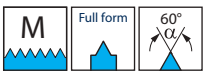

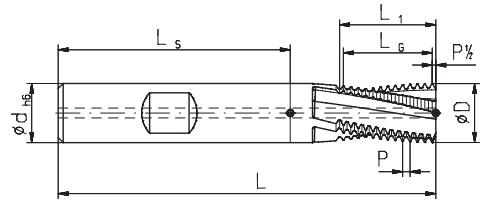
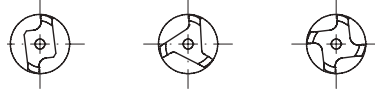
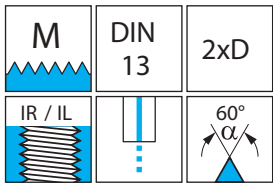


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<b>Metric Internal Fine Thread</b> 	Fixed dimension Universal with chamfer	M5 - M20 M10 - >M27 M8 - M20	52 52 53
<b>Whitworth Pipe Thread</b> 	Fixed dimension Universal with chamfer	1/8" - 1/2" 1/4" - >1" 1/16" - 5/8"	53 54 54
<b>British Standard Whitworth Thread</b> 	Fixed dimension	5/16" - 5/8"	55
<b>British Standard Fine Thread</b> 	Fixed dimension	5/16" - 5/8"	55
<b>Unified National Coarse Thread</b> 	Fixed dimension with chamfer	1/4" - 1/2" 1/4" - 3/4"	56 56
<b>Unified National Fine Thread</b> 	Fixed dimension with chamfer	1/4" - 1/2" 1/4" - 3/4"	57 57
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# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 172



Thread	P mm	D <sup>+0,02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
M3	0,5	2,4	42	7,0	6,5	14	4	2		168192		
M4	0,7	3,15	55	9,8	9,1	14	6	3		168195	168196	168197
M5	0,8	4,0	55	12,0	11,2	15	6	3		168198	168199	168200
M6	1,0	4,8	55	14,0	13	14	6	3		168201	168202	168203
M8	1,25	5,95	60	18,75	17,5	15	6	3	✓	168204	168205	168206
M10	1,5	7,95	70	22,5	21	15	8	3	✓	168207	168208	168209
M12	1,75	9,9	75	28,0	26,25	16	10	4	✓	168210	168211	168212
M14	2,0	11,6	85	32,0	30	16	12	4	✓	168213	168214	168215
M16	2,0	11,95	85	36,0	34	18	12	4	✓	168216	168217	168218
M18	2,5	13,95	90	42,5	40	17	14	4	✓	168219	168220	168221
M20	2,5	15,95	90	42,5	40	17	16	4	✓	168222	168223	168224

- Chamfer type
- Cutting Data see page 172

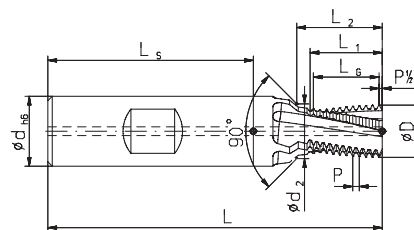
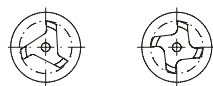


Figure 1: Chamfer on the shank

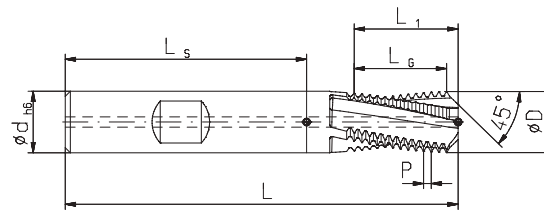
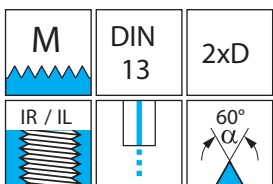
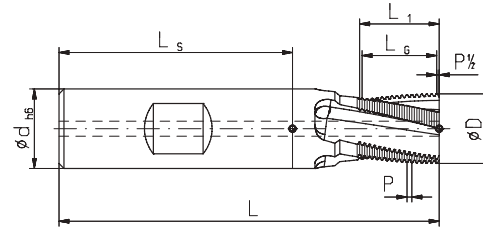
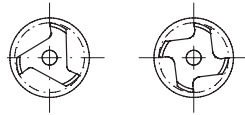
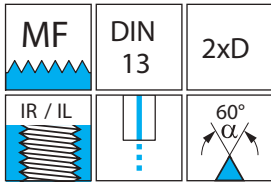


Figure 2: Chamfer on the face

Thread	P mm	D <sup>+0,02</sup> mm	L mm	L1 mm	L2 mm	Lg mm	Number of teeth	dh6 mm	d2 mm	Number of edges	Internal coolant	Fig.	Order No.	
													TINAMATIC	
													DIN 6535 Form HA	DIN 6535 Form HB
M4	0,7	3,15	55	9,80	11,03	9,1	14	6	4,3	3		1	186833	186834
M5	0,8	4,00	62	12,70	13,35	11,2	15	8	5,3	3		1	171556	171565
M6	1,0	4,80	62	14,00	15,55	13	14	8	6,3	3		1	171557	171566
M8	1,25	6,50	74	18,75	20,60	17,5	15	10	8,3	3	✓	1	171558	171567
M10	1,5	7,95	80	22,50	24,80	21	15	10	10,3	3	✓	1	171559	171568
M12	1,75	9,90	90	28,00	30,60	26,25	16	14	12,3	4	✓	1	171560	171569
M14	2,0	11,60	100	32,00	34,85	30	16	16	14,3	4	✓	1	171561	171570
M16	2,0	11,95	90	37,60		34	18	12		4	✓	2	171562	171571
M18	2,5	13,95	110	37,50	41,40	40	17	20	18,3	4	✓	1	171563	171572
M20	2,5	15,95	100	44,00		40	17	16		4	✓	2	171564	171573

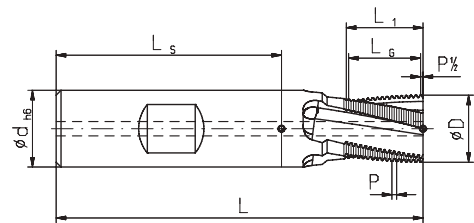
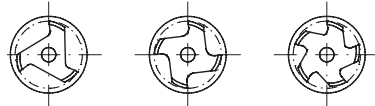
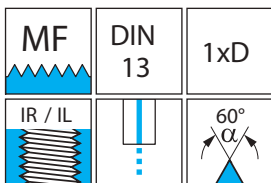
# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 172



Thread	P mm	D <sup>±0.02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
M5 x0,5	0,5	4,0	55	11,5	11	23	6	3		168225	168226	168227
M6 x0,75	0,75	4,8	55	14,25	13,5	19	6	3		168228	168229	168230
M8 x1	1,0	5,95	60	19,0	18	19	6	3	✓	168231	168232	168233
M10 x1	1,0	7,95	70	21,0	20	21	8	3	✓	193058 <b>NEW</b>	on request <b>NEW</b>	on request <b>NEW</b>
M10 x1,25	1,25	7,95	70	21,5	20	17	8	3	✓	168234	168235	168236
M12 x1	1,0	9,9	75	27,0	26	27	10	4	✓	168237	168238	168239
M12 x1,25	1,25	9,9	75	27,5	26,25	22	10	4	✓	168240	168241	168242
M12 x1,5	1,5	9,9	75	27,0	25,5	18	10	4	✓	168243	168244	168245
M14 x1	1,0	11,6	85	31,0	30	31	12	4	✓	168246	168247	168248
M14 x1,25	1,25	11,6	85	31,25	30	25	12	4	✓	on request <b>NEW</b>	on request <b>NEW</b>	on request <b>NEW</b>
M14 x1,5	1,5	11,6	85	31,5	30	21	12	4	✓	168249	168250	168251
M16 x1,5	1,5	11,95	85	34,5	33	23	12	4	✓	168252	168253	168254
M18 x1,5	1,5	13,95	90	42,0	40,5	28	14	4	✓	168255	168256	168257
M20 x1,5	1,5	15,95	90	42,0	40,5	28	16	4	✓	168258	168259	168260

- Universal type
- Cutting Data see page 172



Thread from	P mm	D <sup>±0.02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
> M10	0,5	7,95	70	12	11,5	24	8	3	✓	170779	170780	170781
> M11	0,75	7,95	70	12	11,25	16	8	3	✓	170782	170783	170784
> M12	1,0	9,95	75	16	15	16	10	4	✓	170785	170786	170787
> M14	1,0	11,95	85	20	19	20	12	4	✓	170791	170792	170793
> M18	1,0	15,95	90	25	24	25	16	5	✓	170800	170801	170802
> M22	1,0	19,95	110	32	31	32	20	5	✓	170812	170813	170814
> M14	1,5	9,95	75	16	15	11	10	4	✓	170788	170789	170790
> M16	1,5	11,95	85	20	19,5	14	12	4	✓	170794	170795	170796
> M20	1,5	15,95	90	25	24	17	16	5	✓	170803	170804	170805
> M24	1,5	19,95	110	32	31,5	22	20	5	✓	170815	170816	170817
> M16	2,0	11,95	85	20	18	10	12	4	✓	170797	170798	170799
> M20	2,0	15,95	90	25	24	13	16	5	✓	170806	170807	170808
> M24	2,0	19,95	110	32	30	16	20	5	✓	170818	170819	170820
> M24	3,0	15,95	90	25	24	9	16	5	✓	170809	170810	170811
> M27	3,0	19,95	110	32	30	11	20	5	✓	170821	170822	170823

# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fix ed dimension type
- Cutting Data see page 172

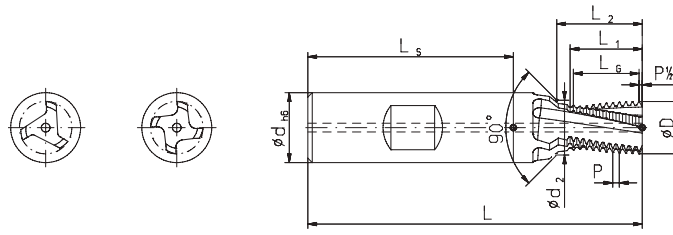


Figure 1:  
Chamfer on the shank

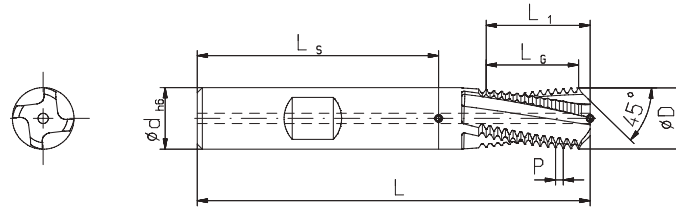
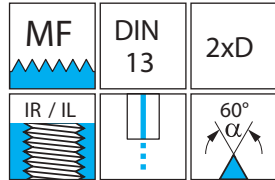
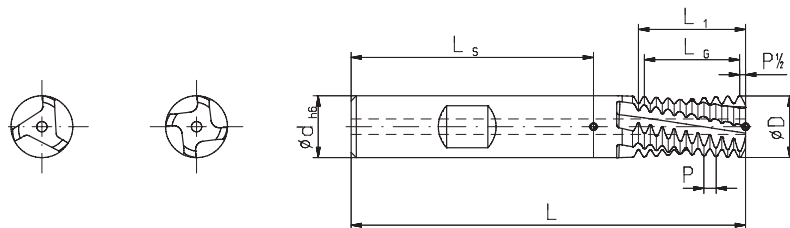
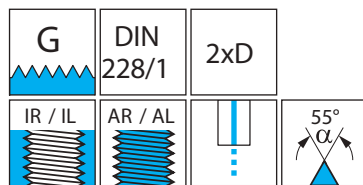


