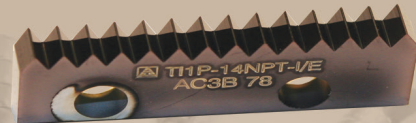




TOOLFLO

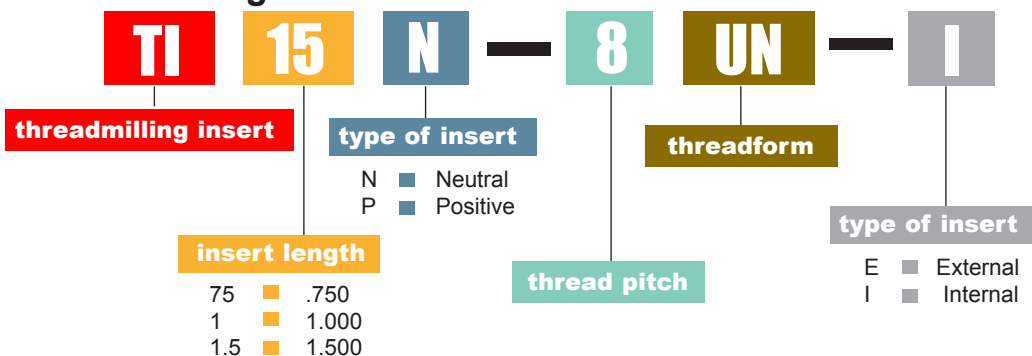


THREAD MILLING

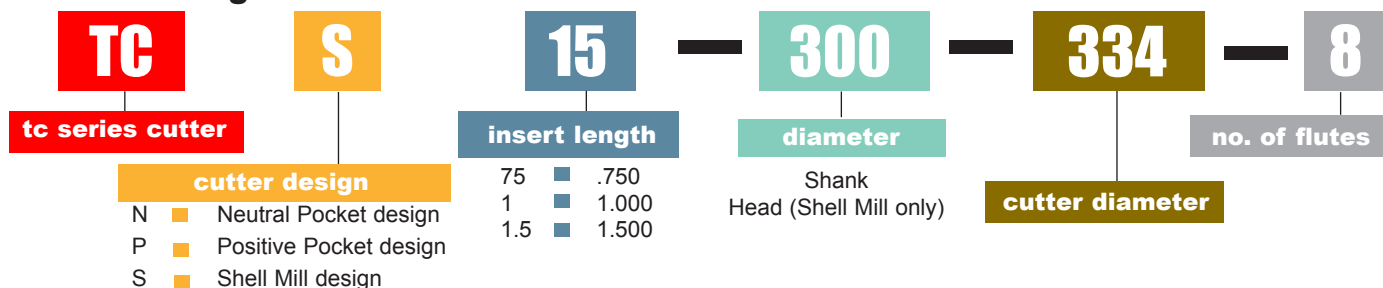
TC SERIES THREADMILLING



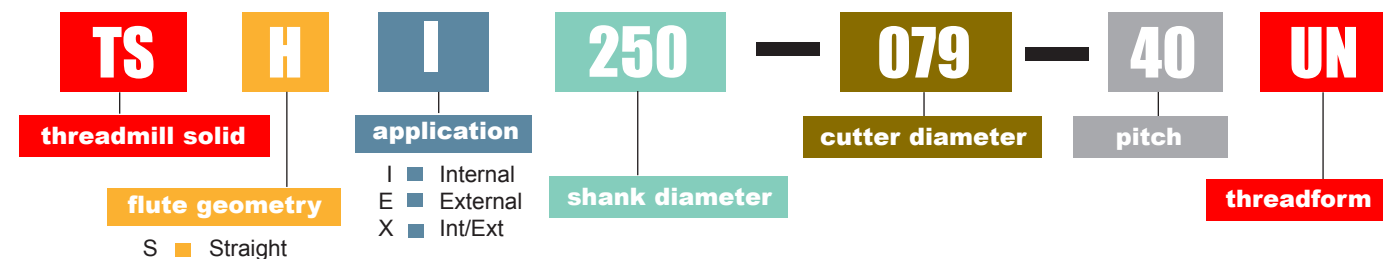
Threadmilling Insert Nomenclature Chart



Threadmilling Cutter Nomenclature Chart



Solid Threadmill Nomenclature Chart



TCT/TCN

- TCT cutters offer tapered head to accommodate NPT and NPTF style inserts
- TCN cutters offer straight head to accommodate UN and ISO style inserts
- Inserts are CNC ground to tolerance of ± 0.0005 effective in the cutter
- Positive geometry provides high shear action which results in better quality threads

TCP

- Cutters feature our patented locking system for accurate indexes
- Inserts are CNC ground to tolerance of ± 0.0005 effective in the cutter
- Positive geometry provides high shear action which results in better quality threads
- Design allows for maximum number of flutes in minimum part diameter

