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Xactform

PERFECTION FOR REFERENCE

YOUR EXPERIENCE & OUR KNOW-HOW: THE BEST TOOLS FOR YOUR MACHINING NEEDS!

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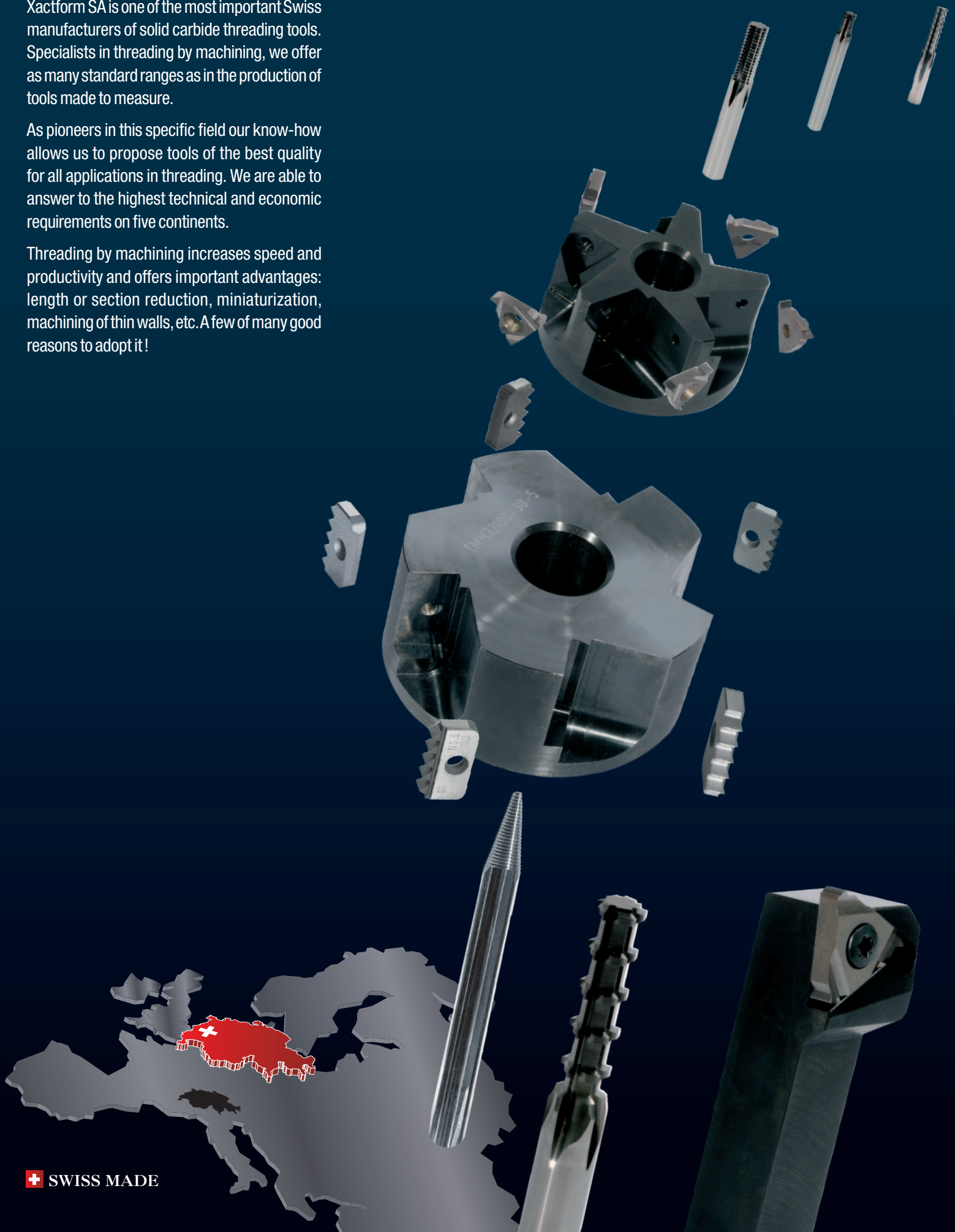
Xactform SA is one of the most important Swiss manufacturers of solid carbide threading tools. Specialists in threading by machining, we offer as many standard ranges as in the production of tools made to measure.

As pioneers in this specific field our know-how allows us to propose tools of the best quality for all applications in threading. We are able to answer to the highest technical and economic requirements on five continents.

Threading by machining increases speed and productivity and offers important advantages: length or section reduction, miniaturization, machining of thin walls, etc. A few of many good reasons to adopt it !



SWISS MADE

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Advantages

Technical and economical advantages of thread milling

Technical advantages

- Allows 100% thread depth where tapping usually permits 65-75%
- Reduced drilling depth: full thread form close to a shoulder and near to depth in blind hole applications.
- Interrupted cutting: Xactform has a positive rake cutting action which cuts instead of shearing and does not "smear" the chip as badly as negative or neutral rakes.
- Multiple starts: easy to achieve using our free and expedient programming services.
- Centerline of the drilled hole can be adjusted with the threadmill.
- Thread height: with 100% of the thread form, it produces better constrained assessment and higher resistances.
- Minimal horsepower requirements, even with coarse pitch threads.
- Chips are smaller and easier to evacuate. Decreases the chance of "bird nesting".

Economic advantages

- Shorter machining times: in one pass, the threadmilling operation can be 5 times shorter than tapping (cost saving).
- Shorter machining times: because of the threadmilling positioning, the hole can be drilled less deeper. For tapered threading, a straight drilled hole is adequate.
- Superior flank finish: no deburring operation.
- Less tools: left or right hand threads, external or internal threads in particular norm, can be produced with the same tool.
- Tool breakage: eliminates chance of scrapping part and costly tool extraction methods.

Material

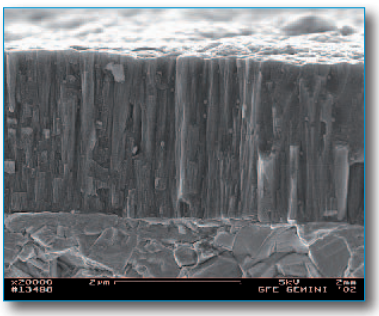
Standard tools
For a wide range of applications the micro-grain grade has excellent resistance to shocks and bending.

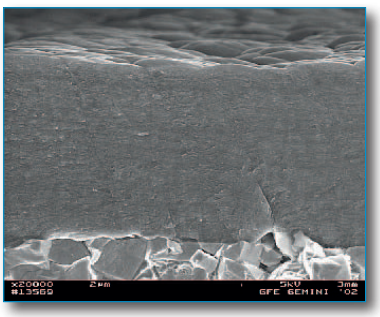
Threadmill diameter ≤ 3 mm
Ultra-fine micro-grain grade for improved tenacity and elasticity.

Upon request for specific applications, special grades ceramic – metal, triangular inserts 3/8″. Finishing inserts and small profiles for high-speed machining.

Honing treatments
Upon request for pitches of 1.50 mm, honing of tool edges is available.

Coating





Coating		Operating temperature (F°)	Color	Applications
K20C	Not coated	~1300°	Silver	General machining
K27C	TiAlN	~2000°	Gray-blue	Rough material
Other coating on demand				

For special applications, contact our technical services in order to select the appropriate tool as well as the optimal coating (info_usa@xactform.com)

Cutting conditions

Helicals

For Helical Flute style use the same surface speed as indicated above.
indicated above. The feed rates can be increased between 25 and 30%.

Straight Flute

Material to be Thread Milled			
Material Group	**Classification**	**Typical Grades**	**Coating**
Steel	Plain Carbon &	AISI/SAE TYPES: 1005, 1020,	K20C
	Low Carbon up to 22Rc	1020, 1108, 1119, 1213, 1215,	
		1513, 1518, 4012, 5015, 9310	K27C
Medium Carbon Steel & Alloy Steels		AISI/SAE Types: 1025, 1095,	K20C
	Heat treatable from 22 to 32 Rc	1130, 1151, 1330, 1345, 1520,	
		4023, 4063, 4120, 4161, 4320,	
		4340, 4620, 4640, 8620, 8660,	
		8740, 8750, 6150, 51000, 52100.	K27C
Medium Carbon & Alloy Steels		AISI/SAE Types: 1040, 1095,	K20C
	Heat treatable from 32 to 42Rc	1130, 1151, 1330, 1345, 1520,	
		1572, 4023, 4063, 4120, 4161,	
		4330, 4340, 4620, 4640, 8620,	
		8660, 8740, 8750, 6150, 5100.	K27C
Stainless Steels	Austenic	Types: 301, 304, 310, 316, 321,	K20C
		347	K27C
Stainless Steels	Martensitic	Types: 403, 410, 416, 420, 430,	
		431, 440C	K20C
Stainless Steels	Precipitation Hardening	Types: 15-5PH, 17-4PH, AM350,	K20C
		AM355, AM363, PH13-8Mo,	
		PH14-8Mo.	K27C
Titanium	Nickel & Nickel Based Alloys	Inconel 700, 713C, 718,	K20C
		Inconel X, Monel 400, 401, 404,	
		& K, Rene 41, Rene 95,	
		Waspoloy, Udimet 500 & 700.	K27C
Cast Iron	Gray, Malleable, Ductile Nodular.	ATSM A48, A220, A436, A319,	K20C
		A602, SAE J158, SAE J434.	K27C
Non Ferrous	Wrought & low Si Cast Aluminum	6061, Free Machining Brass	K20C
			K27C

Coating type
K20C: PVD TiN Titanium Nitride
K27C: PVD TiAlN Titanium Aluminum Nitride

Cutting speed feet/minute	Tool Shank Diameter & Number of Flutes Starting SFPM & Suggested Feed in Inches / Flute							
	Cutting diameter							
	1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"
	Number of flutes							
	3	3	5	5	5	5	6	6
425 - 475	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
525 - 625	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
425 - 450	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
525 - 575	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
325 - 375	0.0003"	0.0003"	0.0005"	0.0007"	0.001'	0.0012"	0.0015"	0.0017"
475 - 525	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017'
375 - 425	0.0003"	0.0003"	0.0005'	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
475 - 525	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
400 - 475	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
250 - 275	0.0003"	0.0003"	0.0005"	0.0007'	0.001"	0.0012"	0.0015"	0.0017"
275 - 325	0.0003"	0.0003"	0.0005"	0.0007"	0.001"	0.0012"	0.0015"	0.0017"
75 - 100	0.0003"	0.0003"	0.0005"	0.0007"	0.0008"	0.0008"	0.001"	0.001"
100 - 120	0.0003"	0.0003"	0.0005"	0.0007"	0.0008"	0.0008"	0.001"	0.001"
475 - 525	0.0003"	0.0003"	0.0006"	0.0007"	0.0008"	0.001"	0.0012"	0.0015"
550 - 600	0.0003"	0.0003"	0.0006"	0.0007"	0.0008"	0.001"	0.0012"	0.0015"
1200 - 1400	0.0003"	0.0003"	0.0006"	0.0007"	0.0008"	0.001"	0.0012"	0.0014"
1500 - 1700	0.0003"	0.0003"	0.0006"	0.0007"	0.0008"	0.001"	0.0012"	0.0014"

Listing

Reference

TMSC	1/2	x	.470	N	14''	UN	T2	HA	WCH

TMSC Straight flute

TMHE Helical flute

TBR Whirling tool

TBRL Long whirling tool

D Shank diameter

D1 Cutting Diameter

N Internal

E External

NE Internal-external

Pitch (thread per inch, mm)

Norm

T2, T3 One thoot every 2 pitch, or 3 pitch

2, 25 L1 = 2xD, 2.5xD

2A L1 = 2xD + chamfer 60°

2T, 3T 2 teeth, 3 teeth

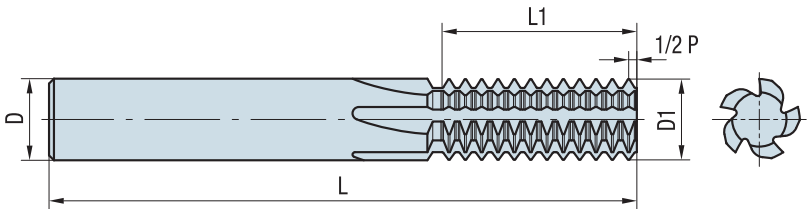
HA Plain cylindrical shanks

HB Weldon 6535-HB

HE Weldon 6535-HE

WCH With Coolant Hole

WCG With Coolant Groove



L Tool overall length

L1 Length of thread

NF Thread quantity

Z Number of flutes

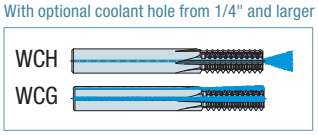
H Thread height

EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70148	78148	N°0-80	TMSC 1/8x.040 N 80''UN	1.50	0.100	0.125	0.040	8	3	0.0073

DIN 6535

HA Plain cylindrical shank
HB Weldon 6535-HB
HE Weldon 6535-HE

With optional coolant hole from 1/4" and larger



WCH With Coolant Hole
WCG With Coolant Groove

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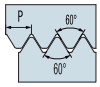
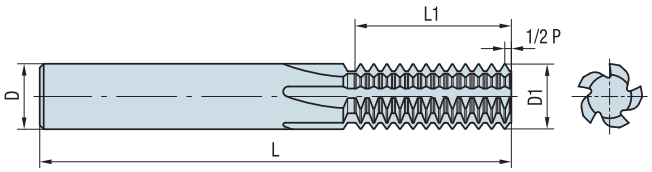
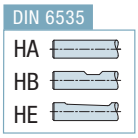
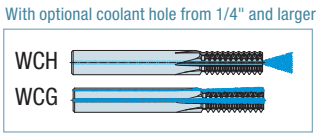
Unified National Standard Inch

DIN IOS 5864, ANSI/ASME B1.7









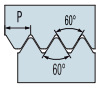
1.5xØ Straight flute

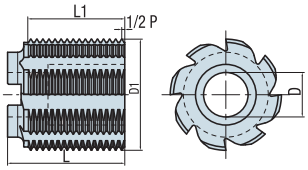
UN, UNC, UNS Internal

EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70148	78148	N°0-80	TMSC 1/8x.040 N 80''UN	1.50	0.100	0.125	0.040	8	3	0.0073
70149	78149	N°1-72	TMSC 1/8x.050 N 72''UN	1.50	0.111	0.125	0.050	8	3	0.0081
70100	78100	N°2-64	TMSC 1/8x.060 N 64''UN	1.50	0.125	0.125	0.060	8	3	0.0092
70101	78101	N°2-56	TMSC 1/8x.060 N 56''UN	1.50	0.125	0.125	0.060	7	3	0.0103
70102	78102	N°3-48	TMSC 1/8x.060 N 48''UN	1.50	0.146	0.125	0.060	7	3	0.0120
70103	78103	N°5-44	TMSC 1/8x.085 N 44''UN	1.50	0.182	0.125	0.085	8	3	0.0131
70138	78138	N°4-40	TMSC 1/8x.080 N 40"UN	1.50	0.175	0.125	0.080	7	3	0.0144
70142	78142	5/16''-40	TMSC 1/8x.080 N 40"UN	2.25	0.375	0.250	0.240	15	5	0.0144
70105	78105	#8-36	TMSC 1/8x.120 N 36''UN	1.50	0.250	0.125	0.120	9	3	0.0160
70107	78107	#8-32	TMSC 1/8x.120 N 32"UN	1.50	0.250	0.125	0.120	8	3	0.0180
70143	78143	#10-32	TMSC 3/16x.140 N 32''UN	1.65	0.343	0.187	0.140	11	3	0.0180
70108	78108	3/8"-32	TMSC 1/4x.240 N 32"UN	2.25	0.563	0.250	0.240	18	5	0.0180
70139	78139	1/2"-32	TMSC 3/8x.370 N 32"UN	2.84	0.969	0.375	0.370	31	5	0.0180
70109	78109	#12-28	TMSC 3/16x.145 N 28"UN	1.65	0.321	0.187	0.145	9	3	0.0206
70144	78144	3/8"-28	TMSC 1/4x.240 N 28"UN	2.25	0.571	0.250	0.240	16	5	0.0206
70110	78110	7/16"-28	TMSC 5/16X.310 N 28"UN	2.48	0.786	0.312	0.310	22	5	0.0206
70145	78145	7/16"-27	TMSC 5/16x.310 N 27"UN	2.48	0.778	0.312	0.310	21	5	0.0214
70140	78140	#12-24	TMSC 3/16x.140 N 24''UN	1.65	0.417	0.187	0.140	10	3	0.0241
70111	78111	1/4"-24	TMSC 3/16x.160 N 24"UN	1.65	0.333	0.187	0.160	8	3	0.0241
70112	78112	5/16"-24	TMSC 1/4x.200 N 24"UN	2.25	0.500	0.250	0.200	12	3	0.0241
70135	78135	3/8"-24	TMSC 1/4x.240 N 24"UN	2.25	0.583	0.250	0.240	14	5	0.0241
70136	78136	1/2"-24	TMSC 3/8x.370 N 24"UN	2.84	0.959	0.375	0.370	23	5	0.0241
70113	78113	1/4"-20	TMSC 3/16x.160 N 20"UN	1.65	0.400	0.187	0.160	8	3	0.0288
70137	78137	1/4"-20	TMSC 1/4x.187 N 20"UN	2.25	0.500	0.250	0.187	10	3	0.0288
70114	78114	7/16"-20	TMSC 5/16x.310 N 20"UN	2.48	0.750	0.312	0.310	15	5	0.0288
70115	78115	9/16"-20	TMSC 3/8x.370 N 20"UN	2.84	0.900	0.375	0.370	18	5	0.0288
70141	78141	5/8"-20	TMSC 1/2x.470 N 20"UN	3.27	1.050	0.500	0.470	21	5	0.0288
70116	78116	5/16"-18	TMSC 1/4x.200 N 18''UN	2.25	0.500	0.250	0.200	9	3	0.0321
70117	78117	9/16"-18	TMSC 3/8x.370 N 18"UN	2.84	0.944	0.375	0.370	17	5	0.0321
70134	78134	5/8"-18	TMSC 1/2x.437 N 18"UN	3.27	1.000	0.500	0.437	18	5	0.0321
70118	78118	3/8"-16	TMSC 1/4x.240 N 16"UN	2.25	0.563	0.250	0.240	9	5	0.0361
70119	78119	11/16"-16	TMSC 1/2x.470 N 16"UN	3.27	1.125	0.500	0.470	18	5	0.0361
70120	78120	7/16"-14	TMSC 5/16x.310 N 14''UN	2.48	0.643	0.312	0.310	9	5	0.0412
70146	78146	1/2"-14	TMSC 3/8x.370 N 14"UN	2.84	0.929	0.375	0.370	13	5	0.0412
70121	78121	7/8"-14	TMSC 1/2x.470 N 14"UN	3.27	1.143	0.500	0.470	16	5	0.0412
70122	78122	1/2"-13	TMSC 5/16x.310 N 13"UN	2.48	0.769	0.312	0.310	10	5	0.0444
70123	78123	9/16"-12	TMSC 3/8x.370 N 12"UN	2.84	0.917	0.375	0.370	11	5	0.0481
70124	78124	3/4"-12	TMSC 1/2x.470 N 12"UN	3.27	1.167	0.500	0.470	14	5	0.0481
70125	78125	9/16"-11	TMSC 3/8x.370 N 11"UN	2.84	0.909	0.375	0.370	10	5	0.0525
70126	78126	5/8"-11	TMSC 1/2x.437 N 11"UN	3.27	1.091	0.500	0.437	12	5	0.0525
70127	78127	3/4"-10	TMSC 1/2x.470 N 10"UN	3.27	1.100	0.500	0.470	11	5	0.0577
70128	78128	7/8"-9	TMSC 5/8x.620 N 9''UN	3.62	1.333	0.625	0.620	12	6	0.0641
70129	78129	1"-8	TMSC 5/8x.620 N 8''UN	3.62	1.500	0.625	0.620	12	6	0.0722
70130	78130	1 1/8"-7	TMSC 5/8x.620 N 7''UN	3.62	1.429	0.625	0.620	10	6	0.0824
70131	78131	1 3/8"-6	TMSC 3/4x.745 N 6''UN	4.10	1.500	0.750	0.745	9	6	0.0962
70132	78132	1 3/4"-5	TMSC 3/4x.745 N 5''UN	4.10	1.400	0.750	0.745	7	6	0.1155
70133	78133	2"-4.5	TMSC 3/4x.745 N 4.5''UN	4.10	1.556	0.750	0.745	7	6	0.1283

Unified National Standard Inch

DIN IOS 5864, ANSI/ASME B1.7





Keyway ISO 240

Straight flute

UN, UNC, UNS Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70700	78700	13/4"	TMSC 350 N 20''UN	1.50	1.150	0.512	1.378	23	12	0.0288
70701	78701	13/4"	TMSC 350 N 18''UN	1.50	1.167	0.512	1.378	21	12	0.0321
70702	78702	13/4"	TMSC 350 N 16''UN	1.50	1.125	0.512	1.378	18	12	0.0361
70703	78703	13/4"	TMSC 350 N 12''UN	1.50	1.167	0.512	1.378	14	12	0.0481
70704	78704	13/4"	TMSC 350 N 8''UN	1.50	1.125	0.512	1.378	9	8	0.0722
70705	78705	13/4"	TMSC 350 N 6''UN	1.50	1.167	0.512	1.378	7	8	0.0962
70706	78706	21/2"	TMSC 450 N 20''UN	1.85	1.550	0.630	1.772	31	12	0.0288
70707	78707	21/2"	TMSC 450 N 16''UN	1.85	1.563	0.630	1.772	25	12	0.0361
70708	78708	21/2"	TMSC 450 N 12''UN	1.85	1.500	0.630	1.772	18	12	0.0481
70709	78709	21/2"	TMSC 450 N 8''UN	1.85	1.500	0.630	1.772	12	12	0.0722
70710	78710	21/2"	TMSC 450 N 6''UN	1.85	1.500	0.630	1.772	9	8	0.0962
70711	78711	21/4"	TMSC 450 N 4.5''UN	1.85	1.556	0.630	1.772	7	8	0.1283
70712	78712	21/2	TMSC 450 N 4''UN	1.85	1.500	0.630	1.772	6	8	0.1443
70713	78713	23/4"	TMSC 550 N 20''UN	2.28	1.950	0.866	2.165	39	12	0.0288
70714	78714	23/4"	TMSC 550 N 16''UN	2.28	1.938	0.866	2.165	31	12	0.0361
70715	78715	23/4"	TMSC 550 N 12''UN	2.28	1.917	0.866	2.165	23	12	0.0481
70716	78716	23/4"	TMSC 550 N 8''UN	2.28	1.875	0.866	2.165	15	12	0.0722
70717	78717	23/4"	TMSC 550 N 6''UN	2.28	1.833	0.866	2.165	11	8	0.0962
70718	78718	23/4"	TMSC 550 N 4''UN	2.28	1.750	0.866	2.165	7	8	0.1443

