



EASY.

EASY Tap

The New Universal Tap

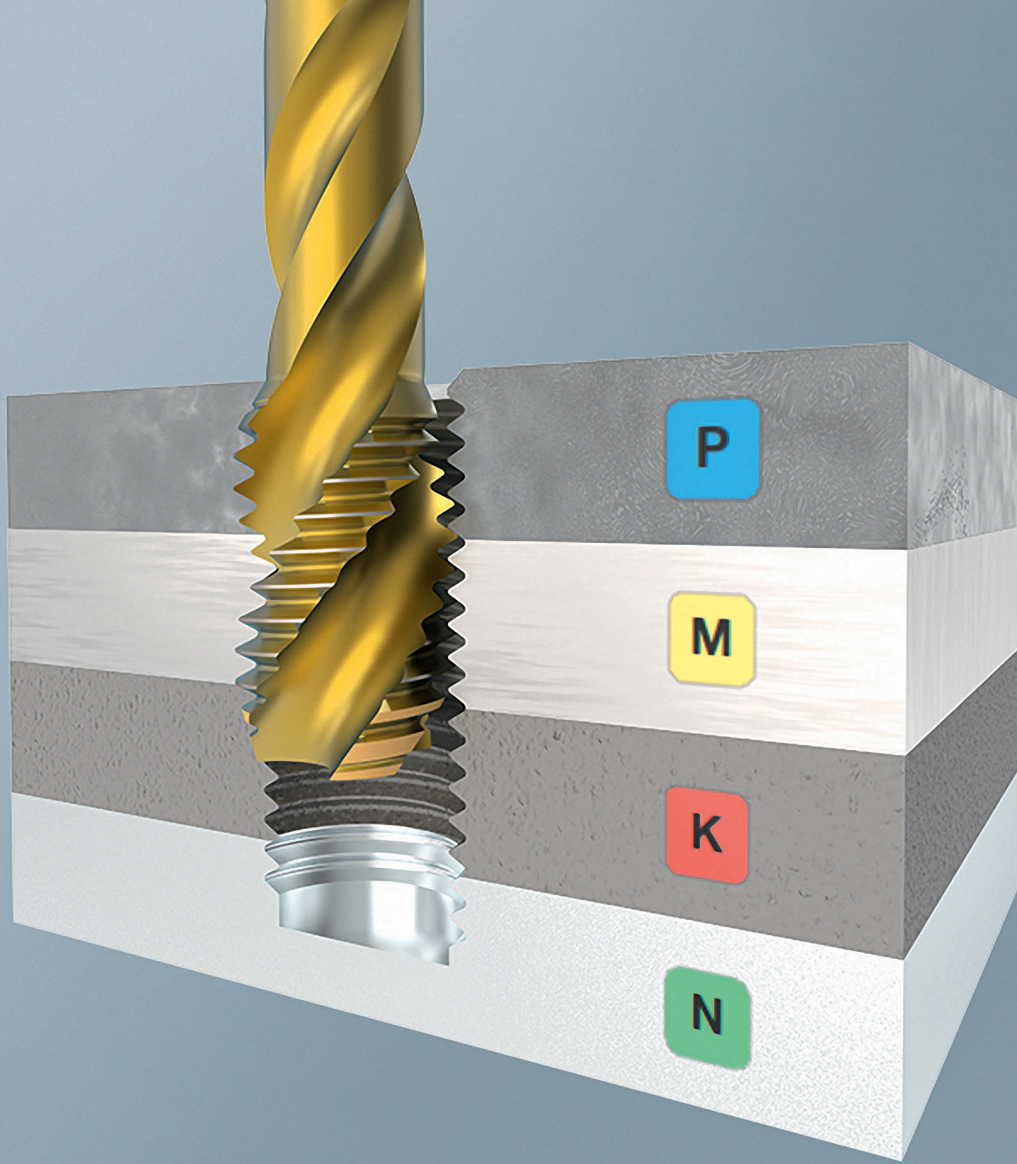
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BELIN
FETTE
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EASY.

The product range for highest efficiency and universal application.
Easy to handle.

Description	Thread form	Tolerance	Chamfer	Depth of thread	Standard	Helix	Page
Blind hole thread							
	M 1-30	6HX			DIN 371/376		6
	M 2-24	6GX					8
	M 3-16	6H +0.1					10
	MF 2,5-30	6HX			DIN 374		12
	UNC No. 2-1	2BX			DIN 2184-1		14
	UNF No. 2-1	2BX					16
	G 1/16-1				DIN 5156		18
	EGM 2-20	6HX mod			DIN 40435		20
	NPT 1/16-1				DIN 5156		22
Through hole thread							
	M 1-30	6HX			DIN 371/376		7
	M 2-24	6GX					9
	M 3-16	6H +0.1					11
	MF 2,5-30	6HX			DIN 374		13
	UNC No. 2-1	2BX			DIN 2184-1		15
	UNF No. 2-1	2BX					17
	G 1/16-1				DIN 5156		19
	EGM 2-20	6HX mod			DIN 40435		21



Universal Tap: Maximum Flexibility for All Thread Types

The EASYTap combines outstanding flexibility and efficiency in one product family. The EASYTap thread portfolio is suitable for use in almost all materials. The advantages of the new EASYTap series lead to a sig-

nificant reduction in time and costs in production. The user-friendly handling and high process reliability make EASYTap the ideal choice for versatile and uncomplicated thread machining.

EASYTap – Your Universal Tap for Every Application

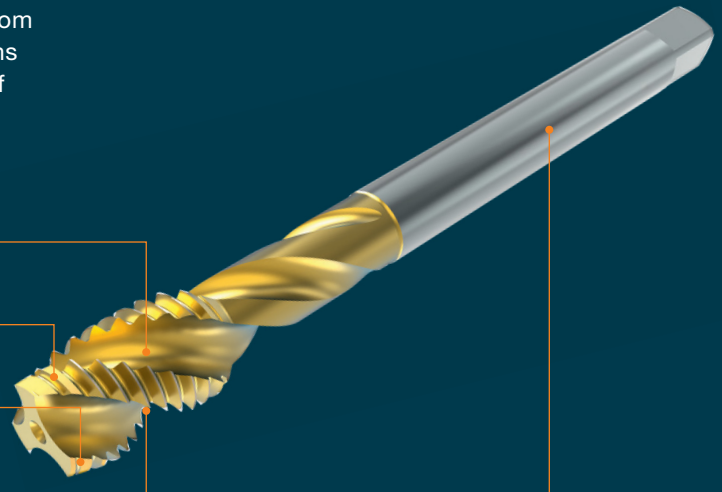
Our EASYTap product family offers the ideal solution for all common thread types such as Metric, Metric Fine, UNC, UNF, G and EG-M. Manufactured from high-quality HSS-E material and finished with a proven TiN coating, the EASYTap guarantees maximum precision and durability.

Universally applicable for a wide range of materials – from steel and stainless steel to cast iron and aluminum – the EASYTap impresses with its versatility. In the Metric range, we offer diameters from M1 to M30 in the standard portfolio, while the Metric Fine range extends from Ø MF2.5 to MF30. For UNC and UNF threads, sizes from No. 2 to 1 inch are available, G threads from 1/16 to 1 inch and EG-M from M2 to M20. This means that the EASYTap covers a particularly wide range of applications.

Rely on the quality of EASYTap and master every challenge effortlessly.

Your benefits:

- The universal tap offers a wide range of applications.
- Long tool life in steel, stainless steel, cast iron and aluminum ensure a low price per thread.
- Process reliability thanks to efficient clamping.