TCS

- Cutters feature our patented locking system for accurate indexes
- Inserts are CNC ground to tolerance of ± 0.0005 effective in the cutter
- Positive geometry provides high shear action which results in better quality threads
- Design allows for maximum number of flutes in minimum part diameter
- Run at high speeds to reduce machining time by as much as 50%

TSSI/X

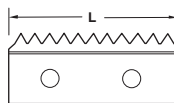
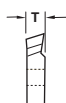
- Produce better quality threads than tapping
- Excels in materials that are difficult to cut

BSPT THREADING

TI_P

Positive Rake

Internal/External



Description	EDP Code	Pitch	L	T	C3	GP3	ZS3
TI75P-19BSPT-I/E	TMIA4419I/E	19	.750	.080		●	●
TI1P-19BSPT-I/E	TMIB4419I/E	19	1.000	.140		●	●
TI1P-14BSPT-I/E	TMIB4414I/E	14	1.000	.140		●	●
TI1N-11BSPT-I/E - Neutral Rake	TMIC4411I/E	11	1.000	.140		●	●

Uncoated	TiN Coated	AlTiN Coated



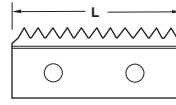
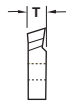
TC SERIES THREADMILLING

BSPP THREADING

TI_P

Positive Rake

Internal/External



	Uncoated	TiN Coated	AlTiN Coated
C3	●	●	●
GP3	●	●	●
ZS3	●	●	●

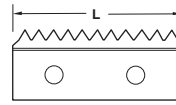
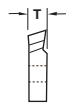
Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI75P-19BSPP-I/E	TMIA4419I/E	19	.750	.080	●	●	●
TI1P-19BSPP-I/E	TMIB4419I/E	19	1.000	.140	●	●	●
TI1P-14BSPP-I/E	TMIB4414I/E	14	1.000	.140	●	●	●

NPT/NPTF THREADING

TI_P

Positive Rake

Internal/External



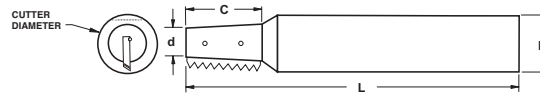
Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI75P-18NPT-I/E	TMIA3618I/E	18	.750	.080	●	●	●
TI75P-18NPTF-I/E	TMIA4618I/E	18	.750	.080	●	●	●
TI1P-14NPT-I/E	TMIB3614I/E	14	1.000	.140	●	●	●
TI1P-14NPTF-I/E	TMIB4614I/E	14	1.000	.140	●	●	●

NPT/NPTF THREADING

TCT_

Cutter Bodies

Internal/External



Description	EDP Code	Insert	D	d	L	Cutter Dia	C	Flutes	Screw*
TCT75-500-400-1	TMTA084001	TI75P-18NPT/NPTF/BSPT	.500	.229	3.000	.400	.750	1	TS250
TCT1-500-659-1	TMTB086591	TI1P-14NPT/NPTF/BSPT	.500	.379	3.000	.659	1.000	1	TS45

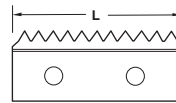
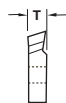
*TS250 uses K-2 wrench, TS45 uses K-3 wrench

UN THREADING

TI_P

Positive Rake

Internal



Description	EDP Code	Pitch	L	T	C3	GP3	ZS3
TI75P-32UN-I	TMIA6632I	32	.750	.080	●	●	●
TI75P-24UN-I	TMIA6624I	24	.750	.080	●	●	●
TI75P-20UN-I	TMIA6620I	20	.750	.080	●	●	●
TI75P-18UN-I	TMIA6618I	18	.750	.080	●	●	●
TI75P-16UN-I	TMIA6616I	16	.750	.080	●	●	●
TI1P-32UN-I	TMIB6632I	32	1.000	.140	●	●	●
TI1P-24UN-I	TMIB6624I	24	1.000	.140	●	●	●
TI1P-20UN-I	TMIB6620I	20	1.000	.140	●	●	●
TI1P-18UN-I	TMIB6618I	18	1.000	.140	●	●	●
TI1P-16UN-I	TMIB6616I	16	1.000	.140	●	●	●
TI1P-14UN-I	TMIB6614I	14	1.000	.140	●	●	●
TI1P-12UN-I	TMIB6612I	12	1.000	.140	●	●	●
TI1P-10UN-I*	TMIB6610I	10	1.000	.140	●	●	●

*To be used in TCN1 750-611-1 cutter only.

