



EASY.

EASYTap

The New Universal Tap

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FETTE
KIENINGER
ONSRUD



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.

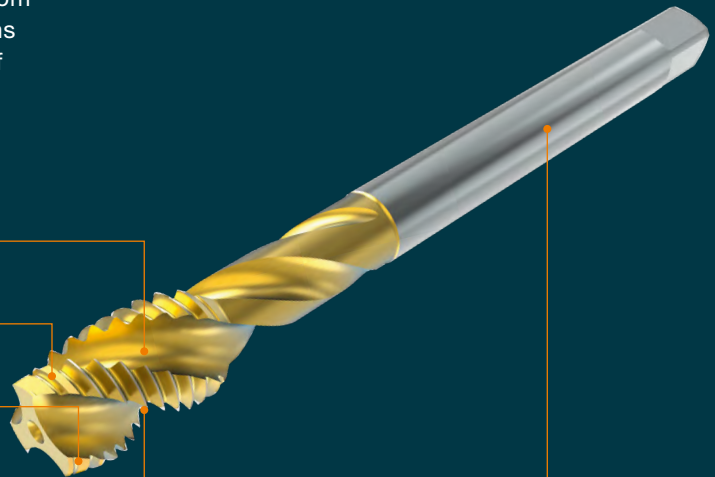
Optimized flutes enable efficient chip formation and greater process reliability

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

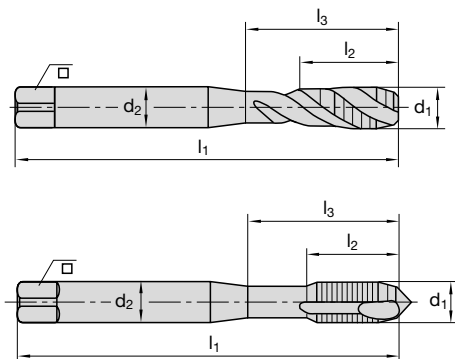
For high-performance thread machining in a wide range of materials:
steel, stainless steel, cast iron and aluminum



Blind hole



Through hole

M **EASY.** **h9** **6HX** **HSS-E** **TiN**
DIN
371 **DIN**
376


Cat-Nr.										ET01					
P1										■ v _c = 15–25 m/min					
P2										■ v _c = 10–20 m/min					
P3										■ v _c = 8–15 m/min					
M1										■ v _c = 6–12 m/min					
K2										■ v _c = 8–20 m/min					
N1										■ v _c = 15–40 m/min					
N2										■ v _c = 15–40 m/min					
N3										■ v _c = 10–30 m/min					
d ₁	P	I ₁	I ₂	I ₃	d ₂	h12	z		Ident No.	LMT-Code	Ident. No.	Ident No.	LMT-Code	Ident. No.	
with reinforced straight shank											7477314 ¹⁾				7477315 ²⁾
M6	1	80	8 ¹⁾	19 ²⁾	30	6	4.9	3	5	7465304		TC-CM 6X1-6HX-ET45-11	7465213	TC-BM 6X1-6HX-ET0-11	
M8	1.25	90	10 ¹⁾	22 ²⁾	35	8	6.2	3	6.8	7465306		TC-CM 8X1.25-6HX-ET45-11	7465215	TC-BM 8X1.25-6HX-ET0-11	
M10	1.5	100	12 ¹⁾	24 ²⁾	39	10	8	3	8.5	7465307		TC-CM 10X1.5-6HX-ET45-11	7465216	TC-BM 10X1.5-6HX-ET0-11	
with standard straight shank															
M12	1.75	110	14 ¹⁾	28 ²⁾	–	9	7	3	10.2	7465308	TC-CM 12X1.75-6HX-ET45-11	7465217	TC-BM 12X1.75-6HX-ET0-11		

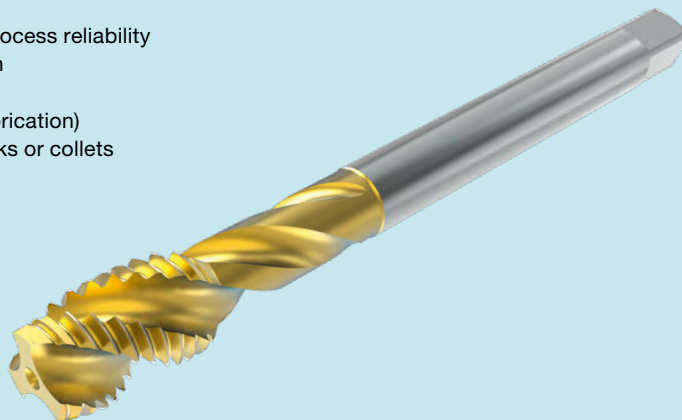
1) for blind hole thread

2) for through hole thread

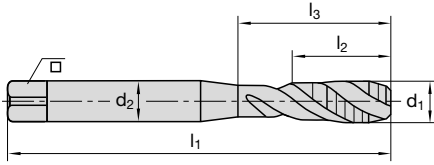
■ = First choice

Features:

