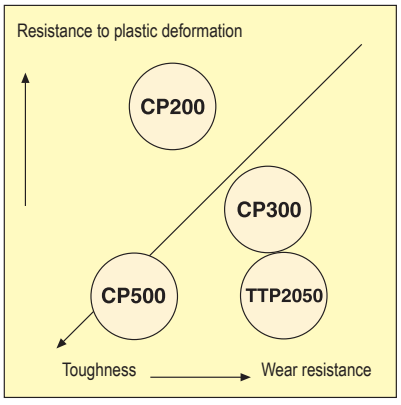


Optimisation

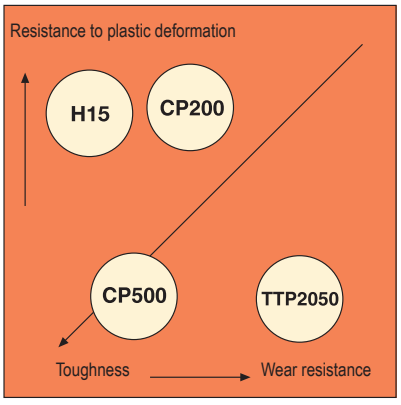
ISO-P (steel)



ISO-M (stainless steel)



ISO-K (cast iron)



Torque values for clamping screws

Maximum Torque value for each screw is shown below

Screw designation	Torque Nm	Torque key
110.26-655	10,0	H00T-60100
117.26-655	5,0	H00T-3050
117.26-657	3,0	H00-2530
170.26-655	6,0	H00T-4060
C02205-T07P	0,9	T00-07P09
C02505-T07P	0,9	T00-07P09
C02506-T07P	0,9	T00-07P09
C03007-T09P	2,0	T00-09P20
C03508-T15P	3,0	T00-15P30
C03509-T15P	3,0	T00-15P30
C03510-T15P	3,0	T00-15P30
C03511-T09P	2,0	T00-09P20
C03512-T15P	3,0	T00-15P30
C04008-T15P	3,5	T00-15P35
C04010-T15P	3,5	T00-15P35
C04011-T15P	3,5	T00-15P35
C04014-T15P	3,5	T00-15P35
C04512-T15P	5,0	T00-15P50
C04518-T15P	5,0	T00-15P50
C05010-T20P	5,0	T00-20P50
C05012-T15P	5,0	T00-15P50
C05013-T20P	5,0	T00-20P50
C05018-T20P	5,0	T00-20P50
C11804-T06P	0,5	T00-06P05
C46017-T20P	6,0	T00T-20P60
C82204-T06P	0,5	T00-06P05
CC05	0,9	H00-1509
CC08P-V13	2,0	T00-09P20
CC09P-D11	2,0	T00-09P20
CC12P-S12	3,5	T00-15P35
CC14	6,0	H00T-4060
CC16	10,0	–
CC17P	10,0	–
CC17P-06	10,0	–
CC17P-09	10,0	–
CC20P	10,0	–
CC20P-V13	10,0	–
CD09-S09	2,0	T00-09P20
CD12-S12	3,5	T00-15P35
CD16-S16	5,0	T00-20P50
CD19-S19	5,0	T00-20P50
CD19-V16	5,0	T00-20P50
CSC8015-T20P	5,0	T00-20P50
CSC1015-T20P	5,0	T00-20P50
CSP16-T15P	2,0	T00-15P20
CSP22-T15P	3,0	T00-15P30
CSP27-T25P	6,0	T00T-25P60

Screw designation	Torque Nm	Torque key
L84017-T09P	2,0	T00-09P20
L85011-T15P	5,0	T00-15P50
L85012-T15P	5,0	T00-15P50
L85017-T09P	2,0	T00-09P20
L85020-T15P	3,5	T00-15P35
L85021-T15P	3,5	T00-15P35
L86015-T20P	6,0	T00T-20P60
L86025-T20P	6,0	T00T-20P60
LD1035-T25P	6,0	T00T-25P60
LD5020-T09P	2,0	T00-09P20
LD6020-T15P	3,0	T00-15P30
LD6021-T09P	2,0	T00-09P20
LD6024-T20P	3,0	T00-15P30
LD6025-T15P	3,0	T00-15P30
LD6026-T09P	2,0	T00-09P20
LD8025-T25P	6,0	T00T-25P60
LD8030-T25P	6,0	T00T-25P60
LS0512	2,5	–
LS0613	3,0	H00-2530
LS0616	3,0	H00-2530
LS0818	4,0	–
LS0822	4,0	–
MC6S4X14	3,5	–
MC6S4X18	3,5	–
MC6S5X14	5,0	H00T-4050
MC6S5X18	5,0	H00T-4050
MN0909L-T09P	2,0	T00-09P20
MN1215L-T15P	3,0	T00-15P30
MN1215R-T15P	3,0	T00-15P30
MN1215S-T15P	3,0	T00-15P30
MN1215T-T15P	3,0	T00-15P30
MN1515-T15P	3,0	T00-15P30
MN1515SL-T15P	3,0	T00-15P30
MN1520-T20P	6,0	T00T-20P60
MN1920-T20P	6,0	T00T-20P60
MN1925-T25P	5,0	T00T-25P50
MN2525-T25P	6,0	T00T-25P60
PL1403-T09P	2,5	T00-09P20
TCEI0409	3,5	–
TCEI0509	6,0	H00T-4060
TCEI0513	6,0	H00T-4060
TCEI0609	8,0	H00T-5080
TCEI0613	8,0	H00T-5080
TCEI0614	8,0	H00T-5080
TCEI0620	8,0	H00T-5080
TCEI0815	10,0	H00T-60100
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

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	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
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

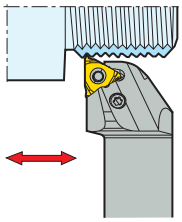
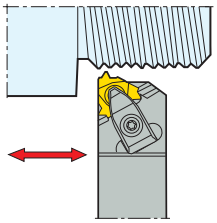
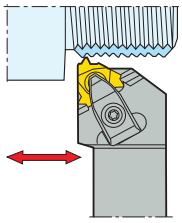
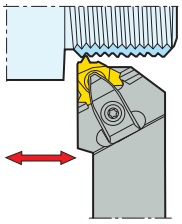
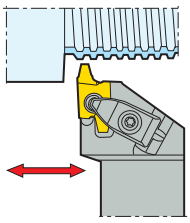
Torque key*	Replaceable blade	Hexagonal size	Torque value
H00T-3050	H00T-3.0	3 mm	5,0 Nm
H00T-4050	H00T-4.0	4 mm	5,0 Nm
H00T-4060	H00T-4.0	4 mm	6,0 Nm
H00T-5050	H00T-5.0	5 mm	5,0 Nm
H00T-5080	H00T-5.0	5 mm	8,0 Nm
H00T-50100	H00T-5.0	5 mm	10,0 Nm
H00T-60100	H00T-6.0	6 mm	10,0 Nm

*Including blade

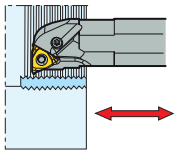
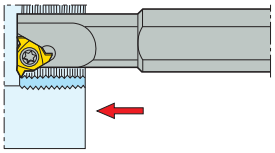
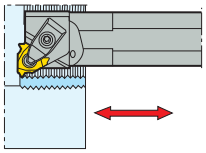
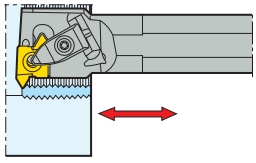
Please note that the blades are not interchangeable between screwdriver type and T-handle type.
Torx Plus® is a registered trade mark belonging to Camcar-Textron (USA)

Application overview, toolholders

External toolholders

PER/L...QHDJETI PER/L...QHDJET	CER/L CER/L...HD	CER/L...Q CER/L...QHD	CER...CQHD	CER...HD CER/L...QHD
				
Page(s) 53-54	Page(s) 58	Page(s) 59-63	Page(s) 64-66	Page(s) 67

Internal toolholders

PNR/L...AHDJET	SNR/L	CNR/L...AHD CNR/L...APIHD	CNR/L...AHD
			
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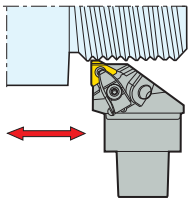
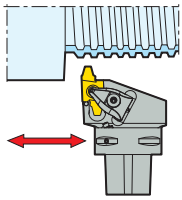
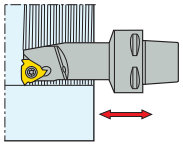
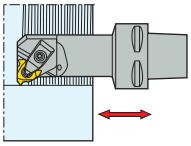
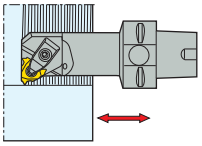
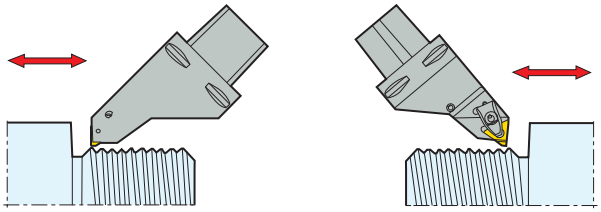
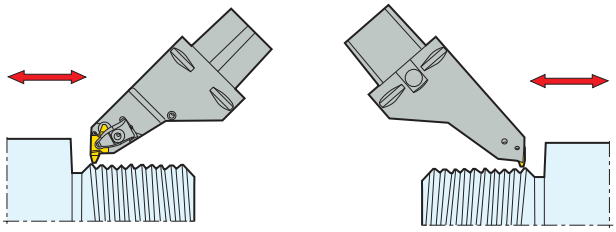
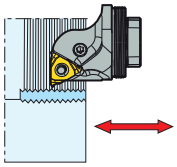
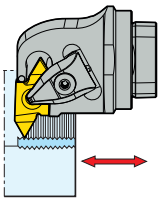
Seco-Capto™

CER/L-..HD...CHD Ext.	CER..HD Ext.	SNR Int.	CNR/L-..HD Int.	CNR/L-..CHD Int.
				
Page(s) 77, 78	Page(s) 81	Page(s) 82	Page(s) 83, 84 - 87	Page(s) 88 - 90

Seco-Capto™ for MTM

CER-..HD	CEL..HD
	
Page(s) 91	Page(s) 92

Steadyline® with GL connection

GL..-PNR/L...AHDJET	GL50-CNR...26AHD
	
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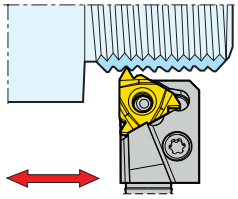
Quick Change, Jetstream Tooling®, QC-heads, external

QC..-PER/L-HDJET

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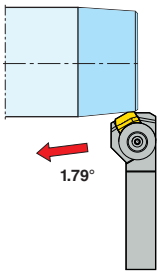
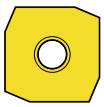
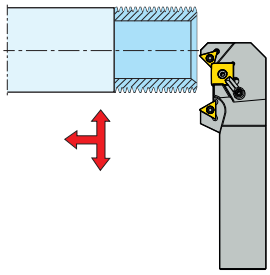
Toolholders for peeling

CSXCR...

Page(s) 97-98

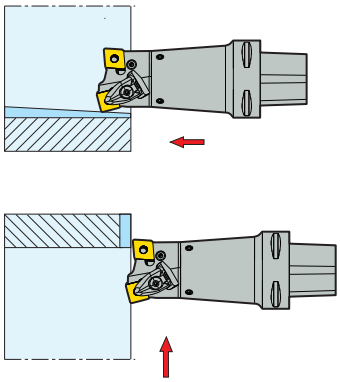
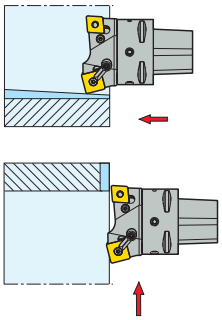
Inserts for peeling

SCNN

Page(s) 121

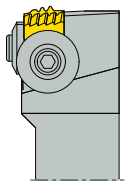
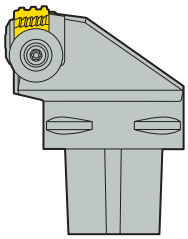
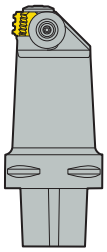
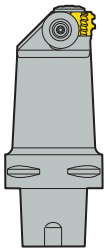
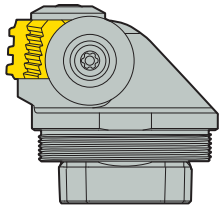
Toolholders for pipe-facing

MSGNR...

Page(s) 99-100

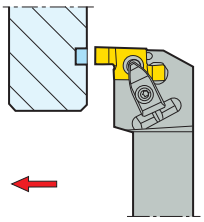
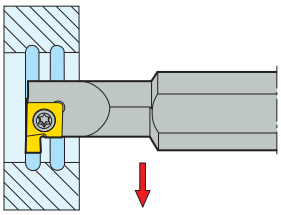
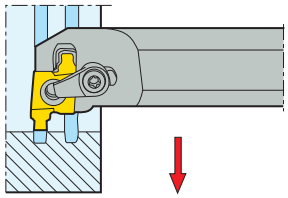
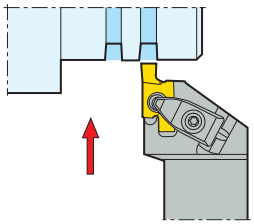
Toolholders for inserts SNMA, SNMG, SNMM / CNMA, CNMG, CNMM

C.-DSKNR/L - CLNR/L 75°	C.-MSKNR/L - PCLNR/L 75°
	
Page(s) 101	Page(s) 102

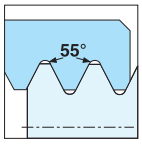
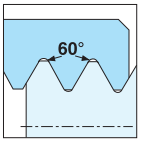
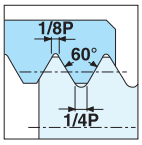
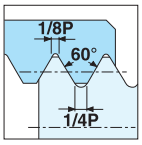
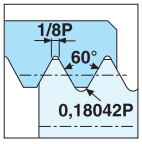
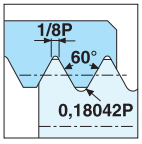
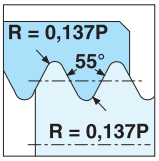
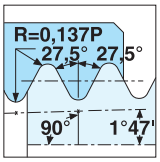
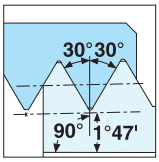
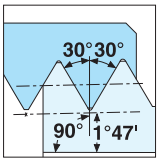
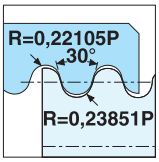
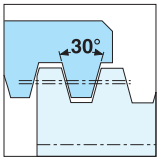
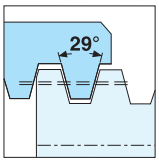
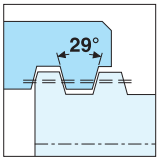
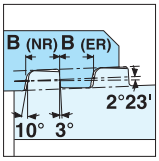
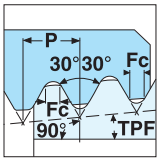
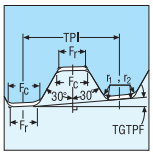
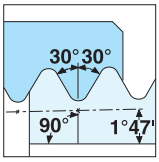
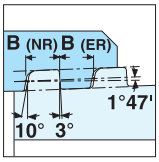
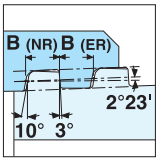
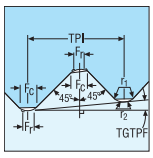
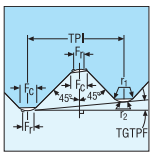
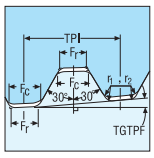
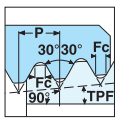
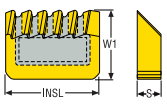
Toolholders for chasers

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) 103-104	Page(s) 105	Page(s) 106 - 107	Page(s) 108 - 109	Page(s) 110

Toolholders for Precision Grooves

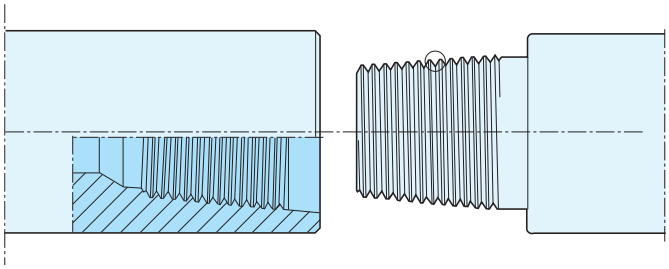
CEAR/L...	SNR/L...	CNR/L...	CER/L...
			
Page(s) 111-112	Page(s) 113-114	Page(s) 115-116	Page(s) 117-120

Application overview, inserts

Partial profile inserts	55° V profile	60° V profile			
					
	Page(s) 122-123	Page(s) 123, 124-125			
Full profile inserts	**ISO metric**	**UN**			
Reusable threaded joints					
	Page(s) 126, 127-128, 129, 130	Page(s) 131, 132-133, 134			
Full profile inserts	**UNJ**	**MJ**			
Reusable threaded joints for the aerospace industry					
	Page(s) 135-136	Page(s) 137-138			
Full profile inserts	**Whitworth, BSW**	**BSPT**	**NPT**	**NPTF**	**Round-DIN405**
Permanent threaded joints for pipe mountings and couplings					
	Page(s) 139, 140-141, 142	Page(s) 143-144	Page(s) 145-146	Page(s) 147-148	Page(s) 149-150
Partial profile inserts	**TR-DIN103**	**ACME**	**Stub-ACME**	**American Butress**	
Motion-transmitting threads					
	Page(s) 151-152	Page(s) 153-154	Page(s) 155-156	Page(s) 157-158	
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) 159-160	Page(s) 161-162	Page(s) 163-164	Page(s) 165-166	Page(s) 167-168
Full profile inserts	**Hughes H90**	**Hughes Slimline H90**	**P.A.C**	**Chasers API/Gost**	**Chipformers for chasers**
Threads for the oil industry					
	Page(s) 161-162	Page(s) 161-162	Page(s) 161-162	Page(s) 169, 170	Page(s) 171, 172, 173

Rotary drilling connections

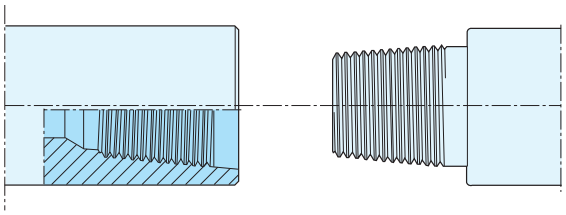
OCTG pipe and coupling illustration



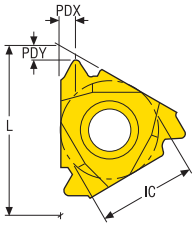
Connections	Pitch TPI	TGTPF	API code	Snap-Tap® code
API Number				
NC10 - NC16	6.0	1.5	V055	6API558
NC23 - NC50	4.0	2.0	V038R	4API386
NC56 - NC77	4.0	3.0	V038R	4API384
API Regular				
1 - 1 1/2 REG	6.0	1.5	V055	6API558
2 3/8 REG - 4 1/2 REG	5.0	3.0	V040	5API404
5 1/2 REG, 7 5/8 REG, 8 5/8 REG	4.0	3.0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

Rotary drilling connections

Connections

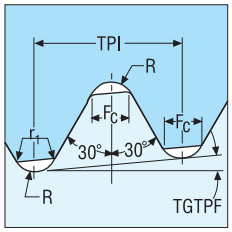
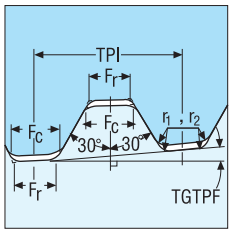
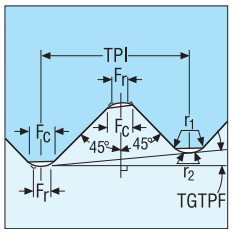
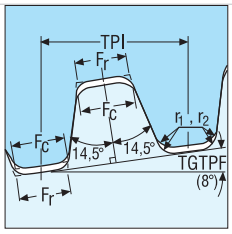


Insert dimensions



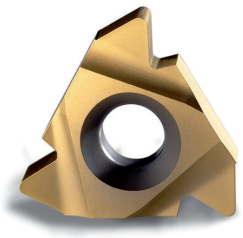
Connections							
Snap-Tap® code	API code	Pitch TPI	TGTPF *inch*	L mm	IC mm	PDX mm	PDY mm
6API558	V055	6.0	*1.5*	22,0	12,700	2,5	2,0
5API404	V040	5.0	*3.0*	22,0	12,700	2,5	2,0
5API404	V040	5.0	*3.0*	27,5	15,875	3,2	2,2
4API386	V038R	4.0	*2.0*	22,0	12,700	2,5	1,9
4API386	V038R	4.0	*2.0*	27,5	15,875	3,2	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_r mm (*Inch*)	F_c mm (*Inch*)	r_1 mm (*Inch*)	r_2 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

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.

2. Dimension check after sintering
Measuring of IC and thickness.
Measured according to SPM.
Values stored in a database.

3. Dimension control after bottom grinding
Thickness and cutting edge height.
Flatness.
Measured according to SPM.

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

7. Final inspection
Visual Inspection.
Sampling in accordance to AQL.

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.

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 hight 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.

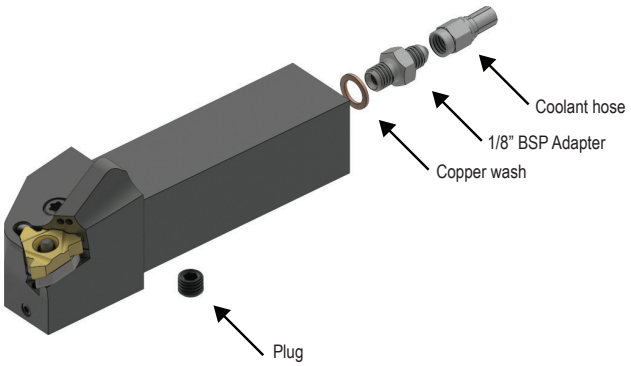
The JETI is developed with a compact assembly in mind, the tooling eliminates the need for any external piping and connections that would otherwise obstruct machine movements in tight workspaces. Coolant hole underneath the square shank holder make it possible for coolant to reach the cutting edge directly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

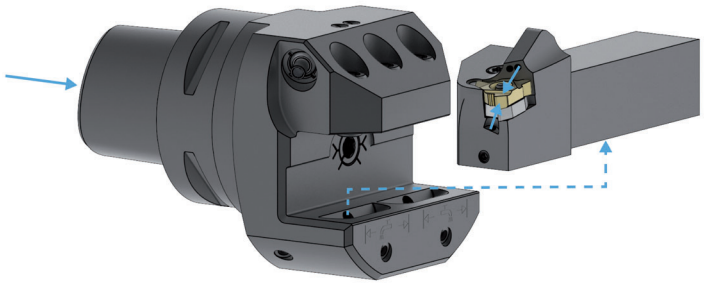


For accessories, see next page.

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)*
Straight fitting	JET-HOSE150SS	150 *(5.906)*
	JET-HOSE200SS	200 *(7.874)*
	JET-HOSE250SS	250 *(9.843)*
	JET-HOSE300SS	300 *(11.811)*
Banjo fitting	JET-HOSE150BS	150 *(5.906)*
	JET-HOSE200BS	200 *(7.874)*
	JET-HOSE250BS	250 *(9.843)*
	JET-HOSE300BS	300 *(11.811)*
Banjo-to-Banjo fitting	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.		...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) 50

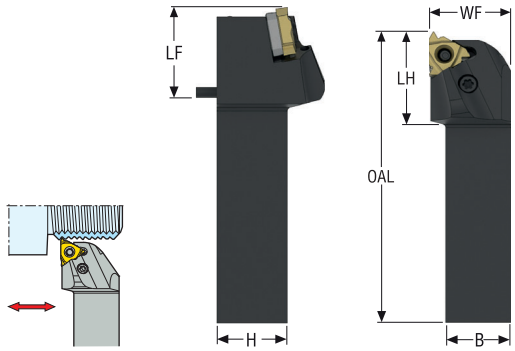
Thread turning Toolholders

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®

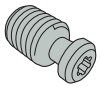


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 159, 161, 163, 165, 167
- 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...	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

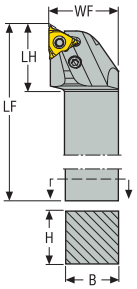
Accessories

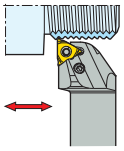
For holders	Insert shim (M)	Insert shim (S) 1	Insert shim (S) 10	Insert shim (S) 11	Insert shim (S) 2	Insert shim (S) 3	Insert shim (S) 4	Insert shim (S) 5	Insert shim (S) 6	Insert shim (S) 7	Insert shim (S) 8	Insert shim (S) 9	Plug
...16QHD...	MXA16-1	GXA16-0	–	–	GXA16-2	GXA16-3	GXA16-4	GXA16-99	GXA16-98	–	–	–	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 / Seco Online Store

Jetstream Tooling® – Toolholders, external

For S-inserts, Snap-Tap®





Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 159, 161, 163, 165, 167
- CP* Max coolant pressure (bar) using hose connection otherwise according machine side adapter

Designation	Item number	H	B	LF	WF	LH	Weight	CP	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	psi	
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

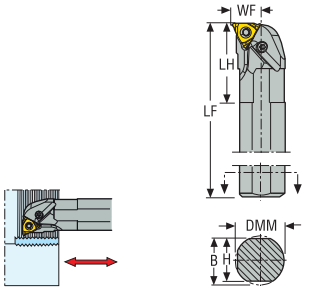
Accessories

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

Please check availability at www.secotools.com / Seco Online Store

Jetstream Tooling® – Toolholders, internal

For S-inserts, Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 164
- 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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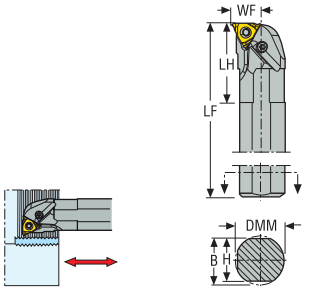
Jetstream Tooling® – Toolholders, internal

For S-inserts, Snap-Tap®

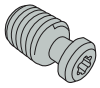


Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 164
- 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
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	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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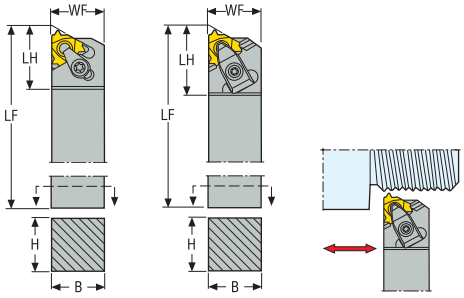
Toolholders, external

For S-inserts, Snap-Tap®

CER/L CER/L..HD

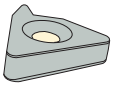


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 161

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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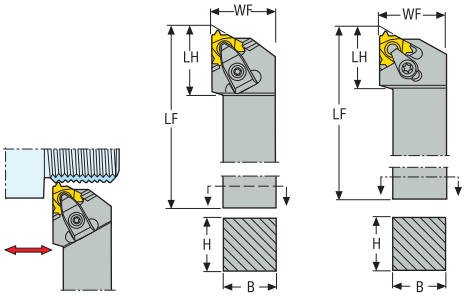
Toolholders, external

For S-inserts, Snap-Tap®

CER/L..Q CER/L..QHD

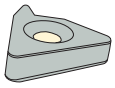


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 161

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CER03753-16Q	00072538	0.375	0.375	3.000	0.375	0.900	0.440	16ER...
CER06254-16Q	00072498	0.625	0.625	4.000	0.750	0.900	0.660	16ER...
CEL06254-16Q	00072544	0.625	0.625	4.000	0.750	0.900	0.660	16EL...
CER0504-16Q	00072524	0.500	0.500	4.000	0.625	0.900	0.440	16ER...
CEL0504-16Q	00072466	0.500	0.500	4.000	0.625	0.900	0.440	16ER...
CEL0755-16HD	02483997	0.750	0.750	5.000	1.000	0.900	1.100	16EL...
CER0755-16QHD	02483996	0.750	0.750	5.000	1.000	0.900	0.880	16ER...
CER1006-16QHD	02462821	1.000	1.000	6.000	1.250	1.100	1.980	16ER...
CEL1006-16QHD	02462852	1.000	1.000	6.000	1.250	1.100	1.980	16EL...
CER1256-16QHD	02462823	1.250	1.250	6.000	1.500	1.181	3.090	16ER...
CEL1256-16QHD	02462853	1.250	1.250	6.000	1.500	1.100	3.090	16EL...
CER1506-16QHD	02462825	1.500	1.500	6.000	1.750	1.100	3.970	16ER...

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
							
CER/L 3753..0504..	–	T15P-2	CSP16-T15P	–	GX16-1	CS3507-T09P	–
CER 06254..	–	T15P-2	CSP16-T15P	–	GX16-1	CS3507-T09P	–
CEL 06254..	–	T15P-2	CSP16-T15P	–	GX16-1	CS3507-T09P	–
CER/L 0755..1006..	CHD16	T15P-7	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
CER/L 1256..1506..	CHD16	T15P-7	–	L85020-T15P	GX16-1	CS3507-T09P	S6912

Accessories

For holders	Insert shim (K) 2	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
CER/L 3753..0504..	–	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CER 06254..	GX16-2	MX16-1	GX16-0	–	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CEL 06254..	–	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CER/L 0755..1006..	–	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CER/L 1256..1506..	–	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2

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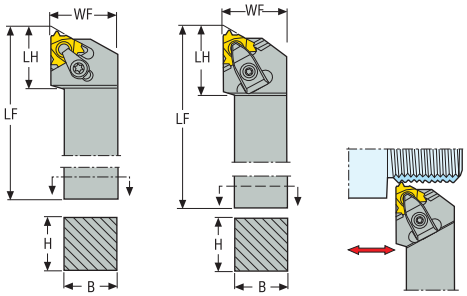
Toolholders, external

For S-inserts, Snap-Tap®

CER/L..Q CER/L..QHD

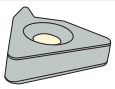


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 161

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

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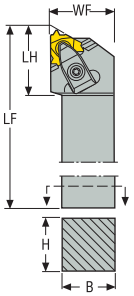
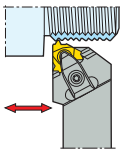
Toolholders, external

For S-inserts, Snap-Tap®



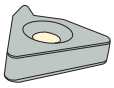


Right-hand version shown

• For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 161

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CER1005-22QHD	02462826	1.000	1.000	5.000	1.250	1.300	0.220	22ER...
CEL1005-22QHD	02462854	1.000	1.000	5.000	1.250	1.300	1.760	22EL...
CER1006-22QHD	02462827	1.000	1.000	6.000	1.250	1.300	1.980	22ER...
CEL1006-22QHD	02462856	1.000	1.000	6.000	1.250	1.300	2.200	22EL...
CER1256-22QHD	02462829	1.250	1.250	6.000	1.500	1.417	2.870	22ER...
CEL1256-22QHD	02462857	1.250	1.250	6.000	1.500	1.300	3.090	22EL...
CER1506-22QHD	02462831	1.500	1.500	6.000	1.750	1.300	4.190	22ER...

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Shim screw	Spring
						
CER/L..22..	CHD22	T20P-7L	L86025-T20P	NX22-1	CS4009-T15P	S7616

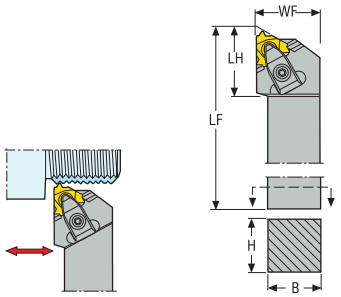
Accessories

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
CER/L..22..	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

Please check availability at www.secotools.com / Seco Online Store

Toolholders, external

For S-inserts, Snap-Tap®

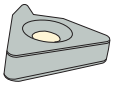


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 161

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CER1006-27QHD	02462835	1.000	1.000	6.000	1.250	1.600	2.200	27ER...
CEL1006-27QHD	02462859	1.000	1.000	6.000	1.250	2.000	2.200	27EL...
CER1256-27QHD	02462837	1.250	1.250	6.000	1.500	1.732	3.090	27ER...
CEL1256-27QHD	02462861	1.250	1.250	6.000	1.500	1.600	2.870	27EL...
CER1506-27QHD	02462839	1.500	1.500	6.000	1.750	1.600	4.190	27ER...
CEL1506-27QHD	02462863	1.500	1.500	6.000	1.750	1.600	4.190	27EL...

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Shim screw	Spring
						
CER 1006-27	CHD27	T20P-7L	L86025-T20P	VX27-1	C05012-T15P	S7616
CEL 1006-27..	CHD27	T20P-7L	L86025-T20P	VX27-1	C05012-T15P	S7616
CER/L 1256-27	CHD27	T20P-7L	L86025-T20P	VX27-1	C05012-T15P	S7616
CER 1506-27..	CHD27	T20P-7L	L86025-T20P	VX27-1	C05012-T15P	S7616
CEL 1506-27	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) 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
CER 1006-27	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
CEL 1006-27..	MX27-1	VX27-98.5	–	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	VX27-2	T15P-2
CER/L 1256-27	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
CER 1506-27..	MX27-1	VX27-99.5	VX27-2	–	VX27-0.5	VX27-1.5	VX27-98	VX27-99	VX27-3	VX27-4	VX27-0	T15P-2
CEL 1506-27	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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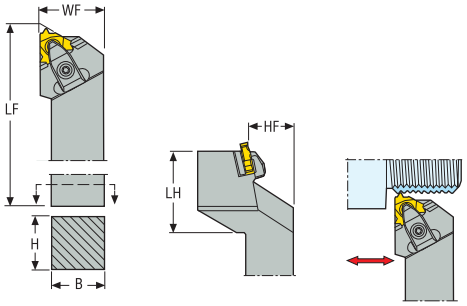
Toolholders, external

For S-inserts, Snap-Tap®

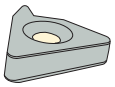


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 139, 140, 145, 147, 149, 151, 153, 155, 157, 159, 161, 163, 165, 167

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

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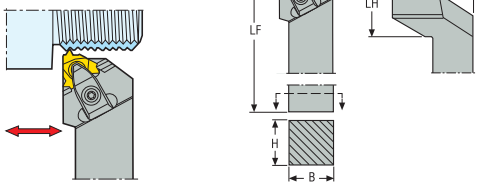
Toolholders, external

For S-inserts, Snap-Tap®

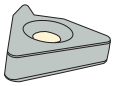


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 139, 140, 145, 147, 149, 151, 153, 155, 157, 159, 161, 163, 165, 167

Designation	Item number	H	B	LF	WF	LH	HF	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CER1006-16CQHD	02467118	1.000	1.000	6.000	1.250	2.000	1.000	1.540	16ER..
CEL1006-16CQHD	02462864	1.000	1.000	6.000	1.250	2.000	1.000	1.540	16EL..
CER1256-16CQHD	02462840	1.250	1.250	6.000	1.250	2.500	1.250	3.090	16ER..
CER1006-22CQHD	02462842	1.000	1.000	6.000	1.250	2.000	1.000	2.200	22ER..
CER1006-27CQHD	02462847	1.000	1.000	6.000	1.250	2.000	1.000	2.200	27ER..

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Screw	Shim screw	Spring
							
CER 1006-16..	CHD16	T15P-7	L85020-T15P	GX16-1	–	CS3507-T09P	S6912
CEL 1006-16..	CHD16	T15P-7	L85020-T15P	GX16-1	–	CS3507-T09P	S6912
CER 1256-16..	CHD16	T15P-7	L85020-T15P	GX16-1	–	CS3507-T09P	S6912
..22CQHD	CHD22	T20P-7L	L86025-T20P	NX22-1	S7616	CS4009-T15P	–
..27CQHD	CHD27	T20P-7L	L86025-T20P	VX27-1	–	C05012-T15P	S7616

Accessories

For holders	Insert shim (M)	Insert shim (S)	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
CER 1006-16..	MX16-1	GX16-99	–	–	–	–	–	–	–	–	–	–	–	T09P-2
CEL 1006-16..	MX16-1	–	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
CER 1256-16..	MX16-1	–	GX16-0	–	–	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	–	–	–	T09P-2
..22CQHD	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
..27CQHD	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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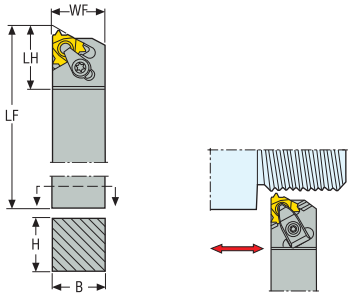
Toolholders, external

For S-inserts, Snap-Tap®

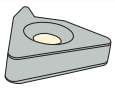


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 161

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CER0505-16Q-S	02508066	0.500	0.500	5.000	0.630	0.840	0.440	16ER..
CER06255-16Q-S	02508068	0.625	0.625	5.000	0.750	0.840	0.880	16ER..

Spare Parts

For holders	Clamp key	Clamp kit	Insert shim (S)	Shim screw
				
..16Q-S	T15P-2	CSP16-T15P	GX16-1	CS3507-T09P

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
..16Q-S	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2

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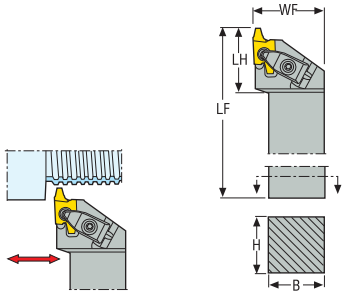
Toolholders, external

For K-inserts, Snap-Tap®

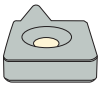


Right-hand version shown

• For inserts program, see page(s) 151, 153, 155

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

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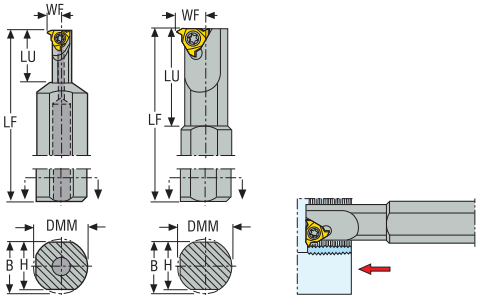
Toolholders, internal

For S-inserts, Snap-Tap®

SNR..09A SNR/L



- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

Right-hand version shown

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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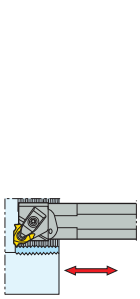
DCINN2, modified. Please see page 35

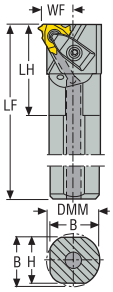
Toolholders, internal

For S-inserts, Snap-Tap®

CNR/L..AHD



CNR/L..APIHD

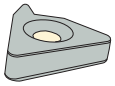


Right-hand version shown

• For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

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..

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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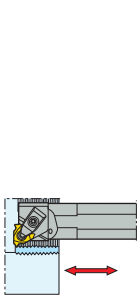
DCINN2, modified. Please see page 35

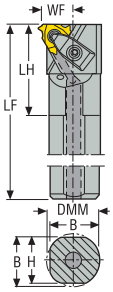
Toolholders, internal

For S-inserts, Snap-Tap®

CNR/L..AHD



CNR/L..APIHD

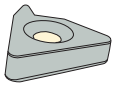


Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

Designation	Item number	DMM	H	B	LF	WF	LH	DCINN	DCINN2	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CNR000757-16AHD	02562574	0.750	0.650	0.707	6.693	0.520	1.181	0.950	0.800	0.880	16..
CNL000757-16AHD	02562790	0.750	0.650	0.707	6.693	0.520	1.181	0.950	0.800	0.880	16..
CNR001008-16AHD	02562785	1.000	0.902	0.957	7.874	0.650	2.126	1.150	1.000	1.540	16..
CNL001008-16AHD	02562791	1.000	0.902	0.957	7.874	0.650	2.126	1.150	1.000	1.540	16..
CNR0012510-16AHD	02562786	1.250	1.150	1.209	9.843	0.780	1.811	1.400	1.200	3.090	16..
CNL0012510-16AHD	02562792	1.250	1.150	1.209	9.843	0.780	1.811	1.400	1.200	3.090	16..
CNR0015012-16AHD	02562787	1.500	1.339	1.427	11.811	0.898	1.811	1.700	1.500	5.070	16..
CNL0015012-16AHD	02562793	1.500	1.339	1.427	11.811	0.898	1.811	1.700	1.500	5.070	16..
CNR0017514-16AHD	02562788	1.750	1.591	1.677	13.780	1.028	2.165	2.000	1.800	8.160	16..
CNL0017514-16AHD	02562794	1.750	1.591	1.677	13.780	1.028	2.165	2.000	1.800	8.160	16..
CNR0020014-16AHD	02562789	2.000	1.843	1.929	13.780	1.150	2.244	2.200	2.000	10.800	16..
CNL0020014-16AHD	02562795	2.000	1.843	1.929	13.780	1.150	2.244	2.200	2.000	10.800	16..

