

**New!**

MilliPro

Miniature Solid Carbide Thread Mills

Minimum Thread Size
M2 x 0.4

- For internal threads as small as M2 x 0.4 (1-64 UN)
- Ideal for difficult-to-machine materials where taps typically break
- Features 3 flutes with 3 teeth each
- For thread depth up to 3 x D
- Short machining time due to high cutting speed
- Economical solution for short threads

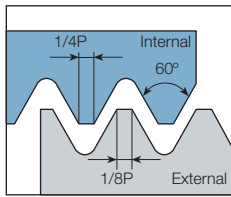


VARDEX Threading Solutions

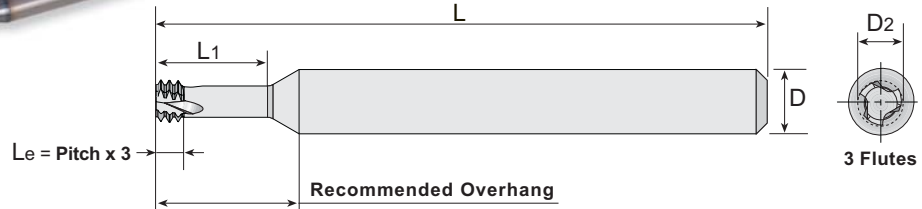
Metric

ISO Metric

Internal



Defined by: R262 (DIN 13)
Tolerance class: 6H



ISO Metric up to 2D Depth

Thread		Pitch	Ordering Code	Dimensions mm				Recommended Drill Size + Hole Tolerance
Coarse	Fine	mm	Internal	D	D2	L	L ₁	mm
M2x0.4		0.4	D3T06015L042-I0.4ISO TM...	6	1.55	57	4.20	1.6 (+0.03)
M2.2x0.45		0.45	D3T06016L046-I0.45ISO TM...	6	1.65	57	4.60	1.8 (+0.03)
M2.5x0.45		0.45	D3T06019L052-I0.45ISO TM...	6	1.95	57	5.20	2.0 (+0.05)
M3x0.5	M3.5-M16x0.5	0.5	D3T06024L062-I0.5ISO TM...	6	2.40	57	6.25	2.5 (+0.05)
M3.5x0.6		0.6	D3T06027L073-I0.6ISO TM...	6	2.75	57	7.30	2.9 (+0.05)
M4x0.7		0.7	D3T06031L083-I0.7ISO TM...	6	3.15	57	8.35	3.3 (+0.05)
M5x0.8		0.8	D3T06040L104-I0.8ISO TM...	6	4.05	57	10.40	4.2 (+0.05)
M6x1.0	M8-M40 x1.0	1.00	D3T06048L125-I1.0ISO TM...	6	4.80	57	12.50	5.0 (+0.05)
M8x1.25		1.25	D3T08065L166-I1.25ISO TM...	8	6.50	63	16.60	6.8 (+0.05)
M10x1.5	M12-M48 x1.50	1.50	D3T10082L208-I1.50ISO TM...	10	8.20	73	20.80	8.5 (+0.05)
M12x1.75		1.75	D3T10099L250-I1.75ISO TM...	10	9.90	83	25.00	10.3 (+0.05)

ISO Metric up to 3D Depth

Thread		Pitch	Ordering Code	Dimensions mm				Recommended Drill Size + Hole Tolerance
Coarse	Fine	mm	Internal	D	D2	L	L ₁	mm
M2.5x0.45		0.45	D3T06019L077-I0.45ISO TM...	6	1.95	57	7.70	2.0 (+0.05)
M3x0.5	M3.5-M16x0.5	0.5	D3T06024L092-I0.5ISO TM...	6	2.40	57	9.25	2.5 (+0.05)
M4x0.7		0.7	D3T06031L123-I0.7ISO TM...	6	3.15	57	12.35	3.3 (+0.05)
M5x0.8		0.8	D3T06040L154-I0.8ISO TM...	6	4.05	57	15.40	4.2 (+0.05)
M6x1.0	M8-M40 x1.0	1.00	D3T06048L185-I1.0ISO TM...	6	4.80	57	18.50	5.0 (+0.05)
M8x1.25		1.25	D3T08065L246-I1.25ISO TM...	8	6.50	63	24.60	6.8 (+0.05)

Ordering example: D3T06015L042-I0.4ISO TMVTH

New! TM Gen Version 6.0.1 - now includes the entire MilliPro line!

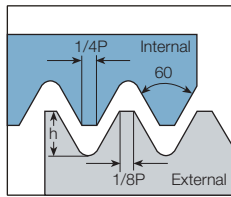
TM Gen

VARDEX TM Gen software automatically selects the right tool for your application and generates the thread milling program (G-code) for your CNC machinery and controls. Ask for a TM Gen CD or download the latest version from the VARGUS website: www.vargustools.com

