

Reliable chip evacuation and processing.

NEW TO THE RANGE

NEW ADDITION TO THE PRODUCT RANGE

- UNC: UNC 1/4–UNC 1

Additional dimensions:

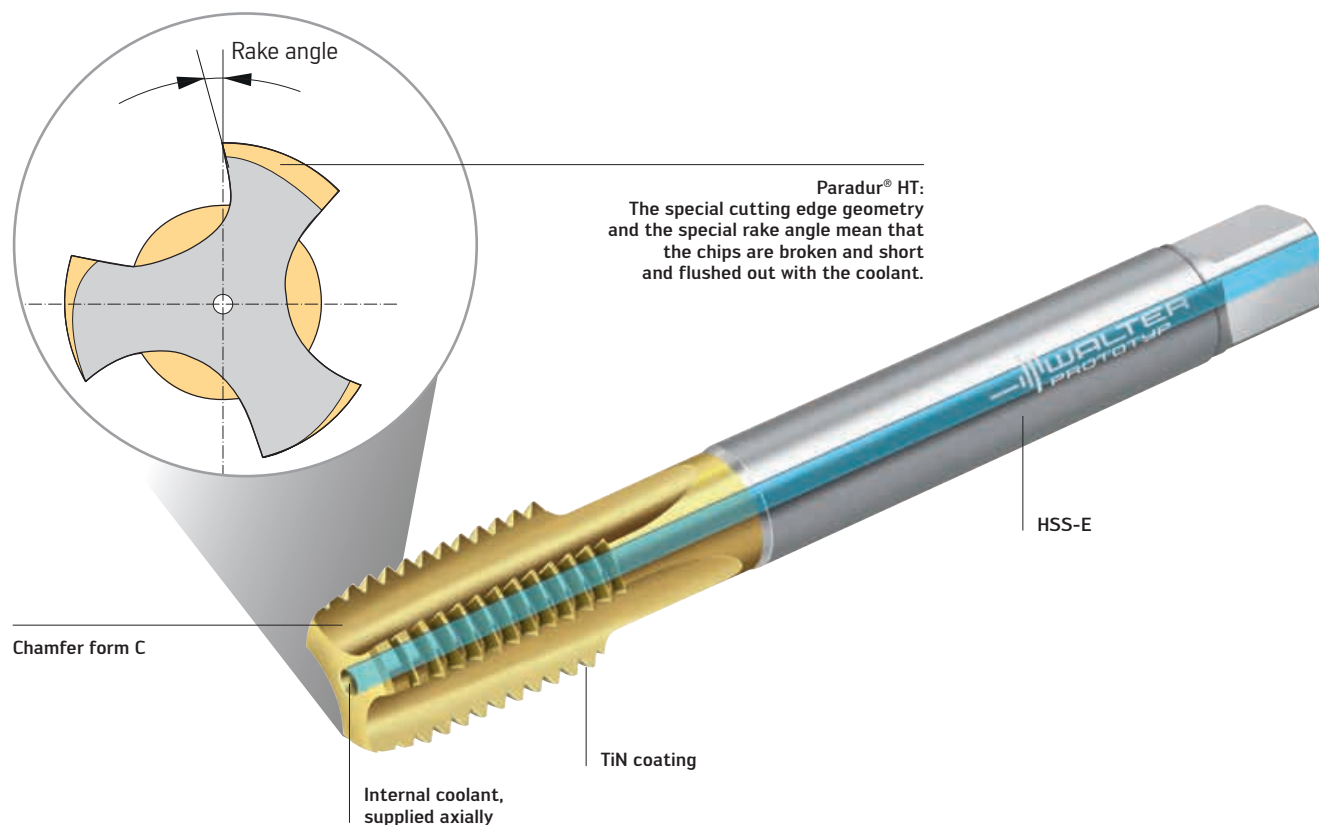
- M: M4–M36
- MF: MF10 × 1–MF33 × 2

THE APPLICATION

- Primary application
ISO P: 200–400 HB
ISO K: Predominantly GJS (GGG) materials
- Secondary application
AlSi alloys > 7% Si content
Short-chipping Cu alloys
Mg alloys
- Up to 3.5 × D_N

