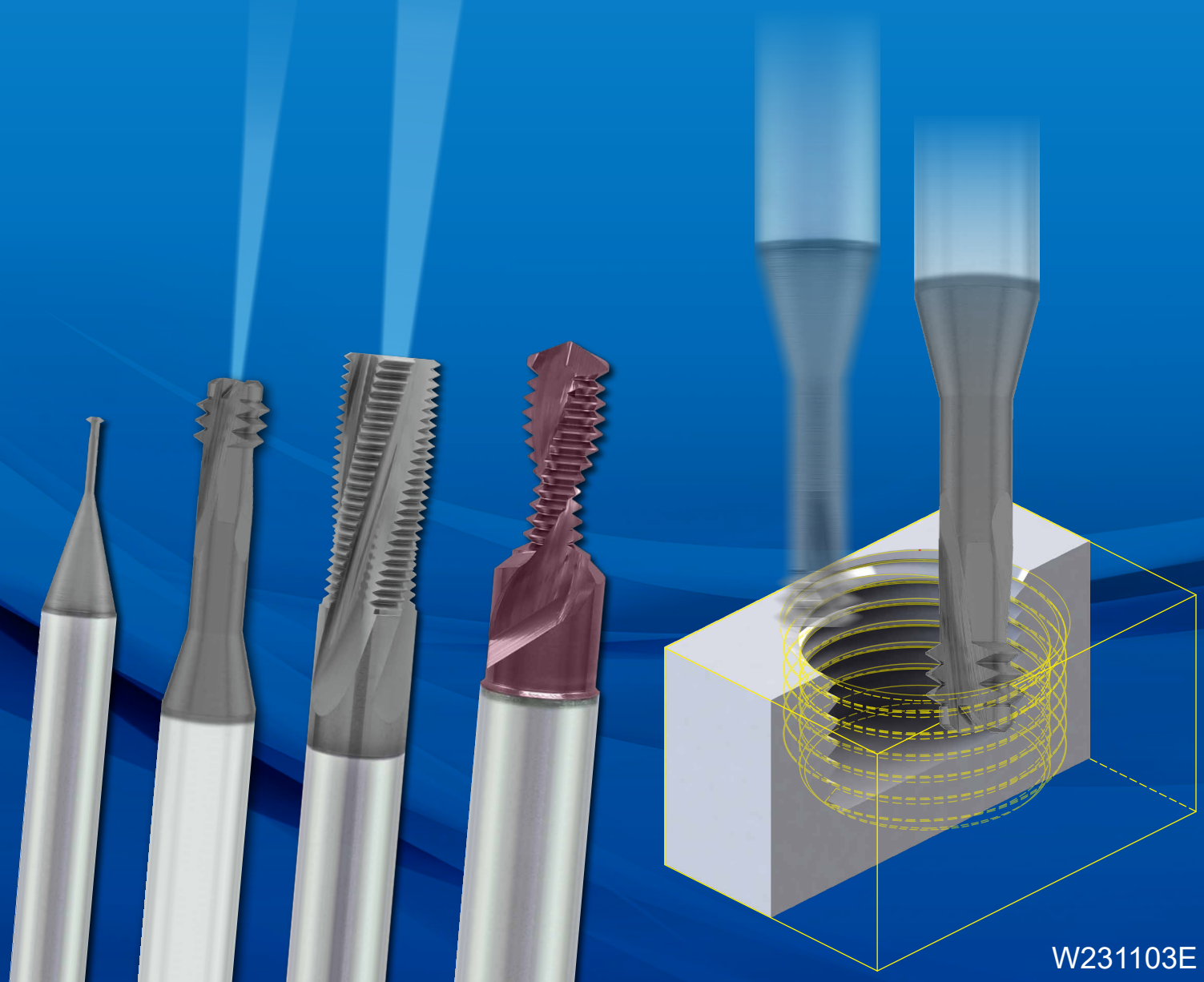
ET Series Solid Carbide Thread Mills

- ETS, ETT, ETM for thread milling.
- ETC for thread milling + chamfering.
- ETL for helical drilling + thread milling + chamfering.
- ETD for drilling + chamfering + thread milling.



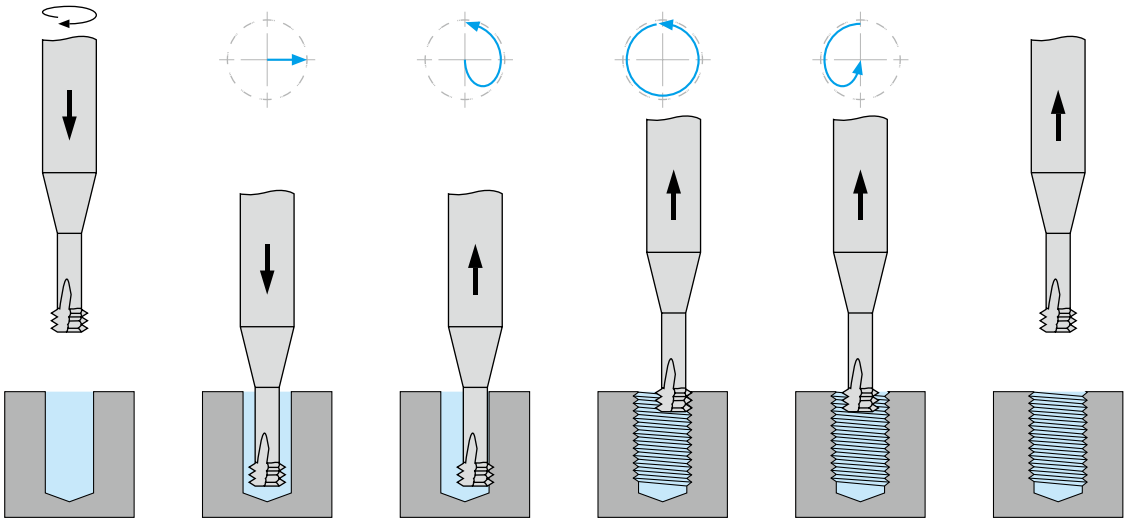
W231103E

Thread mills Index

Type Number		Pitch		No. of Threads	Thread milling	Chamfering	Helical drilling	Drilling	P	M	K	N	S	H	Page
ETSN		TP	0.25~1.75	1	✓				●	●	●		○	○	04
ETTN		TP TPI	0.35~2.5 36~10	3	✓				●	●	●		●	●	05
ETTC		TP TPI	0.45~2.5 36~10	3	✓				●	●	●		●	●	06
ETCN		TP TPI	0.7~2.0 40~11	3	✓	✓			●	●	●		●	●	07
ETCC		TP TPI	0.5~2.0 36~13	3	✓	✓			●	●	●		●	●	08
ETLN	 Left hand cutting	TP TPI	0.7~2.0 40~11	3	✓	✓	✓		●	●	●		●	●	09
ETLC	 Left hand cutting	TP TPI	0.5~2.0 36~13	3	✓	✓	✓		●	●	●		●	●	10
ETMN		TP TPI	1~2.5 36~8	12~24	✓				●	●	●		○	○	11
ETMC		TP	1~1.5	12~24	✓				●	●	●		○	○	13
ETDN		TP	0.8~1.5	11~12	✓	✓		✓			●	●			14

