UKAS MANAGEMENT SYSTEMS
ISO 9001

WINSTAR

ET Series
Solid Carbide Thread Mills, ~ HRC 50

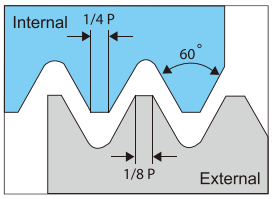
NEW

- *The thread mill is designed to cut threads by milling.*
- *A single tool is suitable for thread cutting in various sizes of diameter.*
- *Large diameter thread can be machined with low power machine.*

WE1820E

ET Series

ETTNM Series



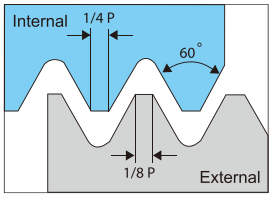
Tolerance class : 6H

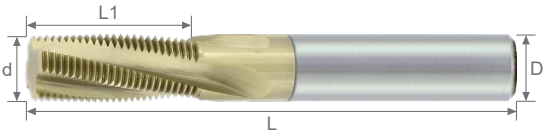
UMG SICO

Order No.	Size	Pitch	No. of Threads	Dia. (d)	CL (L1)	EFF-L (L2)	OAL (L)	Shank (D)	Flutes (F)
ETTNM30150040S	M2	0.40	3	1.5	1.20	4.4	50	6	3
ETTNM30190045S	M2.5	0.45	3	1.9	1.35	5.6	50	6	3
ETTNM30240050S	M3	0.50	3	2.4	1.50	6.5	50	6	3
ETTNM30310070S	M4	0.70	3	3.1	2.10	8.7	50	6	3
ETTNM30400080S	M5	0.80	3	4.0	2.40	10.8	50	6	3

＊ Customize other specification available.

ETMNM Series





Tolerance class : 6H

UMG SICO

Order No.	Size	Pitch	No. of Threads	Dia. (d)	CL (L1)	OAL (L)	Shank (D)	Flutes (F)
ETMNM30390100S	M6	1.00	12	3.90	12.00	50	6	3
ETMNM30390075S		0.75	16	3.90	12.00	50	6	3
ETMNM30580125S	M8	1.25	13	5.80	16.25	60	6	3
ETMNM30590100S		1.00	16	5.90	16.00	60	6	3
ETMNM30770150S	M10	1.50	14	7.70	21.00	60	8	3
ETMNM30770125S		1.25	16	7.70	20.00	60	8	3
ETMNM30790100S		1.00	20	7.90	20.00	60	8	3
ETMNM40870175S	M12	1.75	14	8.70	24.50	75	10	4
ETMNM40940150S		1.50	16	9.40	24.00	75	10	4
ETMNM40990100S		1.00	24	9.90	24.00	75	10	4
ETMNM40990200S	M14	2.00	14	9.90	28.00	75	10	4
ETMNM41120150S		1.50	19	11.20	28.50	75	12	4
ETMNM41190200S	M16	2.00	16	11.90	32.00	100	12	4
ETMNM41190150S		1.50	22	11.90	33.00	100	12	4

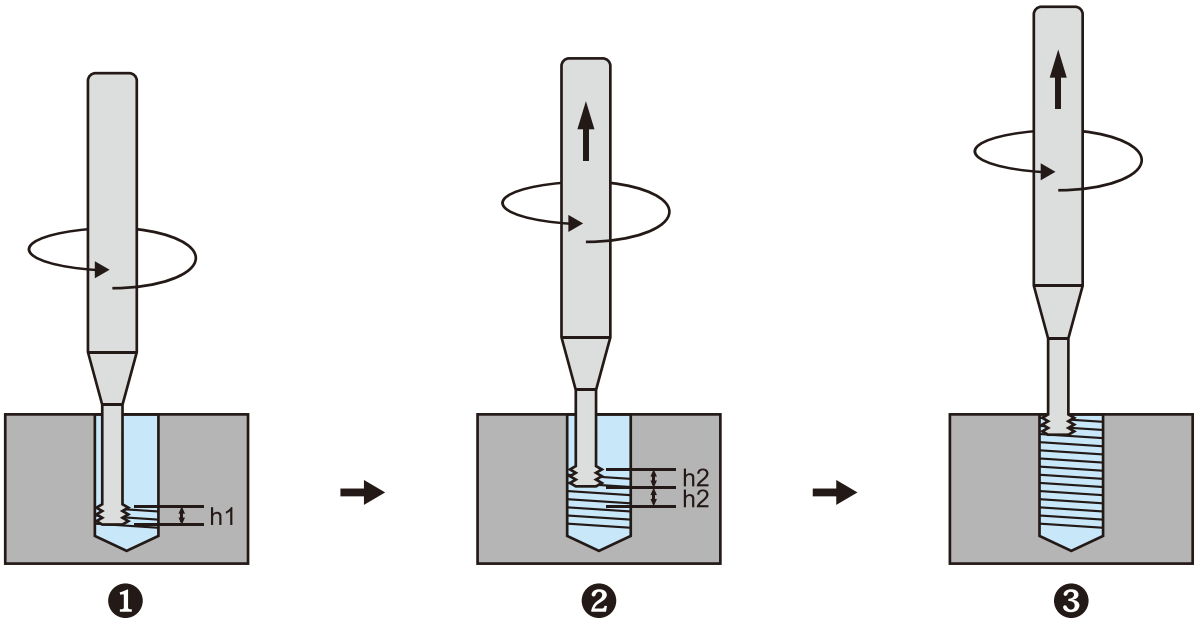
＊ Customize other specification available.

■ *Recommended Cutting Conditions*

Work Material	for ETTNM		for ETMNM	
	Vc (m/min)	Feed (mm/t)	Vc (m/min)	Feed (mm/t)
Carbon Steel	60 ~ 90	0.02 ~ 0.08	50 ~ 70	0.02 ~ 0.07
Stainless Steel	60 ~ 90	0.02 ~ 0.08	50 ~ 70	0.02 ~ 0.07
Cast Iron	50 ~ 100	0.03 ~ 0.10	50 ~ 100	0.03 ~ 0.10
Aluminum	50 ~ 100	0.02 ~ 0.06	50 ~ 70	0.03 ~ 0.10
High temp. & Titanium alloy	20 ~ 60	0.01 ~ 0.03	20 ~ 60	0.01 ~ 0.03
Hardened steel	30 ~ 60	0.01 ~ 0.03	25 ~ 50	0.01 ~ 0.05

※ To choose uncoated tool for aluminum materials machining.

■ ETTNM *Cutting method*



❶ Machine h1 distance at the bottom of the hole and move the tool to the center of the hole. (h1 = 3 Pitch)

❷ Machine h2 distance while moving in Z axial direction.

❸ Repeat operation ❷ to finish the hole.

Remark

h2 value set :

1. for Machining General materials, h2 = 3 Pitch.
2. for Machining Heat resistant alloys or High hardness material, h2 = 1 Pitch.

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