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim screw	Spring
							
CNR/L..0757..1008..	–	T15P-2	CSP16HD-T15P	–	GX16-1	CS3507-T09P	–
CNR..2510..	CHD16	T15P-7	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
CNL..2510..	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
CNR..5012..	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
CNL..5012..	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
CNR..7514..	CHD16	–	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
CNL..7514..	CHD16	T15P-2	–	L85020-T15P	GX16-1	CS3507-T09P	S6912
CNR/L..0014..	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
CNR/L..0757..1008..	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CNR..2510..	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CNL..2510..	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CNR..5012..	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CNL..5012..	MX16-1	GX16-0	GX16-2	GX16-4	GX16-98	GX16-99	–	T09P-2
CNR..7514..	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CNL..7514..	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2
CNR/L..0014..	MX16-1	GX16-0	GX16-2	GX16-3	GX16-4	GX16-98	GX16-99	T09P-2

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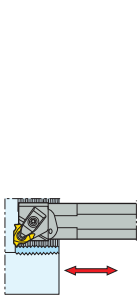
DCINN2, modified. Please see page 35

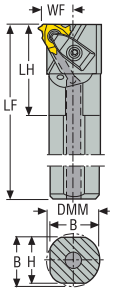
Toolholders, internal

For S-inserts, Snap-Tap®

CNR/L..AHD



CNR/L..APIHD

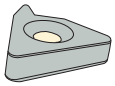


Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

Designation	Item number	DMM	H	B	LF	WF	LH	DCINN	DCINN2	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CNR001008-22AHD	02562797	1.000	0.902	0.957	7.917	0.709	1.736	1.200	1.000	2.870	22..
CNL001008-22AHD	02562803	1.000	0.902	0.957	7.917	0.709	1.736	1.200	1.000	1.760	22..
CNR0012510-22AHD	02562798	1.250	1.150	1.209	9.843	0.839	2.126	1.500	1.200	3.090	22..
CNL0012510-22AHD	02562804	1.250	1.150	1.209	9.843	0.839	2.126	1.500	1.200	3.090	22..
CNR0015012-22AHD	02562799	1.500	1.339	1.427	11.811	0.969	2.126	1.800	1.800	5.070	22..
CNL0015012-22AHD	02562805	1.500	1.339	1.427	11.811	1.183	2.126	1.800	1.800	5.290	22..
CNR0017514-22AHD	02562800	1.750	1.591	1.677	13.780	1.091	2.126	2.100	1.800	8.160	22..
CNL0017514-22AHD	02562806	1.750	1.591	1.677	13.780	1.091	2.126	2.100	1.800	8.380	22..
CNR0020014-22AHD	02562801	2.000	1.843	1.929	13.780	1.209	2.323	2.300	2.000	11.020	22..
CNL0020014-22AHD	02562807	2.000	1.843	1.929	13.780	1.209	2.323	2.300	2.000	11.020	22..
CNR0025016-22AHD	02562802	2.500	2.343	2.429	15.748	1.457	2.402	2.800	2.500	20.280	22..
CNL0025016-22AHD	02562808	2.500	2.343	2.429	15.748	1.457	2.402	2.800	2.500	20.060	22..
CNR00200T22APIHD	02562815	2.000	1.843	1.929	12.000	0.880	5.000	1.600	–	8.380	22..
CNR00250T22APIHD	02562816	2.500	2.343	2.429	12.000	0.880	5.000	1.600	–	11.900	22..

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp kit	Clamp screw	Insert shim (S)	Shim/clamp key	Shim screw	Spring
								
CNR..1008..2510..	–	–	CSP22HD-T15P	–	NX22-1	T15P-2	CS4009-T15P	–
CNL..1008..2510..	–	T15P-2	CSP22HD-T15P	–	NX22-1	–	CS4009-T15P	–
CNR/L..5012..5016..	CHD22	T20P-7L	–	L86025-T20P	NX22-1	–	CS4009-T15P	S7616
CNR..200..250T..	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
CNR..1008..2510..	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	–
CNL..1008..2510..	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	–
CNR/L..5012..5016..	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
CNR..200..250T..	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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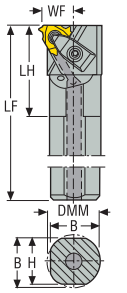
DCINN2, modified. Please see page 35

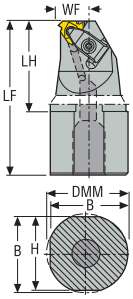
Toolholders, internal

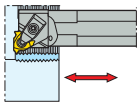
For S-inserts, Snap-Tap®

CNR/L..AHD



CNR/L..APIHD



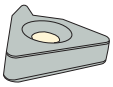


Right-hand version shown

• For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

Designation	Item number	DMM	H	B	LF	WF	LH	DCINN	DCINN2	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CNR0015012-27AHD	02562809	1.500	1.339	1.427	11.811	1.020	2.441	1.900	1.500	5.290	27..
CNL0015012-27AHD	02562812	1.500	1.339	1.427	11.811	1.020	2.441	1.900	1.500	5.290	27..
CNR0017514-27AHD	02562810	1.750	1.591	1.677	13.780	1.150	2.402	2.200	1.800	8.380	27..
CNL0017514-27AHD	02562813	1.750	1.591	1.677	13.780	1.150	2.402	2.200	1.800	8.380	27..
CNR0020014-27HD	02790281	2.000	1.843	1.929	13.780	1.346	2.283	2.362	2.000	11.460	27..
CNR0025016-27AHD	02562811	2.500	2.343	2.429	15.748	1.520	2.756	2.900	2.500	20.060	27..
CNL0025016-27AHD	02562814	2.500	2.343	2.429	15.748	1.520	2.756	2.900	2.500	20.280	27..
CNR00200T27APIHD	02562819	2.000	1.843	1.929	12.000	0.900	5.000	1.600	1.600	8.380	27...
CNR00250T27APIHD	02562820	2.500	2.343	2.429	12.000	0.900	5.000	1.600	1.600	12.130	27...

Spare Parts

For holders	Cantilever clamp	Clamp key	Clamp screw	Insert shim (S)	Shim screw	Spring
						
CNR/L..15012-25016..	CHD27	T20P-7L	L86025-T20P	VX27-1	C05012-T15P	S7616
CNR..200..250T..	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
CNR/L..15012-25016..	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
CNR..200..250T..	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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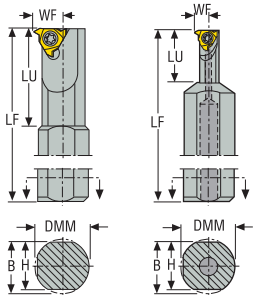
DCINN2, modified. Please see page 35

Toolholders, internal

For S-inserts, Snap-Tap®

SNR...09A SNR/L..



Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

Designation	Item number	DMM	H	B	LF	WF	LU	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
SNR00075055-09A	00086856	0.750	0.691	0.707	5.500	0.201	–	0.660	09NR..
SNR00037540-11	00072380	0.375	0.336	0.350	4.000	0.285	–	0.220	11NR..
SNL00037540-11	00072403	0.375	0.336	0.350	4.000	0.285	–	0.220	11NL..
SNR0005055-11	00072332	0.500	0.441	0.470	5.500	0.315	1.250	0.660	11NR..
SNL0005055-11	00072405	0.500	0.441	0.470	5.500	0.315	–	0.660	11NL..
SNR00037560-11-H	00072376	0.375	0.336	0.350	6.000	0.285	–	0.440	11NR..
SNR00062560-16	00072374	0.625	0.566	0.587	6.000	0.406	–	0.660	16NR..
SNL00062560-16	00072407	0.625	0.566	0.587	6.000	0.406	–	0.660	16NL..
SNR00062580-16-H	00072330	0.625	0.566	0.587	8.000	0.406	–	1.540	16NR..
SNR0007570-22	00072314	0.750	0.691	0.707	7.000	0.492	–	1.100	22NR..
SNL0007570-22	00072411	0.750	0.691	0.707	7.000	0.492	–	0.880	22NL..
SNR00075010-22-H	00072370	0.750	0.691	0.707	10.000	0.492	–	2.650	22NR..

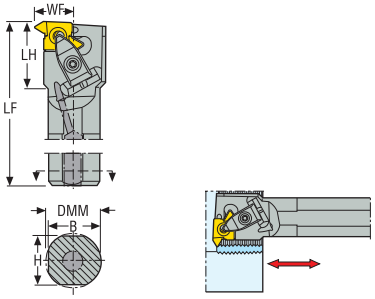
Spare Parts

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

Please check availability at www.secotools.com / Seco Online Store

Toolholders, internal

For K-inserts, Snap-Tap®

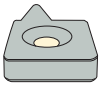


- For inserts program, see page(s) 123, 125, 152, 154, 156

Right-hand version shown

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

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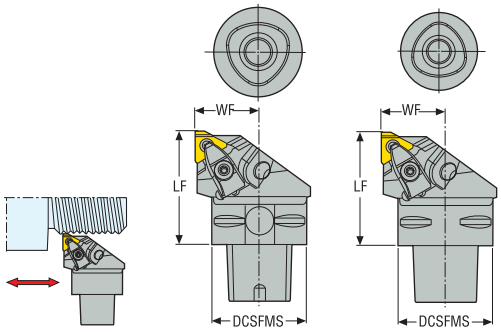
DCINN2, modified. Please see page 35

Seco-Capto™ – Toolholders, external

For S-inserts, Snap-Tap®

CER/L-.. HD CER/L-..CHD

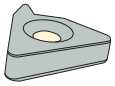


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 159, 161, 163, 165, 167

Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm *Inch*	mm *Inch*	mm *Inch*	kg *lbs*	
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..

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

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

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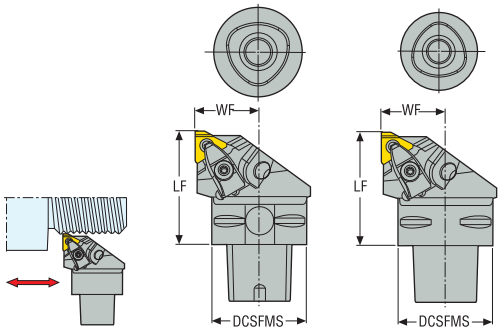
Seco-Capto™ – Toolholders, external

For S-inserts, Snap-Tap®

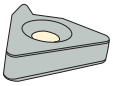


Right-hand version shown

- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157

Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm *Inch*	mm *Inch*	mm *Inch*	kg *lbs*	
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
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
							
...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
...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

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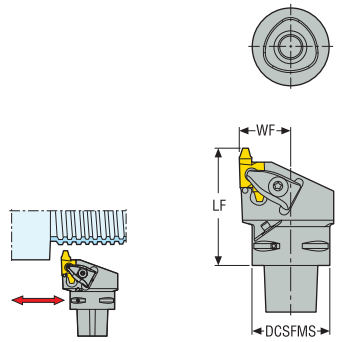
Seco-Capto™ – Toolholders, external

For K-inserts, Snap-Tap®

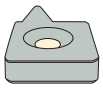


Right-hand version shown

• For inserts program, see page(s) 122-125, 151, 153, 155

Designation	Item number	DCSFMS	LF	WF	Weight	CTWS
		mm *Inch*	mm *Inch*	mm *Inch*	kg *lbs*	
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

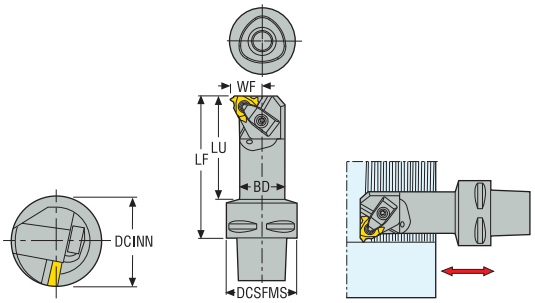
Accessories

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 / Seco Online Store

Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®

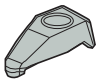
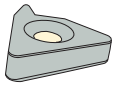


Right-hand version shown

• For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

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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Seco-Capto™ – Toolholders, internal

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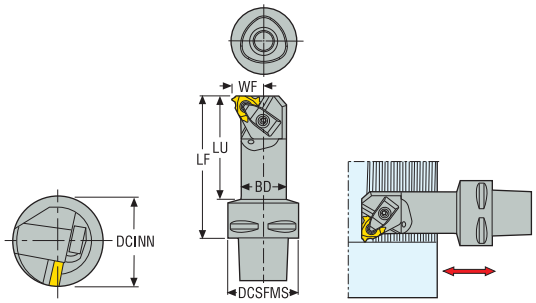

Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

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	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
...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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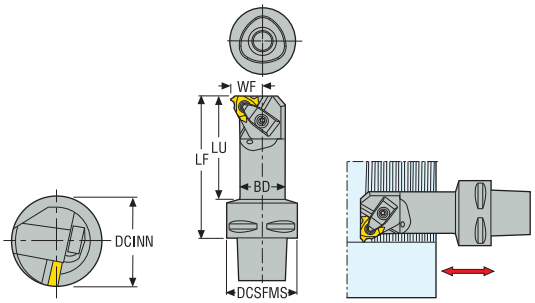
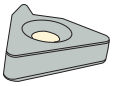


Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 164

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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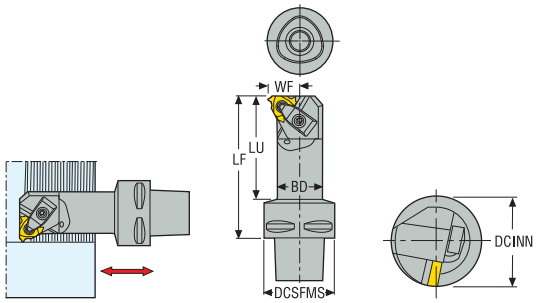
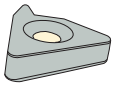


Right-hand version shown

• For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 146, 150, 152, 154, 156, 158, 160, 162, 166, 168

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-18075-22HD	02555772	25,0 *0.984*	63,0 *2.480*	75,0 *2.953*	17,8 *0.701*	30,0 *1.181*	53,0 *2.087*	0,9 *1.980*	22
C6-CNR-22090-22HD	02555773	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-26105-22HD	02555776	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-18075-22HD	02555777	25,0 *0.984*	63,0 *2.480*	75,0 *2.953*	17,8 *0.701*	30,0 *1.181*	53,0 *2.087*	0,9 *1.980*	22
C6-CNL-22090-22HD	02555832	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-26105-22HD	02555833	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
							
..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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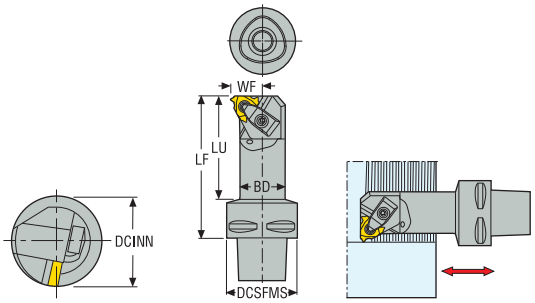
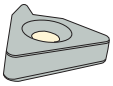


Right-hand version shown

- For inserts program, see page(s) 128, 129, 130 133, 134, 150, 152, 154, 156, 158, 160, 162, 164

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

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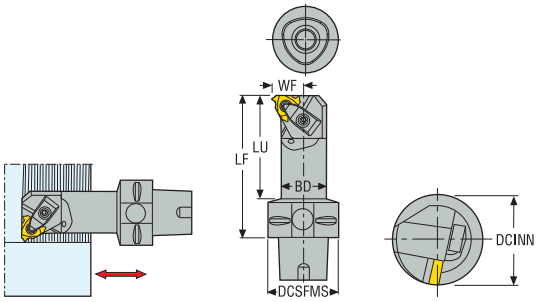
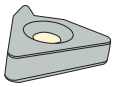


Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

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-CNR-14060-16CHD	02555834	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-14060-16CHD	02555835	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
C5-CNR-17070-16CHD	02555836	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-20090-16CHD	02555837	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-17070-16CHD	02555839	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-20090-16CHD	02555840	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-18070-22CHD	02555841	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-18070-22CHD	02555842	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

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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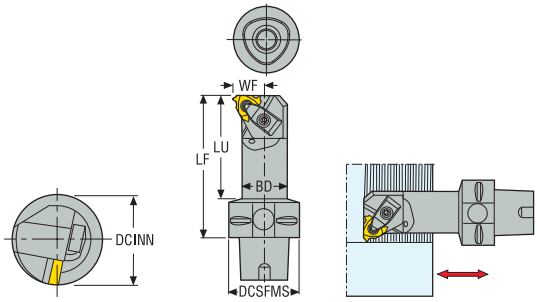
Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®

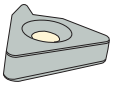


Right-hand version shown

• For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 158, 160, 162, 164, 166, 168

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-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

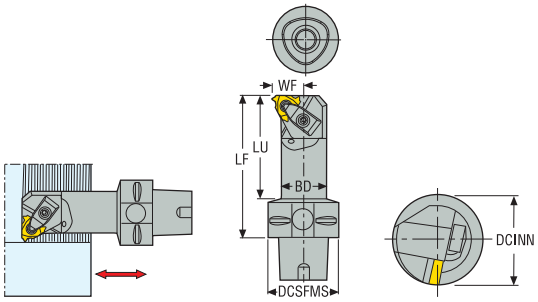
Accessories

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

Please check availability at www.secotools.com / Seco Online Store

Seco-Capto™ – Toolholders, internal

For S-inserts, Snap-Tap®

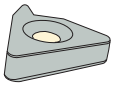


Right-hand version shown

- For inserts program, see page(s) 128, 129, 130, 133, 134, 150, 152, 154, 156, 158, 160, 162, 164

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-26105-27CHD	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

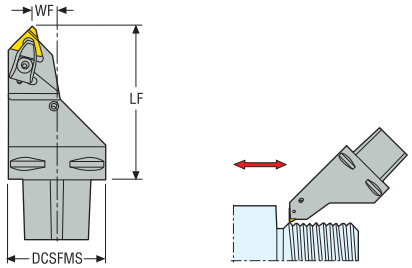
Accessories

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 / Seco Online Store

Seco-Capto™ – Toolholders for MTM

For S-inserts, Snap-Tap®

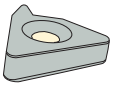


Right-hand version shown

• For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 159, 161, 163, 165, 167

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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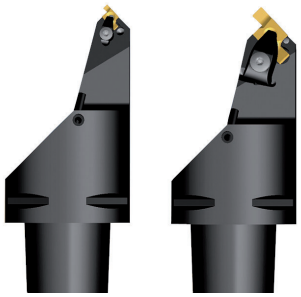
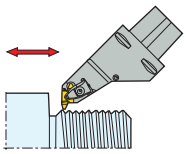
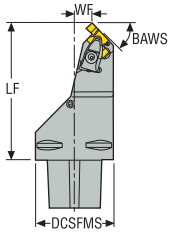
Seco-Capto™ – Toolholders for MTM

For K-inserts, Snap-Tap®





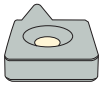


• For inserts program, see page(s) 122-125, 151, 153, 155

Left-hand version shown

Designation	Item number	DCSFMS mm *Inch*	LF mm *Inch*	WF mm *Inch*	Weight kg *lbs*	BAWS°	CTWS
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

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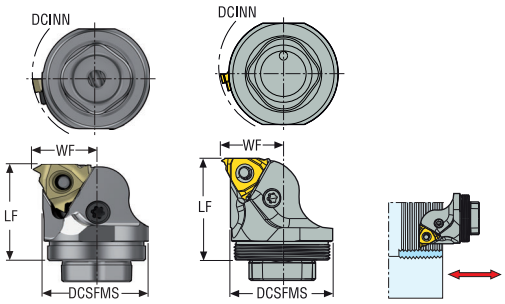
Steadyline®, GL-heads, Jetstream Tooling®

For S-inserts, Snap-Tap®

..16AHDJET ..22/32AHDJET



Right-hand version shown

- For inserts program, see page(s) 123, 125, 128, 129, 130, 133, 134, 136, 138, 141, 142, 144, 146, 148, 150, 152, 154, 156, 164
- 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

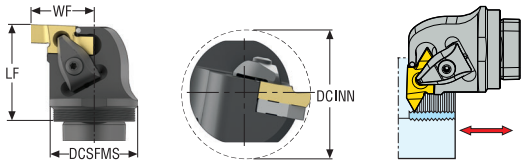
Accessories

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 / Seco Online Store

Steadyline®, GL-heads

For K-inserts, Snap-Tap®

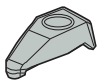
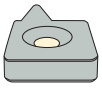


Right-hand version shown

- For inserts program, see page(s) 122-125, 152, 154, 156
- 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

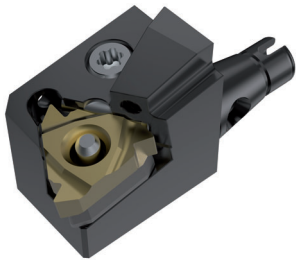
Accessories

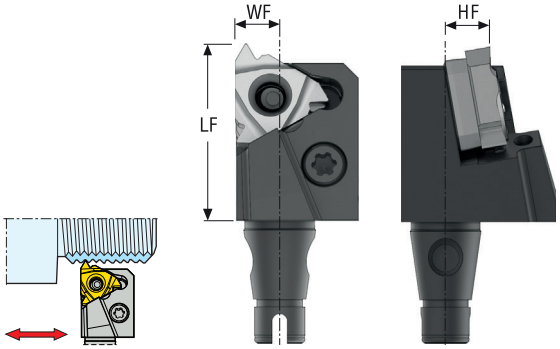
For holders	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Insert shim (K) 6	Shim key
GL50...	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2

Please check availability at www.secotools.com / Seco Online Store

Quick Change, Jetstream Tooling® QC-heads – External

For S-inserts, Snap-Tap®





Right-hand version shown

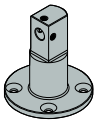
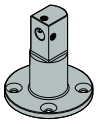
- For inserts program, see page(s) 122, 123, 124, 126, 127, 131, 132, 135, 137, 139, 140, 143, 145, 147, 149, 151, 153, 155, 157, 167
- CP * Max coolant pressure
- For Technical Guide, se catalog Turning

Designation	Item number	LF	WF	HF	CP*	Weight	CTWS
		mm *Inch*	mm *Inch*	mm *Inch*	bar *psi*	kg *lbs*	
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

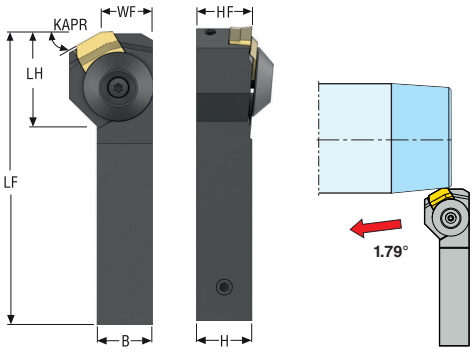
For holders	Insert lever	Insert shim (S)	Lever key	Lever screw	Shim pin
QC12/16	PP3712	GXA16-1	T15P-2	LS0612-T15P	AC4625

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 / Seco Online Store

Toolholder for peeling

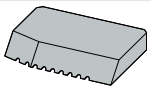


Right-hand version shown

• For inserts program, see page(s) 121

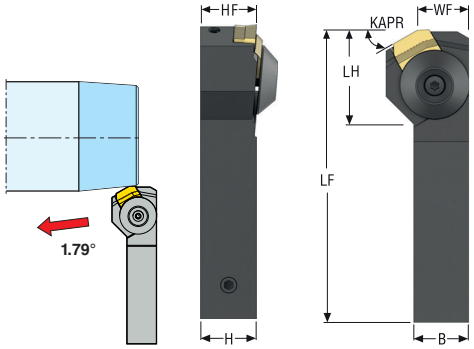
Designation	Item number	KAPR°	B	H	LF	LH	WF	HF	Weight	CTWS
		–	mm	mm	mm	mm	mm	mm	kg	
CSXCR3232P25-R30	03120990	30	32,0	32,0	170,0	64,61	29,53	32,0	0,5	SCNN-R30

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 / Seco Online Store

Toolholder for peeling

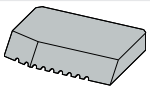


Right-hand version shown

• For inserts program, see page(s) 121

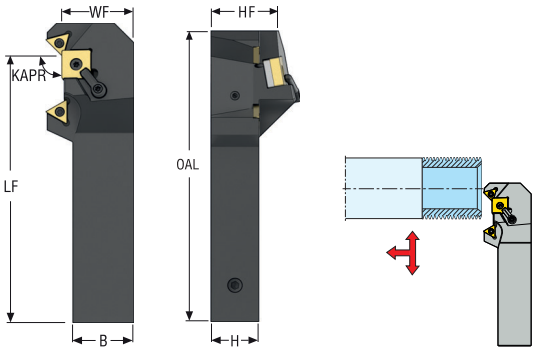
Designation	Item number	KAPR°	B	H	LF	LH	WF	HF	Weight	CTWS
			Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CSXCR20-8D-R30	03120991	30	1.250	1.250	6.693	2.545	1.163	1.250	3.530	SCNN-R30

Spare Parts

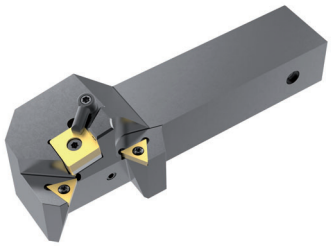
For holders	Anvil screw	Chipbreaker	Insert screw	Key	Key (T-handle)	Plug	Shim
							
CSXCR...	CA4012	PS2518	W400820-T30P	H6B-T30PL	DOUBLE-T	JET-P1/8-5MM	SSN250630

Please check availability at www.secotools.com / Seco Online Store

Toolholder for pipe-facing



Right-hand version shown



- For inserts programme, see catalog Turning

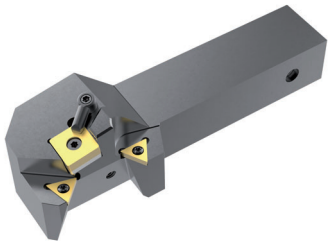
Designation	Item number	KAPR°	B	H	LF	WF	HF	OAL	Weight	CTWS	CTWS
			mm	mm	mm	mm	mm	mm	kg		
MSGNR3240R19-TC-45-60	03120992	90,0	40,0	32,0	174,0	47,0	32,0	195,6	0,7	SN...1906... TCMT16T3...	SN...1906... TCMT16T3...

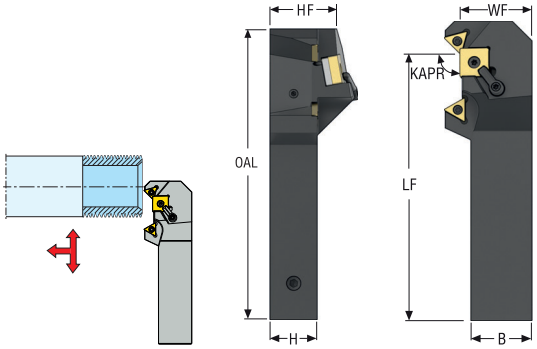
Spare Parts

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 / Seco Online Store

Toolholder for pipe-facing



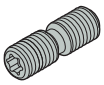


- For inserts programme, see catalog Turning

Right-hand version shown

Designation	Item number	KAPR°	B	H	LF	WF	HF	OAL	Weight	CTWS	CTWS
			Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	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...

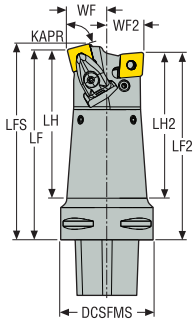
Spare Parts

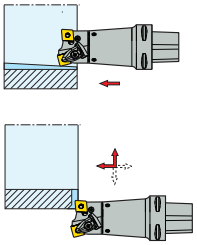
For holders	Cantilever clamp	Clamp screw	Insert key	Insert screw	Insert shim	Key	Key (T-handle)	Plug	Shim pin
									
MSGNR...	MC22	LD6024-T20P	H4B-T15P	C03508-T15P	SSN190412	H6B-T20P	DOUBLE-T	JET-P1/8-5MM	MN1920-T20P

Please check availability at www.secotools.com / Seco Online Store

Seco-Capto™, Multi insert pocket tools, internal

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



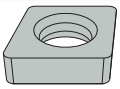


Right-hand version shown
KAPR = 75°
C.-DSKNR/L - CLNR/L 75°

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

Designation	Item number	Seco-Capto size	CTWS	CTWS	GAMO°	LAMS°	DCSFMS	LF	LF2	LFS	LH	LH2	WF	WF2	Weight	CTWS	CTWS
							mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	kg *lbs*		
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

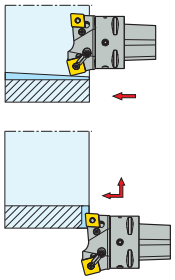
Accessories

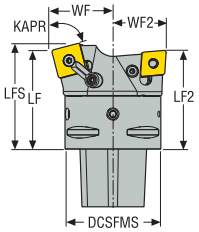
For holders	Clamp kit	Key	Lever key
C6	CD16-S16	T20P-7L	3SMS795

Please check availability at www.secotools.com / Seco Online Store

Seco-Capto™, Multi insert pocket tools, internal

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



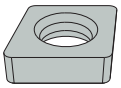


- For inserts program, se catalog Turning
- GAMO° = Rake angle, LAMS° = Inclination angle

Right-hand version shown
KAPR = 75°
C.-DSKNR/L - CLNR/L 75°

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.. CN..1606..	SN..1906.. 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.. CN..1606..	SN..1906.. 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.. CN..1606..	SN..1906.. 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.. CN..1606..	SN..1906.. 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

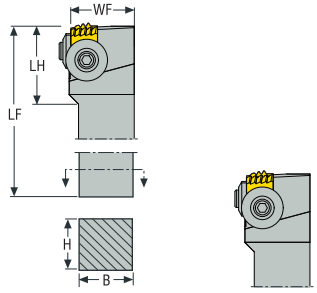
Accessories

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

Please check availability at www.secotools.com / Seco Online Store

Toolholders for chasers, external

Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 169, 170

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

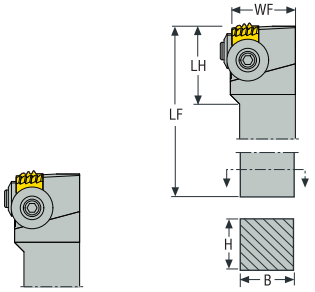
Spare Parts

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 / Seco Online Store

Toolholders for chasers, external

Snap-Tap®



Right-hand version shown

- For inserts program, see page(s) 169, 170

Designation	Item number	B	H	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	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

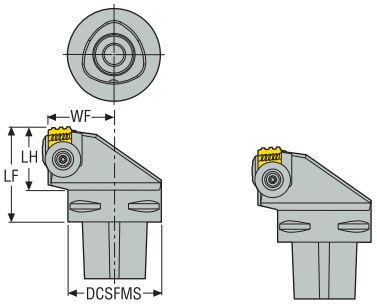
Spare Parts

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 / Seco Online Store

Seco-Capto™ – Toolholders for chasers, external

Snap-Tap®



Right-hand version shown

• For inserts program, see page(s) 169, 170

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

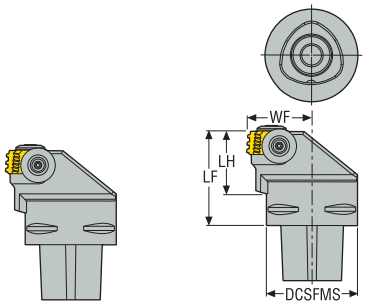
Spare Parts

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 / Seco Online Store

Seco-Capto™ – Toolholders for chasers, internal

Snap-Tap®



Right-hand version shown

• For inserts program, see page(s) 169, 170

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

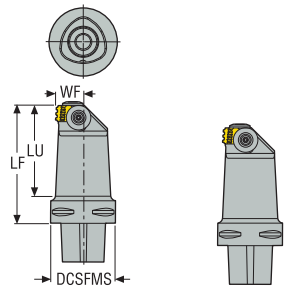
Spare Parts

For holders	Clamp kit side	Clamp kit top	Coolant nozzle	Key, side clamp	Key, top clamp
...CNR...	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 / Seco Online Store

Seco-Capto™ – Toolholders for chasers, internal

Snap-Tap®



Right-hand version shown

• For inserts program, see page(s) 169, 170

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

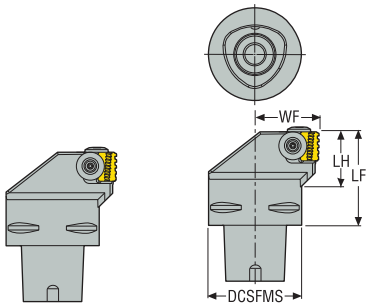
Spare Parts

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 / Seco Online Store

Seco-Capto™ – Toolholders for chasers, internal

Snap-Tap®



Left-hand version shown

• For inserts program, see page(s) 169, 170

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

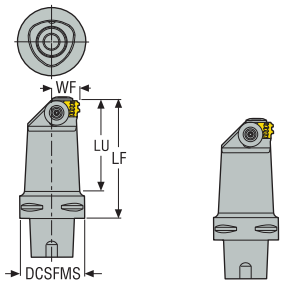
Spare Parts

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 / Seco Online Store

Seco-Capto™ – Toolholders for chasers, internal

Snap-Tap®



Left-hand version shown

• For inserts program, see page(s) 169, 170

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

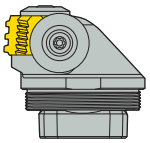
Spare Parts

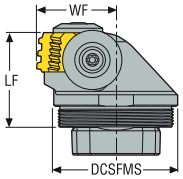
For holders	Clamp kit side	Clamp kit top	Coolant nozzle	Key, side clamp	Key, top clamp
C6...	W240618-T25P	W200613-T20P	CN6	T25P-7	T20P-7

Please check availability at www.secotools.com / Seco Online Store

Steadyline®, GL-heads – Toolholders for chasers, internal

Snap-Tap®





- For inserts program, see page(s) 169, 170

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

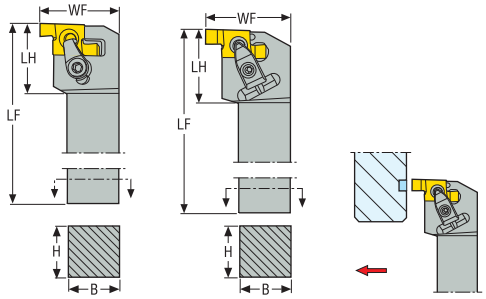
For holders	Clamp kit side	Clamp kit top	Key, clamp	Key, side clamp	Key, top clamp	Key (T-handle)
...9-1	–	W200613-T20P	H6B-T20P	–	–	DOUBLE-T
...1-X, ...5-X	W200613-T20P	W240618-T25P	–	H6B-T20P	H6B-T25P	DOUBLE-T

Please check availability at www.secotools.com / Seco Online Store

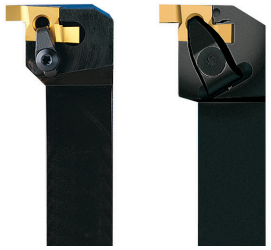
Toolholders for Precision Axial Grooves

Snap-Tap®

CEAR/L..D CEAR/L..HD/QHD



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



- For inserts program and INPLM, se 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

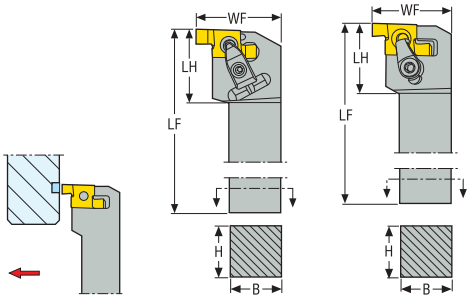
For holders	Insert shim (K)	Shim key
CEAR..10	KX12-2	T07P-2
CEAL..10	KX12-2	T07P-2
CEAR..14	–	T09P-2
CEAL..14	–	T09P-2
CEAR..20	–	T15P-2
CEAL..20	–	T15P-2

Please check availability at www.secotools.com / Seco Online Store

Shim KX12-2 for insert 12..

Toolholders for Precision Axial Grooves

Snap-Tap®



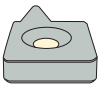
- For inserts program, see catalog Turning

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CEAR1006-10	00072625	1.000	1.000	6.000	1.392	1.110	2.200	10/12EAR
CEAL1006-10	00072613	1.000	1.000	6.000	1.392	1.110	1.980	10/12EAL
CEAR1006-14	00072623	1.000	1.000	6.000	1.451	1.110	2.200	14EAR

Spare Parts

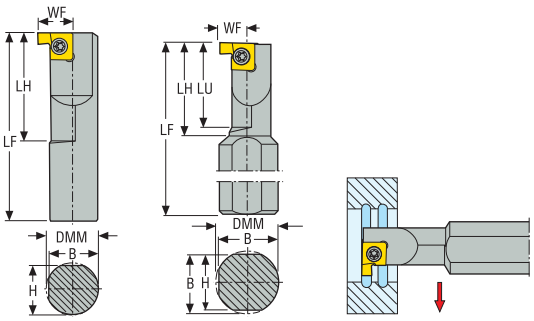
For size	Clamp key	Clamp kit	Insert shim	Insert shim (KL)	Insert shim (KR)	Shim key	Shim screw
CEAR..-10	T15P-2	CSP16-T15P	–	–	AKR10	–	CS2507-T07P
CEAL..-10	T15P-2	CSP16-T15P	–	AKL10	–	–	CS2507-T07P
CEAR..-14	T15P-2	CSP16-T15P	AKR14	–	–	T09P-2	CS3507-T09P

Accessories

For size	Insert shim (K)	Shim key
		
CEAR..-10	–	T07P-2
CEAL..-10	KX12-2	T07P-2
CEAR..-14	–	–

Toolholders for Precision Grooves

SNR/L..H09 SNR/L Snap-Tap®



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..

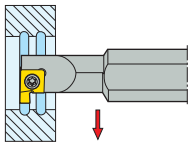
Spare Parts

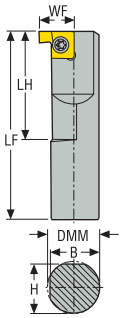
For holders	Insert key	Insert screw
..9	T07P-2	C02506-T07P

Please check availability at www.secotools.com / Seco Online Store

Toolholders for Precision Grooves

Snap-Tap®





- For inserts program, see catalog Turning

Right-hand version shown

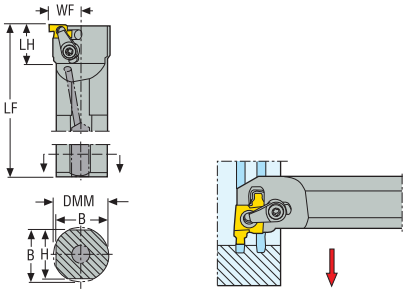
Designation	Item number	H	B	DMM	LF	LH	WF	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
SNR00037550-9	00072560	0.625	0.654	0.375	5.000	1.000	0.266	0.440	9..
SNR0005055-9	00072586	0.441	0.470	0.500	5.500	1.250	0.319	0.660	9..
SNR00062560-9	00072588	0.566	0.587	0.625	6.000	1.500	0.378	0.660	9..
SNL00037540-9	00072552	0.336	0.350	0.375	4.000	–	0.299	0.220	9..
SNL00037550-9	00072595	0.336	0.350	0.375	5.000	1.000	0.259	0.440	9..
SNR00037560-9-H	00072562	0.441	0.350	0.375	6.000	–	0.299	0.660	9..

Spare Parts

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

Toolholders for Precision Grooves

Snap-Tap®



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

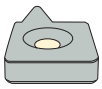
- For inserts program, see catalog Turning
- DCINN - minimum bore diameter

Designation	Item number	H	B	LF	WF	WF2	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

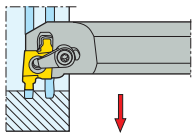
For holders	Insert shim (K)	Shim key
		
..10	KX12-2	T07P-2
..14	–	T09P-2

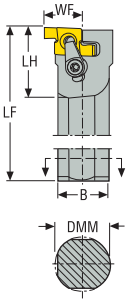
Please check availability at www.secotools.com / Seco Online Store

Shim KX12-2 for insert 12..