ET - Cutting Method

ETS, ETT, ETM Cutting Method



① Start point, position at center of hole

② Go to first helical start position

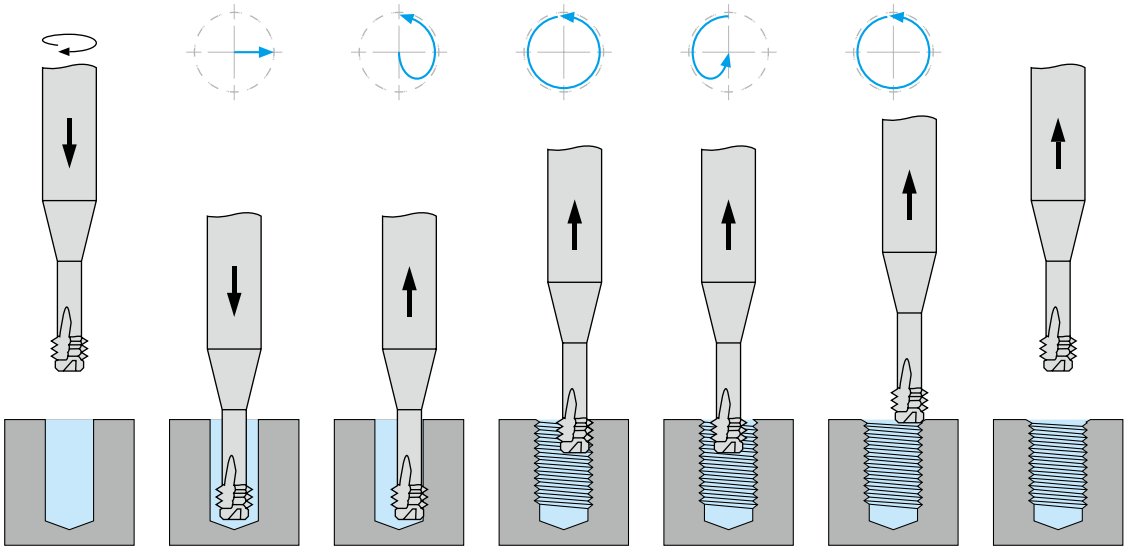
③ Entrance for thread milling

④ Thread milling by helical

⑤ Complete, move to the center of hole

⑥ Return to start point

ETC Cutting Method



① Start point, position at center of hole

② Go to first helical start position

③ Entrance for thread milling

④ Thread milling by helical

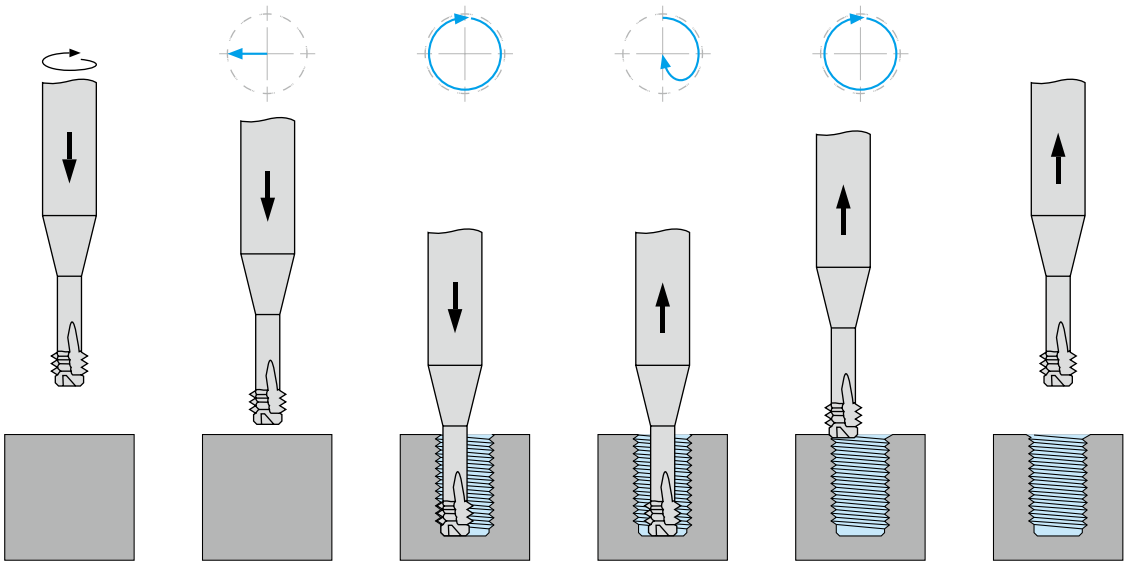
⑤ Complete, move to the center of hole

⑥ Chamfering

⑦ Return to start point

ET - Cutting Method

ETL Cutting Method



① Start position

② Move to helical start position

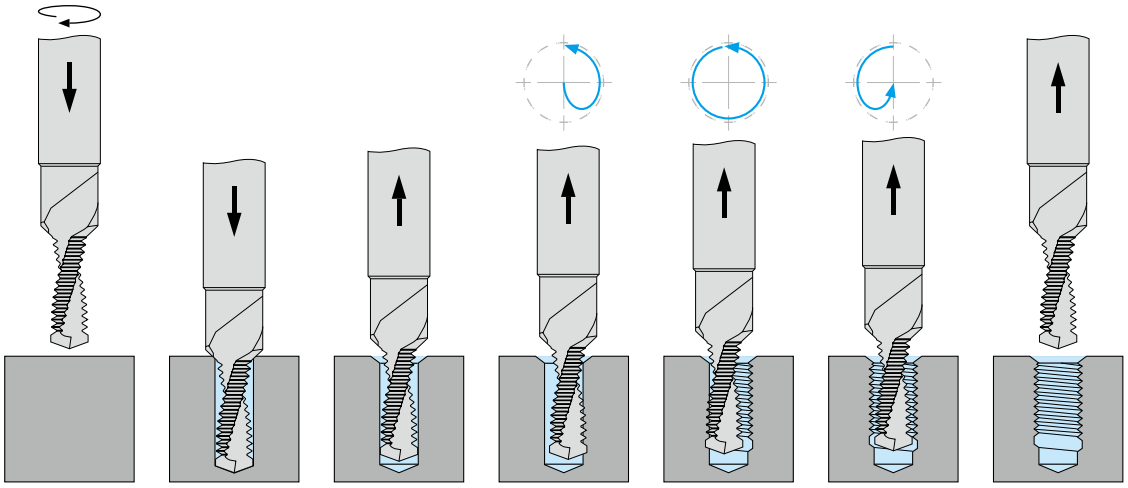
③ Drilling & threading with helical interpolation

④ Complete, move to the center of hole

⑤ Chamfering

⑥ Return to start point

ETD Cutting Method



① Start position

② Drilling & chamfering

③ Up 1/3 pitch

④ Entrance 1/8 pitch

⑤ Thread milling 1 pitch

⑥ Complete, move to the center of hole

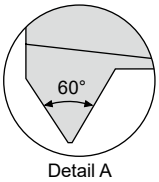
⑦ Return to start point

ET - ETSN Thread mills · 3F / 4F / 5F

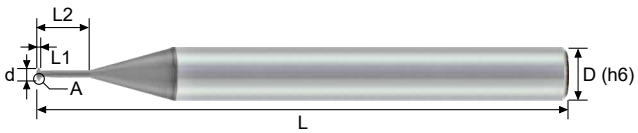
ETSNM (ISO M)

P	M	K	N	S	H
●	●	●		○	○

3 4 5 10~15° UMG ANAX



Detail A



Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (z)
ETSNM30072025A	M1	0.25	0.72	0.25	1	2.75	42	4	3
ETSNM30091025A	M1.2	0.25	0.91	0.25	1	3.25	42	4	3
ETSNM30105030A	M1.4	0.30	1.05	0.30	1	3.80	42	4	3
ETSNM30120035A	M1.6	0.35	1.20	0.35	1	4.35	42	4	3
ETSNM30130035A	M1.7~M1.8	0.35	1.30	0.35	1	4.85	42	4	3
ETSNM30152040A	M2	0.40	1.52	0.40	1	6	42	4	3
ETSNM30240050A	M3	0.50	2.40	0.50	1	9	42	4	3
ETSNM30315070A	M4	0.70	3.15	0.70	1	12	50	4	3
ETSNM40480100A	M6	1.00	4.80	1.00	1	18	60	6	4
ETSNM40590125A	M8	1.25	5.90	1.25	1	25	75	6	4
ETSNM50820150A	M10	1.50	8.20	1.50	1	32	75	10	5
ETSNM50990175A	M12	1.75	9.90	1.75	1	38	75	10	5

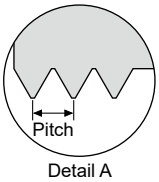