THREAD
MILLING

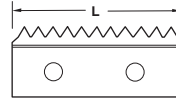
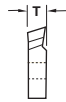
TC SERIES THREADMILLING

UNJ THREADING

TI_P

Positive Rake

Internal



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
T175P-32UNJ-I	TMIA6832I	32	.750	.080			
T175P-24UNJ-I	TMIA6824I	24	.750	.080			
T175P-20UNJ-I	TMIA6820I	20	.750	.080			
T175P-18UNJ-I	TMIA6818I	18	.750	.080			
T175P-16UNJ-I	TMIA6816I	16	.750	.080			
T11P-32UNJ-I	TMIB6832I	32	1.000	.140			
T11P-24UNJ-I	TMIB6824I	24	1.000	.140			
T11P-20UNJ-I	TMIB6820I	20	1.000	.140			
T11P-18UNJ-I	TMIB6818I	18	1.000	.140			
T11P-16UNJ-I	TMIB6816I	16	1.000	.140			
T11P-14UNJ-I	TMIB6814I	14	1.000	.140			
T11P-12UNJ-I	TMIB6812I	12	1.000	.140			
T11P-10UNJ-I	TMIB6810I	10	1.000	.140			



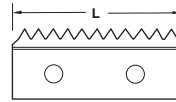
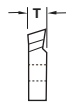
Uncoated	TIN Coated	AlTiN Coated

ISO THREADING

TI_P

Positive Rake

Internal



Description	EDP Code	Pitch	L	T	C3	GP3	ZS3
T175P-1.5 ISO-I	TMIA7015I	1,5	.750	.080			
T175P-1.25 ISO-I	TMIA70125I	1,25	.750	.080			
T175P-1.0 ISO-I	TMIA7010I	1,0	.750	.080			
T175P-0.5 ISO-I	TMIA7005I	0,5	.750	.080			
T11P-2.0 ISO-I	TMIB7020I	2,0	1.000	.140			
T11P-1.5 ISO-I	TMIB7015I	1,5	1.000	.140			
T11P-1.0 ISO-I	TMIB7010I	1,0	1.000	.140			

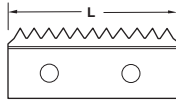
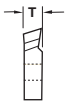
Uncoated	TIN Coated	AlTiN Coated

UN THREADING

TI_P

Positive Rake

External



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
T175P-32UN-E	TMIA6632E	32	.750	.080			
T175P-24UN-E	TMIA6624E	24	.750	.080			
T175P-20UN-E	TMIA6620E	20	.750	.080			
T175P-18UN-E	TMIA6618E	18	.750	.080			
T175P-16UN-E	TMIA6616E	16	.750	.080			
T11P-32UN-E	TMIB6632E	32	1.000	.140			
T11P-24UN-E	TMIB6624E	24	1.000	.140			
T11P-20UN-E	TMIB6620E	20	1.000	.140			
T11P-18UN-E	TMIB6618E	18	1.000	.140			
T11P-16UN-E	TMIB6616E	16	1.000	.140			
T11P-12UN-E	TMIB6612E	12	1.000	.140			

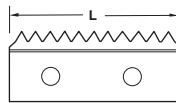
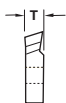
Uncoated	TIN Coated	AlTiN Coated

UNJ THREADING

TI_P

Positive Rake

External



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
T175P-32UNJ-E	TMIA6832E	32	.750	.080			
T175P-24UNJ-E	TMIA6824E	24	.750	.080			
T175P-20UNJ-E	TMIA6820E	20	.750	.080			
T175P-18UNJ-E	TMIA6818E	18	.750	.080			
T175P-16UNJ-E	TMIA6816E	16	.750	.080			
T11P-32UNJ-E	TMIB6832E	32	1.000	.140			
T11P-24UNJ-E	TMIB6824E	24	1.000	.140			
T11P-20UNJ-E	TMIB6820E	20	1.000	.140			
T11P-18UNJ-E	TMIB6818E	18	1.000	.140			
T11P-16UNJ-E	TMIB6816E	16	1.000	.140			
T11P-12UNJ-E	TMIB6812E	12	1.000	.140			

Uncoated	TIN Coated	AlTiN Coated



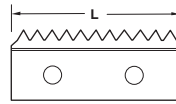
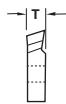
TC SERIES THREADMILLING

ISO THREADING

TI1P

Positive Rake

■ External



Description	EDP Code	Pitch	L	T	C3	GP3	ZS3
TI1P-2.0 ISO-E	TMIB7020E	2.0	1.000	.140		●	●
TI1P-1.5 ISO-E	TMIB7015E	1.5	1.000	.140		●	●
TI1P-1.0 ISO-E	TMIB7010E	1.0	1.000	.140		●	●

Uncoated	TIN Coated	AlTiN Coated

UN THREADING

TCN

Cutter Bodies

■ Internal/External



Description	EDP Code	Insert	D	d	L	Cutter Dia	C	Flutes	Screw*
TCN75-500-394-1	TMNA083941	TI75P-UN/ISO/BSPP/NGT/SGT/UNJ	.500	.250	3.000	.394	.750	1	TS250
TCN75-500-468-1	TMNA084681	TI75P-UN/ISO/BSPP/NGT/SGT/UNJ	.500	.330	3.500	.468	.750	1	TS25
TCN1-750-625-1	TMNB126251	TI1P-UN/ISO/BSPP/NGT/SGT/UNJ	.750	.454	3.500	.625	1.000	1	TS40
TCN1-750-611-1	TMNB126111	TI1P-10UN	.750	.383	3.500	.611	1.000	1	TS40