Available with helical flutes and for external threading

Unified National Standard Inch

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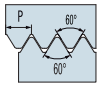

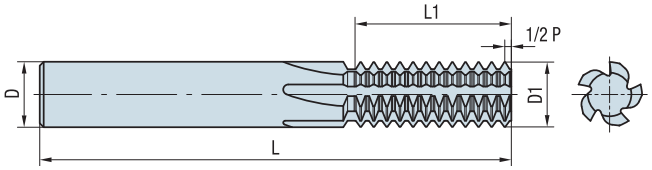

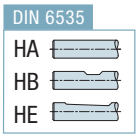

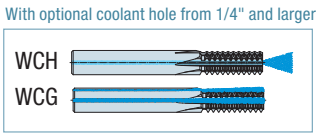

1.5xØ Straight flute

UNF, UNEF Internal fine pitch

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70108	78108	3/8 - 32"	TMSC 1/4x.240 N 32''UN	2.25	0.563	0.250	0.240	18	5	0.0180
70110	78110	7/16 - 28"	TMSC 5/16x.310 N 28''UN	2.48	0.786	0.312	0.310	22	5	0.0206
70115	78115	9/16 - 20"	TMSC 3/8x.370 N 20''UN	2.84	0.900	0.375	0.370	18	5	0.0288
70117	78117	9/16 - 18"	TMSC 3/8x.370 N 18''UN	2.84	0.944	0.375	0.370	17	5	0.0321
70119	78119	11/16 - 16"	TMSC 1/2x.470 N 16''UN	3.27	1.125	0.500	0.470	18	5	0.0361
70124	78124	3/4 - 12"	TMSC 1/2x.470 N 12''UN	3.27	1.167	0.500	0.470	14	5	0.0481

1.5xØ Straight flute

UN, UNC, UNS External

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70208	78208	ALL 36UN	TMSC 1/4x.240 E 36"UN	2.25	0.278	0.250	0.240	10	5	0.0171
70200	78200	ALL 32UN	TMSC 1/4x.240 E 32"UN	2.25	0.562	0.250	0.240	18	5	0.0192
70209	78209	ALL 32UN	TMSC 3/8x.370 E 32"UN	2.84	0.938	0.375	0.370	30	5	0.0192
70201	78201	ALL 28UN	TMSC 5/16x.310 E 28''UN	2.48	0.786	0.312	0.310	22	5	0.0220
70210	78210	ALL 24UN	TMSC 5/16x.310 E 24"UN	2.48	0.792	0.312	0.310	19	5	0.0256
70211	78211	ALL 24UN	TMSC 3/8x.370 E 24"UN	2.84	1.000	0.375	0.370	24	5	0.0256
70202	78202	ALL 20UN	TMSC 3/8x.370 E 20"UN	2.84	0.900	0.375	0.370	18	5	0.0307
70203	78203	ALL 18UN	TMSC 3/8x.370 E 18''UN	2.84	0.944	0.375	0.370	17	5	0.0342
70204	78204	ALL 16UN	TMSC 1/2x.470 E 16''UN	3.27	1.125	0.500	0.470	18	5	0.0384
70212	78212	ALL 14UN	TMSC 5/16x.310 E 14"UN	2.48	0.643	0.312	0.310	9	5	0.0439
70213	78213	ALL 14UN	TMSC 1/2x.470 E 14"UN	3.27	1.143	0.500	0.470	16	5	0.0439
70205	78205	ALL 12UN	TMSC 1/2x.470 E 12''UN	3.27	1.167	0.500	0.470	14	5	0.0512
70206	78206	ALL 8UN	TMSC 5/8x.620 E 8''UN	3.62	1.500	0.625	0.620	12	6	0.0769
70207	78207	ALL 6UN	TMSC 3/4x.745 E 6''UN	4.10	1.500	0.750	0.745	9	6	0.1025

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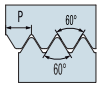
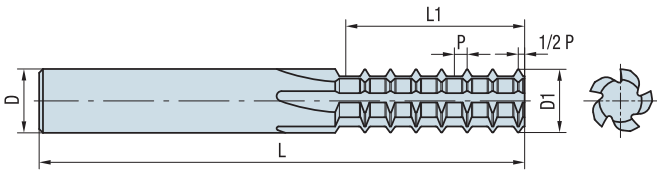
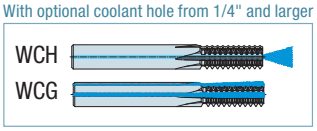




DIN 6535

With optional coolant hole from 1/4" and larger



T2 2xØ Straight flute

UN, UNC, UNS Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70800	78800	# 4-40	TMSC 1/8x.080 N 40"UN T2	1.50	0.224	0.125	0.080	-	3	0.0144
70801	78801	# 6-32	TMSC 1/8x.085 N 32"UN T2	1.50	0.250	0.125	0.085	-	3	0.0180
70802	78802	# 8-32	TMSC 1/8x.120 N 32''UN T2	1.50	0.328	0.125	0.120	-	3	0.0180
70813	78813	1/4"-28	TMSC 3/16X.160 N 28"UN T2	1.97	0.500	0.187	0.160	-	3	0.0206
70814	78814	1/4"-28	TMSC 1/4x.180 N 28"UN T2	2.95	0.786	0.250	0.180	-	3	0.0206
70821	78821	# 10-24	TMSC 1/8x.120 N 24"UN T2	1.50	0.250	0.125	0.120	-	3	0.0241
70815	78815	# 12-24	TMSC 3/16x.140 N 24"UN T2	2.56	0.500	0.187	0.140	-	3	0.0241
70816	78816	5/16"-24	TMSC 1/4x.200 N 24"UN T2	2.95	0.833	0.250	0.200	-	3	0.0241
70822	78822	3/8"-24	TMSC 1/4x.240 N 24"UN T2	2.95	0.750	0.250	0.240	-	5	0.0241
70803	78803	1/4"-20	TMSC 3/16x.160 N 20"UN T2	2.56	0.500	0.187	0.160	-	3	0.0289
70817	78817	7/16"-20	TMSC 5/16x.310 N 20"UN T2	3.35	1.000	0.312	0.310	-	5	0.0289
70804	78804	5/16"-18	TMSC 1/4x.200 N 18"UN T2	2.95	0.625	0.250	0.200	-	3	0.0321
70819	78819	5/8"-18	TMSC 1/2x.437 N 18"UN T2	3.94	1.375	0.500	0.437	-	5	0.0321
70805	78805	3/8"-16	TMSC 1/4x.240 N 16"UN T2	2.95	0.750	0.250	0.240	-	5	0.0361
70820	78820	11/16"-16	TMSC 1/2x.470 N 16"UN T2	3.94	1.375	0.500	0.470	-	5	0.0361
70806	78806	7/16"-14	TMSC 5/16x.310 N 14''UN T2	3.35	0.875	0.312	0.310	-	5	0.0412
70807	78807	1/2"-13	TMSC 5/16x.310 N 13''UN T2	3.35	1.000	0.312	0.310	-	5	0.0444
70808	78808	9/16"-12	TMSC 3/8x.370 N 12''UN T2	3.35	1.125	0.375	0.370	-	5	0.0481
70818	78818	3/4"-12	TMSC 1/2X.470 N 12"UN T2	3.94	1.500	0.500	0.470	-	5	0.0481
70809	78809	5/8"-11	TMSC 1/2X.437 N 11"UN T2	3.94	1.250	0.500	0.437	-	5	0.0525
70810	78810	3/4"-10	TMSC 1/2x.470 N 10"UN T2	3.94	1.500	0.500	0.470	-	5	0.0577
70811	78811	7/8" - 9	TMSC 5/8x.620 N 9"UN T2	4.50	1.750	0.625	0.620	-	6	0.0641
70812	78812	1" - 8	TMSC 5/8x.620 N 8"UN T2	4.50	2.000	0.625	0.620	-	6	0.0722
70823	78823	1 1/8" - 7	TMSC 5/8x.620 N 7"UN T2	4.50	2.000	0.625	0.620	-	6	0.0824

Unified National Standard Inch

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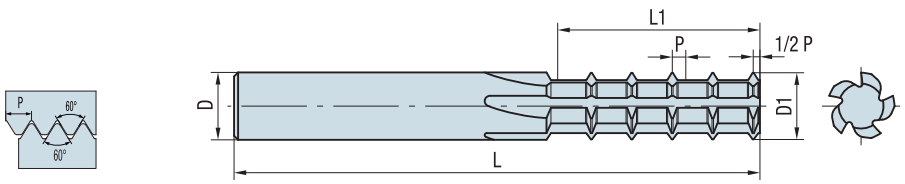

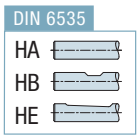

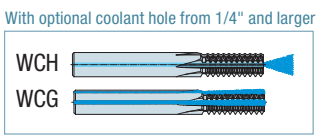

T3 3xØ Straight flute

UN, UNC, UNS Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70900	78900	# 4-40	TMSC 1/8x.080 N 40"UN T3	1.65	0.336	0.125	0.080	-	3	0.0144
70901	78901	# 6-32	TMSC 1/8x.085 N 32"UN T3	1.65	0.375	0.125	0.085	-	3	0.0180
70902	78902	# 8-32	TMSC 1/8x.120 N 32''UN T3	1.65	0.492	0.125	0.120	-	3	0.0180
70913	78913	# 12-28	TMSC 3/16x.160 N 28"UN T3	2.37	0.750	0.187	0.160	-	3	0.0206
70914	78914	1/4"-28	TMSC 1/4x.180 N 28"UN T3	2.90	0.750	0.250	0.180	-	3	0.0206
70921	78921	# 10-24	TMSC 1/8x.120 N 24"UN T3	1.50	0.375	0.125	0.120	-	3	0.0241
70915	78915	# 12-24	TMSC 3/16x.140 N 24"UN T3	2.56	0.625	0.187	0.140	-	3	0.0241
70916	78916	5/16"-24	TMSC 1/4x.200 N 24"UN T3	2.75	0.958	0.250	0.200	-	3	0.0241
70920	78920	3/8"-24	TMSC 1/4x.240 N 24"UN T3	2.95	1.000	0.250	0.240	-	5	0.0241
70903	78903	1/4"-20	TMSC 3/16x.160 N 20"UN T3	2.56	0.750	0.187	0.160	-	3	0.0288
70917	78917	7/16"-20	TMSC 5/16x.310 N 20"UN T3	3.35	1.200	0.312	0.310	-	5	0.0288
70904	78904	5/16"-18	TMSC 1/4x.200 N 18''UN T3	2.95	0.937	0.250	0.200	-	3	0.0321
70905	78905	3/8"-16	TMSC 1/4x.240 N 16''UN T3	2.95	1.125	0.250	0.240	-	5	0.0361
70906	78906	7/16"-14	TMSC 5/16x.310 N 14''UN T3	3.35	1.286	0.312	0.310	-	5	0.0412
78907	78907	1/2"-13	TMSC 5/16x.310 N 13''UN T3	3.35	1.500	0.312	0.310	-	5	0.0444
70908	78908	9/16"-12	TMSC 3/8x.370 N 12''UN T3	3.35	1.687	0.375	0.370	-	5	0.0481
70918	78918	3/4"-12	TMSC 1/2x.470 N 12"UN T3	3.94	2.000	0.500	0.470	-	5	0.0481
70909	78909	5/8"-11	TMSC 1/2x.437 N 11''UN T3	4.35	1.909	0.500	0.437	-	5	0.0525
70910	78910	3/4"-10	TMSC 1/2x.470 N 10''UN T3	4.35	2.250	0.500	0.470	-	5	0.0577
70911	78911	7/8"-9	TMSC 5/8x.620 N 9"UN T3	5.13	2.333	0.625	0.620	-	6	0.0641
70912	78912	1"-8	TMSC 5/8x.620 N 8"UN T3	5.13	1.875	0.625	0.620	-	6	0.0722
70919	78919	1 1/8"-7	TMSC 5/8x.620 N 7"UN T3	5.13	2.000	0.625	0.620	-	6	0.0824

Unified National Standard Inch

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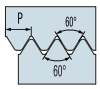
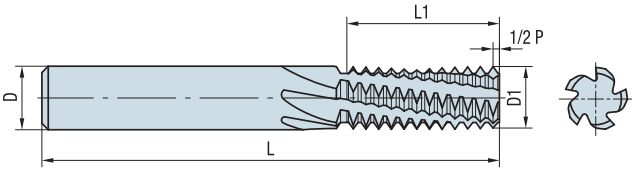
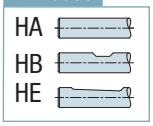
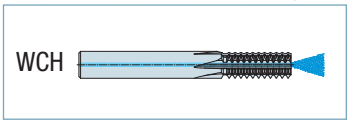




DIN 6535



With optional coolant hole from 1/4" and larger



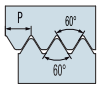
2.0xØ Helical flute

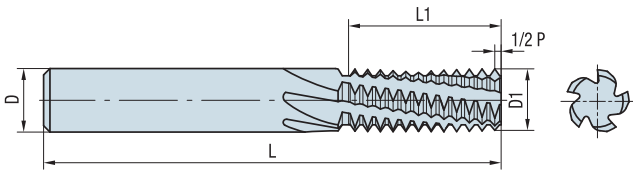
UN, UNC, UNS Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
X8044	X8844	# 0-80	TMHE 1/8x.040 N 80''UN	1.50	0.100	0.125	0.040	8	3	0.0073
X8045	X8845	# 1-72	TMHE 1/8x.050 N 72''UN	1.50	0.111	0.125	0.050	8	3	0.0080
X8046	X8846	# 2-64	TMHE 1/8x.060 N 64''UN	1.50	0.125	0.125	0.060	8	3	0.0090
X8001	X8801	# 2-56	TMHE 1/8x.060 N 56''UN	1.50	0.179	0.125	0.060	10	3	0.0103
X8047	X8847	# 3-48	TMHE 1/8x.060 N 48''UN	1.50	0.146	0.125	0.060	7	3	0.0120
X8048	X8848	# 5-44	TMHE 1/8x.085 N 44''UN	1.50	0.182	0.125	0.085	8	3	0.0131
X8002	X8802	# 4-40	TMHE 1/8x.080 N 40"UN	1.50	0.225	0.125	0.080	9	3	0.0144
X8049	X8849	# 8-36	TMHE 1/8x.120 N 36"UN	1.50	0.250	0.125	0.120	8	3	0.0160
X8003	X8803	# 6-32	TMHE 1/8x.095 N 32"UN	1.50	0.281	0.125	0.095	9	3	0.0180
X8004	X8804	# 8-32	TMHE 1/8x.120 N 32''UN	1.50	0.344	0.125	0.120	11	3	0.0180
X8005	X8805	# 10-32	TMHE 3/16x.146 N 32"UN	1.97	0.406	0.187	0.146	13	3	0.0180
X8050	X8850	# 12-28	TMHE 3/16x.140 N 28"UN	1.97	0.321	0.187	0.140	9	3	0.0206
X8007	X8807	1/4"-28	TMHE 1/4x.200 N 28”UN	2.95	0.500	0.250	0.200	14	3	0.0206
X8006	X8806	# 10-24	TMHE 3/16x.136 N 24''UN	1.97	0.417	0.187	0.136	10	3	0.0241
X8010	X8810	5/16"-24	TMHE 1/4x.248 N 24"UN	2.95	0.625	0.250	0.248	15	3	0.0241
X8012	X8812	3/8"-24	TMHE 5/16x.310 N 24"UN	2.95	0.750	0.312	0.310	18	3	0.0241
X8008	X8808	1/4"-20	TMHE 1/4x.187 N 20"UN	2.95	0.500	0.250	0.187	10	3	0.0289
X8013	X8813	7/16"-20	TMHE 3/8x.360 N 20"UN	3.35	0.900	0.375	0.360	18	5	0.0289
X8015	X8815	1/2"-20	TMHE 3/8x.370 N 20"UN	3.35	1.000	0.375	0.370	20	5	0.0289
X8009	X8809	5/16"-18	TMHE 1/4x.238 N 18"UN	2.95	0.667	0.250	0.238	12	3	0.0321
X8019	X8819	9/16"-18	TMHE 1/2x.420 N 18"UN	3.94	1.222	0.500	0.420	22	5	0.0321
X8020	X8820	5/8"-18	TMHE 1/2x.470 N 18"UN	3.94	1.278	0.500	0.470	23	5	0.0321
X8011	X8811	3/8"-16	TMHE 5/16x.290 N 16"UN	2.95	0.750	0.312	0.290	12	5	0.0361
X8017	X8817	9/16"-16	TMHE 1/2x.420 N 16"UN	3.94	1.125	0.500	0.420	18	5	0.0361
X8023	X8823	3/4”-16	TMHE1/2x.490 N 16”UN	3.94	1.500	0.500	0.490	24	5	0.0361
X8014	X8814	7/16"-14	TMHE 3/8x.340 N 14"UN	3.35	0.929	0.375	0.340	13	5	0.0412
X8016	X8816	1/2"-13	TMHE 3/8x.360 N 13"UN	3.35	1.000	0.375	0.360	13	5	0.0444
X8018	X8818	3/4"-12	TMHE 1/2x.470 N 12"UN	3.94	1.500	0.500	0.470	18	5	0.0481
X8021	X8821	5/8"-11	TMHE 1/2x.470 N 11"UN	3.94	1.273	0.500	0.470	14	5	0.0525
X8022	X8822	3/4"-10	TMHE 1/2x.490 N 10"UN	3,94	1.500	0.500	0.490	15	5	0.0577
X8024	X8824	7/8"-9	TMHE 5/8x.620 N 9''UN	4.50	1.778	0.625	0.620	16	6	0.0641
X8025	X8825	1"-8	TMHE 3/4x.740 N 8"UN	4.50	2.000	0.750	0.740	16	6	0.0723
X8026	X8826	1 1/8"-7	TMHE 3/4x.745 N 7"UN	4.50	2.286	0.750	0.745	16	6	0.0825
X8036	X8836	1 3/8"-6	TMHE 3/4x.745 N 6''UN	4.50	1.500	0.750	0.745	9	6	0.0962
X8037	X8837	1 3/4"-5	TMHE 3/4x.745 N 5''UN	4.50	1.400	0.750	0.745	7	6	0.1155
X8038	X8838	2"-4.5	TMHE 3/4x.745 N 4.5''UN	4.50	1.556	0.750	0.745	7	6	0.1282

Unified National Standard Inch

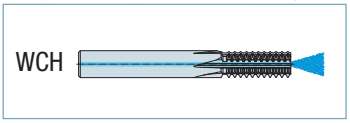
DIN IOS 5864, ANSI/ASME B1.7





DIN 6535

With optional coolant hole from 1/4" and larger



1.5xØ Helical flute

UNF, UNEF Internal fine pitch

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
X8040	X8840	3/8"-32	TMHE 1/4x.240 N 32''UN	2.24	0.562	0.250	0.240	18	5	0.0180
X8041	X8841	7/16"-28	TMHE 5/16x.310 N 28''UN	2.48	0.785	0.312	0.310	22	5	0.0206
X8015	X8815	9/16"-20	TMHE 3/8x.370 N 20''UN	2.83	0.900	0.375	0.370	18	5	0.0289
X8042	X8842	9/16"-18	TMHE 3/8x.370 N 18''UN	2.83	0.944	0.375	0.370	17	5	0.0321
X8043	X8843	11/16"-16	TMHE 1/2x.470 N 16''UN	3.27	1.125	0.500	0.470	18	5	0.0361
X8018	X8818	3/4"-12	TMHE 1/2x.470 N 12''UN	3.27	1.167	0.500	0.470	14	5	0.0481

1.5xØ Helical flute

UN, UNC, UNS External

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
79200	79820	ALL 32 PITCH	TMHE 1/4x.240 E 32''UN	2.24	0.562	0.250	0.240	18	5	0.0192
79201	79801	ALL 28 PITCH	TMHE 5/16x.310 E 28''UN	2.48	0.785	0.312	0.310	22	5	0.0220
79202	79802	ALL 20 PITCH	TMHE 3/8x.370 E 20''UN	2.83	0.900	0.375	0.370	18	5	0.0307
79203	79803	ALL 18 PITCH	TMHE 3/8x.370 E 18''UN	2.83	0.944	0.375	0.370	17	5	0.0342
79204	79804	ALL 16 PITCH	TMHE 1/2x.470 E 16''UN	3.27	1.125	0.500	0.470	18	5	0.0384
79205	78905	ALL 12 PITCH	TMHE 1/2x.470 E 12''UN	3.27	1.167	0.500	0.470	14	5	0.0512
79206	79806	ALL 8 PITCH	TMHE 5/8x.620 E 8''UN	3.62	1.500	0.625	0.620	12	6	0.0769
79207	79807	ALL 6 PITCH	TMHE 3/4x.745 E 6''UN	4.09	1.500	0.750	0.745	9	6	0.1025

Unified National Standard Inch

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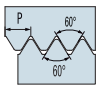
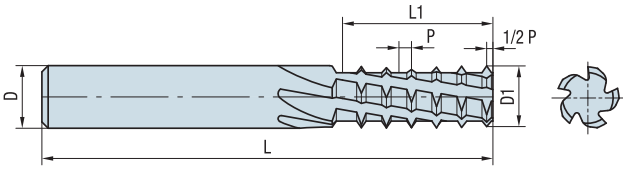