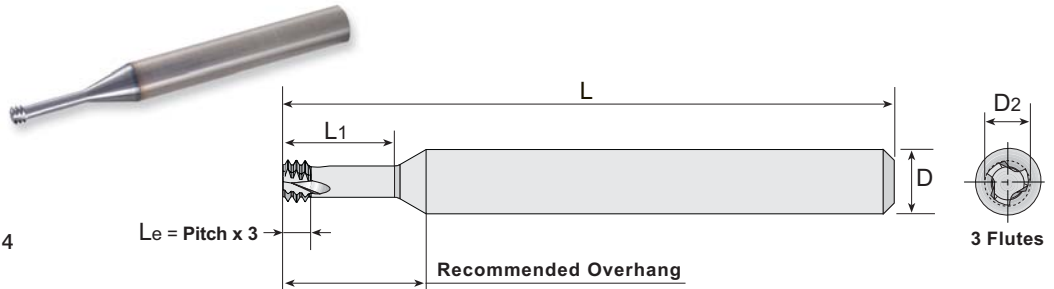


American UNC, UNF

Internal



Defined by: ANSI B1.174
Tolerance class: 2B



American UNC, UNF up to 2D Depth

Thread		Pitch	Ordering Code	Dimensions mm				Recommended Drill Size + Hole Tolerance
Coarse-UNC	Fine-UNF	tpi	Internal	D	D2	L	L ₁	mm
No.1-64	No.2-64	64	D3T06014L042-I64UN TM...	6	1.40	57	4.20	1.5 (+0.03)
	No.1-72	72	D3T06014L039-I72UN TM...	6	1.45	57	3.90	1.55 (+0.03)
No.2-56	No.3-56	56	D3T06016L050-I56UN TM...	6	1.65	57	5.00	1.8 (+0.05)
No.3-48	No.4-48	48	D3T06019L060-I48UN TM...	6	1.90	57	6.00	2.05 (+0.05)
No.4, No.5-40	No.6-40	40	D3T06021L060-I40UN TM...	6	2.10	57	6.00	2.3 (+0.05)
No.5-40	No.6-40	40	D3T06024L072-I40UN TM...	6	2.45	57	7.20	2.6 (+0.05)
	No.8-36	36	D3T06033L087-I36UN TM...	6	3.30	57	8.70	3.5 (+0.05)
No.6, No.8-32	No.10-32	32	D3T06025L074-I32UN TM...	6	2.55	57	7.41	2.8 (+0.05)
No.8-32	No.10-32	32	D3T06032L100-I32UN TM...	6	3.20	57	10.00	3.4 (+0.05)
	1/4"-28	28	D3T06052L132-I28UN TM...	6	5.25	57	13.20	5.5 (+0.05)
No.10-24	5/16"-24	24	D3T06035L102-I24UN TM...	6	3.58	57	10.20	3.8 (+0.05)
	5/16"-24	24	D3T08066L165-I24UN TM...	8	6.68	63	16.50	6.9 (+0.05)
1/4"-20	7/16"-20	20	D3T06048L134-I20UN TM...	6	4.88	57	13.40	5.1 (+0.05)
	7/16"-20	20	D3T10096L230-I20UN TM...	10	9.60	73	23.00	9.9 (+0.05)
7/16"-14		14	D3T10090L233-I14UN TM...	10	9.00	73	23.30	9.4 (+0.05)

American UNC, UNF up to 3D Depth

Thread		Pitch	Ordering Code	Dimensions mm				Recommended Drill Size + Hole Tolerance
Coarse-UNC	Fine-UNF	tpi	Internal	D	D2	L	L ₁	mm
No.5-40	No.6-40	40	D3T06024L100-I40UN TM...	6	2.45	57	10.00	2.6 (+0.05)
No.8-32	No.10-32	32	D3T06032L130-I32UN TM...	6	3.20	57	13.00	3.4 (+0.05)
	1/4"-28	28	D3T06052L196-I28UN TM...	6	5.25	57	19.60	5.5 (+0.05)
	5/16"-24	24	D3T08066L245-I24UN TM...	8	6.68	63	24.50	6.9 (+0.05)
1/4"-20	7/16"-20	20	D3T06048L198-I20UN TM...	6	4.88	57	19.80	5.1 (+0.05)

Ordering example: D3T06014L042-I64UN TMVTH

Recommended Cutting Speeds and Feed

Selected Material			Hardness Brinell HB	Vc [m/min]	Feed f [mm/tooth]
				Coated	(Peripheral Feed)
				Grade VTH	
P	Unalloyed steel	Medium carbon (C=0.25-0.55 %)	150	60-120	0.03-0.12
M	Stainless steel Austenitic	Austenitic	180	60-90	0.03-0.1
K	Aluminium alloys Wrought	Non aging	60	60-250	0.05-0.15

* Cutting data for additional materials is available on VARDEX TM Gen software.

Grade

Grade	Application
VTH	Excellent general-purpose grade. TiCN coated for high wear resistance

VARDEX Thread Milling Solutions for Small Bores



MilliPro



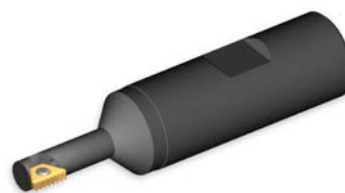
TM Solid Helical



TM Solid Straight

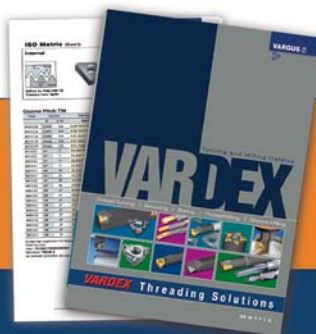


TM Solid Deep Thread

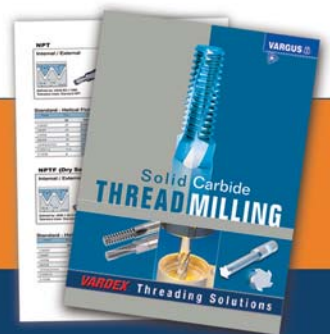


TM Mini

Ask for the Latest
VARDEX Catalogs



VARDEX
Main Catalog



TM Solid
Catalog



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