※Customized specification available.

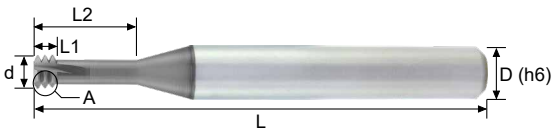
ET - ETTN Thread mills · 3F / 4F

ETTNM (ISO M)

P M K N S H

3 4 10~15° UMG ANAX



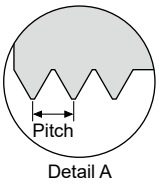


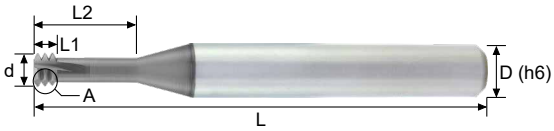
Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (z)
ETTNM30135035A	M1.8	0.35	1.35	1.05	3	4.0	50	6	3
ETTNM30150040A	M2	0.40	1.5	1.20	3	4.4	50	6	3
ETTNM30190045A	M2.5	0.45	1.9	1.35	3	5.6	50	6	3
ETTNM30240050A	M3	0.50	2.4	1.50	3	6.5	50	6	3
ETTNM30310070A	M4	0.70	3.1	2.10	3	8.7	50	6	3
ETTNM30400080A	M5	0.80	4.0	2.40	3	10.8	50	6	3
ETTNM30480100A	M6	1.00	4.8	3.00	3	12.5	50	6	3
ETTNM40650125A	M8	1.25	6.5	3.75	3	16.6	60	8	4
ETTNM40820150A	M10	1.50	8.2	4.50	3	20.8	75	10	4
ETTNM40990175A	M12	1.75	9.9	5.25	3	25.0	75	10	4
ETTNM41190200A	M16	2.00	11.9	6.00	3	33.0	75	12	4
ETTNM41590250A	M20	2.50	15.9	7.50	3	41.3	100	16	4

ETTNU (UN)

P M K N S H

3 4 10~15° UMG ANAX



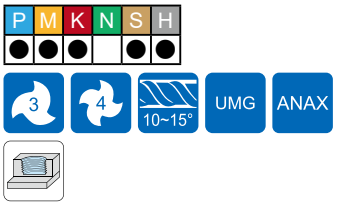


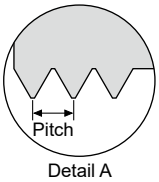
Order No.	TPI	Thread		Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (z)
		UNC	UNF							
ETTNU30331036A	36		8-36UNF	3.31	2.12	3	8.8	50	4	3
ETTNU30257032A	32	6-32UNC		2.57	2.38	3	7.3	50	4	3
ETTNU30322032A	32	8-32UNC	10-32UNF	3.22	2.38	3	10.1	60	6	3
ETTNU30520028A	28		1/4-28UNF	5.2	2.72	3	14	60	6	3
ETTNU40355024A	24	10-24UNC		3.55	3.18	3	10.4	60	6	4
ETTNU40665024A	24		5/16-24UNF	6.65	3.18	3	16.7	60	8	4
ETTNU40485020A	20	1/4-20UNC	7/16-20UNF	4.85	3.81	3	13.7	60	6	4
ETTNU40795020A	20		7/16-20UNF	7.95	3.81	3	24	60	8	4
ETTNU40595018A	18	5/16-18UNC		5.95	4.23	3	16.5	60	6	4
ETTNU40690016A	16	3/8-16UNC		6.9	4.76	3	21	60	8	4
ETTNU40795014A	14	7/16-14UNC		7.95	5.44	3	23.5	60	8	4
ETTNU40930013A	13	1/2-13UNC		9.3	5.86	3	27	80	10	4
ETTNU40995012A	12	9/16-12UNC		9.95	6.35	3	29	80	10	4
ETTNU41150011A	11	5/8-11UNC		11.5	6.93	3	33	80	12	4
ETTNU41440010A	10	3/4-10UNC		14.4	7.62	3	42	110	16	4