DIN 6535

With optional coolant hole from 1/4" and larger

T2 2.5xØ Helical flute

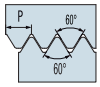
UN, UNC, UNS Internal

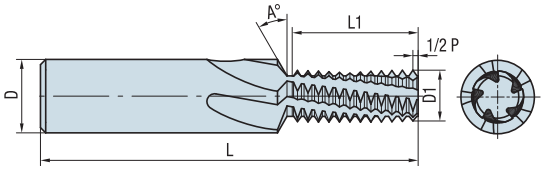
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
X9801	X8901	# 2-56	TMHE 1/8x.060 N 56"UN-25	1.50	0.214	0.125	0.060	-	3	0.0103
X9802	X8902	# 4-40	TMHE 1/8x.080 N 40"UN-25	1.50	0.250	0.125	0.080	-	3	0.0144
X9803	X8903	# 6-32	TMHE 1/8x.095 N 32"UN-25	1.50	0.344	0.125	0.095	-	3	0.0180
X9804	X8904	# 8-32	TMHE 1/8x.120 N 32''UN-25	1.50	0.406	0.125	0.120	-	3	0.0180
X9805	X8905	# 10-32	TMHE 3/16x.146 N 32''UN-25	1.85	0.500	0.187	0.146	-	3	0.0180
X9807	X8907	*1/4"-28	TMHE 1/4x.200 N 28"UN-25	2.44	0.643	0.250	0.200	-	3	0.0206
X9806	X8906	# 10-24	TMHE 3/16x.136 N 24''UN-25	1.85	0.500	0.187	0.136	-	3	0.0241
X9810	X8910	*5/16"-24	TMHE 1/4x.248 N 24''UN-25	2.44	0.792	0.250	0.248	-	5	0.0241
X9812	X8912	*3/8"-24	TMHE 5/16x.310 N 24" UN-25	2.91	0.958	0.312	0.310	-	5	0.0241
X9808	X8908	*1/4"-20	TMHE 1/4x.187 N 20''UN-25	2.44	0.650	0.250	0.187	-	3	0.0288
X9813	X8913	*7/16"-20	TMHE 3/8x.360 N 20"UN-25	3.74	1.100	0.375	0.360	-	5	0.0288
X9815	X8915	*1/2"-20	TMHE 3/8x.370 N 20"UN-25	3.74	1.250	0.375	0.370	-	5	0.0288
X9809	X8909	*5/16"-18	TMHE 1/4x.238 N 18"UN-25	2.44	0.778	0.250	0.238	-	5	0.0321
X9819	X8919	*9/16"-18	TMHE 1/2x.420 N 18''UN-25	3.94	1.444	0.500	0.420	-	5	0.0321
X9820	X8920	*5/8"-18	TMHE 1/2x.470 N 18"UN-25	3.94	1.555	0.500	0.470	-	5	0.0321
X9811	X8911	*3/8"-16	TMHE 5/16x.290 N 16"UN-25	2.91	0.937	0.312	0.290	-	5	0.0361
X9817	X8917	*9/16"-16	TMHE 1/2x.420 N 16''UN-25	3.94	1.437	0.500	0.420	-	5	0.0361
X9823	X8923	*3/4"-16	TMHE 1/2x.490 N 16"UN-25	3.94	1.875	0.500	0.490	-	5	0.0361
X9814	X8914	*7/16"-14	TMHE 3/8x.340 N 14''UN-25	3.74	1.143	0.375	0.340	-	5	0.0412
X9816	X8916	*1/2"-13	TMHE 3/8x.360 N 13"UN-25	3.74	1.308	0.375	0.360	-	5	0.0444
X9821	X8921	*5/8"-11	TMHE 1/2x.470 N 11''UN-25	3.94	1.636	0.500	0.470	-	5	0.0525
X9818	X8918	*3/4"-12	TMHE 1/2x.470 N 12"UN-25	3.94	1.917	0.500	0.470	-	5	0.0481
X9822	X8922	*3/4"-10	TMHE 1/2x.490 N 10"UN-25	3.94	1.900	0.500	0.490	-	5	0.0577
X9824	X8924	*7/8"-9	TMHE 5/8x.620 N 9''UN-25	4.50	2.222	0.625	0.620	-	6	0.0641
X9825	X8925	*1"- 8	TMHE 3/4x.740 N 8"UN-25	5.10	2.500	0.750	0.740	-	6	0.0722
X9826	X8926	*1 1/8"-7	TMHE 3/4x.745 N 7''UN-25	5.10	2.571	0.750	0.745	-	6	0.0824

* With Coolant Hole

Unified National Standard Inch

DIN IOS 5864, ANSI/ASME B1.7





DIN 6535

With optional coolant hole from 1/4" and larger

2xØ + A60° Helical flute

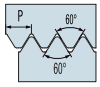
UN, UNC, UNS Internal

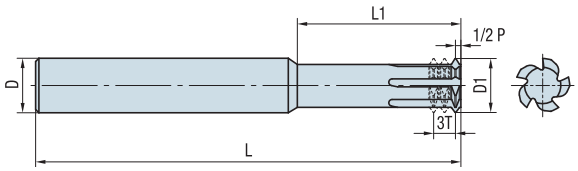
EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70101+A	78101+A	#2-56	TMHE 3/16x.065 N 56''UN-2A	1.65	0.179	0.187	0.065	10	3	0.0103
70102+A	78102+A	#3-48	TMHE 3/16x.075 N 48''UN-2A	1.65	0.208	0.187	0.075	10	3	0.0120
70103+A	78103+A	#5-44	TMHE 3/16x.080 N 44''UN-2A	1.65	0.250	0.187	0.080	11	3	0.0131
70138+A	78138+A	#4-40	TMHE 3/16x.085 N 40''UN-2A	1.65	0.225	0.187	0.085	9	3	0.0144
70142+A	78142+A	#6-40	TMHE 3/16x.095 N 40''UN-2A	1.65	0.300	0.187	0.095	12	3	0.0144
70105+A	78105+A	#8-36	TMHE 1/4x.120 N 36''UN-2A	2.24	0.333	0.250	0.120	12	3	0.0160
70106+A	78106+A	#6-32	TMHE 3/16x.098 N 32"UN-2A	1.65	0.281	0.187	0.098	9	3	0.0180
70107+A	78107+A	#8-32	TMHE 1/4x.120 N 32''UN-2A	2.24	0.344	0.250	0.120	11	3	0.0180
70143+A	78143+A	#10-32	TMHE 1/4x.140 N 32''UN-2A	2.24	0.437	0.250	0.140	14	3	0.0180
70109+A	78109+A	#12-28	TMHE 5/16x.160 N 28''UN-2A	2.48	0.464	0.312	0.160	13	3	0.0206
70141+A	78141+A	#10-24	TMHE 1/4x.140 N 24''UN-2A	2.24	0.417	0.312	0.140	10	3	0.0241
70140+A	78140+A	#12-24	TMHE 5/16x.160 N 24''UN-2A	2.48	0.458	0.312	0.160	11	3	0.0241
70113+A	78113+A	*1/4"-20	TMHE 5/16x.185 N 20''UN-2A	2.48	0.500	0.312	0.185	10	3	0.0288
70116+A	78116+A	*5/16"-18	TMHE 3/8x.240 N 18''UN-2A	2.83	0.667	0.375	0.240	12	5	0.0321
70118+A	78118+A	*3/8"16	TMHE 1/2x.290 N 16''UN-2A	3.27	0.750	0.500	0.290	12	5	0.0361
70120+A	78120+A	*7/16"-14	TMHE 5/8x.340 N 14''UN-2A	4.33	0.929	0.625	0.340	13	5	0.0412
70122+A	78122+A	*1/2"-13	TMHE 5/8x.390 N 13''UN-2A	4.33	1.000	0.625	0.390	13	5	0.0444
70123+A	78123+A	*9/16"-12	TMHE 5/8x.415 N 12''UN-2A	4.33	1.167	0.625	0.415	14	5	0.0481
70126+A	78126+A	*5/8"-11	TMHE 5/8x.470 N 11''UN-2A	4.33	1.273	0.625	0.470	14	5	0.0525
70127+A	78127+A	*3/4"-10	TMHE 5/8x.490 N 10''UN-2A	4.33	1.500	0.625	0.490	15	6	0.0577
70128+A	78128+A	*7/8"-9	TMHE 3/4x.620 N 9''UN-2A	5.12	1.778	0.750	0.620	16	6	0.0641
70129+A	78129+A	*1"-8	TMHE 100x.745 N 8"UN-2A	5.12	2.000	1.000	0.745	16	6	0.0722
70130+A	78130+A	*1 1/8" -7	TMHE 100x745 N 7"UN-2A	5.12	2.286	1.000	0.745	16	6	0.0824

* With Coolant Hole

Unified National Standard Inch

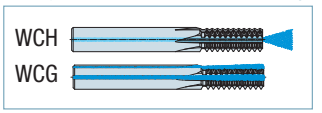
DIN IOS 5864, ANSI/ASME B1.7





DIN 6535

With optional coolant hole from 1/4" and larger



UN

Whirling tool 2xØ Straight flute

UN, UNC, UNS Internal

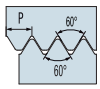
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
40100	46100	#0-80	TBR 1/8x.040 N 80''UN	1.50	0.122	0.125	0.040	-	3	0.0072
40101	46101	#1-72	TBR 1/8x.055 N 72''UN 2T	1.50	0.150	0.125	0.055	-	3	0.0080
40102	46102	#2-64	TBR 1/8x.065 N 64''UN 3T	1.50	0.173	0.125	0.065	-	3	0.0090
40103	46103	#2-56	TBR 1/8x.065 N 56''UN 3T	1.50	0.173	0.125	0.065	-	3	0.0103
40104	46104	#3-48	TBR 1/8x.075 N 48''UN 3T	1.50	0.200	0.125	0.075	-	3	0.0120
40106	46106	#5-44	TBR 1/8x.095 N 44''UN 3T	1.50	0.252	0.125	0.095	-	3	0.0131
40105	46105	#4-40	TBR 1/8x.085 N 40''UN 3T	1.50	0.224	0.125	0.085	-	3	0.0144
40107	46107	#6-40	TBR 1/8x.105 N 40''UN 3T	1.50	0.280	0.125	0.105	-	3	0.0144
40109	46109	#8-36	TBR 3/16x.120 N 36"UN 3T	1.65	0.331	0.187	0.120	-	3	0.0160
40108	46108	#6-32	TBR 1/8x.105 N 32''UN 3T	1.50	0.280	0.125	0.105	-	3	0.0180
40110	46110	#8-32	TBR 3/16x.120 N 32"UN 3T	1.65	0.331	0.187	0.120	-	3	0.0180
40111	46111	#10-32	TBR 3/16x.140 N 32''UN 3T	1.65	0.382	0.187	0.140	-	3	0.0180
40113	46113	#12-28	TBR 1/4x.160 N 28"UN 3T	2.24	0.433	0.250	0.160	-	3	0.0206
40112	46112	#10-24	TBR 3/16x.140 N 24''UN 3T	1.65	0.382	0.187	0.140	-	3	0.0241
40114	46114	#12-24	TBR 1/4x.160 N 24"UN 3T	2.24	0.433	0.250	0.160	-	3	0.0241
40115	46115	1/4"-20	TBR 1/4x.185 N 20"UN 3T	2.44	0.504	0.250	0.185	-	3	0.0288
40116	46116	5/16"-18	TBR 1/4x.240 N 18''UN 3T	2.44	0.630	0.250	0.240	-	5	0.0321
40117	46117	3/8"16	TBR 5/16x.290 N 16''UN 3T	2.48	0.787	0.312	0.290	-	5	0.0361
40118	46118	7/16"-14	TBR 3/8x.340 N 14''UN 3T	2.83	0.906	0.375	0.340	-	5	0.0412
40119	46119	1/2"-13	TBR 3/8x.370 N 13''UN 3T	3.39	1.024	0.375	0.370	-	5	0.0444

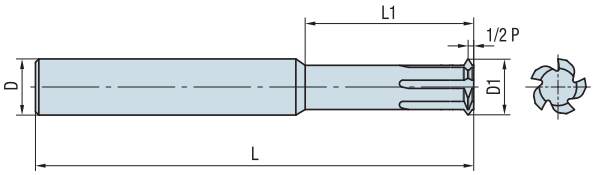
Whirling tool 3xØ Straight flute

UN, UNC, UNS Internal

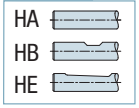
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
40200	46200	#0-80	TBRL 1/8x.040 N 80''UN	1.50	0.181	0.125	0.040	-	3	0.0072
40201	46201	#1-72	TBRL 1/8x.055 N 72''UN 2T	1.50	0.220	0.125	0.055	-	3	0.0080
40202	46202	#2-64	TBRL 1/8x.065 N 64''UN 3T	1.50	0.260	0.125	0.065	-	3	0.0090
40203	46203	#2-56	TBRL 1/8x.065 N 56''UN 3T	1.50	0.260	0.125	0.065	-	3	0.0103
40204	46204	#3-48	TBRL 1/8x.075 N 48''UN 3T	1.50	0.299	0.125	0.075	-	3	0.0120
40206	46206	#5-44	TBRL 1/8x.095 N 44''UN 3T	1.65	0.378	0.125	0.095	-	3	0.0131
40205	46205	#4-40	TBRL 1/8x.080 N 40"UN 3T	1.65	0.339	0.125	0.080	-	3	0.0144
40207	46207	#6-40	TBRL 1/8x.105 N 40''UN 3T	1.65	0.417	0.125	0.105	-	3	0.0144
40209	46209	#8-36	TBRL 3/16x.120 N 36"UN 3T	1.85	0.496	0.187	0.120	-	3	0.0160
40208	46208	#6-32	TBRL 1/8x.105 N 32"UN 3T	1.65	0.417	0.125	0.105	-	3	0.0180
40210	46210	#8-32	TBRL 3/16x.120 N 32"UN 3T	1.85	0.496	0.187	0.120	-	3	0.0180
40211	46211	#10-32	TBRL 3/16x.140 N 32''UN 3T	1.85	0.575	0.187	0.140	-	3	0.0180
40213	46213	#12-28	TBRL 1/4x.160 N 28"UN 3T	2.44	0.654	0.250	0.160	-	3	0.0206
40212	46212	#10-24	TBRL 3/16x.140 N 24''UN 3T	1.85	0.575	0.187	0.140	-	3	0.0241
40214	46214	#12-24	TBRL 1/4x.160 N 24"UN 3T	2.44	0.654	0.250	0.160	-	3	0.0241
40215	46215	1/4"-20	TBRL 1/4x.187 N 20''UN 3T	2.44	0.787	0.250	0.187	-	3	0.0288
40216	46216	5/16"-18	TBRL 1/4x.240 N 18''UN 3T	2.83	0.984	0.250	0.240	-	5	0.0321
40217	46217	3/8"16	TBRL 5/16x.290 N 16''UN 3T	3.39	1.181	0.312	0.290	-	5	0.0361
40218	46218	7/16"-14	TBRL 3/8x.340 N 14''UN 3T	3.74	1.378	0.375	0.340	-	5	0.0412
40219	46219	1/2"-13	TBRL 3/8x.370 N 13''UN 3T	3.74	1.575	0.375	0.370	-	5	0.0444

60° Partial profile Metric + Inch

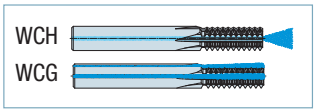




DIN 6535



With optional coolant hole from 1/4" and larger



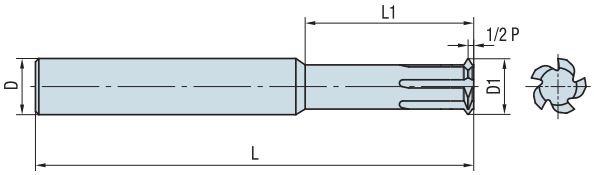
Whirling tool

Straight flute

M+UN Internal/External

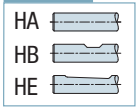
EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
40220	46220	0.50-1.50 / 48-16	TBR 1/4x.240 N A60	2.83	1.181	0.250	0.240	-	5	0.0000
40221	46221	0.50-3.00 / 48-8	TBR 1/2x.470 N AG60	4.53	1.890	0.500	0.470	-	5	0.0000
40222	46222	3.50-5.00 / 7-5	TBR 3/4x.745 N N60	4.72	2.047	0.750	0.745	-	6	0.0000
40223	46223	5.50-6.00 / 4.50-4	TBR 3/4x.745 N Q60	5.51	2.677	0.750	0.745	-	6	0.0000
40224	46224	0.50-1.50 / 48-16	TBR 1/4x.240 E A60	2.83	1.181	0.250	0.240	-	5	0.0000
40225	46225	0.50-3.00 / 48-8	TBR 1/2x.470 E AG60	4.53	1.890	0.500	0.470	-	5	0.0000
40226	46226	3.50-5.00 / 7-5	TBR 3/4x.745 E N60	4.72	2.047	0.750	0.745	-	6	0.0000
40227	46227	5.50-6.00 / 4.50-4	TBR 3/4x.745 E Q60	5.51	2.677	0.750	0.745	-	6	0.0000

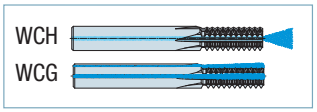
55° Partial profile Metric + Inch



With optional coolant hole from 1/4" and larger

DIN 6535





Whirling tool

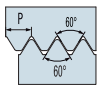
Straight flute

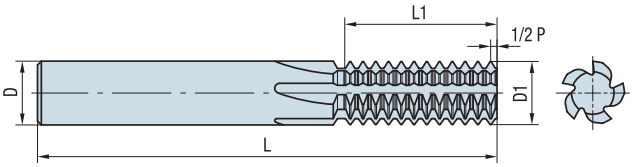
BSW, BSP, G, Rp, BSF Internal/External

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
40228	46228	0.50-1.50 / 48-16	TBR 1/4x.240 NE A55	2.83	1.181	0.250	0.240	-	5	0.0000
40229	46229	0.50-3.00 / 48-8	TBR 5/8x.620 NE AG55	4.72	1.890	0.625	0.620	-	6	0.0000
40230	46230	3.50-5.00 / 7-5	TBR 3/4x.745 NE N55	4.72	2.047	0.750	0.745	-	6	0.0000
40231	46231	5.50-6.00 / 4.50-4	TBR 3/4x.745 NE Q55	5.51	2.677	0.750	0.745	-	6	0.0000

ISO 60° Metric

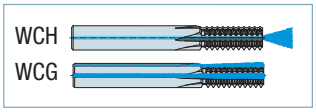
DIN 13, DIN 68, DINISO 965-1, NFISO 965-1





DIN 6535

Available with coolant hole since Ø 6 mm



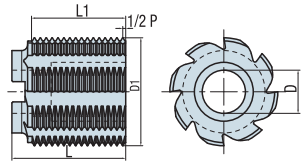
1.5xØ Straight flute

M Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70426	78426	M1.4	TMSC 1/8x.040 N 0.30 ISO	1.50	0.094	0.125	0.040	8	3	0.0068
70400	78400	M1.6	TMSC 1/8x.040 N 0.35 ISO	1.50	0.096	0.125	0.040	7	3	0.0080
70401	78401	M2	TMSC 1/8x.050 N 0.40 ISO	1.50	0.126	0.125	0.050	8	3	0.0091
70402	78402	M2.5	TMSC 1/8x.060 N 0.45 ISO	1.50	0.142	0.125	0.060	8	3	0.0102
70403	78403	M3	TMSC 1/8x.085 N 0.50 ISO	1.50	0.177	0.125	0.085	9	3	0.0114
70427	78427	M3.5	TMSC 1/8x.105 N 0.60 ISO	1.50	0.213	0.125	0.105	9	3	0.0136
70404	78404	M4	TMSC 1/8x.105 N 0.70 ISO	1.50	0.266	0.125	0.105	9	3	0.0159
70405	78405	M4.5	TMSC 1/8x.120 N 0.75 ISO	1.50	0.266	0.125	0.120	9	3	0.0170
70406	78406	M8	TMSC 1/4X.240 N 0.75 ISO	2.25	0.591	0.250	0.240	20	3	0.0170
70407	78407	M5	TMSC 3/16x.145 N 0.80 ISO	1.65	0.315	0.187	0.145	10	3	0.0180
70408	78408	M6	TMSC 3/16x.160 N 1.00 ISO	2.25	0.354	0.187	0.160	9	3	0.0227
70412	78412	M10	TMSC 1/4x.240 N 1.50 ISO	2.25	0.591	0.250	0.240	10	5	0.0341
70413	78413	M14	TMSC 3/8x.370 N 1.50 ISO	2.84	0.945	0.375	0.370	16	5	0.0341
70414	78414	M18	TMSC 1/2x.470 N 1.50 ISO	3.27	1.181	0.500	0.470	20	5	0.0341
70415	78415	M12	TMSC 5/16x.310 N 1.75 ISO	2.48	0.758	0.312	0.310	11	5	0.0398
70416	78416	M14	TMSC 3/8x.370 N 2.00 ISO	2.84	0.945	0.375	0.370	12	5	0.0455
70425	78425	M16	TMSC 1/2x.437 N 2.00 ISO	3.27	1.181	0.500	0.437	15	5	0.0455
70417	78417	M18	TMSC 1/2x.470 N 2.00 ISO	3.27	1.181	0.500	0.470	15	5	0.0455
70418	78418	M20	TMSC 1/2x.470 N 2.50 ISO	3.27	1.181	0.500	0.470	12	5	0.0568
70419	78419	M24	TMSC 5/8x.620 N 3.00 ISO	3.62	1.417	0.625	0.620	12	6	0.0682
70420	78420	M30	TMSC 5/8x.620 N 3.50 ISO	3.62	1.516	0.625	0.620	11	6	0.0795
70421	78421	M36	TMSC 5/8x.620 N 4.00 ISO	3.62	1.575	0.625	0.620	10	6	0.0909
70422	78422	M48	TMSC 3/4x.745 N 5.00 ISO	4.10	1.575	0.750	0.745	8	6	0.1136
70423	78423	M64	TMSC 3/4x.745 N 6.00 ISO	4.10	1.417	0.750	0.745	6	6	0.1364

ISO 60° Metric

DIN 13, DIN 68, DINISO 965-1, NFISO 965-1



Keyway ISO 240

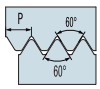
Straight flute

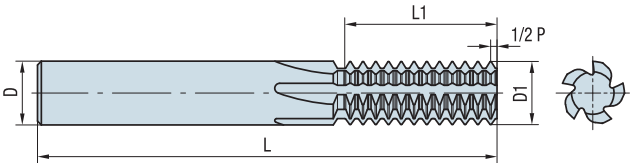
M Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70734	78734	M48	TMSC 350 N 1.25 ISO	1.50	1.181	0.512	1.378	24	12	0.0284
70719	78719	M48	TMSC 350 N 1.50 ISO	1.50	1.181	0.512	1.378	20	12	0.0341
70720	78720	M48	TMSC 350 N 2.00 ISO	1.50	1.181	0.512	1.378	15	12	0.0455
70721	78721	M48	TMSC 350 N 3.00 ISO	1.50	1.181	0.512	1.378	10	8	0.0682
70722	78722	M48	TMSC 350 N 4.00 ISO	1.50	1.102	0.512	1.378	7	8	0.0909
70735	78735	M56	TMSC 450 N 1.25 ISO	1.85	1.575	0.630	1.772	32	12	0.0284
70723	78723	M56	TMSC 450 N 1.50 ISO	1.85	1.535	0.630	1.772	29	12	0.0341
70724	78724	M56	TMSC 450 N 2.00 ISO	1.85	1.575	0.630	1.772	20	12	0.0455
70725	78725	M56	TMSC 450 N 3.00 ISO	1.85	1.535	0.630	1.772	13	12	0.0682
70726	78726	M56	TMSC 450 N 4.00 ISO	1.85	1.575	0.630	1.772	10	8	0.0909
70727	78727	M56	TMSC 450 N 5.50 ISO	1.85	1.516	0.630	1.772	7	8	0.1250
70728	78728	M64	TMSC 450 N 6.00 ISO	1.85	1.417	0.630	1.772	6	8	0.1364
70736	78736	M64	TMSC 550 N 1.25 ISO	2.28	1.969	0.866	2.165	40	12	0.0284
70729	78729	M64	TMSC 550 N 1.50 ISO	2.28	1.949	0.866	2.165	33	12	0.0341
70730	78730	M64	TMSC 550 N 2.00 ISO	2.28	1.969	0.866	2.165	25	12	0.0455
70731	78731	M64	TMSC 550 N 3.00 ISO	2.28	1.890	0.866	2.165	16	12	0.0682
70732	78732	M64	TMSC 550 N 4.00 ISO	2.28	1.890	0.866	2.165	12	8	0.0909
70733	78733	M64	TMSC 550 N 6.00 ISO	2.28	1.890	0.866	2.165	8	8	0.1364