Optimized flutes enable efficient chip formation and greater process reliability

Newly developed lead geometry ensures stable chip formation

Wear-resistant TiN coating

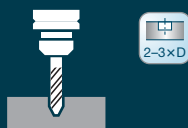
Compatible with oil, emulsion and MQL (minimum quantity lubrication)

Universally applicable in synchro chucks, compensating chucks or collets

EASYTap

For high-performance thread machining in a wide range of materials: steel, stainless steel, cast iron and aluminum

P M K N



Blind hole



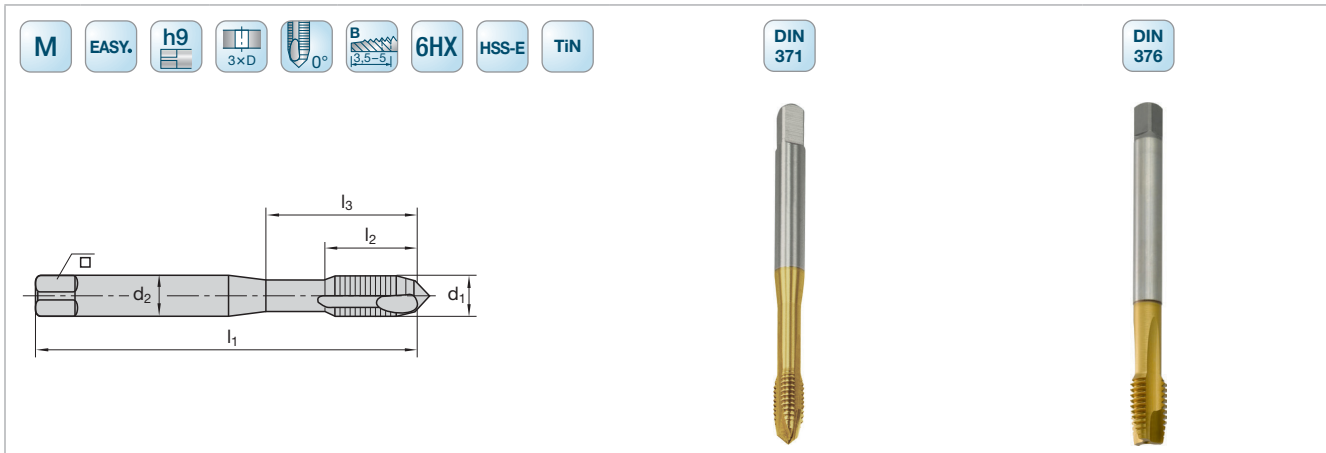
Through hole



Cat.-No.	ET01	ET01
P1 Steel < 500 N/mm ²	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min
P2 Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min
P3 Steel > 1000 N/mm ²	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min
M1 Stainless steel austenitic	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min
M2 Stainless steel martensitic		
K1 Grey cast iron		
K2 Nodular cast iron	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min
N1 Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N2 Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N3 Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min
N4 Graphite		
S1 Titanium alloys medium strength < 900 N/mm ²		
S2 Titanium alloys high strength < 1300 N/mm ²		
H1 Chilled steel and Hardened steel 45–55 HRC		

d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z	Ident No.	LMT-Code	Ident No.	LMT-Code	
with reinforced straight shank												
M1	0.25	40	5	–	2.5	2.1	2	0.75	7465287	TC-CM 1X0.25-4HX-ET45-11	–	–
M1.1	0.25	40	5	–	2.5	2.1	2	0.85	7465288	TC-CM 1.1X0.25-4HX-ET45-11	–	–
M1.2	0.25	40	5	–	2.5	2.1	2	0.95	7465289	TC-CM 1.2X0.25-4HX-ET45-11	–	–
M1.4	0.3	40	6	–	2.5	2.1	2	1.1	7465290	TC-CM 1.4X0.3-6HX-ET45-11	–	–
M1.6	0.35	40	7	–	2.5	2.1	2	1.25	7465291	TC-CM 1.6X0.35-6HX-ET45-11	–	–
M1.7	0.35	40	8	–	2.5	2.1	2	1.3	7465292	TC-CM 1.7X0.35-6HX-ET45-11	–	–
M1.8	0.35	40	8	–	2.5	2.1	2	1.45	7465293	TC-CM 1.8X0.35-6HX-ET45-11	–	–
M2	0.4	45	3.2	10	2.8	2.1	2	1.6	7465294	TC-CM 2X0.4-6HX-ET45-11	–	–
M2.2	0.45	45	3.6	11	2.8	2.1	2	1.75	7465295	TC-CM 2.2X0.45-6HX-ET45-11	–	–
M2.3	0.4	45	3.6	12	2.8	2.1	2	1.9	7465296	TC-CM 2.3X0.4-6HX-ET45-11	–	–
M2.5	0.45	50	3.6	13	2.8	2.1	2	2.05	7465297	TC-CM 2.5X0.45-6HX-ET45-11	–	–
M2.6	0.45	50	3.6	13	2.8	2.1	2	2.1	7465298	TC-CM 2.6X0.45-6HX-ET45-11	–	–
M3	0.5	56	4	18	3.5	2.7	3	2.5	7465299	TC-CM 3X0.5-6HX-ET45-11	–	–
M4	0.7	63	5.6	21	4.5	3.4	3	3.3	7465301	TC-CM 4X0.7-6HX-ET45-11	–	–
M5	0.8	70	6.4	25	6	4.9	3	4.2	7465303	TC-CM 5X0.8-6HX-ET45-11	–	–
M6	1	80	8	30	6	4.9	3	5	7465304	TC-CM 6X1-6HX-ET45-11	–	–
M8	1.25	90	10	35	8	6.2	3	6.8	7465306	TC-CM 8X1.25-6HX-ET45-11	–	–
M10	1.5	100	12	39	10	8	3	8.5	7465307	TC-CM 10X1.5-6HX-ET45-11	–	–
with standard straight shank												
M6	1	80	8	–	4.5	3.4	3	5	–	–	7465320	TC-CM 6X1-6HX-ET45-11
M8	1.25	90	10	–	6	4.9	3	6.8	–	–	7465321	TC-CM 8X1.25-6HX-ET45-11
M10	1.5	100	12	–	7	5.5	3	8.5	–	–	7465322	TC-CM 10X1.5-6HX-ET45-11
M12	1.75	110	14	–	9	7	3	10.2	–	–	7465308	TC-CM 12X1.75-6HX-ET45-11
M14	2	110	16	–	11	9	3	12	–	–	7465309	TC-CM 14X2-6HX-ET45-11
M16	2	110	16	–	12	9	3	14	–	–	7465310	TC-CM 16X2-6HX-ET45-11
M18	2.5	125	25	–	14	11	4	15.5	–	–	7465311	TC-CM 18X2.5-6HX-ET45-11
M20	2.5	140	25	–	16	12	4	17.5	–	–	7465312	TC-CM 20X2.5-6HX-ET45-11
M22	2.5	140	25	–	18	14.5	4	19.5	–	–	7465313	TC-CM 22X2.5-6HX-ET45-11
M24	3	160	30	–	18	14.5	4	21	–	–	7465314	TC-CM 24X3-6HX-ET45-11
M27	3	160	36	–	20	16	4	24	–	–	7465315	TC-CM 27X3-6HX-ET45-11
M30	3.5	180	42	–	22	18	4	26.5	–	–	7465316	TC-CM 30X3.5-6HX-ET45-11

Note: Left Hand Thread from M3 to M24 or excess length from M3 to M20 available on request
 ■ = First choice □ = Second choice

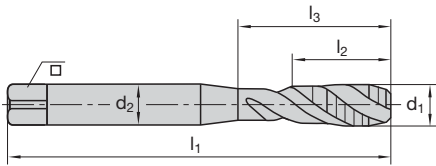


Cat.-No.		ET01		ET01	
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min
M2	Stainless steel martensitic				
K1	Grey cast iron				
K2	Nodular cast iron	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min
N4	Graphite				
S1	Titanium alloys medium strength < 900 N/mm ²				
S2	Titanium alloys high strength < 1300 N/mm ²				
H1	Chilled steel and Hardened steel 45–55 HRC				