- 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


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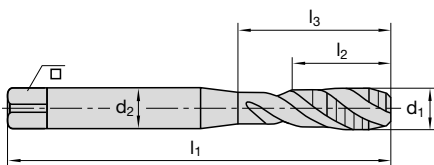
Description	Thread form	Tolerance	Chamfer	Depth of thread	Standard	Helix	Features	Page		
Blind hole thread										
	M 1–30	6HX			DIN 371/376			6		
	M 3–20							7		
	M 3–24							8		
	M 2–24							9		
	M 2–24	6GX						14		
	M 2–16	6H +1/10			DIN 374			16		
	MF 2.5–30	6HX						18		
	MF 8–20							19		
	MF 8–24							20		
	UNC No. 2–1	2BX			DIN 2184-1			24		
	UNF No. 2–1							26		
	G 1/16–1						DIN 5156			28
	G 1/8–1									29
	EGM 2–20	6HX mod			DIN 40435			32		
	NPT 1/16–1				DIN 5156				34	
Through hole thread										
	M 1–30	6HX			DIN 371/376			10		
	M 3–20							12		
	M 3–24							13		
	M 2–24		6GX					15		
	M 2–16	6H +1/10						DIN 374		
	MF 2.5–30	6HX			21					
	MF 8–20				22					
	MF 8–24				23					
	UNC No. 2–1	2BX		DIN 2184-1				25		
	UNF No. 2–1							27		
	G 1/16–1			DIN 5156					30	
	G 1/8–1								31	
	EGM 2–20	6HX mod				DIN 40435		33		



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 , < 31 HRC								■ v _c = 10–20 m/min	■ v _c = 10–20 m/min		
P3	Steel > 1000 N/mm ² , < 40 HRC								■ 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 < 29 HRC											
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

■ = First choice □ = Second choice

M	EASY.	h9	2-3xD	45°	C	6HX	HSS-E	TiN	L ₁ x2	DIN 371	DIN 376
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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 , < 31 HRC								■ v _c = 10–20 m/min	■ v _c = 10–20 m/min		
P3	Steel > 1000 N/mm ² , < 40 HRC								■ 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 < 29 HRC											
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	100	4	18	3.5	2.7	3	2.5	7465364	TC-CM 3X0.5-6HX-ET45-11-2	–	–
M4	0.7	125	5.6	21	4.5	3.4	3	3.3	7465365	TC-CM 4X0.7-6HX-ET45-11-2	–	–
M5	0.8	160	6.4	25	6	4.9	3	4.2	7465366	TC-CM 5X0.8-6HX-ET45-11-2	–	–
M6	1	160	8	30	6	4.9	3	5	7465367	TC-CM 6X1-6HX-ET45-11-2	–	–
M8	1.25	180	10	35	8	6.2	3	6.8	7465368	TC-CM 8X1.25-6HX-ET45-11-2	–	–
M10	1.5	200	12	39	10	8	3	8.5	7465369	TC-CM 10X1.5-6HX-ET45-11-2	–	–
with standard straight shank												
M4	0.7	125	5.6	–	2.8	2.1	3	3.3	–	–	7465374	TC-CM 4X0.7-6HX-ET45-11-2
M5	0.8	160	6.4	–	3.5	2.7	3	4.2	–	–	7465375	TC-CM 5X0.8-6HX-ET45-11-2
M6	1	160	8	–	4.5	3.4	3	5	–	–	7465376	TC-CM 6X1-6HX-ET45-11-2
M8	1.25	180	10	–	6	4.9	3	6.8	–	–	7465377	TC-CM 8X1.25-6HX-ET45-11-2
M10	1.5	200	12	–	7	5.5	3	8.5	–	–	7465378	TC-CM 10X1.5-6HX-ET45-11-2
M12	1.75	200	14	–	9	7	3	10.2	–	–	7465379	TC-CM 12X1.75-6HX-ET45-11-2
M14	2	200	16	–	11	9	3	12	–	–	7465371	TC-CM 14X2-6HX-ET45-11-2
M16	2	200	16	–	12	9	3	14	–	–	7465372	TC-CM 16X2-6HX-ET45-11-2
M20	2.5	200	25	–	16	12	4	17.5	–	–	7465373	TC-CM 20X2.5-6HX-ET45-11-2