Figure 2:  
Chamfer on the face

Thread	P mm	D <sup>±0.02</sup> mm	L mm	L1 mm	L2 mm	Lg mm	Number of teeth	dh6 mm	d2 mm	Number of edges	Internal coolant	Fig.	Order No.	
													TINAMATIC	
													DIN 6535 Form HA	DIN 6535 Form HB
M8 x1	1,0	5,95	74	19	21	18	19	10	8,3	3	✓	1	171574	172376
M10 x1	1,0	8,0	80	22	23,95	21	22	12	10,3	3	✓	1	171575	172377
M10 x1,25	1,25	7,95	80	22,5	24,6	21,25	18	12	10,3	3	✓	1	171576	172378
M12 x1	1,0	9,9	90	27	29	26	27	14	12,3	4	✓	1	171577	172379
M12 x1,25	1,25	9,9	90	27,5	29,6	26,25	22	14	12,3	4	✓	1	171578	172380
M12 x1,5	1,5	9,9	90	27	29,25	25,5	18	14	12,3	4	✓	1	171579	172381
M14 x1	1,0	11,6	100	31	33,15	30	31	16	14,3	4	✓	1	171580	172382
M14 x1,5	1,5	11,6	100	31,5	33,9	30	21	16	14,3	4	✓	1	171581	172383
M16 x1,5	1,5	11,95	90	36,05		33	23	12		4	✓	2	171582	172384
M18 x1,5	1,5	14,0	110	39	42,2	37,5	26	20	18,3	4	✓	1	171583	172385
M20 x1,5	1,5	15,95	100	45,05		42	29	16		4	✓	2	171584	172386

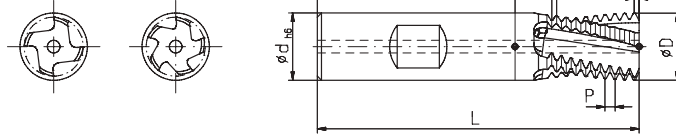
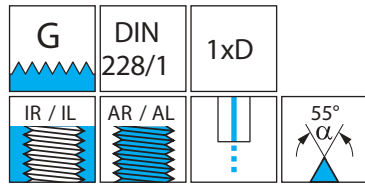
- Fix ed dimension type
- Cutting Data see page 172



Thread	P mm	Pitch/"	D <sup>±0.02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
											TINAMATIC		
											DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
G 1/8"	0,907	28	7,95	70	20,8	20,86	24	8	3	✓	168371	168372	168373
G 1/4"	1,337	19	9,9	75	28,0	26,74	21	10	4	✓	168374	168375	168376
G 3/8"	1,337	19	13,95	90	41,45	40,11	31	14	4	✓	168377	168378	168379
G 1/2"	1,814	14	15,95	90	43,5	41,72	24	16	4	✓	168380	168381	168382

# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Universal type
- Cutting Data see page 172



Thread from	P mm	Pitch/"	D <sup>±0.02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.	
											TINAMATIC	
											DIN 6535 Form HA	DIN 6535 Form HB
G 1/4 - 3/8"	1,337	19	9,95	75	16,0	14,71	12	10	4	✓	186224	187865
G 1/2 - 7/8"	1,814	14	15,95	90	25,4	23,58	14	16	5	✓	186225	187866
> G 1"	2,309	11	19,95	110	32,3	30,02	14	20	5	✓	183759	177967

- Chamfer type
- Cutting Data see page 172

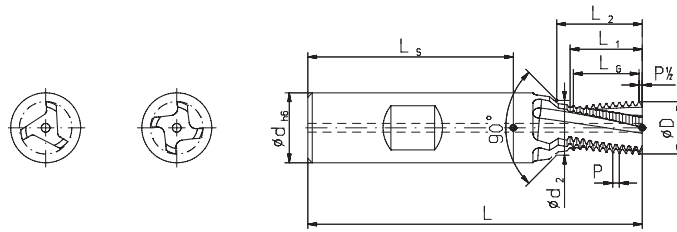


Figure 1: Chamfer on the shank

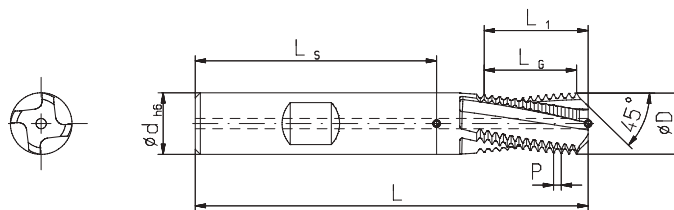
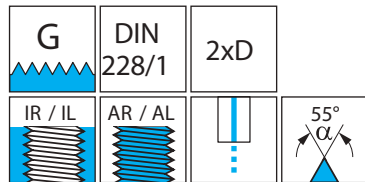
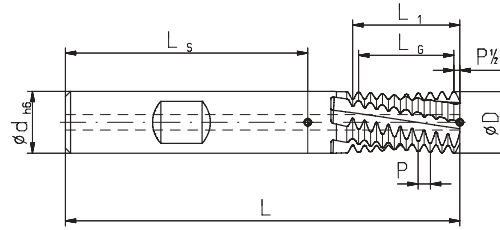
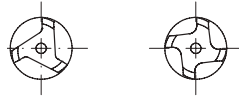
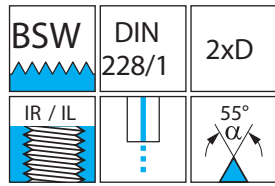


Figure 2: Chamfer on the face

Thread	P mm	Pitch/"	D <sup>±0.02</sup> mm	L mm	L1 mm	L2 mm	Lg mm	Number of teeth	dh6 mm	d2 mm	Number of edges	Fig.	Order No.	
													TINAMATIC	
													DIN 6535 Form HA	DIN 6535 Form HB
G 1/16"	0,907	28	6	74	16,3	18,1	15,42	18	10	8,0	3	1	171585	172387
G 1/8"	0,907	28	7,95	80	21,8	23,5	20,86	24	12	10,0	3	1	171586	172388
G 1/4"	1,337	19	9,9	100	28,0	30,8	26,74	21	16	13,5	4	1	171587	172389
G 3/8"	1,337	19	13,95	90	37,5		34,76	27	14		4	2	171588	172390
G 1/2"	1,814	14	15,95	100	46,75		43,54	25	16		4	2	171589	172391
G 5/8"	1,814	14	17,95	110	41,0		47,16	27	18		4	2	171590	172392

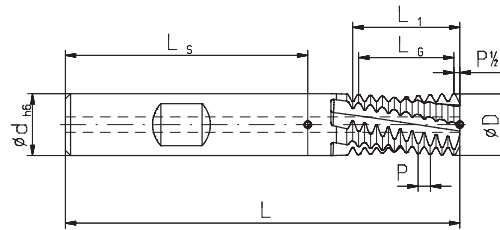
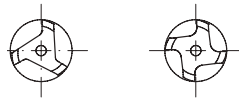
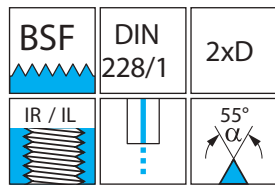
# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fix ed dimension type
- Cutting Data see page 172



Thread	P mm	Pitch/°	D <sup>±0.02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
											TINAMATIC		
											DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
5/16"	1,411	18	6,0	60	19,75	18,34	14	6	3	✓	168383	168384	168385
3/8"	1,588	16	5,95	60	20,60	19,06	13	6	3	✓	168386	168387	168388
7/16"	1,814	14	7,95	70	23,60	21,77	13	8	3	✓	168389	168390	168391
1/2"	2,117	12	7,95	70	23,30	21,17	11	8	3	✓	168392	168393	168394
5/8"	2,309	11	9,90	75	30,00	27,71	13	10	4	✓	168395	168396	168397

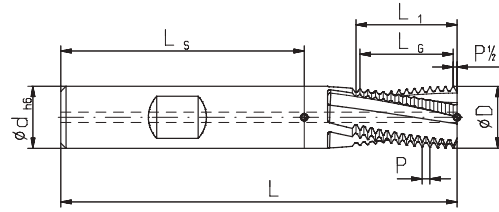
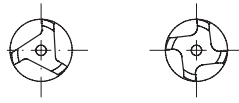
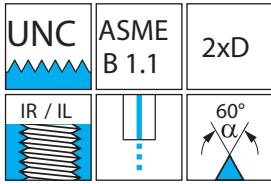
- Fix ed dimension type
- Cutting Data see page 172



Thread	P mm	Pitch/°	D <sup>±0.02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
											TINAMATIC		
											DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
5/16"	1,155	22	5,95	60	19,6	18,48	17	6	3	✓	168398	168399	168400
3/8"	1,270	20	5,95	60	19,0	17,78	15	6	3	✓	168401	168402	168403
7/16"	1,411	18	7,95	70	22,6	21,17	16	8	3	✓	168404	168405	168406
1/2"	1,588	16	7,95	70	23,8	22,23	15	8	3	✓	168407	168408	168409
5/8"	1,814	14	9,90	75	29,0	27,21	16	10	4	✓	168410	168411	168412

# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 172



Thread	P mm	Pitch/"	D <sup>±0,02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number Internal of edges coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
1/4" - 20	1,270	20	4,8	55	14	12,7	11	6	3	168413	168414	168415
5/16" - 18	1,411	18	5,95	60	19,7	18,34	14	6	3	168416	168417	168418
3/8" - 16	1,588	16	7,95	70	23,8	22,23	15	8	3	168419	168420	168421
7/16" - 14	1,814	14	7,95	70	23,6	21,77	13	8	3	168422	168423	168424
1/2" - 13	1,954	13	9,9	75	29,3	27,36	15	10	4	168425	168426	168427