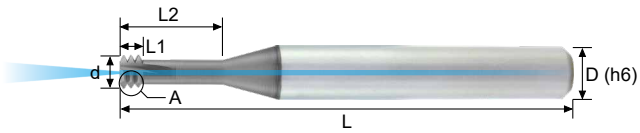
※Customized specification available.

ET - ETTC Thread mills · 3F / 4F

ETTCM (ISO M with Internal Coolant)

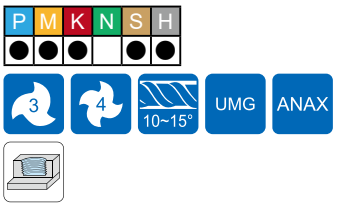


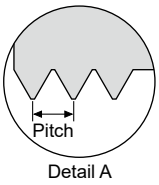


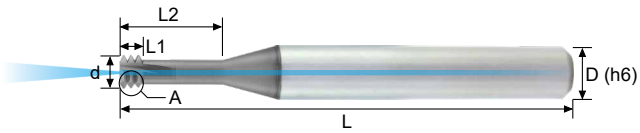


Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (z)
ETTCM30190045A	M2.5	0.45	1.9	1.35	3	5.6	50	6	3
ETTCM30240050A	M3	0.50	2.4	1.50	3	6.5	50	6	3
ETTCM30310070A	M4	0.70	3.1	2.10	3	8.7	50	6	3
ETTCM30400080A	M5	0.80	4.0	2.40	3	10.8	50	6	3
ETTCM30480100A	M6	1.00	4.8	3.00	3	12.5	50	6	3
ETTCM40650125A	M8	1.25	6.5	3.75	3	16.6	60	8	4
ETTCM40820150A	M10	1.50	8.2	4.50	3	20.8	75	10	4
ETTCM40990175A	M12	1.75	9.9	5.25	3	25.0	75	10	4
ETTCM41190200A	M16	2.00	11.9	6.00	3	33.0	75	12	4
ETTCM41590250A	M20	2.50	15.9	7.50	3	41.3	100	16	4

ETTCU (UN with Internal Coolant)







Order No.	TPI	Thread		Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (z)
		UNC	UNF							
ETTCU30331036A	36		8-36UNF	3.31	2.12	3	8.8	50	4	3
ETTCU30257032A	32	6-32UNC		2.57	2.38	3	7.3	50	4	3
ETTCU30322032A	32	8-32UNC	10-32UNF	3.22	2.38	3	10.1	60	6	3
ETTCU30520028A	28		1/4-28UNF	5.2	2.72	3	14	60	6	3
ETTCU40355024A	24	10-24UNC		3.55	3.18	3	10.4	60	6	4
ETTCU40665024A	24		5/16-24UNF	6.65	3.18	3	16.7	60	8	4
ETTCU40485020A	20	1/4-20UNC	7/16-20UNF	4.85	3.81	3	13.7	60	6	4
ETTCU40795020A	20		7/16-20UNF	7.95	3.81	3	24	60	8	4
ETTCU40595018A	18	5/16-18UNC		5.95	4.23	3	16.5	60	6	4
ETTCU40690016A	16	3/8-16UNC		6.9	4.76	3	21	60	8	4
ETTCU40795014A	14	7/16-14UNC		7.95	5.44	3	23.5	60	8	4
ETTCU40930013A	13	1/2-13UNC		9.3	5.86	3	27	80	10	4
ETTCU40995012A	12	9/16-12UNC		9.95	6.35	3	29	80	10	4
ETTCU41150011A	11	5/8-11UNC		11.5	6.93	3	33	80	12	4
ETTCU41440010A	10	3/4-10UNC		14.4	7.62	3	42	110	16	4

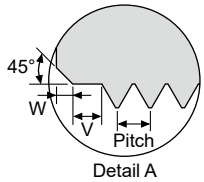
※Customized specification available.

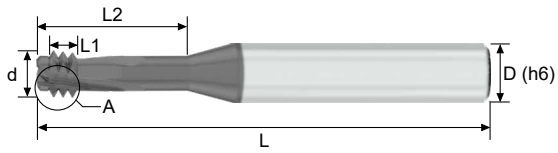
ET - ETCN Chamfer Thread mills · 3F / 4F

ETCNM (ISO M)

P	M	K	N	S	H
●	●	●		●	●

3 | 4 | 10~15° | UMG | ANAX



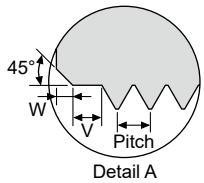


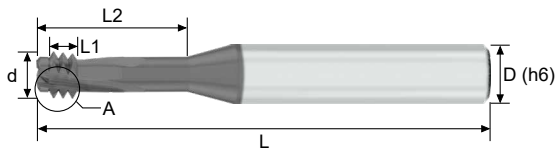
Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
ETCNM30315070A	M4	0.7	3.15	2.10	3	11.6	0.2	0.7	58	6	3
ETCNM30400080A	M5	0.8	4.00	2.40	3	14.4	0.3	0.8	58	6	3
ETCNM30470100A	M6	1.0	4.70	3.00	3	14.4	0.4	1.0	64	8	3
ETCNM40610120A	M8	1.25	6.10	3.75	3	19.0	0.5	1.25	64	8	4
ETCNM40780150A	M10	1.5	7.80	4.50	3	23.6	0.6	1.5	64	8	4
ETCNM40900170A	M12	1.75	9.00	5.25	3	28.1	0.6	1.75	73	10	4
ETCNM41180200A	M16	2.0	11.80	6.00	3	36.6	0.6	2.0	84	12	4