ISO 60° Metric

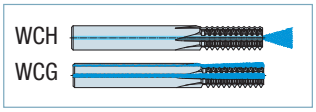
DIN 13, DIN 68, DINISO 965-1, NFISO 965-1





DIN 6535

Available with coolant hole since Ø 6 mm



1.5xØ Straight flute

MF Internal fine pitch

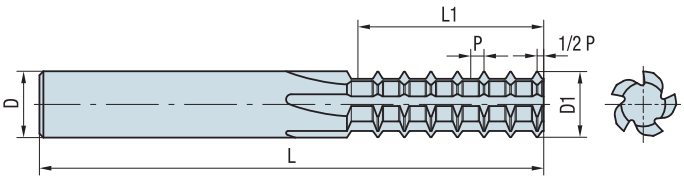
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70429	78429	M10	TMSC 1/4x.240 N 0.50 ISO	2.24	0.591	0.250	0.240	30	5	0.0114
70428	78428	M12	TMSC 5/16x.310 N 0.50 ISO	2.48	0.591	0.312	0.310	30	5	0.0114
70406	78406	M10	TMSC 1/4x.240 N 0.75 ISO	2.24	0.591	0.250	0.240	20	5	0.0170
70424	78424	M10	TMSC 1/4x.240 N 1.00 ISO	2.25	0.591	0.250	0.240	15	5	0.0227
70409	78409	M12	TMSC 5/16x.310 N 1.00 ISO	2.48	0.787	0.312	0.310	20	5	0.0227
70413	78413	M16	TMSC 3/8x.370 N 1.50 ISO	2.83	0.945	0.375	0.370	16	5	0.0341
70414	78414	M18	TMSC 1/2x.470 N 1.50 ISO	3.27	1.181	0.500	0.470	20	5	0.0341
70417	78417	M20	TMSC 1/2x.470 N 2.00 ISO	3.27	1.181	0.500	0.470	15	5	0.0455
70419	78419	M24	TMSC 5/8x.620 N 3.00 ISO	3.62	1.417	0.625	0.620	12	6	0.0682
70421	78421	M36	TMSC 5/8x.620 N 4.00 ISO	3.62	1.575	0.625	0.620	10	6	0.0909
70423	78423	M64	TMSC 3/4x.745 N 6.00 ISO	4.09	1.417	0.750	0.745	6	6	0.1364

M External

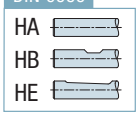
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70500	78500	All M3	TMSC 1/4x.240 E 0.50 ISO	2.24	0.591	0.250	0.240	30	5	0.0121
70508	78508	All M3	TMSC 5/16x.310 E 0.50 ISO	2.48	0.787	0.312	0.310	40	5	0.0121
70509	78509	All M4	TMSC 5/16x.310 E 0.70 ISO	2.48	0.772	0.312	0.310	28	5	0.0171
70501	78501	All M4.5	TMSC 5/16x.310 E 0.75 ISO	2.48	0.768	0.312	0.310	26	5	0.0182
70510	78510	All M5	TMSC 5/16x.310 E 0.80 ISO	2.48	0.787	0.312	0.310	25	5	0.0194
70502	78502	All M6	TMSC 3/8x.370 E 1.00 ISO	2.83	0.945	0.375	0.370	24	5	0.0242
70511	78511	All M8	TMSC 3/8x.370 E 1.25 ISO	2.83	0.984	0.375	0.370	20	5	0.0303
70503	78503	All M10	TMSC 1/2x.470 E 1.50 ISO	3.27	1.181	0.500	0.470	20	5	0.0363
70512	78512	All M12	TMSC 1/2x.470 E 1.75 ISO	3.27	1.171	0.500	0.470	17	5	0.0424
70504	78504	All M14	TMSC 1/2x.470 E 2.00 ISO	3.27	1.181	0.500	0.470	15	5	0.0484
70505	78505	All M24	TMSC 5/8x.620 E 3.00 ISO	3.62	1.417	0.625	0.620	12	6	0.0726
70506	78506	All M36	TMSC 5/8x.620 E 4.00 ISO	3.62	1.575	0.625	0.620	10	6	0.0968
70507	78507	All M64	TMSC 3/4x.745 E 6.00 ISO	4.09	1.417	0.750	0.745	6	6	0.1453

ISO 60° Metric

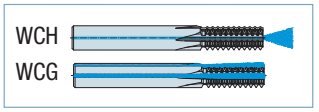
DIN 13, DIN 68, DINISO 965-1, NFISO 965-1



DIN 6535



With optional coolant hole from 1/4" and larger



T2 2xØ Straight flute

M Internal

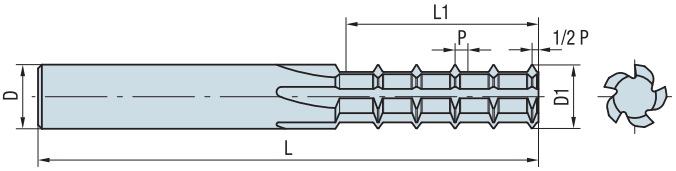
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70850	78850	M4	TMSC 1/8x.105 N 0.70 ISO-T2	1.50	0.315	0.125	0.105	-	3	0.0159
70859	78859	M8	TMSC 1/4x.240 N 0.75 ISO-T2	2.44	0.630	0.250	0.240	-	5	0.0170
70851	78851	M5	TMSC 3/16x.145 N 0.80 ISO-T2	1.65	0.394	0.187	0.145		3	0.0180
70852	78852	M6	TMSC 3/16x.160 N 1.00 ISO-T2	2.24	0.472	0.187	0.160	-	3	0.0227
70853	78853	M8	TMSC 1/4x.200 N 1.25 ISO-T2	2.44	0.630	0.250	0.200	-	3	0.0284
70854	78854	M10	TMSC 1/4x.240 N 1.50 ISO-T2	2.44	0.787	0.250	0.240	-	5	0.0341
70855	78855	M12	TMSC 5/16x.310 N 1.75 ISO-T2	2.90	0.945	0.312	0.310	-	5	0.0398
70856	78856	M14	TMSC 3/8x.370 N 2.00 ISO-T2	3.35	1.102	0.375	0.370	-	5	0.0455
70857	78857	M16	TMSC 1/2x.437 N 2.00 ISO-T2	3.74	1.260	0.500	0.437	-	5	0.0455
70864	78864	M18	TMSC 1/2x.470 N 2.00 ISO-T2	3.74	1.260	0.500	0.470		5	0.0455
70858	78858	M20	TMSC 1/2x.470 N 2.50 ISO-T2	3.74	1.575	0.500	0.470	-	5	0.0568
70865	78865	M24	TMSC 5/8x.620 N 3.00 ISO-T2	4.10	1.890	0.625	0.620		6	0.0682

MF Internal fine pitch

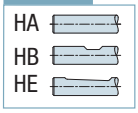
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70859	78859	M8	TMSC 1/4x.240 N 0.75 ISO-T2	2.44	0.630	0.250	0.240	-	5	0.0170
70860	78860	M12	TMSC 5/16x.310 N 1.00 ISO-T2	2.90	0.945	0.312	0.310	-	5	0.0227
70861	78861	M16	TMSC 1/2x.470 N 1.00 ISO-T2	3.74	1.260	0.500	0.470	-	5	0.0227
70862	78862	M14	TMSC 3/8x.370 N 1.50 ISO-T2	3.35	1.102	0.375	0.370	-	5	0.0341
70863	78863	M16	TMSC 1/2x.470 N 1.50 ISO-T2	3.74	1.417	0.500	0.470	-	5	0.0341
70864	78864	M18	TMSC 1/2x.470 N 2.00 ISO-T2	3.74	1.260	0.500	0.470	-	5	0.0455

ISO 60° Metric

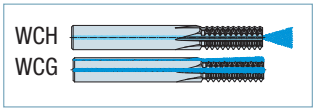
DIN 13, DIN 68, DINISO 965-1, NFISO 965-1



DIN 6535



Available with coolant hole since Ø 6 mm



T3 3xØ Straight flute

M Internal

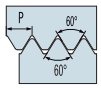
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70950	78950	M4	TMSC 1/8x.105 N 0.70 ISO-T3	1.65	0.472	0.125	0.105	-	3	0.0159
70951	78951	M5	TMSC 3/16x.145 N 0.80 ISO-T3	1.85	0.591	0.187	0.145	-	3	0.0180
70952	78952	M6	TMSC 3/16x.160 N 1.00 ISO-T3	2.36	0.709	0.187	0.160	-	3	0.0227
70953	78953	M8	TMSC 1/4x.200 N 1.25 ISO-T3	2.56	0.944	0.250	0.200	-	3	0.0284
70954	78954	M10	TMSC 1/4x.240 N 1.50 ISO-T3	2.83	1.181	0.250	0.240	-	5	0.0341
70955	78955	M12	TMSC 5/16x.310 N 1.75 ISO-T3	3.38	1.417	0.312	0.310	-	5	0.0398
70956	78956	M14	TMSC 3/8x.370 N 2.00 ISO-T3	3.74	1.654	0.375	0.370	-	5	0.0455
70957	78957	M16	TMSC 1/2x.437 N 2.00 ISO-T3	4.50	1.890	0.500	0.437	-	5	0.0455
70958	78958	M20	TMSC 1/2x.470 N 2.50 ISO-T3	4.50	2.362	0.500	0.470	-	5	0.0568
70965	78965	M24	TMSC 5/8x.620 N 3.00 ISO-T3	4.50	2.216	0.625	0.620	-	5	0.0682

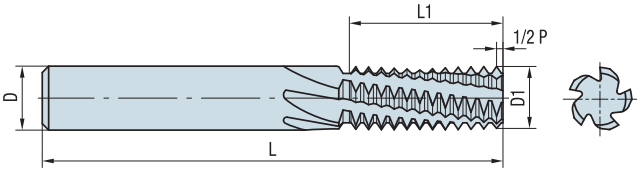
MF Internal fine pitch

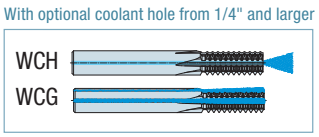
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70959	78959	M8	TMSC 1/4x.240 N 0.75 ISO-T3	2.95	0.945	0.250	0.240	-	5	0.0170
70960	78960	M12	TMSC 5/16x.310 N 1.00 ISO-T3	3.35	1.417	0.312	0.310	-	5	0.0227
70961	78961	M16	TMSC 1/2x.470 N 1.00 ISO-T3	4.50	1.889	0.500	0.470	-	5	0.0227
70962	78962	M14	TMSC 3/8x.370 N 1.50 ISO-T3	3.74	1.654	0.375	0.370	-	5	0.0341
70963	78963	M18	TMSC 1/2x.470 N 1.50 ISO-T3	4.50	2.126	0.500	0.470	-	5	0.0341
70957	78957	M16	TMSC 1/2x.437 N 2.00 ISO-T3	4.50	1.890	0.500	0.437	-	5	0.0455
70964	78964	M18	TMSC 1/2x.470 N 2.00 ISO-T3	4.50	1.890	0.500	0.470	-	5	0.0455

ISO 60° Metric

DIN 13, DIN 68, DINISO 965-1, NFISO 965-1





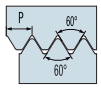


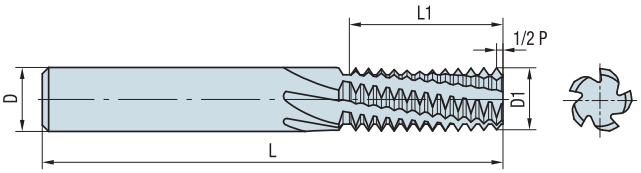
1.5xØ Helical flute

EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
M Internal										
X8100	X8200	M1.6	TMHE 1/8x.040 N 0.35 ISO	1.50	0.096	0.125	0.040	7	3	0.0080
X8101	X8201	M2	TMHE 1/8x.050 N 0.40 ISO	1.50	0.126	0.125	0.050	8	3	0.0091
X8102	X8202	M2.5	TMHE 1/8x.060 N 0.45 ISO	1.50	0.142	0.125	0.060	8	3	0.0102
X8103	X8203	M3	TMHE 1/8x.085 N 0.50 ISO	1.50	0.177	0.125	0.085	9	3	0.0114
X8104	X8204	M3.5	TMHE 1/8x.105 N 0.60 ISO	1.50	0.213	0.125	0.105	9	3	0.0136
X8105	X8205	M4	TMHE 1/8x.105 N 0.70 ISO	1.50	0.248	0.125	0.105	9	3	0.0159
X8106	X8206	M4.5	TMHE 1/8x.120 N 0.75 ISO	1.65	0.266	0.125	0.120	9	3	0.0170
X8107	X8207	M5	TMHE 3/16x.145 N 0.80 ISO	1.65	0.315	0.187	0.145	10	3	0.0180
X8108	X8208	M6	TMHE 3/16x.160 N 1.00 ISO	2.24	0.354	0.187	0.160	9	3	0.0227
X8109	X8209	M8	TMHE 1/4x.200 N 1.25 ISO	2.24	0.492	0.250	0.200	10	3	0.0284
X8110	X8210	M10	TMHE 1/4x.240 N 1.50 ISO	2.24	0.591	0.250	0.240	10	5	0.0341
X8111	X8211	M12	TMHE 5/16x.310 N 1.75 ISO	2.48	0.758	0.312	0.310	11	5	0.0398
X8112	X8212	M16	TMHE 3/8x.370 N 2.00 ISO	2.83	0.945	0.375	0.370	12	5	0.0455
X8113	X8213	M20	TMHE 1/2x.470 N 2.50 ISO	3.27	1.181	0.500	0.470	12	5	0.0568
X8114	X8214	M24	TMHE 5/8x.620 N 3.00 ISO	4.33	1.417	0.625	0.620	12	6	0.0682
X8115	X8215	M30	TMHE 5/8x.620 N 3.50 ISO	4.33	1.516	0.625	0.620	11	6	0.0795
X8116	X8216	M36	TMHE 5/8x.620 N 4.00 ISO	4.33	1.575	0.625	0.620	10	6	0.0909
X8117	X8217	M48	TMHE 3/4x.745 N 5.00 ISO	4.33	1.575	0.750	0.745	8	6	0.1136
X8118	X8218	M64	TMHE 3/4x.745 N 6.00 ISO	4.33	1.417	0.750	0.745	6	6	0.1364
MF Internal fine pitch										
X8119	X8219	M10	TMHE 1/4x.240 N 0.50 ISO	2.24	0.591	0.250	0.240	30	5	0.0114
X8120	X8220	M10	TMHE 1/4x.240 N 0.75 ISO	2.24	0.591	0.250	0.240	20	5	0.0170
X8121	X8221	M12	TMHE 5/16x.310 N 0.50 ISO	2.48	0.591	0.312	0.310	30	5	0.0114
X8122	X8222	M12	TMHE 5/16x.310 N 1.00 ISO	2.48	0.787	0.312	0.310	20	5	0.0227
X8123	X8223	M16	TMHE 3/8x.370 N 1.50 ISO	2.83	0.945	0.375	0.370	16	5	0.0341
X8124	X8224	M18	TMHE 1/2x.470 N 1.50 ISO	3.27	1.181	0.500	0.470	20	5	0.0341
X8125	X8225	M20	TMHE 1/2x.470 N 2.00 ISO	3.27	1.181	0.500	0.470	15	5	0.0455
X8126	X8226	M24	TMHE 5/8x.620 N 3.00 ISO	4.33	1.417	0.625	0.620	12	6	0.0682
X8127	X8227	M36	TMHE 5/8x.620 N 4.00 ISO	4.33	1.575	0.625	0.620	10	6	0.0909
X8128	X8228	M64	TMHE 3/4x.745 N 6.00 ISO	4.33	1.417	0.750	0.745	6	6	0.1364
M External										
X8300	X8400	M3	TMHE 1/4x.240 E 0.50 ISO	2.24	0.591	0.250	0.240	30	5	0.0121
X8301	X8401	M3	TMHE 5/16x.310 E 0.50 ISO	2.48	0.787	0.312	0.310	40	5	0.0121
X8302	X8402	M4	TMHE 5/16x.310 E 0.70 ISO	2.48	0.772	0.312	0.310	28	5	0.0169
X8303	X8403	M4.5	TMHE 5/16x.310 E 0.75 ISO	2.48	0.768	0.312	0.310	26	5	0.0180
X8304	X8404	M5	TMHE 5/16x.310 E 0.80 ISO	2.48	0.787	0.312	0.310	25	5	0.0194
X8305	X8405	M6	TMHE 3/8x.370 E 1.00 ISO	2.83	0.945	0.375	0.370	24	5	0.0242
X8306	X8406	M8	TMHE 3/8x.370 E 1.25 ISO	2.83	0.984	0.375	0.370	20	5	0.0303
X8307	X8407	M10	TMHE 1/2x.470 E 1.50 ISO	3.27	1.181	0.500	0.470	20	5	0.0363
X8308	X8408	M12	TMHE 1/2x.470 E 1.75 ISO	3.27	1.171	0.500	0.470	17	5	0.0424
X8309	X8409	M14	TMHE 1/2x.470 E 2.00 ISO	3.27	1.181	0.500	0.470	15	5	0.0484
X8310	X8410	M24	TMHE 5/8x.620 E 3.00 ISO	4.33	1.417	0.625	0.620	12	6	0.0726
X8311	X8411	M36	TMHE 5/8x.620 E 4.00 ISO	4.33	1.575	0.625	0.620	10	6	0.0968
X8312	X8412	M64	TMHE 3/4x.745 E 6.00 ISO	4.33	1.417	0.750	0.745	6	6	0.1453

ISO 60° Metric

DIN 13, DIN 68, DIN ISO 965-1, NF ISO 965-1





DIN 6535

With optional coolant hole from 1/4" and larger

M

2xØ Helical flute

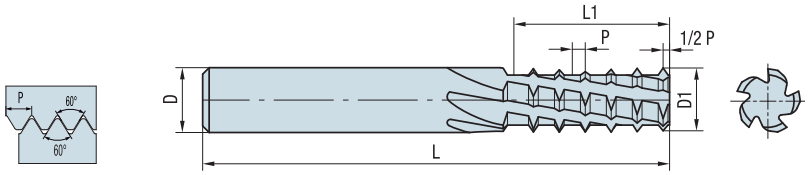
M Internal

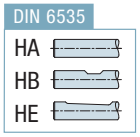
EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
X8500	X8600	M1.6	TMHE 1/8x.045 N 0.35 ISO-2	1.50	0.138	0.125	0.045	10	3	0.0080
X8501	X8601	M2	TMHE 1/8x.060 N 0.40 ISO-2	1.50	0.157	0.125	0.060	10	3	0.0091
X8502	X8602	M2.5	TMHE 1/8x.070 N 0.45 ISO-2	1.50	0.213	0.125	0.070	12	3	0.0102
X8503	X8603	M3	TMHE 1/8x.085 N 0.50 ISO-2	1.50	0.236	0.125	0.085	12	3	0.0114
X8504	X8604	M3.5	TMHE 1/8x.100 N 0.60 ISO-2	1.50	0.283	0.125	0.100	12	3	0.0136
X8505	X8605	M4	TMHE 1/8x.120 N 0.70 ISO-2	1.65	0.331	0.125	0.120	12	3	0.0159
X8506	X8606	M4.5	TMHE 3/16x.130 N 0.75 ISO-2	1.65	0.354	0.187	0.130	12	3	0.0170
X8507	X8607	M5	TMHE 3/16x.150 N 0.80 ISO-2	1.65	0.409	0.187	0.150	13	3	0.0180
X8508	X8608	* M6	TMHE 1/4x.185 N 1.00 ISO-2	2.24	0.472	0.250	0.185	12	3	0.0227
X8509	X8609	* M8	TMHE 1/4x.240 N 1.25 ISO-2	2.44	0.640	0.250	0.240	13	5	0.0284
X8510	X8610	* M10	TMHE 5/16x.310 N 1.50 ISO-2	2.91	0.827	0.312	0.310	14	5	0.0341
X8511	X8611	* M12	TMHE 3/8x.340 N 1.75 ISO-2	2.83	0.965	0.375	0.340	14	5	0.0398
X8512	X8612	* M14	TMHE 3/8x.370 N 2.00 ISO-2	3.39	1.102	0.375	0.370	14	5	0.0455
X8513	X8613	* M16	TMHE 1/2x.470 N 2.00 ISO-2	3.74	1.260	0.500	0.470	16	5	0.0455
X8514	X8614	* M20	TMHE 5/8x.590 N 2.50 ISO-2	4.33	1.575	0.625	0.590	16	6	0.0568
X8515	X8615	* M24	TMHE 5/8x.620 N 3.00 ISO-2	4.72	1.890	0.625	0.620	16	6	0.0682
X8516	X8616	* M30	TMHE 3/4x.745 N 3.50 ISO-2	5.12	2.480	0.750	0.745	18	6	0.0796