d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z	z	Ident No.	LMT-Code	Ident No.	LMT-Code
with reinforced straight shank												
M1	0.25	40	5	–	2.5	2.1	2	0.75	7465196	TC-BM 1X0.25-4HX-ET0-11	–	–
M1.1	0.25	40	5	–	2.5	2.1	2	0.85	7465197	TC-BM 1.1X0.25-4HX-ET0-11	–	–
M1.2	0.25	40	5	–	2.5	2.1	2	0.95	7465198	TC-BM 1.2X0.25-4HX-ET0-11	–	–
M1.4	0.3	40	7	–	2.5	2.1	2	1.1	7465199	TC-BM 1.4X0.3-6HX-ET0-11	–	–
M1.6	0.35	40	8	–	2.5	2.1	2	1.25	7465200	TC-BM 1.6X0.35-6HX-ET0-11	–	–
M1.7	0.35	40	8	–	2.5	2.1	2	1.3	7465201	TC-BM 1.7X0.35-6HX-ET0-11	–	–
M1.8	0.35	40	8	–	2.5	2.1	2	1.45	7465202	TC-BM 1.8X0.35-6HX-ET0-11	–	–
M2	0.4	45	8	–	2.8	2.1	2	1.6	7465203	TC-BM 2X0.4-6HX-ET0-11	–	–
M2.2	0.45	45	9	–	2.8	2.1	2	1.75	7465204	TC-BM 2.2X0.45-6HX-ET0-11	–	–
M2.3	0.4	45	9	–	2.8	2.1	2	1.9	7465205	TC-BM 2.3X0.4-6HX-ET0-11	–	–
M2.5	0.45	50	9	–	2.8	2.1	2	2.05	7465206	TC-BM 2.5X0.45-6HX-ET0-11	–	–
M2.6	0.45	50	9	–	2.8	2.1	2	2.1	7465207	TC-BM 2.6X0.45-6HX-ET0-11	–	–
M3	0.5	56	11	18	3.5	2.7	3	2.5	7465208	TC-BM 3X0.5-6HX-ET0-11	–	–
M4	0.7	63	13	21	4.5	3.4	3	3.3	7465210	TC-BM 4X0.7-6HX-ET0-11	–	–
M5	0.8	70	16	25	6	4.9	3	4.2	7465212	TC-BM 5X0.8-6HX-ET0-11	–	–
M6	1	80	19	30	6	4.9	3	5	7465213	TC-BM 6X1-6HX-ET0-11	–	–
M8	1.25	90	22	35	8	6.2	3	6.8	7465215	TC-BM 8X1.25-6HX-ET0-11	–	–
M10	1.5	100	24	39	10	8	3	8.5	7465216	TC-BM 10X1.5-6HX-ET0-11	–	–
with standard straight shank												
M6	1	80	19	–	4.5	3.4	3	5	–	–	7465229	TC-BM 6X1-6HX-ET0-11
M8	1.25	90	22	–	6	4.9	3	6.8	–	–	7465230	TC-BM 8X1.25-6HX-ET0-11
M10	1.5	100	24	–	7	5.5	3	8.5	–	–	7465231	TC-BM 10X1.5-6HX-ET0-11
M12	1.75	110	28	–	9	7	3	10.2	–	–	7465217	TC-BM 12X1.75-6HX-ET0-11
M14	2	110	30	–	11	9	3	12	–	–	7465218	TC-BM 14X2-6HX-ET0-11
M16	2	110	32	–	12	9	3	14	–	–	7465219	TC-BM 16X2-6HX-ET0-11
M18	2.5	125	34	–	14	11	3	15.5	–	–	7465220	TC-BM 18X2.5-6HX-ET0-11
M20	2.5	140	34	–	16	12	3	17.5	–	–	7465221	TC-BM 20X2.5-6HX-ET0-11
M22	2.5	140	34	–	18	14.5	3	19.5	–	–	7465222	TC-BM 22X2.5-6HX-ET0-11
M24	3	160	38	–	18	14.5	3	21	–	–	7465223	TC-BM 24X3-6HX-ET0-11
M27	3	160	38	–	20	16	4	24	–	–	7465224	TC-BM 27X3-6HX-ET0-11
M30	3.5	180	45	–	22	18	4	26.5	–	–	7465225	TC-BM 30X3.5-6HX-ET0-11

Note: Left Hand Thread from M3 to M24 or excess length from M3 to M20 available on request

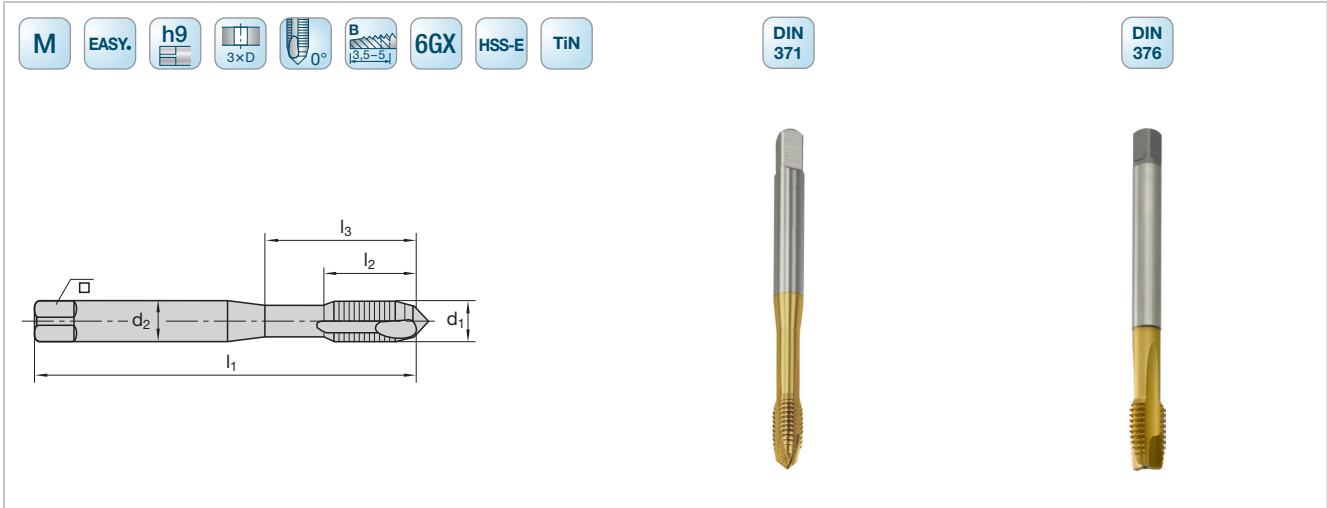
■ = First choice □ = Second choice



Cat.-No.		ET01	ET01
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min
M2	Stainless steel martensitic		
K1	Grey cast iron		
K2	Nodular cast iron	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min
N4	Graphite		
S1	Titanium alloys medium strength < 900 N/mm ²		
S2	Titanium alloys high strength < 1300 N/mm ²		
H1	Chilled steel and Hardened steel 45–55 HRC		

d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code
with reinforced straight shank												
M2	0.4	45	3.2	10	2.8	2.1	2	1.6	7465335	TC-CM 2X0.4-6GX-ET45-11	–	–
M3	0.5	56	4	18	3.5	2.7	3	2.5	7465336	TC-CM 3X0.5-6GX-ET45-11	–	–
M4	0.7	63	5.6	21	4.5	3.4	3	3.3	7465337	TC-CM 4X0.7-6GX-ET45-11	–	–
M5	0.8	70	6.4	25	6	4.9	3	4.2	7465338	TC-CM 5X0.8-6GX-ET45-11	–	–
M6	1	80	8	30	6	4.9	3	5	7465339	TC-CM 6X1-6GX-ET45-11	–	–
M8	1.25	90	10	35	8	6.2	3	6.8	7465340	TC-CM 8X1.25-6GX-ET45-11	–	–
M10	1.5	100	12	39	10	8	3	8.5	7465341	TC-CM 10X1.5-6GX-ET45-11	–	–
with standard straight shank												
M12	1.75	110	14	–	9	7	3	10.2	–	–	7465342	TC-CM 12X1.75-6GX-ET45-11
M14	2	110	16	–	11	9	3	12	–	–	7465343	TC-CM 14X2-6GX-ET45-11
M16	2	110	16	–	12	9	3	14	–	–	7465344	TC-CM 16X2-6GX-ET45-11
M20	2.5	140	25	–	16	12	4	17.5	–	–	7465345	TC-CM 20X2.5-6GX-ET45-11
M24	3	160	30	–	18	14.5	4	21	–	–	7465346	TC-CM 24X3-6GX-ET45-11

■ = First choice □ = Second choice



Cat.-No.		ET01	ET01
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min
M2	Stainless steel martensitic		
K1	Grey cast iron		
K2	Nodular cast iron	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min
N4	Graphite		
S1	Titanium alloys medium strength < 900 N/mm ²		
S2	Titanium alloys high strength < 1300 N/mm ²		
H1	Chilled steel and Hardened steel 45–55 HRC		