ETCNU (UN)

P	M	K	N	S	H
●	●	●		●	●

3 | 4 | 10~15° | UMG | ANAX



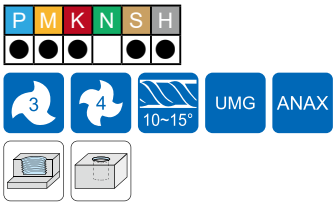


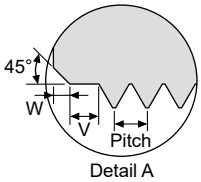
Order No.	TPI	Thread		Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
		UNC	UNF									
ETCNU30210040A	40	4-40UNC	6-40UNF	2.10	1.91	3	7.0	0.1	0.6	58	6	3
ETCNU30260032A	32	6-32UNC		2.60	2.38	3	8.7	0.1	0.8	58	6	3
ETCNU30500028A	28		1/4-28UNF	5.00	2.72	3	14.9	0.4	0.9	64	8	3
ETCNU40650024A	24		5/16-24UNF	6.50	3.18	3	18.5	0.5	1.05	64	8	4
ETCNU40480020A	20	1/4-20UNC		4.80	3.81	3	15.6	0.4	1.25	64	8	4
ETCNU40600018A	18	5/16-18UNC		6.00	4.23	3	19.2	0.5	1.4	64	8	4
ETCNU40670016A	16	3/8-16UNC		6.70	4.76	3	22.8	0.5	1.6	64	8	4
ETCNU40920013A	13	1/2-13UNC		9.20	5.86	3	30.0	0.6	2.0	73	10	4
ETCNU41140011A	11	5/8-11UNC		11.40	6.93	3	37.0	0.6	2.3	84	12	4

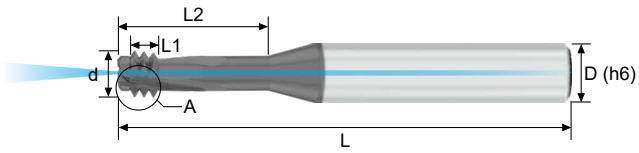
※Customized specification available.

ET - ETCC Chamfer Thread mills · 3F / 4F

ETCCM (ISO M with Internal Coolant)

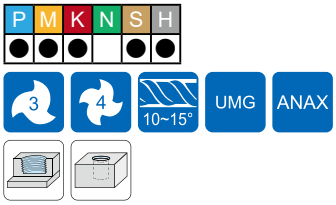


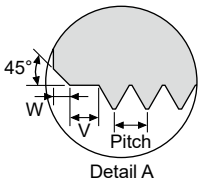


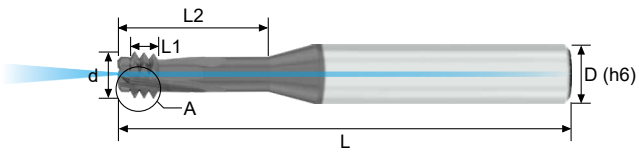


Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
ETCCM30240050A	M3	0.50	2.4	1.50	3	7.2	0.2	0.5	58	6	3
ETCCM30315070A	M4	0.70	3.15	2.10	3	11.6	0.2	0.7	58	6	3
ETCCM30400080A	M5	0.80	4.0	2.40	3	14.4	0.3	0.8	58	6	3
ETCCM30470100A	M6	1.00	4.7	3.00	3	14	0.4	1.0	64	8	3
ETCCM30470101A	M6	1.00	4.7	3.00	3	20.4	0.4	1.0	64	8	3
ETCCM40610120A	M8	1.25	6.1	3.75	3	18	0.5	1.25	64	8	4
ETCCM40610121A	M8	1.25	6.1	3.75	3	27	0.5	1.25	64	8	4
ETCCM40780150A	M10	1.50	7.8	4.50	3	23	0.6	1.5	64	8	4
ETCCM40900170A	M12	1.75	9.0	5.25	3	26	0.6	1.75	73	10	4
ETCCM41180200A	M16	2.00	11.8	6.00	3	35	0.6	2.0	84	12	4

ETCCU (UN with Internal Coolant)





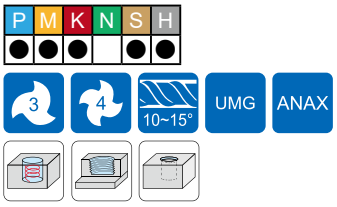


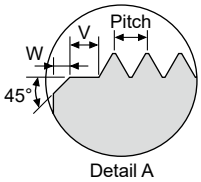
Order No.	TPI	Thread		Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
		UNC	UNF									
ETCCU30330036A	36		8-36UNF	3.3	2.12	3	12	0.2	0.7	58	6	3
ETCCU30260032A	32	6-32UNC		2.6	2.38	3	8.7	0.2	0.8	58	6	3
ETCCU30320032A	32	8-32UNC		3.2	2.38	3	12.3	0.3	0.8	58	6	3
ETCCU30380032A	32		10-32UNF	3.8	2.38	3	14	0.3	0.8	58	6	3
ETCCU30500028A	28		1/4-28UNF	5	2.72	3	14.5	0.4	0.9	64	8	3
ETCCU30350024A	24	10-24UNC		3.5	3.18	3	12.1	0.3	1.05	58	6	3
ETCCU40650024A	24		5/16-24UNF	6.5	3.18	3	17	0.5	1.05	64	8	4
ETCCU40480020A	20	1/4-20UNC		4.8	3.81	3	14	0.4	1.25	64	8	4
ETCCU40600018A	18	5/16-18UNC		6	4.23	3	17	0.5	1.4	64	8	4
ETCCU40670016A	16	3/8-16UNC		6.7	4.76	3	22	0.5	1.6	64	8	4
ETCCU40800014A	14	7/16-14UNC		8	5.44	3	26.5	0.6	1.8	64	8	4
ETCCU40100013A	13	1/2-13UNC		10	5.86	3	29.8	0.6	2.0	73	10	4

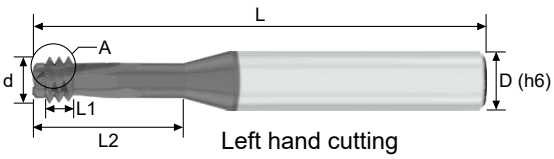
※Customized specification available.