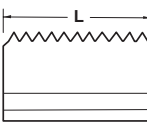
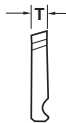
*TS250 and TS25 uses K-2 wrench, TS40 uses K-3 wrench

NGT/SGT THREADING

TI_N

Neutral Rake

■ Internal/External



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI15N-14NGT-I/E	TMID4714I/E	14	1.500	.140		●	●
TI15N-14SGT-I/E	TMID4914I/E	14	1.500	.140		●	●

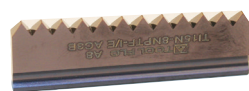
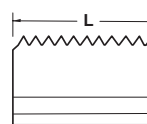
Uncoated	TIN Coated	AlTiN Coated

NPT/NPTF THREADING

TI_N

Neutral Rake

■ Internal/External



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI15N-11.5NPT-I/E	TMID3611I/E	11.5	1.500	.140		●	●
TI15N-11.5NPTF-I/E	TMID4611I/E	11.5	1.500	.140		●	●
TI15N-8NPT-I/E	TMID3608I/E	8	1.500	.140		●	●
TI15N-8NPTF-I/E	TMID4608I/E	8	1.500	.140		●	●

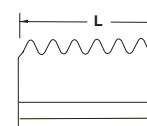
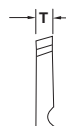
Uncoated	TIN Coated	AlTiN Coated

API ROUND THREADING

TI15N

Neutral Rake

■ Internal/External



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI15N-10RD-I/E	TMID3410I/E	10	1.500	.140		●	●
TI15N-8RD-I/E	TMID3200I/E	8	1.500	.140		●	●

Uncoated	TIN Coated	AlTiN Coated

THREAD
MILLING

TC SERIES THREADMILLING

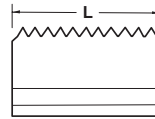
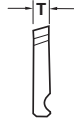


UN THREADING

TI_N

Neutral Rake

Internal



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI1N-32UN-I	TMIC6632I	32	1.000	.140			
TI1N-24UN-I	TMIC6624I	24	1.000	.140			
TI1N-20UN-I	TMIC6620I	20	1.000	.140			
TI1N-18UN-I	TMIC6618I	18	1.000	.140			
TI1N-16UN-I	TMIC6616I	16	1.000	.140			
TI1N-12UN-I	TMIC6612I	12	1.000	.140			
TI1N-10UN-I	TMIC6610I	10	1.000	.140			
TI15N-24UN-I	TMID6624I	24	1.500	.140			
TI15N-20UN-I	TMID6620I	20	1.500	.140			
TI15N-18UN-I	TMID6618I	18	1.500	.140			
TI15N-16UN-I	TMID6616I	16	1.500	.140			
TI15N-14UN-I	TMID6614I	14	1.500	.140			
TI15N-12UN-I	TMID6612I	12	1.500	.140			
TI15N-10UN-I	TMID6610I	10	1.500	.140			
TI15N-8UN-I	TMID6608I	8	1.500	.140			
TI15N-7UN-I	TMID6607I	7	1.500	.140			
TI15N-6UN-I	TMID6606I	6	1.500	.140			

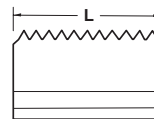
Uncoated	TIN Coated	AlTiN Coated

UNJ THREADING

TI_N

Neutral Rake

Internal



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI1N-32UNJ-I	TMIC6832I	32	1.000	.140			
TI1N-24UNJ-I	TMIC6824I	24	1.000	.140			
TI1N-20UNJ-I	TMIC6820I	20	1.000	.140			
TI1N-18UNJ-I	TMIC6818I	18	1.000	.140			
TI1N-16UNJ-I	TMIC6816I	16	1.000	.140			
TI1N-12UNJ-I	TMIC6812I	12	1.000	.140			
TI1N-10UNJ-I	TMIC6810I	10	1.000	.140			
TI15N-24UNJ-I	TMID6824I	24	1.500	.140			
TI15N-20UNJ-I	TMID6820I	20	1.500	.140			
TI15N-18UNJ-I	TMID6818I	18	1.500	.140			
TI15N-16UNJ-I	TMID6816I	16	1.500	.140			
TI15N-12UNJ-I	TMID6812I	12	1.500	.140			
TI15N-10UNJ-I	TMID6810I	10	1.500	.140			
TI15N-8UNJ-I	TMID6808I	8	1.500	.140			

