

Threading



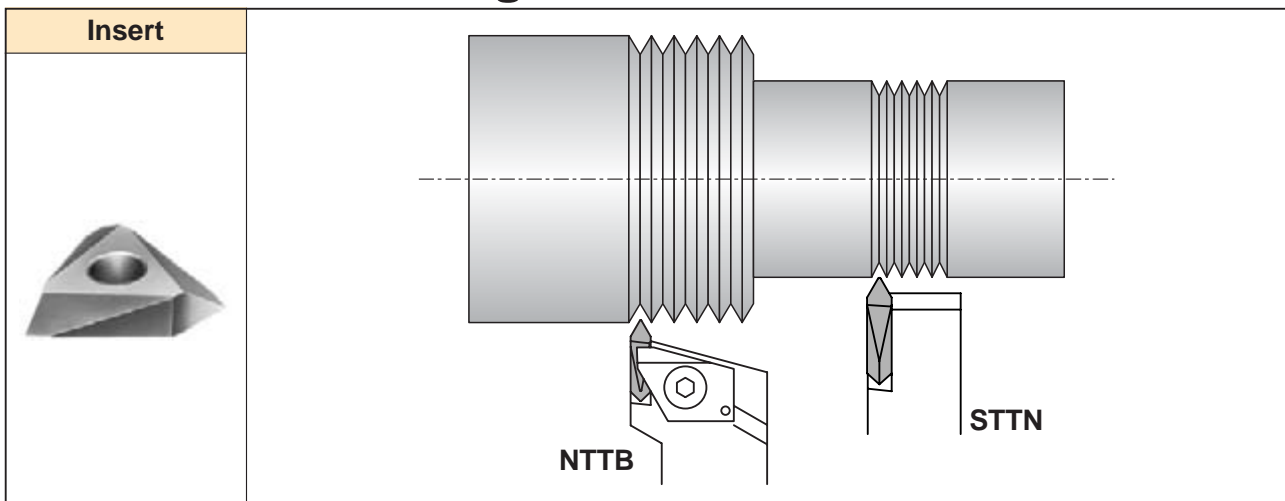
Outside threading P.145

Internal threading P.147

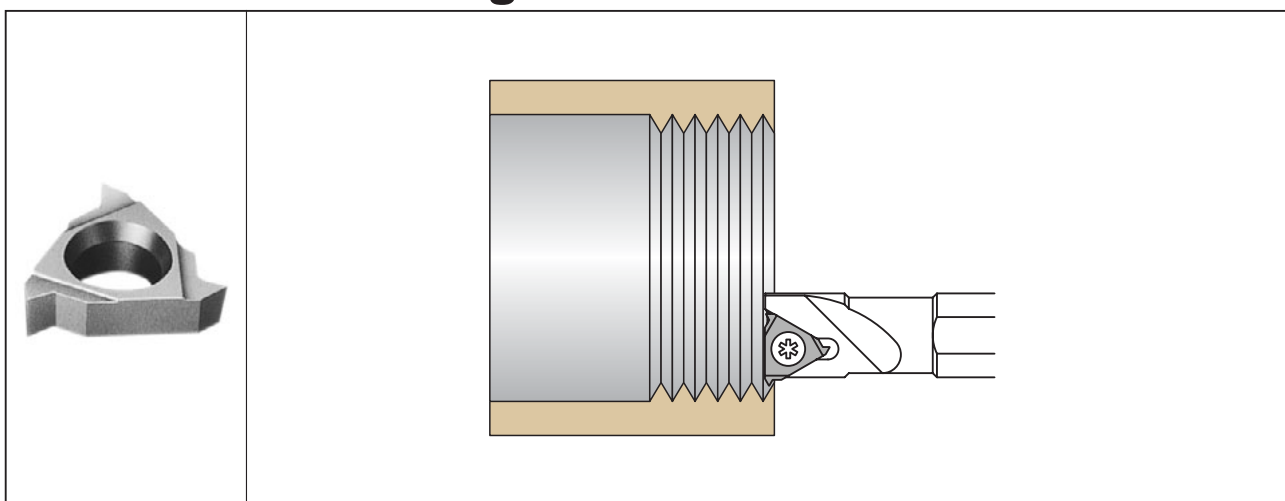
▼ Recommend Cutting Conditions

Insert Grade	Coated carbide		Cermet
	QM3	ZM3	N20
Conditions	Cutting speed (m/min)	Cutting speed (m/min)	Cutting speed (m/min)
Work piece			
Carbon steel Alloy steel	~ 200	~ 180	~ 250
Stainless steel	~ 180	~ 150	~ 180
Cast iron	~ 200	~ 200	