ET - ETLN Chamfer Thread mills · 3F / 4F

ETLNM (ISO M)



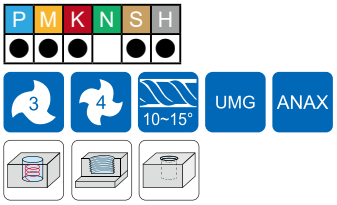


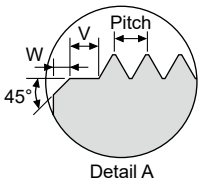


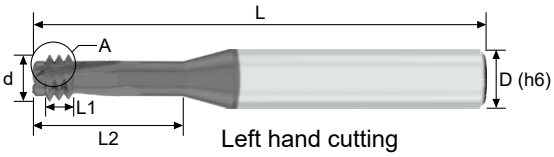
Left hand cutting
(For CNC use M04 code)

Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
ETLNM30315070A	M4	0.7	3.15	2.10	3	11.6	0.2	0.7	58	6	3
ETLNM30400080A	M5	0.8	4.00	2.40	3	14.4	0.3	0.8	58	6	3
ETLNM30470100A	M6	1.0	4.70	3.00	3	14.4	0.4	1.0	64	8	3
ETLNM40610120A	M8	1.25	6.10	3.75	3	19.0	0.5	1.25	64	8	4
ETLNM40780150A	M10	1.5	7.80	4.50	3	23.6	0.6	1.5	64	8	4
ETLNM40900170A	M12	1.75	9.00	5.25	3	28.1	0.6	1.75	73	10	4
ETLNM41180200A	M16	2.0	11.80	6.00	3	36.6	0.6	2.0	84	12	4

ETLNU (UN)







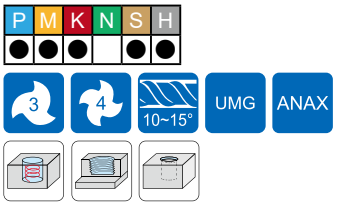
Left hand cutting
(For CNC use M04 code)

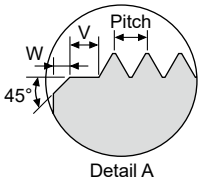
Order No.	TPI	Thread		Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
		UNC	UNF									
ETLNU30210040A	40	4-40UNC	6-40UNF	2.10	1.91	3	7.0	0.1	0.6	58	6	3
ETLNU30260032A	32	6-32UNC		2.60	2.38	3	8.7	0.1	0.8	58	6	3
ETLNU30500028A	28		1/4-28UNF	5.00	2.72	3	14.9	0.4	0.9	64	8	3
ETLNU40650024A	24		5/16-24UNF	6.50	3.18	3	18.5	0.5	1.05	64	8	4
ETLNU40480020A	20	1/4-20UNC		4.80	3.81	3	15.6	0.4	1.25	64	8	4
ETLNU40600018A	18	5/16-18UNC		6.00	4.23	3	19.2	0.5	1.4	64	8	4
ETLNU40670016A	16	3/8-16UNC		6.70	4.76	3	22.8	0.5	1.6	64	8	4
ETLNU40920013A	13	1/2-13UNC		9.20	5.86	3	30.0	0.6	2.0	73	10	4
ETLNU41140011A	11	5/8-11UNC		11.40	6.93	3	37.0	0.6	2.3	84	12	4

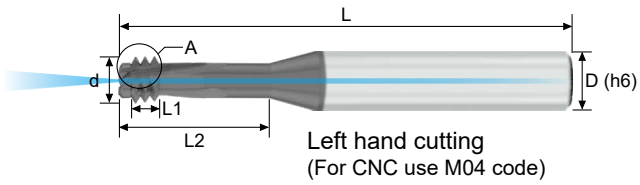
※Customized specification available.

ET - ETLC Chamfer Thread mills · 3F / 4F

ETLCM (ISO M with Internal Coolant)

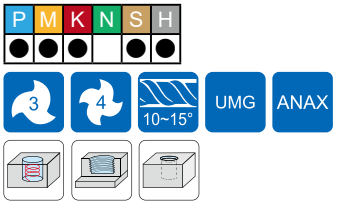


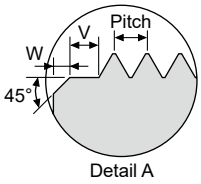


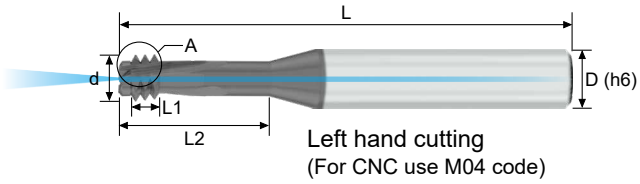


Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
ETLCM30240050A	M3	0.50	2.4	1.50	3	7.2	0.2	0.5	58	6	3
ETLCM30315070A	M4	0.70	3.15	2.10	3	11.6	0.2	0.7	58	6	3
ETLCM30400080A	M5	0.80	4.0	2.40	3	14.4	0.3	0.8	58	6	3
ETLCM30470100A	M6	1.00	4.7	3.00	3	14	0.4	1.0	64	8	3
ETLCM30470101A	M6	1.00	4.7	3.00	3	20.4	0.4	1.0	64	8	3
ETLCM40610120A	M8	1.25	6.1	3.75	3	18	0.5	1.25	64	8	4
ETLCM40610121A	M8	1.25	6.1	3.75	3	27	0.5	1.25	64	8	4
ETLCM40780150A	M10	1.50	7.8	4.50	3	23	0.6	1.5	64	8	4
ETLCM40900170A	M12	1.75	9.0	5.25	3	26	0.6	1.75	73	10	4
ETLCM41180200A	M16	2.00	11.8	6.00	3	35	0.6	2.0	84	12	4

ETLCU (UN with Internal Coolant)