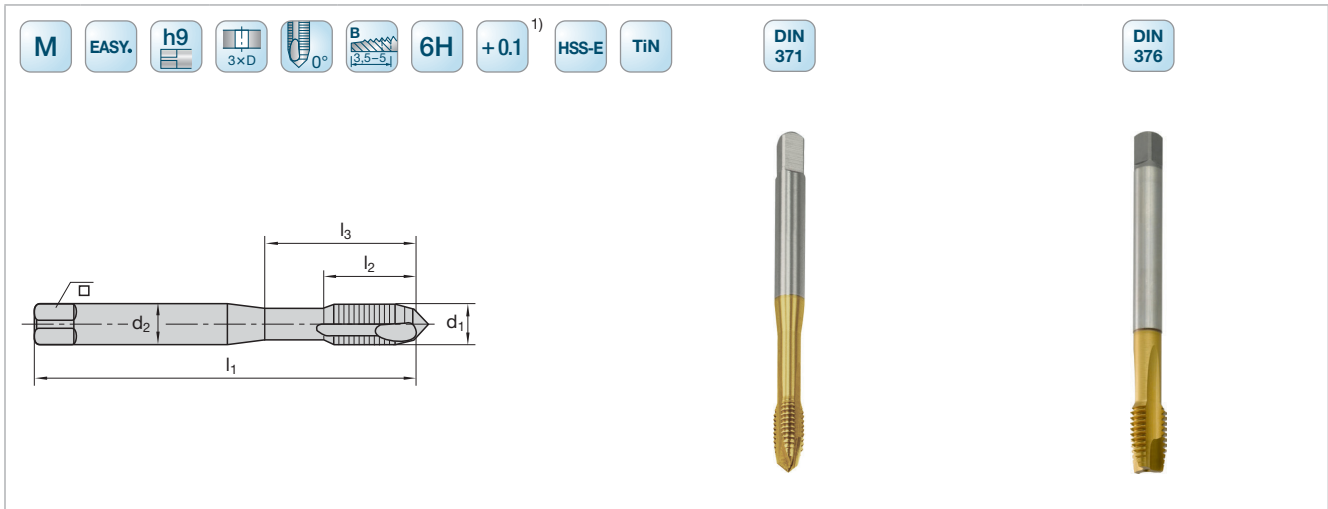
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code
with reinforced straight shank												
M2	0.4	45	8	–	2.8	2.1	2	1.6	7465232	TC-BM 2X0.4-6GX-ET0-11	–	–
M3	0.5	56	11	18	3.5	2.7	3	2.5	7465233	TC-BM 3X0.5-6GX-ET0-11	–	–
M4	0.7	63	13	21	4.5	3.4	3	3.3	7465234	TC-BM 4X0.7-6GX-ET0-11	–	–
M5	0.8	70	16	25	6	4.9	3	4.2	7465235	TC-BM 5X0.8-6GX-ET0-11	–	–
M6	1	80	19	30	6	4.9	3	5	7465236	TC-BM 6X1-6GX-ET0-11	–	–
M8	1.25	90	22	35	8	6.2	3	6.8	7465237	TC-BM 8X1.25-6GX-ET0-11	–	–
M10	1.5	100	24	39	10	8	3	8.5	7465238	TC-BM 10X1.5-6GX-ET0-11	–	–
with standard straight shank												
M12	1.75	110	28	–	9	7	3	10.2	–	–	7465239	TC-BM 12X1.75-6GX-ET0-11
M14	2	110	30	–	11	9	3	12	–	–	7465240	TC-BM 14X2-6GX-ET0-11
M16	2	110	32	–	12	9	3	14	–	–	7465241	TC-BM 16X2-6GX-ET0-11
M20	2.5	140	34	–	16	12	3	17.5	–	–	7465242	TC-BM 20X2.5-6GX-ET0-11
M24	3	160	38	–	18	14.5	3	21	–	–	7465243	TC-BM 24X3-6GX-ET0-11

■ = First choice □ = Second choice

Cat.-No.										ET01		ET01	
P1 Steel < 500 N/mm ²										■ v _c = 15–25 m/min		■ v _c = 15–25 m/min	
P2 Steel 500–1000 N/mm ²										■ v _c = 10–20 m/min		■ v _c = 10–20 m/min	
P3 Steel > 1000 N/mm ²										■ v _c = 8–15 m/min		■ v _c = 8–15 m/min	
M1 Stainless steel austenitic										■ v _c = 6–12 m/min		■ v _c = 6–12 m/min	
M2 Stainless steel martensitic													
K1 Grey cast iron													
K2 Nodular cast iron										■ v _c = 8–20 m/min		■ v _c = 8–20 m/min	
N1 Alu- & Copper alloys long chipping < 5 % Si										■ v _c = 15–40 m/min		■ v _c = 15–40 m/min	
N2 Alu- & Copper alloys long chipping 5–10 % Si										■ v _c = 15–40 m/min		■ v _c = 15–40 m/min	
N3 Alu- & Copper alloys short chipping > 10 % Si										■ v _c = 10–30 m/min		■ v _c = 10–30 m/min	
N4 Graphite													
S1 Titanium alloys medium strength < 900 N/mm ²													
S2 Titanium alloys high strength < 1300 N/mm ²													
H1 Chilled steel and Hardened steel 45–55 HRC													
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code	
with reinforced straight shank													
M3	0.5	56	4	18	3.5	2.7	3	2.6	7465356	TC-CM 3X0.5-6H+0.1-ET45-11	–	–	
M4	0.7	63	5.6	21	4.5	3.4	3	3.4	7465357	TC-CM 4X0.7-6H+0.1-ET45-11	–	–	
M5	0.8	70	6.4	25	6	4.9	3	4.3	7465358	TC-CM 5X0.8-6H+0.1-ET45-11	–	–	
M6	1	80	8	30	6	4.9	3	5.1	7465359	TC-CM 6X1-6H+0.1-ET45-11	–	–	
M8	1.25	90	10	35	8	6.2	3	6.9	7465360	TC-CM 8X1.25-6H+0.1-ET45-11	–	–	
M10	1.5	100	12	39	10	8	3	8.6	7465361	TC-CM 10X1.5-6H+0.1-ET45-11	–	–	
with standard straight shank													
M12	1.75	110	14	–	9	7	3	10.3	–	–	7465362	TC-CM 12X1.75-6H+0.1-ET45-11	
M16	2	110	16	–	12	9	3	14.1	–	–	7465363	TC-CM 16X2-6H+0.1-ET45-11	

¹⁾ Tolerance class 6H+0.1

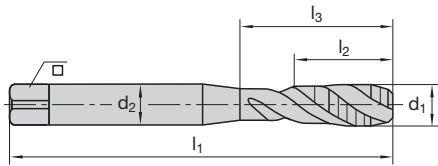
■ = First choice □ = Second choice



Cat.-No.		ET01		ET01								
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min	■ v _c = 15–25 m/min							
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min							
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min	■ v _c = 8–15 m/min							
M1	Stainless steel austenitic	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min	■ v _c = 6–12 m/min							
M2	Stainless steel martensitic											
K1	Grey cast iron											
K2	Nodular cast iron	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min	■ v _c = 8–20 m/min							
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min							
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min	■ v _c = 15–40 m/min							
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min	■ v _c = 10–30 m/min							
N4	Graphite											
S1	Titanium alloys medium strength < 900 N/mm ²											
S2	Titanium alloys high strength < 1300 N/mm ²											
H1	Chilled steel and Hardened steel 45–55 HRC											
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code	Ident No.	LMT-Code
with reinforced straight shank												
M3	0.5	56	11	18	3.5	2.7	3	2.6	7465253	TC-BM 3X0.5-6H+0.1-ET0-11	–	–
M4	0.7	63	13	21	4.5	3.4	3	3.4	7465254	TC-BM 4X0.7-6H+0.1-ET0-11	–	–
M5	0.8	70	16	25	6	4.9	3	4.3	7465255	TC-BM 5X0.8-6H+0.1-ET0-11	–	–
M6	1	80	19	30	6	4.9	3	5.1	7465256	TC-BM 6X1-6H+0.1-ET0-11	–	–
M8	1.25	90	22	35	8	6.2	3	6.9	7465257	TC-BM 8X1.25-6H+0.1-ET0-11	–	–
M10	1.5	100	24	39	10	8	3	8.6	7465258	TC-BM 10X1.5-6H+0.1-ET0-11	–	–
with standard straight shank												
M12	1.75	110	28	–	9	7	3	10.3	–	–	7465259	TC-BM 12X1.75-6H+0.1-ET0-11
M16	2	110	32	–	12	9	3	14.1	–	–	7465260	TC-BM 16X2-6H+0.1-ET0-11