Toolholders for Precision Grooves

Snap-Tap®



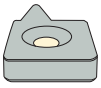


- For inserts program, see catalog Turning

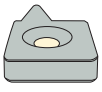
Right-hand version shown

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CNR000757-10	00072573	0.691	0.707	7.000	0.490	1.480	1.100	10../12..
CNL000757-10	00072624	0.650	0.707	7.000	0.490	1.480	0.880	10../12..
CNR001008-10	00072569	0.921	0.957	8.000	0.618	2.500	1.760	10../12..
CNL001008-10	00072610	0.902	0.957	8.000	0.620	1.559	1.760	10../12..
CNR0012510-10	00072563	1.150	1.209	10.000	0.750	1.772	3.310	10../12..
CNR0015012-10	00072592	1.339	1.427	12.008	0.858	1.772	5.730	10../12..
CNR00075010-10-H	00072583	0.691	0.730	10.000	0.490	1.480	2.650	10../12..
CNR000757-14	00072571	0.691	0.707	7.000	0.570	1.693	0.880	14..
CNR001008-14	00072567	0.921	0.957	8.000	0.700	1.732	1.980	14..
CNL001008-14	00072582	1.000	0.961	8.000	0.704	–	1.760	14..
CNR0012510-14	00072561	1.150	1.209	10.000	0.831	1.969	3.530	–

Spare Parts

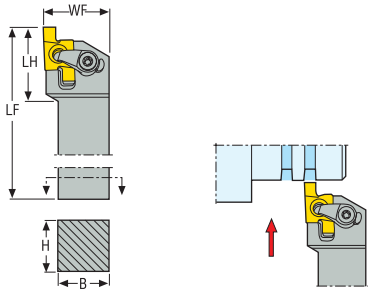
For size	Clamp key	Clamp kit	Insert shim (K)	Shim screw
				
..-10	T15P-2	CSP16-T15P	KX10-2	CS2507-T07P
..-10-10-H	T15P-2	CSP16-T15P	KX10-2	CS2507-T07P
..-14	T15P-2	CSP16-T15P	KX14-2	CS3507-T09P

Accessories

For size	Insert shim (K)	Shim key
		
..-10	KX12-2	T07P-2
..-10-10-H	–	T07P-2
..-14	–	–

Toolholders for Precision Grooves

Snap-Tap

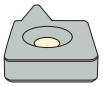


Right-hand version shown

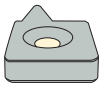
- For inserts program, see catalog Turning

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CER0504-10Q	00072566	0.500	0.500	4.000	0.625	0.900	0.440	10../12..
CER0755-10Q	00072564	0.750	0.750	5.000	1.000	0.900	1.100	10../12..
CEL0755-10Q	00072559	0.750	0.750	5.000	1.000	0.900	1.100	10../12..
CER1006-10Q	00072600	1.000	1.000	6.000	1.250	0.900	1.980	10../12..
CEL1006-10Q	00072596	1.000	1.000	6.000	1.250	0.900	1.980	10../12..
CER1006-14Q	00072634	1.000	1.000	6.000	1.250	1.100	1.760	14..
CEL1006-14Q	00072628	1.000	1.000	6.000	1.250	1.100	1.980	14..

Spare Parts

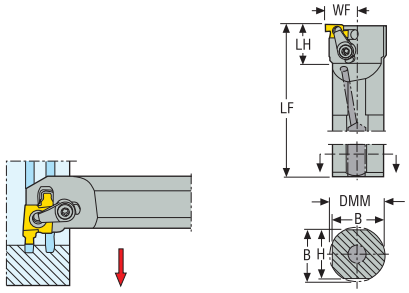
For size	Clamp key	Clamp kit	Insert shim (K)	Shim screw
				
..-10Q	T15P-2	CSP16-T15P	KX10-2	CS2507-T07P
R..-14Q	T15P-2	CSP16-T15P	KX14-2	CS3507-T09P
L..-14Q	T15P-2	CSP16-T15P	KX14-2	CS3507-T09P

Accessories

For size	Insert shim (K)	Shim key
		
..-10Q	KX12-2	T07P-2
R..-14Q	–	T09P-2
L..-14Q	–	T09P-2

Toolholders for Precision Grooves

Snap-Tap®

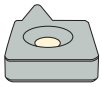


- For inserts program, see catalog Turning
- DCINN - minimum bore diameter

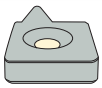
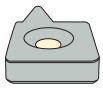
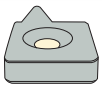
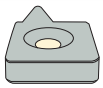
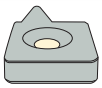
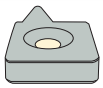
Right-hand version shown
WF (10../14../20../26..) = WF2 (12..)

Designation	Item number	DMM	H	B	LF	WF	LH	DCINN	DCINN2	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CNR001008-20AHD	02562823	1.000	0.902	0.957	7.992	0.705	1.969	1.400	–	1.540	20..
CNL001008-20AHD	02562826	1.000	0.902	0.957	7.992	0.705	1.969	1.400	–	1.540	20..
CNR0012510-20AHD	02562824	1.250	1.150	1.209	10.000	0.945	2.165	1.700	1.400	3.310	20..
CNL0012510-20AHD	02562827	1.250	1.150	1.209	10.000	0.945	2.165	1.700	1.400	3.310	20..
CNR0015012-20AHD	02562825	1.500	1.339	1.427	12.008	1.063	2.165	2.000	1.600	5.510	20..
CNL0015012-20AHD	02562828	1.500	1.339	1.427	12.008	1.063	2.165	2.000	1.600	5.510	20..
CNR0012510-26AHD	02562830	1.250	1.150	1.209	10.000	1.063	2.323	2.000	1.600	3.090	26..
CNL0012510-26AHD	02564043	1.250	1.150	1.209	10.000	1.063	2.323	2.000	1.600	3.090	26..
CNR0015012-26AHD	02562831	1.500	1.339	1.427	12.008	1.183	2.323	2.100	2.100	5.510	26..
CNL0015012-26AHD	02563555	1.500	1.339	1.427	12.008	1.177	2.323	2.100	2.100	5.510	26..
CNR0017514-26AHD	02562832	1.750	1.591	1.677	13.976	1.307	2.283	2.300	1.800	8.820	26..
CNL0017514-26AHD	02563563	1.750	1.591	1.677	13.976	1.307	2.283	2.300	1.800	8.820	26..
CNR0020014-26AHD	02562833	2.000	1.843	1.929	13.976	1.433	2.283	2.500	2.000	11.460	26..
CNR0025016-26AHD	02562834	2.500	2.343	2.429	15.984	1.683	2.283	3.000	2.500	20.720	26..
CNL0025016-26AHD	02563564	2.500	2.343	2.429	15.984	1.683	2.283	3.000	2.500	20.720	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
..-26	CHD27	T20P-7	L86025-T20P	KX26-2	C05012-T15P	S7616

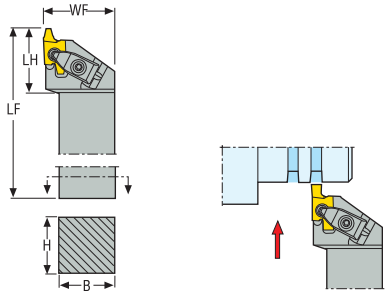
Accessories

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
..-26	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2

Please check availability at www.secotools.com / Seco Online Store

Toolholders for Precision Grooves

Snap-Tap

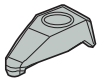
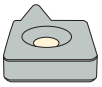


Right-hand version shown

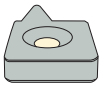
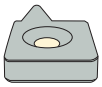
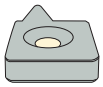
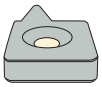
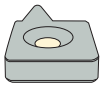
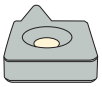
- For inserts program, see catalog Turning

Designation	Item number	H	B	LF	WF	LH	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs	
CER1006-20QHD	02529045	1.000	1.000	6.000	1.250	1.300	1.980	20..
CEL1006-20QHD	02529053	1.000	1.000	6.000	1.250	1.300	1.980	20..
CER1256-20QHD	02529057	1.250	1.250	6.000	1.500	1.417	2.870	20..
CEL1256-20QHD	02529061	1.250	1.250	6.000	1.500	1.300	2.870	20..
CER1006-26QHD	02529063	1.000	1.000	6.000	1.250	1.800	2.200	26..
CEL1006-26QHD	02529064	1.000	1.000	6.000	1.250	1.800	2.200	26..
CER1256-26QHD	02529066	1.250	1.250	6.000	1.500	1.800	3.090	26..
CER1506-26QHD	02529069	1.500	1.500	6.000	1.750	1.800	3.970	26..

Spare Parts

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

Accessories

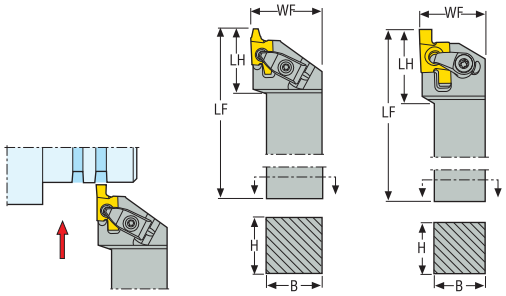
For size	Insert shim (K) 1	Insert shim (K) 2	Insert shim (K) 3	Insert shim (K) 4	Insert shim (K) 5	Insert shim (K) 6	Shim key
							
..-20Q	KX20-99	KX20-0	KX20-1	KX20-3	KX20-4	KX20-5	T15P-2
..-26Q	KX26-99	KX26-0	KX26-1	KX26-3	KX26-4	KX26-5	T15P-2

Toolholders for Precision Grooves

Snap-Tap®

- For inserts program, see catalog Turning

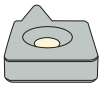
CER/L..D CER/L..QHD



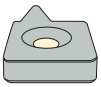
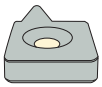
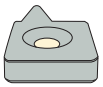
Right-hand version shown
LF (10../14..) = LF2 (12..)
LH (10../14..) = LH2 (12..)

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

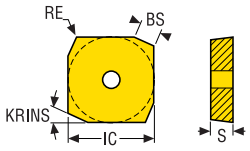
Accessories

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 / Seco Online Store

* Shim KX12-2 for insert 12..

SCNN for peeling

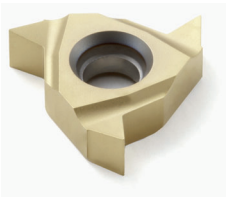


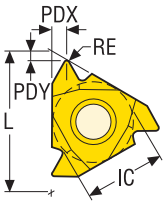
RE	BS	IC	S	KRINS°	Designation	Note	Grades
mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				**TP250T** Coated
4,0 *0.157*	6,6 *0.260*	25,0 *0.984*	6,35 *0.250*	28.0	SCNN250640-R30		■
4,0 *0.157*	6,2 *0.244*	25,0 *0.984*	6,35 *0.250*	23.0	SCNN250640-R25	*	■

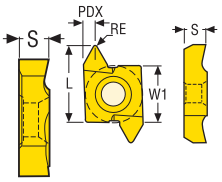
* R25 for use in 25 degree pockets only - not the 30degree - R30
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

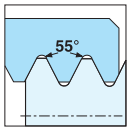
Partial Profile 55° – External Threading

Snap-Tap®









16ER..A

16ER..A1

16ER..A2

16Ex/22Ex

16V55*

26ER/26NR..

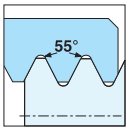
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP500** Coated
0,5-1,5	48.0-16.0	0,08 *0.003*	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			■				

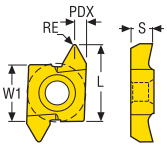
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

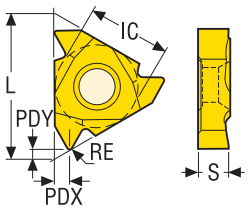
* Toolset contents: 3 pcs 16ERG55, CP500, 3 pcs 16NRG55, CP500, 2 pcs 16ERA55, CP500 and 2 pcs 16NRA55, CP500

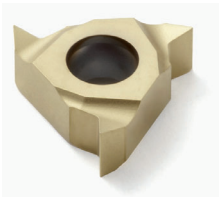
Partial Profile 55° – Internal Threading

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 / Seco Online Store

Partial Profile 60° – External Threading

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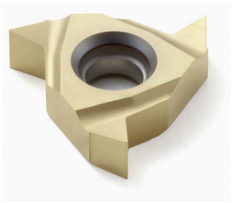
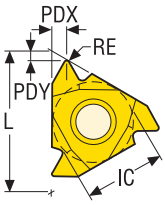
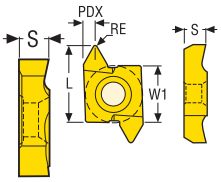
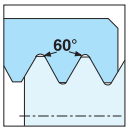








16ER..A

16ER..A1

16ER..A2

16Ex/22Ex..

16V60*

26ER/26NR..

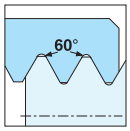
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP300** Coated	**CP500** Coated
0,5-1,5	48.0-16.0	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			■					

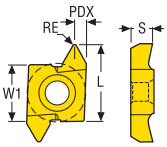
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

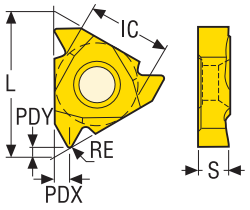
* Toolset contents:3 pcs 16ERG60, CP500, 3 pcs 16NRG60, CP500, 2 pcs 16ERA60, CP500 and 2 pcs 16NRA60, CP500

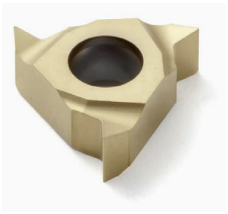
Partial Profile 60° – Internal Threading

Snap-Tap®









09NR/11Nx/16Nx/22Nx

11NR/16NR..A

11NR/16NR..A1

11NR/16NR..A2

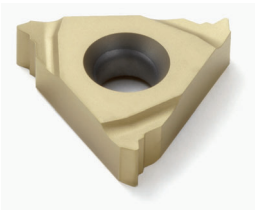
26ER/26NR..

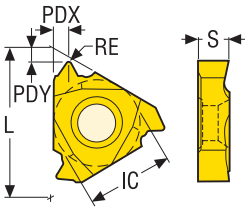
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP300 Coated	CP500 Coated
0,5-1,5	48.0-16.0	0,08 *0.003*	0,7 *0.028*	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	■	■

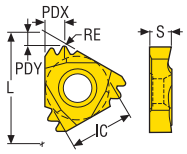
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

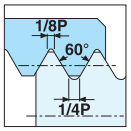
ISO Metric – External Threading

Snap-Tap®









ISO965/1 - 1980
3h/4h

16ER/22ER/27ER..M

16ER..A

16ER..A1

16ER..A2

16ER..TT

16Ex/22Ex/27ER

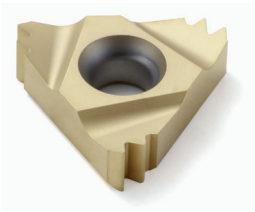
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP300 Coated	CP500 Coated
0,5-0,5	–	0,06 *0.002*	0,8 *0.031*	0,8 *0.031*	9,525 *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			■	■				

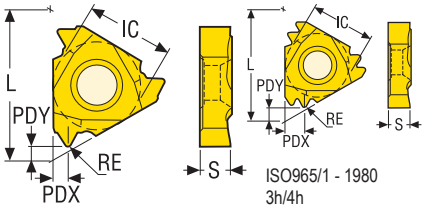
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP300** Coated	**CP500** Coated
3,0-3,0	–	0,42 *0.017*	1,2 *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			■					

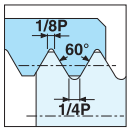
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

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		■

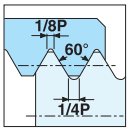
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
3,0-3,0	–	0,21 *0.008*	1,2 *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			■					

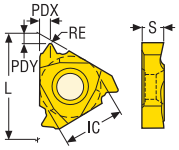
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
3,0-3,0	–	0,21 *0.008*	1,2 *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			■					

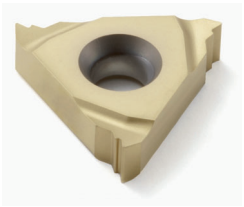
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

UN – External Threading

Snap-Tap®







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
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
–	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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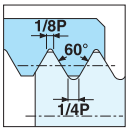
UN – Internal Threading

Snap-Tap®



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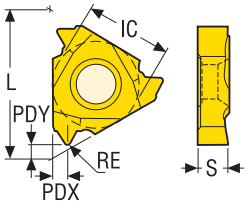
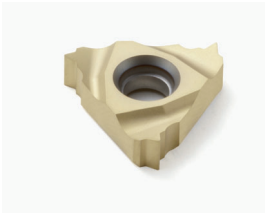




09NR/11Nx/16Nx/22Nx/27NR

16NR/22NR..M

16NR..A

16NR..A1

16NR..A2

16NR..TT

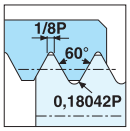
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
–	20.0-20.0	0,09 *0.004*	0,7 *0.028*	0,8 *0.031*	5,56 *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		■

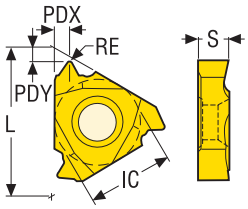
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
–	9.0-9.0	0,19 *0.007*	1,2 *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			■					

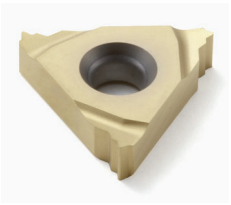
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

UNJ – External Threading ®

Snap-Tap







BS4084 - 1996
MIL-SPECS - 8879A
3A

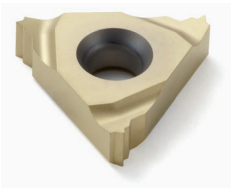
16Ex

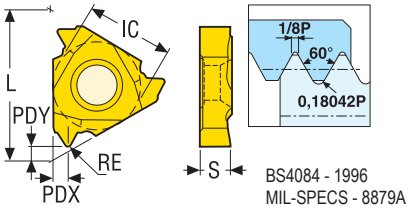
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades				
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated
–	32.0-32.0	0,13 *0.005*	0,8 *0.031*	0,8 *0.031*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16ER32UNJ	■		■		
–	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 / Seco Online Store

UNJ – Internal Threading

Snap-Tap®





BS4084 - 1996
MIL-SPECS - 8879A
3B

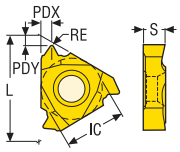
16Ex

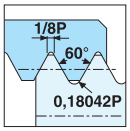
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades				
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated
–	32.0-32.0	0,03 *0.001*	1,2 *0.047*	0,4 *0.016*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16NR32UNJ	■				
–	28.0-28.0	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 / Seco Online Store

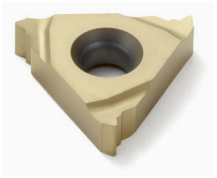
MJ – External Threading

Snap-Tap®





ISO5855 - 1983
4h/6h



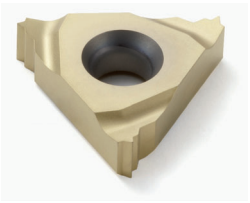
16Ex

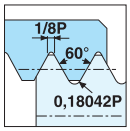
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
1,0-1,0	–	0,16 *0.006*	0,8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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

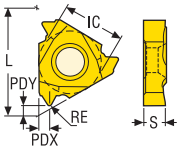
MJ – Internal Threading

Snap-Tap®





ISO5855 - 1983
4H/5H



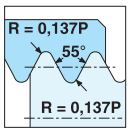
16Ex

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

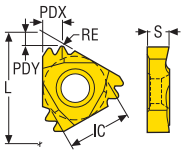
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

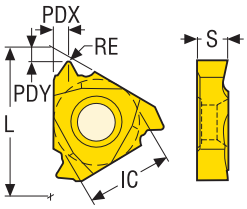
Whitworth, BSW – External Threading

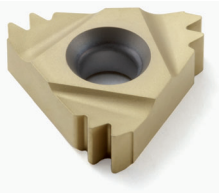
Snap-Tap®



BS84 -1956
ISO228 - 1982
BS2779 - 1973







16ER..A

16ER..A1

16ER..A2

16ER..TT

16Ex/22Ex

22ER..M

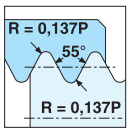
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
–	28.0-28.0	0,09 *0.004*	0,8 *0.031*	0,8 *0.031*	9,525 *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			■					

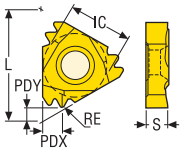
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

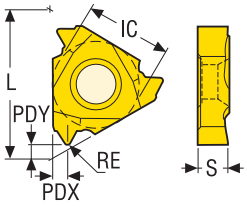
Whitworth, BSW – Internal Threading

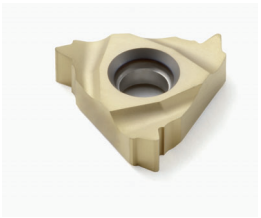
Snap-Tap®



BS84 -1956
ISO228 - 1982
BS2779 - 1973







09NR/11Nx/16Nx/22Nx

11NR/16NR..A

11NR/16NR..A1

11NR/16NR..A2

16NR..TT

22NR..M

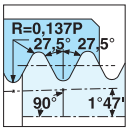
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CP200 Coated	CP300 Coated	CP500 Coated	TTP2050 Coated	H15 Uncoated		CP200 Coated	CP500 Coated
–	19.0-19.0	0,15 *0.006*	0,7 *0.028*	0,8 *0.031*	5,56 *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			■					

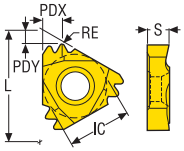
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
–	14.0-14.0	0,24 *0.009*	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 / Seco Online Store

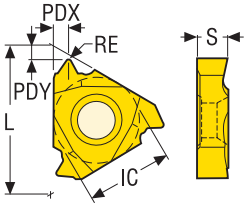
BSPT – External Threading

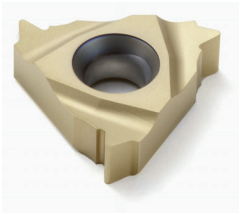
Snap-Tap®





ISO228/1 35 21 1959 ISO7/1





16ER..TT

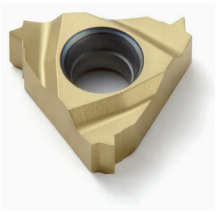
16Ex..

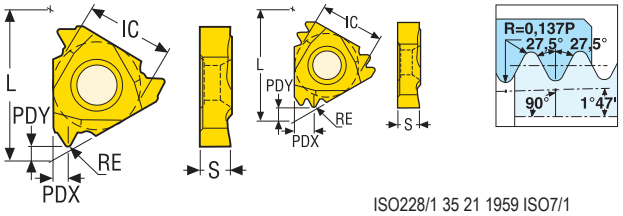
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
–	28.0-28.0	0,08 *0.003*	0,7 *0.028*	0,8 *0.031*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16ER28BSPT			■					
–	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*	16ER19BSPT			■					
–	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*	16ER14BSPT			■			16EL14BSPT		■
–	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*	16ER11BSPT			■			16EL11BSPT		■
–	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*	16ER14BSPT-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*	16ER11BSPT-TT			■					

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

BSPT – Internal Threading

Snap-Tap®





ISO228/1 35 21 1959 ISO7/1

09NR/16Nx..

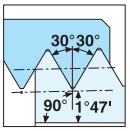
16NR..TT

Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *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*	0,8 *0.031*	0,8 *0.031*	5,56 *0.219*	9,6 *0.378*	2,4 *0.094*	09NR19BSPT			■					
–	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*	16NR14BSPT			■			16NL14BSPT		■
–	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*	16NR11BSPT			■			16NL11BSPT		■
–	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*	16NR14BSPT-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*	16NR11BSPT-TT			■					

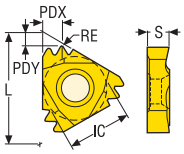
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

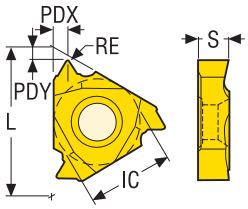
NPT– External Threading

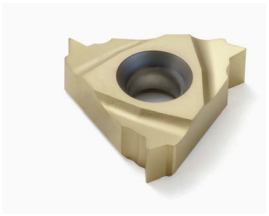
Snap-Tap®



ANSI B1.20.1 - 1983







16ER..A1

16ER..A2

16Ex..

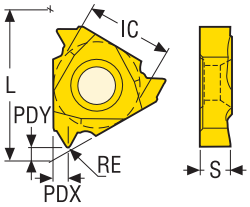
22ER/27ER..M

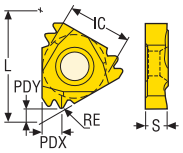
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
–	27.0-27.0	0,04 *0.002*	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			■					

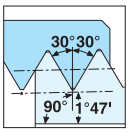
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

NPT – Internal Threading

Snap-Tap®







ANSI B1.20.1 - 1983

09NR/11NR/16Nx

16NR..A1

16NR..A2

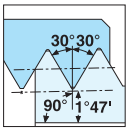
22NR..M

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			■					

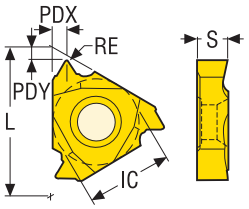
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

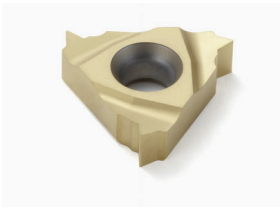
NPTF– External Threading

Snap-Tap®



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





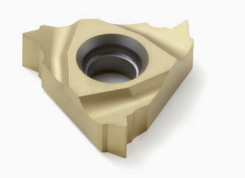
16ER..

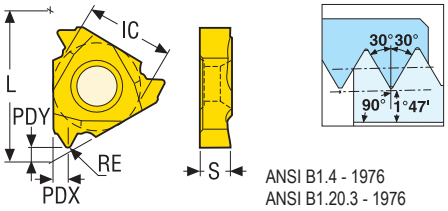
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
–	27.0-27.0	0,04 *0.002*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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

NPTF – Internal Threading

Snap-Tap®





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

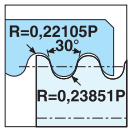
11NR/16Nx

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
–	18.0-18.0	0,04 *0.002*	0,7 *0.028*	0,8 *0.031*	6,35 *0.250*	11,0 *0.433*	3,0 *0.118*	11NR18NPTF			■					
–	14.0-14.0	0,05 *0.002*	1,1 *0.043*	1,5 *0.059*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16NR14NPTF			■					
–	11.5-11.5	0,06 *0.002*	1,1 *0.043*	1,5 *0.059*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16NR11.5NPTF			■			16NL11.5NPTF		■

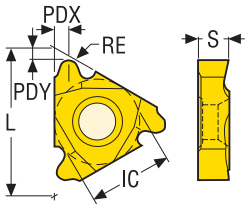
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

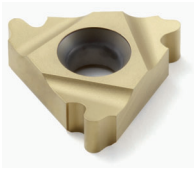
Round-DIN405 – External Threading

Snap-Tap®



DIN405 - 1981
7h/6h





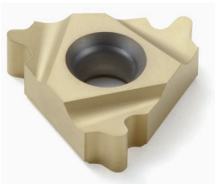
16ER/22Ex/27ER

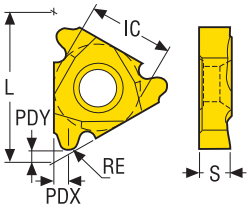
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
–	10.0-10.0	0,58 *0.023*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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

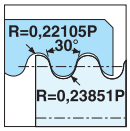
Round-DIN405 – Internal Threading

Snap-Tap®





DIN405 - 1981
7h/6h



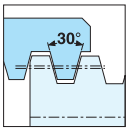
16NR/22Nx/27NR

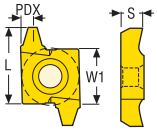
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades	
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP200** Coated	**CP500** Coated
–	10.0-10.0	0,51 *0.020*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

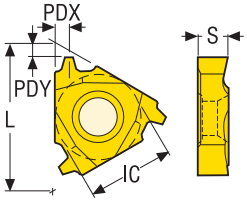
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

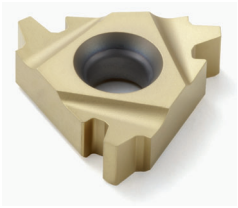
TR-DIN103 – External Threading

Snap-Tap®









DIN103 - 1977
ISO2901/3 - 1977
7e

16Ex/22Ex27ER

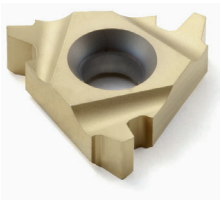
20ER/26ER

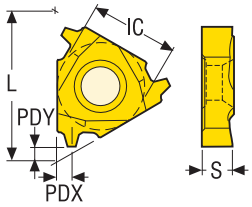
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP500** Coated
1,5-1,5	–	– –	0,9 *0.035*	0,8 *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 / 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		**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*	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 / Seco Online Store

ACME – External Threading

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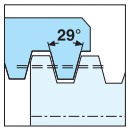

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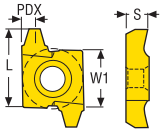

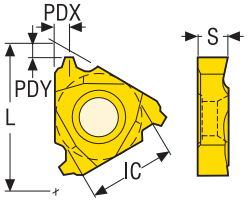

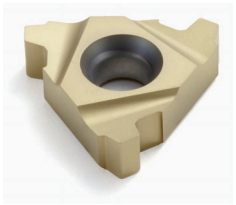

16Ex/22Ex/27Ex

20ER/26ER

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

ACME – Internal Threading

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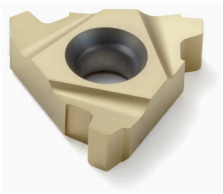

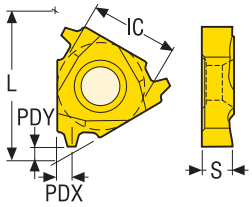

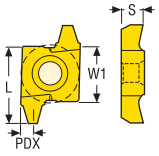

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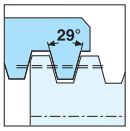


16NR/22Nx/27NR

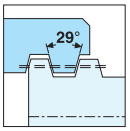
20NR/26NR

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 / Seco Online Store

Stub-ACME – External Threading

Snap-Tap®



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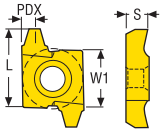
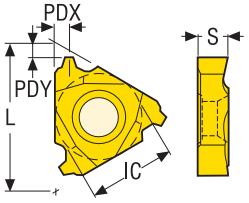
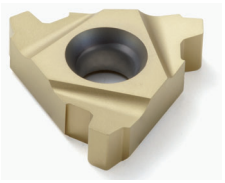
2G







16ER

16ER/22Ex/27ER

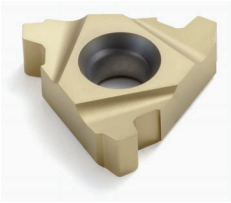
20ER/26ER

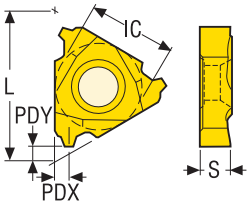
Pitch		RE	PDY	PDX	IC	W1	L	S	Insert Part No. Right	Grades					Insert Part No. Left	Grades
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**TTP2050** Coated	**H15** Uncoated		**CP500** Coated
–	14.0-14.0	– –	1,3 *0.051*	1,5 *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			■				

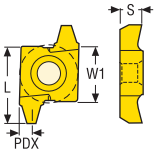
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

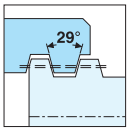
Stub-ACME – Internal Threading

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		**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*	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			■				

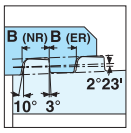
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

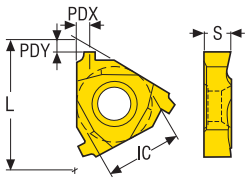
AMERICAN API BUTTRESS 1:12 Taper - External Threading

Snap-Tap®

API spec. 5B - 1988

Crest and root are parallel to axis





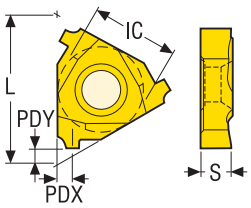
16ER

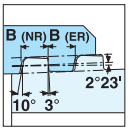
Pitch		PDY	PDX	IC	L	S	Designation	Grades		
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated
–	12.0	2,0 *0.079*	1,3 *0.051*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16ER12ASB45/7			■

■ **Stock standard.** Please check availability at 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

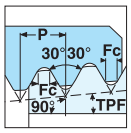
Pitch		PDY	PDX	IC	L	S	Designation	Grades		
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated
–	12.0	2,0 *0.079*	1,3 *0.051*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16NR12ASB45/7			■

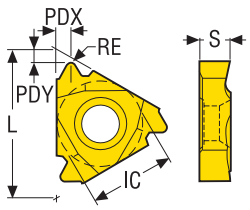
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

API Rotary Drilling connection - External threading

Snap-Tap®

API Spec 7-2 2017





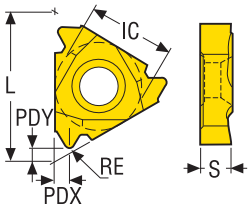
22ER/27ER

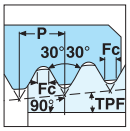
Pitch		RE	PDY	PDX	IC	L	S	API-CODE	TGTPF	Designation	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	5.0	0,508 *0.020*	2,0 *0.079*	2,5 *0.098*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	V040	3	22ER5API404		■	■	
–	4.0	0,965 *0.038*	1,95 *0.077*	2,55 *0.100*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	V038R	2	22ER4API386		■	■	
–	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	27ER5API404		■	■	
–	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	27ER4API384	■		■	
–	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	27ER4API386	■	■	■	
–	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	27ER4API504	■	■	■	
–	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	27ER4API506	■	■	■	

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

API Rotary Drilling connection - Internal threading

Snap-Tap®





API Spec 7-2 2017

22NR/27NR

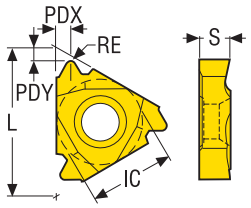
Pitch		RE	PDY	PDX	IC	L	S	API-CODE	TGTPF	Designation	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	5.0	0,508 *0.020*	2,0 *0.079*	2,5 *0.098*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	V040	3	22NR5API404		■	■	
–	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 / 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

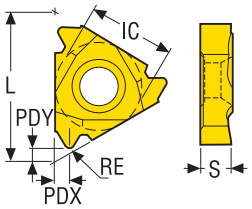
PAC

Pitch		PDY	PDX	IC	L	S	APICODE	TGTPF	Designation	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	6.0	2,0 *0.079*	2,5 *0.098*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*		2	22ER6HEF			■	
–	3.5	2,7 *0.106*	3,5 *0.138*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	90V050	3	27ER3.5H904			■	
–	3.5	2,7 *0.106*	3,5 *0.138*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	90V050	2	27ER3.5H906			■	
–	3.0	3,5 *0.138*	3,6 *0.142*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	90V050	1,25	27ER3H90			■	
–	4.0	2,4 *0.094*	2,63 *0.104*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	V076	1,5	22ER4PAC			■	
–	4.0	2,75 *0.108*	3,2 *0.126*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	V076	1,5	27ER4PAC			■	

■ **Stock standard.** Please check availability at 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

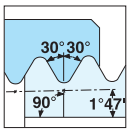
Pitch		PDY	PDX	IC	L	S	APICODE	TGTPF	Designation	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	6.0	2,0 *0.079*	2,5 *0.098*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*		2	22NR6HEF			■	
–	3.5	2,7 *0.106*	3,5 *0.138*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	90V050	3	27NR3.5H904			■	
–	3.5	2,7 *0.106*	3,5 *0.138*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	90V050	2	27NR3.5H906			■	
–	3.0	3,5 *0.138*	3,6 *0.142*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	90V050	1,25	27NR3H90			■	
–	4.0	2,4 *0.094*	2,6 *0.102*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	V076	1,5	22NR4PAC			■	
–	4.0	2,75 *0.108*	3,2 *0.126*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	V076	1,5	27NR4PAC			■	

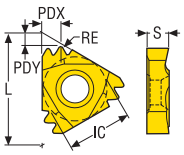
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

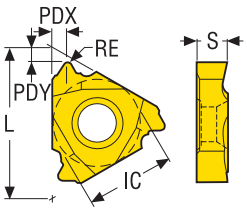
API Spec. 5B ROUND - External Threading

Snap-Tap®

API spec. 5B - 1988







16ER

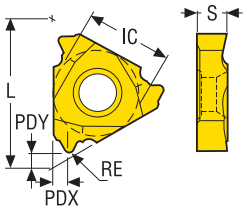
22ER/27ER..M

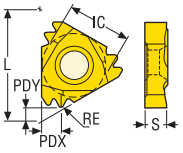
Pitch		RE	PDY	PDX	IC	L	S	Insert Part No. Right	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	10.0-10.0	0,38 *0.015*	1,5 *0.059*	1,5 *0.059*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16ER10APIRD			■	
–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

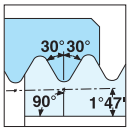
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

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 *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	10.0-10.0	0,38 *0.015*	1,5 *0.059*	1,5 *0.059*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16NR10APIRD			■	
–	8.0-8.0	0,46 *0.018*	1,5 *0.059*	1,5 *0.059*	9,525 *0.375*	16,5 *0.650*	3,47 *0.137*	16NR8APIRD			■	
–	8.0-8.0	0,46 *0.018*	2,9 *0.114*	4,5 *0.177*	15,875 *0.625*	27,0 *1.063*	6,15 *0.242*	27NR8APIRD2M		■		

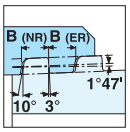
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

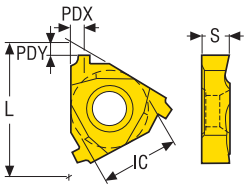
API 5B BUTTRESS, VAM BUTTRESS 1:16 Taper - External Threading

Snap-Tap®

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

Crest and root are parallel to taper





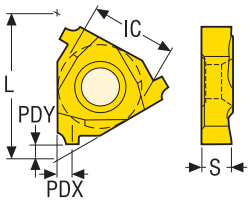
22ER

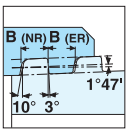
Pitch		PDY	PDX	IC	L	S	TGTPF	Designation	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	5.0	2,2 *0.087*	2,5 *0.098*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	3/4”	22ER5BUT2.5			■	
–	6.0	2,2 *0.087*	2,5 *0.098*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	3/4”	22ER6VAM			■	

■ **Stock standard.** Please check availability at 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 *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	5.0	2,0 *0.079*	2,1 *0.083*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	3/4"	22NR5BUT2.5		■	■	
–	6.0	2,0 *0.079*	2,0 *0.079*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	3/4"	22NR6VAM		■	■	
–	5.0	2,0 *0.079*	2,0 *0.079*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	3/4"	22NR5VAM			■	

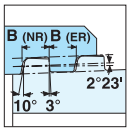
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

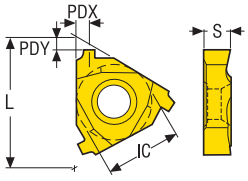
API BUTTRESS 1:12 Taper - External Threading

Snap-Tap®

API spec. 5B - 1988

Crest and root are parallel to axis





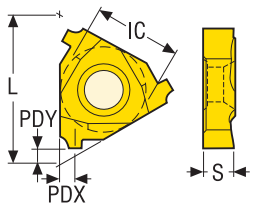
22ER

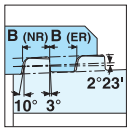
Pitch		PDY	PDX	IC	L	S	TGTPF	Designation	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	5.0	2,2 *0.087*	2,5 *0.098*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	1	22ER5BUT2.6			■	

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

API BUTTRESS 1:12 Taper - Internal Threading

Snap-Tap®





API spec. 5B - 1988

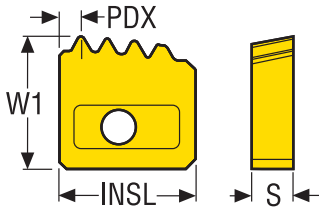
Crest and root are parallel to axis

22NR

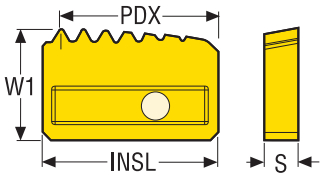
Pitch		PDY	PDX	IC	L	S	TGTPF	Designation	Grades			
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			**CP200** Coated	**CP300** Coated	**CP500** Coated	**H15** Uncoated
–	5.0	2,0 *0.079*	2,1 *0.083*	12,7 *0.500*	22,0 *0.866*	4,71 *0.185*	1	22NR5BUT2.6			■	

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

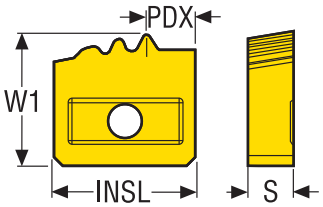
Chasers



Type 3



Type 2



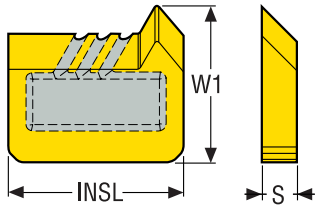
Type 1

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

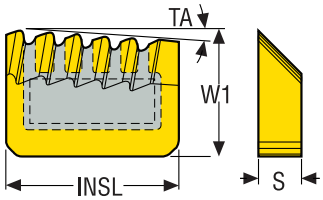
Pitch	INSL	W1	PDX	S	NT	Int./Ext.	Type	Designation	Thread Form Product	CHF1	Grades		
TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							**CP250T** Coated	**CP500T** Coated	**TP150T** Coated
5.0	17,0 –	14,825 *0.584*	3,858 *0.152*	4,76 *0.187*	3	External	1	5-3105-2	API_BUTTRESS_5TPI_1/16_PMC_2	C-3901-2	■		
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	■		

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Chipformers



Type 4



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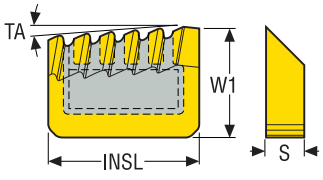
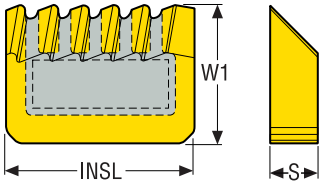
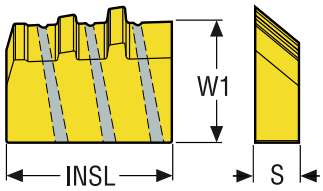


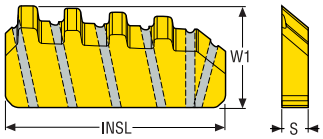
Type 2



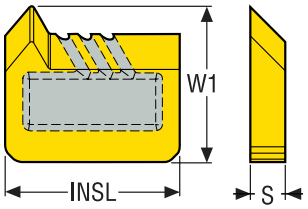
Type 1



Type 7



Type 6



Type 5

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*

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 *Inch*	mm *Inch*	mm *Inch*
C-5003-96	3	24,8 *0.976*	11,5 *0.453*	3,97 *0.156*
C-5005	1	24,8 *0.976*	11,5 *0.453*	3,0 *0.118*
C-5006	1	24,8 *0.976*	11,5 *0.453*	3,0 *0.118*
C-5705-G	6	24,8 *0.976*	13,0 *0.512*	3,0 *0.118*
C-5803-4	6	24,8 *0.976*	13,5 *0.531*	3,97 *0.156*
C-5805-G	6	24,8 *0.976*	13,5 *0.531*	3,0 *0.118*
C-5905-G	6	24,8 *0.976*	14,0 *0.551*	3,0 *0.118*
C-9001-I	4	12,6 *0.496*	11,5 *0.453*	3,18 *0.125*

Thread turning MDT

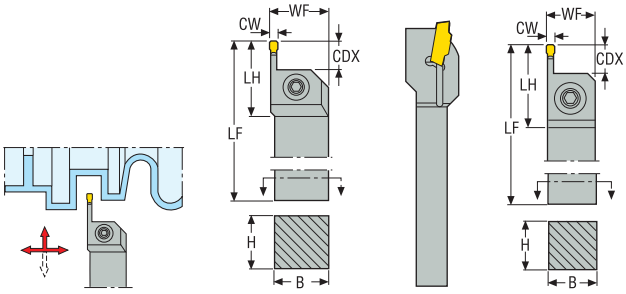
The highly stable and reliable Seco MDT (Multi-Directional Turning) system consists of holders and inserts that offers excellent performance in thread-turning operations. Products are available for both external and internal threads. Its unique clamping method is a combination of V-shaped top clamp and 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

CFIR/L/1212../1616 CFIRL/1212.. CFIR/L



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..