* With Coolant Hole

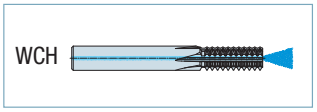
ISO 60° Metric

DIN 13, DIN 68, DIN ISO 965-1, NF ISO 965-1





With optional coolant hole from 1/4" and larger



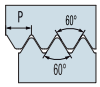
T2 2.5xØ Helical flute

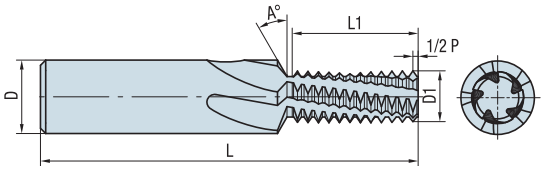
M Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
X8530	X8630	M1.6	TMHE 1/8x.045 N 0.35 ISO-25	1.65	0.165	0.125	0.045	10	3	0.0080
X8531	X8631	M2	TMHE 1/8x.060 N 0.40 ISO-25	1.65	0.220	0.125	0.060	10	3	0.0091
X8532	X8632	M2.5	TMHE 1/8x.070 N 0.45 ISO-25	1.65	0.248	0.125	0.070	12	3	0.0102
X8533	X8633	M3	TMHE 1/8x.085 N 0.50 ISO-25	1.65	0.315	0.125	0.085	12	3	0.0114
X8534	X8634	M3.5	TMHE 1/8x.100 N 0.60 ISO-25	1.65	0.378	0.125	0.100	12	3	0.0136
X8535	X8635	M4	TMHE 1/8x.120 N 0.70 ISO-25	1.85	0.441	0.125	0.120	12	3	0.0159
X8536	X8636	M4.5	TMHE 3/16x.130 N 0.75 ISO-25	1.85	0.472	0.187	0.130	12	3	0.0170
X8537	X8637	M5	TMHE 3/16x.150 N 0.80 ISO-25	1.85	0.504	0.187	0.150	13	3	0.0180
X8538	X8638	* M6	TMHE 1/4x.185 N 1.00 ISO-25	2.44	0.630	0.250	0.185	12	3	0.0227
X8539	X8639	* M8	TMHE 1/4x.240 N 1.25 ISO-25	2.44	0.787	0.250	0.240	13	5	0.0284
X8540	X8640	* M10	TMHE 5/16x.310 N 1.50 ISO-25	3.39	1.063	0.312	0.310	14	5	0.0341
X8541	X8641	* M12	TMHE 3/8x.340 N 1.75 ISO-25	3.74	1.240	0.370	0.340	14	5	0.0398
X8542	X8642	* M14	TMHE 3/8x.370 N 2.00 ISO-25	3.74	1.417	0.375	0.370	14	5	0.0455
X8543	X8643	* M16	TMHE 1/2x.470 N 2.00 ISO-25	3.74	1.575	0.500	0.470	16	5	0.0455
X8544	X8644	* M20	TMHE 5/8x.590 N 2.50 ISO-25	4.72	1.969	0.625	0.590	16	6	0.0568
X8545	X8645	* M24	TMHE 5/8x.620 N 3.00 ISO-25	4.72	2.362	0.625	0.620	16	6	0.0682
X8546	X8646	* M30	TMHE 3/4x.745 N 3.50 ISO-25	5.51	3.031	0.750	0.745	18	6	0.0796

ISO 60° Metric

DIN 13, DIN 68, DIN ISO 965-1, NF ISO 965-1





DIN 6535

With optional coolant hole from 1/4" and larger

2xØ + A60° Helical flute

M

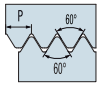
M Internal

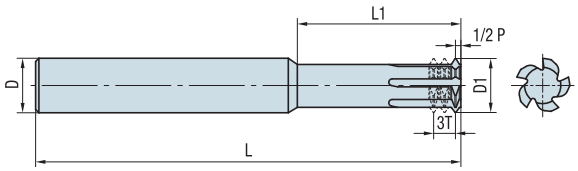
EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
X8550	X8650	M1.6	TMHE 3/16x.045 N 0.35 ISO-2A	1.65	0.138	0.187	0.045	10	3	0.0080
X8551	X8651	M2	TMHE 3/16x.060 N 0.40 ISO-2A	1.65	0.157	0.187	0.060	10	3	0.0091
X8552	X8652	M2.5	TMHE 3/16x.070 N 0.45 ISO-2A	1.65	0.213	0.187	0.070	12	3	0.0102
X8553	X8653	M3	TMHE 3/16x.085 N 0.50 ISO-2A	1.65	0.236	0.187	0.085	12	3	0.0114
X8554	X8654	M3.5	TMHE 3/16x.100 N 0.60 ISO-2A	1.65	0.283	0.187	0.100	12	3	0.0136
X8555	X8655	M4	TMHE 1/4x.120 N 0.70 ISO-2A	2.24	0.331	0.250	0.120	12	3	0.0159
X8556	X8656	M4.5	TMHE 1/4x.130 N 0.75 ISO-2A	2.24	0.354	0.250	0.130	12	3	0.0170
X8557	X8657	M5	TMHE 1/4x.150 N 0.80 ISO-2A	2.24	0.409	0.250	0.150	13	3	0.0180
X8558	X8658	* M6	TMHE 5/16x.185 N 1.00 ISO-2A	2.48	0.472	0.312	0.185	12	3	0.0227
X8559	X8659	* M8	TMHE 3/8x.240 N 1.25 ISO-2A	2.83	0.640	0.375	0.240	13	5	0.0284
X8560	X8660	* M10	TMHE 1/2x.310 N 1.50 ISO-2A	3.27	0.827	0.500	0.310	14	5	0.0341
X8561	X8661	* M12	TMHE 5/8x.340 N 1.75 ISO-2A	4.33	0.965	0.625	0.340	14	5	0.0398
X8562	X8662	* M14	TMHE 5/8x.390 N 2.00 ISO-2A	4.33	1.102	0.625	0.390	14	5	0.0455
X8563	X8663	* M16	TMHE 5/8x.470 N 2.00 ISO-2A	4.33	1.260	0.625	0.470	16	5	0.0455
X8564	X8664	* M20	TMHE 3/4x.590 N 2.50 ISO-2A	5.12	1.575	0.750	0.590	16	6	0.0568
X8565	X8665	* M24	TMHE 3/4x.625 N 3.00 ISO-2A	5.12	1.890	0.750	0.625	16	6	0.0682
X8566	X8666	* M30	TMHE 1/1x.785 N 3.50 ISO-2A	5.12	2.480	1.000	0.785	18	6	0.0796

* With Coolant Hole

ISO 60° Metric

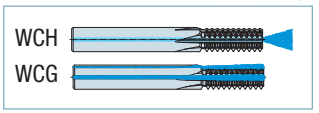
DIN 13, DIN 68, DIN ISO 965-1, NF ISO 965-1





DIN 6535

With optional coolant hole from 1/4" and larger



Whirling tool 2xØ

Straight flute

M Internal

EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
42100	46100	M1	TBR 1/8x.030 N 0.25 ISO	1.50	0.079	0.125	0.030	-	3	0.0057
42101	46101	M1.4	TBR 1/8x.040 N 0.30 ISO	1.50	0.110	0.125	0.040	-	3	0.0068
42102	46102	M1.6	TBR 1/8x.045 N 0.35 ISO 2T	1.50	0.126	0.125	0.045	-	3	0.0080
42103	46103	M2	TBR 1/8x.060 N 0.40 ISO 3T	1.50	0.157	0.125	0.060	-	3	0.0091
42104	46104	M2.5	TBR 1/8x.070 N 0.45 ISO 3T	1.50	0.197	0.125	0.070	-	3	0.0102
42105	46105	M3	TBR 1/8x.085 N 0.50 ISO 3T	1.50	0.236	0.125	0.085	-	3	0.0114
42106	46106	M3.5	TBR 1/8x.100 N 0.60 ISO 3T	1.50	0.276	0.125	0.100	-	3	0.0136
42107	46107	M4	TBR 1/8x.120 N 0.70 ISO 3T	1.65	0.315	0.125	0.120	-	3	0.0159
42108	46108	M4.5	TBR 3/16x.130 N 0.75 ISO 3T	1.65	0.354	0.187	0.130	-	3	0.0170
42109	46109	M5	TBR 1/4x.150 N 0.80 ISO 3T	2.24	0.394	0.250	0.150	-	3	0.0180
42110	46110	M6	TBR 1/4x.185 N 1.00 ISO 3T	2.24	0.472	0.250	0.185	-	3	0.0227
42111	46111	M8	TBR 1/4x.240 N 1.25 ISO 3T	2.44	0.630	0.250	0.240	-	5	0.0284
42112	46112	M10	TBR 5/16x.310 N 1.50 ISO 3T	2.91	0.787	0.312	0.310	-	5	0.0341

Whirling tool 3xØ

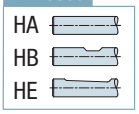
M Internal

EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
42200	46200	M1	TBRL 1/8x.030 N 0.25 ISO	1.50	0.118	0.125	0.030	-	3	0.0057
42201	46201	M1.4	TBRL 1/8x.040 N 0.30 ISO	1.50	0.165	0.125	0.040	-	3	0.0068
42202	46202	M1.6	TBRL 1/8x.045 N 0.35 ISO 2T	1.50	0.189	0.125	0.045	-	3	0.0080
42203	46203	M2	TBRL 1/8x.060 N 0.40 ISO 3T	1.50	0.236	0.125	0.060	-	3	0.0091
42204	46204	M2.5	TBRL 1/8x.070 N 0.45 ISO 3T	1.50	0.295	0.125	0.070	-	3	0.0102
42205	46205	M3	TBRL 1/8x.085 N 0.50 ISO 3T	1.65	0.354	0.125	0.085	-	3	0.0114
42206	46206	M3.5	TBRL 1/8x.100 N 0.60 ISO 3T	1.65	0.413	0.125	0.100	-	3	0.0136
42207	46207	M4	TBRL 1/8x.120 N 0.70 ISO 3T	1.85	0.472	0.125	0.120	-	3	0.0159
42208	46208	M4.5	TBRL 3/16x.130 N 0.75 ISO 3T	1.85	0.531	0.187	0.130	-	3	0.0170
42209	46209	M5	TBRL 1/4x.150 N 0.80 ISO 3T	2.24	0.591	0.250	0.150	-	3	0.0180
42210	46210	M6	TBRL 1/4x.185 N 1.00 ISO 3T	2.44	0.709	0.250	0.185	-	3	0.0227
42211	46211	M8	TBRL 1/4x.240 N 1.25 ISO 3T	2.56	0.945	0.250	0.240	-	5	0.0284
42212	46212	M10	TBRL 5/16x.310 N 1.50 ISO 3T	3.39	1.181	0.312	0.310	-	5	0.0341

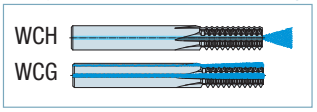
Aerospace thread Inch

DINISO 3161

DIN 6535



With optional coolant hole from 1/4" and larger



UNJ

1.5xØ Straight flute

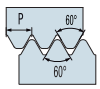
UNJ, UNJC, UNJEF Internal

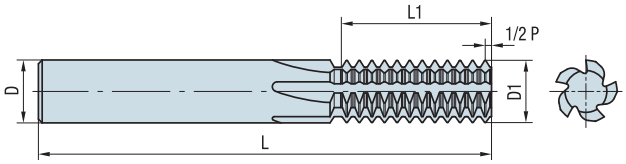
EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
43500	44500	N°5	TMSC 1/8x.085 N 44''UNJ	1.50	0.182	0.125	0.085	8	3	0.0121
43501	44501	N°4-N°6	TMSC 1/8x.060 N 40''UNJ	1.50	0.175	0.125	0.060	7	3	0.0133
43502	44502	N°8	TMSC 1/8x.120 N 36''UNJ	1.65	0.278	0.125	0.120	10	3	0.0148
43503	44503	N°6 - 1/4"	TMSC 1/8x.105 N 32''UNJ	1.50	0.177	0.125	0.105	9	3	0.0167
43504	44504	5/16" - 3/8"	TMSC 1/4x.240 N 32''UNJ	2.24	0.594	0.250	0.240	19	5	0.0167
43505	44505	N°12 - 1/4"	TMSC 1/4x.165 N 28''UNJ	2.24	0.393	0.250	0.165	11	3	0.0191
43506	44506	7/16" - 1/2"	TMSC 5/16x.310 N 28''UNJ	2.48	0.714	0.312	0.310	20	5	0.0191
43507	44507	N°10 - N°12	TMSC 1/8x.120 N 24''UNJ	1.65	0.333	0.125	0.120	8	3	0.0222
43508	44508	5/16" - 3/8"	TMSC 1/4x.240 N 24''UNJ	2.24	0.583	0.250	0.240	14	5	0.0222
43509	44509	9/16" - 11/16"	TMSC 3/8x.370 N 24''UNJ	2.83	1.042	0.375	0.370	25	5	0.0222
43510	44510	1/4"	TMSC 1/4x.165 N 20''UNJ	2.24	0.350	0.250	0.165	7	3	0.0267
43511	44511	7/16" - 1/2"	TMSC 5/16x.310 N 20''UNJ	2.48	0.750	0.312	0.310	15	5	0.0263
43512	44512	3/4" - 1"	TMSC 5/8x.620 N 20''UNJ	3.62	1.500	0.625	0.620	30	6	0.0263
43513	44513	5/16"	TMSC 1/4x.240 N 18''UNJ	2.24	0.500	0.250	0.240	9	5	0.0296
43514	44514	9/16" - 5/8"	TMSC 3/8x.370 N 18''UNJ	2.83	0.944	0.375	0.370	17	5	0.0296
43515	44515	11/16" - 1 11/16"	TMSC 3/4x.745 N 18''UNJ	4.09	1.556	0.750	0.745	28	6	0.0296
43516	44516	3/8" - 7/16"	TMSC 1/4x.240 N 16''UNJ	2.24	0.625	0.250	0.240	10	5	0.0333
43517	44517	1/2" - 9/16"	TMSC 5/16x.310 N 16''UNJ	2.48	0.813	0.312	0.310	13	5	0.0333
43518	44518	5/8" - 13/16"	TMSC 1/2x.470 N 16''UNJ	3.27	1.187	0.500	0.470	19	5	0.0333
43519	44519	7/8" - 1"	TMSC 5/8x.620 N 16''UNJ	3.62	1.500	0.625	0.620	24	6	0.0333
43520	44520	1 1/16" - 2 /2"	TMSC 3/4x.745 N 16''UNJ	4.09	1.563	0.750	0.745	25	6	0.0333
43521	44521	7/16"	TMSC 5/16x.310 N 14''UNJ	2.48	0.714	0.312	0.310	10	5	0.0381
43522	44522	7/8"	TMSC 5/8x.620 N 14''UNJ	3.62	1.357	0.625	0.620	19	6	0.0381
43523	44523	1/2"	TMSC 5/16x.310 N 13''UNJ	2.48	0.769	0.312	0.310	10	5	0.0410
43524	44524	9/16"	TMSC 3/8x.370 N 12''UNJ	2.83	0.917	0.375	0.370	11	5	0.0444
43525	44525	5/8" - 13/16"	TMSC 1/2x.470 N 12''UNJ	3.27	1.167	0.500	0.470	14	5	0.0444
43526	44526	7/8" - 1"	TMSC 5/8x.620 N 12''UNJ	3.62	1.500	0.625	0.620	18	6	0.0444
43527	44527	1 1/16" - 2 1/2"	TMSC 3/4x.745 N 12''UNJ	4.09	1.583	0.750	0.745	19	6	0.0444
43528	44528	5/8"	TMSC 1/2x.470 N 11''UNJ	3.27	1.000	0.500	0.470	11	5	0.0485
43529	44529	3/4"	TMSC 1/2x.470 N 10''UNJ	3.27	1.200	0.500	0.470	12	5	0.0533

Available with helical flutes

Aerospace thread Inch

DIN ISO 3161





DIN 6535

With optional coolant hole from 1/4" and larger

1.5xØ Straight flute

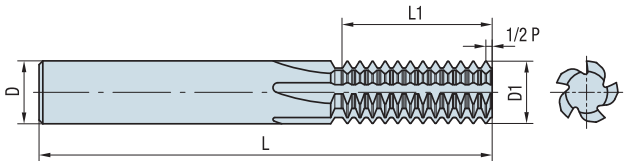
UNJ, UNJC, UNJEF External

EDP number K20C	EDP number K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
71010	78010	All N°5	TMSC 1/4x.240 E 44''UNJ	2.24	0.591	0.250	0.240	26	5	0.0138
71011	78011	All N°4 - N°6	TMSC 1/4x.240 E 40''UNJ	2.24	0.575	0.250	0.240	23	5	0.0154
71012	78012	All N°8	TMSC 5/16x.310 E 36''UNJ	2.48	0.778	0.312	0.310	28	5	0.0171
71000	71800	ALL 32"	TMSC 1/4x.240 E 32” UNJ	2.25	0.531	0.250	0.240	17	5	0.0192
71013	78013	All N°6 - 1/4"	TMSC 5/16x.310 E 32''UNJ	2.48	0.781	0.312	0.310	25	5	0.0192
71014	78014	All 5/16" - 3/8"	TMSC 3/8x.370 E 32''UNJ	2.83	0.937	0.375	0.370	30	5	0.0192
71015	78015	All N°12 - 1/2"	TMSC 3/8x.370 E 28''UNJ	2.83	0.929	0.375	0.370	26	5	0.0220
71016	78016	All N°10 - N°12	TMSC 5/16x.310 E 24''UNJ	2.48	0.750	0.312	0.310	18	5	0.0256
71001	71801	ALL 24"	TMSC 3/8x.370 E 24” UNJ	2.84	0.958	.375	.370	23	5	0.0256
71017	78017	All 5/16" - 11/16"	TMSC 1/2x.470 E 24''UNJ	3.27	1.167	0.500	0.470	28	5	0.0256
71002	71802	All 1/4"	TMSC 3/8x.370 E 20''UNJ	2.83	0.950	0.375	0.370	19	5	0.0307
71018	78018	All 7/16" - 1/2"	TMSC 1/2x.470 E 20''UNJ	3.27	1.150	0.500	0.470	23	5	0.0307
71019	78019	All 3/4" - 1"	TMSC 5/8x.620 E 20''UNJ	3.62	1.550	0.625	0.620	31	6	0.0307
71003	71803	ALL 18”	TMSC 5/16x.310 E 18” UNJ	2.48	0.778	0.312	0.310	14	5	0.0342
71004	71804	All 5/16" - 5/8"	TMSC 1/2x.470 E 18''UNJ	3.27	1.111	0.500	0.470	21	5	0.0342
71020	78020	All 11/16" - 1 11/16"	TMSC 5/8x.620 E 18''UNJ	3.62	1.556	0.625	0.620	28	6	0.0342
71005	71805	ALL 16”	TMSC 5/16x.310 E 16” UNJ	2.48	1.000	0.312	0.310	16	5	0.0384
71006	71806	All 3/8" - 9/16"	TMSC 1/2x.470 E 16''UNJ	3.27	1.124	0.500	0.470	18	5	0.0384
71021	78021	All 5/8" - 1"	TMSC 5/8x.620 E 16''UNJ	3.62	1.437	0.625	0.620	23	6	0.0384
71022	78022	All 11/16" - 2 1/2"	TMSC 3/4x.745 E 16''UNJ	4.09	1.563	0.750	0.745	25	6	0.0384
71007	71807	All 7/16" - 7/8"	TMSC 1/2x.470 E 14''UNJ	3.27	1.143	0.500	0.470	16	5	0.0439
71023	78023	All 1/2"	TMSC 1/2x.470 E 13''UNJ	3.27	1.154	0.500	0.470	15	5	0.0473
71008	71808	All 9/16" - 1"	TMSC 1/2x.470 E 12''UNJ	3.27	1.167	0.500	0.470	14	5	0.0512
71024	78024	All 11/16" - 2 1/2"	TMSC 3/4x.745 E 12''UNJ	4.09	1.583	0.750	0.745	19	6	0.0512
71025	78025	All 5/8"	TMSC 1/2x.470 E 11''UNJ	3.27	1.091	0.500	0.470	12	5	0.0559
71026	78026	All 3/4"	TMSC 1/2x.470 E 10''UNJ	3.27	1.200	0.500	0.470	12	5	0.0615

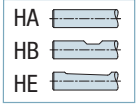
Available with helical flutes

Aerospace thread Metric

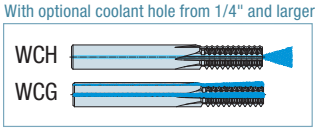
DIN ISO 5855-1



DIN 6535



With optional coolant hole from 1/4" and larger



MJ

1.5xØ Straight flute

MJ Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
43100	44100	MJ 1.6	TMSC 1/8x.040 N 0.35 MJ	1.50	0.096	0.125	0.040	7	3	0.0073
43101	44101	MJ 2	TMSC 1/8x.050 N 0.40 MJ	1.50	0.126	0.125	0.050	8	3	0.0084
43102	44102	MJ 2.5	TMSC 1/8x.060 N 0.45 MJ	1.50	0.142	0.125	0.060	8	3	0.0094
43103	44103	MJ 3	TMSC 1/8x.085 N 0.50 MJ	1.50	0.177	0.125	0.085	9	3	0.0105
43104	44104	MJ 3.5	TMSC 1/8x.105 N 0.60 MJ	1.50	0.213	0.125	0.105	9	3	0.0126
43105	44105	MJ 4	TMSC 1/8x.120 N 0.70 MJ	1.65	0.248	0.125	0.120	9	3	0.0147
43106	44106	MJ 5	TMSC 3/16x.140 N 0.80 MJ	1.65	0.315	0.187	0.140	10	3	0.0168
43107	44107	MJ 6 - MJ 7	TMSC 1/4x.155 N 1.00 MJ	2.24	0.354	0.250	0.155	9	3	0.0210
43108	44108	MJ 8	TMSC 1/4x.195 N 1.00 MJ	2.24	0.472	0.250	0.195	12	3	0.0210
43109	44109	MJ 10 - MJ 12	TMSC 1/4x.230 N 1.25 MJ	2.24	0.591	0.250	0.230	12	5	0.0262
43110	44110	MJ 14	TMSC 5/16x.310 N 1.50 MJ	2.48	0.768	0.312	0.310	13	5	0.0315
43111	44111	MJ 16 - MJ 18	TMSC 3/8x.370 N 1.50 MJ	2.83	0.945	0.375	0.370	16	5	0.0315
43112	44112	MJ 20 - MJ 22	TMSC 1/2x.470 N 1.50 MJ	3.27	1.181	0.500	0.470	20	5	0.0315
43113	44113	MJ 24 - MJ 39	TMSC 5/8x.620 N 2.00 MJ	3.62	1.575	0.625	0.620	20	6	0.0451