¹⁾ Tolerance class 6H+0.1

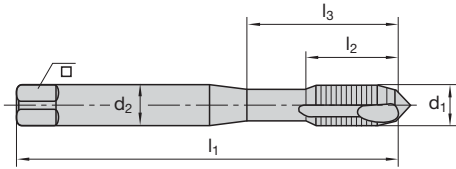
■ = First choice □ = Second choice



Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min								
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min								
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min								
M1	Stainless steel austenitic	■ v _c = 6–12 m/min								
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■ v _c = 8–20 m/min								
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min								
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min								
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min								
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	d ₂	□ h12	z		Ident No.	LMT-Code	
with standard straight shank										
MF 2.5	0.35	50	9	–	1.8	2	2.15	7465439	TC-CMF 2.5X0.35-6HX-ET45-11	
MF 2.6	0.35	50	9	–	1.8	2	2.25	7465440	TC-CMF 2.6X0.35-6HX-ET45-11	
MF 3	0.35	56	4	–	2.2	3	2.65	7465441	TC-CMF 3X0.35-6HX-ET45-11	
MF 3.5	0.35	56	4.8	–	2.5	3	3.15	7465442	TC-CMF 3.5X0.35-6HX-ET45-11	
MF 4	0.35	63	5.6	–	2.8	3	3.65	7465443	TC-CMF 4X0.35-6HX-ET45-11	
MF 4	0.5	63	5.6	–	2.8	3	3.5	7465444	TC-CMF 4X0.5-6HX-ET45-11	
MF 4.5	0.5	70	6	–	3.5	3	4	7465445	TC-CMF 4.5X0.5-6HX-ET45-11	
MF 5	0.5	70	6.4	–	3.5	3	4.5	7465446	TC-CMF 5X0.5-6HX-ET45-11	
MF 6	0.5	80	8	4.5	3.4	3	5.5	7465447	TC-CMF 6X0.5-6HX-ET45-11	
MF 6	0.75	80	8	4.5	3.4	3	5.25	7465448	TC-CMF 6X0.75-6HX-ET45-11	
MF 6.5	0.75	80	8	–	5.5	3	5.75	7465449	TC-CMF 6.5X0.75-6HX-ET45-11	
MF 8	0.75	80	8	6	4.9	3	6.5	7465451	TC-CMF 8X0.75-6HX-ET45-11	
MF 8	1	90	10	6	4.9	3	7.25	7465452	TC-CMF 8X1-6HX-ET45-11	
MF 10	1	90	10	7	5.5	3	7	7465455	TC-CMF 10X1-6HX-ET45-11	
MF 10	1.25	100	12	7	5.5	3	8	7465456	TC-CMF 10X1.25-6HX-ET45-11	
MF 12	1	100	12	9	7	3	11	7465460	TC-CMF 12X1-6HX-ET45-11	
MF 12	1.25	100	12	9	7	3	10.75	7465461	TC-CMF 12X1.25-6HX-ET45-11	
MF 12	1.5	100	14	9	7	3	10.5	7465462	TC-CMF 12X1.5-6HX-ET45-11	
MF 14	1.5	100	16	11	9	3	12.5	7465464	TC-CMF 14X1.5-6HX-ET45-11	
MF 16	1.5	100	16	12	9	3	14.5	7465465	TC-CMF 16X1.5-6HX-ET45-11	
MF 18	1.5	110	16	14	11	4	16.5	7465467	TC-CMF 18X1.5-6HX-ET45-11	
MF 20	1.5	125	16	16	12	4	18.5	7465468	TC-CMF 20X1.5-6HX-ET45-11	
MF 22	1.5	125	16	18	14.5	4	20.5	7465469	TC-CMF 22X1.5-6HX-ET45-11	
MF 24	1.5	140	16	18	14.5	4	22.5	7465470	TC-CMF 24X1.5-6HX-ET45-11	
MF 26	1.5	140	24	–	18	4	24.5	7465471	TC-CMF 26X1.5-6HX-ET45-11	
MF 30	1.5	150	36	–	22	4	28.5	7465472	TC-CMF 30X1.5-6HX-ET45-11	

Note: Left Hand Thread from M8 to M24 or excess length from M8 to M24 available on request

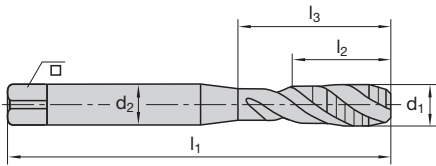
■ = First choice □ = Second choice



Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min								
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min								
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min								
M1	Stainless steel austenitic	■ v _c = 6–12 m/min								
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■ v _c = 8–20 m/min								
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min								
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min								
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min								
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	d ₂	□ h12	z		Ident No.	LMT-Code	
with standard straight shank										
MF 2.5	0.35	50	9	1.8	–	2	2.15	7465390	TC-BMF 2.5X0.35-6HX-ET0-11	
MF 2.6	0.35	50	9	1.8	–	2	2.25	7465391	TC-BMF 2.6X0.35-6HX-ET0-11	
MF 3	0.35	56	8	2.2	–	3	2.65	7465392	TC-BMF 3X0.35-6HX-ET0-11	
MF 3.5	0.35	56	9	2.5	2.1	3	3.15	7465393	TC-BMF 3.5X0.35-6HX-ET0-11	
MF 4	0.35	63	10	2.8	2.1	3	3.65	7465394	TC-BMF 4X0.35-6HX-ET0-11	
MF 4	0.5	63	10	2.8	2.1	3	3.5	7465395	TC-BMF 4X0.5-6HX-ET0-11	
MF 4.5	0.5	70	12	3.5	2.7	3	4	7465396	TC-BMF 4.5X0.5-6HX-ET0-11	
MF 5	0.5	70	16	3.5	2.7	3	4.5	7465397	TC-BMF 5X0.5-6HX-ET0-11	
MF 6	0.5	80	14	4.5	3.4	3	5.5	7465398	TC-BMF 6X0.5-6HX-ET0-11	
MF 6	0.75	80	14	4.5	3.4	3	5.25	7465399	TC-BMF 6X0.75-6HX-ET0-11	
MF 6.5	0.75	80	14	5.5	4.3	3	5.75	7465400	TC-BMF 6.5X0.75-6HX-ET0-11	
MF 8	0.75	80	22	6	4.9	3	7.25	7465402	TC-BMF 8X0.75-6HX-ET0-11	
MF 8	1	90	22	6	4.9	3	7	7465403	TC-BMF 8X1-6HX-ET0-11	
MF 10	1	90	20	7	5.5	3	9	7465406	TC-BMF 10X1-6HX-ET0-11	
MF 10	1.25	100	24	7	5.5	3	8.75	7465407	TC-BMF 10X1.25-6HX-ET0-11	
MF 12	1	100	22	9	7	3	11	7465411	TC-BMF 12X1-6HX-ET0-11	
MF 12	1.25	100	22	9	7	3	10.75	7465412	TC-BMF 12X1.25-6HX-ET0-11	
MF 12	1.5	100	22	9	7	3	10.5	7465413	TC-BMF 12X1.5-6HX-ET0-11	
MF 14	1.5	100	22	11	9	3	12.5	7465415	TC-BMF 14X1.5-6HX-ET0-11	
MF 16	1.5	100	22	12	9	3	14.5	7465416	TC-BMF 16X1.5-6HX-ET0-11	
MF 18	1.5	110	25	14	11	3	16.5	7465418	TC-BMF 18X1.5-6HX-ET0-11	
MF 20	1.5	125	25	16	12	3	18.5	7465419	TC-BMF 20X1.5-6HX-ET0-11	
MF 22	1.5	125	25	18	14.5	3	20.5	7465420	TC-BMF 22X1.5-6HX-ET0-11	
MF 24	1.5	140	28	18	14.5	3	22.5	7465421	TC-BMF 24X1.5-6HX-ET0-11	
MF 26	1.5	140	28	18	14.5	4	24.5	7465422	TC-BMF 26X1.5-6HX-ET0-11	
MF 30	1.5	150	28	22	18	4	28.5	7465423	TC-BMF 30X1.5-6HX-ET0-11	

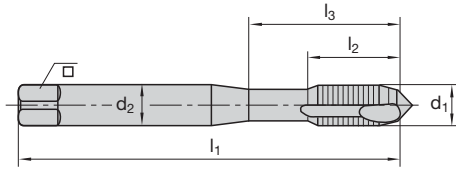
Note: Left Hand Thread from M8 to M24 or excess length from M8 to M24 available on request

■ = First choice □ = Second choice



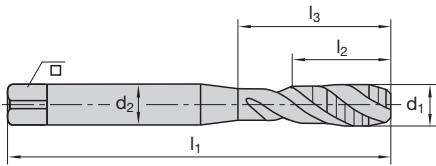
Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■	v _c = 15–25 m/min							
P2	Steel 500–1000 N/mm ²	■	v _c = 10–20 m/min							
P3	Steel > 1000 N/mm ²	■	v _c = 8–15 m/min							
M1	Stainless steel austenitic	■	v _c = 6–12 m/min							
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■	v _c = 8–20 m/min							
N1	Alu- & Copper alloys long chipping < 5 % Si	■	v _c = 15–40 m/min							
N2	Alu- & Copper alloys long chipping 5–10 % Si	■	v _c = 15–40 m/min							
N3	Alu- & Copper alloys short chipping > 10 % Si	■	v _c = 10–30 m/min							
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code
with reinforced straight shank										
UNC No. 2	56	45	3.6	11	2.8	2.1	2	1.85	7465559	TC-CUNC #2-56X3.6-ET45-11
UNC No. 3	48	50	3.6	13	2.8	2.1	2	2.1	7465560	TC-CUNC #3-48X3.6-ET45-11
UNC No. 4	40	56	5.1	18	3.5	2.7	2	2.35	7465561	TC-CUNC #4-40X5.1-ET45-11
UNC No. 5	40	56	5.1	18	3.5	2.7	2	2.65	7465562	TC-CUNC #5-40X5.1-ET45-11
UNC No. 6	32	56	6.4	20	4	3	2	2.85	7465563	TC-CUNC #6-32X6.4-ET45-11
UNC No. 8	32	63	6.4	21	4.5	3.4	2	3.5	7465564	TC-CUNC #8-32X6.4-ET45-11
UNC No. 10	24	70	8.5	25	6	4.9	2	3.9	7465565	TC-CUNC #10-24X8.5-ET45-11
UNC No. 12	24	80	8.5	30	6	4.9	2	4.5	7465566	TC-CUNC #12-24X8.5-ET45-11
UNC 1/4	20	80	10.2	30	7	5.5	2	5.2	7465567	TC-CUNC 1/4-20X10.2-ET45-11
UNC 5/16	18	90	11.3	35	8	6.2	3	6.6	7465568	TC-CUNC 5/16-18X11.3-ET45-11
UNC 3/8	16	100	12.7	39	10	8	3	8	7465569	TC-CUNC 3/8-16X12.7-ET45-11
with standard straight shank										
UNC 1/2	13	110	15.6	–	9	7	3	10.8	7465570	TC-CUNC 1/2-13X15.6-ET45-11
UNC 5/8	11	110	18.5	–	12	9	3	13.5	7465571	TC-CUNC 5/8-11X18.5-ET45-11
UNC 3/4	10	125	25.4	–	14	11	4	16.5	7465572	TC-CUNC 3/4-10X25.4-ET45-11
UNC 7/8	9	140	28.2	–	18	14.5	4	19.5	7465573	TC-CUNC 7/8-9X28.2-ET45-11
UNC 1	8	160	31.8	–	18	14.5	4	22.25	7465574	TC-CUNC 1-8X31.8-ET45-11