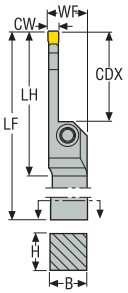
Spare Parts

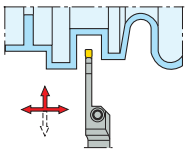
For holders	Clamp key	Clamp screw
..1212M03	3SMS795	TCEI0409
..1616H03	4SMS795	TCEI0509
..2020K03	4SMS795	TCEI0513
..2525M03	4SMS795	TCEI0513
..3225P03	4SMS795	TCEI0513

Please check availability at www.secotools.com / 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..

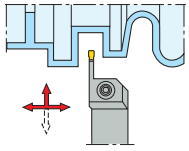
Spare Parts

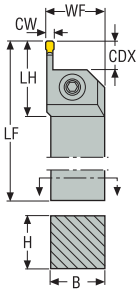
For holders	Clamp key	Clamp screw
CFSR/L..03	4SMS795	TCEI0513

Please check availability at www.secotools.com / Seco Online Store

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

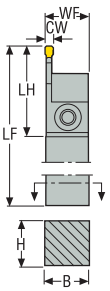
For holders	Clamp key	Clamp screw
CFMR/L..-03	4SMS795	TCEI0513

Please check availability at www.secotools.com / Seco Online Store

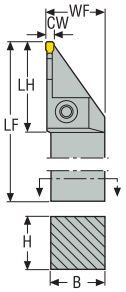
MDT Toolholders, external

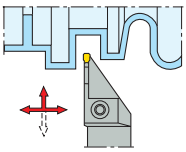
Toolholders for inserts LCGN and LCMR

CF..1212, 1616



CF..2020, 2525





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

Right-hand version shown

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

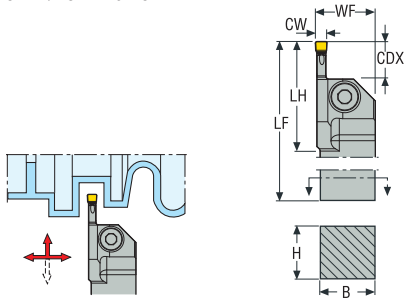
For holders	Clamp key	Clamp screw
CFOR/L..-03	3SMS795	TCEI0409
CFTR/L..-03	4SMS795	TCEI0513

Please check availability at www.secotools.com / Seco Online Store

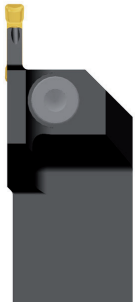
MDT Toolholders, external

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..

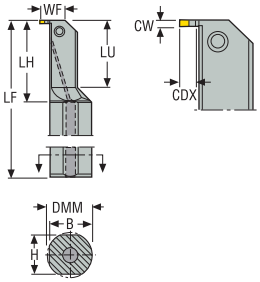
Spare Parts

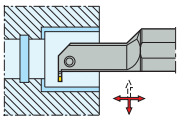
For holders	Clamp key	Clamp screw	Plug
CFIR/L..-03	4SMS795	TCEI0513	JET-P1/8-5MM
CFMR/L..-03	4SMS795	TCEI0513	JET-P1/8-5MM

Please check availability at www.secotools.com / 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..

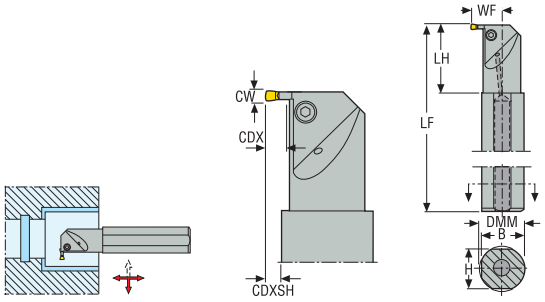
Spare Parts

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

Please check availability at www.secotools.com / Seco Online Store

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..

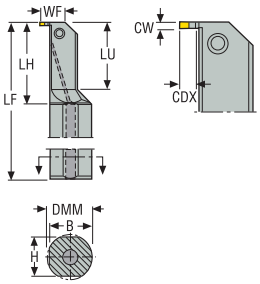
Spare Parts

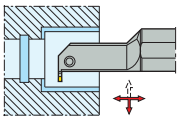
For holders	Clamp key	Clamp screw
-..03	3SMS795	MC6S4X14

Please check availability at www.secotools.com / 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
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*lbs*	
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..

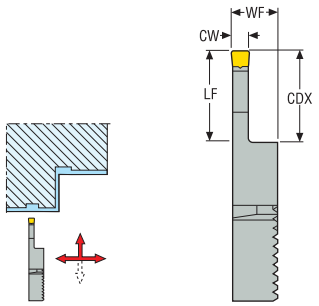
Spare Parts

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

Please check availability at www.secotools.com / Seco Online Store

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 / Seco Online Store

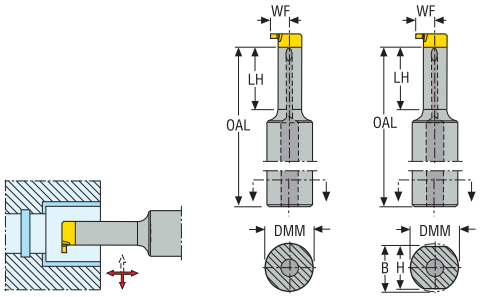
Thread turning Mini-Shaft™

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) 188-194

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

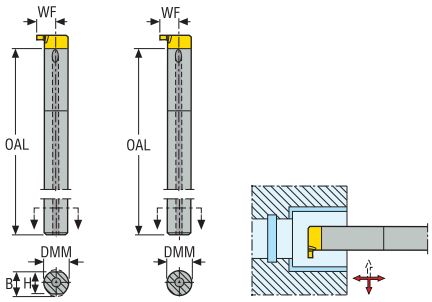
For holders	Insert key	Insert screw
A12G-..	T08P-2	C02506-T08P
A16H-..	T10P-2	C03509-T10P

Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Holders

Toolholders for inserts LCEX

E...-SGXN E...-SGXN-R



• For inserts programme, see page(s) 188-194

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

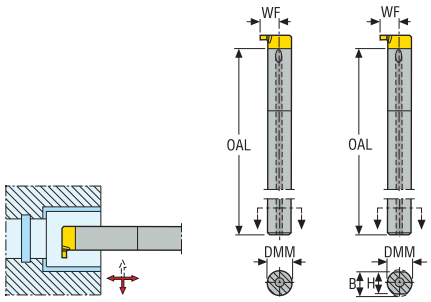
For holders	Insert key	Insert screw
E06G-..	T08P-2	C02506-T08P
E08H-..	T10P-2	C03509-T10P

Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Holders

Toolholders for inserts LCEX

E...-SGXN E...-SGXN-R



Right-hand version shown

• For inserts programme, see page(s) 188-194

Designation	Item number	B	H	LF	LH	WF	DCINN	DMM	Weight	CTWS
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*lbs*	
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..

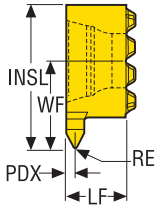
Spare Parts

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 / Seco Online Store

Mini-Shaft™ Inserts

Partial profile 60°

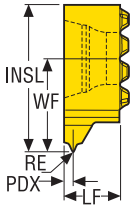


Pitch		RE	PDX	WF	INSL	LF	Designation	Coated
mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**CP500** Coated
0,5-0,75	48.0-36.0	0,03 *0.001*	0,48 *0.019*	4,78 *0.188*	7,78 *0.306*	3,3 *0.130*	LCEX0804-A60R	■
0,5-0,75	48.0-36.0	0,03 *0.001*	0,48 *0.019*	4,78 *0.188*	7,78 *0.306*	3,3 *0.130*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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Inserts

ISO Metric



..L

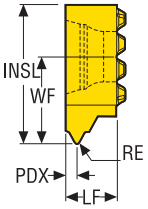
..R

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Inserts

Whitworth, BSW



..L

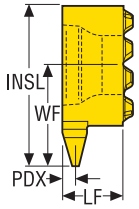
..R

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Inserts

TR-DIN103



..RL

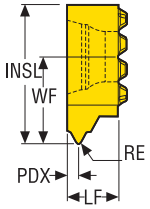
..RR

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Inserts

UN



..L

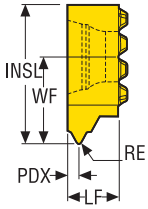
..R

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Inserts

NPT



..L

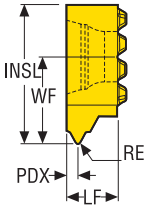
..R

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Mini-Shaft™ Inserts

NPTF



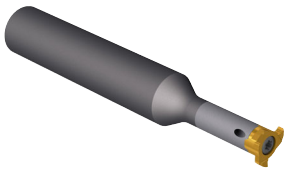
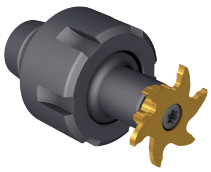
..L

..R

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

Range overview

Threading	∅ Range	Length
Threadmaster™ **Page(s) 204, 205-208, 209**	M1-M20	~ 1,5-2 x D
R396.18/19/20 **Page(s) 218-223**	14 ≤	~ 2 - 3.5 x D
R335.14   **Page(s) 230-232**	12<	~1xD<
Threadmaster™ Taps **Page(s) 244-379**	M1-M64	~ 1,5–3,5 x D

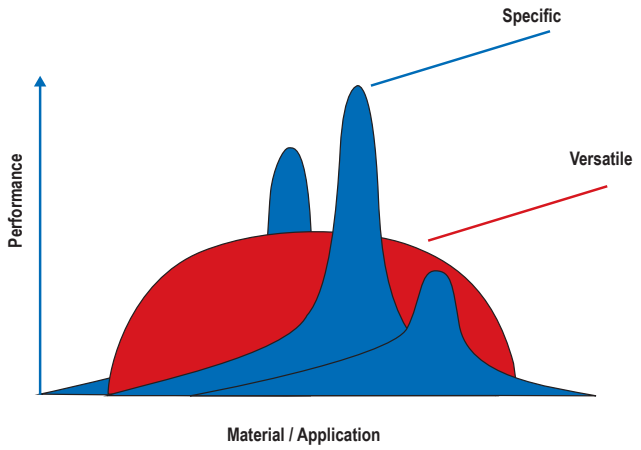
Versatile & Specific

Thread milling and Tapping – Choice of tool

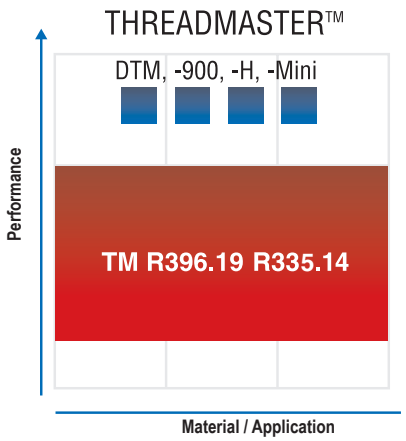
Continuous research and development of better materials, coatings and optimal geometries help fulfil customer's requirements.

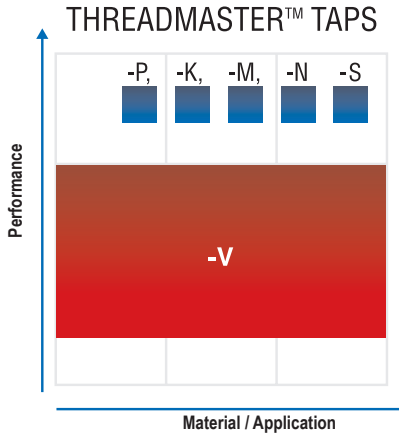
Our product strategy is to provide the market with versatile first choice tools and specific optimized solutions for threading.

Product Strategy



Product Assortment





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^2
- 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 380 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 199
- 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)

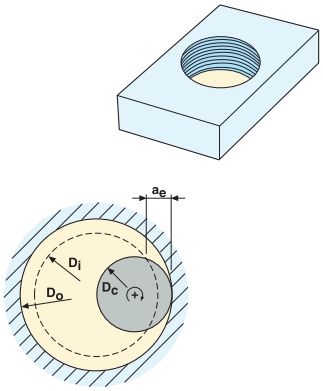
Feed rate
- Divide the radial cutting depth with the cutter diameter to get the actual cutter engagement percentage (a_e/D_c%). Use the cutting data table to get a feed per tooth recommendation, see page(s) 210, 211 - 214.

Cutting speed
- Use the tables beginning at page 380 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 199

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

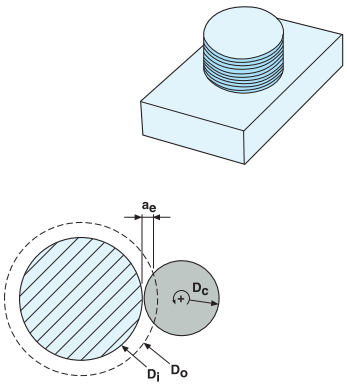
Radial infeed value a_e:

$$a_e = \frac{D_O^2 - D_i^2}{4\,(D_O - D_C)}$$

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

Choice of cutter, inserts and cutting data

RPM

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

Cutting speed

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

$$v_c = \frac{n \cdot D_c}{3.82} \quad \text{(sf/min)}$$

Feed speed

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

$$v_f = n \cdot z_c \cdot f_z \quad \text{(in/min)}$$

Feed per revolution

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

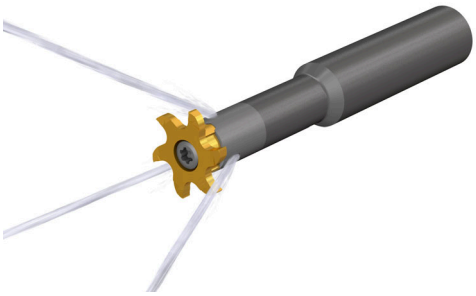
$$f = z_c \cdot f_z \quad \text{(in/rev)}$$

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

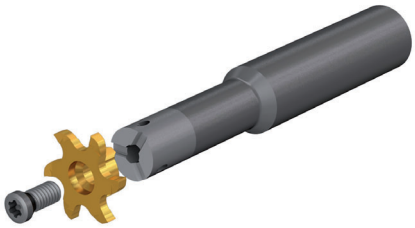
Disc Milling cutter 335.14

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

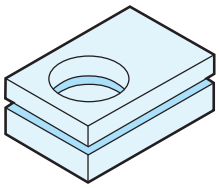
A broad range of heads and shanks available for all your disc milling operation by circular interpolation or linear slotting.



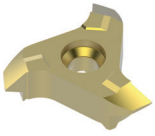
Strong, reliable and precise connection between the head and the cutter body.

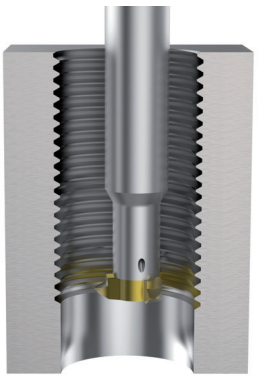


Cover all type of material with universal M geometry and F32M grade.

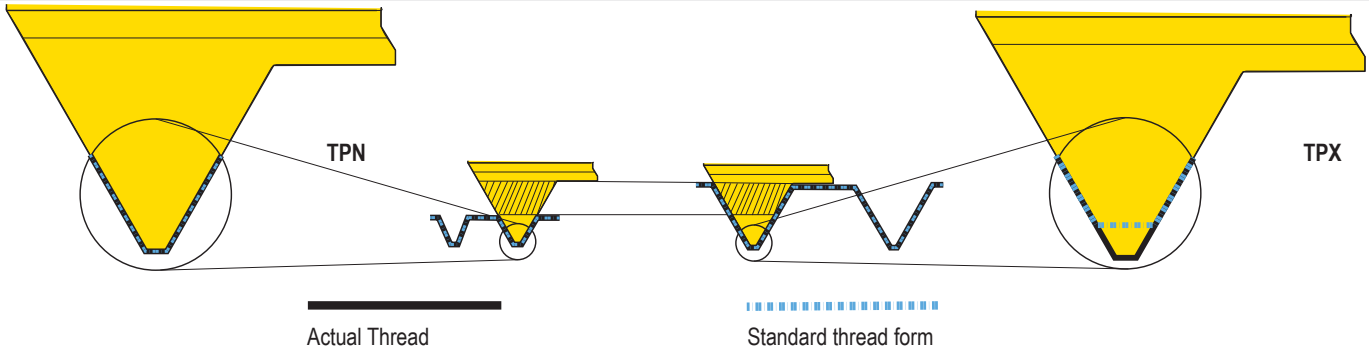


Threading:
Head from dia 11,7 to 27,7 mm *(0.461 to 1.091 in)* for partial metric threads with pitch 1-6 mm *(0.039-0.236 in)* and full profile whitworth threads with pitch 19 to 11 tpi and UN threads with pitch 24 to 6 tpi.





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.

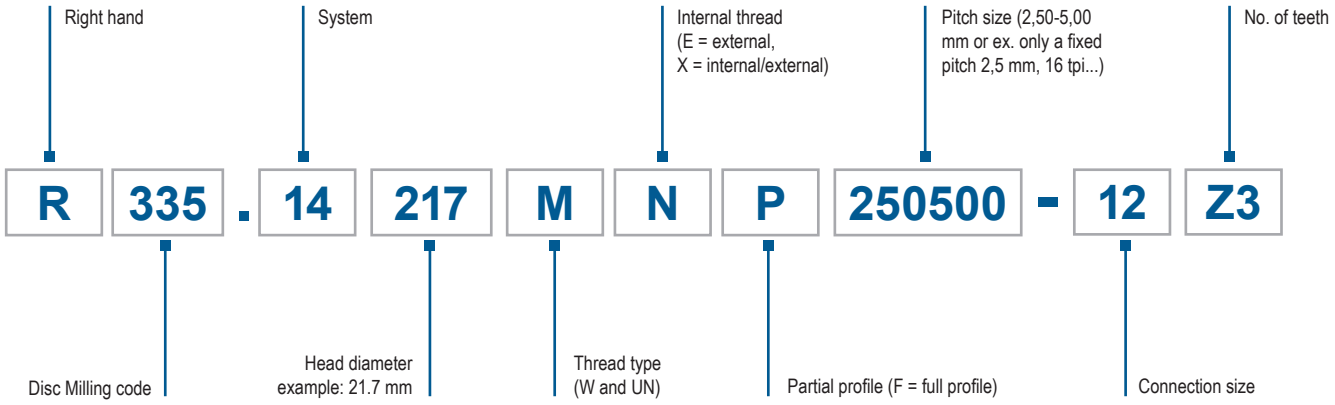
The recommended maximum pitch size (TPX) can also be machined with this insert at the expense of standard conformity: The result will be a slightly deeper thread than the standard. The deeper thread is normally accepted, but the application and use needs to be evaluated.

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

ISO-Thread, partial profile

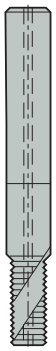
Pitch	M12	M16	M20	M24	M27	M30	M36	M42	M48	M56	M60
1	10	14	18	22	25	28	34	40	45	53	57
1,5	8	12	16	20	24	26	32	37	43	51	55
2	7	10	14	18	22	24	30	35	40	48	52
2,5	6	8	12	16	20	22	28	32	37	45	48
3		6	10	14	18	20	26	30	36	43	47
3,5				12	16	18	24	29	35	42	46
4							22	27	32	39	43
4,5								24	30	37	40
5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

Code key

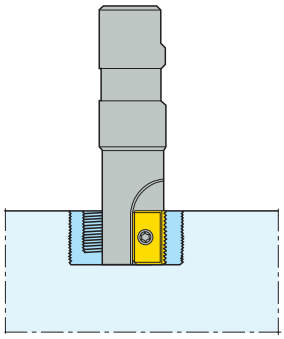
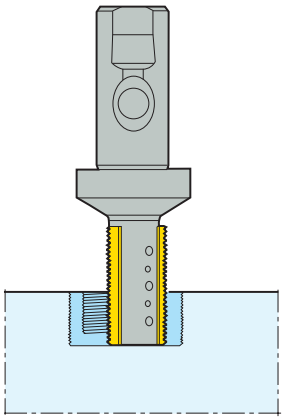
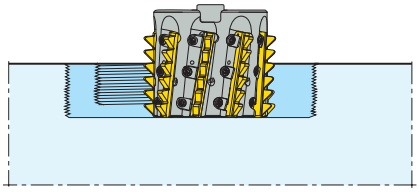


Application overview milling cutters

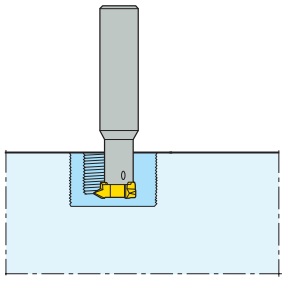
Solid carbide

Threadmaster™

TM - Thread size M1-M20 Solid carbide thread milling cutters
Page(s) 204, 205-208, 209

Cutter with inserts

396.18	396.19	396.20
		
Ø 12 mm *(0.472 in)* Thread milling cutters with indexable insert	Ø 17-58 mm *(0.669-2.283 in)* Thread milling cutters with indexable inserts	Ø 63 mm *(2.480 in)* Thread milling cutters with indexable inserts
Page(s) 218-219	Page(s) 218-221	Page(s) 223

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) 230

Threadmaster™

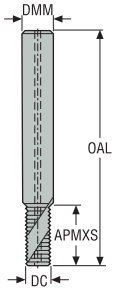
Threadmaster™ thread mills provide high thread quality at low cost per hole. Machining up to 100 percent depth, Threadmasters have high helix angles that reduce cutting forces and eliminate chatter. They feature an excellent carbide substrate and TiCN-coating (TM and TM-900) or TiAlN-coating (TM-H and 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) 210, 211
- TM; 2 x D
- Chamfer angle STA = 45°

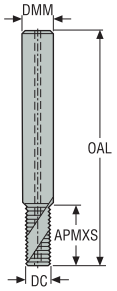
* = Metric coarse, for Internal Threading
** = Metric fine, for Internal Threading
*** = UNC, for Internal Threading

Designation	Item number	TDZ	Pitch		Thread profile	DC	DMM	OAL	APMXS	NOF	Through coolant
			TPX	TPIX		mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		
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	✓

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



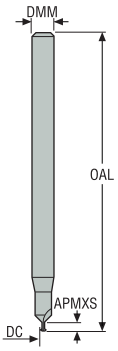
- For cutting data see page(s) 210, 211
- TM; 2 x D
- Chamfer angle = 45°

* = 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		mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		
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	✓

Threadmaster™ – TM-Mini

Solid carbide thread milling cutters



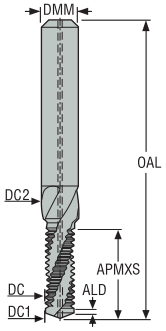
* = Metric coarse, for Internal Threading

- Left-hand cutter
- For cutting data see page(s) 210, 211
- TM ; 1.5 x D
- Chamfer angle = 90°

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-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) 212
- 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		mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		
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	✓

Designation	Item number	TDZ	Pitch		Thread profile	DC	DC1	DC2	DMM	ALD	OAL	APMXS	NOF	Through coolant
			TPX	TPIX		mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		
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	✓

Threadmaster™ – Cutting data

SMG	TM		TM-900		TM-H		TM-MINI	
	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c
P1	0,010 *0.00040*	145 *475*	— —	— —	— —	— —	— —	— —
P2	0,010 *0.00040*	140 *460*	— —	— —	— —	— —	— —	— —
P3	0,0095 *0.00038*	120 *395*	— —	— —	— —	— —	— —	— —
P4	0,0095 *0.00038*	105 *345*	0,0040 *0.00016*	105 *345*	— —	— —	— —	— —
P5	0,0090 *0.00036*	100 *330*	0,0040 *0.00016*	100 *330*	— —	— —	— —	— —
P6	0,0090 *0.00036*	115 *375*	0,0040 *0.00016*	115 *375*	— —	— —	— —	— —
P7	0,0090 *0.00036*	110 *360*	0,0040 *0.00016*	110 *360*	— —	— —	— —	— —
P8	0,0095 *0.00038*	100 *330*	0,0042 *0.00017*	100 *330*	— —	— —	— —	— —
P11	0,0090 *0.00036*	105 *345*	0,0040 *0.00016*	105 *345*	— —	— —	— —	— —
P12	0,0060 *0.00024*	60 *195*	0,0028 *0.00011*	60 *195*	— —	— —	— —	— —
M1	0,010 *0.00040*	100 *330*	0,0044 *0.00017*	100 *330*	— —	— —	— —	— —
M2	0,0090 *0.00036*	80 *260*	0,0040 *0.00016*	80 *260*	— —	— —	— —	— —
M3	0,0075 *0.00030*	60 *195*	0,0032 *0.00013*	60 *195*	— —	— —	— —	— —
M4	0,0065 *0.00026*	47 *155*	0,0028 *0.00011*	47 *155*	— —	— —	— —	— —
M5	0,0065 *0.00026*	39 *130*	0,0028 *0.00011*	39 *130*	— —	— —	— —	— —
K1	0,010 *0.00040*	145 *475*	0,0044 *0.00017*	100 *330*	— —	— —	— —	— —
K2	0,0090 *0.00036*	125 *410*	0,0040 *0.00016*	90 *295*	— —	— —	— —	— —
K3	0,0090 *0.00036*	105 *345*	0,0040 *0.00016*	75 *245*	— —	— —	— —	— —
K4	0,0090 *0.00036*	100 *330*	0,0040 *0.00016*	70 *230*	— —	— —	— —	— —
K5	0,0080 *0.00032*	60 *195*	0,0036 *0.00014*	42 *140*	— —	— —	— —	— —
K6	0,0090 *0.00036*	90 *295*	0,0040 *0.00016*	65 *215*	— —	— —	— —	— —
K7	0,0080 *0.00032*	80 *260*	0,0036 *0.00014*	55 *180*	— —	— —	— —	— —
N1	0,013 *0.00050*	395 *1300*	0,0055 *0.00022*	335 *1100*	— —	— —	— —	— —
N2	0,013 *0.00050*	255 *840*	0,0055 *0.00022*	215 *710*	— —	— —	— —	— —
N3	0,013 *0.00050*	170 *560*	0,0055 *0.00022*	145 *475*	— —	— —	— —	— —
N11	0,013 *0.00050*	225 *740*	0,0055 *0.00022*	195 *640*	— —	— —	— —	— —
S1	0,0065 *0.00026*	50 *165*	0,0028 *0.00011*	20 *65*	— —	— —	— —	— —
S2	0,0065 *0.00026*	41 *135*	0,0028 *0.00011*	15 *49*	— —	— —	— —	— —
S3	0,0060 *0.00024*	20 *65*	0,0026 *0.00010*	10 *33*	— —	— —	— —	— —
S11	0,0075 *0.00030*	105 *345*	0,0032 *0.00013*	40 *130*	— —	— —	— —	— —
S12	0,0075 *0.00030*	80 *260*	0,0032 *0.00013*	31 *100*	— —	— —	— —	— —
S13	0,0065 *0.00026*	65 *215*	0,0028 *0.00011*	24 *80*	— —	— —	— —	— —
H3	— —	— —	— —	— —	0,0016 *0.000065*	19 *60*	0,0022 *0.000085*	11 *36*
H5	— —	— —	— —	— —	0,0025 *0.00010*	36 *120*	0,0032 *0.00013*	21 *70*
H7	— —	— —	— —	— —	0,0016 *0.000065*	19 *60*	0,0022 *0.000085*	11 *36*
H8	— —	— —	— —	— —	0,0019 *0.000075*	36 *120*	0,0025 *0.00010*	21 *70*
H11	— —	— —	— —	— —	0,0025 *0.00010*	45 *150*	0,0032 *0.00013*	26 *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 *0.00026*	175 *570*
K2	0,0060 *0.00024*	155 *510*
K3	0,0060 *0.00024*	130 *425*
K4	0,0060 *0.00024*	125 *410*
K5	0,0055 *0.00022*	75 *245*
K6	0,0060 *0.00024*	110 *360*
K7	0,0055 *0.00022*	95 *310*
N1	0,0085 *0.00034*	400 *1300*
N2	0,0085 *0.00034*	255 *840*
N3	0,0085 *0.00034*	170 *560*
N11	0,0085 *0.00034*	225 *740*

Drilling Threadmaster™ – Cutting data, drilling

SMG	f						v_c
	Ø 3.01-5.0 Ø 0.118-0.196	Ø 5.01-7.0 Ø 0.197-0.275	Ø 7.01-9.0 Ø 0.276-0.354	Ø 9.01-11.0 Ø 0.355-0.433	Ø 11.01-13.0 Ø 0.434-0.511	Ø 13.01-15.0 Ø 0.512-0.590	
K1	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	170 *560*
K2	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	150 *490*
K3	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	125 *410*
K4	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	120 *395*
K5	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	70 *230*
K6	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	105 *345*
K7	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	90 *295*
N1	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	0,32 *0.013*	390 *1275*
N2	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	0,32 *0.013*	250 *820*
N3	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	0,32 *0.013*	165 *540*
N11	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	0,32 *0.013*	220 *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 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 *0.0020*	385 *1275*	0,050 *0.0020*	385 *1275*	— —	— —
P2	0,055 *0.0022*	375 *1225*	0,055 *0.0022*	375 *1225*	— —	— —
P3	0,050 *0.0020*	325 *1075*	0,050 *0.0020*	325 *1075*	— —	— —
P4	0,050 *0.0020*	285 *940*	0,050 *0.0020*	285 *940*	— —	— —
P5	0,048 *0.0019*	275 *900*	0,048 *0.0019*	275 *900*	— —	— —
P6	0,048 *0.0019*	305 *1000*	0,048 *0.0019*	305 *1000*	— —	— —
P7	0,048 *0.0019*	290 *950*	0,048 *0.0019*	290 *950*	— —	— —
P8	0,050 *0.0020*	275 *900*	0,050 *0.0020*	275 *900*	— —	— —
P11	0,048 *0.0019*	280 *920*	0,048 *0.0019*	280 *920*	— —	— —
P12	0,032 *0.0013*	165 *540*	0,032 *0.0013*	165 *540*	— —	— —
M1	0,055 *0.0022*	285 *940*	0,055 *0.0022*	285 *940*	— —	— —
M2	0,048 *0.0019*	230 *750*	0,048 *0.0019*	230 *750*	— —	— —
M3	0,038 *0.0015*	175 *570*	0,038 *0.0015*	175 *570*	— —	— —
M4	0,034 *0.0013*	130 *425*	0,034 *0.0013*	130 *425*	— —	— —
M5	0,034 *0.0013*	110 *360*	0,034 *0.0013*	110 *360*	— —	— —
K1	0,055 *0.0022*	300 *980*	0,055 *0.0022*	300 *980*	0,040 *0.0016*	270 *890*
K2	0,048 *0.0019*	260 *850*	0,048 *0.0019*	260 *850*	0,038 *0.0015*	235 *770*
K3	0,048 *0.0019*	220 *720*	0,048 *0.0019*	220 *720*	0,038 *0.0015*	200 *660*
K4	0,048 *0.0019*	210 *690*	0,048 *0.0019*	210 *690*	0,038 *0.0015*	190 *620*
K5	0,044 *0.0017*	125 *410*	0,044 *0.0017*	125 *410*	0,034 *0.0013*	115 *375*
K6	0,048 *0.0019*	185 *610*	0,048 *0.0019*	185 *610*	0,038 *0.0015*	170 *560*
K7	0,044 *0.0017*	160 *520*	0,044 *0.0017*	160 *520*	0,034 *0.0013*	145 *475*
N1	0,070 *0.0028*	1375 *4500*	0,070 *0.0028*	1375 *4500*	0,050 *0.0020*	1375 *4500*
N2	0,070 *0.0028*	890 *2925*	0,070 *0.0028*	890 *2925*	0,050 *0.0020*	890 *2925*
N3	0,070 *0.0028*	590 *1925*	0,070 *0.0028*	590 *1925*	0,050 *0.0020*	590 *1925*
N11	0,070 *0.0028*	780 *2550*	0,070 *0.0028*	780 *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 vc)
All cutting data are start values

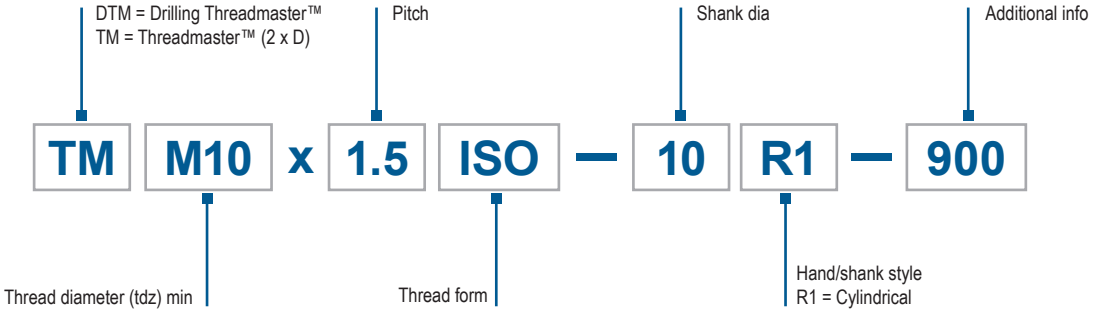
All feed are related to the centre of the cutter and not the periphery.