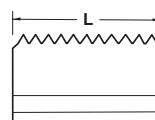
Uncoated	TIN Coated	AlTiN Coated

ISO THREADING

TI15N

Neutral Rake

Internal



Description	EDP Code	TPI	L	T	C3	GP3	ZS3
TI15N-6.0 ISO-I	TMID7060I	6.0	1.500	.140			
TI15N-5.0 ISO-I	TMID7050I	5.0	1.500	.140			
TI15N-4.5 ISO-I	TMID7045I	4.5	1.500	.140			
TI15N-4.0 ISO-I	TMID7040I	4.0	1.500	.140			
TI15N-3.5 ISO-I	TMID7035I	3.5	1.500	.140			
TI15N-3.0 ISO-I	TMID7030I	3.0	1.500	.140			
TI15N-2.5 ISO-I	TMID7025I	2.5	1.500	.140			
TI15N-2.0 ISO-I	TMID7020I	2.0	1.500	.140			
TI15N-1.5 ISO-I	TMID7015I	1.5	1.500	.140			

Uncoated	TIN Coated	AlTiN Coated



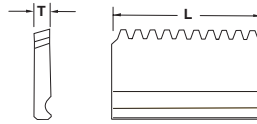
TC SERIES THREADMILLING

ACME THREADING

TI_N

Neutral Rake - Full Profile

Internal/External



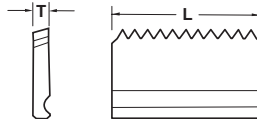
Description	EDP Code	TPI	L	T	C3	GP3	ZS3	Uncoated	TIN Coated	AlTiN Coated
TI1N-12ACME-I/E	TMIC0212I/E	12	1.000	.140						
TI1N-10ACME-I/E	TMIC0210I/E	10	1.000	.140						
TI1N-8ACME-I/E	TMIC0208I/E	8	1.000	.140						
TI15N-12ACME-I/E	TMID0212I/E	12	1.500	.140						
TI15N-10ACME-I/E	TMID0210I/E	10	1.500	.140						
TI15N-8ACME-I/E	TMID0208I/E	8	1.500	.140						
TI15N-6ACME-I/E	TMID0206I/E	6	1.500	.140						
TI15N-5ACME-I/E	TMID0205I/E	5	1.500	.140						
TI15N-4ACME-I/E	TMID0204I/E	4	1.500	.140						

UN THREADING

TI_N

Neutral Rake

External



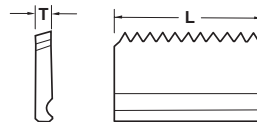
Description	EDP Code	TPI	L	T	C3	GP3	ZS3	Uncoated	TIN Coated	AlTiN Coated
TI1N-32UN-E	TMIC6632E	32	1.000	.140						
TI1N-24UN-E	TMIC6624E	24	1.000	.140						
TI1N-20UN-E	TMIC6620E	20	1.000	.140						
TI1N-18UN-E	TMIC6618E	18	1.000	.140						
TI1N-16UN-E	TMIC6616E	16	1.000	.140						
TI1N-12UN-E	TMIC6612E	12	1.000	.140						
TI1N-10UN-E	TMIC6610E	10	1.000	.140						
TI15N-24UN-E	TMID6624E	24	1.500	.140						
TI15N-20UN-E	TMID6620E	20	1.500	.140						
TI15N-18UN-E	TMID6618E	18	1.500	.140						
TI15N-16UN-E	TMID6616E	16	1.500	.140						
TI15N-12UN-E	TMID6612E	12	1.500	.140						
TI15N-10UN-E	TMID6610E	10	1.500	.140						
TI15N-8UN-E	TMID6608E	8	1.500	.140						
TI15N-6UN-E	TMID6606E	6	1.500	.140						

UNJ THREADING

TI_N

Neutral Rake

External



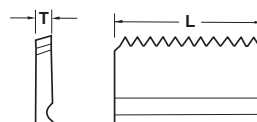
Description	EDP Code	TPI	L	T	C3	GP3	ZS3	Uncoated	TIN Coated	AlTiN Coated
TI1N-32UNJ-E	TMIC6832E	32	1.000	.140						
TI1N-24UNJ-E	TMIC6824E	24	1.000	.140						
TI1N-20UNJ-E	TMIC6820E	20	1.000	.140						
TI1N-18UNJ-E	TMIC6818E	18	1.000	.140						
TI1N-16UNJ-E	TMIC6816E	16	1.000	.140						
TI1N-12UNJ-E	TMIC6812E	12	1.000	.140						
TI1N-10UNJ-E	TMIC6810E	10	1.000	.140						
TI15N-24UNJ-E	TMID6824E	24	1.500	.140						
TI15N-20UNJ-E	TMID6820E	20	1.500	.140						
TI15N-18UNJ-E	TMID6818E	18	1.500	.140						
TI15N-16UNJ-E	TMID6816E	16	1.500	.140						
TI15N-12UNJ-E	TMID6812E	12	1.500	.140						
TI15N-10UNJ-E	TMID6810E	10	1.500	.140						
TI15N-8UNJ-E	TMID6808E	8	1.500	.140						

ISO THREADING

TI15N

Neutral Rake

External



Description	EDP Code	TPI	L	T	C3	GP3	ZS3	Uncoated	TIN Coated	AlTiN Coated
TI15N-6.0 ISO-E	TMID7060E	6.0	1.500	.140						
TI15N-5.0 ISO-E	TMID7050E	5.0	1.500	.140						
TI15N-4.5 ISO-E	TMID7045E	4.5	1.500	.140						
TI15N-4.0 ISO-E	TMID7040E	4.0	1.500	.140						
TI15N-2.0 ISO-E	TMID7020E	2.0	1.500	.140						