THE TOOL

- Blind-hole tap
- TiN coating
- Chamfer form C
- Internal coolant, supplied axially
- Tolerance 2B



Walter Prototyp

Fig.: 2236115

BENEFITS FOR YOU

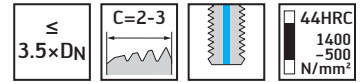
- Extremely high process reliability even with deep threads
- Outstanding chip breaking even in long-chipping materials – no more birds nesting
- Optimum transport of the short broken chips thanks to axial internal coolant

HSS-E machine taps

Paradur® HT

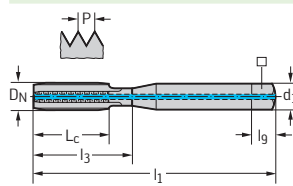


– For long- and short-chipping materials



	P	M	K	N	S	H	O
TIN	●	●	●	●	●	●	●

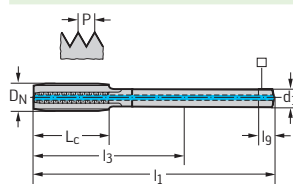
DIN 2184-1



Designation TIN	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N
★ 2231115-UNC1/4	UNC 1/4-20	6.35	80	15	30	7	5.5	8	3
★ 2231115-UNC5/16	UNC 5/16-18	7.938	90	18	35	8	6.2	9	3
★ 2231115-UNC3/8	UNC 3/8-16	9.525	100	20	39	10	8	11	3

★ New addition to the product range

DIN 2184-1



Designation TIN	D _N -P	D _N mm	l ₁ mm	L _c mm	l ₃ mm	d ₁ h9 mm	mm	l _g mm	N
★ 2236115-UNC1/2	UNC 1/2-13	12.7	110	23	83	9	7	10	3
★ 2236115-UNC5/8	UNC 5/8-11	15.875	110	25	68	12	9	12	3
★ 2236115-UNC3/4	UNC 3/4-10	19.05	125	30	81	14	11	14	3
★ 2236115-UNC1	UNC 1"-8	25.4	160	36	113	18	14.5	17	4

★ New addition to the product range

Maximum productivity – absolute process reliability.

NEW

THE TOOL

- Universal indexable insert thread milling cutter
- Designed for high cutting speeds and high feeds per tooth
- Adjustable internal coolant supply:
Radial or axial coolant outlets
- T2712 family:
Designed for $2 \times D_N$ thread lengths and with an additional neck in order to bridge interference contours

THE APPLICATION

- For threads with a nominal diameter from 24 mm
- Pitch range: 1.5–6 mm/18–4 TPI
- Thread depth up to $2.5 \times D_N$
- Can be used universally with ISO P, M, K, S and H up to 55 HRC



Powered by
Tiger-tec®Silver

T2711/T2712 thread milling cutter

Fig.: T2711

Significant reduction in machining time as multiple thread sections are machined simultaneously. This enables machining times to be achieved which are comparable with tapping and thread forming in many cases. The row spacing must be an integer which is a multiple of the thread pitch to be produced. This means that numerous different pitches can be produced with just a few heads.