Cutting speed Thread milling 335.14

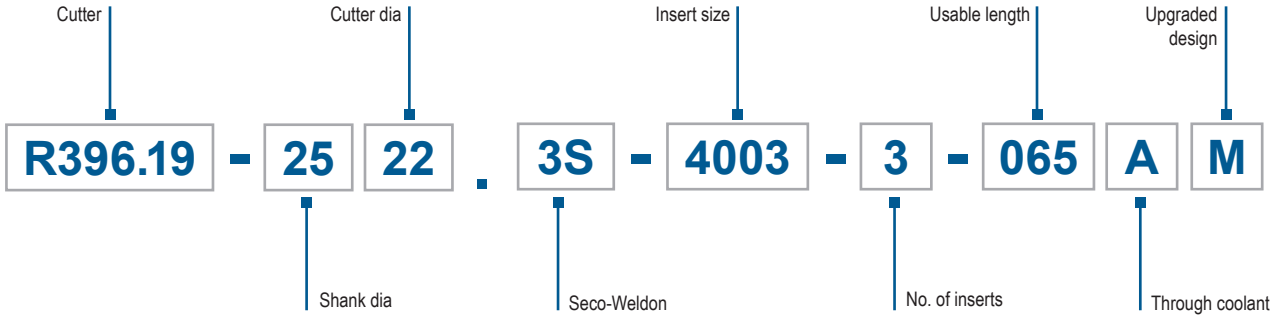
SMG	R335.14	
	f_z	v_c
P1	0,070 *0.0028*	275 *900*
P2	0,070 *0.0028*	270 *890*
P3	0,070 *0.0028*	230 *750*
P4	0,065 *0.0026*	205 *670*
P5	0,065 *0.0026*	195 *640*
P6	0,065 *0.0026*	215 *710*
P7	0,065 *0.0026*	205 *670*
P8	0,070 *0.0028*	195 *640*
P11	0,065 *0.0026*	200 *660*
P12	0,044 *0.0017*	120 *395*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

Code keys

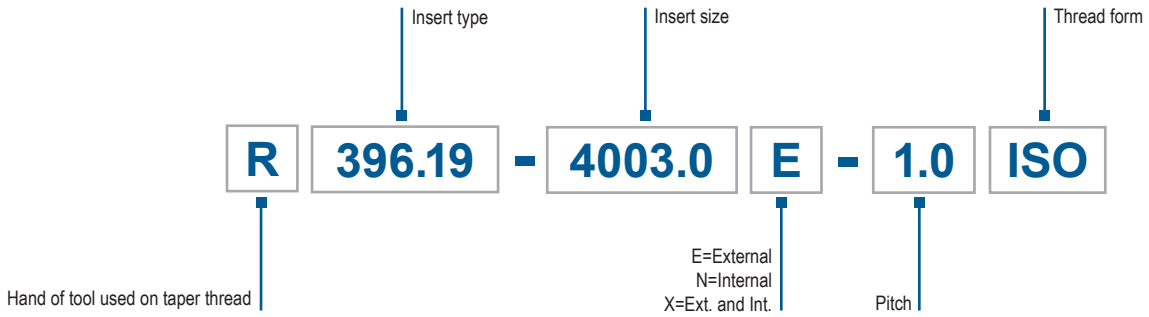
Threadmaster™



R396.18/19/20

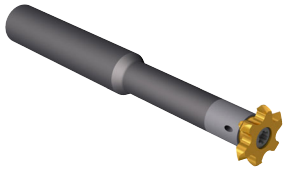


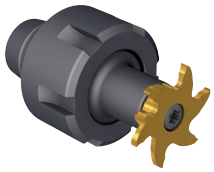
Insert 396.19/20



Code keys

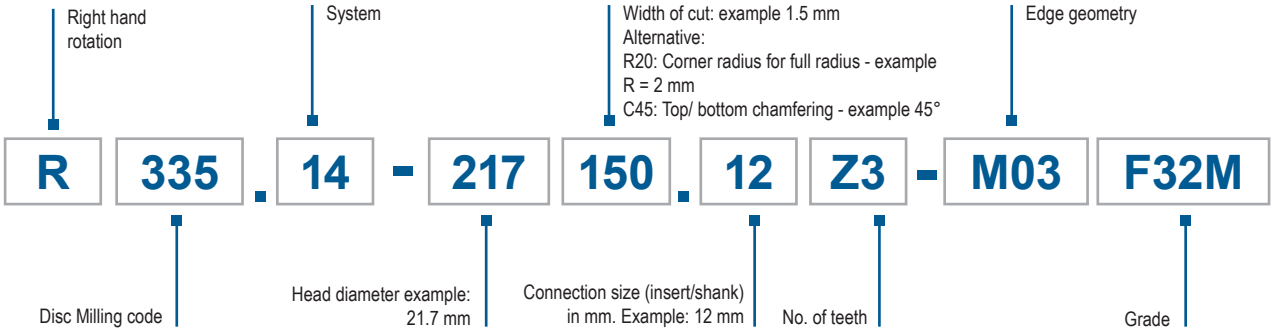
Disc Milling cutter 335.14



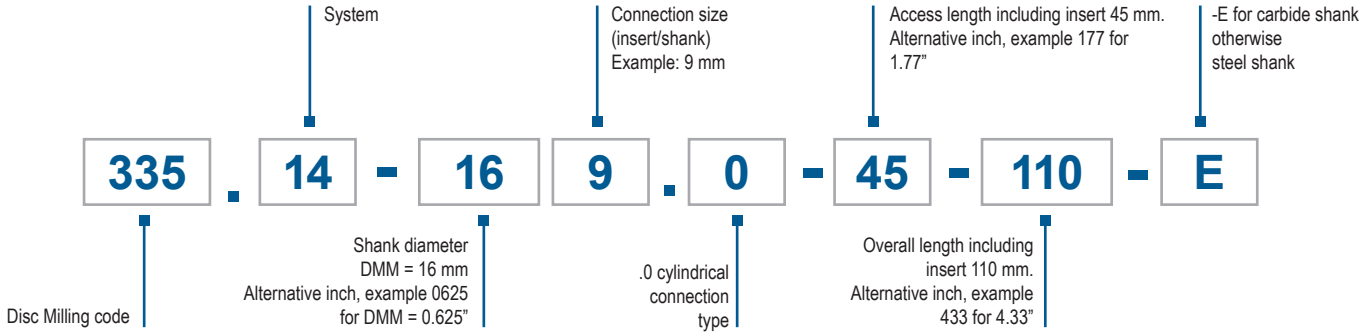


2 types of shanks available: cylindrical available both in steel and carbide, or ER collet chuck system

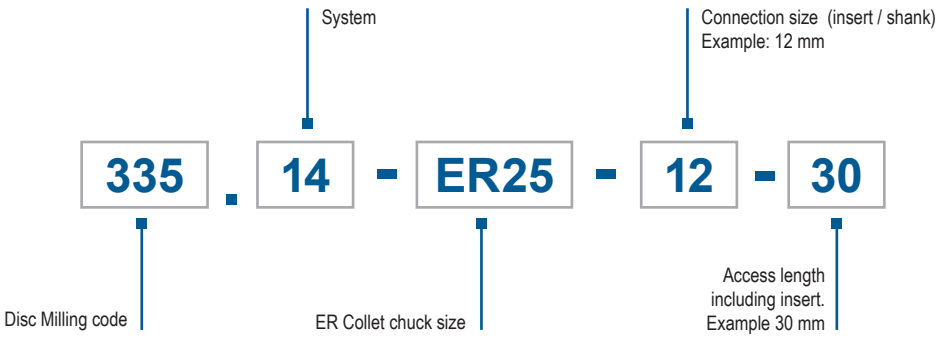
Threading insert



Cylindrical shank



Collet chuck

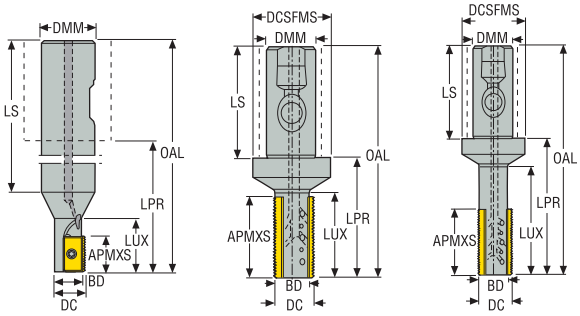


Thread milling Indexable

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 Ø14 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



- For cutting data see page(s) 213
- For insert information see page(s) 225-227
- Min thread diameter, see page(s) 224
- Note: Type of mounting * = Weldon
- Note: Type of mounting ** = Seco-Weldon

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

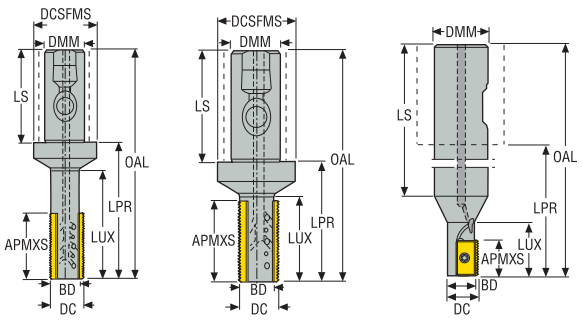
Designation	Item number	DC	DMM	OAL	APMXS	BD	DCSFMS	LPR	LUX	LS	Weight	NOF	RPMX	Note	Insert
		mm	mm	mm	mm	mm	mm	mm	mm	mm	kg				
R396.18-2012.3-13A	75036662	12,0	20,0	105,0	13,0	10,0	–	38,0	20,0	67,0	0,2	1	30000	*	13.MS
R396.19-2517.3S-4003-2AM	02534461	17,0	25,0	116,0	25,0	13,0	40,0	60,0	26,0	56,0	0,5	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 / 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 sze 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) 213
- For insert information see page(s) 225-227
- Min thread diameter, see page(s) 224
- Note: Type of mounting * = Weldon
- Note: Type of mounting ** = Seco-Weldon

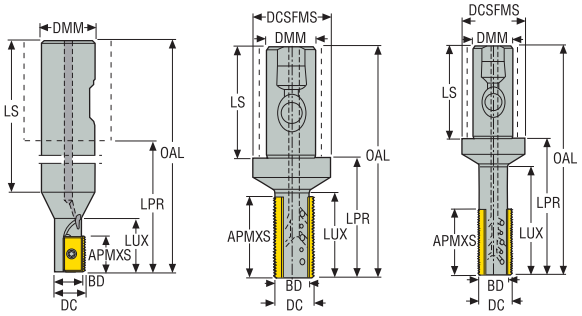
Designation	Item number	DC	DMM	OAL	APMXS	BD	DCSFMS	LPR	LUX	LS	Weight	NOF	RPMX	Note	
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*lbs*				
R396.18-00.39-3-13AT	00087568	*0.390*	*0.750*	*4.140*	*0.510*	*0.310*	–	–	*0.530*	*3.610*	*0.440*	1	30000	*	13..
R396.18-00.50-3-13AT	00074293	*0.390*	*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 / 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 sze 4,5 ISO/6 TPI can be used.
*Torque key T00-07P09, T00-09P20.

R396.19



- For cutting data see page(s) 213
- For insert information see page(s) 225-227
- Min thread diameter, see page(s) 224
- Note: Type of mounting ** = Seco-Weldon

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

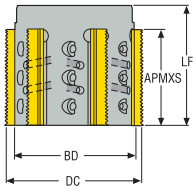
Designation	Item number	DC	DMM	OAL	APMXS	BD	DCSFMS	LPR	LUX	LS	Weight	NOF	RPMX	Note	Insert
		mm	mm	mm	mm	mm	mm	mm	mm	mm	kg				
R396.19-3232.3S-4003-3-079AM	02963138	32,0	32,0	156,0	40,0	27,4	50,0	96,0	79,57	60,0	0,9	3	20000	**	396.19-4003
R396.19-3232.3S-4005-3-079AM	02963139	32,0	32,0	156,0	40,0	24,2	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 / 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 sze 4,5 ISO/6 TPI can be used.
*Torque key T00-07P09, T00-09P20.

R396.19



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

- For cutting data see page(s) 213
- For insert information see page(s) 225-227
- Min thread diameter, see page(s) 224

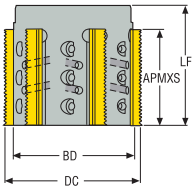
Designation	Item number	DC	APMXS	BD	LF	Weight	NOF	RPMX	Insert
		mm	mm	mm	mm	kg			
R396.19-0058-4003-6AM	02546921	58,0	40,0	53,0	50,0	0,7	6	8600	396.19-4003
R396.19-0058-4005-6AM	02546920	58,0	40,0	50,0	50,0	0,6	6	8600	396.19-4005

Spare Parts

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

Please check availability at www.secotools.com / Seco Online Store
***Torque values 2 Nm**. Torque key, T00-09P20.

R396.19



- For cutting data see page(s) 213
- For insert information see page(s) 225-227
- Min thread diameter, see page(s) 224

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

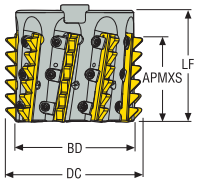
Designation	Item number	DC	APMXS	BD	LF	Weight	NOF	RPMX	Insert
		Inch	*Inch*	*Inch*	*Inch*	lbs			
R396.19-02.28-4003-6AM	02546955	2.283	1.575	2.087	1.969	1.760	6	8600	396.19-4003
R396.19-02.28-4005-6AM	02546956	2.283	1.575	1.969	1.969	1.540	6	8600	396.19-4005

Spare Parts

For holders	Arbor screw	Fastening screw	Insert key
	UC6S1/2UNFX1-1/4	P6SS4X4-T09P	T09P-2

Please check availability at www.secotools.com / Seco Online Store
***Torque values 2 Nm**. Torque key, T00-09P20.

R396.20

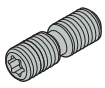


Tool angle:
GAMO= -15°
GAMP= -15°
GAMF= -15°

- For cutting data see page(s) 213
- For insert information see page(s) 228
- Min thread diameter, see page(s) 224

Designation	Item number	DC	APMXS	BD	LF	Weight	NOF	RPMX	Insert
		Inch	*Inch*	*Inch*	*Inch*	lbs			
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 / Seco Online Store
***Torque values 2 Nm**. Torque key, T00-09P20.

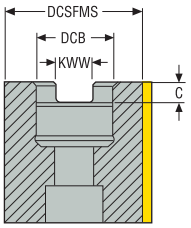
Min thread diameter (major dia), for different pitch and cutter combinations

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

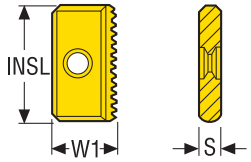
Note! When milling threads to smaller diameters than indicated for a certain pitch/cutter combination, an incorrect thread form will result.

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

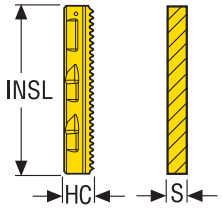


Tolerances:
INSL = ± 0,012 mm
HC = ± 0,012 mm
S = ± 0,025 mm

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

■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

396.19-4003

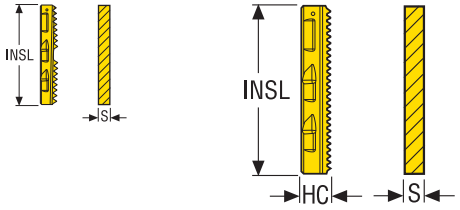


Tolerances:
INSL = ± 0,007 mm, HC = ± 0,012 mm, S = ± 0,05 mm

Designation	Insert	INSL	S	Grades	
		mm *Inch*	mm *Inch*	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 / Seco Online Store

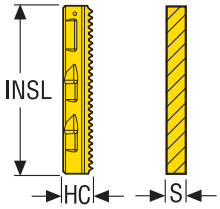
396.19-4003/4005



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

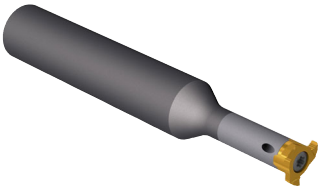
■ **Stock standard.** Please check availability at www.secotools.com / Seco Online Store

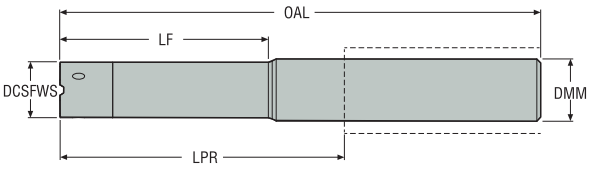
Thread milling Shanks

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

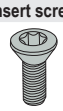




- For cutting data see page(s) 214
- Technical information, see page 201
- -E = Carbide shank with DMM tolerance = h6
- Steel shank: DMM tolerance = g6
- Max RPM = 30 000 rev/min

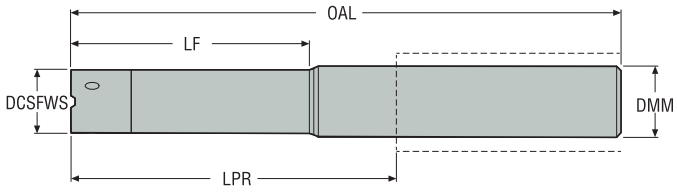
Designation	Item number	DCSFWS	DMM	LF	OAL	LPR	Weight	Through coolant	Insert
		mm	mm	mm	mm	mm	kg		
335.14-1006.0-015-060	03042024	6,0	10,0	11,5	56,5	16,5	0,1	–	R335.14...06Z..
335.14-1206.0-021-080-E	03042025	6,0	12,0	17,5	76,5	31,5	0,1	✓	R335.14...06Z..
335.14-1206.0-030-090-E	03042026	6,0	12,0	26,5	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..

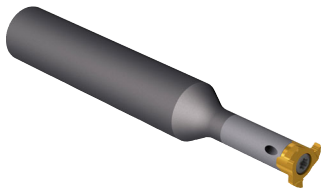
Spare Parts

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 / Seco Online Store

335.14 Shank - Cylindrical version





- For cutting data see page(s) 214
- Technical information, see page 201
- -E = Carbide shank with DMM tolerance = h6
- Steel shank: DMM tolerance = g6
- Max RPM = 30 000 rev/min

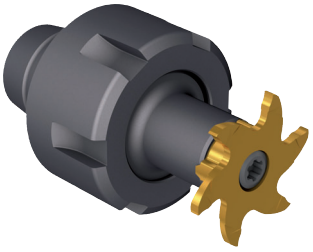
Designation	Item number	DCSFWS	DMM	LF	OAL	LPR	Weight	Through coolant	Insert
		Inch	*Inch*	*Inch*	*Inch*	*Inch*	lbs		
335.14-050006.0-083-315-E	03042121	0.236	0.500	0.689	3.012	1.240	0.220	✓	R334.14...06Z..
335.14-050006.0-118-354-E	03042122	0.236	0.500	1.043	3.406	1.634	0.440	✓	R334.14...06Z..
335.14-050006.0-165-394-E	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..

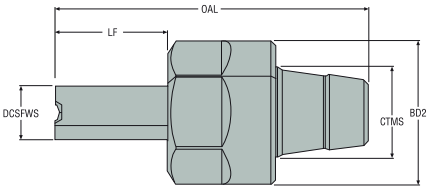
Spare Parts

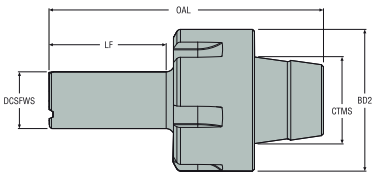
For cutter	Insert key	Insert screw	Key (T-handle)
335.14-..06	H4B-T08P	C92608-T08P	DOUBLE-T
335.14-..08	H4B-T10P	C93510-T10P	DOUBLE-T
335.14-..09	H4B-T15P	C94012-T15P	DOUBLE-T
335.14-..12/14	H6B-T20P	C95012-T20P	DOUBLE-T

Please check availability at www.secotools.com / Seco Online Store

335.14 Shank with ER collet







- For cutting data see page(s) 214
- Technical information, see page 201

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..

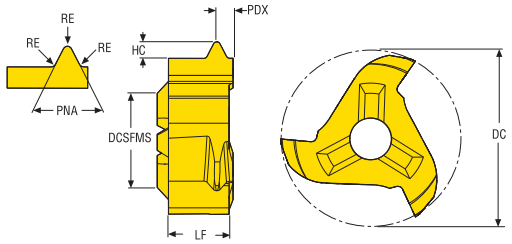
Spare Parts

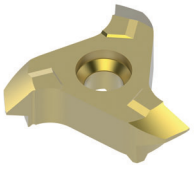
For cutter	Insert key	Insert screw	Key (T-handle)
335.14-ER..-06	H4B-T08P	C92608-T08P	DOUBLE-T
335.14-ER..-08	H4B-T10P	C93510-T10P	DOUBLE-T
335.14-ER..-09	H4B-T15P	C94012-T15P	DOUBLE-T
335.14-ER..-12/14	H6B-T20P	C95012-T20P	DOUBLE-T

Please check availability at www.secotools.com / Seco Online Store

335.14 Insert

Thread profile Whitworth - Metric





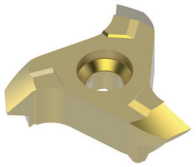
- For cutting data see page(s) 214
- Technical information, see page 201

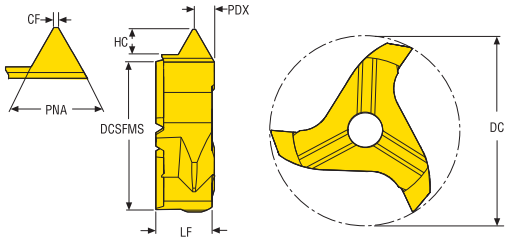
Designation	Pitch	RE	DC	DCSFMS	HC	LF	PDX	PNA	ZEFP	Grades
	mm *TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**F32M** Coated
R335.14-117WXF11.06Z3	– *11.000*	0,31 *0.012*	11,7 *0.461*	6,0 *0.236*	1,48 *0.058*	3,6 *0.142*	1,6 *0.063*	55,0 *2.165*	3	■
R335.14-117WXF14.06Z3	– *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 / Seco Online Store

335.14 Insert

Thread profile Partial Metric





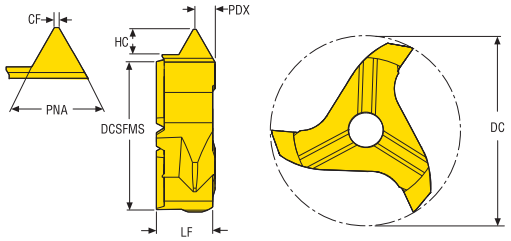
- For cutting data see page(s) 214
- Technical information, see page 201

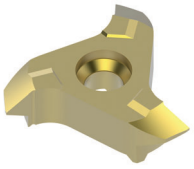
Designation	Pitch		DC	DCSFMS	HC	LF	PDX	PNA	ZEFP	Grades
	mm TPN *Inch TPN*	mm TPX *Inch TPX*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**F32M** Coated
R335.14-117MNP100200.06Z3	1,0 *0.039*	2,0 *0.079*	11,7 *0.461*	6,0 *0.236*	1,25 *0.049*	3,6 *0.142*	0,8 *0.031*	60,0 *2.362*	3	■
R335.14-117MNP200300.06Z3	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 / Seco Online Store

335.14 Insert

Thread profile UN - Metric





- For cutting data see page(s) 214
- Technical information, see page 201

Designation	Pitch	DC	DCSFMS	HC	LF	PDX	PNA	ZEFP	Grades
	mm *TPI*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		**F32M** Coated
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 / 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.

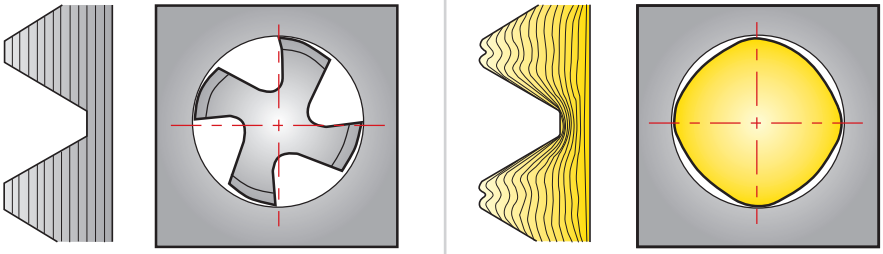
- Features spiral helixes for blind holes and spiral points for through holes.
- Straight flutes accommodate for short chipping materials
- Advanced coatings for faster tapping

Introduction to taps

What are you looking for in a thread?

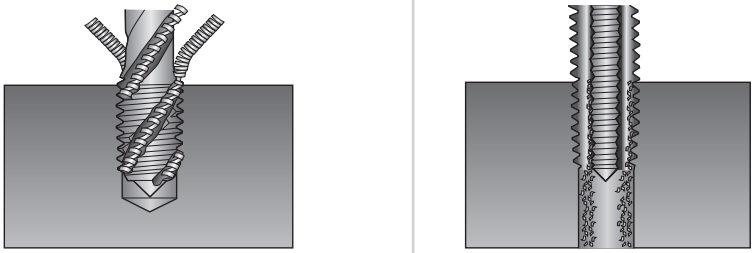
Cutting a thread vs forming a thread

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).

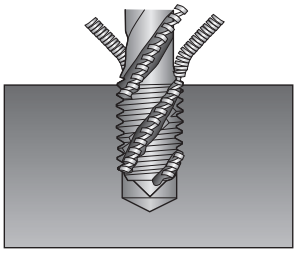


Hole size

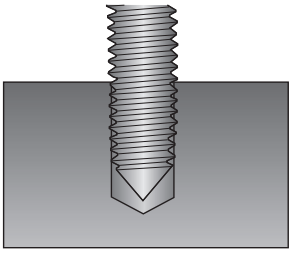
Dimension of the hole differs between cutting and forming the thread.

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

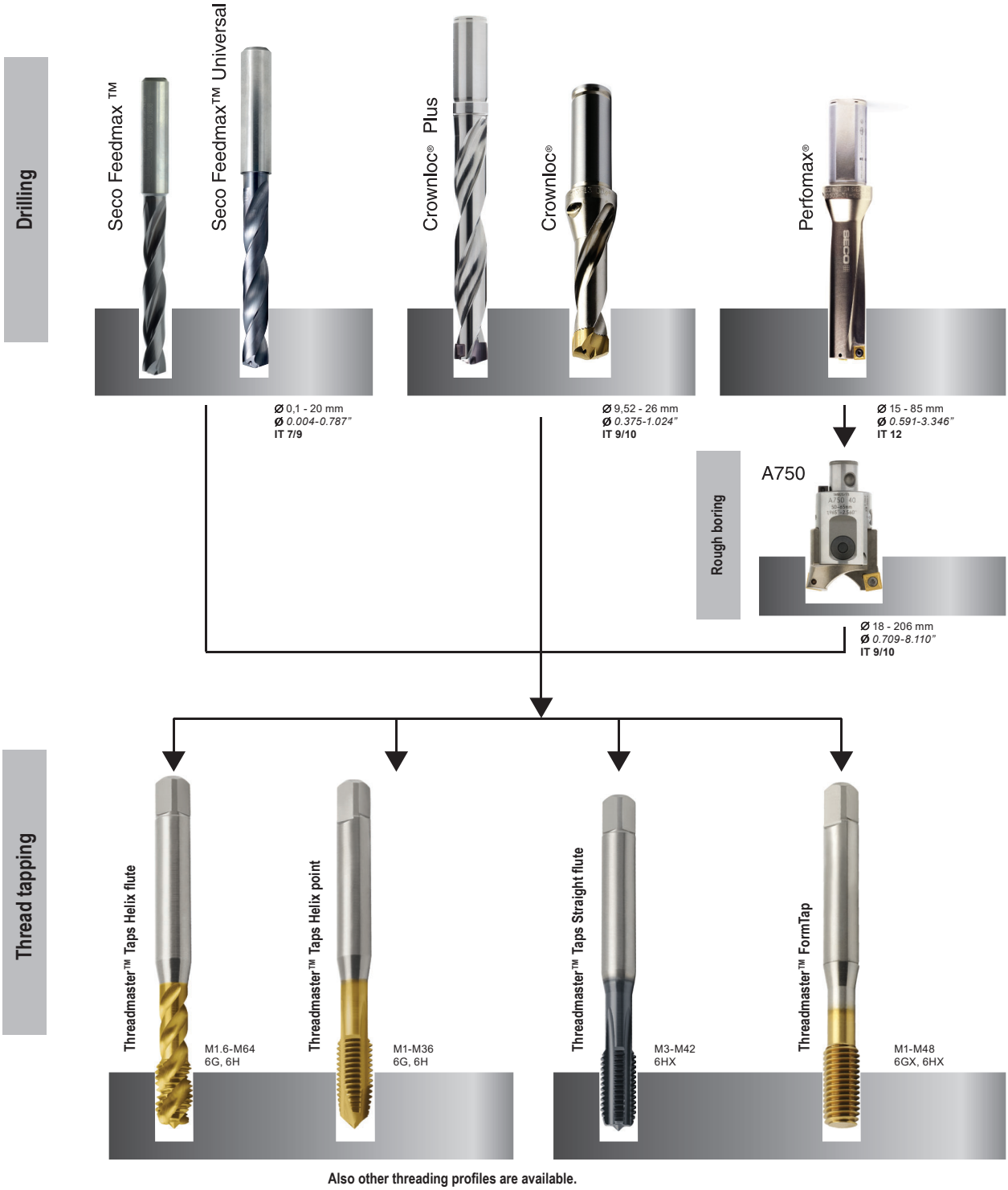
Cutting tap
D = TD-PTH



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



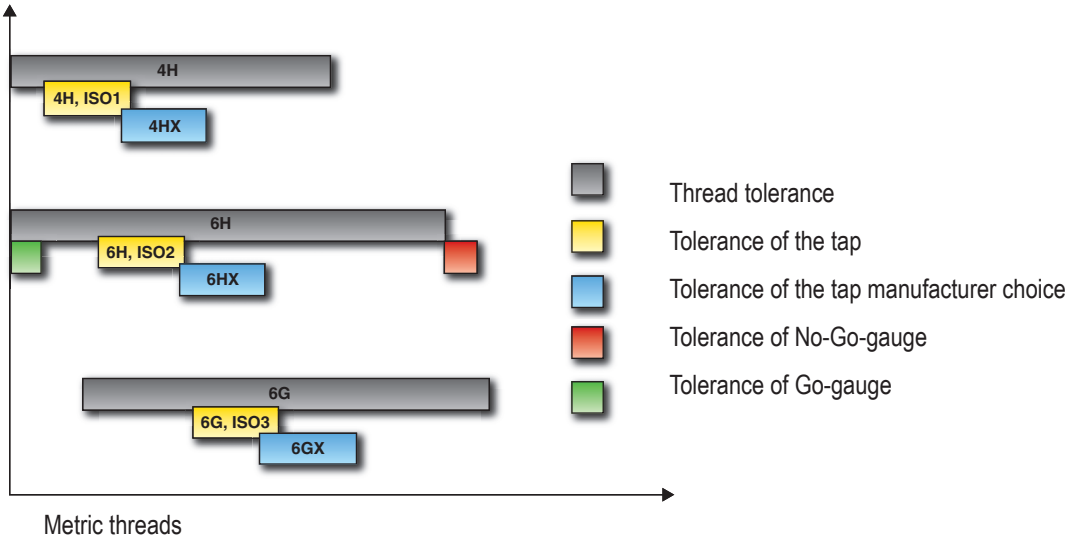
Introduction to taps – Tool guide



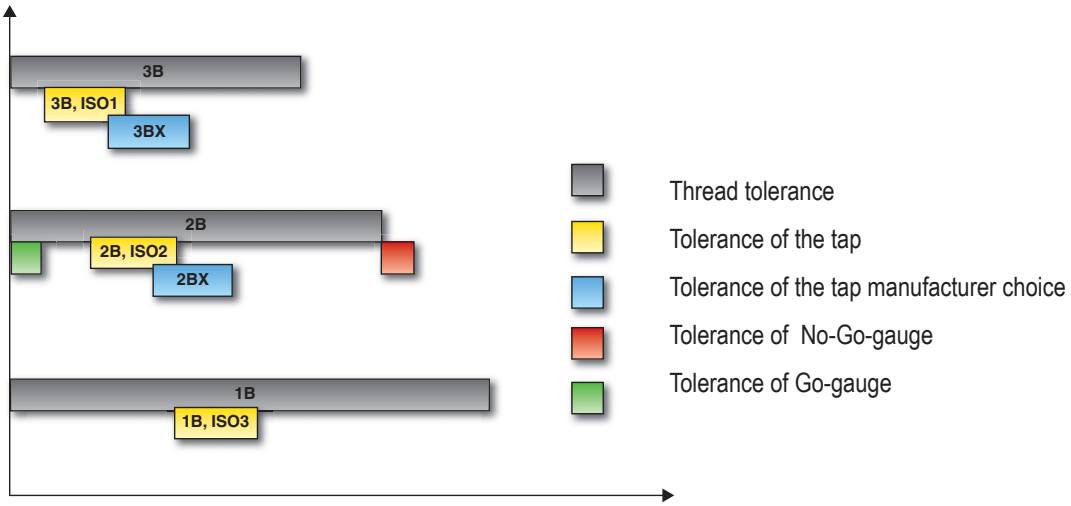
Also other threading profiles are available.

Taps – Choice of Tap tolerance

The Threadmaster™ Taps from Seco are available for threads with different tolerences 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.



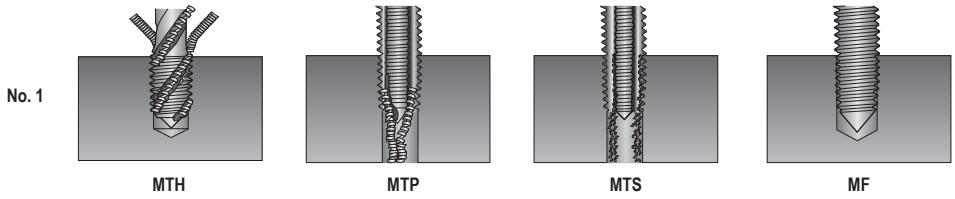
Metric threads



UN threads

Code key – Taps

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

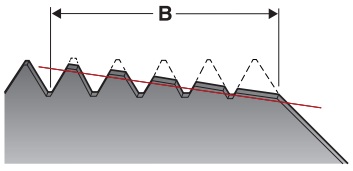


	Description
1	MTH = Threadmaster™ Tap Helix flute MTP = Threadmaster™ Tap Helix point MTS = Threadmaster™ Tap Straight flute tap MF = Threadmaster™ FormTap
2	Thread type and size
3	Pitch and thread form
4	Tolerance (tctr) 4H, 6H, 6HX, 6G, 6GX metric and 2B, 2BX, 3B, 3BX, Normal, NormalX inch
5	Operation,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

Taps – Entering chamfer THCHT

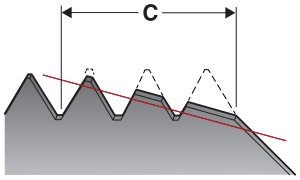
B-type

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



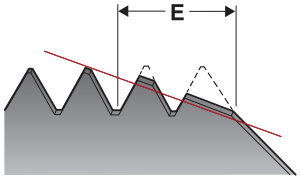
C-type

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

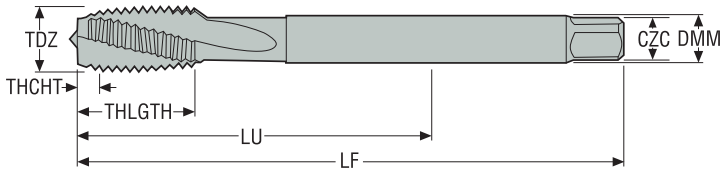


E-type

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



Definitions



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

Oversized thread

Wrong tap for application
- Refer to application charts

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

Wrong cutting speed
- Refer to recommendations

Wrong tolerance
- Choose tap with lower tolerance

Undersized thread

Tap worn out
- Replace tap

Tap drill hole too small
- Check drilling recommendations

Material closing after tapping
- Increase drill diameter

Wrong tolerance on tap
- Choose tap with higher tolerance

Chipping

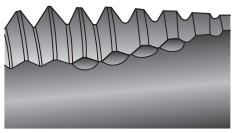
Wrong tap for the application
- Check for tool selection

Incorrect or lack of lubricant
- Use appropriate emulsion or oil

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

Trapped chip
- Check tool selection

Surface hardening in drilled hole
- Check drilling recommendations



Breakage

Too high torque
- Use tap holder with torque settings

Tap worn out
- Replace tap

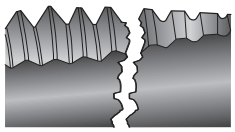
Incorrect or lack of lubricant
- Use appropriate emulsion or oil

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

Wrong cutting speed
- Refer to recommendations

“Birdnest” around tool
- Check tool selection

Tap drill hole too small
- Check drilling recommendations



Rapid wear

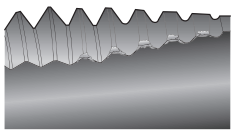
Wrong type of tap for application
- Refer to tap choice

Incorrect or lack of lubricant
- Use appropriate emulsion or oil

Too high cutting speed
- Refer to recommendations

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

Tap drill hole too small
- Check drilling recommendations



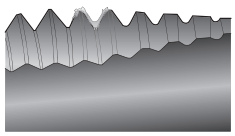
Built-up edge

Incorrect or lack of lubricant
- Use appropriate emulsion or oil

Tap worn out
- Replace tap

Wrong cutting speed
- Refer to recommendations

Wrong type of tap for application
- Refer to tap choice



Taps Selection 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)	309	310	311	312	313	314	315	316	317, 318

For cutting data, see next page

Cutting data MTH-P001 (-A) – P011

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

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

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

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

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

Taps Selection MTP-P001 – MTP-P011

Tool type	MTP-P001 30-48 HRC	MTP-P002 30-48 HRC	MTP-P003	MTP-P003-A	MTP-P004	MTP-P004-A	MTP-P011
Thread type	M	M	M	M	M	M	MF
TCTR	6H	6H	5HX/6HX	6HX	6HX	6HX	6HX
ULDR	2.5	2.5	3	3	3	3	3
THCHT	B	B	B	B	B	B	B
BSG	SECO-DIN	DIN376	DIN371	DIN371	DIN376	DIN376	DIN374
Thread size	M3 - M10	M12 - M20	M1 - M10	M4 - M10	M4 - M30	M12 - M30	MF 4X0.5 - MF 30X2.0
Coolant	No	No	No	Yes	No	Yes	No
Page(s)	272	273	274	275	276	277	278, 279

For cutting data, see next page

Cutting data MTP-P001 – P011

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

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

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

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

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

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

Tool type	MTH-M003	MTH-M003-A	MTH-M004	MTH-M004-A	MTP-M003	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)	319	320	321	322	280	281	282	283

For cutting data, see next page

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

SMG	v_c							
	MTH- M003	MTH- M003-A	MTH- M004	MTH- M004-A	MTP- M003	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_c = m/min (sf/min)

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

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

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

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

Tool type	MTH-N001	MTH-N002	MTP-N001	MTP-N001-A	MTP-N002	MTP-N002-A
Thread type	M	M	M	M	M	M
TCTR	6H	6H	6H	6H	6H	6H
ULDR	1.5	1.5	3	3	3	3
THCHT	C	C	B	B	B	B
BSG	DIN371	DIN376	DIN371	DIN371	DIN376	DIN376
Thread size	M3 - M10	M12 - M16	M3 - M10	M4 - M10	M12 - M16	M12 - M16
FHA	15°	15°	–	–	–	–
Coolant	No	No	No	Yes	No	Yes
Page(s)	323	324	284	285	286	287

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.

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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-UN-JC3/8-16
FHA	10°	10°	10°	10°	10°	10°	25°	10°
Coolant	No	No	No	No	No	No	No	No
Page(s)	325	326	327	328	329	330	331	332

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 increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%. Due to machine, material and setup condition it is advisable also to optimize cutting data.
Recommended ranges to use for each type of tap:
K001-K002: +25% / -25%
V015-V016: +15% / -15%
V001-V045: +15% / -15%
V048-V050: +35% / -35%
V053-V063: +15% / -15%

Taps Selection MTH-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)	333	334	333	336	337	338	339	340	341

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	3	7	3	7	7	7	3	7
	10	*10*	*23*	*10*	*23*	*23*	*23*	*10*	*23*
P7	3	3	7	3	7	7	7	3	7
	10	*10*	*23*	*10*	*23*	*23*	*23*	*10*	*23*
P8	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
P11	3	3	6	3	6	6	6	3	6
	10	*10*	*20*	*10*	*20*	*20*	*20*	*10*	*20*
P12	2	2	4	2	4	4	4	2	4
	7	*7*	*13*	*7*	*13*	*13*	*13*	*7*	*13*
M1	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
M2	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
M3	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
M4	2	—	6	—	6	6	6	—	6
	7	—	*20*	—	*20*	*20*	*20*	—	*20*
M5	2	—	5	—	5	5	5	—	5
	7	—	*16*	—	*16*	*16*	*16*	—	*16*
K1	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
N3	—	16	25	16	25	25	25	16	25
	—	*50*	*80*	*50*	*80*	*80*	*80*	*50*	*80*
N11	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
S1	2	2	—	2	—	—	—	2	—
	7	*7*	—	*7*	—	—	—	*7*	—
S2	2	2	—	2	—	—	—	2	—
	7	*7*	—	*7*	—	—	—	*7*	—
S3	2	2	—	2	—	—	—	2	—
	7	*7*	—	*7*	—	—	—	*7*	—
S11	—	—	5	—	5	5	5	—	5
	—	—	*16*	—	*16*	*16*	*16*	—	*16*
S12	—	—	4	—	4	4	4	—	4
	—	—	*13*	—	*13*	*13*	*13*	—	*13*
S13	—	—	3	—	3	3	3	—	3
	—	—	*10*	—	*10*	*10*	*10*	—	*10*
H5	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—

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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)	288	289	290	291	292	293	294

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	— —	— —	— —	— —	— —	— —	— —

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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)	362	363	364	365	366	367	368	369

For cutting data, see next page

Cutting data MTS-K001 (-A) – MTS-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 increse speed by 20% and at 2,5 x D reduce speed by 20%. At 3 x D reduce by 30%.
Due to machine, material and setup condition it is advisable also to optimize cutting data.

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

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

Tool type	MTH-V011	MTH-V015	MTH-V016	MTH-V025	MTH-V026	MTH-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)	342	343	344	345	346	347	348	349	350

For cutting data, see next page

Cutting data MTH-V011 – MTH-V030 (-A)

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

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

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

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

Taps Selection MTH-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)	351	352	353, 354	355, 356	357	358	359

For cutting data, see next page

Cutting data MTH-V033 (-A) – MTH-V045

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

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

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

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

Taps Selection MTP-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)	295	296	297	298	299	300	301	302

For cutting data, see next page

Cutting data MTP-V001 – MTP-V008 (-A)

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

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

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

Tool type	MTP-V014	MTP-V014-A	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)	303, 304	305	306	307	308

For cutting data, see next page

Cutting data MTP-V014 (-A) – MTP-V023

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

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

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

Taps Selection MTH-V048 – MTH-V050

Tool type	MTH-V048	MTH-V050
Thread type	NPT	NPTF
TCTR	NORMAL	NORMAL
ULDR	1.5	1.5
THCHT	C	C
BSG	DIN/ANSI	DIN/ANSI
Thread size	NPT 1/16-27 NPT 1-11.5	NPTF 1/16-27 NPTF 3/4-14
FHA	15°	15°
Coolant	No	No
Page(s)	360	361

For cutting data, see next page

Cutting data MTH-V048 – V050

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

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

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

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

Taps Selection MF-V053 – MF-V063 (-A)

Tool type	MF-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)	370	371	372	373	374	375	376	377	378	379

For cutting data, see next page

Cutting data MF-V053 – MF-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 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
P2	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
P3	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*	48 *155*
P4	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*
P5	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*
P6	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*	45 *150*
P7	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*	42 *140*
P8	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*	40 *130*
P11	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*	41 *135*
P12	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*	24 *80*
M1	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*	17 *55*
M2	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*	14 *46*
M3	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*	11 *36*
M4	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*	8 *26*
M5	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*	7 *23*
K1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	50 *165*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*	55 *180*
N2	32 *105*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*	35 *115*
N3	21 *70*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*	23 *75*
N11	28 *90*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*	31 *100*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

SMG = Seco material group
v_c = m/min

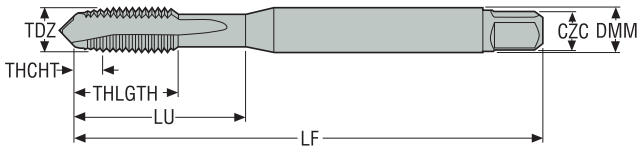
Cutting speeds (v_c) in the table are recommendations for a start value and calculated when running in 2xD, except for V048, V050 and MTH-S (001, 002, 003, 004, 011, 012, 031, 032, 041, 042 and 044) that are calculated from 1,5xD.