THREAD
MILLING

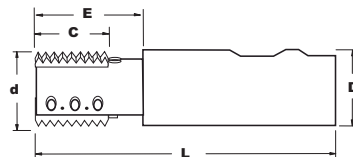
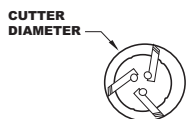
TC SERIES THREADMILLING



UN/NPT/ISO/ACME/API THREADING

TCP Cutter Bodies

Internal/External

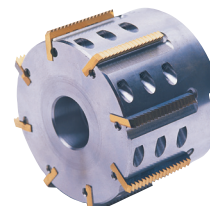
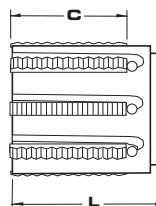
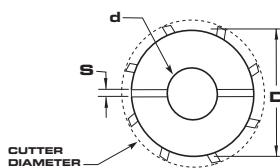


Description	EDP Code	Insert	Coolant Port	D	d	E	L	Cutter Dia. (UN/115NPT)	Cutter Dia. (8NPT)	C	Flutes	Screw	Pin
TCP1 100-969-2	TMPB169692	TI1N		1.000	.750	1.500	4.500	.969	.969	1.000	2	TSS-3	DP1
TCP1 125-175-5	TMPB201755	TI1N	✓	1.250	1.500	1.750	4.000	1.755	1.755	1.000	5	TSS-2	DP1
TCP15 100-932-1	TMPC169321	TI15N		1.000	.722	1.900	4.500	.932	1.065	1.500	1	TSS-2	DP135
TCP15 100-111-3	TMPC161113	TI15N	✓	1.000	.812	2.000	4.500	1.116	1.247	1.500	3	TSS-3	DP135
TCP15 125-175-5	TMPC201755	TI15N	✓	1.250	1.500	2.550	4.500	1.755	1.888	1.500	5	TSS-2	DP135
TCP15 125-175-5L	TMPC201755L	TI15N	✓	1.250	1.500	2.750	8.750	1.755	1.888	1.500	5	TSS-2	DP135

UN/NPT/ISO/ACME THREADING

TCS Shell Mill Cutter Bodies

Internal/External

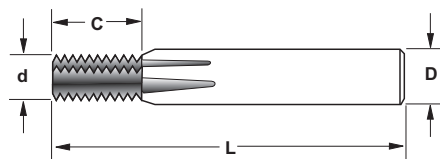


Description	EDP Code	Insert	D	d	S	L	Cutter Dia.	C	Flutes	Pin	Screw
TCS15 200-234-6	TMSC322346	TI15N	2.000	.750	.250	2.250	2.349	1.500	6	DP135	TSS-2
TCS15 250-274-7	TMSC402747	TI15N	2.500	1.000	.375	2.250	2.846	1.500	7	DP135	TSS-2
TCS15 300-334-8	TMSC483348	TI15N	3.000	1.250	.500	2.250	3.341	1.500	8	DP135	TSS-2

UN THREADING

TSSI Solid Threadmills

Internal

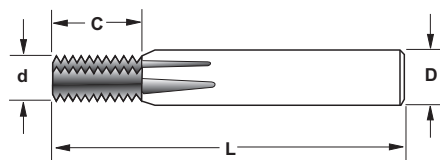


Min. I.D. Thread/Pitch	Description	EDP Code	d	C	Flutes	D	L	AC22
8-32	TSSI 125-120-32UN	TMCS0012032U	.120	.250	3	.125	1.500	●
12-24	TSSI 187-140-24UN	TMCS0114024U	.140	.417	3	.187	1.650	●
12-28	TSSI 187-145-28UN	TMCS0114528U	.145	.321	3	.187	1.650	●
10-32	TSSI 187-140-32UN	TMCS0114032U	.140	.343	3	.187	1.650	●
1/4-20	TSSI 187-160-20UN	TMCS0116020U	.160	.400	3	.187	1.650	●
5/16-18	TSSI 250-200-18UN	TMCS0220018U	.200	.500	3	.250	2.250	●
5/16-24	TSSI 250-200-24UN	TMCS0220024U	.200	.500	3	.250	2.250	●
3/8-16	TSSI 250-240-16UN	TMCS0224016U	.240	.563	5	.250	2.250	●
3/8-24	TSSI 250-240-24UN	TMCS0224024U	.240	.583	5	.250	2.250	●
7/16-14	TSSI 312-310-14UN	TMCS0431014U	.310	.625	5	.312	2.480	●
7/16-20	TSSI 312-310-20UN	TMCS0431020U	.310	.750	5	.312	2.480	●
1/2-13	TSSI 312-310-13UN	TMCS0431013U	.310	.769	5	.312	2.480	●
9/16-12	TSSI 375-375-12UN	TMCS0637512U	.375	.917	5	.375	2.840	●
9/16-18	TSSI 375-370-18UN	TMCS0637518U	.370	.944	5	.375	2.840	●
5/8-11	TSSI 500-437-11UN	TMCS0843711U	.437	1.090	5	.500	3.270	●
3/4-10	TSSI 500-470-10UN	TMCS0847010U	.470	1.100	5	.500	3.270	●
3/4-12	TSSI 500-470-12UN	TMCS0847012U	.470	1.167	5	.500	3.270	●
7/8-14	TSSI 500-470-14UN	TMCS0847014U	.470	1.142	5	.500	3.270	●
1-8	TSSI 625-620-8UN	TMCS1062008U	.620	1.500	6	.625	3.620	●