■ = First choice □ = Second choice



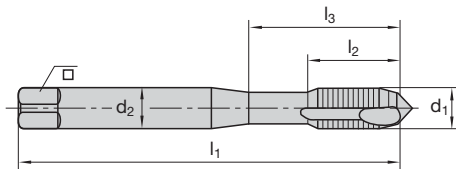
Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■	v _c = 15–25 m/min							
P2	Steel 500–1000 N/mm ²	■	v _c = 10–20 m/min							
P3	Steel > 1000 N/mm ²	■	v _c = 8–15 m/min							
M1	Stainless steel austenitic	■	v _c = 6–12 m/min							
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■	v _c = 8–20 m/min							
N1	Alu- & Copper alloys long chipping < 5 % Si	■	v _c = 15–40 m/min							
N2	Alu- & Copper alloys long chipping 5–10 % Si	■	v _c = 15–40 m/min							
N3	Alu- & Copper alloys short chipping > 10 % Si	■	v _c = 10–30 m/min							
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code
with reinforced straight shank										
UNC No. 2	56	45	9	–	2.8	2.1	2	1.85	7465544	TC-BUNC #2-56X9-ET0-11
UNC No. 4	40	56	11	18	3.5	2.7	2	2.35	7465545	TC-BUNC #4-40X11-ET0-11
UNC No. 5	40	56	11	18	3.5	2.7	3	2.65	7465546	TC-BUNC #5-40X11-ET0-11
UNC No. 6	32	56	12	20	4	3	3	2.85	7465547	TC-BUNC #6-32X12-ET0-11
UNC No. 8	32	63	13	21	4.5	3.4	3	3.5	7465548	TC-BUNC #8-32X13-ET0-11
UNC No. 10	24	70	16	25	6	4.9	3	3.9	7465549	TC-BUNC #10-24X16-ET0-11
UNC No. 12	24	80	17	30	6	4.9	3	4.5	7465550	TC-BUNC #12-24X17-ET0-11
UNC 1/4	20	80	19	30	7	5.5	3	5.2	7465551	TC-BUNC 1/4-20X19-ET0-11
UNC 5/16	18	90	22	35	8	6.2	3	6.6	7465552	TC-BUNC 5/16-18X22-ET0-11
UNC 3/8	16	100	24	39	10	8	3	8	7465553	TC-BUNC 3/8-16X24-ET0-11
with standard straight shank										
UNC 1/2	13	110	28	–	9	7	3	10.8	7465554	TC-BUNC 1/2-13X28-ET0-11
UNC 5/8	11	110	32	–	12	9	3	13.5	7465555	TC-BUNC 5/8-11X32-ET0-11
UNC 3/4	10	125	34	–	14	11	3	16.5	7465556	TC-BUNC 3/4-10X34-ET0-11
UNC 7/8	9	140	34	–	18	14.5	3	19.5	7465557	TC-BUNC 7/8-9X34-ET0-11
UNC 1	8	160	38	–	18	14.5	3	22.25	7465558	TC-BUNC 1-8X38-ET0-11

■ = First choice □ = Second choice



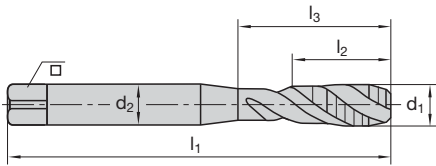
Cat.-No.		ET01									
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min									
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min									
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min									
M1	Stainless steel austenitic	■ v _c = 6–12 m/min									
M2	Stainless steel martensitic										
K1	Grey cast iron										
K2	Nodular cast iron	■ v _c = 8–20 m/min									
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min									
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min									
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min									
N4	Graphite										
S1	Titanium alloys medium strength < 900 N/mm ²										
S2	Titanium alloys high strength < 1300 N/mm ²										
H1	Chilled steel and Hardened steel 45–55 HRC										
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code	
with reinforced straight shank											
UNF No. 2	64	45	3.6	11	2.8	2.1	2	1.85	7465592	TC-CUNF #2-64X3.6-ET45-11	
UNF No. 3	56	50	3.6	13	2.8	2.1	2	2.15	7465593	TC-CUNF #3-56X3.6-ET45-11	
UNF No. 4	48	56	5.1	18	3.5	2.7	2	2.4	7465594	TC-CUNF #4-48X5.1-ET45-11	
UNF No. 5	44	56	5.1	18	3.5	2.7	2	2.7	7465595	TC-CUNF #5-44X5.1-ET45-11	
UNF No. 6	40	56	6.4	20	4	3	2	2.95	7465596	TC-CUNF #6-40X6.4-ET45-11	
UNF No. 8	36	63	6.4	21	4.5	3.4	2	3.5	7465597	TC-CUNF #8-36X6.4-ET45-11	
UNF No. 10	32	70	8.5	25	6	4.9	2	4.1	7465598	TC-CUNF #10-32X8.5-ET45-11	
UNF No. 12	28	80	8.5	30	6	4.9	2	4.6	7465599	TC-CUNF #12-28X8.5-ET45-11	
UNF 1/4	28	80	10.2	30	7	5.5	2	5.5	7465600	TC-CUNF 1/4-28X10.2-ET45-11	
UNF 5/16	24	90	11.3	35	8	6.2	3	6.9	7465601	TC-CUNF 5/16-24X11.3-ET45-11	
UNF 3/8	24	90	12.7	35	10	8	3	8.5	7465602	TC-CUNF 3/8-24X12.7-ET45-11	
UNF 7/16	20	100	14.5	–	8	6.2	3	9.9	7465603	TC-CUNF 7/16-20X14.5-ET45-11	
with standard straight shank											
UNF 1/2	20	100	15.6	–	9	7	3	11.5	7465604	TC-CUNF 1/2-20X15.6-ET45-11	
UNF 9/16	18	100	16.9	–	11	9	3	12.9	7465605	TC-CUNF 9/16-18X16.9-ET45-11	
UNF 5/8	18	100	18.5	–	12	9	3	14.5	7465606	TC-CUNF 5/8-18X18.5-ET45-11	
UNF 3/4	16	110	25.4	–	14	11	4	17.5	7465607	TC-CUNF 3/4-16X25.4-ET45-11	
UNF 7/8	14	125	28.2	–	18	14.5	4	20.4	7465608	TC-CUNF 7/8-14X28.2-ET45-11	
UNF 1	12	140	31.8	–	18	14.5	4	23.25	7465609	TC-CUNF 1-12X31.8-ET45-11	