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

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

MTP-P001

Through holes



- For cutting data see page(s) 247
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M3X0.50ISO6H-TB-P001	02999886	M3	0,5	–	4,5 *0.177*	12,0 *0.472*	12,0 *0.472*	63,0 *2.480*	2,5 *0.098*	4.50X3.40	3	SECO-DIN	6H	B
MTP-M4X0.70ISO6H-TB-P001	02999887	M4	0,7	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	70,0 *2.756*	3,4 *0.134*	6.00X4.90	3	SECO-DIN	6H	B
MTP-M5X0.80ISO6H-TB-P001	02999888	M5	0,8	–	6,0 *0.236*	15,0 *0.591*	15,0 *0.591*	80,0 *3.150*	4,3 *0.169*	6.00X4.90	3	SECO-DIN	6H	B
MTP-M6X1.00ISO6H-TB-P001	02999889	M6	1,0	–	8,0 *0.315*	18,0 *0.709*	18,0 *0.709*	90,0 *3.543*	5,1 *0.201*	8.00X6.20	3	SECO-DIN	6H	B
MTP-M8X1.25ISO6H-TB-P001	02999890	M8	1,25	–	10,0 *0.394*	20,0 *0.787*	20,0 *0.787*	100,0 *3.937*	6,8 *0.268*	10.00X8.00	3	SECO-DIN	6H	B
MTP-M10X1.50ISO6H-TB-P001	02999891	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	SECO-DIN	6H	B

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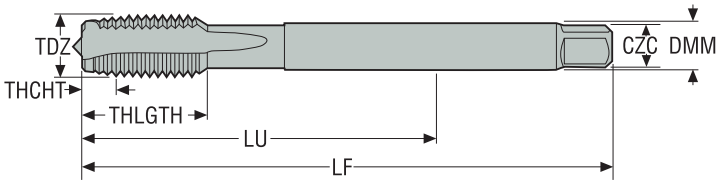
MTP-P002

Through holes



- For cutting data see page(s) 247
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-P002	02999892	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-P002	02999893	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-P002	02999894	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-P002	02999895	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	125,0 *4.921*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-P002	02999896	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	140,0 *5.512*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	B

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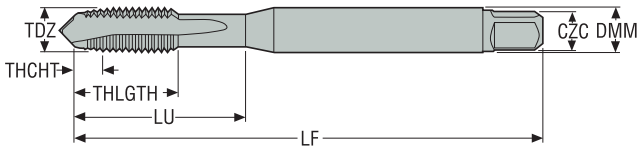
MTP-P003

Through holes



- For cutting data see page(s) 247
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M1X0.25ISO5HX-TB-P003	02999897	M1	0,25	–	2,5 *0.098*	20,0 *0.787*	5,0 *0.197*	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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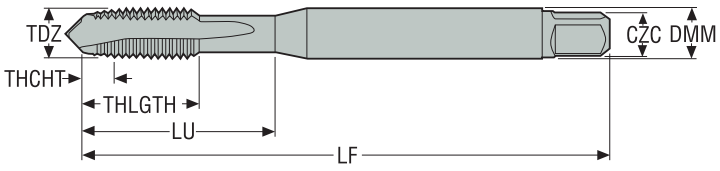
MTP-P003-A

Through holes



- For cutting data see page(s) 247
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.70ISO6HX-TB-P003-A	02999929	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	11,7 *0.461*	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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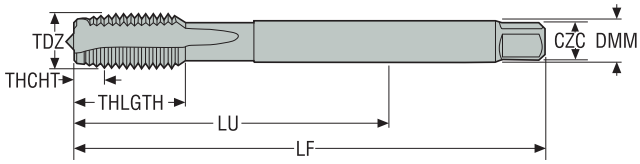
MTP-P004

Through holes



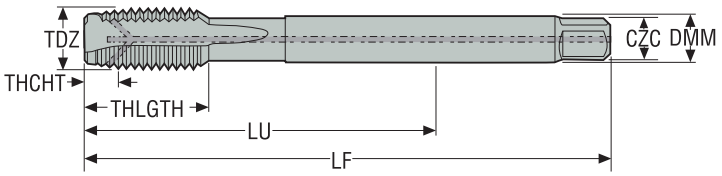
- For cutting data see page(s) 247
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.70ISO6HX-TB-P004	02999915	M4	0,7	–	2,8 *0.110*	43,0 *1.693*	12,0 *0.472*	63,0 *2.480*	3,4 *0.134*	2.80X2.10	3	DIN376	6HX	B
MTP-M5X0.80ISO6HX-TB-P004	02999916	M5	0,8	–	3,5 *0.138*	49,0 *1.929*	13,2 *0.520*	70,0 *2.756*	4,3 *0.169*	3.50X2.70	3	DIN376	6HX	B
MTP-M6X1.00ISO6HX-TB-P004	02999917	M6	1,0	–	4,5 *0.177*	59,0 *2.323*	15,1 *0.594*	80,0 *3.150*	5,1 *0.201*	4.50X3.40	3	DIN376	6HX	B
MTP-M8X1.25ISO6HX-TB-P004	02999918	M8	1,25	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	90,0 *3.543*	6,8 *0.268*	6.00X4.90	3	DIN376	6HX	B
MTP-M10X1.50ISO6HX-TB-P004	02999919	M10	1,5	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	100,0 *3.937*	8,6 *0.339*	7.00X5.50	3	DIN376	6HX	B
MTP-M12X1.75ISO6HX-TB-P004	02999920	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	4	DIN376	6HX	B
MTP-M14X2.00ISO6HX-TB-P004	02999921	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	4	DIN376	6HX	B
MTP-M16X2.00ISO6HX-TB-P004	02999922	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	4	DIN376	6HX	B
MTP-M18X2.50ISO6HX-TB-P004	02999923	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	125,0 *4.921*	15,7 *0.618*	14.00X11.00	4	DIN376	6HX	B
MTP-M20X2.50ISO6HX-TB-P004	02999924	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	140,0 *5.512*	17,7 *0.697*	16.00X12.00	4	DIN376	6HX	B
MTP-M22X2.50ISO6HX-TB-P004	02999925	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	140,0 *5.512*	19,7 *0.776*	18.00X14.50	4	DIN376	6HX	B
MTP-M24X3.00ISO6HX-TB-P004	02999926	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	160,0 *6.299*	21,0 *0.827*	18.00X14.50	4	DIN376	6HX	B
MTP-M27X3.00ISO6HX-TB-P004	02999927	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	160,0 *6.299*	24,0 *0.945*	20.00X16.00	4	DIN376	6HX	B
MTP-M30X3.50ISO6HX-TB-P004	02999928	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	180,0 *7.087*	26,5 *1.043*	22.00X18.00	4	DIN376	6HX	B

Please check availability at www.secotools.com / Seco Online Store

MTP-P004-A

Through holes



- For cutting data see page(s) 247
- 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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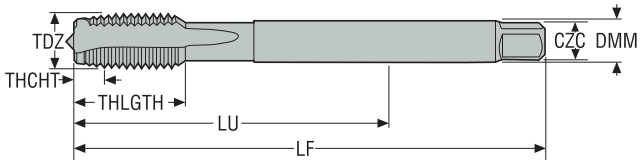
MTP-P011

Through holes



- For cutting data see page(s) 247
- Coating: AlTiN-based
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M4X0.50ISO6HX-TB-P011	02999944	MF4X0.5	0,5	–	2,8 *0.110*	43,0 *1.693*	12,0 *0.472*	63,0 *2.480*	3,5 *0.138*	2.80X2.10	3	DIN374	6HX	B
MTP-M5X0.50ISO6HX-TB-P011	02999945	MF5X0.5	0,5	–	3,5 *0.138*	49,0 *1.929*	13,0 *0.512*	70,0 *2.756*	4,5 *0.177*	3.50X2.70	3	DIN374	6HX	B
MTP-M6X0.75ISO6HX-TB-P011	02999946	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	15,0 *0.591*	80,0 *3.150*	5,3 *0.209*	4.50X3.40	3	DIN374	6HX	B
MTP-M8X0.75ISO6HX-TB-P011	02999947	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	15,0 *0.591*	80,0 *3.150*	7,3 *0.287*	6.00X4.90	3	DIN374	6HX	B
MTP-M8X1.00ISO6HX-TB-P011	02999948	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	90,0 *3.543*	7,1 *0.280*	6.00X4.90	3	DIN374	6HX	B
MTP-M10X0.75ISO6HX-TB-P011	02999949	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	90,0 *3.543*	9,3 *0.366*	7.00X5.50	3	DIN374	6HX	B
MTP-M10X1.00ISO6HX-TB-P011	02999950	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	90,0 *3.543*	9,1 *0.358*	7.00X5.50	3	DIN374	6HX	B
MTP-M10X1.25ISO6HX-TB-P011	02999951	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	100,0 *3.937*	8,8 *0.346*	7.00X5.50	3	DIN374	6HX	B
MTP-M12X1.00ISO6HX-TB-P011	02999952	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	11,1 *0.437*	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.25ISO6HX-TB-P011	02999953	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	10,8 *0.425*	9.00X7.00	4	DIN374	6HX	B
MTP-M12X1.50ISO6HX-TB-P011	02999954	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	10,6 *0.417*	9.00X7.00	4	DIN374	6HX	B
MTP-M14X1.00ISO6HX-TB-P011	02999955	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	13,1 *0.516*	11.00X9.00	4	DIN374	6HX	B
MTP-M14X1.25ISO6HX-TB-P011	02999956	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	12,8 *0.504*	11.00X9.00	4	DIN374	6HX	B
MTP-M14X1.50ISO6HX-TB-P011	02999957	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	12,6 *0.496*	11.00X9.00	4	DIN374	6HX	B
MTP-M16X1.00ISO6HX-TB-P011	02999958	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	100,0 *3.937*	15,1 *0.594*	12.00X9.00	4	DIN374	6HX	B
MTP-M16X1.50ISO6HX-TB-P011	02999959	MF16X1.5	1,5	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	100,0 *3.937*	14,6 *0.575*	12.00X9.00	4	DIN374	6HX	B
MTP-M18X1.00ISO6HX-TB-P011	02999960	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	110,0 *4.331*	17,1 *0.673*	14.00X11.00	4	DIN374	6HX	B
MTP-M18X1.50ISO6HX-TB-P011	02999961	MF18X1.5	1,5	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	110,0 *4.331*	16,6 *0.654*	14.00X11.00	4	DIN374	6HX	B
MTP-M20X1.00ISO6HX-TB-P011	02999962	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	125,0 *4.921*	19,1 *0.752*	16.00X12.00	4	DIN374	6HX	B
MTP-M20X1.50ISO6HX-TB-P011	02999963	MF20X1.5	1,5	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	125,0 *4.921*	18,6 *0.732*	16.00X12.00	4	DIN374	6HX	B
MTP-M22X1.50ISO6HX-TB-P011	02999964	MF22X1.5	1,5	–	18,0 *0.709*	78,0 *3.071*	25,0 *0.984*	125,0 *4.921*	20,5 *0.807*	18.00X14.50	4	DIN374	6HX	B

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M24X1.50ISO6HX-TB-P011	02999965	MF24X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	22,5 *0.886*	18.00X14.50	4	DIN374	6HX	B
MTP-M24X2.00ISO6HX-TB-P011	02999966	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	22,0 *0.866*	18.00X14.50	4	DIN374	6HX	B
MTP-M25X1.50ISO6HX-TB-P011	02999967	MF25X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	23,5 *0.925*	18.00X14.50	4	DIN374	6HX	B
MTP-M26X1.50ISO6HX-TB-P011	02999968	MF26X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	24,5 *0.965*	18.00X14.50	4	DIN374	6HX	B
MTP-M27X1.50ISO6HX-TB-P011	02999969	MF27X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	140,0 *5.512*	25,5 *1.004*	20.00X16.00	4	DIN374	6HX	B
MTP-M27X2.00ISO6HX-TB-P011	02999970	MF27X2.0	2,0	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	140,0 *5.512*	25,0 *0.984*	20.00X16.00	4	DIN374	6HX	B
MTP-M28X1.50ISO6HX-TB-P011	02999971	MF28X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	140,0 *5.512*	26,5 *1.043*	20.00X16.00	4	DIN374	6HX	B
MTP-M30X1.50ISO6HX-TB-P011	02999972	MF30X1.5	1,5	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	150,0 *5.906*	28,5 *1.122*	22.00X18.00	4	DIN374	6HX	B
MTP-M30X2.00ISO6HX-TB-P011	02999973	MF30X2.0	2,0	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	150,0 *5.906*	28,0 *1.102*	22.00X18.00	4	DIN374	6HX	B

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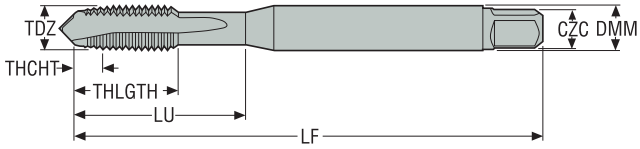
MTP-M003

Through holes



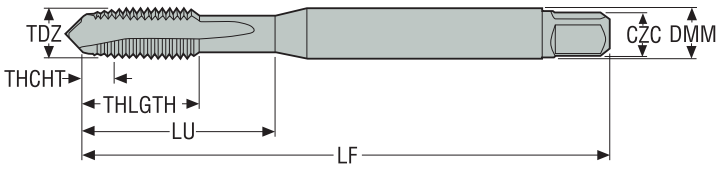
- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

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-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

Please check availability at www.secotools.com / Seco Online Store

MTP-M003-A

Through holes



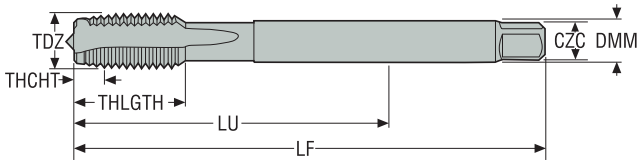
- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

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

Please check availability at www.secotools.com / Seco Online Store

MTP-M004

Through holes



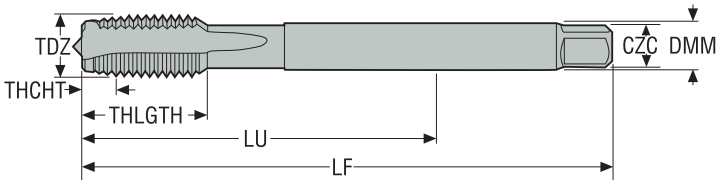
- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-M004	03000087	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	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

Please check availability at www.secotools.com / Seco Online Store

MTP-M004-A

Through holes



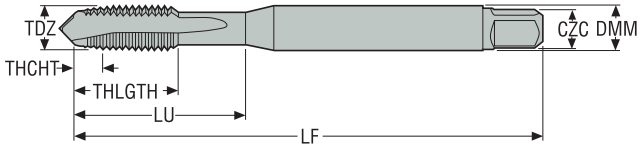
- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-M004-A	03000099	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-M004-A	03000100	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-M004-A	03000101	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B
MTP-M18X2.50ISO6H-TB-M004-A	03000102	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	125,0 *4.921*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	B
MTP-M20X2.50ISO6H-TB-M004-A	03000103	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	140,0 *5.512*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	B
MTP-M22X2.50ISO6H-TB-M004-A	03000104	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	140,0 *5.512*	19,7 *0.776*	18.00X14.50	4	DIN376	6H	B
MTP-M24X3.00ISO6H-TB-M004-A	03000105	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	160,0 *6.299*	21,0 *0.827*	18.00X14.50	4	DIN376	6H	B

Please check availability at www.secotools.com / Seco Online Store

MTP-N001

Through holes



- For cutting data see page(s) 251
- Coating: BRIGHT
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M3X0.50ISO6H-TB-N001	03000136	M3	0,5	–	3,5 *0.138*	16,0 *0.630*	9,0 *0.354*	56,0 *2.205*	2,5 *0.098*	3.50X2.70	2	DIN371	6H	B
MTP-M4X0.70ISO6H-TB-N001	03000137	M4	0,7	–	4,5 *0.177*	19,0 *0.748*	12,0 *0.472*	63,0 *2.480*	3,4 *0.134*	4.50X3.40	2	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-N001	03000138	M5	0,8	–	6,0 *0.236*	23,0 *0.906*	13,0 *0.512*	70,0 *2.756*	4,3 *0.169*	6.00X4.90	2	DIN371	6H	B
MTP-M6X1.00ISO6H-TB-N001	03000139	M6	1,0	–	6,0 *0.236*	27,0 *1.063*	15,0 *0.591*	80,0 *3.150*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	B
MTP-M8X1.25ISO6H-TB-N001	03000140	M8	1,25	–	8,0 *0.315*	28,0 *1.102*	18,0 *0.709*	90,0 *3.543*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	B
MTP-M10X1.50ISO6H-TB-N001	03000141	M10	1,5	–	10,0 *0.394*	30,0 *1.181*	20,0 *0.787*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	B

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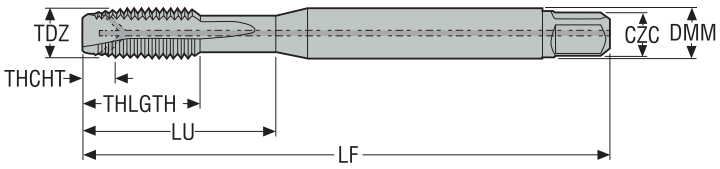
MTP-N001-A

Through holes



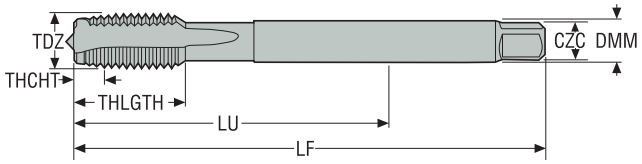
- For cutting data see page(s) 251
- Coating: BRIGHT
- Substrate: HSS-PM
- Internal coolant

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

Please check availability at www.secotools.com / Seco Online Store

MTP-N002

Through holes



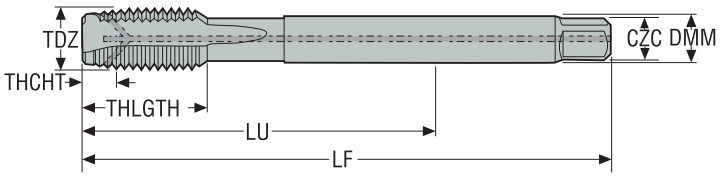
- For cutting data see page(s) 251
- Coating: BRIGHT
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6H-TB-N002	03000142	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	B
MTP-M14X2.00ISO6H-TB-N002	03000143	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	B
MTP-M16X2.00ISO6H-TB-N002	03000144	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	B

Please check availability at www.secotools.com / Seco Online Store

MTP-N002-A

Through holes



- For cutting data see page(s) 251
- 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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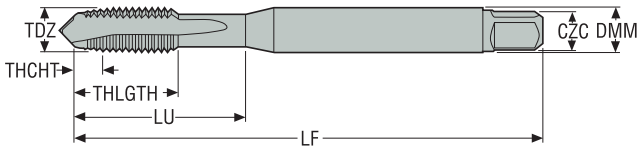
MTP-S001

Through holes



- For cutting data see page(s) 257
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M2X0.40ISO6HX-TB-S001	10001159	M2	0,4	–	2,8 *0.110*	8,0 *0.315*	8,0 *0.315*	45,0 *1.772*	1,6 *0.063*	2.80X2.10	2	DIN371	6HX	B
MTP-M2.5X0.45ISO6HX-TB-S001	10001161	M2.5	0,45	–	2,8 *0.110*	9,0 *0.354*	9,0 *0.354*	50,0 *1.969*	2,05 *0.081*	2.80X2.10	2	DIN371	6HX	B
MTP-M3X0.50ISO6HX-TB-S001	10001162	M3	0,5	–	3,5 *0.138*	10,0 *0.394*	10,0 *0.394*	56,0 *2.205*	2,5 *0.098*	3.50X2.70	2	DIN371	6HX	B
MTP-M3.5X0.60ISO6HX-TB-S001	10001163	M3.5	0,6	–	4,0 *0.157*	12,0 *0.472*	12,0 *0.472*	56,0 *2.205*	2,9 *0.114*	4.00X3.00	3	DIN371	6HX	B
MTP-M4X0.70ISO6HX-TB-S001	10001164	M4	0,7	–	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	63,0 *2.480*	3,3 *0.130*	4.50X3.40	3	DIN371	6HX	B
MTP-M5X0.80ISO6HX-TB-S001	10001165	M5	0,8	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	70,0 *2.756*	4,2 *0.165*	6.00X4.90	3	DIN371	6HX	B
MTP-M6X1.00ISO6HX-TB-S001	10001166	M6	1,0	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	80,0 *3.150*	5,0 *0.197*	6.00X4.90	3	DIN371	6HX	B
MTP-M8X1.25ISO6HX-TB-S001	10001167	M8	1,25	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	90,0 *3.543*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	B
MTP-M10X1.50ISO6HX-TB-S001	10001168	M10	1,5	–	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	100,0 *3.937*	8,5 *0.335*	10.00X8.00	3	DIN371	6HX	B

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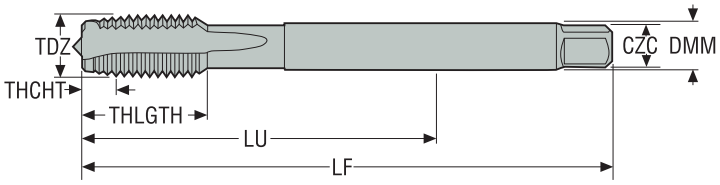
MTP-S002

Through holes



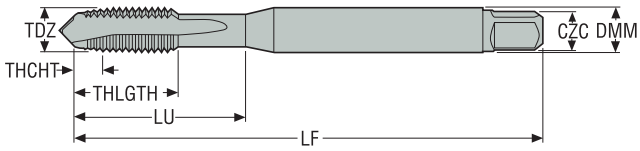
- For cutting data see page(s) 257
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M12X1.75ISO6HX-TB-S002	10001169	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	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

Please check availability at www.secotools.com / Seco Online Store

MTP-S011

Through holes



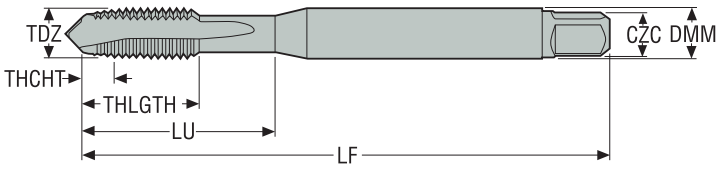
- For cutting data see page(s) 257
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M6X0.75ISO6HX-TB-S011	10001176	MF6X0.75	0,75	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	80,0 *3.150*	5,25 *0.207*	6.00X4.90	3	DIN371	6HX	B
MTP-M8X0750ISO6HX-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

Please check availability at www.secotools.com / Seco Online Store

MTP-S012

Through holes



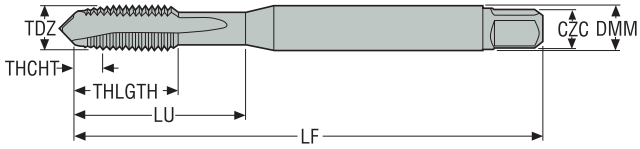
- For cutting data see page(s) 257
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-MJ4X0.70ISO4H-TB-S012	10001172	MJ4X0.7	0,7	–	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	63,0 *2.480*	3,4 *0.134*	4.50X3.40	3	DIN371	4H	B
MTP-MJ5X0.80ISO4H-TB-S012	10001173	MJ5X0.8	0,8	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	70,0 *2.756*	4,3 *0.169*	6.00X4.90	3	DIN371	4H	B
MTP-MJ6X1.00ISO4H-TB-S012	10001174	MJ6X1	1,0	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	80,0 *3.150*	5,1 *0.201*	6.00X4.90	3	DIN371	4H	B
MTP-MJ8X1.25ISO4H-TB-S012	10001175	MJ8X1.25	1,25	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	90,0 *3.543*	6,9 *0.272*	8.00X6.20	3	DIN371	4H	B

Please check availability at www.secotools.com / Seco Online Store

MTP-S013

Through holes



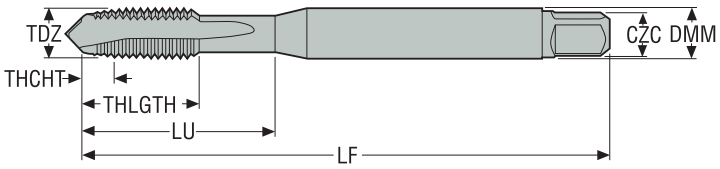
- For cutting data see page(s) 257
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-EGM4X0.7ISO4H-TB-S013 *MTP-STIM4X0.7ISO4H-TB-S013*	10001218	EGM4	0,7	–	6,0 0.236	16 0.630	16,0 0.630	70,0 2.756	4,2 *0.165*	6.00X4.90	3	DIN40435	4H	B
MTP-EGM5X0.8ISO4H-TB-S013 *MTP-STIM5X0.8ISO4H-TB-S013*	10001219	EGM5	0,8	–	6,0 0.236	23 0.906	15,0 0.591	80,0 3.150	5,3 *0.207*	6.00X4.90	3	DIN40435	4H	B
MTP-EGM6X1.0ISO4H-TB-S013 *MTP-STIM6X1.0ISO4H-TB-S013*	10001220	EGM6	1,0	–	8,0 0.315	35 1.378	18,0 0.709	90,0 3.543	6,3 *0.248*	8.00X6.20	3	DIN40435	4H	B
MTP-EGM8X1.25ISO4H-TB-S013 *MTP-STIM8X1.25ISO4H-TB-S013*	10001221	EGM8	1,25	–	10,0 0.394	34 1.319	20,0 0.787	100,0 3.937	8,4 *0.331*	10.00X8.00	3	DIN40435	4H	B

Please check availability at www.secotools.com / Seco Online Store

MTP-S042

Through holes



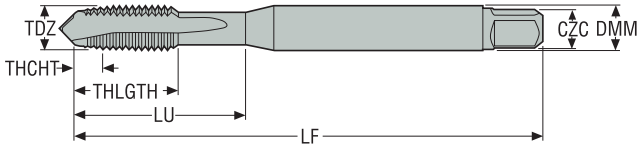
- For cutting data see page(s) 257
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-10-32UNJF3B-TB-S042	10001183	UNJF10-32	–	32.0	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	70,0 *2.756*	4,15 *0.163*	6.00X4.90	3	DIN2184-1	3B	B
MTP-1/4-28UNJF3B-TB-S042	10001184	UNJF1/4-28	–	28.0	7,0 *0.276*	25,0 *0.984*	15,0 *0.591*	80,0 *3.150*	5,6 *0.220*	7.00X5.50	3	DIN2184-1	3B	B
MTP-5/16-24UNJF3B-TB-S042	10001186	UNJF5/16-24	–	24.0	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	90,0 *3.543*	7,0 *0.276*	8.00X6.20	3	DIN2184-1	3B	B
MTP-3/8-24UNJF3B-TB-S042	10001185	UNJF3/8-24	–	24.0	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	DIN2184-1	3B	B

Please check availability at www.secotools.com / Seco Online Store

MTP-S043

Through holes



- For cutting data see page(s) 257
- 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

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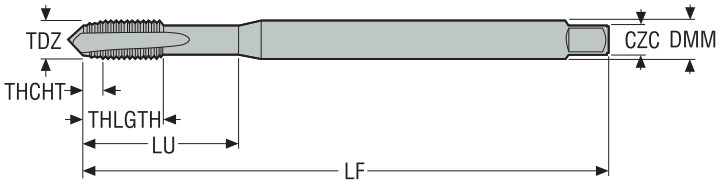
MTP-V001

Through holes



- For cutting data see page(s) 265
- 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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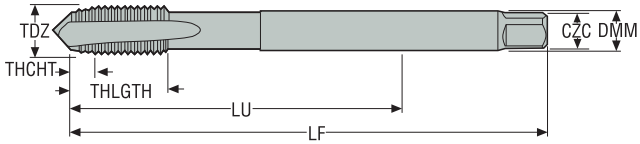
MTP-V002

Through holes



- For cutting data see page(s) 265
- 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-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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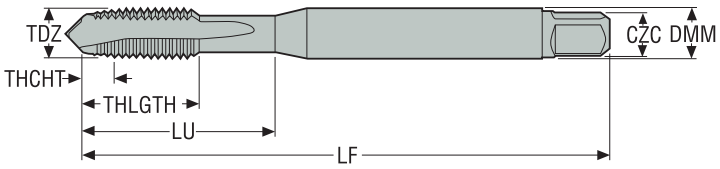
MTP-V005

Through holes



- For cutting data see page(s) 265
- 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-M3X0.50ISO6G-TB-V005	03019094	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	6G	B
MTP-M4X0.70ISO6G-TB-V005	03019095	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	6G	B
MTP-M5X0.80ISO6G-TB-V005	03019096	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	6G	B
MTP-M6X1.00ISO6G-TB-V005	03019097	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	6G	B
MTP-M8X1.25ISO6G-TB-V005	03019098	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	6G	B
MTP-M10X1.50ISO6G-TB-V005	03019099	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	6G	B

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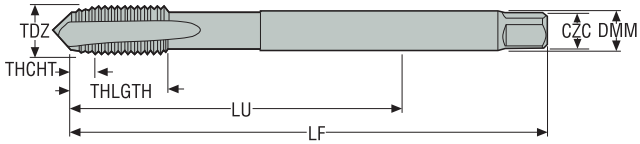
MTP-V006

Through holes



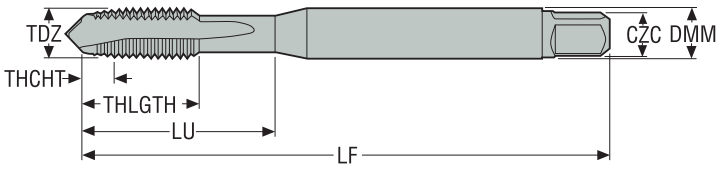
- For cutting data see page(s) 265
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

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-M12X1.75ISO6G-TB-V006	03019100	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	6G	B
MTP-M16X2.00ISO6G-TB-V006	03019101	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	6G	B
MTP-M20X2.50ISO6G-TB-V006	03019102	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	6G	B

Please check availability at www.secotools.com / Seco Online Store

MTP-V007

Through holes



- For cutting data see page(s) 265
- Coating: TiN
- Substrate: HSS-E ≤ M2,5; HSS-PM > M2,5

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M2X0.40ISO6H-TB-V007	03019103	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-M2.5X0.45ISO6H-TB-V007	03019104	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-M3X0.50ISO6H-TB-V007	03019105	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-M3.50X0.60ISO6H-TB-V007	03019106	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-V007	03019107	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-M4.5X0.75ISO6H-TB-V007	03019108	M4.5	0,75	–	6,0 *0.236*	25,0 *0.984*	12,6 *0.496*	70,0 *2.756*	3,8 *0.150*	6.00X4.90	3	DIN371	6H	B
MTP-M5X0.80ISO6H-TB-V007	03019109	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-V007	03019110	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-M7X1.00ISO6H-TB-V007	03019111	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	6H	B
MTP-M8X1.25ISO6H-TB-V007	03019112	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-V007	03019113	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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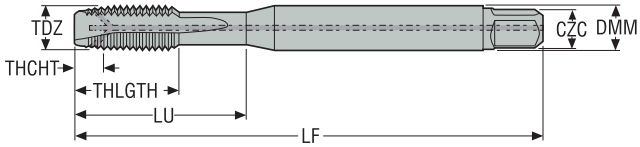
MTP-V007-A

Through holes



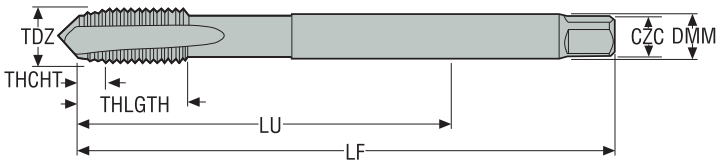
- For cutting data see page(s) 265
- Coating: TiN
- Substrate: HSS-PM
- Internal coolant

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

Please check availability at www.secotools.com / Seco Online Store

MTP-V008

Through holes



- For cutting data see page(s) 265
- 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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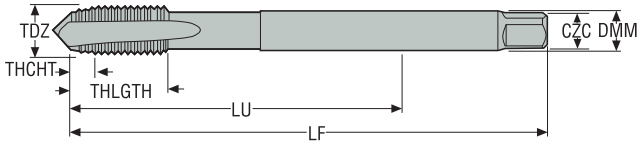
MTP-V008-A

Through holes



- For cutting data see page(s) 265
- 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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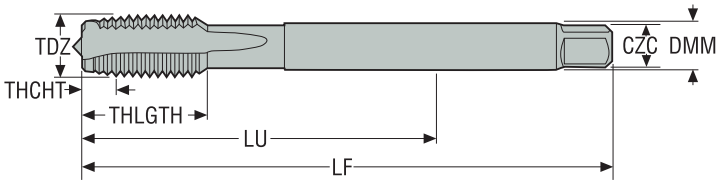
MTP-V014

Through holes



- For cutting data see page(s) 267
- 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-M4X0.50ISO6H-TB-V014	03019130	MF4X0.5	0,5	–	2,8 *0.110*	43,0 *1.693*	11,9 *0.469*	63,0 *2.480*	3,5 *0.138*	2.80X2.10	3	DIN374	6H	B
MTP-M5X0.50ISO6H-TB-V014	03019131	MF5X0.5	0,5	–	3,5 *0.138*	49,0 *1.929*	13,2 *0.520*	70,0 *2.756*	4,5 *0.177*	3.50X2.70	3	DIN374	6H	B
MTP-M6X0.75ISO6H-TB-V014	03019210	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	15,1 *0.594*	80,0 *3.150*	5,3 *0.209*	4.50X3.40	3	DIN374	6H	B
MTP-M8X0.75ISO6H-TB-V014	03019132	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	14,9 *0.587*	80,0 *3.150*	7,3 *0.287*	6.00X4.90	3	DIN374	6H	B
MTP-M8X1.00ISO6H-TB-V014	03019133	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	90,0 *3.543*	7,1 *0.280*	6.00X4.90	3	DIN374	6H	B
MTP-M9X1.00ISO6H-TB-V014	03000358	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	B
MTP-M10X0.75ISO6H-TB-V014	03019134	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	90,0 *3.543*	9,3 *0.366*	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.00ISO6H-TB-V014	03019135	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	90,0 *3.543*	9,1 *0.358*	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.25ISO6H-TB-V014	03019136	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	100,0 *3.937*	8,8 *0.346*	7.00X5.50	3	DIN374	6H	B
MTP-M11X1.00ISO6H-TB-V014	03000359	MF11X1.0	1,0	–	8,0 *0.315*	63,0 *2.480*	18,0 *0.709*	90,0 *3.543*	10,1 *0.398*	8.00X6.20	3	DIN374	6H	B
MTP-M11X1.25ISO6H-TB-V014	03000360	MF11X1.25	1,25	–	8,0 *0.315*	63,0 *2.480*	22,0 *0.866*	90,0 *3.543*	9,8 *0.386*	8.00X6.20	3	DIN374	6H	B
MTP-M12X1.00ISO6H-TB-V014	03019137	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	11,1 *0.437*	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.25ISO6H-TB-V014	03019138	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	3	DIN374	6H	B
MTP-M12X1.50ISO6H-TB-V014	03019139	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	3	DIN374	6H	B
MTP-M14X1.00ISO6H-TB-V014	03019140	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	13,1 *0.516*	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.25ISO6H-TB-V014	03019141	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	12,8 *0.504*	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.50ISO6H-TB-V014	03019142	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	3	DIN374	6H	B
MTP-M16X1.00ISO6H-TB-V014	03019143	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	100,0 *3.937*	15,1 *0.594*	12.00X9.00	3	DIN374	6H	B
MTP-M16X1.50ISO6H-TB-V014	03019144	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	3	DIN374	6H	B
MTP-M18X1.00ISO6H-TB-V014	03019145	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	110,0 *4.331*	17,1 *0.673*	14.00X11.00	4	DIN374	6H	B
MTP-M18X1.50ISO6H-TB-V014	03019146	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	6H	B

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M20X1.00ISO6H-TB-V014	03019147	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	125,0 *4.921*	19,1 *0.752*	16.00X12.00	4	DIN374	6H	B
MTP-M20X1.50ISO6H-TB-V014	03019148	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	6H	B
MTP-M22X1.50ISO6H-TB-V014	03019149	MF22X1.5	1,5	–	18,0 *0.709*	78,0 *3.071*	25,0 *0.984*	125,0 *4.921*	20,5 *0.807*	18.00X14.50	4	DIN374	6H	B
MTP-M24X1.50ISO6H-TB-V014	03019151	MF24X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	22,5 *0.886*	18.00X14.50	4	DIN374	6H	B
MTP-M24X2.00ISO6H-TB-V014	03019152	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	22,0 *0.866*	18.00X14.50	4	DIN374	6H	B
MTP-M25X1.50ISO6H-TB-V014	03019153	MF25X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	23,5 *0.925*	18.00X14.50	4	DIN374	6H	B
MTP-M26X1.50ISO6H-TB-V014	03019155	MF26X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	24,5 *0.965*	18.00X14.50	4	DIN374	6H	B
MTP-M27X1.50ISO6H-TB-V014	03019156	MF27X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	140,0 *5.512*	25,5 *1.004*	20.00X16.00	4	DIN374	6H	B
MTP-M27X2.00ISO6H-TB-V014	03019157	MF27X2.0	2,0	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	140,0 *5.512*	25,0 *0.984*	20.00X16.00	4	DIN374	6H	B
MTP-M28X1.50ISO6H-TB-V014	03019158	MF28X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	28,0 *1.102*	140,0 *5.512*	26,5 *1.043*	20.00X16.00	4	DIN374	6H	B
MTP-M30X1.50ISO6H-TB-V014	03019159	MF30X1.5	1,5	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	150,0 *5.906*	28,5 *1.122*	22.00X18.00	4	DIN374	6H	B
MTP-M30X2.00ISO6H-TB-V014	03019160	MF30X2.0	2,0	–	22,0 *0.866*	85,0 *3.346*	28,0 *1.102*	150,0 *5.906*	28,0 *1.102*	22.00X18.00	4	DIN374	6H	B

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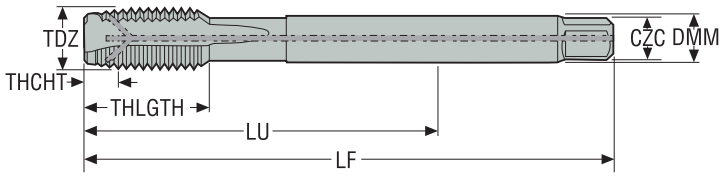
MTP-V014-A

Through holes

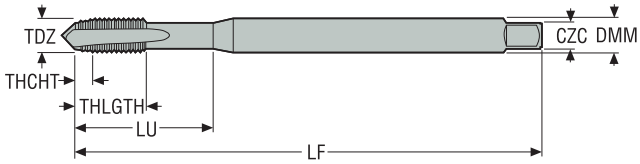


- For cutting data see page(s) 267
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTP-M6X0.75ISO6H-TB-V014-A	03000200	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	15,1 *0.594*	80,0 *3.150*	5,3 *0.209*	4.50X3.40	3	DIN374	6H	B
MTP-M8X0.75ISO6H-TB-V014-A	03000201	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	14,9 *0.587*	80,0 *3.150*	7,3 *0.287*	6.00X4.90	3	DIN374	6H	B
MTP-M8X1.00ISO6H-TB-V014-A	03000202	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	90,0 *3.543*	7,1 *0.280*	6.00X4.90	3	DIN374	6H	B
MTP-M10X0.75ISO6H-TB-V014-A	03000203	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	90,0 *3.543*	9,3 *0.366*	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.00ISO6H-TB-V014-A	03000204	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	17,6 *0.693*	90,0 *3.543*	9,1 *0.358*	7.00X5.50	3	DIN374	6H	B
MTP-M10X1.25ISO6H-TB-V014-A	03000205	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	19,8 *0.780*	100,0 *3.937*	8,8 *0.346*	7.00X5.50	3	DIN374	6H	B
MTP-M12X1.00ISO6H-TB-V014-A	03000206	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	11,1 *0.437*	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.25ISO6H-TB-V014-A	03000207	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	10,8 *0.425*	9.00X7.00	3	DIN374	6H	B
MTP-M12X1.50ISO6H-TB-V014-A	03000208	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	3	DIN374	6H	B
MTP-M14X1.00ISO6H-TB-V014-A	03000209	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	13,1 *0.516*	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.25ISO6H-TB-V014-A	03000210	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	12,8 *0.504*	11.00X9.00	3	DIN374	6H	B
MTP-M14X1.50ISO6H-TB-V014-A	03000211	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	3	DIN374	6H	B
MTP-M16X1.00ISO6H-TB-V014-A	03000212	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	100,0 *3.937*	15,1 *0.594*	12.00X9.00	3	DIN374	6H	B
MTP-M16X1.50ISO6H-TB-V014-A	03000213	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	3	DIN374	6H	B
MTP-M18X1.00ISO6H-TB-V014-A	03000214	MF18X1.0	1,0	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	110,0 *4.331*	17,1 *0.673*	14.00X11.00	4	DIN374	6H	B
MTP-M18X1.50ISO6H-TB-V014-A	03000215	MF18X1.5	1,5	–	14,0 *0.551*	66,0 *2.598*	24,0 *0.945*	110,0 *4.331*	16,6 *0.654*	14.00X11.00	4	DIN374	6H	B
MTP-M20X1.00ISO6H-TB-V014-A	03000216	MF20X1.0	1,0	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	125,0 *4.921*	19,1 *0.752*	16.00X12.00	4	DIN374	6H	B
MTP-M20X1.50ISO6H-TB-V014-A	03000217	MF20X1.5	1,5	–	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	125,0 *4.921*	18,6 *0.732*	16.00X12.00	4	DIN374	6H	B
MTP-M22X1.50ISO6H-TB-V014-A	03000218	MF22X1.5	1,5	–	18,0 *0.709*	78,0 *3.071*	25,0 *0.984*	125,0 *4.921*	20,5 *0.807*	18.00X14.50	4	DIN374	6H	B
MTP-M24X1.50ISO6H-TB-V014-A	03000219	MF24X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	22,5 *0.886*	18.00X14.50	4	DIN374	6H	B
MTP-M24X2.00ISO6H-TB-V014-A	03000220	MF24X2.0	2,0	–	18,0 *0.709*	93,0 *3.661*	28,0 *1.102*	140,0 *5.512*	22,0 *0.866*	18.00X14.50	4	DIN374	6H	B