Order No.	TPI	Thread		Dia. (d)	CL (L1)	No. of Threads	EFF-L (L2)	W	V	OAL (L)	Shank (D)	Flutes (z)
		UNC	UNF									
ETLCU30330036A	36		8-36UNF	3.3	2.12	3	12	0.2	0.7	58	6	3
ETLCU30260032A	32	6-32UNC		2.6	2.38	3	8.7	0.2	0.8	58	6	3
ETLCU30320032A	32	8-32UNC		3.2	2.38	3	12.3	0.3	0.8	58	6	3
ETLCU30380032A	32		10-32UNF	3.8	2.38	3	14	0.3	0.8	58	6	3
ETLCU30500028A	28		1/4-28UNF	5	2.72	3	14.5	0.4	0.9	64	8	3
ETLCU30350024A	24	10-24UNC		3.5	3.18	3	12.1	0.3	1.05	58	6	3
ETLCU40650024A	24		5/16-24UNF	6.5	3.18	3	17	0.5	1.05	64	8	4
ETLCU40480020A	20	1/4-20UNC		4.8	3.81	3	14	0.4	1.25	64	8	4
ETLCU40600018A	18	5/16-18UNC		6	4.23	3	17	0.5	1.4	64	8	4
ETLCU40670016A	16	3/8-16UNC		6.7	4.76	3	22	0.5	1.6	64	8	4
ETLCU40800014A	14	7/16-14UNC		8	5.44	3	26.5	0.6	1.8	64	8	4
ETLCU40100013A	13	1/2-13UNC		10	5.86	3	29.8	0.6	2.0	73	10	4

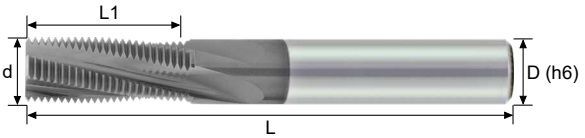
※Customized specification available.

ET - ETMN Thread mills · 3F / 4F / 5F

ETMNM (ISO M)

P	M	K	N	S	H
●	●	●		○	○

3 4 5 10~15° UMG ANAX



Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	OAL (L)	Shank (D)	Flutes (z)
ETMNM30390075A	M6	0.75	3.90	12.00 *	16	50	6	3
ETMNM30390100A		1.00	3.90	12.00 *	12	50	6	3
ETMNM30590100A	M8	1.00	5.90	16.00	16	60	6	3
ETMNM30580125A		1.25	5.80	16.25	13	60	6	3
ETMNM30790100A	M10	1.00	7.90	20.00	20	60	8	3
ETMNM30770125A		1.25	7.70	20.00	16	60	8	3
ETMNM30770150A		1.50	7.70	21.00	14	60	8	3
ETMNM40990100A	M12	1.00	9.90	24.00	24	75	10	4
ETMNM40940150A		1.50	9.40	24.00	16	75	10	4
ETMNM40870175A		1.75	8.70	24.50 *	14	75	10	4
ETMNM41120150A	M14	1.50	11.20	28.50	19	75	12	4
ETMNM40990200A		2.00	9.90	28.00	14	75	10	4
ETMNM41190150A	M16	1.50	11.90	33.00	22	100	12	4
ETMNM41190200A		2.00	11.90	32.00	16	100	12	4
ETMNM51370250A	M20	2.50	13.70	45.00 *	18	133	16	5

* Increase neck length 2~5mm

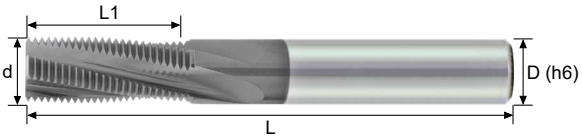
※Customized specification available.

ET - ETMN Thread mills · 3F / 4F / 5F

ETMNU (UN)

P	M	K	N	S	H
●	●	●		○	○

3 4 5 10~15° UMG ANAX

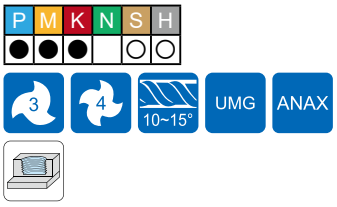


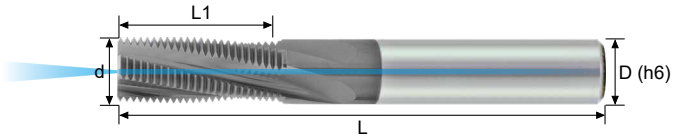
Order No.	TPI	Thread			Dia. (d)	CL (L1)	No. of Threads	OAL (L)	Shank (D)	Flutes (z)
		UNC	UNF	UNEF						
ETMNU30300036A	36		No.8		3.0	8.5	12	50	4	3
ETMNU30330032A	32		No.10	No.12-3/8"	3.3	11.1	14	50	4	3
ETMNU30380028A	28		No.12, 1/4"	7/16", 1/2"	3.8	11.8	13	50	4	3
ETMNU30460028A	28		1/4"	7/16, 1/2"	4.6	12.7 *	14	60	6	3
ETMNU40920028A	28			7/16", 1/2"	9.2	22.7	25	75	10	4
ETMNU30290024A	24	No.10	5/16", 3/8"	9/16"-11/16"	2.9	10.6 *	10	50	4	3
ETMNU30350024A	24	No.12	5/16", 3/8"	9/16"-11/16"	3.5	11.6	11	50	4	3
ETMNU30570024A	24		5/16", 3/8"	9/16"-11/16"	5.7	15.9	15	60	6	3
ETMNU30740024A	24		3/8"	9/16"-11/16"	7.4	19.1	18	60	8	3
ETMNU41190024A	24			9/16"-11/16"	11.9	28.6	27	100	12	4
ETMNU30390020A	20	1/4"	7/16", 1/2"	3/4"-1"	3.9	12.7	10	50	4	3
ETMNU40850020A	20		7/16", 1/2"	3/4"-1"	8.5	22.9 *	18	75	10	4
ETMNU40990020A	20		1/2"	3/4"-1"	9.9	25.4	20	75	10	4
ETMNU51590020A	20			3/4"-1"	15.9	38.1	30	100	16	5
ETMNU30520018A	18	5/16"	9/16", 5/8"	11/16"-1 11/16"	5.2	16.9	12	60	6	3
ETMNU41130018A	18		9/16", 5/8"	11/16"-1 11/16"	11.3	29.6	21	100	12	4
ETMNU41190018A	18		5/8"	11/16"-1 11/16"	11.9	32.5	23	100	12	4
ETMNU30670016A	16	3/8"	3/4"		6.7	19.1 *	12	60	8	3
ETMNU41590016A	16		3/4"		15.9	38.1	24	100	16	4
ETMNU40760014A	14	7/16"	7/8"		7.6	23.6	13	60	8	4
ETMNU41870014A	14		7/8"		18.7	44.4 *	24	100	20	4
ETMNU40890013A	13	1/2"			8.9	25.4	13	75	10	4
ETMNU41030012A	12	9/16"	1"-1 1/2"		10.3	29.6 *	14	100	12	4
ETMNU51990012A	12		1"-1 1/2"		19.9	50.8	24	100	20	5
ETMNU41100011A	11	5/8"			11.0	32.3	14	100	12	4
ETMNU51350010A	10	3/4"			13.5	38.1 *	15	100	16	5
ETMNU41520009A	9	7/8"			15.2	45.2	16	100	16	4
ETMNU41700008A	8	1"			17.0	50.8 *	16	100	20	4