● Outside Threading

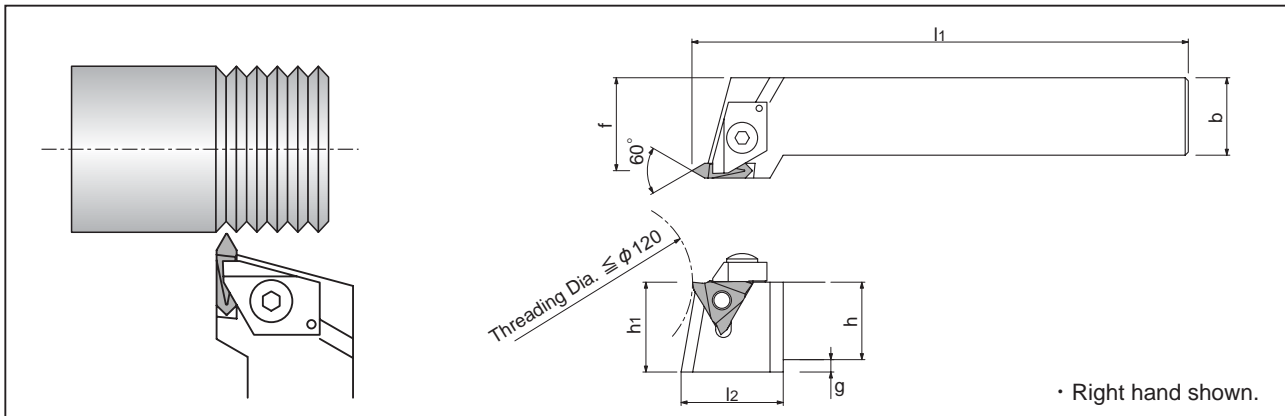


● Internal Threading



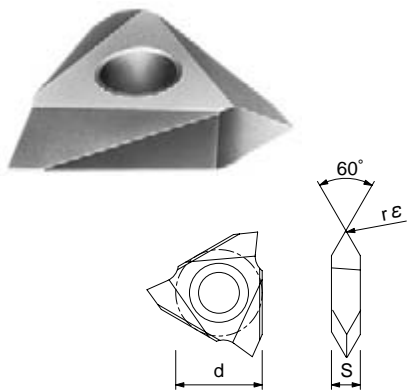
NTTB

Clamp-on type



Dimensions (mm)							Insert	Item-No.	Stock	
h	b	l1	h1	f	l2	g			R	L
16	16	120	16	20	20	4	TTMH 3260 R	NTTB ^{R/L} 161632	●	
20	20	140	20	25				202032	●	
25	25	160	25	30				252543	●	

TTM Insert



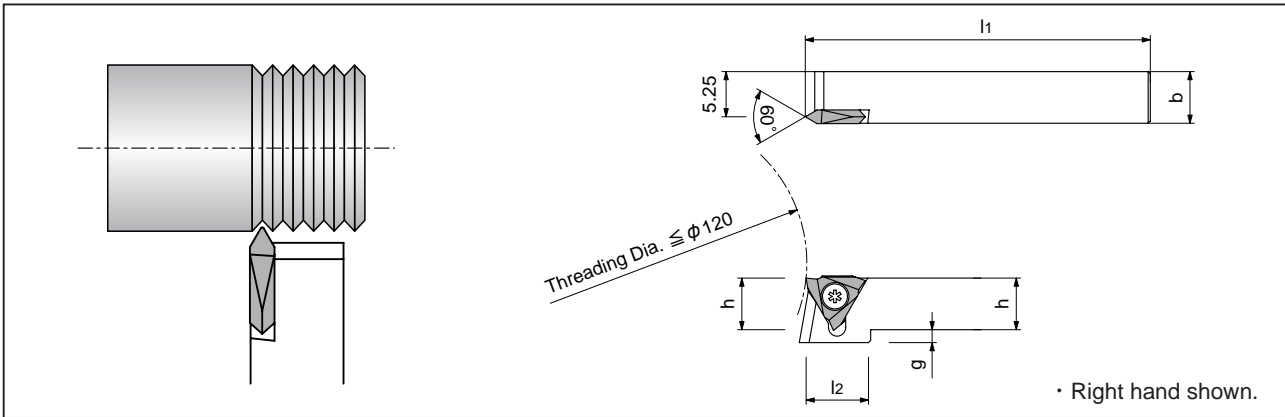
Dimensions (mm)			Item-No.	N20	ZM3
d	S	rε			
9.525	3.18	0.1	TTMH 3260R010	○	○
		0.15	3260R015	○	○
		0.2	3260R020		○
		0.25	3260R025	○	
12.7	4.76	0.15	TTMA 4360R015	○	
		0.2	4360R020	○	
		0.25	4360R025		
		0.3	4360R030		