MTP-V017

Through holes



- For cutting data see page(s) 267
- 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-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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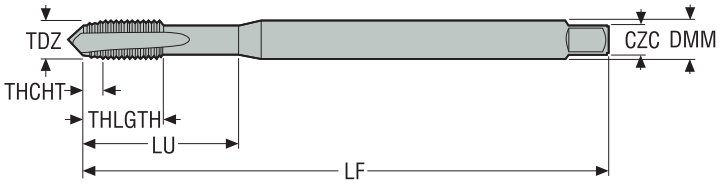
MTP-V020

Through holes



- For cutting data see page(s) 267
- 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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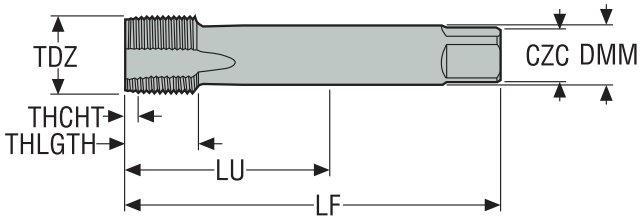
MTP-V023

Through holes



- For cutting data see page(s) 267
- 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-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

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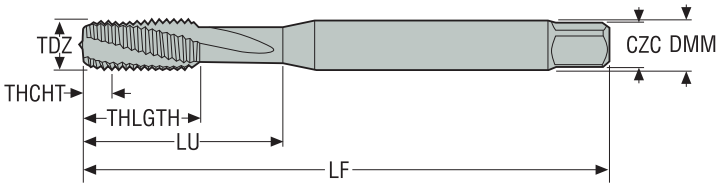
MTH-P001

Blind holes



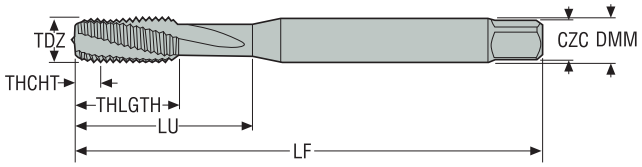
- For cutting data see page(s) 245
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6H-BC-P001	02999974	M3	0,5	–	4,5 *0.177*	12,0 *0.472*	12,0 *0.472*	63,0 *2.480*	2,5 *0.098*	4.50X3.40	3	SECO-DIN	6H	C
MTH-M4X0.70ISO6H-BC-P001	02999975	M4	0,7	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	70,0 *2.756*	3,4 *0.134*	6.00X4.90	3	SECO-DIN	6H	C
MTH-M5X0.80ISO6H-BC-P001	02999976	M5	0,8	–	6,0 *0.236*	15,0 *0.591*	15,0 *0.591*	80,0 *3.150*	4,3 *0.169*	6.00X4.90	3	SECO-DIN	6H	C
MTH-M6X1.00ISO6H-BC-P001	02999977	M6	1,0	–	8,0 *0.315*	18,0 *0.709*	18,0 *0.709*	90,0 *3.543*	5,1 *0.201*	8.00X6.20	3	SECO-DIN	6H	C
MTH-M8X1.25ISO6H-BC-P001	02999978	M8	1,25	–	10,0 *0.394*	20,0 *0.787*	20,0 *0.787*	100,0 *3.937*	6,8 *0.268*	10.00X8.00	3	SECO-DIN	6H	C
MTH-M10X1.50ISO6H-BC-P001	02999979	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	SECO-DIN	6H	C

Please check availability at www.secotools.com / Seco Online Store

MTH-P001-A

Blind holes



- For cutting data see page(s) 245
- 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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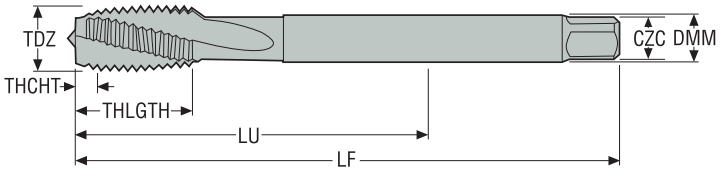
MTH-P002

Blind holes



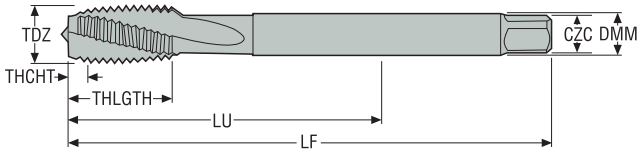
- For cutting data see page(s) 245
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-P002	02999980	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	4	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-P002	02999981	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	4	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-P002	02999982	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-P002	02999983	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	125,0 *4.921*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-P002	02999984	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	140,0 *5.512*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C

Please check availability at www.secotools.com / Seco Online Store

MTH-P002-A

Blind holes



- For cutting data see page(s) 245
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-P002-A	02999990	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	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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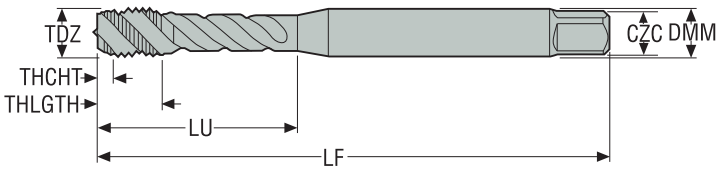
MTH-P003

Blind holes



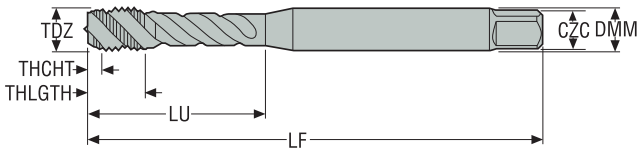
- For cutting data see page(s) 245
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M1.6X0.35ISO6HX-BC-P003	02999995	M1.6	0,35	–	2,5 *0.098*	6,0 *0.236*	4,0 *0.157*	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 in current price and stock-list

MTH-P003-A

Blind holes



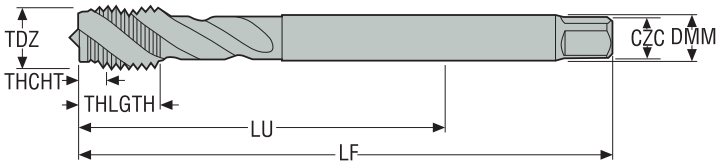
- For cutting data see page(s) 245
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

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 / Seco Online Store

MTH-P004

Blind holes



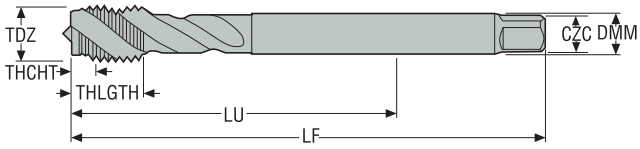
- For cutting data see page(s) 245
- Coating: AlTiN-based
- Substrate: HSS-E-PM

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 / Seco Online Store

MTH-P004-A

Blind holes



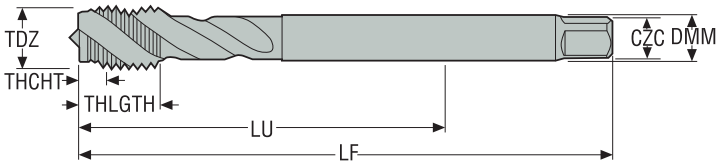
- For cutting data see page(s) 245
- Coating: AlTiN-based
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-P004-A	03000030	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	16,0 *0.630*	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 in current price and stock-list

MTH-P011

Blind holes



- For cutting data see page(s) 245
- Coating: AlTiN-based
- Substrate: HSS-E-PM

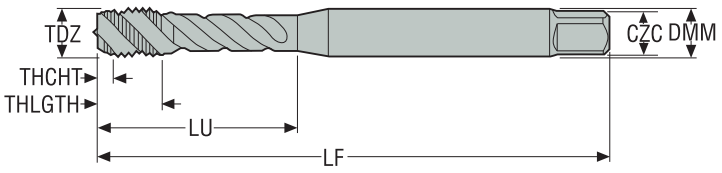
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.50ISO6HX-BC-P011	03000040	MF4X0.5	0,5	–	2,8 *0.110*	43,0 *1.693*	7,0 *0.276*	63,0 *2.480*	3,5 *0.138*	2.80X2.10	3	DIN374	6HX	C
MTH-M5X0.50ISO6HX-BC-P011	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

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-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
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

Please check availability at www.secotools.com / Seco Online Store

MTH-M003

Blind holes



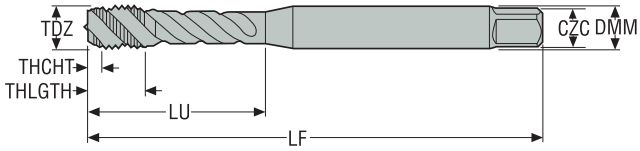
- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E

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

Please check availability at www.secotools.com / Seco Online Store

MTH-M003-A

Blind holes



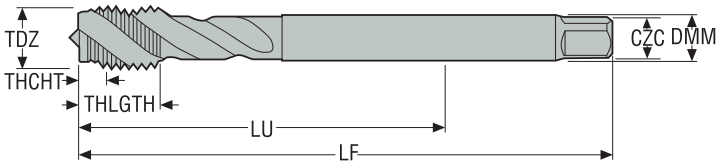
- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.70ISO6H-BC-M003-A	03000125	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	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

Please check availability at www.secotools.com / Seco Online Store

MTH-M004

Blind holes



- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-M004	03000120	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-M004	03000121	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-M004	03000122	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	20,0 *0.787*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	4	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-M004	03000123	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	25,0 *0.984*	125,0 *4.921*	15,7 *0.618*	14.00X11.00	4	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-M004	03000124	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	25,0 *0.984*	140,0 *5.512*	17,7 *0.697*	16.00X12.00	4	DIN376	6H	C

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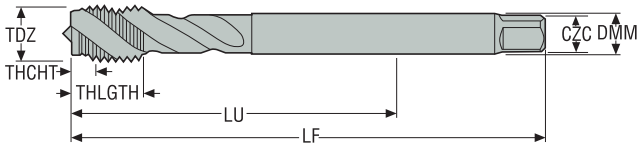
MTH-M004-A

Blind holes



- For cutting data see page(s) 249
- Coating: TiCN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-M004-A	03000131	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	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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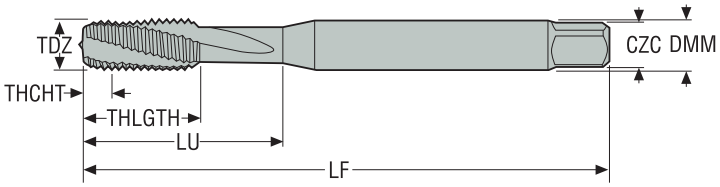
MTH-N001

Blind holes



- For cutting data see page(s) 251
- Coating: BRIGHT
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6H-BC-N001	03000153	M3	0,5	–	3,5 *0.138*	18,0 *0.709*	9,0 *0.354*	56,0 *2.205*	2,5 *0.098*	3.50X2.70	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-N001	03000154	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	12,0 *0.472*	63,0 *2.480*	3,4 *0.134*	4.50X3.40	3	DIN371	6H	C
MTH-M5X0.80ISO6H-BC-N001	03000155	M5	0,8	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	70,0 *2.756*	4,3 *0.169*	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-N001	03000156	M6	1,0	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	80,0 *3.150*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-N001	03000157	M8	1,25	–	8,0 *0.315*	35,0 *1.378*	18,0 *0.709*	90,0 *3.543*	6,8 *0.268*	8.00X6.20	3	DIN371	6H	C
MTH-M10X1.50ISO6H-BC-N001	03000158	M10	1,5	–	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	DIN371	6H	C

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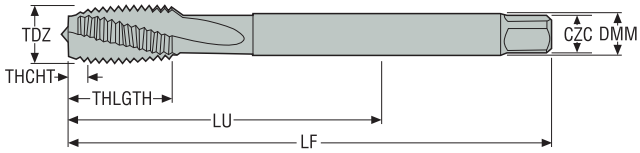
MTH-N002

Blind holes



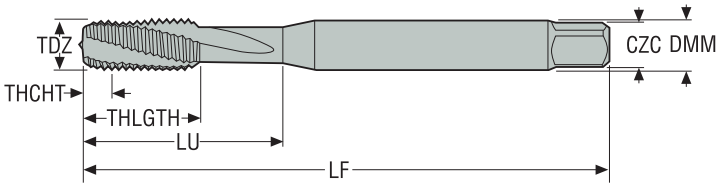
- For cutting data see page(s) 251
- Coating: BRIGHT
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-N002	03000159	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-N002	03000160	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-N002	03000161	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	3	DIN376	6H	C

Please check availability at www.secotools.com / Seco Online Store

MTH-S001

Blind holes



- For cutting data see page(s) 253
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6HX-BC-S001	10001105	M3	0,5	–	3,5 *0.138*	8,0 *0.315*	8,0 *0.315*	56,0 *2.205*	2,5 *0.098*	3.50X2.70	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S001	10001106	M4	0,7	–	4,5 *0.177*	10,5 *0.413*	10,5 *0.413*	63,0 *2.480*	3,3 *0.130*	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S001	10001107	M5	0,8	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	70,0 *2.756*	4,2 *0.165*	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S001	10001108	M6	1,0	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	80,0 *3.150*	5,0 *0.197*	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S001	10001109	M8	1,25	–	8,0 *0.315*	20,5 *0.807*	20,5 *0.807*	90,0 *3.543*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S001	10001110	M10	1,5	–	10,0 *0.394*	25,5 *1.004*	25,5 *1.004*	100,0 *3.937*	8,5 *0.335*	10.00X8.00	3	DIN371	6HX	C

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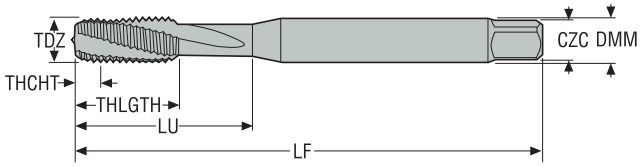
MTH-S002

Blind holes



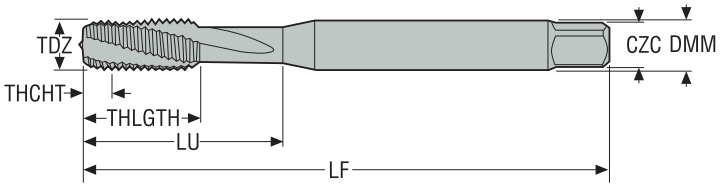
- For cutting data see page(s) 253
- Substrate: HSS-E-PM

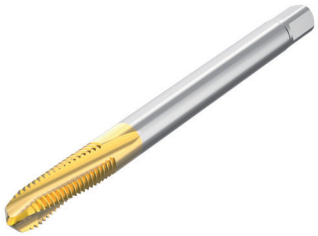
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-S002	10001111	M12	1,75	–	12,0 *0.472*	30,5 *1.201*	30,5 *1.201*	110,0 *4.331*	10,2 *0.402*	12.00X9.00	4	DIN371	6HX	C
MTH-M16X2.00ISO6HX-BC-S002	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

Please check availability at www.secotools.com / Seco Online Store

MTH-S003

Blind holes





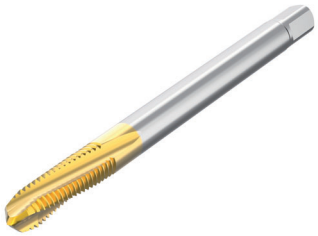
- For cutting data see page(s) 251
- Coating: TiN
- Substrate: HSS-E-PM

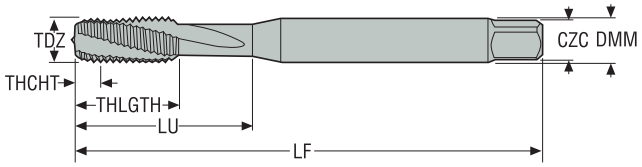
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M3X0.50ISO6HX-BC-S003	10001073	M3	0,5	–	3,5 *0.138*	8,0 *0.315*	8,0 *0.315*	56,0 *2.205*	2,5 *0.098*	3.50X2.70	3	DIN371	6HX	C
MTH-M4X0.70ISO6HX-BC-S003	10001074	M4	0,7	–	4,5 *0.177*	10,5 *0.413*	10,5 *0.413*	63,0 *2.480*	3,3 *0.130*	4.50X3.40	3	DIN371	6HX	C
MTH-M5X0.80ISO6HX-BC-S003	10001075	M5	0,8	–	6,0 *0.236*	13,0 *0.512*	13,0 *0.512*	70,0 *2.756*	4,2 *0.165*	6.00X4.90	3	DIN371	6HX	C
MTH-M6X1.00ISO6HX-BC-S003	10001076	M6	1,0	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	80,0 *3.150*	5,0 *0.197*	6.00X4.90	3	DIN371	6HX	C
MTH-M8X1.25ISO6HX-BC-S003	10001077	M8	1,25	–	8,0 *0.315*	20,5 *0.807*	20,5 *0.807*	90,0 *3.543*	6,8 *0.268*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.50ISO6HX-BC-S003	10001078	M10	1,5	–	10,0 *0.394*	25,5 *1.004*	25,5 *1.004*	100,0 *3.937*	8,5 *0.335*	10.00X8.00	3	DIN371	6HX	C

Please check availability at www.secotools.com / Seco Online Store

MTH-S004

Blind holes





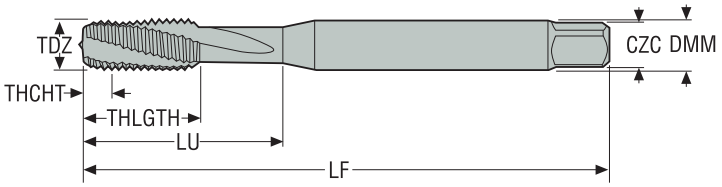
- For cutting data see page(s) 253
- Coating: TiN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-S004	10001079	M12	1,75	–	12,0 *0.472*	30,5 *1.201*	30,5 *1.201*	110,0 *4.331*	10,2 *0.402*	12.00X9.00	4	DIN371	6HX	C
MTH-M16X2.00ISO6HX-BC-S004	10001080	M16	2,0	–	16,0 *0.630*	39,5 *1.555*	39,5 *1.555*	110,0 *4.331*	14,0 *0.551*	16.00X12.00	4	DIN371	6HX	C

Please check availability at www.secotools.com / Seco Online Store

MTH-S011

Blind holes



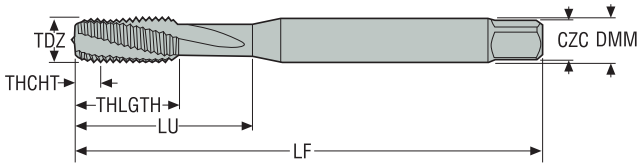
- For cutting data see page(s) 253
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M8X1.00ISO6HX-BC-S011	10001082	MF8X1	1,0	–	8,0 *0.315*	20,0 *0.787*	20,0 *0.787*	90,0 *3.543*	7,0 *0.276*	8.00X6.20	3	DIN371	6HX	C
MTH-M10X1.00ISO6HX-BC-S011	10001083	MF10X1	1,0	–	10,0 *0.394*	24,0 *0.945*	24,0 *0.945*	90,0 *3.543*	9,0 *0.354*	10.00X8.00	3	DIN371	6HX	C
MTH-M10X1.25ISO6HX-BC-S011	10001084	MF10X1.25	1,25	–	10,0 *0.394*	24,5 *0.965*	24,5 *0.965*	100,0 *3.937*	8,75 *0.344*	10.00X8.00	3	DIN371	6HX	C
MTH-M12X1.25ISO6HX-BC-S011	10001085	MF12X1.25	1,25	–	12,0 *0.472*	28,5 *1.122*	28,5 *1.122*	100,0 *3.937*	10,75 *0.423*	12.00X9.00	4	DIN371	6HX	C
MTH-M12X1.50ISO6HX-BC-S011	10001086	MF12X1.5	1,5	–	12,0 *0.472*	29,5 *1.161*	29,5 *1.161*	100,0 *3.937*	10,5 *0.413*	12.00X9.00	4	DIN371	6HX	C

Please check availability at www.secotools.com / Seco Online Store

MTH-S012

Blind holes



- For cutting data see page(s) 253
- 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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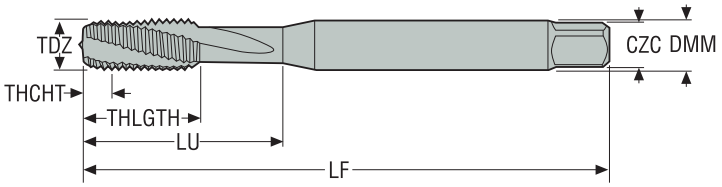
MTH-S031

Blind holes



- For cutting data see page(s) 253
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-2-56UNC2B-BC-S031	10001113	UNC2-56	–	56.0	2,8 *0.110*	9,0 *0.354*	9,0 *0.354*	45,0 *1.772*	1,85 *0.073*	2.80X2.10	3	DIN2184-1	2B	C
MTH-3-48UNC2B-BC-S031	10001114	UNC3-48	–	48.0	2,8 *0.110*	9,0 *0.354*	9,0 *0.354*	50,0 *1.969*	2,1 *0.083*	2.80X2.10	3	DIN2184-1	2B	C
MTH-4-40UNC2B-BC-S031	10001115	UNC4-40	–	40.0	3,5 *0.138*	10,0 *0.394*	10,0 *0.394*	56,0 *2.205*	2,35 *0.093*	3.50X2.70	3	DIN2184-1	2B	C
MTH-6-32UNC2B-BC-S031	10001116	UNC6-32	–	32.0	4,0 *0.157*	12,0 *0.472*	12,0 *0.472*	56,0 *2.205*	2,85 *0.112*	4.00X3.00	3	DIN2184-1	2B	C
MTH-8-32UNC2B-BC-S031	10001117	UNC8-32	–	32.0	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	63,0 *2.480*	3,5 *0.138*	4.50X3.40	3	DIN2184-1	2B	C
MTH-10-24UNC2B-BC-S031	10001119	UNC10-24	–	24.0	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	70,0 *2.756*	3,9 *0.154*	6.00X4.90	3	DIN2184-1	2B	C
MTH-1/4-20UNC2B-BC-S031	10001120	UNC1/4-20	–	20.0	7,0 *0.276*	15,0 *0.591*	15,0 *0.591*	80,0 *3.150*	5,1 *0.201*	7.00X5.50	3	DIN2184-1	2B	C
MTH-5/16-18UNC2B-BC-S031	10001122	UNC5/16-18	–	18.0	8,0 *0.315*	18,0 *0.709*	18,0 *0.709*	90,0 *3.543*	6,6 *0.260*	8.00X6.20	3	DIN2184-1	2B	C
MTH-3/8-16UNC2B-BC-S031	10001121	UNC3/8-16	–	16.0	10,0 *0.394*	20,0 *0.787*	20,0 *0.787*	100,0 *3.937*	8,0 *0.315*	10.00X8.00	4	DIN2184-1	2B	C

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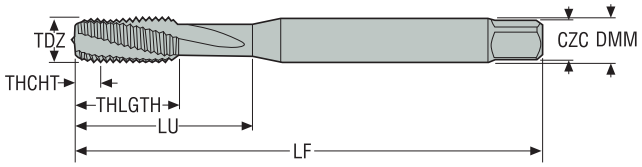
MTH-S032

Blind holes



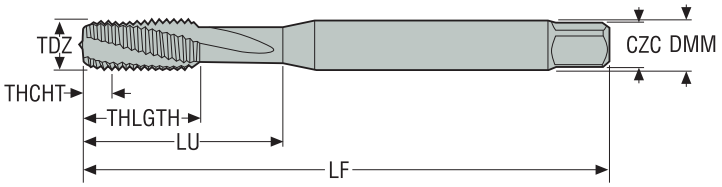
- For cutting data see page(s) 253
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-4-40UNJC3B-BC-S032	10001087	UNJC4-40	–	40.0	3,5 *0.138*	8,0 *0.315*	8,0 *0.315*	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

Please check availability at www.secotools.com / Seco Online Store

MTH-S041

Blind holes



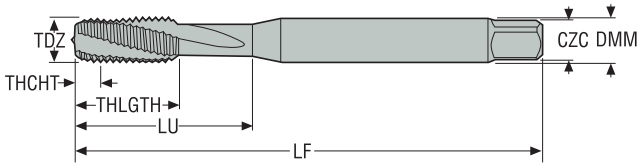
- For cutting data see page(s) 255
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-6-40UNF3B-BC-S041	10001123	UNF6-40	–	40.0	4,0 *0.157*	12,0 *0.472*	12,0 *0.472*	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 / Seco Online Store

MTH-S042

Blind holes



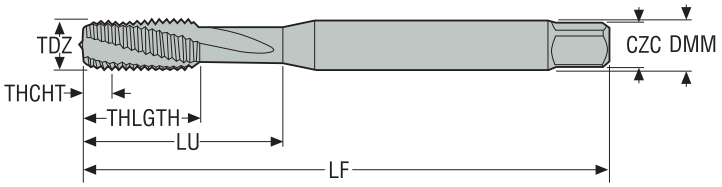
- For cutting data see page(s) 255
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-6-40UNJF3B-BC-S042	10001094	UNJF6-40	–	40.0	4,0 *0.157*	9,5 *0.374*	9,5 *0.374*	56,0 *2.205*	2,95 *0.116*	4.00X3.00	3	DIN2184-1	3B	C
MTH-8-36UNJF3B-BC-S042	10001095	UNJF8-36	–	36.0	4,5 *0.177*	11,0 *0.433*	11,0 *0.433*	63,0 *2.480*	3,6 *0.142*	4.50X3.40	3	DIN2184-1	3B	C
MTH-10-32UNJF3B-BC-S042	10001097	UNJF10-32	–	32.0	6,0 *0.236*	12,5 *0.492*	12,5 *0.492*	70,0 *2.756*	4,15 *0.163*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNJF3B-BC-S042	10001098	UNJF1/4-28	–	28.0	7,0 *0.276*	16,0 *0.630*	16,0 *0.630*	80,0 *3.150*	5,6 *0.220*	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNJF3B-BC-S042	10001100	UNJF5/16-24	–	24.0	8,0 *0.315*	20,0 *0.787*	20,0 *0.787*	90,0 *3.543*	7,0 *0.276*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNJF3B-BC-S042	10001099	UNJF3/8-24	–	24.0	10,0 *0.394*	23,0 *0.906*	23,0 *0.906*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	DIN2184-1	3B	C

Please check availability at www.secotools.com / Seco Online Store

MTH-S043

Blind and through holes



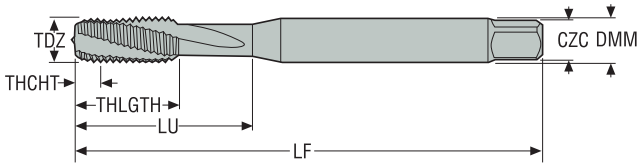
- For cutting data see page(s) 255
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-10-32EGUNF3B-BC-S043 *MTH-10-32STIUNF3B-BC-S043*	10001199	EGUN10-32	–	32.0	6,0 0.236	23 0.906	15,0 0.591	80,0 3.150	5,1 *0.201*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28EGUNF3B-BC-S043 *MTH-1/4-28STIUNF3B-BC-S043*	10001200	EGUNF1/4-28	–	28.0	8,0 0.315	30 1.161	18,0 0.709	90,0 3.543	6,6 *0.260*	8.00X6.20	3	DIN2184-1	3B	C
MTH-5/16-24EGUNF3B-BC-S043 *MTH-5/16-24STIUNF3B-BC-S043*	10001201	EGUNF5/16-24	–	24.0	10,0 0.394	34 1.319	20,0 0.787	100,0 3.937	8,2 *0.323*	10.00X8.00	3	DIN2184-1	3B	C
MTH-3/8-24EGUNF3B-BC-S043 *MTH-3/8-24STIUNF3B-BC-S043*	10001202	EGUNF3/8-24	–	24.0	8,0 0.315	76 2.992	20,0 0.787	100,0 3.937	9,8 *0.386*	8.00X6.20	4	DIN2184-1	3B	C

Please check availability at www.secotools.com / Seco Online Store

MTH-S044

Blind holes



- For cutting data see page(s) 255
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-10-32EGUNF3B-BC-S044 *MTH-10-32STIUNF3B-BC-S044*	10001101	EGUNF10-32	–	32.0	6,0 0.236	15 0.591	15,0 0.591	80,0 3.150	5,1 *0.201*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28EGUNF3B-BC-S044 *MTH-1/4-28STIUNF3B-BC-S044*	10001102	EGUNF1/4-28	–	28.0	8,0 0.315	18 0.709	18,0 0.709	90,0 3.543	6,6 *0.260*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24EGUNF3B-BC-S044 *MTH-3/8-24STIUNF3B-BC-S044*	10001103	EGUNF3/8-24	–	24.0	11,0 0.433	20 0.787	20,0 0.787	90,0 3.543	9,8 *0.386*	11.00X9.00	4	DIN2184-1	3B	C
MTH-5/16-24EGUNF3B-BC-S044 *MTH-5/16-24STIUNF3B-BC-S044*	10001104	EGUNF5/16-24	–	24.0	10,0 0.394	20 0.787	20,0 0.787	90,0 3.543	8,2 *0.323*	10.00X8.00	3	DIN2184-1	3B	C

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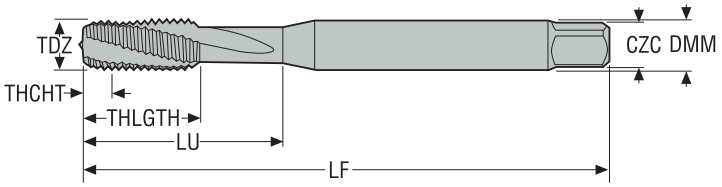
MTH-S101

Blind holes



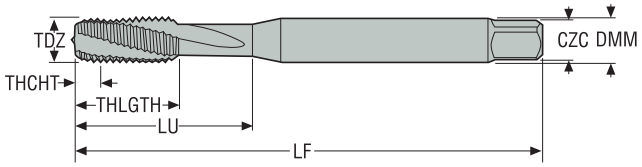
- For cutting data see page(s) 255
- Coating: AlCrN
- Substrate: HSS-E-PM

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

Please check availability at www.secotools.com / Seco Online Store

MTH-S102

Blind holes



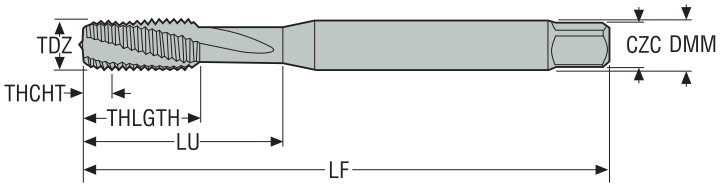
- For cutting data see page(s) 255
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6HX-BC-S102	10001143	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,2 *0.402*	9.00X7.00	4	DIN376	6HX	C
MTH-M16X2.00ISO6HX-BC-S102	10001145	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,0 *0.551*	12.00X9.00	4	DIN376	6HX	C
MTH-M20X2.50ISO6HX-BC-S102	10001146	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	140,0 *5.512*	17,5 *0.689*	16.00X12.00	4	DIN376	6HX	C

Please check availability at www.secotools.com / Seco Online Store

MTH-S111

Blind holes



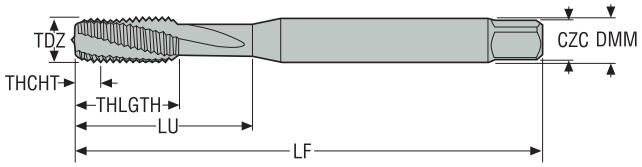
- For cutting data see page(s) 255
- Coating: AlCrN
- Substrate: HSS-E-PM

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

Please check availability at www.secotools.com / Seco Online Store

MTH-S112

Blind holes



- For cutting data see page(s) 255
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-MJ3X0.50ISO4H-BC-S112	10001203	MJ3X0.5	0,5	–	3,5 *0.138*	10,0 *0.394*	10,0 *0.394*	56,0 *2.205*	2,6 *0.102*	3.50X2.70	3	DIN371	4H	C
MTH-MJ4X0.70ISO4H-BC-S112	10001204	MJ4X0.7	0,7	–	4,5 *0.177*	13,0 *0.512*	13,0 *0.512*	63,0 *2.480*	3,4 *0.134*	4.50X3.40	3	DIN371	4H	C
MTH-MJ5X0.80ISO4H-BC-S112	10001205	MJ5X0.8	0,8	–	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	70,0 *2.756*	4,3 *0.169*	6.00X4.90	3	DIN371	4H	C
MTH-MJ6X1.00ISO4H-BC-S112	10001206	MJ6X1	1,0	–	6,0 *0.236*	23,0 *0.906*	15,0 *0.591*	80,0 *3.150*	5,1 *0.201*	6.00X4.90	3	DIN371	4H	C
MTH-MJ8X1.25ISO4H-BC-S112	10001207	MJ8X1.25	1,25	–	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	90,0 *3.543*	6,9 *0.272*	8.00X6.20	3	DIN371	4H	C
MTH-MJ10X1.5ISO4H-BC-S112	10001208	MJ10X1.5	1,5	–	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	100,0 *3.937*	8,7 *0.343*	10.00X8.00	3	DIN371	4H	C

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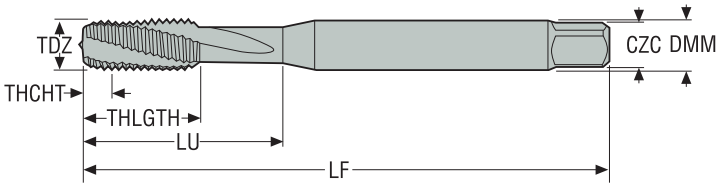
MTH-S142

Blind holes



- For cutting data see page(s) 255
- Coating: AlCrN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-10-32UNJF3B-BC-S142	10001153	UNJF10-32	–	32.0	6,0 *0.236*	16,0 *0.630*	16,0 *0.630*	70,0 *2.756*	4,15 *0.163*	6.00X4.90	3	DIN2184-1	3B	C
MTH-1/4-28UNJF3B-BC-S142	10001154	UNJF1/4-28	–	28.0	7,0 *0.276*	25,0 *0.984*	15,0 *0.591*	80,0 *3.150*	5,6 *0.220*	7.00X5.50	3	DIN2184-1	3B	C
MTH-5/16-24UNJF3B-BC-S142	10001155	UNJF5/16-24	–	24.0	8,0 *0.315*	29,5 *1.161*	18,0 *0.709*	90,0 *3.543*	7,0 *0.276*	8.00X6.20	3	DIN2184-1	3B	C
MTH-3/8-24UNJF3B-BC-S142	10001156	UNJF3/8-24	–	24.0	10,0 *0.394*	33,5 *1.319*	20,0 *0.787*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	DIN2184-1	3B	C

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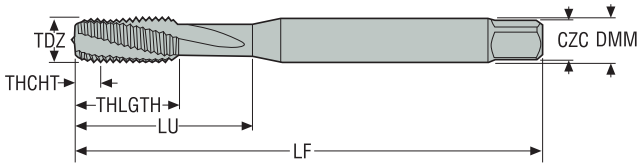
MTH-V011

Blind holes



- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M8X0.75ISO6HX-BC-V011	03000162	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	13,0 *0.512*	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

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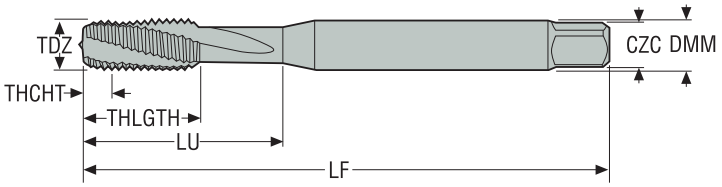
MTH-V015

Blind holes



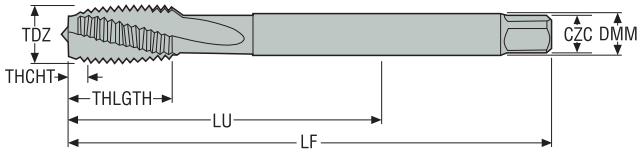
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-E

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 / Seco Online Store

MTH-V016

Blind holes



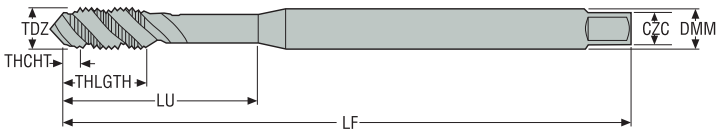
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-E

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M12X1.75ISO6H-BC-V016	03019195	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	3	DIN376	6H	C
MTH-M14X2.00ISO6H-BC-V016	03019196	M14	2,0	–	11,0 *0.433*	81,0 *3.189*	25,0 *0.984*	110,0 *4.331*	12,1 *0.476*	11.00X9.00	3	DIN376	6H	C
MTH-M16X2.00ISO6H-BC-V016	03019197	M16	2,0	–	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,1 *0.555*	12.00X9.00	3	DIN376	6H	C
MTH-M18X2.50ISO6H-BC-V016	03019198	M18	2,5	–	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	125,0 *4.921*	15,7 *0.618*	14.00X11.00	3	DIN376	6H	C
MTH-M20X2.50ISO6H-BC-V016	03019199	M20	2,5	–	16,0 *0.630*	95,0 *3.740*	30,0 *1.181*	140,0 *5.512*	17,7 *0.697*	16.00X12.00	3	DIN376	6H	C
MTH-M22X2.50ISO6H-BC-V016	03019200	M22	2,5	–	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	140,0 *5.512*	19,7 *0.776*	18.00X14.50	4	DIN376	6H	C
MTH-M24X3.00ISO6H-BC-V016	03019201	M24	3,0	–	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	160,0 *6.299*	21,0 *0.827*	18.00X14.50	4	DIN376	6H	C
MTH-M27X3.00ISO6H-BC-V016	03019202	M27	3,0	–	20,0 *0.787*	97,0 *3.819*	38,0 *1.496*	160,0 *6.299*	24,0 *0.945*	20.00X16.00	4	DIN376	6H	C
MTH-M30X3.50ISO6H-BC-V016	03019203	M30	3,5	–	22,0 *0.866*	115,0 *4.528*	45,0 *1.772*	180,0 *7.087*	26,5 *1.043*	22.00X18.00	4	DIN376	6H	C
MTH-M33X3.50ISO6H-BC-V016	03019204	M33	3,5	–	25,0 *0.984*	113,0 *4.449*	50,0 *1.969*	180,0 *7.087*	29,5 *1.161*	25.00X20.00	4	DIN376	6H	C
MTH-M36X4.00ISO6H-BC-V016	03019205	M36	4,0	–	28,0 *1.102*	131,0 *5.157*	55,0 *2.165*	200,0 *7.874*	32,0 *1.260*	28.00X22.00	4	DIN376	6H	C

Please check availability at www.secotools.com / Seco Online Store

MTH-V025

Blind holes



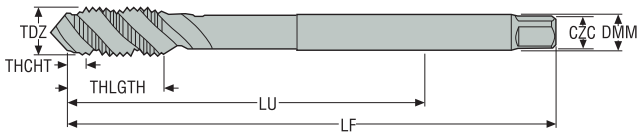
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-E
- Long version

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 / Seco Online Store

MTH-V026

Blind holes



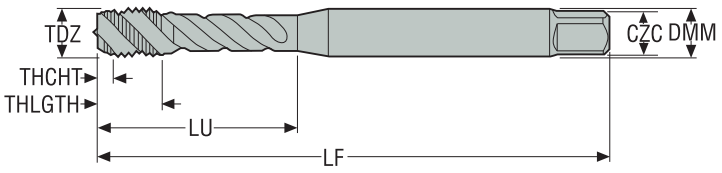
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-E
- Long version