Available with helical flutes

1.5xØ Straight flute

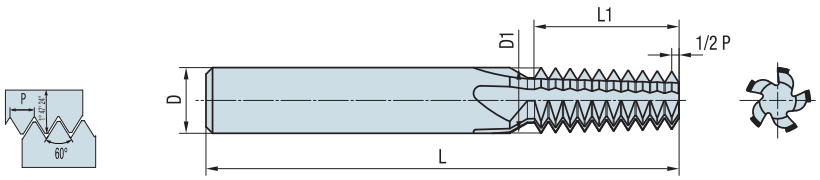
MJ External

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
43200	44200	MJ 1.6	TMSC 3/16x.140 E 0.35 MJ	1.65	0.303	0.187	0.140	22	3	0.0085
43201	44201	MJ 2	TMSC 3/16x.140 E 0.40 MJ	1.65	0.315	0.187	0.140	20	3	0.0097
43202	44202	MJ 2.5	TMSC 3/16x.140 E 0.45 MJ	1.65	0.319	0.187	0.140	18	3	0.0109
43203	44203	MJ 3	TMSC 1/4x.240 E 0.50 MJ	2.24	0.591	0.250	0.240	30	5	0.0121
43204	44204	MJ 3.5	TMSC 5/16x.310 E 0.60 MJ	2.48	0.756	0.312	0.310	32	5	0.0145
43205	44205	MJ 4	TMSC 5/16x.310 E 0.70 MJ	2.48	0.772	0.312	0.310	28	5	0.0169
43206	44206	MJ 5	TMSC 5/16x.310 E 0.80 MJ	2.48	0.787	0.312	0.310	25	5	0.0194
43207	44207	MJ 6 - MJ 8	TMSC 3/8x.370 E 1.00 MJ	2.83	0.945	0.375	0.370	24	5	0.0242
43208	44208	MJ 10 - MJ 12	TMSC 1/2x.470 E 1.25 MJ	3.27	1.181	0.500	0.470	24	5	0.0303
43209	44209	MJ 14 - MJ 22	TMSC 1/2x.470 E 1.50 MJ	3.27	1.181	0.500	0.470	20	5	0.0363
43210	44210	MJ 24 - MJ 39	TMSC 5/8x.620 E 2.00 MJ	3.62	1.575	0.625	0.620	20	6	0.0484

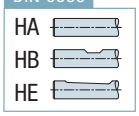
Available with helical flutes

National Pipe Taper 60° Inch

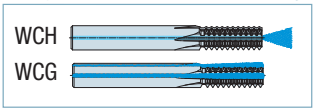
NF E29-684, ANSI/ASME B1.20.1



DIN 6535



With optional coolant hole from 1/4" and larger



Straight flute

NPT Internal/external

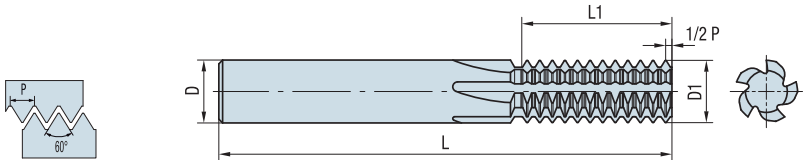
EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70300	78300	1/16" - 1/8"	TMSC 1/4x.240 NE 27''NPT	2.25	0.370	0.250	0.240	10	5	0.0281
70301	78301	1/4" - 3/8"	TMSC 5/16x.310 NE 18''NPT	2.48	0.556	0.312	0.310	10	5	0.0422
70302	78302	1/2" - 3/4"	TMSC 1/2x.470 NE 14''NPT	3.27	0.786	0.500	0.470	11	5	0.0543
70303	78303	1" - 2"	TMSC 5/8x.620 NE 11.5''NPT	3.62	1.044	0.625	0.620	12	6	0.0661
70304	78304	2 1/2" - 6"	TMSC 5/8x.620 NE 8''NPT	3.62	1.250	0.625	0.620	10	6	0.0950
70305	78305	2 1/2" - 6"	TMSC 3/4x.745 NE 8''NPT	4.10	1.500	0.750	0.745	12	6	0.0950
70350	78350	1" - 2" API	TMSC 5/8x.620 NE 11.5"NPT	3.62	1.217	0.625	0.620	14	6	0.0661

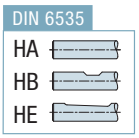
NPTF (Dryseal Pipe Thread) Internal/external

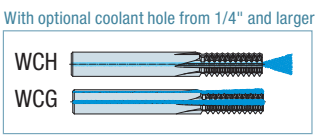
EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70306	78306	1/16" - 1/8"	TMSC 1/4x.240 NE 27''NPTF	2.25	0.370	0.250	0.240	10	5	0.0281
70307	78307	1/4" - 3/8"	TMSC 5/16x.310 NE 18''NPTF	2.48	0.556	0.312	0.310	10	5	0.0422
70308	78308	1/2" - 3/4"	TMSC 1/2x.470 NE 14''NPTF	3.27	0.786	0.500	0.470	11	5	0.0543
70309	78309	1" - 2"	TMSC 5/8x.620 NE 11.5''NPTF	3.62	1.044	0.625	0.620	12	6	0.0661
70310	78310	2 1/2" - 6"	TMSC 5/8x.620 NE 8''NPTF	3.62	1.250	0.625	0.620	10	6	0.0950
70311	78311	2 1/2" - 6"	TMSC 3/4x.745 NE 8''NPTF	4.10	1.500	0.750	0.745	12	6	0.0950

Straight Pipe Mechanical / Straight Pipe Inch

ANSI/ASME B1.20.1







Straight flute

NPSM (Straight Pipe Mechanical) Internal

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70318	78318	1/16" - 1/8"	TMSC 1/4x.240 N 27''NPSM	2.25	0.593	0.250	0.240	16	5	0.0200
70319	78319	1/4" - 3/8"	TMSC 5/16x.310 N 18''NPSM	2.48	0.722	0.312	0.310	13	5	0.0301
70320	78320	1/2" - 3/4"	TMSC 1/2x.470 N 14''NPSM	3.27	1.143	0.500	0.470	16	5	0.0387
70321	78321	1" - 2"	TMSC 5/8x.620 N 11.5''NPSM	3.62	1.391	0.625	0.620	16	6	0.0470
70322	78322	2 ½"-6"	TMSC 5/8x.620 N 8''NPSM	3.62	1.250	0.625	0.620	10	6	0.0677
70323	78323	2 ½"-6"	TMSC 3/4x.745 N 8''NPSM	4.10	1.500	0.750	0.745	12	6	0.0677

NPSM (Straight Pipe Mechanical) External

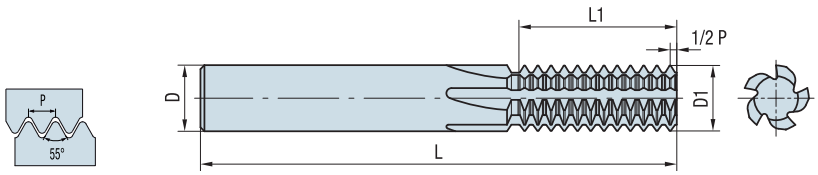
EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70360	78360	1/16" - 1/8"	TMSC 5/16x.310 E 27''NPSM	2.48	0.741	0.312	0.310	20	5	0.0244
70361	78361	1/4" - 3/8"	TMSC 3/8x.370 E 18''NPSM	2.84	0.944	0.375	0.370	17	5	0.0361
70362	78362	1/2" - 3/4"	TMSC 5/8x.620 E 14''NPSM	3.62	1.357	0.625	0.620	19	6	0.0464
70363	78363	1" - 2"	TMSC 5/8x.620 E 11.5''NPSM	3.62	1.478	0.625	0.620	17	6	0.0565
70364	78364	2 ½"-6"	TMSC 3/4x.745 E 8''NPSM	4.10	1.500	0.750	0.745	12	6	0.0812

NPSF (Dryseal Pipe Thread) Internal/External

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70312	78312	1/16"-1/8"	TMSC 1/4x.240 NE 27 NPSF	2.25	0.593	0.250	.240	10	5	0.0244
70313	78313	1/4" – 3/8"	TMSC 5/16x.310 NE 18 NPSF	2.48	0.667	0.312	0.310	10	5	0.0361
70314	78314	1/2"-3/4"	TMSC 1/2x.470 NE 14 NPSF	3.27	0.786	0.500	0.470	11	5	0.0464
70315	78315	1"-2"	TMSC 5/8x.620 NE 11.5 NPSF	3.62	1.391	0.625	0.620	12	6	0.0565
70316	78316	2 ½"-6"	TMSC 5/8x.620 NE 8 NPSF	3.62	1.250	0.625	0.620	10	6	0.0812
70317	78317	2 ½"-6"	TMSC 3/4x.745 NE 8 NPSF	4.10	1.500	0.750	0.745	12	6	0.0812

British Straight Whitworth Inch

DIN 6630, NF E 03-005



DIN 6535

HA
HB
HE

With optional coolant hole from 1/4" and larger

WCH
WCG

Straight flute

W (BSW) Internal/External

BSW

Norm	Reference	L	L1	D	D1	NF	Z	H
3/32"	TMSC 1/8x.060 NE 48''BSW	1.50	0.146	0.125	0.060	7	3	0.0133
1/8"	TMSC 1/8x.085 NE 40''BSW	1.50	0.175	0.125	0.085	7	3	0.0160
5/32"	TMSC 1/8x.105 NE 32''BSW	1.50	0.219	0.125	0.105	7	3	0.0200
1/4"	TMSC 1/4x.165 NE 20''BSW	2.24	0.400	0.250	0.165	8	3	0.0320
5/16"	TMSC 1/4x.200 NE 18''BSW	2.24	0.444	0.250	0.200	8	3	0.0356
3/8"	TMSC 1/4x.240 NE 16''BSW	2.24	0.562	0.250	0.240	9	5	0.0400
7/16"	TMSC 5/16x.310 NE 14''BSW	2.48	0.714	0.312	0.310	10	5	0.0457
1/2"	TMSC 5/16x.310 NE 12''BSW	2.48	0.750	0.312	0.310	9	5	0.0533
5/8"	TMSC 3/8x.370 NE 11''BSW	2.83	0.909	0.375	0.370	10	5	0.0582
3/4"	TMSC 1/2x.470 NE 10''BSW	3.27	1.100	0.500	0.470	11	5	0.0640
7/8"	TMSC 1/2x.470 NE 9''BSW	3.27	1.111	0.500	0.470	10	5	0.0711
1"	TMSC 5/8x.620 NE 8''BSW	3.62	1.375	0.625	0.620	11	6	0.0800
1 1/8"-1 1/4"	TMSC 5/8x.620 NE 7''BSW	3.62	1.429	0.625	0.620	10	6	0.0915
1 3/8"-1 1/2"	TMSC 5/8x.620 NE 6''BSW	3.62	1.500	0.625	0.620	9	6	0.1067
1 5/8"-1 3/4"	TMSC 3/4x.745 NE 5''BSW	4.09	1.600	0.750	0.745	8	6	0.1280
1 7/8"-2"	TMSC 3/4x.745 NE 5''BSW	4.09	1.556	0.750	0.745	7	6	0.1423

Available with helical flute

British Straight Pipe

DIN ISO 228-1, DIN 259

Straight flute

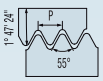
BSP, G, Rp, BSF Internal/External

BSP

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70324	78324	R 1/16" & R 1/8"	TMSC 1/4x.240 NE 28''BSP	2.25	0.571	0.250	0.240	16	5	0.0229
70325	78325	R 1/4" & R 3/8"	TMSC 5/16x.310 NE 19''BSP	2.48	0.737	0.312	0.310	14	5	0.0337
70326	78326	R 1/2" & R 3/4"	TMSC 1/2x.470 NE 14''BSP	3.27	1.143	0.500	0.470	16	5	0.0457
70327	78327	R 1" thru R 2"	TMSC 5/8x.620 NE 11''BSP	3.62	1.364	0.625	0.620	15	6	0.0582

British Pipe Taper

DIN ISO 7-1, DIN 3858, NF E 03-004



Straight flute

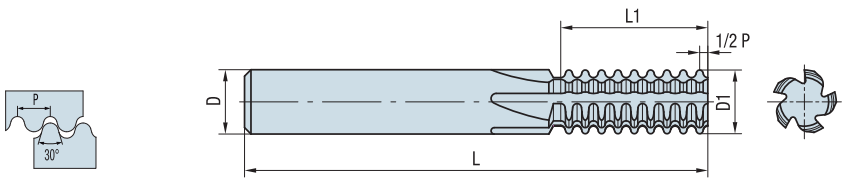
BSPT, R Internal/External

BSPT

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
70328	78328	1/16" - 1/8"	TMSC 1/4x.240 NE 28''BSPT	2.25	0.393	0.250	0.240	11	5	0.0229
70329	78329	1/4" - 3/8"	TMSC 5/16x.310 NE 19''BSPT	2.48	0.579	0.312	0.310	11	5	0.0337
70330	78330	1/2" - 3/4"	TMSC 1/2x.470 NE 14''BSPT	3.27	0.786	0.500	0.470	11	5	0.0457
70331	78331	1" - 2"	TMSC 5/8x.620 NE 11''BSPT	3.62	1.545	0.625	0.620	17	6	0.0582

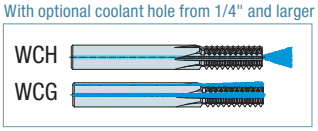
Knuckle thread Inch

DIN 405



DIN 6535

With optional coolant hole from 1/4" and larger



RD

Straight flute

RD Internal

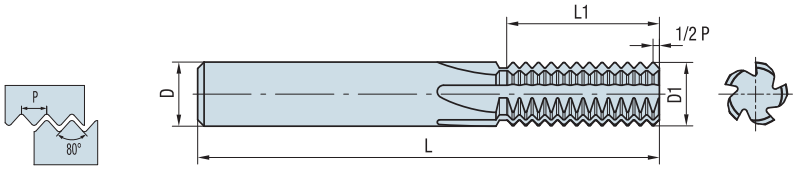
Norm	Reference	L	L1	D	D1	NF	Z	H
RD 8 - RD 10	TMSC 1/4x.240 N 10''RD	2.24	0.600	0.250	0.240	6	5	0.0500
RD 11 - RD 12	TMSC 5/16x.310 N 10''RD	2.48	0.800	0.312	0.310	8	5	0.0500
RD 14 - RD 16	TMSC 3/8x.370 N 8''RD	2.83	1.000	0.375	0.370	8	5	0.0625
RD 18 - RD 22	TMSC 1/2x.470 N 8''RD	3.27	1.125	0.500	0.470	9	5	0.0625
RD 24 - RD 38	TMSC 5/8x.620 N 8''RD	3.62	1.500	0.625	0.620	12	6	0.0625
RD 40 - RD 65	TMSC 3/4x.745 N 6''RD	4.09	1.500	0.750	0.745	9	6	0.1667

RD External

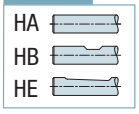
Norm	Reference	L	L1	D	D1	NF	Z	H
RD 8 - RD 10	TMSC 3/8x.240 E 10''RD	2.24	0.600	0.375	0.240	6	5	0.0500
RD 11 - RD 12	TMSC 1/2x.310 E 10''RD	2.48	0.800	0.500	0.310	8	5	0.0500
RD 14 - RD 16	TMSC 1/2x.390 E 8''RD	2.83	1.000	0.500	0.390	8	5	0.0625
RD 18 - RD 22	TMSC 5/8x.470 E 8''RD	3.27	1.125	0.625	0.470	9	5	0.0625
RD 24 - RD 38	TMSC 3/4x.745 E 8''RD	3.62	1.500	0.750	0.745	12	6	0.0833
RD 40 - RD 65	TMSC 3/4x.745 E 6''RD	4.09	1.500	0.750	0.745	9	6	0.1667

Electric tube thread Inch

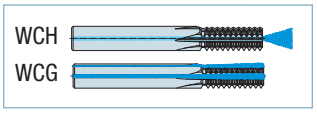
DIN 40430



DIN 6535



With optional coolant hole from 1/4" and larger



PG

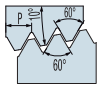
Straight flute

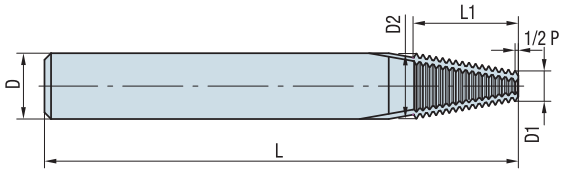
PG Internal/external

EDP number										
K20C	K27C	Norm	Reference	L	L1	D	D1	NF	Z	H
71226	75226	7	TMSC 5/16x.310 NE 20''PG	2.48	0.750	0.312	0.310	15	5	0.0240
71227	75227	9-11-13.5-16	TMSC 3/8x.370 NE 18''PG	2.83	0.944	0.375	0.370	17	5	0.0264
71228	75228	21-29-36-42-48	TMSC 1/2x.470 NE 16''PG	3.27	1.125	0.500	0.470	18	5	0.0299

Medical Implant Metric

DIN 405





DIN 6535

HA

HB

HE

Straight flute

CSP 10° Internal

EDP number										
K20C	K27C	Reference	L	L1	D	D1	D2	NF	Z	H
CSP701	CSP781	TMSC 03026 N 0.30 CSP	1.50	0.118	0.118	0.063	0.106	10	3	0.007
CSP702	CSP782	TMSC 03026 N 0.35 CSP	1.50	0.152	0.118	0.053	0.106	11	3	0.008
CSP703	CSP783	TMSC 03024 N 0.375 CSP	1.50	0.177	0.118	0.054	0.111	12	3	0.008
CSP704	CSP784	TMSC 03026 N 0.40 CSP	1.50	0.157	0.118	0.049	0.104	10	3	0.009
CSP705	CSP785	TMSC 06059 N 0.40 CSP	2.24	0.394	0.236	0.106	0.231	25	3	0.009
CSP706	CSP786	TMSC 06059 N 0.45 CSP	2.24	0.195	0.236	0.160	0.228	11	3	0.010
CSP707	CSP787	TMSC 06059 N 0.50 CSP	2.24	0.315	0.236	0.122	0.226	16	3	0.012
CSP708	CSP788	TMSC 06059 N 0.55 CSP	2.24	0.217	0.236	0.152	0.228	10	3	0.012
CSP709	CSP789	TMSC 06059 N 0.625 CSP	2.24	0.295	0.236	0.122	0.227	12	3	0.018

Available with 55° profile and various tapered angles

Listing

Reference

TM21 N 20" UN-S

TM
Insert type

L
Insert length

N
Internal

E
External

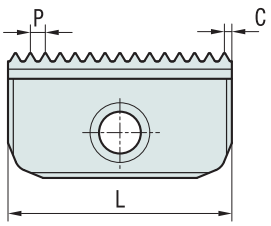
NE
Internal-external

Pitch
(thread per inch, mm)

Norm

S
Single side use only

SXP
Single side use only,
release on the other side

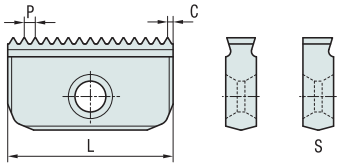


L Insert length
NF Number of pitches
C Centering
H Thread height

EDP number K20C	EDP number K27C	Pitch	Reference	L	NF	C	H	Tool holder
74100	76100	48	TM14 N 48"UN	0.551	26	0.005	0.012	TMH….-…-.-14

Unified National Standard Inch

DIN ISO 5864. ANSI/ASME B1.7

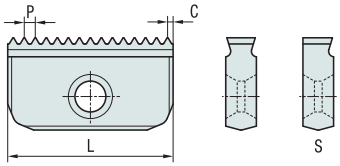


UN, UNC, UNS, UNF, UNEF Internal

EDP number								
K20C	K27C	Pitch	Reference	L	NF	C	H	Tool holder
74100	76100	48	TM14 N 48"UN	0.551	26	0.005	0.012	TMH....-...-.-14
74101	76101	40	TM14 N 40"UN	0.551	22	0.001	0.015	TMH....-...-.-14
74102	76102	32	TM14 N 32"UN	0.551	17	0.010	0.018	TMH....-...-.-14
74112	76112	32	TM21 N 32” UN	0.827	27	?	0.018	TMH....-...-.-21
74103	76103	28	TM14 N 28"UN	0.551	15	0.008	0.021	TMH....-...-.-14
74104	76104	27	TM14 N 27"UN	0.551	14	0.016	0.022	TMH....-...-.-14
74105	76105	24	TM14 N 24"UN	0.551	13	0.005	0.024	TMH....-...-.-14
74106	76106	20	TM14 N 20"UN	0.551	11	0.001	0.029	TMH....-...-.-14
74113	76113	20	TM21 N 20"UN	0.827	16	0.013	0.029	TMH....-...-.-21
74107	76107	18	TM14 N 18"UN	0.551	10	-0.002	0.033	TMH....-...-.-14
74114	76114	18	TM21 N 18"UN	0.827	14	0.024	0.033	TMH....-...-.-21
74120	76120	18	TM30 N 18"UN	1.181	21	0.007	0.033	TMH....-...-.-30
74129	76129	18	TM40 N 18"UN	1.575	28	0.010	0.033	TMH....-...-.-40
74108	76108	16	TM14 N 16"UN	0.551	8	0.026	0.037	TMH....-...-.-14
74115	76115	16	TM21 N 16"UN	0.827	13	0.007	0.037	TMH....-...-.-21
74121	76121	16	TM30 N 16"UN	1.181	18	0.028	0.037	TMH....-...-.-30
74130	76130	16	TM40 N 16"UN	1.575	25	0.006	0.037	TMH....-...-.-40
74109	76109	14	TM14 N 14"UN	0.551	8	-0.010	0.042	TMH....-...-.-14
74116	76116	14	TM21 N 14"UN	0.827	11	0.021	0.042	TMH....-...-.-21
74122	76122	14	TM30 N 14"UN	1.181	16	0.019	0.042	TMH....-...-.-30
74140	76140	14	TM40 N 14"UN	1.575	22	0.002	0.042	TMH....-...-.-40
74110	76110	12	TM14 N 12"UN	0.551	6	0.026	0.049	TMH....-...-.-14
74117	76117	12	TM21 N 12"UN	0.827	10	-0.003	0.049	TMH....-...-.-21
74123	76123	12	TM30 N 12"UN	1.181	14	0.007	0.049	TMH....-...-.-30
74131	76131	12	TM40 N 12"UN	1.575	18	0.037	0.049	TMH....-...-.-40
74118	76118	10	TM21 N 10"UN	0.827	8	0.013	0.059	TMH....-...-.-21
74124	76124	10	TM30 N 10"UN	1.181	11	0.041	0.059	TMH....-...-.-30
74132	76132	10	TM40 N 10"UN	1.575	14	0.087	0.059	TMH....-...-.-40
74140	76140	9	TM21 N 9"UN	0.827	7	0.024	0.065	TMH....-...-.-21
74150	76150	9	TM30 N 9"UN	1.181	10	0.035	0.065	TMH....-...-.-30
74151	76151	9	TM40 N 9"UN	1.575	14	0.010	0.065	TMH....-...-.-40
74119	76119	8	TM21 N 8"UN-S	0.827	6	0.038	0.073	TMH....-...-.-21
74125	76125	8	TM30 N 8"UN	1.181	9	0.028	0.073	TMH....-...-.-30
74133	76133	8	TM40 N 8"UN	1.575	12	0.037	0.073	TMH....-...-.-40
74111	76111	7	TM21 N 7” UN	0.827	6	?	0.084	TMH....-...-.-21
74126	76126	7	TM30 N 7"UN	1.181	8	0.019	0.084	TMH....-...-.-30
74134	76134	7	TM40 N 7"UN	1.575	11	0.002	0.084	TMH....-...-.-40
74127	76127	6	TM30 N 6"UN-S	1.181	7	0.007	0.098	TMH....-...-.-30
74135	76135	6	TM40 N 6"UN	1.575	9	0.037	0.098	TMH....-...-.-40
74128	76128	5	TM30 N 5"UN-S	1.181	6	-0.009	0.117	TMH....-...-.-30
74136	76136	5	TM40 N 5"UN	1.575	8	-0.013	0.117	TMH....-...-.-40
74137	76137	4.5	TM40 N 4.5"UN	1.575	7	0.010	0.130	TMH....-...-.-40
74138	76138	4	TM40 N 4"UN-S	1.575	6	0.037	0.147	TMH....-...-.-40
74152	76152	3.5	TM40 N 3.5"UN-S	1.575	5	0.073	0.168	TMH....-...-.-40
74139	76139	3	TM40 N 3” UN-S	1.575	5	?	0.192	TMH....-...-.-40