- Chamfer type
- Cutting Data see page 172

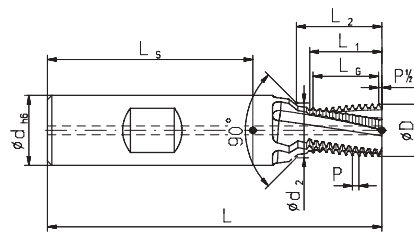


Figure 1:  
Chamfer on the shank

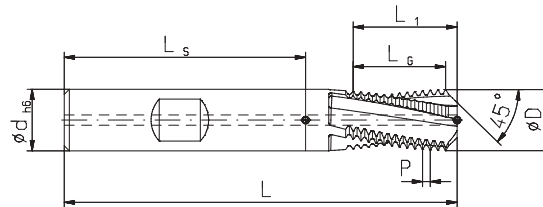
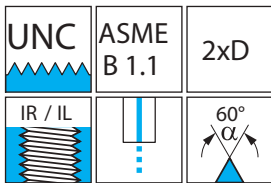
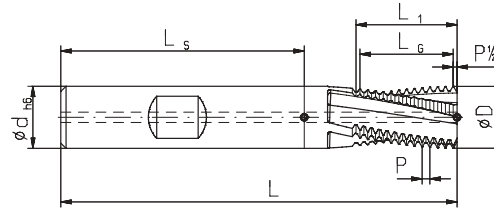
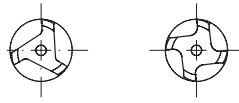
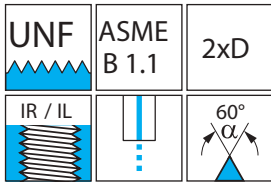


Figure 2:  
Chamfer on the face

Thread	P mm	Pitch/"	D <sup>±0,02</sup> mm	L mm	L1 mm	L2 mm	Lg mm	Number of teeth	dh6 mm	d2 mm	Number Internal of edges coolant	Fig.	Order No.	
													TINAMATIC	
													DIN 6535 Form HA	DIN 6535 Form HB
1/4" - 20	1,270	20	4,8	62	14,0	15,73	12,7	11	8	6,65	3	1	171591	172393
5/16" - 18	1,411	18	5,95	74	19,7	21,9	18,34	14	10	8,25	3	✓	171592	172394
3/8" - 16	1,588	16	7,95	80	23,8	25,85	22,23	15	12	9,83	3	✓	171593	172395
7/16" - 14	1,814	14	7,95	90	23,6	26,5	21,77	13	14	11,43	3	✓	171594	172396
1/2" - 13	1,954	13	9,9	90	29,3	32,1	27,36	15	14	13	4	✓	171595	172397
9/16" - 12	2,117	12	11,8	100	33,9	36,6	31,76	16	16	14,61	4	✓	171596	172398
5/8" - 11	2,309	11	12,7	90	38,4		34,63	16	14		4	✓	171597	172399
3/4" - 10	2,540	10	15,2	110	40,6	44,3	38,1	16	20	19,35	5	✓	171598	172400

# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 172



Thread	P mm	Pitch/"	D <sup>±0.02</sup> mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number Internal of edges coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
1/4" - 28	0,907	28	4,8	55	14,5	13,61	16	6	3	168428	168429	168430
5/16" - 24	1,058	24	5,95	60	19,0	17,99	18	6	3 ✓	168431	168432	168433
3/8" - 24	1,058	24	7,95	70	22,2	21,16	21	8	3 ✓	168434	168435	168436
7/16" - 20	1,270	20	7,95	70	22,8	21,59	18	8	3 ✓	168437	168438	168439
1/2" - 20	1,270	20	9,9	75	27,9	26,67	22	10	4 ✓	168440	168441	168442

- Chamfer type
- Cutting Data see page 172

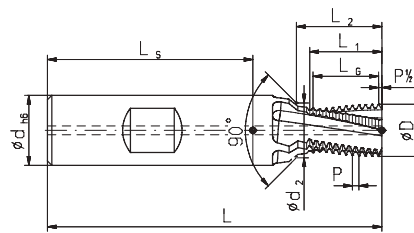


Figure 1: Chamfer on the shank

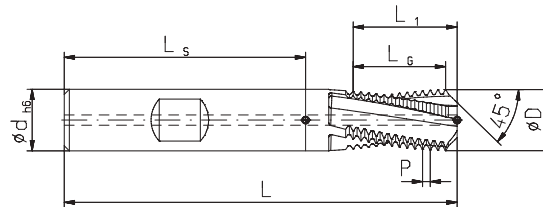
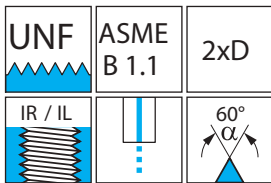


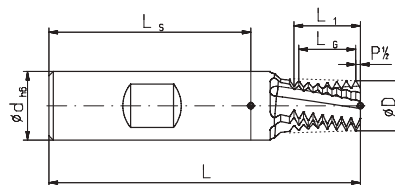
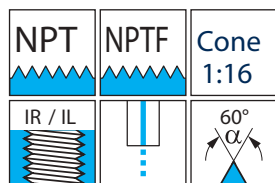
Figure 2: Chamfer on the face

Thread	P mm	Pitch/"	D <sup>±0.02</sup> mm	L mm	L1 mm	L2 mm	Lg mm	Number of teeth	dh6 mm	d2 mm	Number Internal of edges coolant	Fig.	Order No.	
													TINAMATIC	
													DIN 6535 Form HA	DIN 6535 Form HB
1/4" - 28	0,907	28	4,8	62	14,5	16,2	13,61	16	8	6,65	3	1	171599	172401
5/16" - 24	1,058	24	5,95	74	19,0	21	17,99	18	10	8,25	3	✓ 1	171600	172402
3/8" - 24	1,058	24	7,6	80	22,2	23	21,16	21	12	9,83	3	✓ 1	171601	172403
7/16" - 20	1,270	20	7,95	90	22,8	25,5	21,59	18	14	11,4	3	✓ 1	171602	172404
1/2" - 20	1,270	20	9,9	90	27,9	30,43	26,67	22	14	13	4	✓ 1	171603	172405
9/16" - 18	1,411	18	12	100	31,0	33,35	29,63	22	16	14,61	4	✓ 1	171604	172406
5/8" - 18	1,411	18	13,5	90	36,8		33,86	25	14		4	✓ 2	171605	172407
3/4" - 16	1,588	16	17	110	39,7	42	38,11	25	20	19,35	5	✓ 1	171606	172408



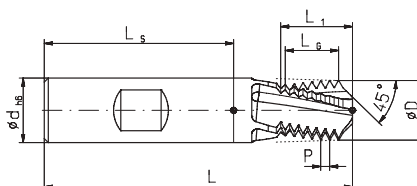
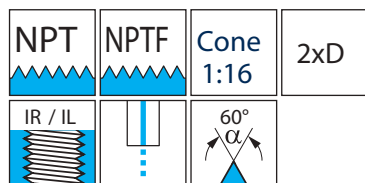
# SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 172



Thread	P mm	Pitch/"	D <sup>±0.02</sup> mm	L mm	L1 mm	LG mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
											TINAMATIC		
											DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
1/16"	0,941	27	5,8	70	11,3	10,35	12	8	3	✓	170752	170753	170754
1/8"	0,941	27	7,6	75	11,3	10,35	12	10	3	✓	170755	170756	170757
1/4"	1,411	18	10,1	90	15,5	14,11	11	14	3	✓	170758	170759	170760
3/8"	1,411	18	12,8	90	16,7	14,11	11	16	4	✓	170761	170762	170763
1/2"	1,814	14	16,0	110	21,35	18,14	11	20	5	✓	170764	170765	170766
3/4"	1,814	14	18,5	110	19,95	18,14	11	20	5	✓	170767	170768	170769

- Chamfer type
- Cutting Data see page 172

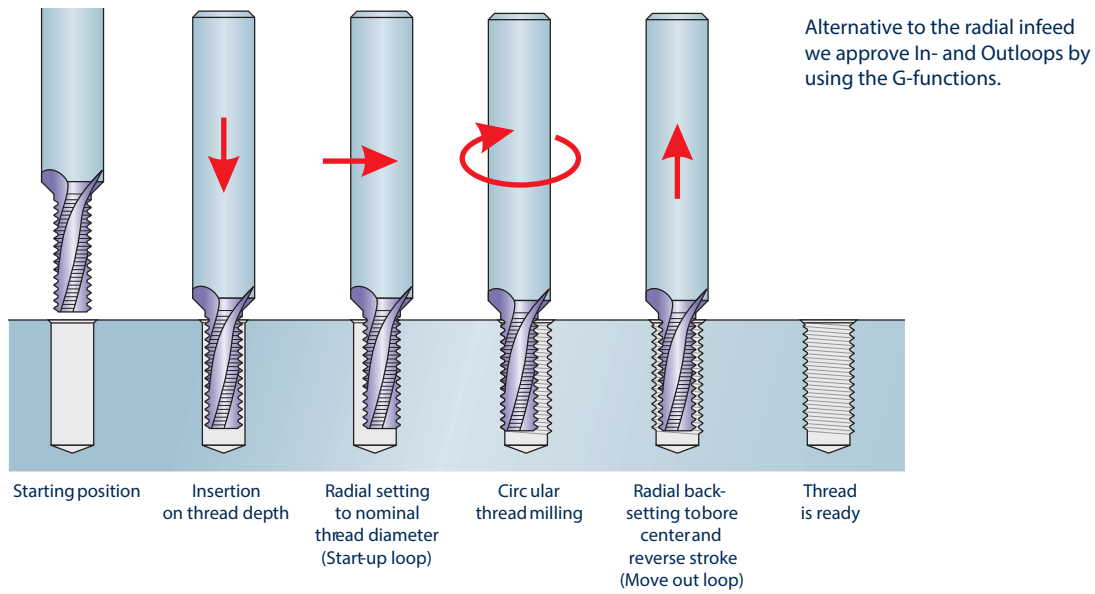


Thread	P mm	Pitch/"	D <sup>±0.02</sup> mm	L mm	L1 mm	LG mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.	
											TINAMATIC	
											DIN 6535 Form HA	DIN 6535 Form HB
1/4"	1,411	18	10,1	90	18,2	14,11	11	14	3	✓	171609	172411
3/8"	1,411	18	12,8	90	18,2	14,11	11	16	4	✓	171610	172412
1/2"	1,814	14	16,0	110	22,8	18,14	11	20	5	✓	171611	172413
3/4"	1,814	14	18,5	110	23,0	18,14	11	20	5	✓	171612	172414

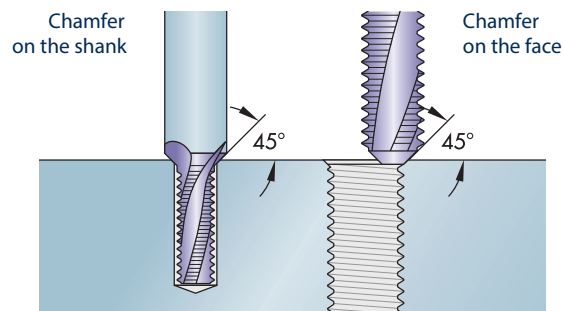
**i** NPS and NPSM on request !