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

Please check availability at www.secotools.com / Seco Online Store

MTH-V028

Blind holes



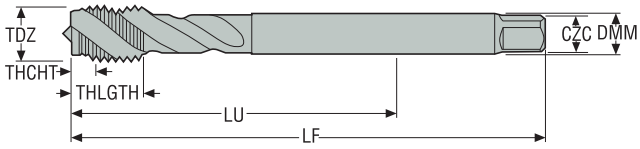
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-PM

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-M3X0.50ISO6G-BC-V028	02880652	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	6G	C
MTH-M4X0.70ISO6G-BC-V028	02880653	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	6G	C
MTH-M5X0.80ISO6G-BC-V028	02880654	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	6G	C
MTH-M6X1.00ISO6G-BC-V028	02880655	M6	1,0	–	6,0 *0.236*	31,0 *1.220*	10,0 *0.394*	80,0 *3.150*	5,1 *0.201*	6.00X4.90	3	DIN371	6G	C
MTH-M8X1.25ISO6G-BC-V028	02880656	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	6G	C
MTH-M10X1.50ISO6G-BC-V028	02880657	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	6G	C

Please check availability at www.secotools.com / Seco Online Store

MTH-V029

Blind holes



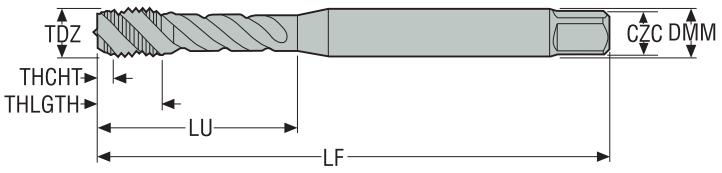
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

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

Please check availability at www.secotools.com / Seco Online Store

MTH-V030

Blind holes



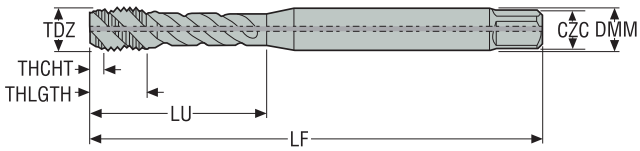
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-E ≤ M2,5; HSS-PM > M2,5

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M2X0.40ISO6H-BC-V030	02880662	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-M2.5X0.45ISO6H-BC-V030	02880663	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-M3X0.50ISO6H-BC-V030	02880664	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-V030	02880665	M3.5	0,6	–	4,0 *0.157*	20,0 *0.787*	6,3 *0.248*	56,0 *2.205*	2,9 *0.114*	4.00X3.00	3	DIN371	6H	C
MTH-M4X0.70ISO6H-BC-V030	02880666	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	02880667	M5	0,8	–	6,0 *0.236*	21,0 *0.827*	7,7 *0.303*	70,0 *2.756*	4,3 *0.169*	6.00X4.90	3	DIN371	6H	C
MTH-M6X1.00ISO6H-BC-V030	02880668	M6	1,0	–	6,0 *0.236*	31,0 *1.220*	10,0 *0.394*	80,0 *3.150*	5,1 *0.201*	6.00X4.90	3	DIN371	6H	C
MTH-M7X1.00ISO6H-BC-V030	02880669	M7	1,0	–	7,0 *0.276*	31,0 *1.220*	10,0 *0.394*	80,0 *3.150*	6,1 *0.240*	7.00X5.50	3	DIN371	6H	C
MTH-M8X1.25ISO6H-BC-V030	02880670	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	02880671	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

Please check availability at www.secotools.com / Seco Online Store

MTH-V030-A

Blind holes



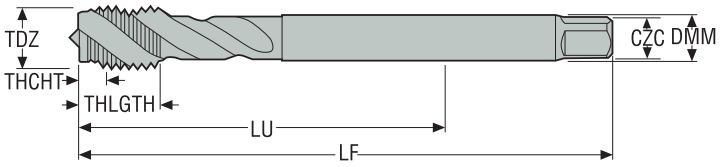
- For cutting data see page(s) 261
- Coating: TiN
- Substrate: HSS-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M4X0.70ISO6H-BC-V030-A	03000228	M4	0,7	–	4,5 *0.177*	21,0 *0.827*	6,7 *0.264*	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

Please check availability at www.secotools.com / Seco Online Store

MTH-V033

Blind holes



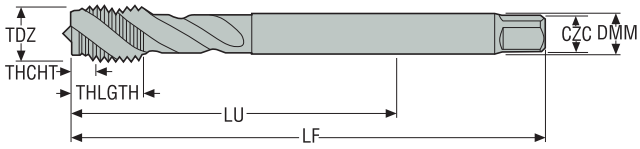
- For cutting data see page(s) 263
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16

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

Please check availability at www.secotools.com / Seco Online Store

MTH-V033-A

Blind holes



- For cutting data see page(s) 263
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-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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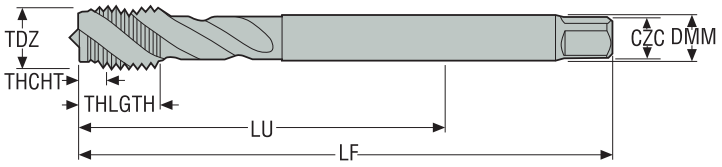
MTH-V038

Blind holes



- For cutting data see page(s) 263
- 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-M4X0.50ISO6H-BC-V038 *MTH-M4X0.50ISO6H-BC-V038*	02880687	MF4X0.5	0,5	–	2,8 0.110	43 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 *MTH-M5X0.50ISO6H-BC-V038*	02880688	MF5X0.5	0,5	–	3,5 0.138	49 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 *MTH-M6X0.75ISO6H-BC-V038*	02880689	MF6X0.75	0,75	–	4,5 0.177	59 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 *MTH-M8X0.75ISO6H-BC-V038*	02880690	MF8X0.75	0,75	–	6,0 0.236	57 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 *MTH-M8X1.00ISO6H-BC-V038*	02880691	MF8X1.0	1,0	–	6,0 0.236	67 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 *MTH-M9X1.00ISO6H-BC-V038*	03000361	MF9X1.0	1,0	–	7,0 0.276	67 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 *MTH-M10X0.75ISO6H-BC-V038*	02880692	MF10X0.75	0,75	–	7,0 0.276	67 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 *MTH-M10X1.00ISO6H-BC-V038*	02880693	MF10X1.0	1,0	–	7,0 0.276	67 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 *MTH-M10X1.25ISO6H-BC-V038*	02880694	MF10X1.25	1,25	–	7,0 0.276	77 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 *MTH-M11X1.00ISO6H-BC-V038*	03000362	MF11X1.0	1,0	–	8,0 0.315	63 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 *MTH-M11X1.25ISO6H-BC-V038*	03000363	MF11X1.25	1,25	–	8,0 0.315	63 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 *MTH-M12X1.00ISO6H-BC-V038*	02880695	MF12X1.0	1,0	–	9,0 0.354	73 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 *MTH-M12X1.25ISO6H-BC-V038*	02880696	MF12X1.25	1,25	–	9,0 0.354	73 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 *MTH-M12X1.50ISO6H-BC-V038*	02880697	MF12X1.5	1,5	–	9,0 0.354	73 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 *MTH-M14X1.00ISO6H-BC-V038*	02880698	MF14X1.0	1,0	–	11,0 0.433	71 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 *MTH-M14X1.25ISO6H-BC-V038*	02880699	MF14X1.25	1,25	–	11,0 0.433	71 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 *MTH-M14X1.50ISO6H-BC-V038*	02880701	MF14X1.5	1,5	–	11,0 0.433	71 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 *MTH-M16X1.00ISO6H-V038*	02880702	MF16X1.0	1,0	–	12,0 0.472	58 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 *MTH-M16X1.50ISO6H-BC-V038*	02880703	MF16X1.5	1,5	–	12,0 0.472	58 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 *MTH-M18X1.00ISO6H-BC-V038*	02880704	MF18X1.0	1,0	–	14,0 0.551	66 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 *MTH-M18X1.50ISO6H-BC-V038*	02880705	MF18X1.5	1,5	–	14,0 0.551	66 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 *MTH-M20X1.00ISO6H-BC-V038*	02880706	MF20X1.0	1,0	–	16,0 0.630	80 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 *MTH-M20X1.50ISO6H-BC-V038*	02880707	MF20X1.5	1,5	–	16,0 0.630	80 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 *MTH-M22X1.50ISO6H-BC-V038*	02880708	MF22X1.5	1,5	–	18,0 0.709	78 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 *MTH-M24X1.50ISO6H-BC-V038*	02880709	MF24X1.5	1,5	–	18,0 0.709	93 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 *MTH-M24X2.00ISO6H-BC-V038*	02880710	MF24X2.0	2,0	–	18,0 0.709	93 3.661	20,0 0.787	140,0 5.512	22,0 *0.866*	18.00X14.50	4	DIN374	6H	C
MTH-M25X1.50ISO6H-BC-V038 *MTH-M25X1.50ISO6H-BC-V038*	02880711	MF25X1.5	1,5	–	18,0 0.709	93 3.661	20,0 0.787	140,0 5.512	23,5 *0.925*	18.00X14.50	4	DIN374	6H	C
MTH-M26X1.50ISO6H-BC-V038 *MTH-M26X1.50ISO6H-BC-V038*	02880712	MF26X1.5	1,5	–	18,0 0.709	93 3.661	20,0 0.787	140,0 5.512	24,5 *0.965*	18.00X14.50	4	DIN374	6H	C
MTH-M27X1.50ISO6H-BC-V038 *MTH-M27X1.50ISO6H-BC-V038*	02880713	MF27X1.5	1,5	–	20,0 0.787	77 3.031	20,0 0.787	140,0 5.512	25,5 *1.004*	20.00X16.00	4	DIN374	6H	C
MTH-M27X2.00ISO6H-BC-V038 *MTH-M27X2.00ISO6H-BC-V038*	02880714	MF27X2.0	2,0	–	20,0 0.787	77 3.031	20,0 0.787	140,0 5.512	25,0 *0.984*	20.00X16.00	4	DIN374	6H	C
MTH-M28X1.50ISO6H-BC-V038 *MTH-M28X1.50ISO6H-BC-V038*	02880715	MF28X1.5	1,5	–	20,0 0.787	77 3.031	20,0 0.787	140,0 5.512	26,5 *1.043*	20.00X16.00	4	DIN374	6H	C
MTH-M30X1.50ISO6H-BC-V038 *MTH-M30X1.50ISO6H-BC-V038*	02880717	MF30X1.5	1,5	–	22,0 0.866	85 3.346	20,0 0.787	150,0 5.906	28,5 *1.122*	22.00X18.00	4	DIN374	6H	C
MTH-M30X2.00ISO6H-BC-V038 *MTH-M30X2.00ISO6H-BC-V038*	02880718	MF30X2.0	2,0	–	22,0 0.866	85 3.346	20,0 0.787	150,0 5.906	28,0 *1.102*	22.00X18.00	4	DIN374	6H	C

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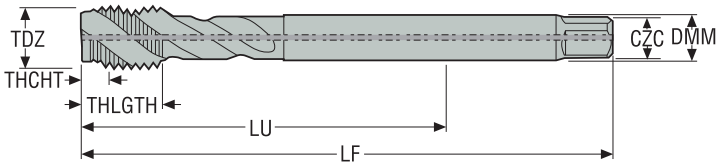
MTH-V038-A

Blind holes



- For cutting data see page(s) 263
- Coating: TiN
- Substrate: HSS-PM ≤ M16, HSS-E > M16
- Internal coolant

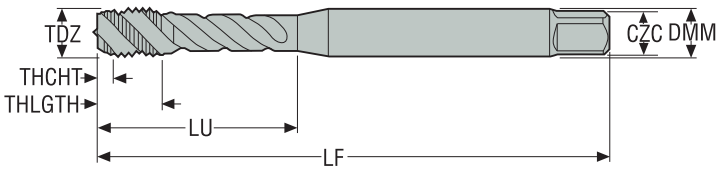
Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTH-M6X0.75ISO6H-BC-V038-A	03000250	MF6X0.75	0,75	–	4,5 *0.177*	59,0 *2.323*	10,0 *0.394*	80,0 *3.150*	5,3 *0.209*	4.50X3.40	3	DIN374	6H	C
MTH-M8X0.75ISO6H-BC-V038-A	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

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-M25X1.50ISO6H-BC-V038-A	03000271	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	6H	C
MTH-M26X1.50ISO6H-BC-V038-A	03000272	MF26X1.5	1,5	–	18,0 *0.709*	93,0 *3.661*	20,0 *0.787*	140,0 *5.512*	24,5 *0.965*	18.00X14.50	4	DIN374	6H	C
MTH-M27X1.50ISO6H-BC-V038-A	03000273	MF27X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	140,0 *5.512*	25,5 *1.004*	20.00X16.00	4	DIN374	6H	C
MTH-M27X2.00ISO6H-BC-V038-A	03000274	MF27X2.0	2,0	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	140,0 *5.512*	25,0 *0.984*	20.00X16.00	4	DIN374	6H	C
MTH-M28X1.50ISO6H-BC-V038-A	03000275	MF28X1.5	1,5	–	20,0 *0.787*	77,0 *3.031*	20,0 *0.787*	140,0 *5.512*	26,5 *1.043*	20.00X16.00	4	DIN374	6H	C
MTH-M30X1.50ISO6H-BC-V038-A	03000276	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	6H	C
MTH-M30X2.00ISO6H-BC-V038-A	03000277	MF30X2.0	2,0	–	22,0 *0.866*	85,0 *3.346*	20,0 *0.787*	150,0 *5.906*	28,0 *1.102*	22.00X18.00	4	DIN374	6H	C

Please check availability at www.secotools.com / Seco Online Store

MTH-V040

Blind holes



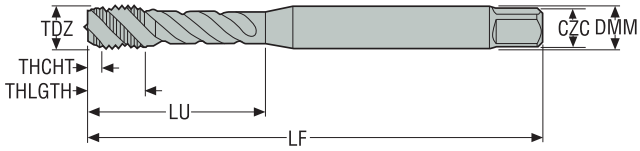
- For cutting data see page(s) 263
- Coating: TiN
- Substrate: HSS-PM

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

Please check availability at www.secotools.com / Seco Online Store

MTH-V043

Blind holes



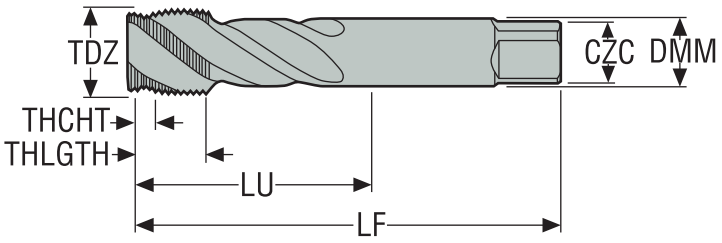
- For cutting data see page(s) 263
- Coating: TiN
- Substrate: HSS-PM

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-8-36UNF-BC-V043	02880731	UNF8-36	–	36.0	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-10-32UNF-BC-V043	02880732	UNF10-32	–	32.0	6,0 *0.236*	25,0 *0.984*	7,3 *0.287*	70,0 *2.756*	4,1 *0.161*	6.00X4.90	3	DIN2184-1	2B	C
MTH-1/4-28UNF-BC-V043	02880733	UNF1/4-28	–	28.0	7,0 *0.276*	30,0 *1.181*	10,0 *0.394*	80,0 *3.150*	5,5 *0.217*	7.00X5.50	3	DIN2184-1	2B	C
MTH-5/16-24UNF-BC-V043	02880734	UNF5/16-24	–	24.0	8,0 *0.315*	35,0 *1.378*	12,0 *0.472*	90,0 *3.543*	7,0 *0.276*	8.00X6.20	3	DIN2184-1	2B	C
MTH-3/8-24UNF-BC-V043	02880735	UNF3/8-24	–	24.0	10,0 *0.394*	39,0 *1.535*	15,0 *0.591*	100,0 *3.937*	8,6 *0.339*	10.00X8.00	3	DIN2184-1	2B	C
MTH-7/16-20UNF-BC-V043	02880736	UNF7/16-20	–	20.0	8,0 *0.315*	75,75 *2.982*	15,0 *0.591*	100,0 *3.937*	10,0 *0.394*	8.00X6.20	3	DIN2184-1	2B	C
MTH-1/2-20UNF-BC-V043	02880737	UNF1/2-20	–	20.0	9,0 *0.354*	83,0 *3.268*	18,0 *0.709*	110,0 *4.331*	11,5 *0.453*	9.00X7.00	3	DIN2184-1	2B	C
MTH-9/16-18UNF-BC-V043	03000278	UNF9/16-18	–	18.0	11,0 *0.433*	71,0 *2.795*	20,0 *0.787*	100,0 *3.937*	13,0 *0.512*	11.00X9.00	4	DIN2184-1	2B	C
MTH-5/8-18UNF-BC-V043	02880738	UNF5/8-18	–	18.0	12,0 *0.472*	67,75 *2.667*	20,0 *0.787*	110,0 *4.331*	14,6 *0.575*	12.00X9.00	4	DIN2184-1	2B	C
MTH-3/4-16UNF-BC-V043	03000279	UNF3/4-16	–	16.0	14,0 *0.551*	77,5 *3.051*	25,0 *0.984*	125,0 *4.921*	17,6 *0.693*	14.00X11.00	4	DIN2184-1	2B	C
MTH-7/8-14UNF-BC-V043	03000280	UNF7/8-14	–	14.0	18,0 *0.709*	93,0 *3.661*	25,0 *0.984*	140,0 *5.512*	20,6 *0.811*	18.00X14.50	4	DIN2184-1	2B	C
MTH-1-12UNF-BC-V043	03000281	UNF1-12	–	12.0	18,0 *0.709*	113,0 *4.449*	30,0 *1.181*	160,0 *6.299*	23,5 *0.925*	18.00X14.50	4	DIN2184-1	2B	C

Please check availability at www.secotools.com / Seco Online Store

MTH-V045

Blind holes



- For cutting data see page(s) 263
- 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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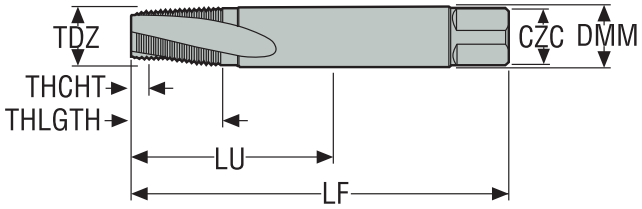
MTH-V048

Blind holes



- For cutting data see page(s) 269
- Vaporised
- Substrate: HSS-E

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

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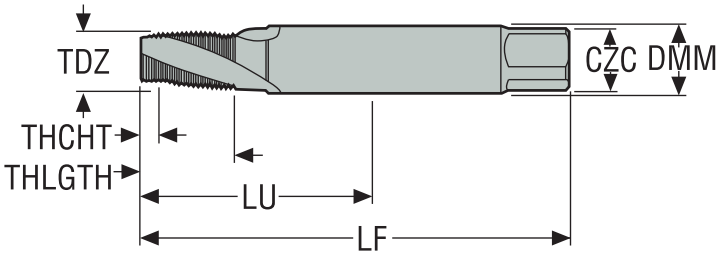
MTH-V050

Blind holes



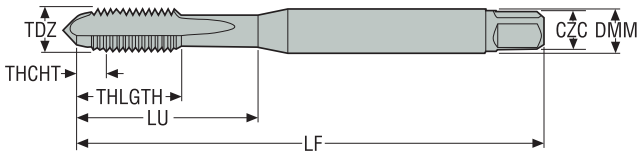
- For cutting data see page(s) 269
- Vaporised
- Substrate: HSS-E

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

Please check availability at www.secotools.com / Seco Online Store

MTS-K001

Blind and through holes



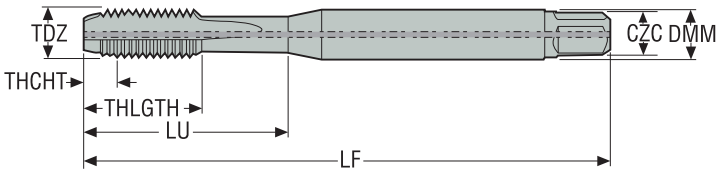
- For cutting data see page(s) 259
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M3X0.50ISO6HX-XC-K001	03019067	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	C
MTS-M4X0.70ISO6HX-XC-K001	03019068	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	03019069	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-M6X1.00ISO6HX-XC-K001	03019070	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-M8X1.25ISO6HX-XC-K001	03019071	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-M10X1.50ISO6HX-XC-K001	03019072	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

Please check availability at www.secotools.com / Seco Online Store

MTS-K001-A

Blind and through holes



- For cutting data see page(s) 259
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M4X0.70ISO6HX-XC-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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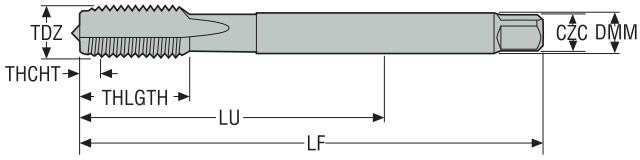
MTS-K002

Blind and through holes



- For cutting data see page(s) 259
- 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	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
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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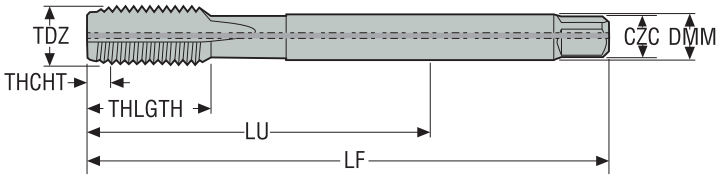
MTS-K002-A

Blind and through holes



- For cutting data see page(s) 259
- Coating: TiAlN
- Substrate: HSS-E-PM
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M12X1.75ISO6HX-XC-K002-A	02999832	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	24,0 *0.945*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	4	DIN376	6HX	C
MTS-M12X1.75ISO6HX-XE-K002-A	02999848	M12	1,75	–	9,0 *0.354*	83,0 *3.268*	24,0 *0.945*	110,0 *4.331*	10,4 *0.409*	9.00X7.00	4	DIN376	6HX	E
MTS-M14X2.00ISO6HX-XC-K002-A	02999833	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-A	02999834	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-M20X2.50ISO6HX-XC-K002-A	02999835	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-A	02999836	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-A	02999837	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-A	02999838	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-A	02999839	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-A	02999840	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-A	02999841	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-A	02999842	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-A	02999843	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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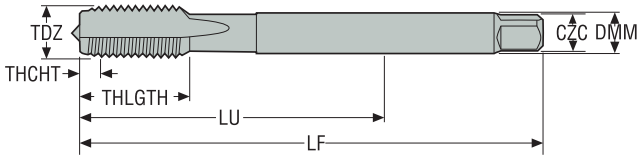
MTS-K011

Blind and through holes



- For cutting data see page(s) 259
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-M10X1.00ISO6HX-XC-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

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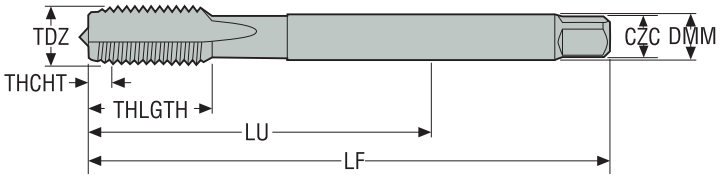
MTS-K021

Blind and through holes



- For cutting data see page(s) 259
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-1/8-28G-XC-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

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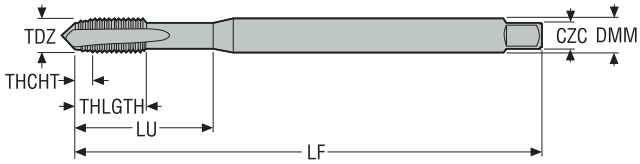
MTS-K031

Blind and through holes



- For cutting data see page(s) 259
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-1/4-20UNC-XC-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

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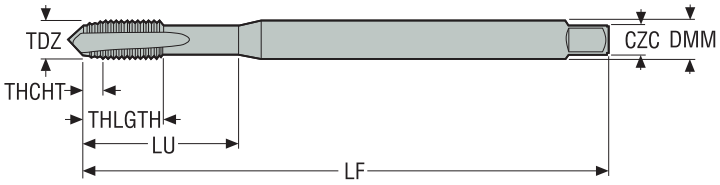
MTS-K041

Blind and through holes



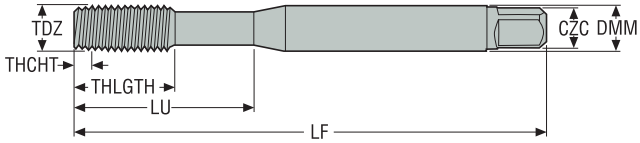
- For cutting data see page(s) 259
- Coating: TiAlN
- Substrate: HSS-E-PM

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MTS-1/4-28UNF-XC-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 / Seco Online Store

MF-V053

Forming holes



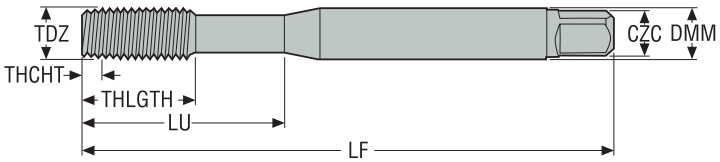
- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-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 / Seco Online Store

MF-V054

Forming holes



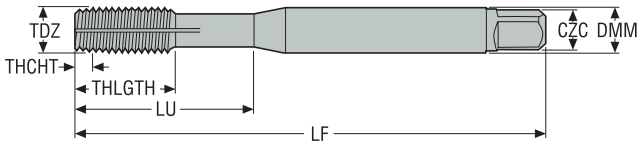
- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M1X0.25ISO5HX-XC-V054	03000282	*	M1	0,25	–	2,5 *0.098*	20,0 *0.787*	5,5 *0.217*	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 / Seco Online Store

MF-V055

Forming holes



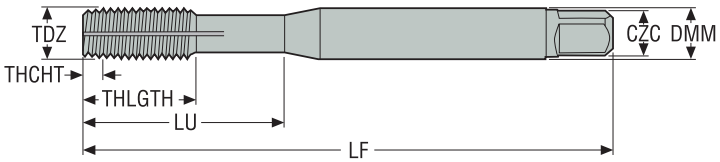
- With channels for lubrication
- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-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 / Seco Online Store

MF-V056

Forming holes



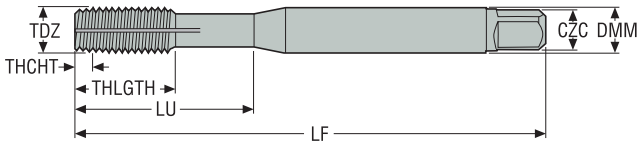
- With channels for lubrication
- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-4-40UNC-XC-V056	03000306	*	UNC4-40	–	40.0	3,5 *0.138*	18,0 *0.709*	9,0 *0.354*	56,0 *2.205*	2,6 *0.102*	3.50X2.70	4	DIN2184-1	2BX	C
MF-6-32UNC-XC-V056	03000307	*	UNC6-32	–	32.0	4,0 *0.157*	20,0 *0.787*	11,0 *0.433*	56,0 *2.205*	3,2 *0.126*	4.00X3.00	4	DIN2184-1	2BX	C
MF-8-32UNC-XC-V056	03000308	*	UNC8-32	–	32.0	4,5 *0.177*	21,0 *0.827*	12,0 *0.472*	63,0 *2.480*	3,8 *0.150*	4.50X3.40	5	DIN2184-1	2BX	C
MF-10-24UNC-XC-V056	03000309	*	UNC10-24	–	24.0	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	70,0 *2.756*	4,4 *0.173*	6.00X4.90	5	DIN2184-1	2BX	C
MF-12-24UNC-XC-V056	03000310	*	UNC12-24	–	24.0	6,0 *0.236*	30,0 *1.181*	14,0 *0.551*	80,0 *3.150*	5,0 *0.197*	6.00X4.90	5	DIN2184-1	2BX	C
MF-1/4-20UNC-XC-V056	03000311	*	UNC1/4-20	–	20.0	7,0 *0.276*	30,0 *1.181*	15,0 *0.591*	80,0 *3.150*	5,8 *0.228*	7.00X5.50	5	DIN2184-1	2BX	C
MF-5/16-18UNC-XC-V056	03000312	*	UNC5/16-18	–	18.0	8,0 *0.315*	35,0 *1.378*	18,0 *0.709*	90,0 *3.543*	7,3 *0.287*	8.00X6.20	5	DIN2184-1	2BX	C
MF-3/8-16UNC-XC-V056	03000313	*	UNC3/8-16	–	16.0	10,0 *0.394*	39,0 *1.535*	20,0 *0.787*	100,0 *3.937*	8,8 *0.346*	10.00X8.00	5	DIN2184-1	2BX	C
MF-7/16-14UNC-XC-V056	03000314		UNC7/16-14	–	14.0	8,0 *0.315*	77,0 *3.031*	20,0 *0.787*	100,0 *3.937*	10,3 *0.406*	8.00X6.20	5	DIN2184-1	2BX	C
MF-1/2-13UNC-XC-V056	03000315		UNC1/2-13	–	13.0	9,0 *0.354*	83,0 *3.268*	23,0 *0.906*	110,0 *4.331*	11,9 *0.469*	9.00X7.00	6	DIN2184-1	2BX	C
MF-5/8-11UNC-XC-V056	03000316		UNC5/8-11	–	11.0	12,0 *0.472*	68,0 *2.677*	25,0 *0.984*	110,0 *4.331*	14,85 *0.585*	12.00X9.00	6	DIN2184-1	2BX	C
MF-3/4-10UNC-XC-V056	03000317		UNC3/4-10	–	10.0	14,0 *0.551*	81,0 *3.189*	30,0 *1.181*	125,0 *4.921*	17,93 *0.706*	14.00X11.00	7	DIN2184-1	2BX	C
MF-7/8-9UNC-XC-V056	03000318		UNC7/8-9	–	9.0	18,0 *0.709*	93,0 *3.661*	34,0 *1.339*	140,0 *5.512*	20,98 *0.826*	18.00X14.50	7	DIN2184-1	2BX	C
MF-1-8UNC-XC-V056	03000319		UNC1-8	–	8.0	18,0 *0.709*	113,0 *4.449*	38,0 *1.496*	160,0 *6.299*	24,0 *0.945*	18.00X14.50	8	DIN2184-1	2BX	C

Please check availability at www.secotools.com / Seco Online Store

MF-V057

Forming holes



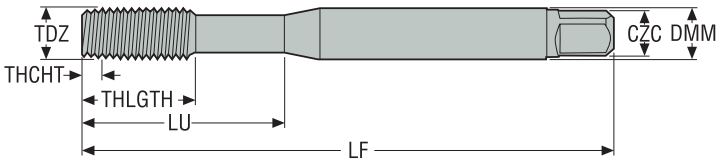
- With channels for lubrication
- For cutting data see page(s) 271
- Coating: TiN
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-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

Please check availability at www.secotools.com / Seco Online Store

MF-V058

Forming holes



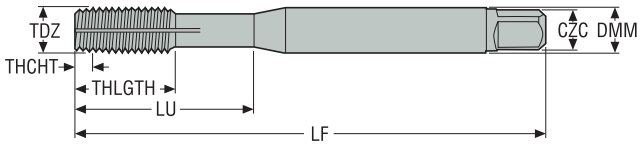
- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-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

Please check availability at www.secotools.com / Seco Online Store

MF-V059

Forming holes



- With channels for lubrication
- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-1/8-28G-XC-V059	03000301	*	G1/8-28	–	28.0	7,0 *0.276*	67,0 *2.638*	20,0 *0.787*	90,0 *3.543*	9,3 *0.366*	7.00X5.50	5	DIN2189	NOR-MAL-X	C
MF-1/4-19G-XC-V059	03000302		G1/4-19	–	19.0	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	12,5 *0.492*	11.00X9.00	6	DIN2189	NOR-MAL-X	C
MF-3/8-19G-XC-V059	03000303		G3/8-19	–	19.0	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	100,0 *3.937*	16,0 *0.630*	12.00X9.00	6	DIN2189	NOR-MAL-X	C
MF-1/2-14G-XC-V059	03000304		G1/2-14	–	14.0	16,0 *0.630*	80,0 *3.150*	24,0 *0.945*	125,0 *4.921*	20,0 *0.787*	16.00X12.00	7	DIN2189	NOR-MAL-X	C
MF-5/8-14G-XC-V059	03000305		G5/8-14	–	14.0	18,0 *0.709*	78,0 *3.071*	24,0 *0.945*	125,0 *4.921*	22,0 *0.866*	18.00X14.50	7	DIN2189	NOR-MAL-X	C

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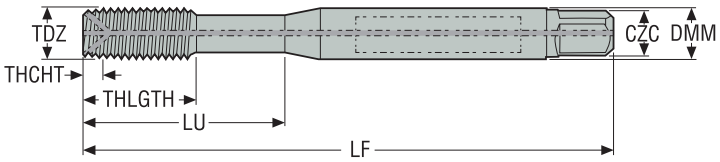
MF-V060-A

Forming holes



- For cutting data see page(s) 271
- 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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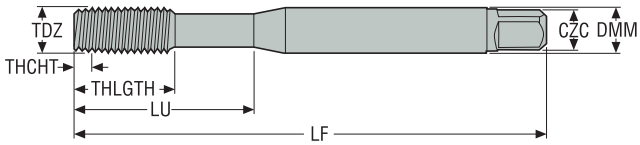
MF-V063

Forming holes



- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- * With tip shape. More information: Suggest at secotools.com

Designation	Item number	*	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
				mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-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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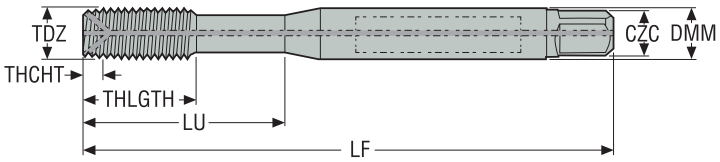
MF-V063-A

Forming holes



- For cutting data see page(s) 271
- Coating: TiN
- Substrate: HSS-E
- Internal coolant

Designation	Item number	TDZ	Pitch		DMM	LU	THLGTH	LF	PHDR	CZC	NOF	BSG	TCTR	THCHT
			mm	TPI	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					
MF-M5X0.50ISO6HX-XC-V063-A	03000342	MF5X0.5	0,5	–	6,0 *0.236*	25,0 *0.984*	13,0 *0.512*	70,0 *2.756*	4,8 *0.189*	6.00X4.90	5	DIN2174	6HX	C
MF-M6X0.75ISO6HX-XC-V063-A	03000343	MF6X0.75	0,75	–	6,0 *0.236*	30,0 *1.181*	15,0 *0.591*	80,0 *3.150*	5,65 *0.222*	6.00X4.90	5	DIN2174	6HX	C
MF-M8X0.75ISO6HX-XC-V063-A	03000344	MF8X0.75	0,75	–	6,0 *0.236*	57,0 *2.244*	15,0 *0.591*	80,0 *3.150*	7,65 *0.301*	6.00X4.90	5	DIN2174	6HX	C
MF-M8X1.00ISO6HX-XC-V063-A	03000345	MF8X1.0	1,0	–	6,0 *0.236*	67,0 *2.638*	18,0 *0.709*	90,0 *3.543*	7,55 *0.297*	6.00X4.90	5	DIN2174	6HX	C
MF-M10X0.75ISO6HX-XC-V063-A	03000346	MF10X0.75	0,75	–	7,0 *0.276*	67,0 *2.638*	18,0 *0.709*	90,0 *3.543*	9,65 *0.380*	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.00ISO6HX-XC-V063-A	03000347	MF10X1.0	1,0	–	7,0 *0.276*	67,0 *2.638*	18,0 *0.709*	90,0 *3.543*	9,55 *0.376*	7.00X5.50	5	DIN2174	6HX	C
MF-M10X1.25ISO6HX-XC-V063-A	03000349	MF10X1.25	1,25	–	7,0 *0.276*	77,0 *3.031*	20,0 *0.787*	100,0 *3.937*	9,45 *0.372*	7.00X5.50	5	DIN2174	6HX	C
MF-M12X1.00ISO6HX-XC-V063-A	03000350	MF12X1.0	1,0	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	11,55 *0.455*	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.25ISO6HX-XC-V063-A	03000351	MF12X1.25	1,25	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	11,45 *0.451*	9.00X7.00	5	DIN2174	6HX	C
MF-M12X1.50ISO6HX-XC-V063-A	03000352	MF12X1.5	1,5	–	9,0 *0.354*	73,0 *2.874*	21,0 *0.827*	100,0 *3.937*	11,35 *0.447*	9.00X7.00	5	DIN2174	6HX	C
MF-M14X1.00ISO6HX-XC-V063-A	03000353	MF14X1.0	1,0	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	13,55 *0.533*	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.25ISO6HX-XC-V063-A	03000354	MF14X1.25	1,25	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	13,45 *0.530*	11.00X9.00	6	DIN2174	6HX	C
MF-M14X1.50ISO6HX-XC-V063-A	03000355	MF14X1.5	1,5	–	11,0 *0.433*	71,0 *2.795*	21,0 *0.827*	100,0 *3.937*	13,35 *0.526*	11.00X9.00	6	DIN2174	6HX	C
MF-M16X1.00ISO6HX-XC-V063-A	03000356	MF16X1.0	1,0	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	100,0 *3.937*	15,55 *0.612*	12.00X9.00	6	DIN2174	6HX	C
MF-M16X1.50ISO6HX-XC-V063-A	03000357	MF16X1.5	1,5	–	12,0 *0.472*	58,0 *2.283*	21,0 *0.827*	100,0 *3.937*	15,35 *0.604*	12.00X9.00	6	DIN2174	6HX	C

Please check availability at www.secotools.com / Seco Online Store

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 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 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 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 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 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 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 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 N/mm^2	2400	0,20
P11	Ferritic & martensitic stainless steels	415 < R_m < 1200	X 20 Cr 13 R_m = 675 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 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%		AlSi17Cu5		
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, (α)		Ti		
S12	Titanium, medium alloyed, (α+β)		TiAl6V4	1500	0,24
S13	Titanium, high alloyed, (near β and β)		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 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
	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			
P1	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
	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
P2			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	C 20	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
			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			
P3	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		
	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
P4			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
	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		
			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
P5	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
	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
P6	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		C 120 KU	SK 2		

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	St14kP	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	

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 MWCV 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	T30102
			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 DKCWV 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 DCWV 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 CrN 28	1.4749	1.4749	X 18 CrN 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 CNUNb 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
M2	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 CNNb 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
M3	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
	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 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 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
M4	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
	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

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

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
K1	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
K2	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
	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
K4	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
										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
K5	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
K6	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
	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
K7	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
	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
N1	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		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
	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
N2	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
	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
N11			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	CuZn29Sn1				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

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
	A48 25 B	Sc 15	422 415			Grey cast iron (GCI)
	A48 30 B	Sc 20	422 420			Grey cast iron (GCI)
	A48 35 B	Sc 25	422 425			Grey cast iron (GCI)
	A48 50 B	Sc 35				Grey cast iron (GCI)
	G 3500					Grey cast iron (GCI)
	Grade 350					Compacted graphite iron (CGI)
	Grade 400					Compacted graphite iron (CGI)
	Grade 400-15					Compacted graphite iron (CGI)
	Grade 450					Compacted graphite iron (CGI)
	Grade 500					Compacted graphite iron (CGI)
	A220 60004				Tempered	Malleable cast iron (MCI)
						Nodular cast iron (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Nodular cast iron (SGI)
	60-40-18	Vc 42-12				Nodular cast iron (SGI)
FGE 50-7	A536, 80-55-06	Vc 50-2	422 305			Nodular cast iron (SGI)
FGE 60-2	A476, 80-60-03	Vc 60-2	422 306			Nodular cast iron (SGI)
FGE 70-2	A536, 100-70-03	Vc 70-2				Nodular cast iron (SGI)
	1600/1300/-					Austempered ductile iron (ADI)
	1050/700/7					Austempered ductile iron (ADI)
	1200/850/4					Austempered ductile iron (ADI)
	1400/1100/1					Austempered ductile iron (ADI)
	850/550/10					Austempered ductile iron (ADI)
	A436 Type 2			Ni-Resist 2		Austenitic lamellar cast iron
	A436 Type 3			Ni-Resist 3		Austenitic lamellar cast iron
	A436 Type 1			Ni-Resist 1		Austenitic lamellar cast iron
				Nodumag		Austenitic nodular cast iron
	A436 Type D-2			Ni-Resist D-2		Austenitic nodular cast iron
	A439 Type D-2M			Ni-Resist D-2M		Austenitic nodular cast iron
	A436 Type D-3			Ni-Resist D-3		Austenitic nodular cast iron
	A439 Type D-5			Ni-Resist D-5		Austenitic nodular cast iron
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

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 WCrV 7	55 WC 20		55 WCrV 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
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 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
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 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 DKCWV 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

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

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 then 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	■				■	■			■									

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