■ = First choice □ = Second choice

M	EASY.	h9	2-3xD	45°	C	6HX	HSS-E	TiN		DIN 371	DIN 376
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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 , < 31 HRC								■ v _c = 10–20 m/min		■ v _c = 10–20 m/min	
P3	Steel > 1000 N/mm ² , < 40 HRC								■ 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 < 29 HRC											
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	2.5	7465379	TC-CM 3X0.5-6HX-ET45-11-A	–	–
M4	0.7	63	5.6	21	4.5	3.4	3	3.3	7465380	TC-CM 4X0.7-6HX-ET45-11-A	–	–
M5	0.8	70	6.4	25	6	4.9	3	4.2	7465381	TC-CM 5X0.8-6HX-ET45-11-A	–	–
M6	1	80	8	30	6	4.9	3	5	7465382	TC-CM 6X1-6HX-ET45-11-A	–	–
M8	1.25	90	10	35	8	6.2	3	6.8	7465383	TC-CM 8X1.25-6HX-ET45-11-A	–	–
M10	1.5	100	12	39	10	8	3	8.5	7465384	TC-CM 10X1.5-6HX-ET45-11-A	–	–
with standard straight shank												
M12	1.75	110	14	–	9	7	3	10.2	–	–	7465385	TC-CM 12X1.75-6HX-ET45-11-A
M14	2	110	16	–	11	9	3	12	–	–	7465386	TC-CM 14X2-6HX-ET45-11-A
M16	2	110	16	–	12	9	3	14	–	–	7465387	TC-CM 16X2-6HX-ET45-11-A
M20	2.5	140	25	–	16	12	4	17.5	–	–	7465388	TC-CM 20X2.5-6HX-ET45-11-A
M24	3	160	30	–	18	14.5	4	21	–	–	7465389	TC-CM 24X3-6HX-ET45-11-A

■ = First choice □ = Second choice

M	EASY.	h9	2-3xD	45°	E 1.5-2	6HX	HSS-E	TiN	DIN 371	DIN 376
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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 , < 31 HRC	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ 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 < 29 HRC		
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	7465323	TC-EM 2X0.4-6HX-ET45-11	–	–
M3	0.5	56	4	18	3.5	2.7	3	2.5	7465324	TC-EM 3X0.5-6HX-ET45-11	–	–
M4	0.7	63	5.6	21	4.5	3.4	3	3.3	7465325	TC-EM 4X0.7-6HX-ET45-11	–	–
M5	0.8	70	6.4	25	6	4.9	3	4.2	7465326	TC-EM 5X0.8-6HX-ET45-11	–	–
M6	1	80	8	30	6	4.9	3	5	7465327	TC-EM 6X1-6HX-ET45-11	–	–
M8	1.25	90	10	35	8	6.2	3	6.8	7465328	TC-EM 8X1.25-6HX-ET45-11	–	–
M10	1.5	100	12	39	10	8	3	8.5	7465329	TC-EM 10X1.5-6HX-ET45-11		
with standard straight shank												
M12	1.75	110	14	–	9	7	3	10.2	–	–	7465330	TC-EM 12X1.75-6HX-ET45-11
M14	2	110	16	–	11	9	3	12	–	–	7465331	TC-EM 14X2-6HX-ET45-11
M16	2	110	16	–	12	9	3	14	–	–	7465332	TC-EM 16X2-6HX-ET45-11
M20	2.5	140	25	–	16	12	4	17.5	–	–	7465333	TC-EM 20X2.5-6HX-ET45-11
M24	3	160	30	–	18	14.5	4	21	–	–	7465334	TC-EM 24X3-6HX-ET45-11

■ = First choice □ = Second choice

M	EASY.	h9	3xD	0°	B 3.5-5.1	6HX	HSS-E	TiN	DIN 371	DIN 376		
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 , < 31 HRC					■ v _c = 10–20 m/min		■ v _c = 10–20 m/min				
P3	Steel > 1000 N/mm ² , < 40 HRC					■ 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 < 29 HRC											
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	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	–	–
M 2	0.4	45	8	–	2.8	2.1	2	1.6	7465203	TC-BM 2X0.4-6HX-ET0-11	–	–
M 2.2	0.45	45	9	–	2.8	2.1	2	1.75	7465204	TC-BM 2.2X0.45-6HX-ET0-11	–	–
M 2.3	0.4	45	9	–	2.8	2.1	2	1.9	7465205	TC-BM 2.3X0.4-6HX-ET0-11	–	–
M 2.5	0.45	50	9	–	2.8	2.1	2	2.05	7465206	TC-BM 2.5X0.45-6HX-ET0-11	–	–
M 2.6	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	–	–
								</				

■ = First choice □ = Second choice



M	EASY.	h9	3xD	0°	B 3.5–5.1	6HX	HSS-E	TiN	DIN 371	DIN 376
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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 , < 31 HRC	■ v _c = 10–20 m/min	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ 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 < 29 HRC		
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 standard straight shank												
M3	0.5	56	11	–	2.2	–	3	2.5	–	–	7465226	TC-BM 3X0.5-6HX-ET0-11
M4	0.7	63	13	–	2.8	2.1	3	3.3	–	–	7465227	TC-BM 4X0.7-6HX-ET0-11
M5	0.8	70	16	–	3.5	2.7	3	4.2	–	–	7465228	TC-BM 5X0.8-6HX-ET0-11
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

