

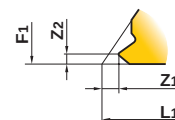
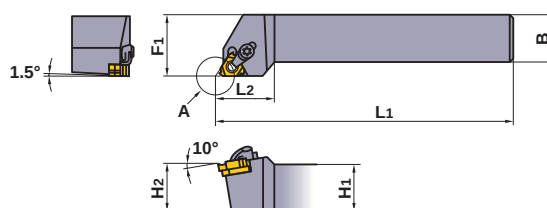
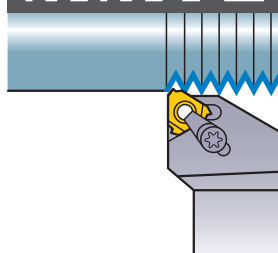
## EXTERNAL THREADING

## MMTE HOLDER

- Various insert types.
- Precision class insert.
- Available with a wiper cutting edge to provide a precise thread geometry.
- Able to change lead angle by replacing shim.

MMTE

External threading



Details of position A  
Refer to page G014—G020,  
for size Z1, Z2.

Right hand tool holder only.

| Order Number   | Stock<br>R | Insert Number    | Dimensions (mm) |    |     |    |    |    |        |        |     |          |           |                    |
|----------------|------------|------------------|-----------------|----|-----|----|----|----|--------|--------|-----|----------|-----------|--------------------|
|                |            |                  | H1              | B  | L1  | L2 | H2 | F1 |        |        |     |          |           |                    |
| MMTER1212H16-C | ●          | MMT16ER<br>○○○○○ | 12              | 12 | 100 | 25 | 12 | 16 | SETK51 | SETS51 | CR4 | HFC03008 | CTE32TP15 | ①TKY15F<br>②HKY20R |
| 1616H16-C      | ●          |                  | 16              | 16 | 100 | 25 | 16 | 20 | SETK51 | SETS51 | CR4 | HFC03008 | CTE32TP15 | ①TKY15F<br>②HKY20R |
| 2020K16-C      | ●          |                  | 20              | 20 | 125 | 26 | 20 | 25 | SETK51 | SETS51 | CR4 | HFC03008 | CTE32TP15 | ①TKY15F<br>②HKY20R |
| 2525M16-C      | ●          |                  | 25              | 25 | 150 | 28 | 25 | 32 | SETK51 | SETS51 | CR4 | HFC03008 | CTE32TP15 | ①TKY15F<br>②HKY20R |
| 3232P16-C      | ●          |                  | 32              | 32 | 170 | 32 | 32 | 40 | SETK51 | SETS51 | CR4 | HFC03008 | CTE32TP15 | ①TKY15F<br>②HKY20R |
| MMTER2525M22-C | ●          | MMT22ER<br>○○○○○ | 25              | 25 | 150 | 32 | 25 | 32 | SETK61 | SETS61 | CR5 | HFC04010 | CTE43TP15 | ①TKY20F<br>②HKY25R |
| 3232P22-C      | ●          |                  | 32              | 32 | 170 | 32 | 32 | 40 | SETK61 | SETS61 | CR5 | HFC04010 | CTE43TP15 | ①TKY20F<br>②HKY25R |

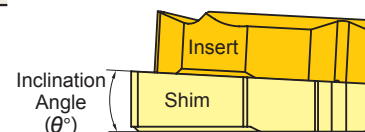
(Note) Select and use a shim as shown below (sold separately), dependant on the lead angle.