NPT THREADING

TSSX Solid Threadmills

Internal/External



Min. I.D. Thread/Pitch	Description	EDP Code	d	C	Flutes	D	L	AC22
1/16&1/8-27	TSSX 250-240-27NPT	TMCS0224027N	.240	.370	5	.250	2.250	●
1/4&3/8-18	TSSX 312-310-18NPT	TMCS0431018N	.310	.556	5	.312	2.480	●
1/2&3/4-14	TSSX 500-470-14NPT	TMCS0847014N	.470	.786	5	.500	3.270	●



TC SERIES THREADMILLING

Threadmilling Kits



NPT THREADING KITS

18NPT-THREADING

KIT #101

Kit Contents

1	TCT75 500-400-1
4	TI75-18NPT AC3
1	T8 WRENCH
1	TS252 INSERT SCREW

14NPT-THREADING

KIT #102

Kit Contents

1	TCT1 500-659-1
4	TI1P-14NPT AC3
1	T8 WRENCH
1	TS252 INSERT SCREW

UN THREADING KITS

16UN-THREADING

KIT #201

Kit Contents

1	TCN75 500-394-1
4	TI75P-16UN AC3
1	T8 WRENCH
1	TS252 INSERT SCREW

18UN-THREADING

KIT #202

Kit Contents

1	TCN75 500-394-1
4	TI75P-18UN AC3
1	T8 WRENCH
1	TS252 INSERT SCREW

20UN-THREADING

KIT #203

Kit Contents

1	TCN75 500-394-1
4	TI75P-20UN AC3
1	T8 WRENCH
1	TS252 INSERT SCREW

24UN-THREADING

KIT #204

Kit Contents

1	TCN75 500-394-1
4	TI75P-24UN AC3
1	T6 WRENCH
1	TS252 INSERT SCREW

32UN-THREADING

KIT #205

Kit Contents

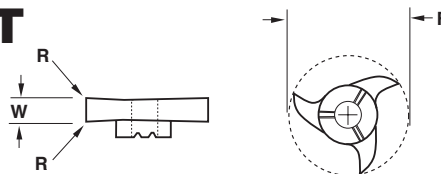
1	TCN75 500-394-1
4	TI75P-32UN AC3
1	T6 WRENCH
1	TS252 INSERT SCREW

*We welcome specials!
Please call us with your
specs.*

MILL GROOVING INSERT

TFMG

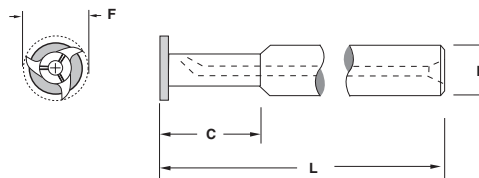
Grooving



Description	EDP Code	W	D.O.C.	R	F	GP22
TFMG-039W	9MG039	0.039	.177	-	0.854	●
TFMG-056W	9MG056	0.056	.177	-	0.854	●
TFMG-062W	9MG062	0.062	.177	0.008	0.854	●
TFMG-078W	9MG078	0.078	.177	0.008	0.854	●
TFMG-094W	9MG094	0.094	.177	0.008	0.854	●
TFMG-125W	9MG125	0.125	.177	0.008	0.854	●
TFMG-187W	9MG187	0.187	.177	0.008	0.854	●
TFMG-250W	9MG250	0.250	.177	0.008	0.854	●

MILL GROOVING HOLDER

TFM



Description	EDP Code	C	L	D	F	Insert Screw
TFM-7-12M-100C	9CMI712M100	Straight shank	100mm	12mm	0.854	SD25
TFM-7-12M-130C	9CMI712M130	Straight shank	130mm	12mm	0.854	SD25
TFM-7-16M-42C	9CMI716M42	42mm	100mm	16mm	0.854	SD25
TFM-7-16M-60C	9CMI716M60	60mm	130mm	16mm	0.854	SD25
TFM-7-16M-85C	9CMI716M85	85mm	160mm	16mm	0.854	SD25
TFM-7-500-394C	9CMI7500394	Straight shank	3.94	0.500	0.854	SD25
TFM-7-500-512C	9CMI7500512	Straight shank	5.12	0.500	0.854	SD25
TFM-7-625-165C	9CMI7625165	1.650	3.94	0.625	0.854	SD25
TFM-7-625-236C	9CMI7625236	2.630	5.12	0.625	0.854	SD25
TFM-7-625-335C	9CMI7625335	3.350	6.30	0.625	0.854	SD25