■ = First choice □ = Second choice

M	EASY.	h9	3xD	0°	B 3.5-5.1	6HX	HSS-E	TiN	L ₁ x2	DIN 371	DIN 376	
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 , < 31 HRC								■ v _c = 10–20 m/min	■ v _c = 10–20 m/min		
P3	Steel > 1000 N/mm ² , < 40 HRC								■ 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 < 29 HRC											
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	100	11	20	3.5	2.7	3	2.5	7465261	TC-BM 3X0.5-6HX-ET0-11-2	–	–
M4	0.7	125	13	27	4.5	3.4	3	3.3	7465262	TC-BM 4X0.7-6HX-ET0-11-2	–	–
M5	0.8	160	16	33	6	4.9	3	4.2	7465263	TC-BM 5X0.8-6HX-ET0-11-2	–	–
M6	1	160	19	40	6	4.9	3	5	7465264	TC-BM 6X1-6HX-ET0-11-2	–	–
M8	1.25	180	22	52.4	8	6.2	3	6.8	7465265	TC-BM 8X1.25-6HX-ET0-11-2	–	–
M10	1.5	200	24	65	10	8	3	8.5	7465266	TC-BM 10X1.5-6HX-ET0-11-2	–	–
with standard straight shank												
M4	0.7	125	13	–	2.8	2.1	3	3.3	–	–	7465271	TC-BM 4X0.7-6HX-ET0-11-2
M5	0.8	160	16	–	3.5	2.7	3	4.2	–	–	7465272	TC-BM 5X0.8-6HX-ET0-11-2
M6	1	160	19	–	4.5	3.4	3	5	–	–	7465273	TC-BM 6X1-6HX-ET0-11-2
M8	1.25	180	22	–	6	4.9	3	6.8	–	–	7465274	TC-BM 8X1.25-6HX-ET0-11-2
M10	1.5	200	24	–	7	5.5	3	8.5	–	–	7465275	TC-BM 10X1.5-6HX-ET0-11-2
M12	1.75	200	28	–	9	7	3	10.2	–	–	7465267	TC-BM 12X1.75-6HX-ET0-11-2
M14	2	200	30	–	11	9	3	12	–	–	7465268	TC-BM 14X2-6HX-ET0-11-2
M16	2	200	32	–	12	9	3	14	–	–	7465269	TC-BM 16X2-6HX-ET0-11-2
M20	2.5	200	34	–	16	12	3	17.5	–	–	7465270	TC-BM 20X2.5-6HX-ET0-11-2

■ = First choice □ = Second choice

M EASY. h9 3xD 0° B 3.5-5.1 6HX HSS-E TiN DIN 371 DIN 376												
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 , < 31 HRC								■ v _c = 10–20 m/min		■ v _c = 10–20 m/min	
P3	Steel > 1000 N/mm ² , < 40 HRC								■ 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 < 29 HRC											
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	11	18	3.5	2.7	3	2.5	7465276	TC-BM 3X0.5-6HX-ET0-11-A	–	–
M4	0.7	63	13	21	4.5	3.4	3	3.3	7465277	TC-BM 4X0.7-6HX-ET0-11-A	–	–
M5	0.8	70	16	25	6	4.9	3	4.2	7465278	TC-BM 5X0.8-6HX-ET0-11-A	–	–
M6	1	80	19	30	6	4.9	3	5	7465279	TC-BM 6X1-6HX-ET0-11-A	–	–
M8	1.25	90	22	35	8	6.2	3	6.8	7465280	TC-BM 8X1.25-6HX-ET0-11-A	–	–
M10	1.5	100	24	39	10	8	3	8.5	7465281	TC-BM 10X1.5-6HX-ET0-11-A	–	–
with standard straight shank												
M12	1.75	110	28	–	9	7	3	10.2	–	–	7465282	TC-BM 12X1.75-6HX-ET0-11-A
M14	2	110	30	–	11	9	3	12	–	–	7465283	TC-BM 14X2-6HX-ET0-11-A
M16	2	110	32	–	12	9	3	14	–	–	7465284	TC-BM 16X2-6HX-ET0-11-A
M20	2.5	140	34	–	16	12	3	17.5	–	–	7465285	TC-BM 20X2.5-6HX-ET0-11-A
M24	3	160	38	–	18	14.5	3	21	–	–	7465286	TC-BM 24X3-6HX-ET0-11-A

■ = First choice □ = Second choice

M	EASY.	h9	2-3xD	45°	C	6GX	HSS-E	TiN	DIN 371	DIN 376
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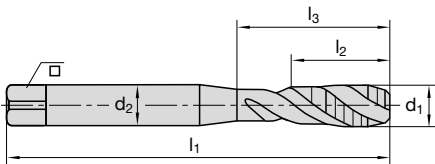
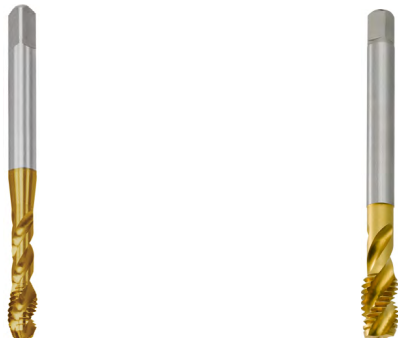
Cat.-No.							ET01		ET01	
P1	Steel < 500 N/mm ²						■	v _c = 15–25 m/min	■	v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC						■	v _c = 10–20 m/min	■	v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC						■	v _c = 8–15 m/min	■	v _c = 8–15 m/min
M1	Stainless steel austenitic						■	v _c = 6–12 m/min	■	v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC									
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