★ Clamp Torque (N · m) : SETS51=3.5, SETS61=5.0, HFC03008=1.5, HFC04010=2.2

## SHIM

| Lead Angle (α°) | Order Number | Stock<br>R | Inclination Angle (θ°) | Applicable Holder      |
|-----------------|--------------|------------|------------------------|------------------------|
| -1.5°           | CTE32TN15    | ●          | -3°                    | MMTER<br>○○○○○<br>16-C |
| -0.5°           | N05          | ●          | -2°                    |                        |
| 0.5°            | P05          | ●          | -1°                    |                        |
| 1.5°            | P15          | ●          | 0°                     |                        |
| 2.5°            | P25          | ●          | 1°                     |                        |
| 3.5°            | P35          | ●          | 2°                     |                        |
| 4.5°            | P45          | ●          | 3°                     |                        |

| Lead Angle (α°) | Order Number | Stock<br>R | Inclination Angle (θ°) | Applicable Holder      |
|-----------------|--------------|------------|------------------------|------------------------|
| -1.5°           | CTE43TN15    | ●          | -3°                    | MMTER<br>○○○○○<br>22-C |
| -0.5°           | N05          | ●          | -2°                    |                        |
| 0.5°            | P05          | ●          | -1°                    |                        |
| 1.5°            | P15          | ●          | 0°                     |                        |
| 2.5°            | P25          | ●          | 1°                     |                        |
| 3.5°            | P35          | ●          | 2°                     |                        |
| 4.5°            | P45          | ●          | 3°                     |                        |



Standard shim delivered with the holder.

## IDENTIFICATION

|                    |                    |                     |                                              |           |                             |                             |                          |
|--------------------|--------------------|---------------------|----------------------------------------------|-----------|-----------------------------|-----------------------------|--------------------------|
| <b>MMT</b>         | <b>E</b>           | <b>R</b>            | <b>12</b>                                    | <b>12</b> | <b>H</b>                    | <b>16</b>                   | <b>-C</b>                |
| <b>Designation</b> | <b>Application</b> | <b>Hand of Tool</b> | <b>Tool Size (mm)<br/>(Height and Width)</b> |           | <b>Tool Length<br/>(mm)</b> | <b>Insert Size<br/>(mm)</b> | <b>Method of Holding</b> |
| E                  | External           | R                   | 12                                           | 12        | H                           | 16                          | C                        |
|                    |                    |                     | 16                                           | 16        | K                           | 12.7                        |                          |
|                    |                    |                     | 20                                           | 20        | M                           |                             |                          |
|                    |                    |                     | 25                                           | 25        | P                           |                             |                          |
|                    |                    |                     | 32                                           | 32        | R                           |                             |                          |
|                    |                    |                     | 40                                           | 40        |                             |                             |                          |

## RECOMMENDED CUTTING CONDITIONS

|   | Work Material            | Hardness                    | Grade  | Cutting Speed (m/min) |
|---|--------------------------|-----------------------------|--------|-----------------------|
| P | Mild Steel               | ≤180HB                      | VP10MF | 150 (70—230)          |
|   |                          |                             | VP15TF | 100 (60—140)          |
|   |                          |                             | VP20RT | 80 (60—100)           |
| M | Carbon Steel Alloy Steel | 180—280HB                   | VP10MF | 140 (80—200)          |
|   |                          |                             | VP15TF | 100 (60—140)          |
|   |                          |                             | VP20RT | 80 (60—100)           |
| M | Stainless Steel          | ≤200HB                      | VP15TF | 80 (40—120)           |
| K | Cast Iron                | Tensile Strength<br>≤350MPa | VP10MF | 140 (80—200)          |
|   |                          |                             | VP15TF | 90 (60—120)           |

|   | Work Material        | Hardness | Grade  | Cutting Speed (m/min) |
|---|----------------------|----------|--------|-----------------------|
| S | Heat-Resistant Alloy | —        | VP10MF | 45 (15—70)            |
|   |                      |          | VP15TF | 30 (20—40)            |
|   |                      |          | VP20RT |                       |
| H | Titanium Alloy       | —        | VP10MF | 60 (40—80)            |
|   |                      |          | VP15TF | 45 (25—65)            |
|   |                      |          | VP20RT |                       |
| H | Heat-Treated Alloy   | 45—55HRC | VP10MF | 50 (30—70)            |
|   |                      |          | VP15TF | 40 (20—60)            |

● : Inventory maintained. ★ : Inventory maintained in Japan.