

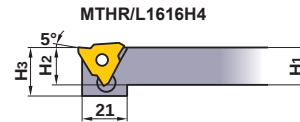
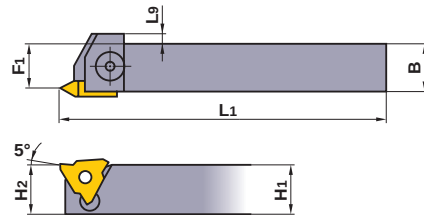
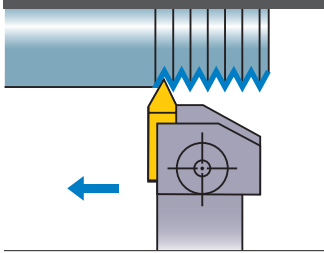
EXTERNAL THREADING

MT HOLDER

- Clamp-on type.
- Positive insert suffers from negligible chattering and thus produces good finished surfaces.
- Thread pitch $\leq 4.5\text{mm}$.

MTH

External threading



(Note) Cutting in the opposite direction is not possible.

Right hand tool holder shown.

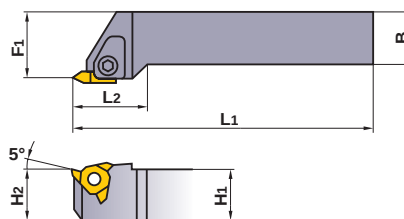
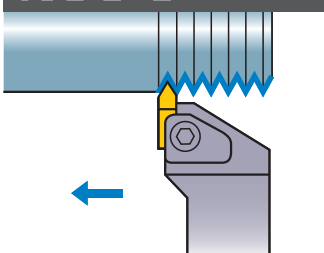
Order Number	Stock		Insert Number	Dimensions (mm)								 *		
	R	L		H1	B	L1	H2	H3	F1	L9	Clamp Bridge	Clamp Screw	Spring	Wrench
MTHR/L1616H4	★	★	MTTR/L43○○○○	16	16	100	16	19	13.8	3	MTK1R/L	HBH06020	MES3	HKY40R
2020K4	●	★		20	20	125	20	—	17.8	—	MTK1R/L	HBH06020	MES3	HKY40R
2525M4	●	★		25	25	150	25	—	22.8	—	MTK1R/L	HBH06020	MES3	HKY40R

★ Clamp Torque (N • m) : HBH06020=7.0

THREADING

MT1

External threading



(Note) Cutting in the opposite direction is not possible.

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)									*		
	R	L		H1	B	L1	L2	H2	F1						
MT1R/L2020K4	★	★	MTTR/L43○○○○	20	20	125	30	20	25			MTK1R/L	HBH06020	MES3	HKY40R
2525M4	★	★		25	25	150	30	25	32			MTK1R/L	HBH06020	MES3	HKY40R
3232P4	★	★		32	32	170	30	32	40			MTK1R/L	HBH06020	MES3	HKY40R

★ Clamp Torque (N • m) : HBH06020=7.0

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)
P	$\leq 180\text{HB}$	UP20M	140 (100—180)
		UTi20T	120 (100—150)
	180—280HB	UP20M	120 (100—150)
		UTi20T	100 (70—120)

Work Material	Hardness	Grade	Cutting Speed (m/min)
M	$\leq 200\text{HB}$	UP20M	120 (80—150)
		UTi20T	100 (70—130)
K	Tensile Strength $\leq 350\text{MPa}$	UP20M	80 (60—100)
		UTi20T	80 (60—100)
		HTi10	100 (70—130)

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