SolidCUT

Machining Sequence



Types with chamfer

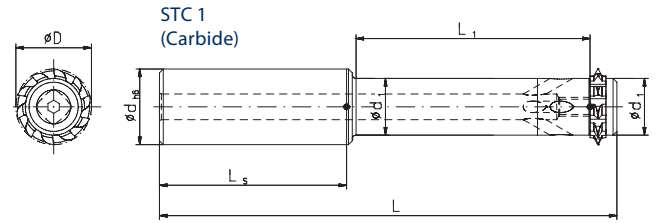
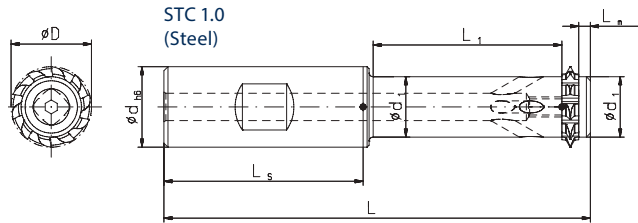


**i** More information to circular thread milling see page 181

Milling System for Threads from Drill Hole  $\varnothing 20,5 \text{ mm}$  (

$\geq M 24$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



DIN 1835 Form A

DIN 1835 Form B

DIN 65 35 Form A

for		Spare Parts	
		④ Clamping disc *	② Clamping screw *    ③ Screw-driver *
156500	156501	159784	163852    178296
182043			
			Screw torques max. 163852 SW3 6,0 Nm

Type	Shank DIN	① Order No.	d h6 mm	L mm	L <sub>1</sub> mm	L <sub>s</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	③ Thread inserts required
STC 1.0	1835 A	156500	20	106	47,9	50	-	2,9	20	15	-	1
	1835 B	156501	20	106	47,9	50	-	2,9	20	15	-	1
STC 1	6535 A	182043	20	121	62,9	50	-	2,9	20	15	-	1

Milling Inserts

- Cutting Data see page 174

Full form

M24 M27

Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
3	10	20	1,702	2,1	159757

Full form

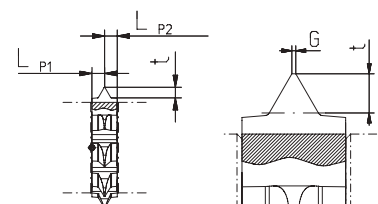
UNC

Pitch G / "	Number of teeth	D mm	t mm	LP1=L P2 mm	Thread	Order No TINAMATIC
8	10	20	1,809	2,1	1"	180331
7	10	20	2,043	2,1		156760
8	10	20	1,809	2,1	>1"	186515

Partial form

M MF UN UNC NPSM

Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	20	2,25	0,1	2,1
2,5-4	10-6	10	20	3,20	0,25	2,1

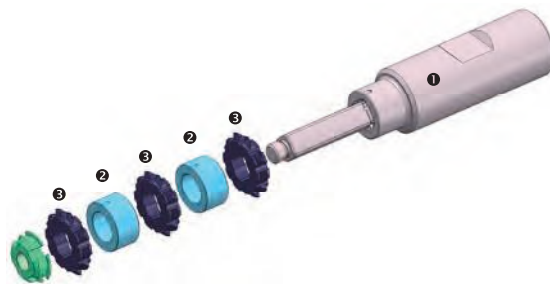
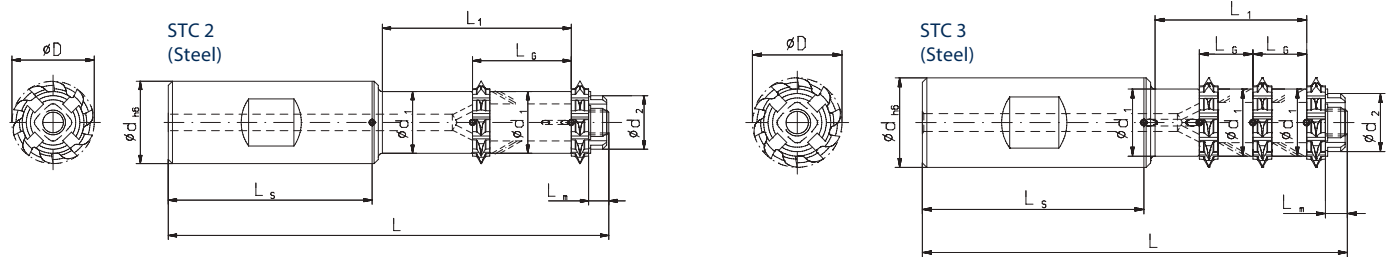


ATTENTION: Please ask for distance sleeves separately!

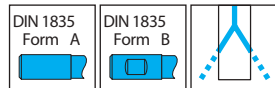
\* Included in delivery

# Milling System for Threads from Drill Hole $\varnothing 20,5 \text{ mm}$ ( $\geq M 24$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



	Spare Parts	Accessories
for	2 Set of distance sleeves *	Slotted nut * Key
159876 159875	159796	185192 186814
159862 159861	159789	185192
		Slotted nut torques max. 185192 11 Nm

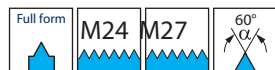


Complete holder without inserts / assembling wrench

Type	Shank DIN	1 Order No.	d h6 mm	L mm	L1 mm	Ls mm	Lg mm	Lm mm	D mm	d1 mm	d2 mm	3 Thread inserts required
STC 2 2 x D	1835 A	159876	20	107	46,9	50	24	4,9	20	15	13	2
	1835 B	159875	20	107	46,9	50	24	4,9	20	15	13	2
STC 3 1,5 x D	1835 A	159862	20	95	34,9	50	12	4,9	20	15	13	3
	1835 B	159861	20	95	34,9	50	12	4,9	20	15	13	3

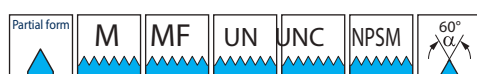
## Milling Inserts

- Cutting Data see page 174

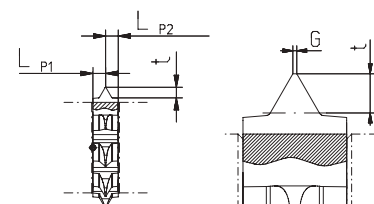


Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
3	10	20	1,702	2,1	159757

Pitch G / "	Number of teeth	D mm	t mm	LP1=L P2 mm	Thread	Order No TINAMATIC
8	10	20	1,809	2,1	1"	180331
7	10	20	2,043	2,1		156760
8	10	20	1,809	2,1	>1"	186515



Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	2,25	0,1	2,1	181817
2,5-4	10-6	10	3,20	0,25	2,1	181818



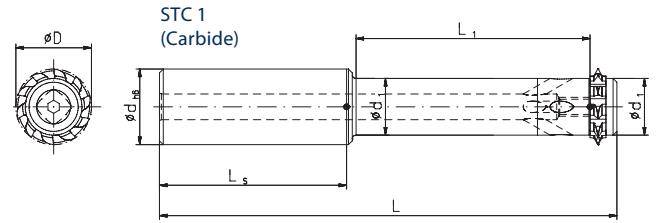
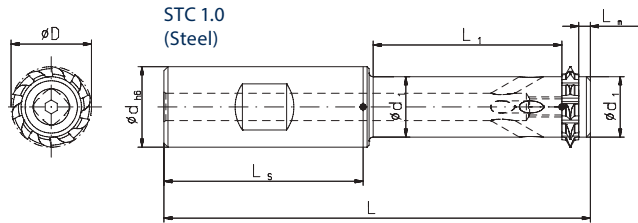
ATTENTION: Please ask for distance sleeves separately!

\* Included in delivery

# Milling System for Threads from Drill Hole $\varnothing 26$ mm (

$\geq M 30$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



DIN 1835 Form A

DIN 1835 Form B

DIN 65 35 Form A

for		Spare Parts	
		④ Clamping disc *	② Clamping screw * Screw-driver *
156502	156503	159785	163852
182042			178296

Screw torques max.  
163852 SW3 6,0 Nm

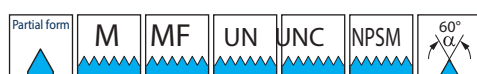
Type	Shank DIN	① Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>s</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	③ Thread inserts required
STC 1.0	1835 A	156502	20	121	62,9	50	-	2,9	24	19	-	1
	1835 B	156503	20	121	62,9	50	-	2,9	24	19	-	1
STC 1	6535 A	182042	20	141	82,9	50	-	2,9	24	19	-	1

## Milling Inserts

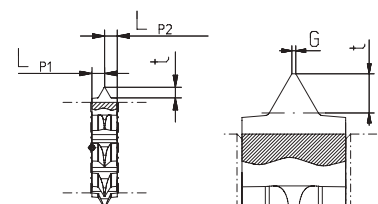
- Cutting Data see page 174



Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
3,5	10	24	1,982	2,1	159758



Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	24	2,25	0,1	181726
3-4	9-6	10	24	3,20	0,25	181730



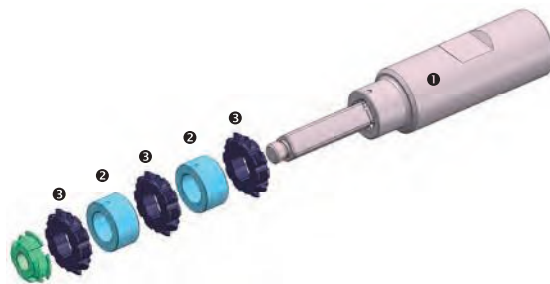
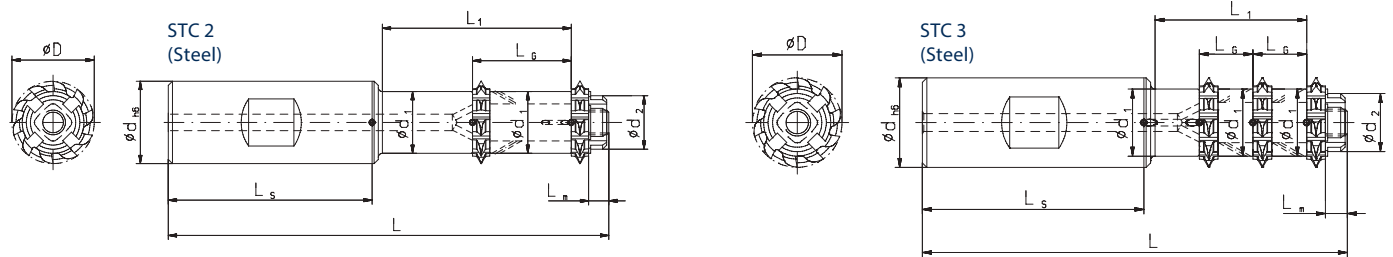
ATTENTION: Please ask for distance sleeves separately!