* Increase neck length 2~5mm

ET - ETMC Thread mills · 3F / 4F

ETMCM (ISO M with Internal Coolant)





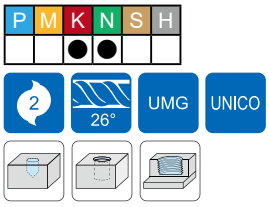
Order No.	Processing Size	Pitch	Dia. (d)	CL (L1)	No. of Threads	OAL (L)	Shank (D)	Flutes (z)
ETMCM30390075A	M6	0.75	3.90	12.00 *	16	50	6	3
ETMCM30390100A		1.00	3.90	12.00 *	12	50	6	3
ETMCM30590100A	M8	1.00	5.90	16.00	16	60	6	3
ETMCM30580125A		1.25	5.80	16.25	13	60	6	3
ETMCM30790100A	M10	1.00	7.90	20.00	20	60	8	3
ETMCM30770125A		1.25	7.70	20.00	16	60	8	3
ETMCM30770150A		1.50	7.70	21.00	14	60	8	3
ETMCM40990100A	M12	1.00	9.90	24.00	24	75	10	4
ETMCM40940150A		1.50	9.40	24.00	16	75	10	4
ETMCM40870175A		1.75	8.70	24.50 *	14	75	10	4
ETMCM41120150A	M14	1.50	11.20	28.50	19	75	12	4
ETMCM40990200A		2.00	9.90	28.00	14	75	10	4
ETMCM41190150A	M16	1.50	11.90	33.00	22	100	12	4
ETMCM41190200A		2.00	11.90	32.00	16	100	12	4

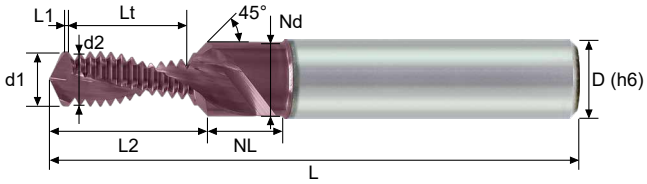
* Increase neck length 2~5mm

※Customized specification available.

ET - ETDN Drll / Thread mills · 2F

ETMCM (ISO M with Internal Coolant)





Order No.	Size (Coarse)	Pitch	d1	d2	Lt	L1	L2	No. of Threads	Nd	NL	L	D	h	Coating
ETDNM20420080U	M5	0.80	4.2	4.00	9.60	0.8	11.9	12	5.7	6.1	55	6	0.46	●
ETDNM20500100U	M6	1.00	5.0	4.85	11.00	1.0	13.7	11	6.6	9.5	60	8	0.58	●
ETDNM20680125U	M8	1.25	6.8	6.45	13.75	1.3	17.1	11	9.0	16.8	75	10	0.72	●
ETDNM20850150U	M10	1.50	8.5	8.08	18.00	1.5	22.1	12	11.0	11.6	80	12	0.87	●
ETDNM20420080	M5	0.80	4.2	4.00	9.60	0.8	11.9	12	5.7	6.1	55	6	0.46	
ETDNM20500100	M6	1.00	5.0	4.85	11.00	1.0	13.7	11	6.6	9.5	60	8	0.58	
ETDNM20680125	M8	1.25	6.8	6.45	13.75	1.3	17.1	11	9.0	16.8	75	10	0.72	
ETDNM20850150	M10	1.50	8.5	8.08	18.00	1.5	22.1	12	11.0	11.6	80	12	0.87	

∗ Maximum chamfering depth = (Nd - d1) × 0.5

ET - Recommended Cutting Conditions

Recommended Cutting Conditions

For ETS, ETT, ETC, ETL

Work Material	Vc (m/min)	Feed (mm/t)
Carbon Steel / Alloy Steel	60 ~ 90	0.02 ~ 0.08
Stainless Steel	60 ~ 90	0.02 ~ 0.08
Cast Iron	50 ~ 100	0.03 ~ 0.10
Aluminum Alloy	50 ~ 100	0.02 ~ 0.06
High Temperature Alloy	20 ~ 60	0.01 ~ 0.03
Hardened Steel	30 ~ 60	0.01 ~ 0.03

For ETM

Work Material	Vc (m/min)	Feed (mm/t)
Carbon Steel / Alloy Steel	50 ~ 70	0.02 ~ 0.07
Stainless Steel	50 ~ 70	0.02 ~ 0.07
Cast Iron	50 ~ 100	0.03 ~ 0.10
Aluminum Alloy	50 ~ 70	0.03 ~ 0.10
High Temperature Alloy	20 ~ 60	0.01 ~ 0.03
Hardened Steel	25 ~ 50	0.01 ~ 0.05

For ETD

Work Material		Vc (m/min)	Drilling f (mm/rev)		Thread milling fz (mm)	
			≤ 6mm	≤ 12mm	≤ 6mm	≤ 12mm
K	Grey Cast Iron	55 ~ 85	0.07 ~ 0.105	0.105 ~ 0.154	0.014 ~ 0.035	0.035 ~ 0.07
	Grey Cast Iron (Heat Treated)	55 ~ 85	0.07 ~ 0.105	0.105 ~ 0.154	0.014 ~ 0.035	0.035 ~ 0.07
N	Short Chips, Brass, Bronze	70 ~ 280	0.07 ~ 0.210	0.042 ~ 0.070	0.021 ~ 0.042	0.042 ~ 0.07
	Aluminium, Cast Alloy (Si<10%)	70 ~ 280	0.07 ~ 0.175	0.175 ~ 0.210	0.021 ~ 0.042	0.042 ~ 0.07
	Aluminium, Cast Alloy (Si≥10%)	70 ~ 280	0.07 ~ 0.175	0.175 ~ 0.210	0.021 ~ 0.042	0.042 ~ 0.07
	Thermoplastics	40 ~ 80	0.07 ~ 0.175	0.175 ~ 0.210	0.021 ~ 0.042	0.042 ~ 0.07

※ To choose uncoated tool for aluminum materials machining.