● Parts

Item-No.	Clamp	Clamping screw	Spring	Wrench
NTTB ^{R/L} 161632 202032 252543	CP ^{R/L} 5	AOS - 5×25	ASG - 5	LW - 2.5
	CP ^{R/L} 6	AOS - 6×30	ASG - 6	LW - 3

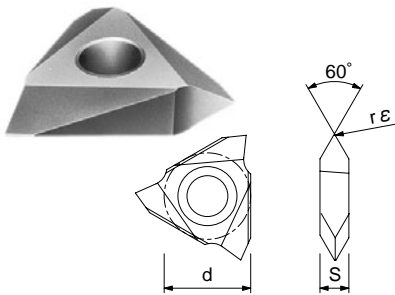
STTN

Screw-on type




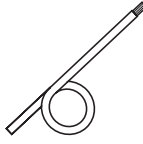
Dimensions (mm)							Insert	Item-No.	Stock	
h	b	l1	h1	f	l2	g			R	L
10	10	80	10	8.5	15	5	TTMH 3260 R/L	STTN R/L 101032	●	
12	12	80	12	10.5	15	5		121232	●	
12	12	125	12	10.5	15	5		121232-K		

TTM Insert



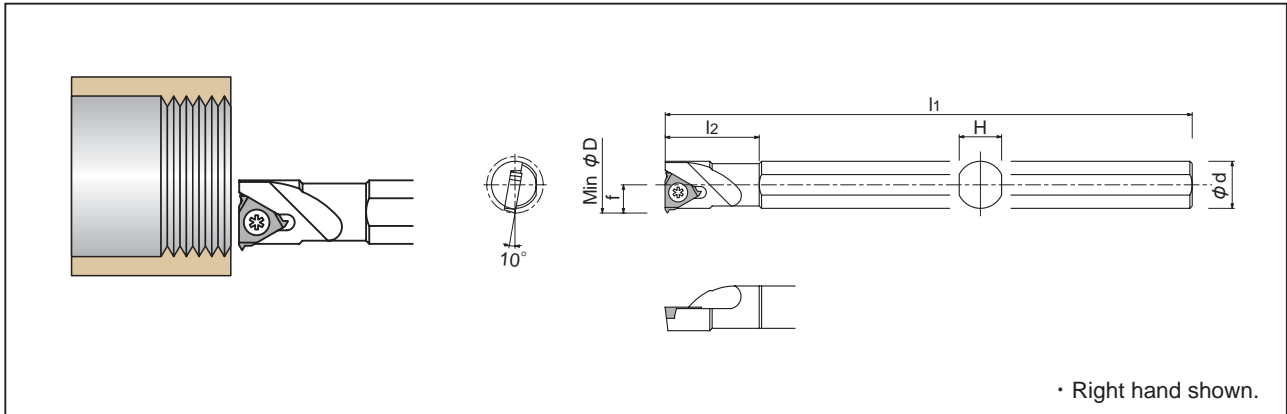
Dimensions (mm)			Item-No.	N20	ZM3
d	S	rε			
9.525	3.18	0.1	TTMH 3260R010	●	○
		0.15	3260R015	○	○
		0.2	3260R020		○
		0.25	3260R025	○	

● Parts

Toolholder	Clamp	Wrench
		
STTN ^{R/L} 101032 121232 121232-K	LR - S - 4 × 5.8	RLR - 20S

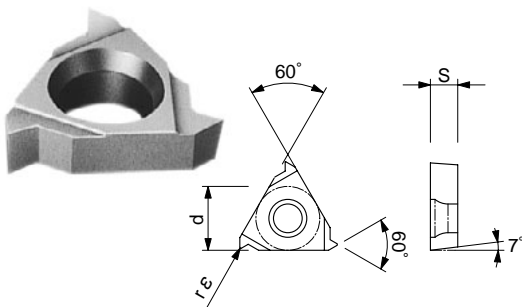
HN

Screw-on type





Dimensions (mm)						Insert	Item-No.	Stock	
Minimum diameter	ϕd	H	l_1	l_2	f			R	
8	6	5.5	100	13	3.8	TMN 06R03 08R03 09R03	HN 59Z-0028 59Z-0029 59Z-0030	<input type="radio"/>	
10	8	7.0	125	17	4.7			<input type="radio"/>	
12	10	9.0	150	20	6.0			<input type="radio"/>	

TMN Insert



Dimensions (mm)			Item-No.	ZM3
d	S	rE		
3.97	1.59	0.03	TMN 06R03 08R03 09R03	<input type="radio"/>
4.76	2.38			<input type="radio"/>
5.56				<input type="radio"/>

● Parts

Toolholder		Clamp	Wrench
			
HN	59Z-0028	LR -S - 2 × 4.4	RLR - 13S
	59Z-0029	LR -S - 2 × 5.5	
	59Z-0030	LR -S - 2 × 6	