■ = First choice □ = Second choice



Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■	v _c = 15–25 m/min							
P2	Steel 500–1000 N/mm ²	■	v _c = 10–20 m/min							
P3	Steel > 1000 N/mm ²	■	v _c = 8–15 m/min							
M1	Stainless steel austenitic	■	v _c = 6–12 m/min							
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■	v _c = 8–20 m/min							
N1	Alu- & Copper alloys long chipping < 5 % Si	■	v _c = 15–40 m/min							
N2	Alu- & Copper alloys long chipping 5–10 % Si	■	v _c = 15–40 m/min							
N3	Alu- & Copper alloys short chipping > 10 % Si	■	v _c = 10–30 m/min							
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code
with reinforced straight shank										
UNF No. 2	64	45	9	–	2.8	2.1	2	1.85	7465575	TC-BUNF #2-64X9-ET0-11
UNF No. 3	56	50	9	–	2.8	2.1	2	2.15	7465576	TC-BUNF #3-56X9-ET0-11
UNF No. 4	48	56	11	18	3.5	2.7	2	2.4	7465577	TC-BUNF #4-48X11-ET0-11
UNF No. 5	44	56	11	18	3.5	2.7	3	2.7	7465578	TC-BUNF #5-44X11-ET0-11
UNF No. 6	40	56	12	20	4	3	3	2.95	7465579	TC-BUNF #6-40X12-ET0-11
UNF No. 8	36	63	13	21	4.5	3.4	3	3.5	7465580	TC-BUNF #8-36X13-ET0-11
UNF No. 10	32	70	16	25	6	4.9	3	4.1	7465581	TC-BUNF #10-32X16-ET0-11
UNF 1/4	28	80	19	30	7	5.5	3	5.5	7465582	TC-BUNF 1/4-28X19-ET0-11
UNF 5/16	24	90	22	35	8	6.2	3	6.9	7465583	TC-BUNF 5/16-24X22-ET0-11
UNF 3/8	24	90	20	35	10	8	3	8.5	7465584	TC-BUNF 3/8-24X20-ET0-11
UNF 7/16	20	100	24	–	8	6.2	3	9.9	7465585	TC-BUNF 7/16-20X24-ET0-11
with standard straight shank										
UNF 1/2	20	100	22	–	9	7	3	11.5	7465586	TC-BUNF 1/2-20X22-ET0-11
UNF 9/16	18	100	22	–	11	9	3	12.9	7465587	TC-BUNF 9/16-18X22-ET0-11
UNF 5/8	18	100	22	–	12	9	3	14.5	7465588	TC-BUNF 5/8-18X22-ET0-11
UNF 3/4	16	110	25	–	14	11	3	17.5	7465589	TC-BUNF 3/4-16X25-ET0-11
UNF 7/8	14	125	25	–	18	14.5	3	20.4	7465590	TC-BUNF 7/8-14X25-ET0-11
UNF 1	12	140	28	–	18	14.5	3	23.25	7465591	TC-BUNF 1-12X28-ET0-11

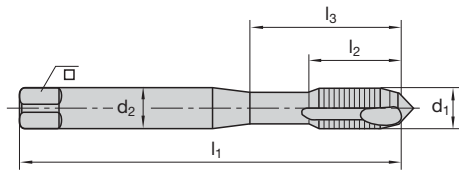
■ = First choice □ = Second choice



Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min								
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min								
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min								
M1	Stainless steel austenitic	■ v _c = 6–12 m/min								
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■ v _c = 8–20 m/min								
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min								
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min								
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min								
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	d ₂	□ h12	z		Ident No.	LMT-Code	
with standard straight shank										
G 1/16	28	90	9.1	6	4.9	3	6.8	7465524	TC-CG 1/16X9.1-ET45-11	
G 1/8	28	90	9.1	7	5.5	3	8.8	7465525	TC-CG 1/8X9.1-ET45-11	
G 1/4	19	100	13.4	11	9	3	11.8	7465526	TC-CG 1/4X13.4-ET45-11	
G 3/8	19	100	13.4	12	9	4	15.25	7465527	TC-CG 3/8X13.4-ET45-11	
G 1/2	14	125	18.2	16	12	4	19	7465528	TC-CG 1/2X18.2-ET45-11	
G 5/8	14	125	18.2	18	14.5	4	21	7465529	TC-CG 5/8X18.2-ET45-11	
G 3/4	14	140	28	20	16	4	24.5	7465530	TC-CG 3/4X28-ET45-11	
G 1	11	160	30	25	20	4	30.75	7465531	TC-CG 1X30-ET45-11	

Note: Excess length from G 1/8 to G 1 available on request

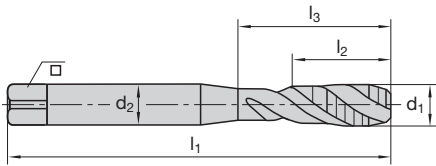
■ = First choice □ = Second choice



Cat.-No.		ET01									
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min									
P2	Steel 500–1000 N/mm ²	■ v _c = 10–20 m/min									
P3	Steel > 1000 N/mm ²	■ v _c = 8–15 m/min									
M1	Stainless steel austenitic	■ v _c = 6–12 m/min									
M2	Stainless steel martensitic										
K1	Grey cast iron										
K2	Nodular cast iron	■ v _c = 8–20 m/min									
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v _c = 15–40 m/min									
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v _c = 15–40 m/min									
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v _c = 10–30 m/min									
N4	Graphite										
S1	Titanium alloys medium strength < 900 N/mm ²										
S2	Titanium alloys high strength < 1300 N/mm ²										
H1	Chilled steel and Hardened steel 45–55 HRC										
d ₁	P	l ₁	l ₂	d ₂	□ h12	z		Ident No.	LMT-Code		
with standard straight shank											
G 1/16	28	90	20	6	4.9	3	6.8	7465510	TC-BG 1/16X20-ET0-11		
G 1/8	28	90	20	7	5.5	3	8.8	7465511	TC-BG 1/8X20-ET0-11		
G 1/4	19	100	22	11	9	3	11.8	7465512	TC-BG 1/4X22-ET0-11		
G 3/8	19	100	22	12	9	3	15.25	7465513	TC-BG 3/8X22-ET0-11		
G 1/2	14	125	25	16	12	3	19	7465514	TC-BG 1/2X25-ET0-11		
G 5/8	14	125	25	18	14.5	3	21	7465515	TC-BG 5/8X25-ET0-11		
G 3/4	14	140	28	20	16	4	24.5	7465516	TC-BG 3/4X28-ET0-11		
G 1	11	160	30	25	20	4	30.75	7465517	TC-BG 1X30-ET0-11		