M EASY. h9 3xD 0° B 3.5-5.1 6GX HSS-E TiN DIN 371 DIN 376												
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 , < 31 HRC							■ v _c = 10–20 m/min			■ v _c = 10–20 m/min		
P3 Steel > 1000 N/mm ² , < 40 HRC							■ 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 < 29 HRC												
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

M EASY. h9 2-3xD 45° C 6H +1/10¹⁾ HSS-E TiN DIN 371 DIN 376												
 												
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 , < 31 HRC						■ v _c = 10–20 m/min			■ v _c = 10–20 m/min		
P3	Steel > 1000 N/mm ² , < 40 HRC						■ 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 < 29 HRC											
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	7491485	TC-CM 2X0.4-6H+0.1-ET45-11	–	–
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

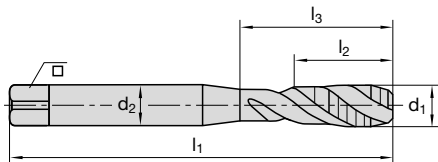
¹⁾ Tolerance class 6H+0.1

■ = First choice □ = Second choice

M EASY. h9 3xD 0° B 3.5-5.1 6H +1/10¹⁾ HSS-E TiN DIN 371 DIN 376												
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 , < 31 HRC						■ v _c = 10–20 m/min			■ v _c = 10–20 m/min		
P3	Steel > 1000 N/mm ² , < 40 HRC						■ 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 < 29 HRC											
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	10	2.8	2.1	2	1.6	7491484	TC-BM 2X0.4-6H+0.1-ET0-11	–	–
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

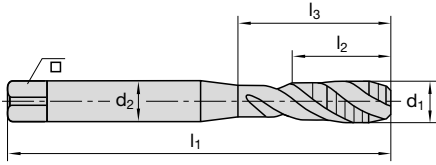
¹⁾ Tolerance class 6H+0.1

■ = First choice □ = Second choice

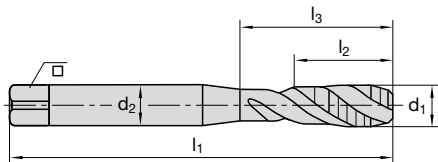


Cat.-No.								ET01	
P1	Steel < 500 N/mm ²							■ v _c = 15–25 m/min	
P2	Steel 500–1000 N/mm ² , < 31 HRC							■ v _c = 10–20 m/min	
P3	Steel > 1000 N/mm ² , < 40 HRC							■ v _c = 8–15 m/min	
M1	Stainless steel austenitic							■ v _c = 6–12 m/min	
M2	Stainless steel martensitic < 29 HRC								
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

■ = First choice □ = Second choice



■ = First choice □ = Second choice



Cat.-No.

ET01

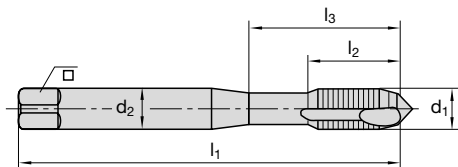
P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC	
K1	Grey cast iron	
K2	Nodular cast iron	■ v _c = 8–20 m/min
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
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with standard straight shank

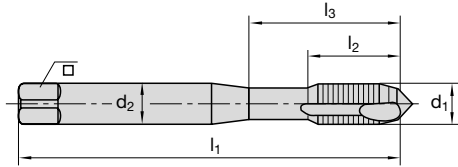
MF 8	1	90	10	6	4.9	3	7	7465480	TC-CMF 8X1-6HX-ET45-11-A
MF 10	1	90	10	7	5.5	3	9	7465481	TC-CMF 10X1-6HX-ET45-11-A
MF 10	1.25	100	12	7	5.5	3	8.75	7465482	TC-CMF 10X1.25-6HX-ET45-11-A
MF 12	1.25	100	12	9	7	3	10.75	7465483	TC-CMF 12X1.25-6HX-ET45-11-A
MF 12	1.5	100	14	9	7	3	10.5	7465484	TC-CMF 12X1.5-6HX-ET45-11-A
MF 16	1.5	100	16	12	9	3	14.5	7465485	TC-CMF 16X1.5-6HX-ET45-11-A
MF 20	1.5	125	16	16	12	4	18.5	7465486	TC-CMF 20X1.5-6HX-ET45-11-A
MF 24	1.5	140	16	18	14.5	4	22.5	7465487	TC-CMF 24X1.5-6HX-ET45-11-A