\* Included in delivery

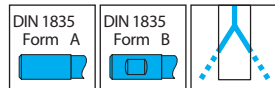
# Milling System for Threads from Drill Hole Ø 26 mm (

≥ M 30)

- Cutting data see page 174
- Recommendation plunging movements see page 184



		Spare Parts	Accessories
for	2	Set of distance sleeves *	Slotted nut * Key
159878 159878	159797	185299	186811
159864 159863	159790	185299	
		Slotted nut torques max. 185299 45 Nm	

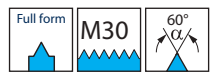


Complete holder without inserts / assembling wrench

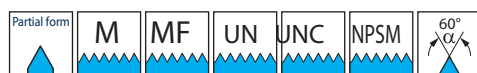
Type	Shank DIN	1 Order No.	d h6 mm	L mm	L1 mm	Ls mm	Lg mm	Lm mm	D mm	d1 mm	d2 mm	3 Thread inserts required
STC 2 2 x D	1835 A	159878	20	120	59,9	50	31,5	4,9	24	19	17	2
	1835 B	159877	20	120	59,9	50	31,5	4,9	24	19	17	2
STC 3 1,5 x D	1835 A	159864	20	104	43,9	50	14	4,9	24	19	17	3
	1835 B	159863	20	104	43,9	50	14	4,9	24	19	17	3

## Milling Inserts

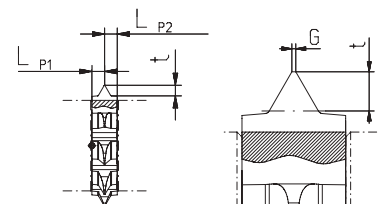
- Cutting Data see page 174



Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
3,5	10	24	1,982	2,1	159758



Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC	
1-3	24-9	10	24	2,25	0,1	2,1	181726
3-4	9-6	10	24	3,20	0,25	2,1	181730



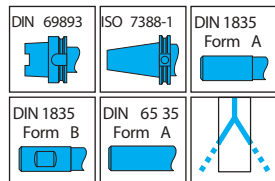
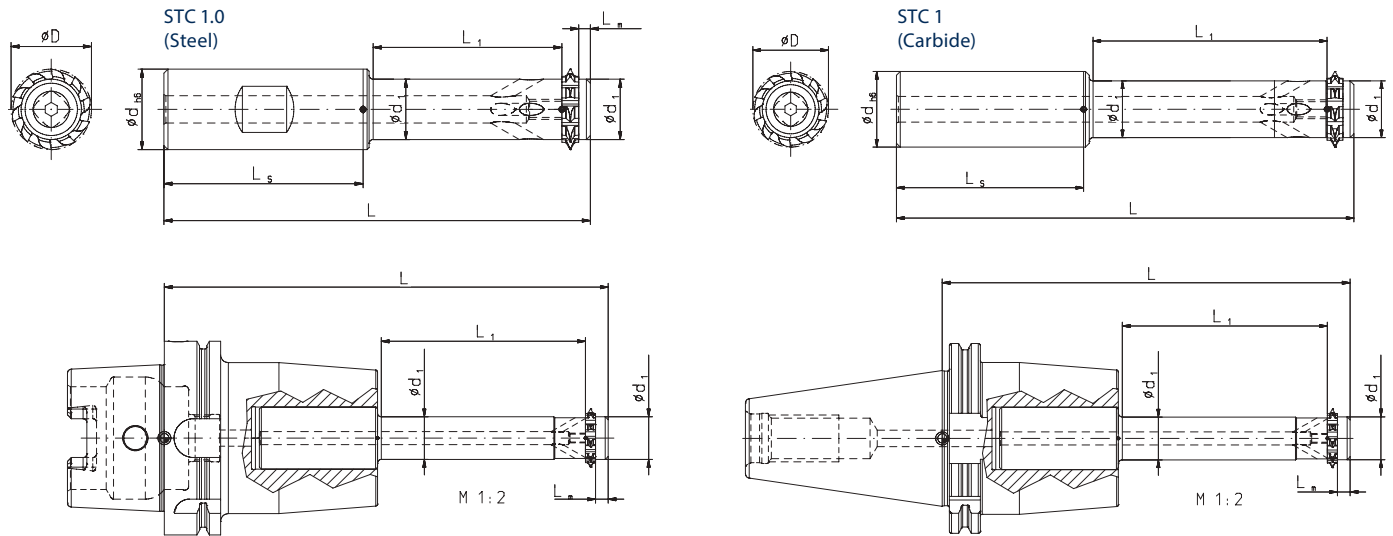
ATTENTION: Please ask for distance sleeves separately!

\* Included in delivery

# Milling System for Threads from Drill Hole $\varnothing 30$ mm (

$\geq M 36$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without Inserts

Spare Parts			
for	④ Clamping disc *	② Clamping screw *	Screw-driver *
156504	159786	114402	178640
156505			
160178			
156489			
156490			
Screw torques max. 114402 SW6 24,5 Nm			

Type	Shank DIN	① Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>S</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	③ Thread inserts required
STC 1.0	1835 A	156504	32	145,1	72,4	60	-	6,5	30	22	-	1
	1835 B	156505	32	145,1	72,4	60	-	6,5	30	22	-	1
STC 1 3xD	6535 A	160178	32	180,1	107,4	60	-	6,5	30	22	-	1
	HSK 100	156489	-	229,1	107,4	110	-	6,5	30	22	-	1
	SK 50	156490	-	209,1	107,4	90	-	6,5	30	22	-	1

## Milling Inserts

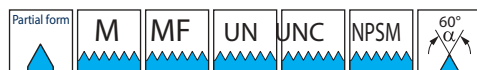
- Cutting Data see page 174



Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
4	10	30	2,263	2,6	159759

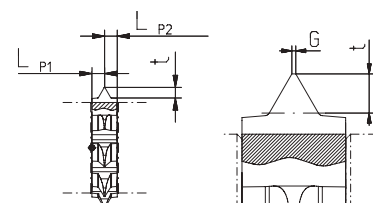


Pitch G / "	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
6	10	28	2,454	2,6	156761



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Pitch G / "	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	30	2,25	0,1	2,6	181732
3-4	9-6	10	30	3,80	0,25	2,6	181733

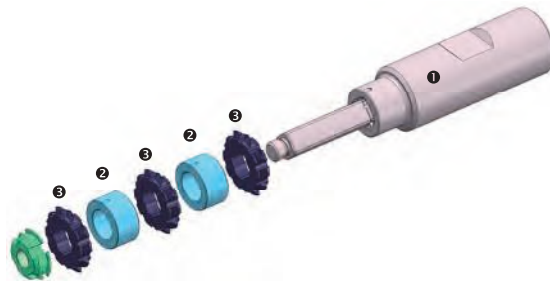
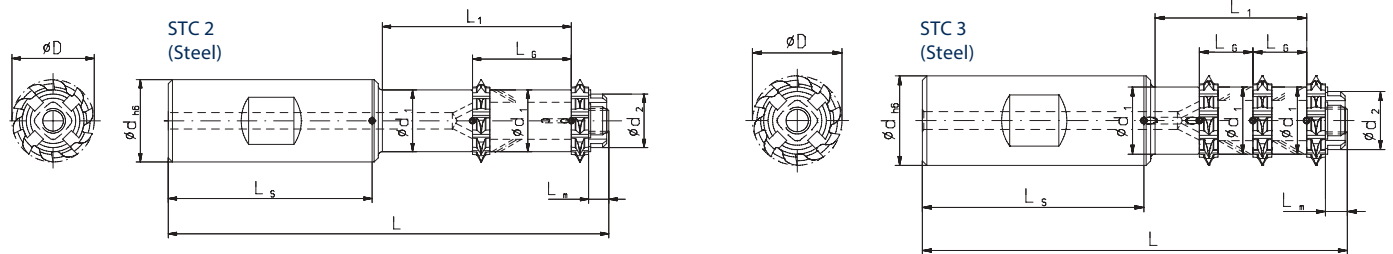


\* Included in delivery

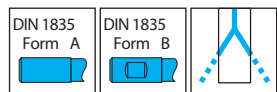
# Milling System for Threads from Drill Hole Ø 30 mm (

≥ M 36)

- Cutting data see page 174
- Recommendation plunging movements see page 184



	Spare Parts	Accessories
for	2 Set of distance sleeves *	Slotted nut * Key
159880 159879	159798	186195 186813
159866 159865	159791	186195
		Slotted nut torques max. 185195 55 Nm



Complete holder without inserts / assembling wrench

Type	Shank DIN	1 Order No.	d h6 mm	L mm	L1 mm	Ls mm	Lg mm	Lm mm	D mm	d1 mm	d2 mm	3 Thread inserts required
STC 2 2 x D	1835 A	159880	32	144	70,8	60	36	6,0	30	22	20	2
	1835 B	159879	32	144	70,8	60	36	6,0	30	22	20	2
STC 3 1,5 x D	1835 A	159866	32	126	52,8	60	16	6,0	30	22	20	3
	1835 B	159865	32	126	52,8	60	16	6,0	30	22	20	3

## Milling Inserts

- Cutting Data see page 174



Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
4	10	30	2,263	2,6	159759

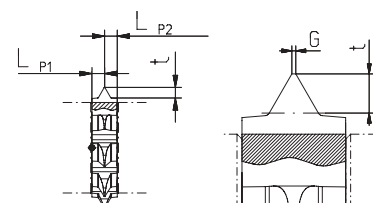


Pitch G / "	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
6	10	28	2,454	2,6	156761



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Pitch G / "	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	30	2,25	0,1	2,6	181732
3-4	9-6	10	30	3,80	0,25	2,6	181733



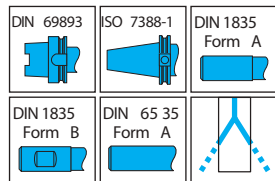
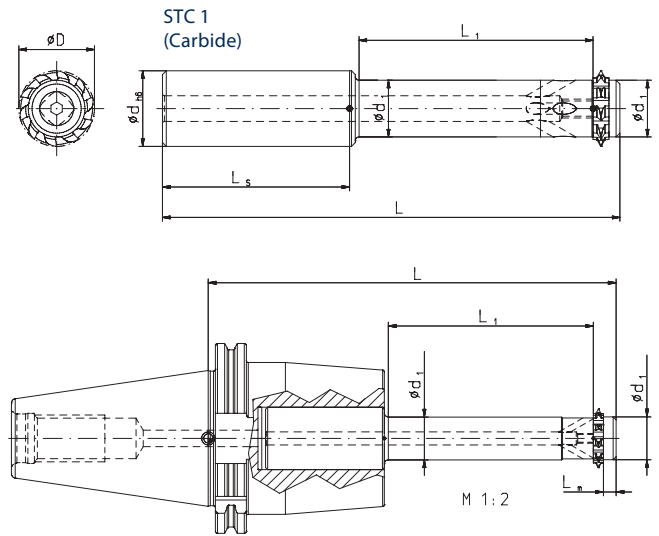
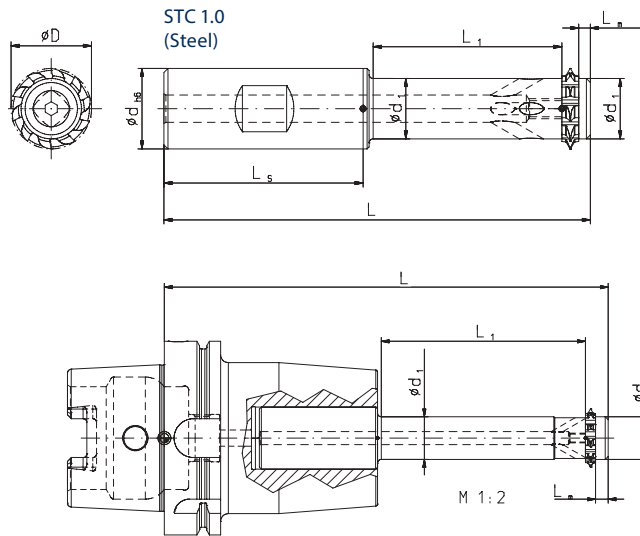
\* Included in delivery