THREAD
MILLING



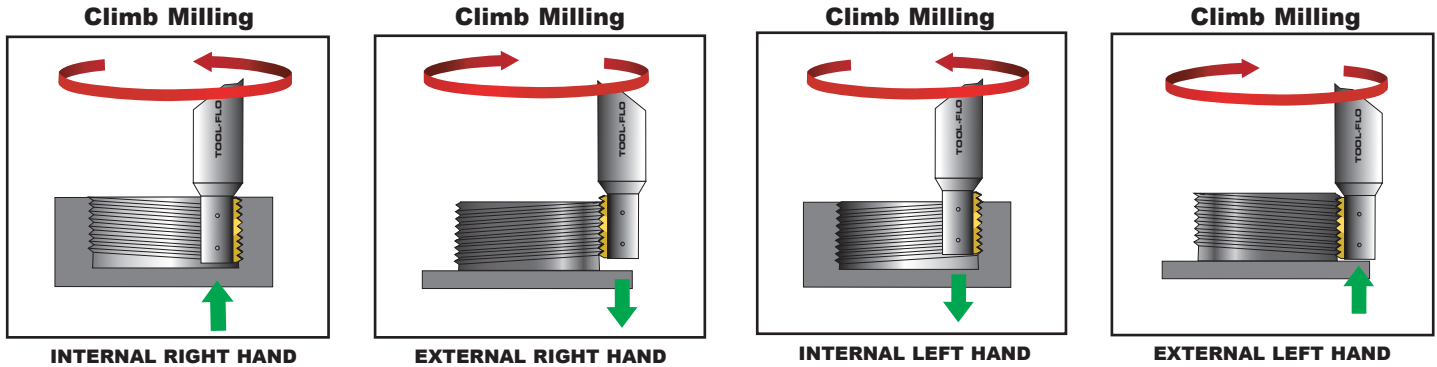
Technical Information

NPT & NPTF

When programming an NPT or NPTF thread form, a correction factor to compensate for the tapered thread form may need to be made. This is achieved by dividing the circular move into quarters or eighths, and moving the cutter out as the arc is generated so that the taper is included in the movement. The amount of taper for a given form is determined by the following formula:

$$\text{Taper per pitch} = \frac{.0625''}{\text{pitch}}$$

This amount of taper per pitch is then divided by number of programmed quadrants. This determines the amount that the cutter forms of the thread.



NPT SELECTION CHART		
SIZE	CUTTER	INSERT
1/4", 3/8"	TCT75 500-400-1	TI75P-18NPT
1/2", 3/4"	TCT1 500-659-1	TI1P-14NPT
1"	TCP15 100-932-1	TI15N-11.5NPT
1-1/4", 1-1/2"	TCP15 100-111-3	TI15N-11.5NPT
2"	TCP15 125-175-5	TI15N-11.5NPT
3"	TCP15 125-175-5	TI15N-8NPT

RECOMMENDED SPEED AND FEED RATES		
MATERIAL	CHIP LOAD	SPEED (SFPM)
1018 Steel	.0008 - .002	250 - 500
Standard steel (4140)	.0005 - .002	175 - 350
300 Series Stainless	.0005 - .0035	250 - 500
400 Series Stainless	.0002 - .0015	125 - 300
Gray Iron	.0005 - .003	400 - 800
Ductile iron	.001 - .005	600 - 1000
Aluminum	.0015 - .006	800 - 1200
Brass	.002 - .0065	400 - 700

Minimum internal thread size vs pitch for given cutter body for UN threads

cutter body description	pitch	32	24	20	18	16	14	12	10	8
TCN75 500-394-1		1/2"	1/2"	1/2"	9/16"	9/16"	9/16"	9/16"		
TCN75 500-468-1		5/8"	5/8"	5/8"	5/8"	5/8"	11/16"	11/16"		
TCN1 750-625-1		3/4"	3/4"	3/4"	3/4"	3/4"	3/4"	3/4"		
TCP1 100-969-2		1-1/8"	1-1/8"	1-1/8"	1-3/16"	1-3/16"	1-3/16"	1-3/16"		
TCP1 125-175-5		1-15/16"	1-15/16"	1-15/16"	1-15/16"	1-15/16"	1-15/16"	1-15/16"		
TCP15 100-932-1				1-1/8"	1-1/8"	1-1/8"	1-1/8"	1-1/8"	1-1/8"	1-1/8"
TCP15 100-111-3				1-5/16"	1-5/16"	1-5/16"	1-5/16"	1-5/16"	1-3/8"	1-3/8"
TCP15 125-175-5				1-15/16"	1-15/16"	1-15/16"	2"	2"	2"	2"