Note: Excess length from G 1/8 to G 1 available on request

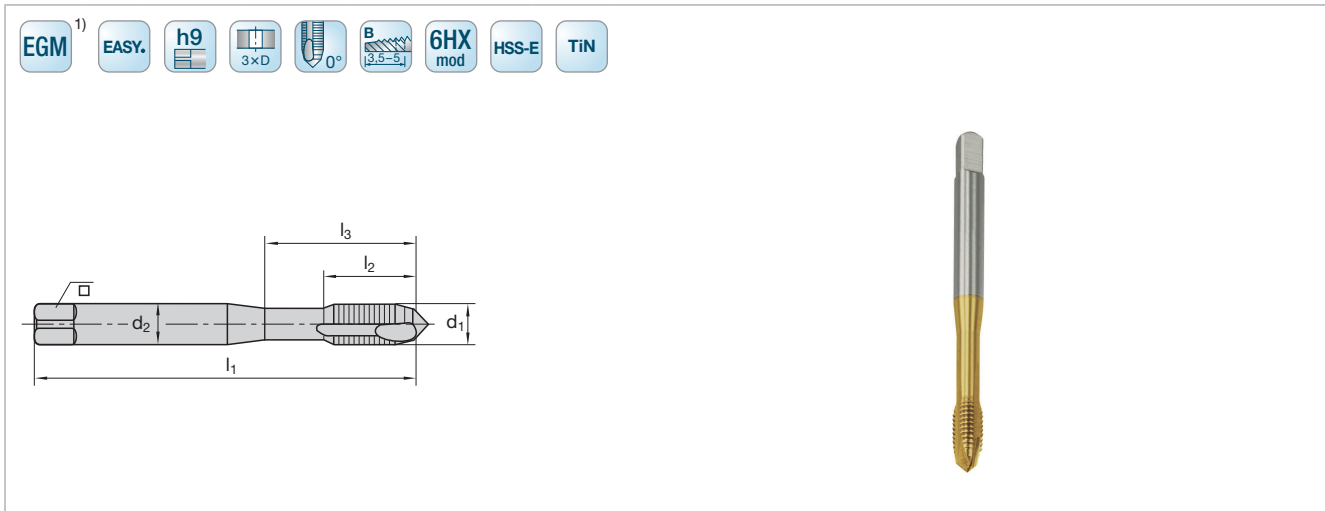
■ = First choice □ = Second choice



Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■	v _c = 15–25 m/min							
P2	Steel 500–1000 N/mm ²	■	v _c = 10–20 m/min							
P3	Steel > 1000 N/mm ²	■	v _c = 8–15 m/min							
M1	Stainless steel austenitic	■	v _c = 6–12 m/min							
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■	v _c = 8–20 m/min							
N1	Alu- & Copper alloys long chipping < 5 % Si	■	v _c = 15–40 m/min							
N2	Alu- & Copper alloys long chipping 5–10 % Si	■	v _c = 15–40 m/min							
N3	Alu- & Copper alloys short chipping > 10 % Si	■	v _c = 10–30 m/min							
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code
with reinforced straight shank										
EG M 2	0.4	50	4.5	13	2.8	2.1	2	2.1	7465499	TC-EEGM 2.52X0.4-6HX
EG M 2.5	0.45	56	5	18	3.5	2.7	3	2.65	7465500	TC-EEGM 3.085X0.45-6HX
EG M 3	0.5	63	5	21	4.5	3.4	3	3.15	7465501	TC-EEGM 3.65X0.5-6HX
EG M 4	0.7	70	7	25	6	4.9	3	4.2	7465502	TC-EEGM 4.909X0.7-6HX
EG M 5	0.8	80	8	30	6	4.9	3	5.25	7465503	TC-EEGM 6.039X0.8-6HX
EG M 6	1	90	10	35	8	6.2	3	6.3	7465504	TC-EEGM 7.299X1-6HX
EG M 8	1.25	100	13	39	10	8	3	8.4	7465505	TC-EEGM 9.624X1.25-6HX
with standard straight shank										
EG M10	1.5	100	15	–	9	7	3	10.5	7465506	TC-EEGM 11.949X1.5-6HX
EG M12	1.75	110	18	–	11	9	3	12.5	7465507	TC-EEGM 14.273X1.75-6HX
EG M16	2	125	20	–	14	11	4	16.5	7465508	TC-EEGM 18.598X2-6HX
EG M20	2.5	160	25	–	18	14.5	4	20.5	7465509	TC-EEGM 23.248X2.5-6HX

¹⁾ Metric insert thread for wire thread inserts

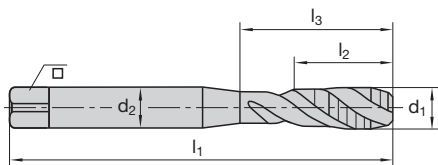
■ = First choice □ = Second choice



Cat.-No.		ET01								
P1	Steel < 500 N/mm ²	■	v _c = 15–25 m/min							
P2	Steel 500–1000 N/mm ²	■	v _c = 10–20 m/min							
P3	Steel > 1000 N/mm ²	■	v _c = 8–15 m/min							
M1	Stainless steel austenitic	■	v _c = 6–12 m/min							
M2	Stainless steel martensitic									
K1	Grey cast iron									
K2	Nodular cast iron	■	v _c = 8–20 m/min							
N1	Alu- & Copper alloys long chipping < 5 % Si	■	v _c = 15–40 m/min							
N2	Alu- & Copper alloys long chipping 5–10 % Si	■	v _c = 15–40 m/min							
N3	Alu- & Copper alloys short chipping > 10 % Si	■	v _c = 10–30 m/min							
N4	Graphite									
S1	Titanium alloys medium strength < 900 N/mm ²									
S2	Titanium alloys high strength < 1300 N/mm ²									
H1	Chilled steel and Hardened steel 45–55 HRC									
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z		Ident No.	LMT-Code
with reinforced straight shank										
EG M 2	0.4	50	9	–	2.8	2.1	2	2.1	7465488	TC-BEGM 2.52X0.4-6HX
EG M 2.5	0.45	56	11	18	3.5	2.7	3	2.65	7465489	TC-BEGM 3.085X0.45-6HX
EG M 3	0.5	63	13	21	4.5	3.4	3	3.15	7465490	TC-BEGM 3.65X0.5-6HX
EG M 4	0.7	70	16	25	6	4.9	3	4.2	7465491	TC-BEGM 4.909X0.7-6HX
EG M 5	0.8	80	19	30	6	4.9	3	5.25	7465492	TC-BEGM 6.039X0.8-6HX
EG M 6	1	90	22	35	8	6.2	3	6.3	7465493	TC-BEGM 7.299X1-6HX
EG M 8	1.25	100	24	39	10	8	3	8.4	7465494	TC-BEGM 9.624X1.25-6HX
with standard straight shank										
EG M10	1.5	100	29	–	9	7	3	10.5	7465495	TC-BEGM 11.949X1.5-6HX
EG M12	1.75	110	30	–	11	9	3	12.5	7465496	TC-BEGM 14.273X1.75-6HX
EG M16	2	125	34	–	14	11	3	16.5	7465497	TC-BEGM 18.598X2-6HX
EG M20	2.5	160	34	–	18	14.5	3	20.5	7465498	TC-BEGM 23.248X2.5-6HX

¹⁾ Metric insert thread for wire thread inserts

■ = First choice □ = Second choice



Cat.-No.		ET01							
P1	Steel < 500 N/mm ²	■	v _c = 15–25 m/min						
P2	Steel 500–1000 N/mm ²	■	v _c = 10–20 m/min						
P3	Steel > 1000 N/mm ²	■	v _c = 8–15 m/min						
M1	Stainless steel austenitic	■	v _c = 6–12 m/min						
M2	Stainless steel martensitic								
K1	Grey cast iron								
K2	Nodular cast iron	■	v _c = 8–20 m/min						
N1	Alu- & Copper alloys long chipping < 5 % Si	■	v _c = 15–40 m/min						
N2	Alu- & Copper alloys long chipping 5–10 % Si	■	v _c = 15–40 m/min						
N3	Alu- & Copper alloys short chipping > 10 % Si	■	v _c = 10–30 m/min						
N4	Graphite								
S1	Titanium alloys medium strength < 900 N/mm ²								
S2	Titanium alloys high strength < 1300 N/mm ²								
H1	Chilled steel and Hardened steel 45–55 HRC								
d ₁	P	l ₁	l ₂	d ₂	□ h12	z		Ident No.	LMT-Code
with standard straight shank									
NPT 1/16	27	90	18	6	4.9	3	6.4	7465610	TC-CNPT 1/16X18-ET40-11
NPT 1/8	27	90	19	7	5.5	3	8.7	7465611	TC-CNPT 1/8X19-ET40-11
NPT 1/4	18	100	28	11	9	3	11.4	7465612	TC-CNPT 1/4X28-ET40-11
NPT 3/8	18	100	28	12	9	4	14.7	7465613	TC-CNPT 3/8X28-ET40-11
NPT 1/2	14	125	35	16	12	4	18.3	7465614	TC-CNPT 1/2X35-ET40-11
NPT 3/4	14	140	35	20	16	4	23.7	7465615	TC-CNPT 3/4X35-ET40-11
NPT 1	11.5	160	45	25	20	4	29.7	7465616	TC-CNPT 1X45-ET40-11

■ = First choice □ = Second choice



Component: Locknut

Tool:

EASYTap, blind hole thread M12
 TC-CM 12X1.75-6HX-ET45-11, Ident No. 7465308

Material:

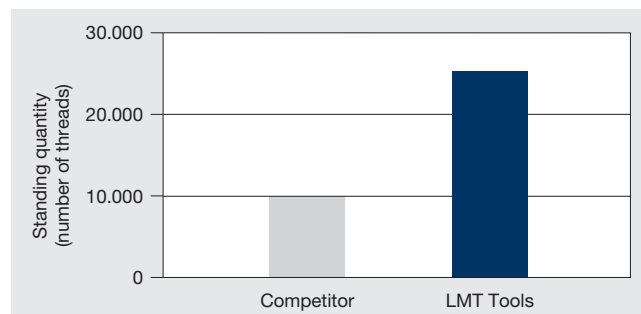
Stainless steel martensitic, 1.4104/X14CrMoS17,
 $R_m = 730 \text{ N/mm}^2$

Cutting data:

$v_c = 12 \text{ m/min}$

Further details:

Thread depth: 12 mm, Cooling: Emulsion with 8 % oil content



Component: Profile

Tool:

EASYTap, through hole M12
 TC-BM 12X1.75-6HX-ET0-11, Ident No. 7465217

Material:

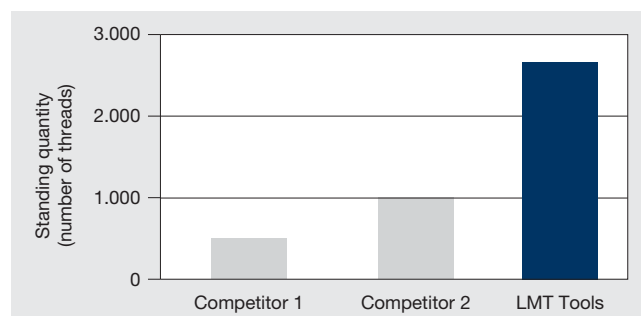
Stainless steel austenitic, 1.4404/X2CrNiMo17-12-2,
 $R_m = 700 \text{ N/mm}^2$

Cutting data:

$v_c = 15 \text{ m/min}$

Further details:

Thread depth: 20 mm, Cooling: Emulsion with 8 % oil content



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