# Milling System for Threads from Drill Hole $\varnothing 37 \text{ mm}$ (

$\geq \text{M } 42)$

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without Inserts

Type	Shank DIN	Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>S</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	Thread inserts required
STC 1.0	1835 A	156506	32	170,85	97,15	60	-	7,0	36	30	-	1
	1835 B	156507	32	170,85	97,15	60	-	7,0	36	30	-	1
STC 1 3xD	6535 A	160179	32	200,9	127,15	60	-	7,0	36	30	-	1
	HSK 100	156487	-	249,4	127,15	110	-	7,0	36	30	-	1
	SK 50	156488	-	229,8	127,15	90	-	7,0	36	30	-	1

Spare Parts			
for	4 Clamping disc *	2 Clamping screw *	Screw-driver *
156506 156507 160179 156487 156488	159787	114523	178640
Screw torques max. 114523 SW6 24,5 Nm			

## Milling Inserts

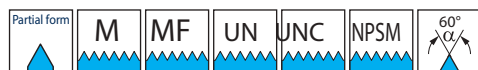
- Cutting Data see page 174



Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
4,5	10	36	2,553	2,85	159760

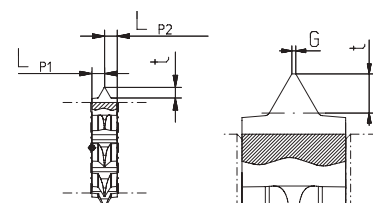


Pitch G / "	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
5	10	36	2,979	2,85	156762



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Pitch G / "	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	36	2,25	0,1	2,85	182040
3-4	9-6	10	36	3,80	0,25	2,85	182041

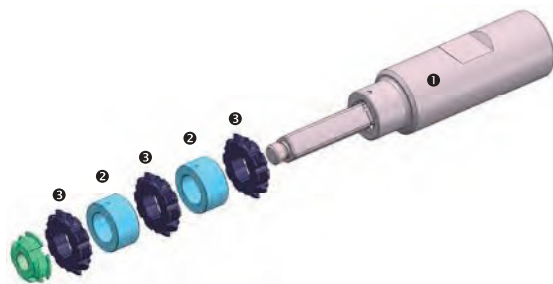
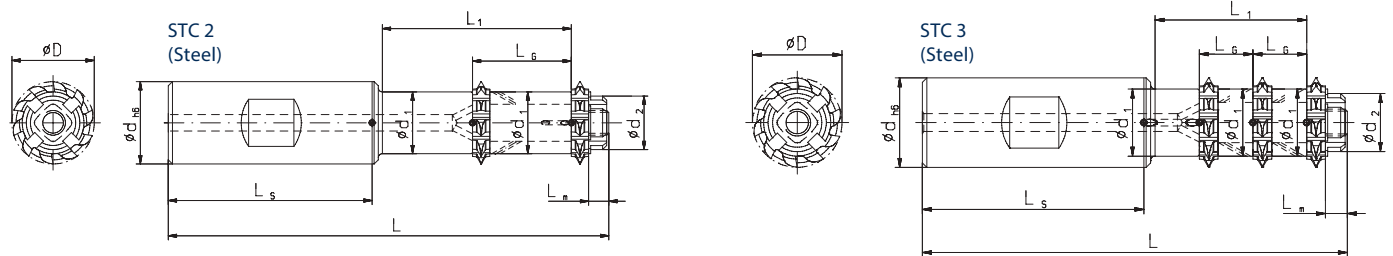


\* Included in delivery

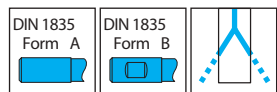
Milling System for Threads from Drill Hole Ø 37 mm (

≥ M 42)

- Cutting data see page 174
- Recommendation plunging movements see page 184



	Spare Parts	Accessories
for	2 Set of distance sleeves *	Slotted nut * Key
159882 159881	159799	186195 186813
159868 159867	159792	186195
		Slotted nut torques max. 185195 55 Nm



Complete holder without inserts / assembling wrench

Type	Shank DIN	1 Order No.	dh6 mm	L mm	L1 mm	Ls mm	Lg mm	Lm mm	D mm	d1 mm	d2 mm	3 Thread inserts required
STC2 2 x D	1835 A	159882	32	158	85,15	60	40,5	6,15	36	30	20	2
	1835 B	159881	32	158	85,15	60	40,5	6,15	36	30	20	2
STC 3 1,5 x D	1835 A	159868	32	137	45	60	22,5	6,15	36	30	20	3
	1835 B	159867	32	137	45	60	22,5	6,15	36	30	20	3

Milling Inserts

- Cutting Data see page 174



Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
4,5	10	36	2,553	2,85	159760

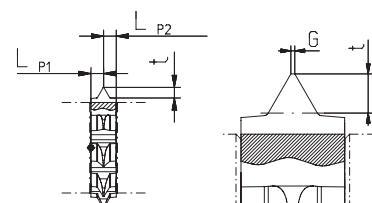


Pitch G / "	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
5	10	36	2,979	2,85	156762



ATTENTION: Please ask for distance sleeves separately!

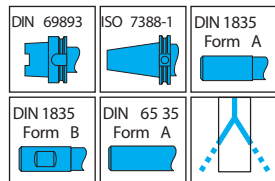
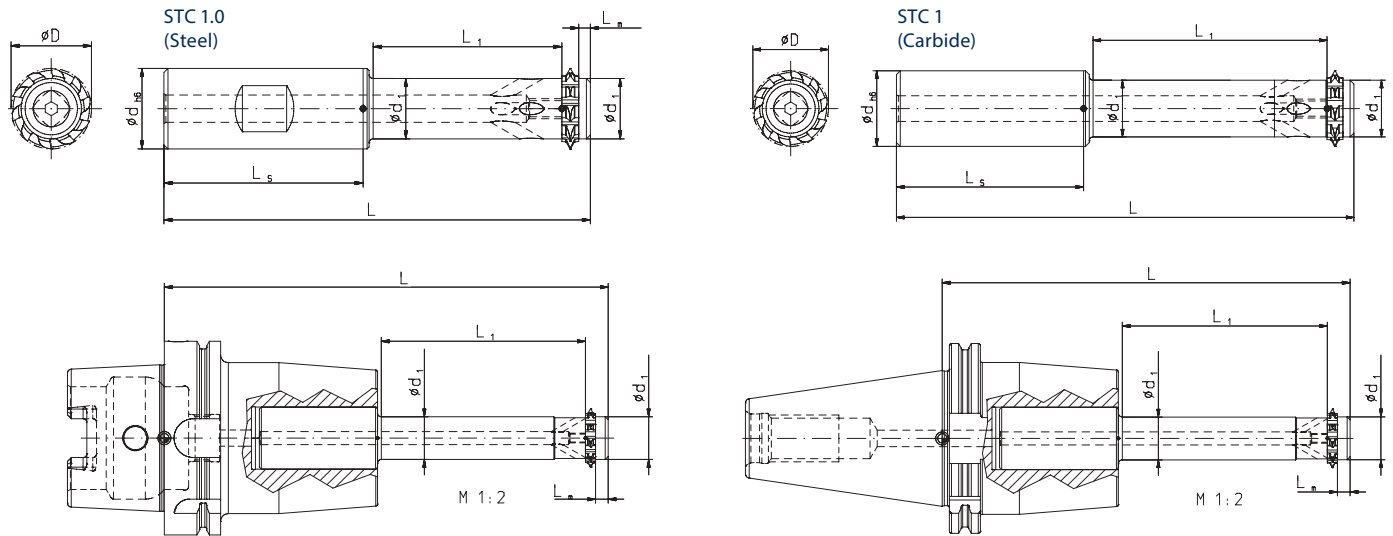
Pitch mm	Pitch G / "	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	36	2,25	0,1	2,85	182040
3-4	9-6	10	36	3,80	0,25	2,85	182041



\* Included in delivery

Milling System for Threads from Drill Hole  $\varnothing 42,6 \text{ mm}$  ( $\geq M 48$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without Inserts

Type	Shank DIN	Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>S</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	Thread inserts required
STC 1.0	1835 A	156508	32	201	126,9	60	-	7,0	40	32	-	1
	1835 B	156509	32	201	126,9	60	-	7,0	40	32	-	1
STC 1 3xD	6535 A	160180	32	221,1	147,9	60	-	7,0	40	32	-	1
	HSK 100	156486	-	270	146,9	110	-	7,0	40	32	-	1
	SK 50	156485	-	250	146,9	90	-	7,0	40	32	-	1

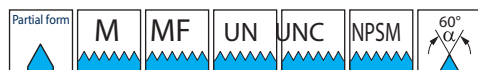
Spare Parts			
for	4 Clamping disc *	2 Clamping screw *	Screw-driver *
156508 156509 160180 156486 156485	159788	114523	178640
Screw torques max. SW6 24,5 Nm			

Milling Inserts

- Cutting Data see page 174

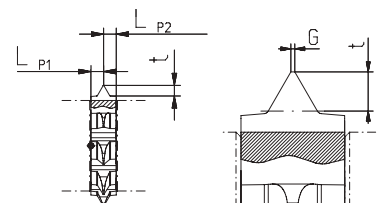


Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
5	10	40	2,836	3,1	159761



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	40	2,25	0,1	159836
3-4	9-6	10	40	3,80	0,25	180440

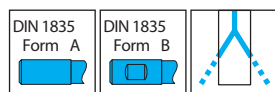
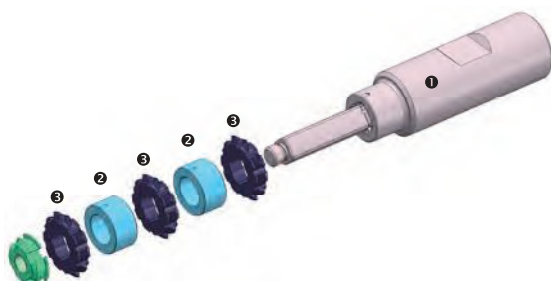
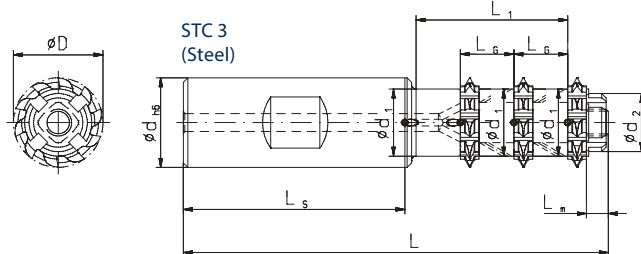
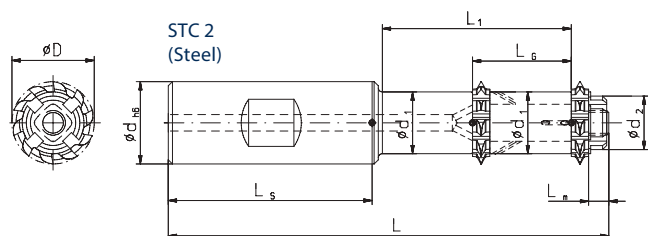