■ = First choice □ = Second choice

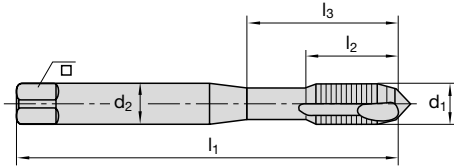


Cat.-No.								ET01	
P1	Steel < 500 N/mm ²							■ v _c = 15–25 m/min	
P2	Steel 500–1000 N/mm ² , < 31 HRC							■ v _c = 10–20 m/min	
P3	Steel > 1000 N/mm ² , < 40 HRC							■ v _c = 8–15 m/min	
M1	Stainless steel austenitic							■ v _c = 6–12 m/min	
M2	Stainless steel martensitic < 29 HRC								
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

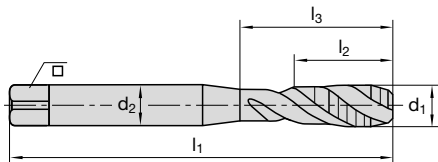
■ = First choice □ = Second choice



■ = First choice □ = Second choice



■ = First choice □ = Second choice



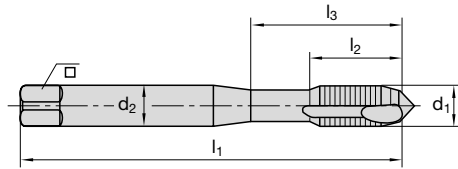
Cat.-No.

ET01

P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC	
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	

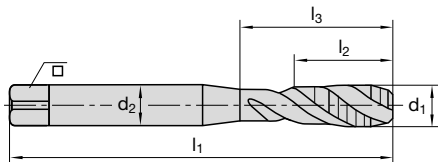
d ₁	P	l ₁	l ₂	l ₃	d ₂	□ h12	z	Ident No.	LMT-Code
with reinforced straight shank									
UNC No. 2	56	45	3.6	11	2.8	2.1	2	7465559	TC-CUNC #2-56X3.6-ET45-11
UNC No. 3	48	50	3.6	13	2.8	2.1	2	7465560	TC-CUNC #3-48X3.6-ET45-11
UNC No. 4	40	56	5.1	18	3.5	2.7	2	7465561	TC-CUNC #4-40X5.1-ET45-11
UNC No. 5	40	56	5.1	18	3.5	2.7	2	7465562	TC-CUNC #5-40X5.1-ET45-11
UNC No. 6	32	56	6.4	20	4	3	2	7465563	TC-CUNC #6-32X6.4-ET45-11
UNC No. 8	32	63	6.4	21	4.5	3.4	2	7465564	TC-CUNC #8-32X6.4-ET45-11
UNC No. 10	24	70	8.5	25	6	4.9	2	7465565	TC-CUNC #10-24X8.5-ET45-11
UNC No. 12	24	80	8.5	30	6	4.9	2	7465566	TC-CUNC #12-24X8.5-ET45-11
UNC 1/4	20	80	10.2	30	7	5.5	2	7465567	TC-CUNC 1/4-20X10.2-ET45-11
UNC 5/16	18	90	11.3	35	8	6.2	3	7465568	TC-CUNC 5/16-18X11.3-ET45-11
UNC 3/8	16	100	12.7	39	10	8	3	7465569	TC-CUNC 3/8-16X12.7-ET45-11
with standard straight shank									
UNC 1/2	13	110	15.6	–	9	7	3	7465570	TC-CUNC 1/2-13X15.6-ET45-11
UNC 5/8	11	110	18.5	–	12	9	3	7465571	TC-CUNC 5/8-11X18.5-ET45-11
UNC 3/4	10	125	25.4	–	14	11	4	7465572	TC-CUNC 3/4-10X25.4-ET45-11
UNC 7/8	9	140	28.2	–	18	14.5	4	7465573	TC-CUNC 7/8-9X28.2-ET45-11
UNC 1	8	160	31.8	–	18	14.5	4	7465574	TC-CUNC 1-8X31.8-ET45-11

■ = First choice □ = Second choice



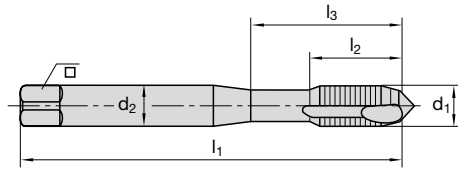
Cat.-No.										ET01	
P1	Steel < 500 N/mm ²									■	v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC									■	v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC									■	v _c = 8–15 m/min
M1	Stainless steel austenitic									■	v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC										
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/mm²								■	v _c = 15–25 m/min
P2	Steel 500–1000 N/mm², < 31 HRC								■	v _c = 10–20 m/min
P3	Steel > 1000 N/mm², < 40 HRC								■	v _c = 8–15 m/min
M1	Stainless steel austenitic								■	v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC									
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/mm²									
S2	Titanium alloys high strength < 1300 N/mm²									
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