Unified National Standard Inch

DIN ISO 5864. ANSI/ASME B1.7

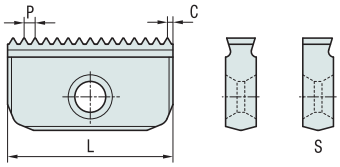


UN, UNC, UNS, UNF, UNEF External

EDP number								
K20C	K27C	Pitch	Reference	L	NF	C	H	Tool holder
74200	76200	48	TM14 E 48"UN	0.551	26	0.005	0.014	TMH....-...-.-14
74201	76201	40	TM14 E 40"UN	0.551	22	0.001	0.016	TMH....-...-.-14
74202	76202	32	TM14 E 32"UN	0.551	17	0.010	0.020	TMH....-...-.-14
74203	76203	28	TM14 E 28"UN	0.551	15	0.008	0.023	TMH....-...-.-14
74204	76204	27	TM14 E 27"UN	0.551	14	0.016	0.024	TMH....-...-.-14
74205	76205	24	TM14 E 24"UN	0.551	13	0.005	0.027	TMH....-...-.-14
74206	76206	20	TM14 E 20"UN	0.551	11	0.001	0.032	TMH....-...-.-14
74217	76217	20	TM21 E 20"UN	0.827	16	0.013	0.032	TMH....-...-.-21
74208	76208	18	TM14 E 18"UN	0.551	10	-0.002	0.036	TMH....-...-.-14
74219	76219	18	TM21 E 18"UN	0.827	14	0.024	0.036	TMH....-...-.-21
74232	76232	18	TM30 E 18"UN	1.181	21	0.007	0.036	TMH....-...-.-30
74247	76247	18	TM40 E 18"UN	1.575	28	0.010	0.036	TMH....-...-.-40
74210	76210	16	TM14 E 16"UN	0.551	8	0.026	0.041	TMH....-...-.-14
74221	76221	16	TM21 E 16"UN	0.827	13	0.007	0.041	TMH....-...-.-21
74234	76234	16	TM30 E 16"UN	1.181	18	0.028	0.041	TMH....-...-.-30
74248	76248	16	TM40 E 16"UN	1.575	25	0.006	0.041	TMH....-...-.-40
74212	76212	14	TM14 E 14"UN	0.551	8	-0.010	0.046	TMH....-...-.-14
74223	76223	14	TM21 E 14"UN	0.827	11	0.021	0.046	TMH....-...-.-21
74236	76236	14	TM30 E 14"UN	1.181	16	0.019	0.046	TMH....-...-.-30
74249	76249	14	TM40 E 14"UN	1.575	22	0.002	0.046	TMH....-...-.-40
74214	76214	12	TM14 E 12"UN	0.551	6	0.026	0.054	TMH....-...-.-14
74225	76225	12	TM21 E 12"UN	0.827	9	-0.003	0.054	TMH....-...-.-21
74238	76238	12	TM30 E 12"UN	1.181	14	0.007	0.054	TMH....-...-.-30
74250	76250	12	TM40 E 12"UN	1.575	18	0.037	0.054	TMH....-...-.-40
74227	76227	10	TM21 E 10"UN	0.827	8	0.013	0.065	TMH....-...-.-21
74240	76240	10	TM30 E 10"UN	1.181	11	0.041	0.065	TMH....-...-.-30
74251	76251	10	TM40 E 10"UN	1.575	14	0.087	0.065	TMH....-...-.-40
74229	76229	9	TM21 E 9"UN	0.827	7	0.024	0.072	TMH....-...-.-21
74520	76520	9	TM30 E 9"UN	1.181	10	0.035	0.072	TMH....-...-.-30
74521	76521	9	TM40 E 9"UN	1.575	14	0.010	0.072	TMH....-...-.-40
74230	76230	8	TM21 E 8"UN-S	0.827	6	0.038	0.081	TMH....-...-.-21
74242	76242	8	TM30 E 8"UN	1.181	9	0.028	0.081	TMH....-...-.-30
74252	76252	8	TM40 E 8"UN	1.575	12	0.037	0.081	TMH....-...-.-40
74244	76244	7	TM30 E 7"UN	1.181	8	0.019	0.093	TMH....-...-.-30
74253	76253	7	TM40 E 7"UN	1.575	11	0.002	0.093	TMH....-...-.-40
74245	76245	6	TM30 E 6"UN-S	1.181	7	0.007	0.108	TMH....-...-.-30
74254	76254	6	TM40 E 6"UN	1.575	9	0.037	0.108	TMH....-...-.-40
74246	76246	5	TM30 E 5"UN-S	1.181	6	-0.009	0.130	TMH....-...-.-30
74255	76255	5	TM40 E 5"UN	1.575	8	-0.013	0.130	TMH....-...-.-40
74256	76256	4.5	TM40 E 4.5"UN	1.575	7	0.010	0.144	TMH....-...-.-40
74257	76257	4	TM40 E 4"UN-S	1.575	6	0.037	0.162	TMH....-...-.-40
74259	76259	3.5	TM40 E 3.5"UN-S	1.575	5	0.073	0.186	TMH....-...-.-40
74258	76258	3	TM40 E 3” UN-S	1.575	4	?	0.205	TMH....-...-.-40

ISO 60° Metric

DIN 13, DIN 68, DIN ISO 965-1, NF ISO 965-1

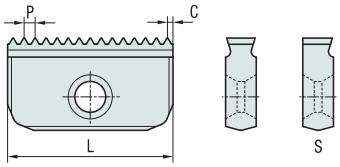


M Internal

EDP number								
K20C	K27C	Pitch	Reference	L	NF	C	H	Tool holder
74394	76394	0.50	TM14 N 0.50 ISO	0.551	28	0.000	0.012	TMH....-...-.-14
74395	76395	0.60	TM14 N 0.60 ISO	0.551	23	0.004	0.014	TMH....-...-.-14
74396	76396	0.70	TM14 N 0.70 ISO	0.551	20	0.000	0.016	TMH....-...-.-14
74397	76397	0.75	TM14 N 0.75 ISO	0.551	18	0.010	0.017	TMH....-...-.-14
74398	76398	0.80	TM14 N 0.80 ISO	0.551	17	0.008	0.019	TMH....-...-.-14
74399	76399	0.80	TM21 N 0.80 ISO	0.827	26	0.004	0.019	TMH....-...-.-21
74400	76400	1.00	TM14 N 1.00 ISO	0.551	14	0.000	0.023	TMH....-...-.-14
74403	76403	1.00	TM21 N 1.00 ISO	0.827	21	0.000	0.023	TMH....-...-.-21
74404	76404	1.25	TM14 N 1.25 ISO	0.551	11	0.005	0.029	TMH....-...-.-14
74405	76405	1.25	TM21 N 1.25 ISO	0.827	16	0.020	0.029	TMH....-...-.-21
74401	76401	1.50	TM14 N 1.50 ISO	0.551	9	0.010	0.035	TMH....-...-.-14
74405	76405	1.50	TM21 N 1.50 ISO	0.827	14	0.000	0.035	TMH....-...-.-21
74410	76410	1.50	TM30 N 1.50 ISO	1.181	20	0.000	0.035	TMH....-...-.-30
74405S	76405S	1.75	TM21 N 1.75 ISO	0.827	12	0.000	0.040	TMH....-...-.-30
74402	76402	2.00	TM14 N 2.00 ISO-S	0.551	7	0.000	0.046	TMH....-...-.-14
74406	76406	2.00	TM21 N 2.00 ISO	0.827	10	0.020	0.046	TMH....-...-.-21
74411	76411	2.00	TM30 N 2.00 ISO	1.181	15	0.000	0.046	TMH....-...-.-30
74407	76411	2.50	TM21 N 2.50 ISO	0.827	8	0.020	0.058	TMH....-...-.-21
74412	76412	2.50	TM30 N 2.50 ISO	1.181	12	0.000	0.058	TMH....-...-.-30
74408	76408	3.00	TM21 N 3.00 ISO	0.827	7	0.000	0.069	TMH....-...-.-21
74413	76413	3.00	TM30 N 3.00 ISO	1.181	10	0.000	0.069	TMH....-...-.-30
74409	76409	3.50	TM21 N 3.50 ISO-S	0.827	6	0.000	0.081	TMH....-...-.-21
74414	76414	3.50	TM30 N 3.50 ISO	1.181	8	0.039	0.081	TMH....-...-.-30
74415	76415	4.00	TM30 N 4.00 ISO-S	1.181	7	0.039	0.092	TMH....-...-.-30
74423	76423	4.00	TM40 N 4.00 ISO	1.575	10	0.000	0.092	TMH....-...-.-40
74416	76416	4.50	TM30 N 4.50 ISO-S	1.181	6	0.059	0.104	TMH....-...-.-30
74424	76424	4.50	TM40 N 4.50 ISO	1.575	8	0.079	0.104	TMH....-...-.-40
74417	76417	5.00	TM30 N 5.00 ISO-S	1.181	6	0.000	0.116	TMH....-...-.-30
74425	76425	5.00	TM40 N 5.00 ISO	1.575	8	0.079	0.116	TMH....-...-.-40
74418	76418	5.50	TM30 N 5.50 ISO-S	1.181	5	0.049	0.127	TMH....-...-.-30
74426	76426	5.50	TM40 N 5.50 ISO	1.575	7	0.030	0.127	TMH....-...-.-40
74427	76427	6.00	TM40 N 6.00 ISO	1.575	6	0.079	0.139	TMH....-...-.-40

ISO 60° Metric

DIN 13, DIN 68, DIN ISO 965-1, NF ISO 965-1

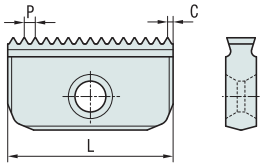


M External

EDP number								
K20C	K27C	Pitch	Reference	L	NF	C	H	Tool holder
74496	76496	0.50	TM14 E 0.50 ISO	0.551	28	0.000	0.012	TMH....-...-.-14
74497	76497	0.75	TM14 E 0.75 ISO	0.551	18	0.010	0.019	TMH....-...-.-14
74498	76498	0.80	TM14 E 0.80 ISO	0.551	17	0.008	0.020	TMH....-...-.-14
74499	76499	0.80	TM21 E 0.80 ISO	0.827	26	0.004	0.020	TMH....-...-.-21
74500	76500	1.00	TM14 E 1.00 ISO	0.551	14	0.000	0.025	TMH....-...-.-14
74503	76503	1.00	TM21 E 1.00 ISO	0.827	21	0.000	0.025	TMH....-...-.-21
74501	76501	1.50	TM14 E 1.50 ISO	0.551	9	0.010	0.037	TMH....-...-.-14
74504	76504	1.50	TM21 E 1.50 ISO	0.827	14	0.000	0.037	TMH....-...-.-21
74509	76509	1.50	TM30 E 1.50 ISO	1.181	20	0.000	0.037	TMH....-...-.-30
74502	76502	2.00	TM14 E 2.00 ISO	0.551	7	0.000	0.050	TMH....-...-.-14
74505	76505	2.00	TM21 E 2.00 ISO	0.827	10	0.020	0.050	TMH....-...-.-21
74510	76510	2.00	TM30 E 2.00 ISO	1.181	15	0.000	0.050	TMH....-...-.-30
74506	76506	2.50	TM21 E 2.50 ISO	0.827	8	0.020	0.062	TMH....-...-.-21
74511	76511	2.50	TM30 E 2.50 ISO	1.181	12	0.000	0.062	TMH....-...-.-30
74507	76507	3.00	TM21 E 3.00 ISO	0.827	7	0.000	0.075	TMH....-...-.-21
74512	76512	3.00	TM30 E 3.00 ISO	1.181	10	0.000	0.075	TMH....-...-.-30
74508	76508	3.50	TM21 E 3.50 ISO-S	0.827	6	0.000	0.087	TMH....-...-.-21
74513	76513	3.50	TM30 E 3.50 ISO	1.181	8	0.039	0.087	TMH....-...-.-30
74514	76514	4.00	TM30 E 4.00 ISO-S	1.181	7	0.039	0.100	TMH....-...-.-30
74515	76515	4.00	TM40 E 4.00 ISO	1.575	10	0.000	0.100	TMH....-...-.-40
74516	76516	5.00	TM40 E 5.00 ISO	1.575	8	0.000	0.125	TMH....-...-.-40
74517	76517	6.00	TM40 E 6.00 ISO	1.575	6	0.079	0.149	TMH....-...-.-40

Aerospace thread Inch

DINISO 3161

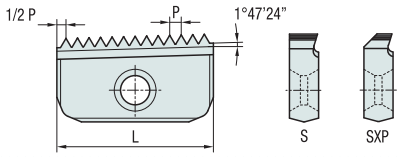


UNJ, UNJC, UNJEF External

EDP number K20C	EDP number K27C	Pitch	Reference	L	NF	C	H	Tool holder
74207	76207	20	TM14 E 20''UNJ	0.551	11	0.001	0.030	TMH....-...-.-14
74218	76218	20	TM21 E 20''UNJ	0.827	16	0.013	0.030	TMH....-...-.-21
74209	76209	18	TM14 E 18''UNJ	0.551	9	0.026	0.033	TMH....-...-.-14
74220	76220	18	TM21 E 18” UNJ	0.827	15	-0.080	0.033	TMH....-...-.-21
74211	76211	16	TM14 E 16''UNJ	0.551	8	0.026	0.037	TMH....-...-.-14
74222	76222	16	TM21 E 16''UNJ	0.827	13	0.007	0.037	TMH....-...-.-21
74235	76235	16	TM30 E 16''UNJ	1.181	18	0.028	0.037	TMH....-...-.-30
74213	76213	14	TM14 E 14''UNJ	0.551	7	0.026	0.042	TMH....-...-.-14
74224	76224	14	TM21 E 14''UNJ	0.827	11	0.021	0.042	TMH....-...-.-21
74237	76237	14	TM30 E 14” UNJ	1.181	16	0.486	0.042	TMH....-...-.-30
74216	76216	12	TM14 E 12''UNJ	0.551	6	0.026	0.049	TMH....-...-.-14
74226	76226	12	TM21 E 12''UNJ	0.827	9	0.038	0.049	TMH....-...-.-21
74239	76239	12	TM30 E 12''UNJ	1.181	14	0.007	0.049	TMH....-...-.-30
74228	76228	10	TM21 E 10” UNJ	0.827	8	0.340	0.059	TMH....-...-.-21
74241	76241	10	TM30 E 10''UNJ	1.181	11	0.041	0.059	TMH....-...-.-30
74231	76231	8	TM21 E 8''UNJ	0.827	6	0.038	0.074	TMH....-...-.-21

National Pipe Taper 60° Inch

NF E29-684, ANSI/ASME B1.20.1

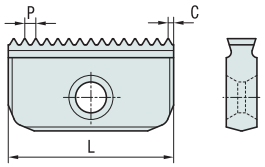


NPT Internal/external

EDP number K20C	EDP number K27C	Pitch	Reference	L	NF	C	H	Tool holder
74360	76360	18	TM14 NE 18"NPT-SXP	0.551	10	-0.002	0.041	TMH....-...-.-14T
74302	76302	18	TM21 NE 18"NPT-S	0.827	14	0.028	0.041	TMH....-...-.-21T
74361	76361	14	TM14 NE 14"NPT-SXP	0.551	7	0.026	0.054	TMH....-...-.-14T
74362	76362	14	TM21 NE 14"NPT-SXP	0.827	11	0.021	0.054	TMH....-...-.-21T
74304	76304	11.5	TM21 NE 11.5"NPT-S	0.827	9	0.022	0.066	TMH....-...-.-21
74305	76305	11.5	TM30 NE 11.5"NPT-S	1.181	13	0.043	0.066	TMH....-...-.-30
74307	76307	11.5	TM40 NE 11.5"NPT-S	1.575	18	0.005	0.066	TMH....-...-.-40
74306	76306	8	TM30 NE 8"NPT-S	1.181	9	0.028	0.096	TMH....-...-.-30
74308	76308	8	TM40 NE 8"NPT-S	1.575	12	0.037	0.096	TMH....-...-.-40
NPTF Internal/external								
74363	76363	18	TM14 NE 18"NPTF-SXP	0.551	10	-0.002	0.039	TMH....-...-.-14T
74311	76311	18	TM21 NE 18"NPTF-S	0.827	14	0.028	0.039	TMH....-...-.-21T
74364	76364	14	TM14 NE 14"NPTF-SXP	0.551	7	0.026	0.053	TMH....-...-.-14T
74365	76365	14	TM21 NE 14"NPTF-SXP	0.827	11	0.021	0.053	TMH....-...-.-21T
74313	76313	11.5	TM21 NE 11.5"NPTF-S	0.827	9	0.022	0.064	TMH....-...-.-21
74314	76314	11.5	TM30 NE 11.5"NPTF-S	1.181	13	0.043	0.064	TMH....-...-.-30
74316	76316	11.5	TM40 NE 11.5"NPTF-S	1.575	18	0.005	0.064	TMH....-...-.-40
74315	76315	8	TM30 NE 8"NPTF-S	1.181	9	0.028	0.094	TMH....-...-.-30
74317	76317	8	TM40 NE 8"NPTF-S	1.575	12	0.037	0.094	TMH....-...-.-40

Straight Pipe Mechanical Inch

ANSI/ASME B1.20.1



NPSM

NPSM Internal

EDP number K20C	EDP number K27C	Pitch	Reference	L	NF	C	H	Tool holder
74318	76318	18	TM14 N 18"NPSM	0.551	9	0.026	0.030	TMH....-...-.-14
74319	76319	14	TM14 N 14"NPSM	0.551	8	-0.010	0.039	TMH....-...-.-14
74321	76321	14	TM21 N 14"NPSM	0.827	11	0.021	0.039	TMH....-...-.-21
74322	76322	11.5	TM21 N 11.5"NPSM	0.827	9	0.022	0.047	TMH....-...-.-21
74323	76323	11.5	TM30 N 11.5"NPSM	1.181	13	0.025	0.047	TMH....-...-.-30
74324	76324	8	TM30 N 8"NPSM	1.181	9	0.028	0.068	TMH....-...-.-30

NPSM External

EDP number K20C	EDP number K27C	Pitch	Reference	L	NF	C	H	Tool holder
74325	76325	18	TM14 E 18"NPSM	0.551	9	0.026	0.033	TMH....-...-.-14
74327	76327	18	TM21 E 18" NPSM	0.827	14	0.622	0.033	TMH....-...-.-21
74326	76326	14	TM14 E 14"NPSM	0.551	8	-0.010	0.042	TMH....-...-.-14
74328	76328	14	TM21 E 14"NPSM	0.827	11	0.021	0.042	TMH....-...-.-21
74329	76329	11.5	TM21 E 11.5"NPSM	0.827	9	0.022	0.051	TMH....-...-.-21
74330	76330	11.5	TM30 E 11.5"NPSM	1.181	13	0.025	0.051	TMH....-...-.-30
74331	76331	8	TM30 E 8"NPSM	1.181	9	0.028	0.073	TMH....-...-.-30

Straight Pipe Inch

ANSI/ASME B1.20.1

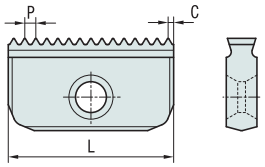
NPSF

NPSF-NPSI Internal/external

EDP number K20C	EDP number K27C	Pitch	Reference	L	NF	C	H	Tool holder
74332	76332	18	TM14 NE 18"NPSF	0.551	9	0.026	0.033	TMH....-...-.-14
74333	76333	14	TM14 NE 14"NPSF	0.551	8	-0.010	0.055	TMH....-...-.-14
74335	76335	14	TM21 NE 14"NPSF	0.827	11	0.021	0.055	TMH....-...-.-21
74336	76336	11.5	TM21 NE 11.5"NPSF	0.827	9	0.022	0.067	TMH....-...-.-21
74337	76337	11.5	TM30 NE 11.5"NPSF	1.181	13	0.025	0.067	TMH....-...-.-30
74338	76338	8	TM30 NE 8"NPSF	1.181	9	0.028	0.096	TMH....-...-.-30

British Staight Pipe Inch

DIN ISO 228-1



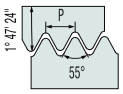
BSP, G, Rp, BSF Internal/external

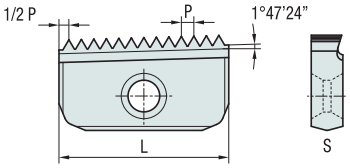
BSP

EDP number								
K20C	K27C	Pitch	Reference	L	NF	C	H	Tool holder
74341	76341	19	TM14 NE 19"BSP	0.551	10	0.012	0.034	TMH....-...-.-14
74342	76342	14	TM14 NE 14"BSP	0.551	7	0.026	0.046	TMH....-...-.-14
74344	76344	14	TM21 NE 14"BSP	0.827	11	0.021	0.046	TMH....-...-.-21
74347	76347	14	TM30 NE 14"BSP	1.181	16	0.019	0.046	TMH....-...-.-30
74343	76343	11	TM14 NE 11"BSP	0.551	6	0.004	0.058	TMH....-...- -14
74345	76345	11	TM21 NE 11"BSP	0.827	9	0.004	0.058	TMH....-...-.-21
74346	76346	11	TM30 NE 11"BSP	1.181	13	0.000	0.058	TMH....-...-.-30
74348	76348	11	TM40 NE 11"BSP	1.575	17	0.015	0.058	TMH....-...-.-40