\* Included in delivery

Milling System for Threads from Drill Hole Ø 42,6 mm (

≥ M 48)

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without inserts / assembling wrench

for	Spare Parts	Accessories
	Set of distance sleeves *	Slotted nut * Key
159884 159883	159801	186145 186819
159870 159869	159793	186145

Slotted nut torques max.  
186145 110 Nm

Type	Shank DIN	Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>s</sub> mm	L <sub>g</sub> mm	L <sub>m</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	Thread inserts required
STC 2 2 x D	1835 A	159884	32	170	95,3	60	50	6,5	40	32	30	2
	1835 B	159883	32	170	95,3	60	50	6,5	40	32	30	2
STC 3 1,5 x D	1835 A	159870	32	147	72,3	60	25	6,5	40	32	30	3
	1835 B	159869	32	147	72,3	60	25	6,5	40	32	30	3

Milling Inserts

- Cutting Data see page 174

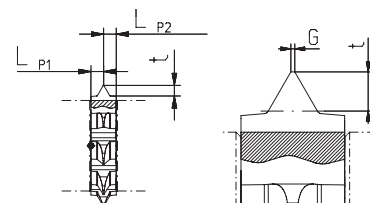


Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
5	10	40	2,836	3,1	159761



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	40	2,25	0,1	159836
3-4	9-6	10	40	3,80	0,25	180440

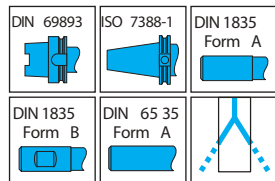
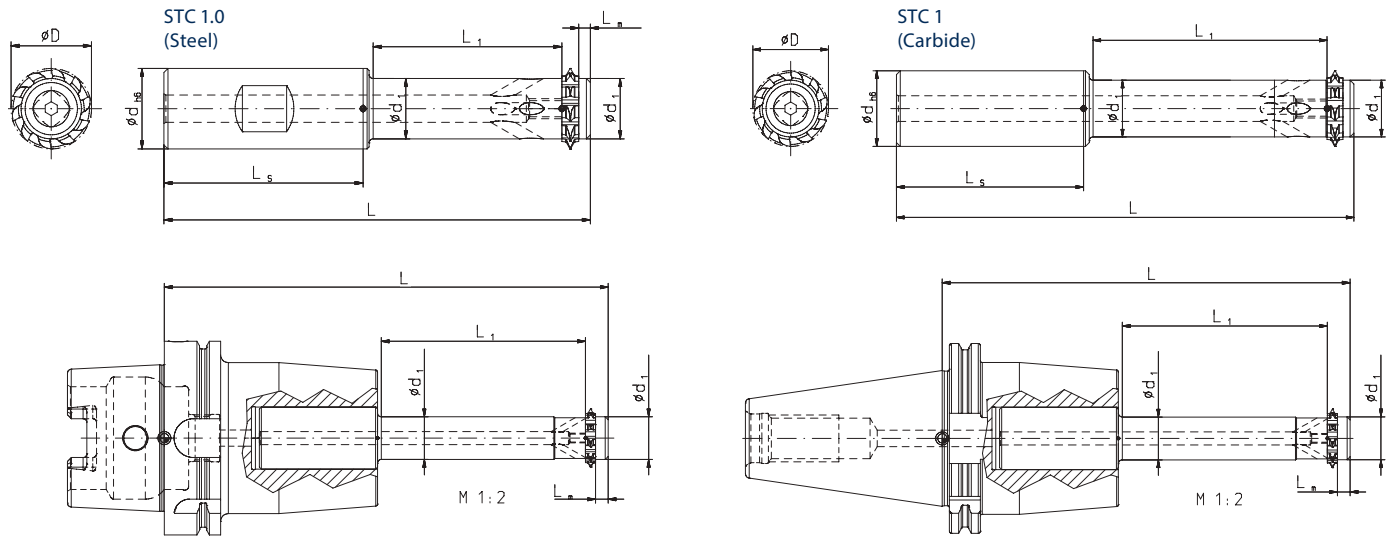


\* Included in delivery

Milling System for Threads from Drill Hole  $\varnothing 50 \text{ mm}$  (

$\geq M 56$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without Inserts

Type	Shank DIN	Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>S</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	Thread inserts required
STC 1.0	1835 A	156508	32	201	126,9	60	-	7,0	40	32	-	1
	1835 B	156509	32	201	126,9	60	-	7,0	40	32	-	1
STC 1 3xD	6535 A	160180	32	221,1	147,9	60	-	7,0	40	32	-	1
	HSK 100	156486	-	270	146,9	110	-	7,0	40	32	-	1
	SK 50	156485	-	250	146,9	90	-	7,0	40	32	-	1

Spare Parts			
for	④ Clamping disc *	② Clamping screw *	Screw-driver *
156508	159786	114523	178640
156509			
160180			
156486			
156485			

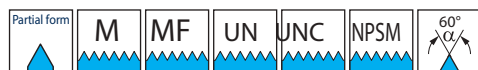
Screw torques max. SW6 24,5 Nm

Milling Inserts

- Cutting Data see page 174

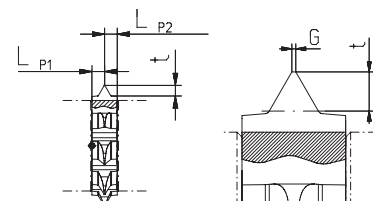


Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No
					TINAMATIC
5,5	10	40	3,106	3,1	159762



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No
						TINAMATIC
1-3	24-9	10	40	2,25	0,1	159836
3-4	9-6	10	40	3,80	0,25	180440

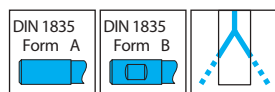
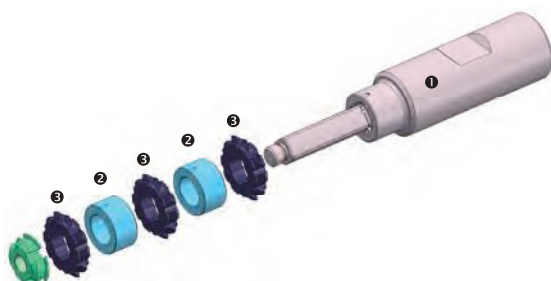
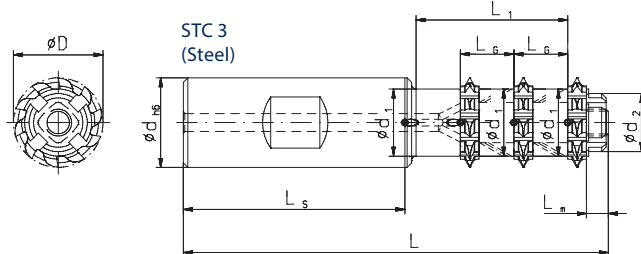
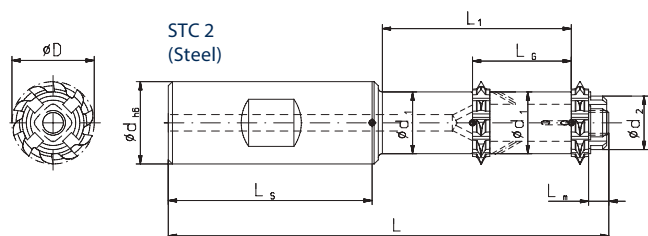


\* Included in delivery

Milling System for Threads from Drill Hole Ø 50 mm (

≥ M 56)

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without inserts / assembling wrench

for	Spare Parts		Accessories
	Set of distance sleeves *	Slotted nut *	Key
159886 159885	159798	186145	186819
159872 159871	159791	186145	

Slotted nut torques max.  
186145 110 Nm

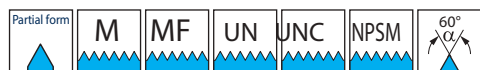
Type	Shank DIN	Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>s</sub> mm	L <sub>g</sub> mm	L <sub>m</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	Thread inserts required
STC 2 2 x D	1835 A	159886	32	186	111,3	60	55,0	6,5	40	32	30	2
	1835 B	159885	32	186	111,3	60	55,0	6,5	40	32	30	2
STC 3 1,5 x D	1835 A	159872	32	158	83,3	60	27,5	6,5	40	32	30	3
	1835 B	159871	32	158	83,3	60	27,5	6,5	40	32	30	3

Milling Inserts

- Cutting Data see page 174

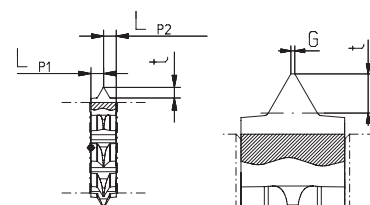


Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No
5,5	10	40	3,106	3,1	TINAMATIC 159762



ATTENTION: Please ask for distance sleeves separately!