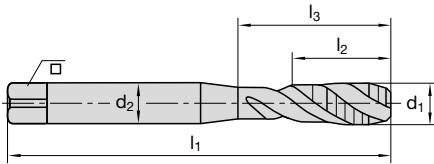
■ = First choice □ = Second choice



Cat.-No.		ET01	
P1	Steel < 500 N/mm ²	■	v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC	■	v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■	v _c = 8–15 m/min
M1	Stainless steel austenitic	■	v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC		
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



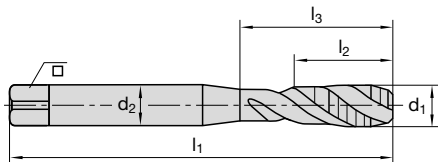
Cat.-No.

ET01

P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC	
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

■ = First choice □ = Second choice



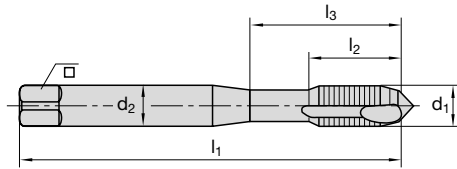
Cat.-No.

ET01

P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC	
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	

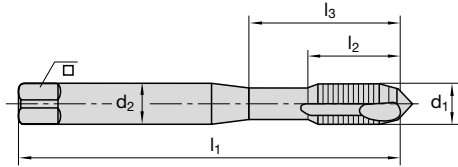
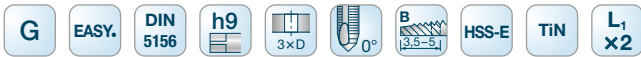
d ₁	P	l ₁	l ₂	d ₂	□ h12	z		Ident No.	LMT-Code
with standard straight shank									
G 1/8	28	180	9.1	7	5.5	3	8.8	7465532	TC-CG 1/8X9.1-ET45-11-2
G 1/4	19	200	13.4	11	9	3	11.8	7465533	TC-CG 1/4X13.4-ET45-11-2
G 3/8	19	200	13.4	12	9	4	15.25	7465534	TC-CG 3/8X13.4-ET45-11-2
G 1/2	14	250	18.2	16	12	4	19	7465535	TC-CG 1/2X18.2-ET45-11-2
G 3/4	14	280	28	20	16	4	24.5	7465536	TC-CG 3/4X28-ET45-11-2
G 1	11	280	30	25	20	4	30.75	7465537	TC-CG 1X30-ET45-11-2

■ = 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 , < 31 HRC							■ v _c = 10–20 m/min	
P3	Steel > 1000 N/mm ² , < 40 HRC							■ v _c = 8–15 m/min	
M1	Stainless steel austenitic							■ v _c = 6–12 m/min	
M2	Stainless steel martensitic < 29 HRC								
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

■ = First choice □ = Second choice



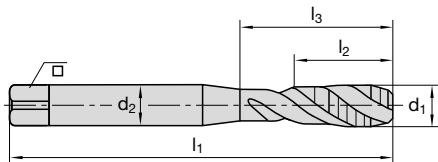
Cat.-No.

ET01

P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC	
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 1/8	28	180	20	7	5.5	3	8.8	7465518	TC-BG 1/8X20-ET0-11-2
G 1/4	19	200	22	11	9	3	11.8	7465519	TC-BG 1/4X22-ET0-11-2
G 3/8	19	200	22	12	9	3	15.25	7465520	TC-BG 3/8X22-ET0-11-2
G 1/2	14	250	25	16	12	3	19	7465521	TC-BG 1/2X25-ET0-11-2
G 3/4	14	280	28	20	16	4	24.5	7465522	TC-BG 3/4X28-ET0-11-2
G 1	11	280	30	25	20	4	30.75	7465523	TC-BG 1X30-ET0-11-2

■ = First choice □ = Second choice



Cat.-No.

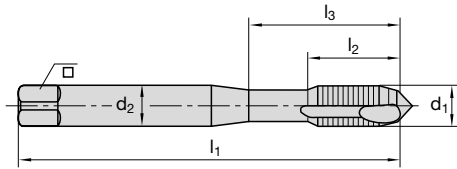
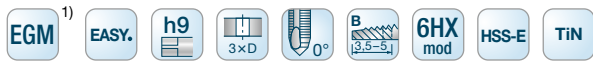
ET01