British Pipe Taper Inch

DIN ISO 7-1, DIN 3858, NF E 03-004



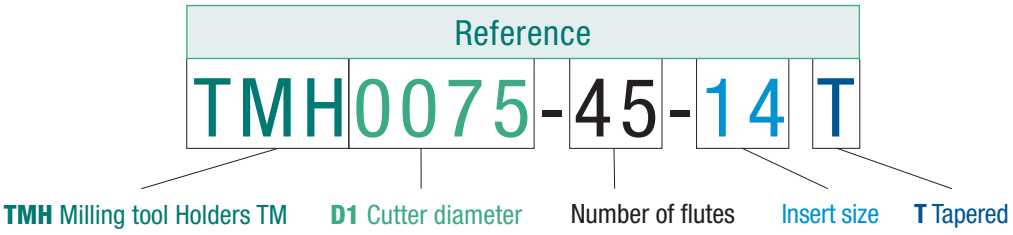


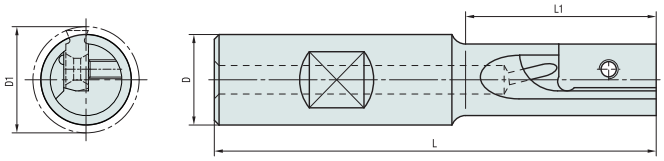
BSPT, R Internal/external

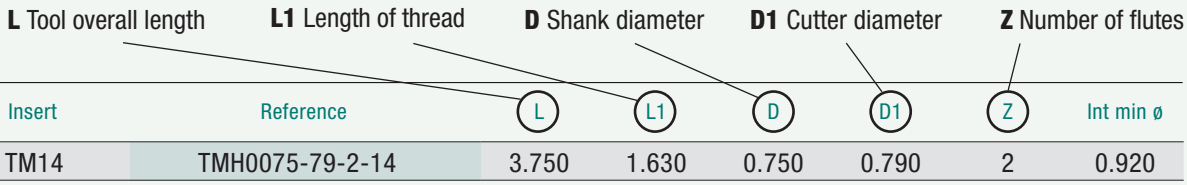
BSPT

EDP number								
K20C	K27C	Pitch	Reference	L	NF	C	H	Tool holder
74366	76366	19	TM14 NE 19"BSPT-S	0.551	10	0.012	0.034	TMH....-...-.-14
74349	76349	14	TM14 NE 14"BSPT-S	0.551	7	0.026	0.046	TMH....-...-.-14
74350	76350	14	TM21 NE 14"BSPT-S	0.827	11	0.036	0.046	TMH....-...-.-21
74600	76600	14	TM30 NE 14"BSPT-S	1.181	16	0.019	0.046	TMH....-...-.-30
74351	76351	11	TM21 NE 11"BSPT-S	0.827	9	0.045	0.058	TMH....-...-.-21
74352	76352	11	TM30 NE 11"BSPT-S	1.181	13	0.045	0.058	TMH....-...-.-30
74353	76353	11	TM40 NE 11"BSPT-S	1.575	17	0.015	0.058	TMH....-...-.-40

Listing

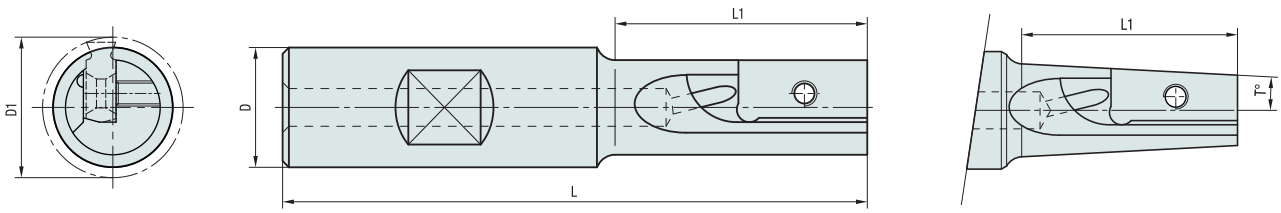






EDP number	Insert	Reference	L	L1	D	D1	Z	Int min ø
72103	TM14	TMH0075-79-2-14	3.750	1.630	0.750	0.790	2	0.920

Milling tool holders TM



Single flute holders

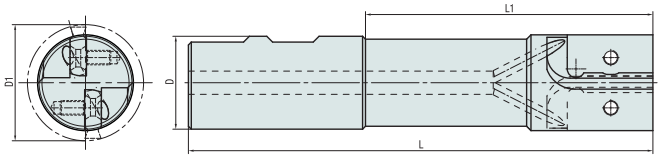
EDP number	Insert	Reference	L	L1	D	D1	Z	Int min ø
72100	TM14	TMH0075-50-14	3.000	0.800	0.750	0.500	1	0.530
72101	TM14	TMH0075-50-14 HM	3.350	1.000	0.750	0.500	1	0.530
72123	TM14	TMH0075-54-14	3.390	0.880	0.750	0.540	1	0.630
72124	TM14	TMH0075-57-14	3.390	1.000	0.750	0.570	1	0.670
72102	TM14	TMH0075-67-14	3.390	1.180	0.750	0.670	1	0.750
72104	TM21	TMH0075-75-21	3.750	1.575	0.750	0.750	1	0.840
72115	TM21	TMH0075-88-21	3.750	1.575	0.750	0.880	1	1.000
72107	TM30	TMH0100-114-30	4.370	1.968	1.000	1.140	1	1.350
72112	TM40	TMH0150-173-40	6.000	3.070	1.500	1.730	1	2.050

Single flute holders for tapered pipe thread applications

EDP number	Insert	Reference	L	L1	D	D1	Z	Threading
72120	TM14	TMH0075-45-14T	3.390	1.000	0.750	0.450	1	3/8-18''NPT/19''BSPT
72121	TM14	TMH0075-54-14T	3.390	1.250	0.750	0.540	1	1/2-14''NPT/BSPT
72122	TM21	TMH0075-70-21T	3.750	1.375	0.750	0.700	1	3/4-14''NPT/BSPT

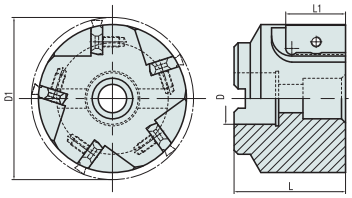
For larger threads, use straight neck styles

Milling tool holders TM



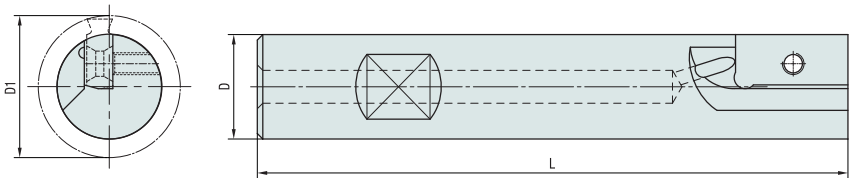
Two flutes holders

EDP number	Insert	Reference	L	L1	D	D1	Z	Int min ø
72103	TM14	TMH0075-79-2-14	3.750	1.630	0.750	0.790	2	0.920
72106	TM21	TMH0100-118-2-21	4.250	2.000	1.000	1.180	2	1.350
72109	TM30	TMH0125-158-2-30	5.120	2.850	1.250	1.580	2	1.850
72113	TM40	TMH0150-197-2-40	6.000	3.250	1.500	1.970	2	2.350



Five flutes shell mill holders

EDP number	Insert	Reference	L	D	D1	Z	Int min ø
72110	TM30	TMH0075-248-5-30	1.968	0.750	2.480	5	2.750
72111	TM30	TMH0100-315-5-30	2.165	1.000	3.150	5	3.500
72114	TM40	TMH0100-315-5-40	2.560	1.000	3.150	5	3.500



Long holders

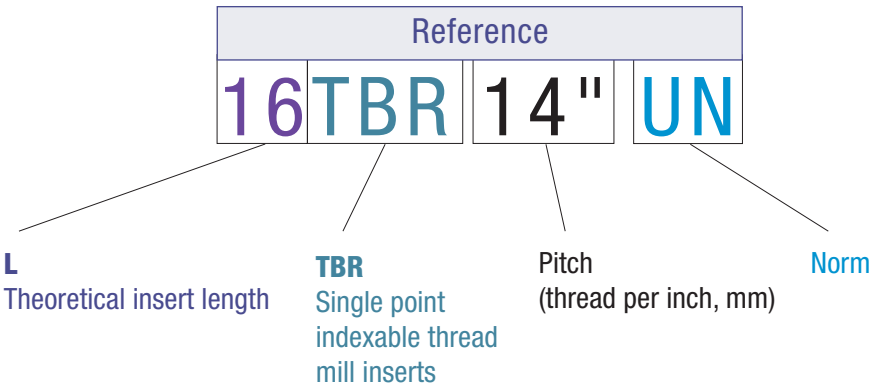
EDP number	Insert	Reference	L	L1	D	D1	Z	Int min ø
72118	TM21	TMH0075-095-1-21 L	4.921	-	0.750	0.947	1	1.120
72119	TM30	TMH0100-119-1-30 L	5.906	-	1.000	1.197	1	1.350
72120	TM30	TMH0125-144-1-30 L	5.906	-	1.250	1.446	1	1.700
72121	TM40	TMH0150-169-1-40 L	8.268	-	1.500	1.697	1	1.900

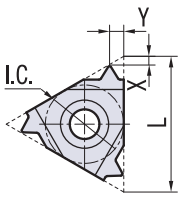
Spare parts

Spare parts

EDP number	Insert	Wrench	Screw
73102	TM14	T7	M2.5x6
73103	TM21	T20	M4x10
73104	TM30	T20	M5x12
73104	TM40	T20	M5x12

Listing





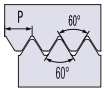
Intérieur droit (NR)

IC
Inscribed circle insert

EDP number	I/C	Reference	Pitch
BR2001	3/8	16TBR 16" UN	16

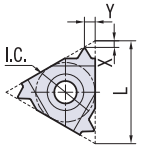
Unified National Standard

DIN ISO 5864, ANSI/ASME B1.7



Partial Profile

DIN ISO 5864, ANSI/ASME B1.7



Intérieur droit (NR)

UN, UNC, UNS, UNF, UNEF Internal

EDP number	I/C	Reference	Pitch
BR2000	3/8	16TBR 18"UN	18
BR2001	3/8	16TBR 16"UN	16
BR2002	3/8	16TBR 14"UN	14
BR2003	3/8	16TBR 12"UN	12
BR2006	3/8	16TBR 8"UN	8
BR2029	5/8	27TBR 4"UN	4

Partial Profile

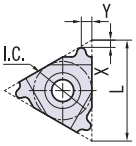
EDP number	I/C	Reference	Pitch
BR2100	3/8	16TBR AG60	48 - 8
BR2101	3/8	16TBR G60	14 - 8
BR2102	3/8U	TNEB-320.0	4 > 8
BR2103	1/2U	TNEB-431	4 > 4,5

ACME

ANSI B1.5:1988

STUB ACME

ANSI B1.8:1988



Intérieur droit (NR)

ACME Internal

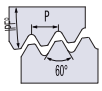
EDP number	I/C	Reference	Pitch
BR2201	3/8	16TBR 8"ACME	8
BR2018	3/8	16TBR 12"ACME	12
BR2023	5/8	27TBR 4"ACME	4

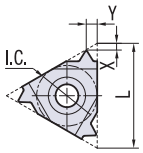
STACME Internal

EDP number	I/C	Reference	Pitch
BR2022	1/2	22TBR 12"STACME	12
BR2019	1/2	22TBR 6"STACME	6
BR2024	5/8	27TBR 4"STACME	4

Pipe thread API Round

API STD. 5B:1979





Intérieur (NR)

API RD Internal

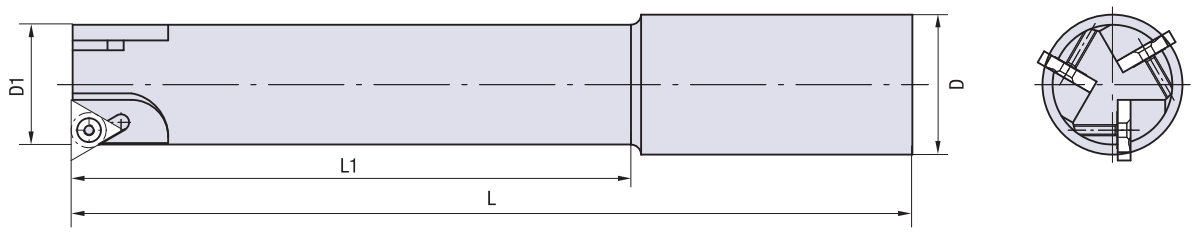
EDP number	I/C	Reference	Pitch
BR2007	3/8	16TBR 10"API RD	10
BR2008	3/8	16TBR 8"API RD	8

Listing

Reference

POTBR0150-16-3

Triangular insert tool holder | Shank diameter | Insert size | Number of flutes

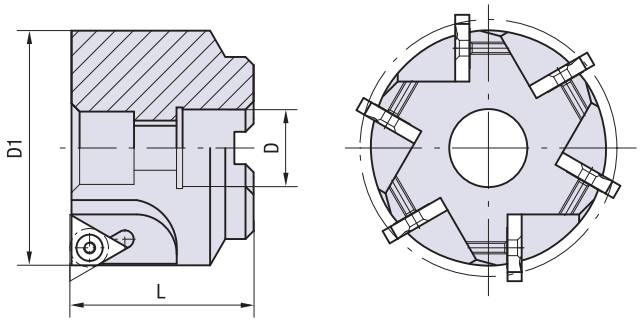


EDP number	Reference	L	L1	D	D1	# Flutes	Insert Size	Screw
SPM1503	POTBR0150-16-3	9.000	6.000	1.500	1.500	3	16TBR	S16-1/4L

Reference

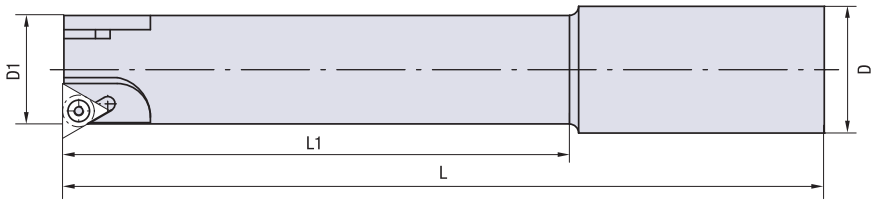
POTBR075-250-16-3

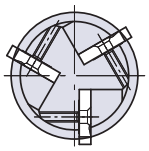
Triangular insert tool holder | Internal diameter | Cutting diameter | Insert size | Number of flutes



EDP number	Reference	L	D	D1	# Flutes	Insert Size	Key Slot	Screw
SPM2506	POTBR075-250-6-16	1.770	0.75	2.500	6	16	0.3125	S16-1/4L

Triangular insert tool holders





One flute holders

EDP number	Reference	L	L1	D	D1	# Flutes	Insert Size	Screw
SPM1171	POTBR0075-720-16-1	4.500	2.490	0.750	0.720	1	16TBR	S16-1/4L

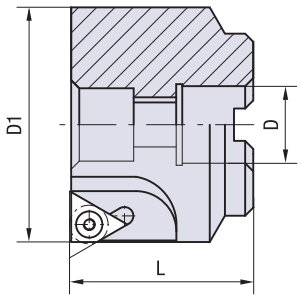
Two flutes holders

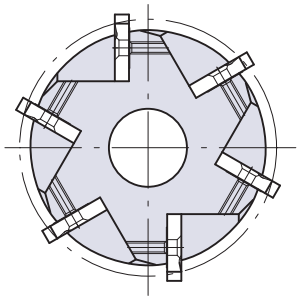
EDP number	Reference	L	L1	D	D1	# Flutes	Insert Size	Screw
SPM112911	POTBR0150-1625-43U-2	7.250	4.500	1.500	1.620	2	TN4U	SA4T20
SPM112910	POTBR0125-125-32U-2	6.000	3.625	1.250	1.250	2	TN3U	SA3T10
SPM112943	POTBR0125-125-32U2-S	7.000	4.625	1.250	1.250	2	TN3U	SA3T10
SPM1170	POTBR0125-1170-16-2	7.000	3.750	1.250	1.170	2	16TBR	S16-1/4L

Three flutes holders

EDP number	Reference	L	L1	D	D1	# Flutes	Insert Size	Screw
SPM1503	POTBR0150-16-3	9.000	6.000	1.500	1.500	3	16TBR	S16-1/4L
SPM1504	POTBR0150-16-3A	7.000	4.000	1.500	1.500	3	16TBR	S16-1/4L

Triangular insert tool holders





Four flutes holders

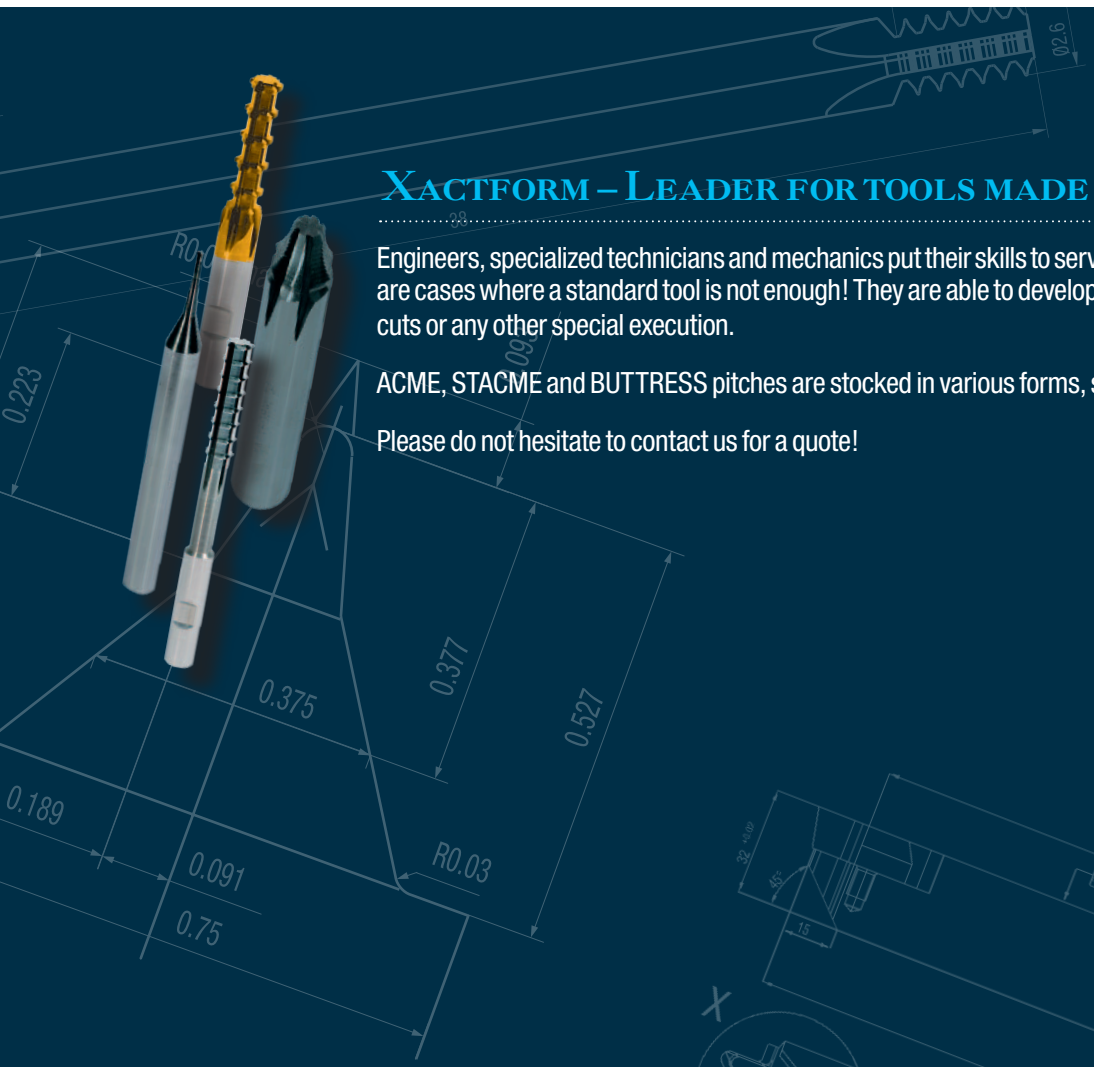
EDP number	Reference	L	D	D1	# Flutes	Insert Size	Key Slot	Screw
SPM2804	POTBR075-280-4-27	1.770	0.75	2.800	4	27	0.3125	S27

Five flutes holders

EDP number	Reference	L	D	D1	# Flutes	Insert Size	Key Slot	Screw
SPM2505	POTBR075-250-5-22	1.770	0.75	2.500	5	22	0.3125	S22
SPM2755	POTBR075-275-5-22	1.770	0.75	2.750	5	22	0.3125	S22

Six flutes holders

EDP number	Reference	L	D	D1	# Flutes	Insert Size	Key Slot	Screw
SPM2506	POTBR075-250-6-16	1.770	0.75	2.500	6	16	0.3125	S16-1/4L



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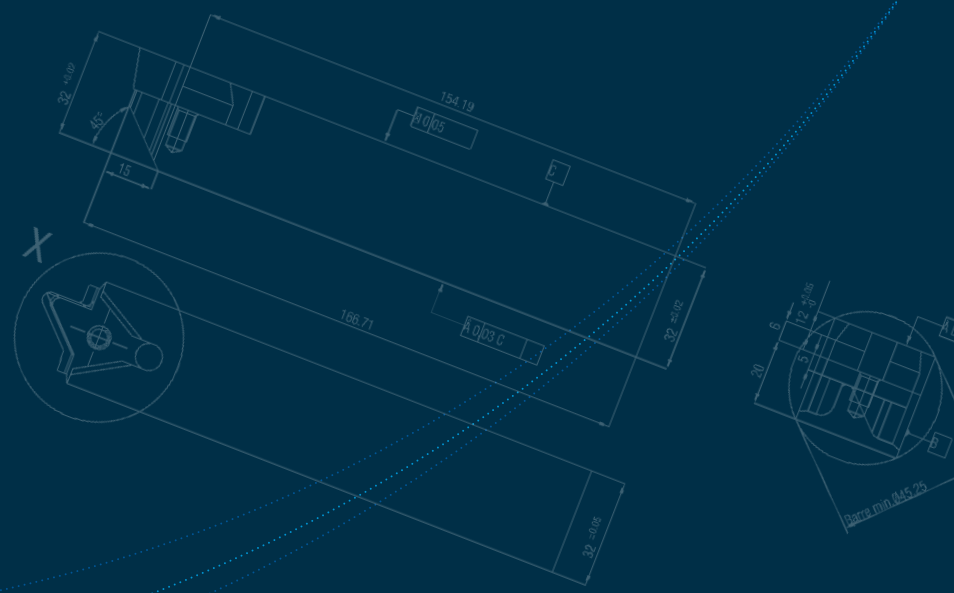

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