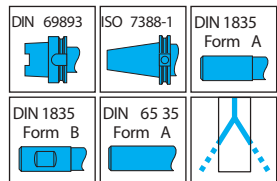
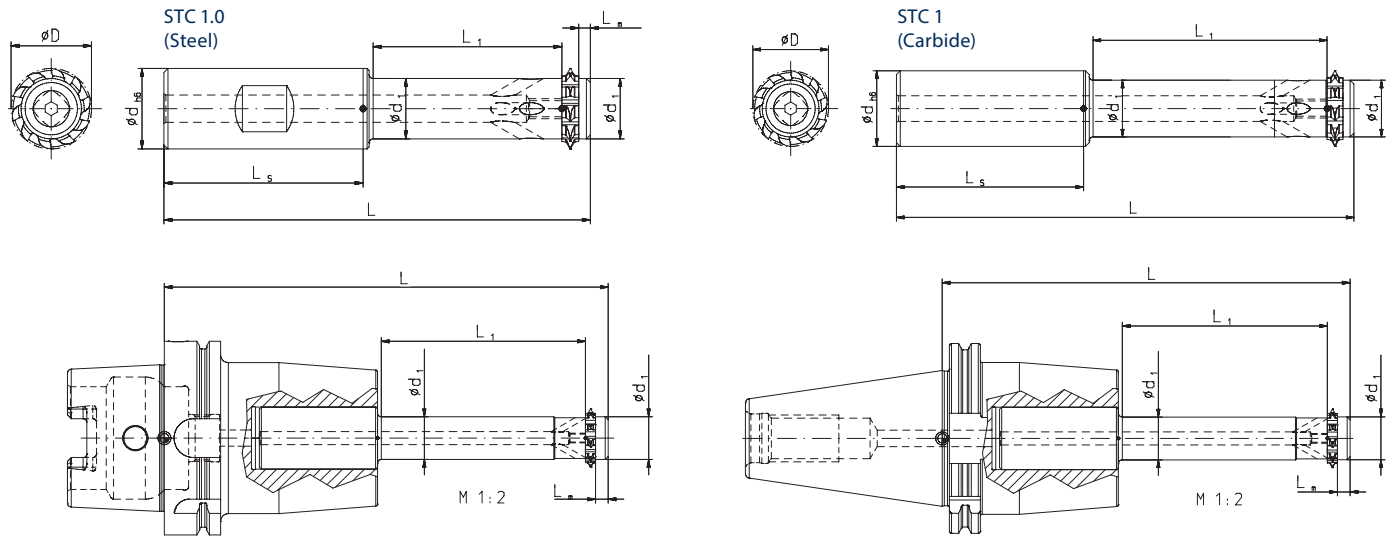
Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No	
1-3	24-9	10	40	2,25	0,1	3,1	TINAMATIC 159836
3-4	9-6	10	40	3,80	0,25	3,1	TINAMATIC 180440



\* Included in delivery

# Milling System for Threads from Drill Hole $\varnothing 57,5 \text{ mm}$ ( $\geq M 64$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without Inserts

Type	Shank DIN	Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>s</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	Thread inserts required
STC 1.0	1835 A	156508	32	201	126,9	60	-	7,0	40	32	-	1
	1835 B	156509	32	201	126,9	60	-	7,0	40	32	-	1
STC 1 3xD	6535 A	160180	32	221,1	147,9	60	-	7,0	40	32	-	1
	HSK 100	156486	-	270	146,9	110	-	7,0	40	32	-	1
	SK 50	156485	-	250	146,9	90	-	7,0	40	32	-	1

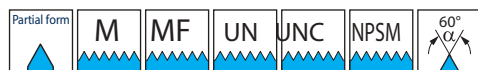
Spare Parts			
for	4 Clamping disc *	2 Clamping screw *	Screw-driver *
156508 156509 160180 156486 156485	159788	114523	178640
Screw torques max. SW6 24,5 Nm			

## Milling Inserts

- Cutting Data see page 174

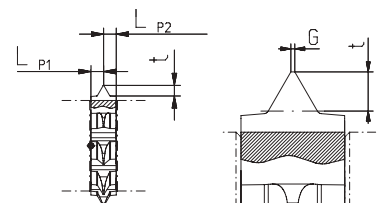


Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No TINAMATIC
6	10	40	3,415	3,1	159763



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	10	40	2,25	0,1	159836
3-4	9-6	10	40	3,80	0,25	180440

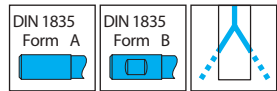
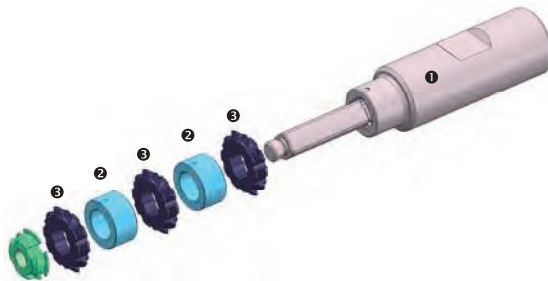
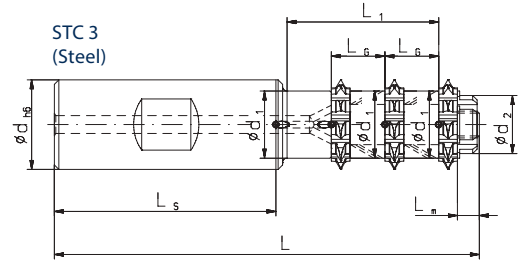
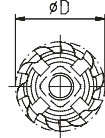
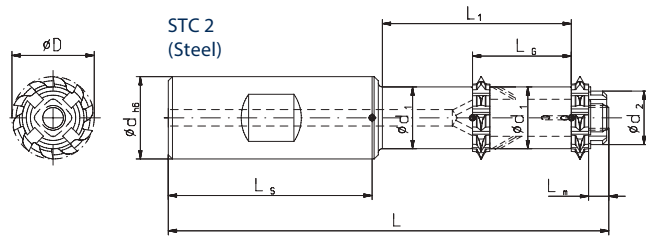


\* Included in delivery

Milling System for Threads from Drill Hole Ø 57,5 mm (

≥ M 64)

- Cutting data see page 174
- Recommendation plunging movements see page 184



Complete holder without inserts / assembling wrench

for	Spare Parts		Accessories
	Set of distance sleeves *	Slotted nut *	Key
159888 159887	159803	186145	186819
159874 159873	159795	186145	

Slotted nut torques max.  
186145 110 Nm

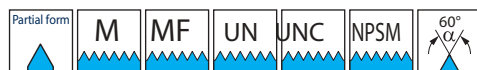
Type	Shank DIN	Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>s</sub> mm	L <sub>g</sub> mm	L <sub>m</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	Thread inserts required
STC 2 2 x D	1835 A	159888	32	202	127,3	60	66	6,5	40	32	30	2
	1835 B	159887	32	202	127,3	60	66	6,5	40	32	30	2
STC 3 1,5 x D	1835 A	159874	32	170	95,3	60	30	6,5	40	32	30	3
	1835 B	159873	32	170	95,3	60	30	6,5	40	32	30	3

Milling Inserts

- Cutting Data see page 174

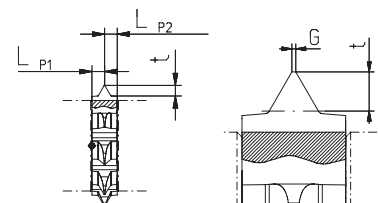


Pitch mm	Number of teeth	D mm	t mm	LP1=L P2 mm	Order No
6	10	40	3,415	3,1	TINAMATIC 159763



ATTENTION: Please ask for distance sleeves separately!

Pitch mm	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No	
1-3	24-9	10	40	2,25	0,1	3,1	TINAMATIC 159836
3-4	9-6	10	40	3,80	0,25	3,1	TINAMATIC 180440



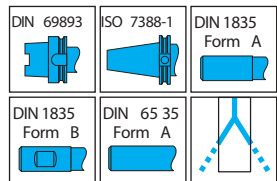
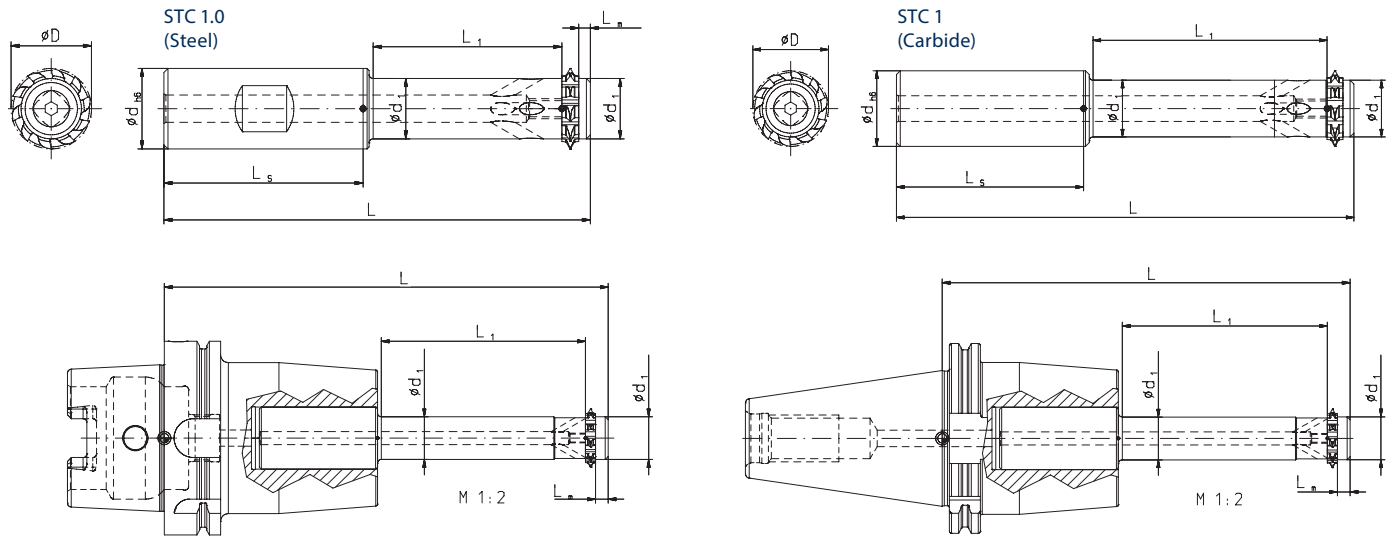
\* Included in delivery



# Milling System for Threads from Drill Hole $\varnothing 60$ mm (

$\geq M 64$ )

- Cutting data see page 174
- Recommendation plunging movements see page 184



Spare Parts			
for	④ Clamping disc *	② Clamping screw *	Screw-driver *
156510	182775	114523	178640
156511			
182044			
182715			
182716			

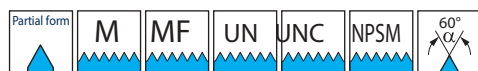
Screw torques max.  
SW6 24,5 Nm

Complete holder without Inserts

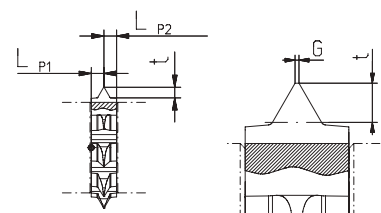
Type	Shank DIN	① Order No.	d <sub>h6</sub> mm	L mm	L <sub>1</sub> mm	L <sub>s</sub> mm	L <sub>G</sub> mm	L <sub>M</sub> mm	D mm	d <sub>1</sub> mm	d <sub>2</sub> mm	③ Thread inserts required
STC 1.0	1835 A	156510	40	232	146,4	70	-	7,4	50	39	-	1
	1835 B	156511	40	232	146,4	70	-	7,4	50	39	-	1
STC 1 3xD	6535 A	182044	40	299	196,4	88	-	7,4	50	39	-	1
	HSK 100	182715	-	351	196,4	140	-	7,4	50	39	-	1
	SK 50	182716	-	311	196,4	100	-	7,4	50	39	-	1

## Milling Inserts

- Cutting Data see page 174



Pitch mm	Pitch G / "	Number of teeth	D mm	t mm	G mm	LP1=L P2 mm	Order No TINAMATIC
1-3	24-9	12	50	2,25	0,1	3,6	181735
3-6	9-4	12	50	3,80	0,25	3,6	181736
5-8	6-3	12	50	5,30	0,4	3,6	181737



\* Included in delivery