P1	Steel < 500 N/mm ²	■ v _c = 15–25 m/min
P2	Steel 500–1000 N/mm ² , < 31 HRC	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC	
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	7465499	TC-EEGM 2X0,4-6HX
EG M 2.5	0.45	56	5	18	3.5	2.7	3	7465500	TC-EEGM 2,5X0,45-6HX
EG M 3	0.5	63	5	21	4.5	3.4	3	7465501	TC-EEGM 3X0,5-6HX
EG M 4	0.7	70	7	25	6	4.9	3	7465502	TC-EEGM 4X0,7-6HX
EG M 5	0.8	80	8	30	6	4.9	3	7465503	TC-EEGM 5X0,8-6HX
EG M 6	1	90	10	35	8	6.2	3	7465504	TC-EEGM 6X1-6HX
EG M 8	1.25	100	13	39	10	8	3	7465505	TC-EEGM 8X1,25-6HX
with standard straight shank									
EG M10	1.5	100	15	–	9	7	3	7465506	TC-EEGM 10X1,5-6HX
EG M12	1.75	110	18	–	11	9	3	7465507	TC-EEGM 12X1,75-6HX
EG M16	2	125	20	–	14	11	4	7465508	TC-EEGM 16X2-6HX
EG M20	2.5	160	25	–	18	14.5	4	7465509	TC-EEGM 20X2,5-6HX

¹⁾ Metric insert thread for wire thread inserts

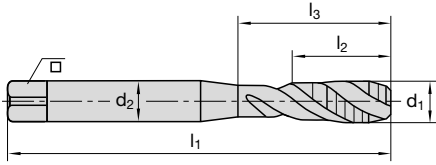
■ = First choice □ = Second choice



Cat.-No.									ET01		
P1	Steel < 500 N/mm ²								■	v _c = 15–25 m/min	
P2	Steel 500–1000 N/mm ² , < 31 HRC								■	v _c = 10–20 m/min	
P3	Steel > 1000 N/mm ² , < 40 HRC								■	v _c = 8–15 m/min	
M1	Stainless steel austenitic								■	v _c = 6–12 m/min	
M2	Stainless steel martensitic < 29 HRC										
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 2X0,4-6HX	
EG M 2.5	0.45	56	11	18	3.5	2.7	3	2.65	7465489	TC-BEGM 2,5X0,45-6HX	
EG M 3	0.5	63	13	21	4.5	3.4	3	3.15	7465490	TC-BEGM 3X0,5-6HX	
EG M 4	0.7	70	16	25	6	4.9	3	4.2	7465491	TC-BEGM 4X0,7-6HX	
EG M 5	0.8	80	19	30	6	4.9	3	5.25	7465492	TC-BEGM 5X0,8-6HX	
EG M 6	1	90	22	35	8	6.2	3	6.3	7465493	TC-BEGM 6X1-6HX	
EG M 8	1.25	100	24	39	10	8	3	8.4	7465494	TC-BEGM 8X1,25-6HX	
with standard straight shank											
EG M10	1.5	100	29	–	9	7	3	10.5	7465495	TC-BEGM 10X1,5-6HX	
EG M12	1.75	110	30	–	11	9	3	12.5	7465496	TC-BEGM 12X1,75-6HX	
EG M16	2	125	34	–	14	11	3	16.5	7465497	TC-BEGM 16X2-6HX	
EG M20	2.5	160	34	–	18	14.5	3	20.5	7465498	TC-BEGM 20X2,5-6HX	

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 , < 31 HRC	■ v _c = 10–20 m/min
P3	Steel > 1000 N/mm ² , < 40 HRC	■ v _c = 8–15 m/min
M1	Stainless steel austenitic	■ v _c = 6–12 m/min
M2	Stainless steel martensitic < 29 HRC	
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:

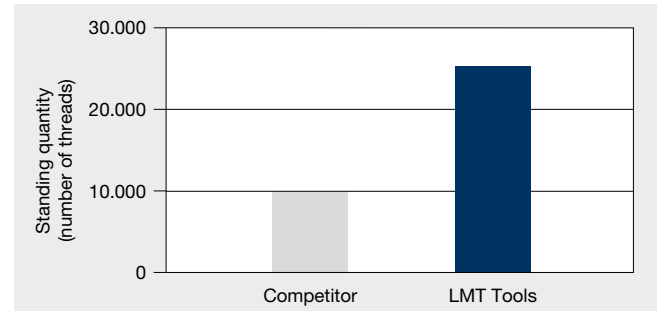
Stainless steel martensitic, 1.4104/X14CrMoS17,
 $R_m = 730 \text{ N/mm}^2$

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:

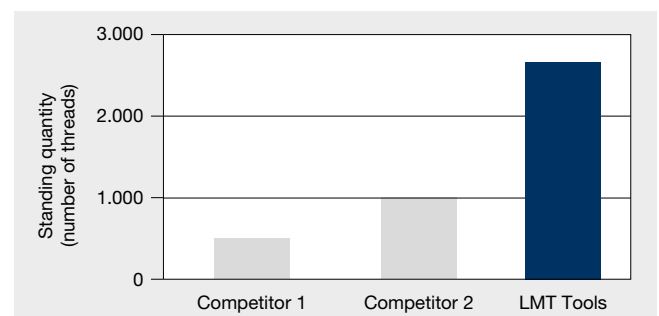
Stainless steel austenitic, 1.4404/X2CrNiMo17-12-2,
 $R_m = 700 \text{ N/mm}^2$

Cutting data:

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

Further details:

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



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