BENEFITS FOR YOU

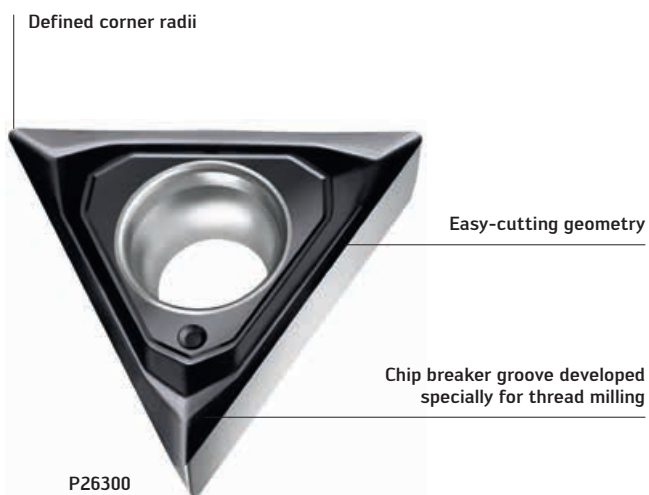
- **100% productivity:** Low costs per thread thanks to quick machining and high tool life quantity
- **100% process reliability:** Easy handling and few radius corrections
- **100% quality:** Outstanding thread quality thanks to superb operational smoothness – threads are free of chip residue

Walter  **press**

For more information, see page 3.

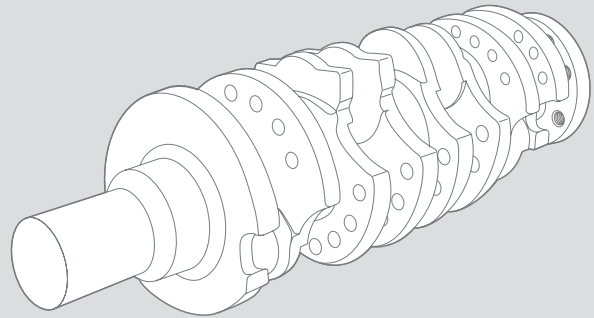
THE THREAD MILLING CUTTER INSERT

- Positive basic shape with three cutting edges
- Easy-cutting geometry
- Wear-resistant, universal grade: WSM37S
- Defined corner radii for producing threads in accordance with various standards



APPLICATION EXAMPLE

Large crankshaft



Material: 4150 steel, 320 HB
Thread: M36, 70 mm (2.756 inch) deep
Tool: T2711-29-W32-3-09-3-24
Insert: P26300-0902-D67 WSM37S

Cutting data:

	Competitor: Tap	Walter: T2711
Cutting speed v_c	43 SFM	656 SFM
Feed per tooth f_z	–	0.0157 inch
t	22.5 secs	19 secs
Tool life quantity (no. of threads)	200	250*

* Per cutting edge

Costs per thread
(tool costs + machine costs)

T2711

Competitors

- 60 %

Costs

Ordering information
from page 142.

Watch the product animation:
Scan this QR code or go directly to
<http://goo.gl/ok3MVX>



Two families – singularly productive.

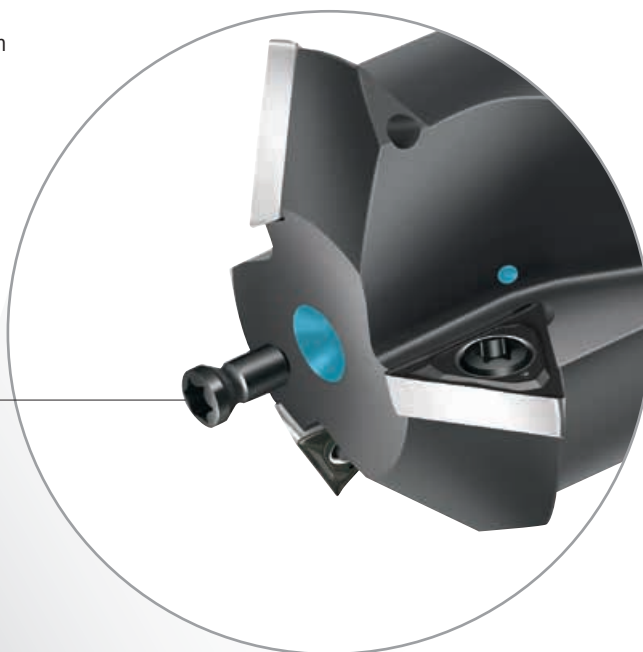
NEW

Adjustable internal coolant supply

In order to ensure optimal chip evacuation during blind-hole machining, the coolant screw should be removed.

If through-hole threads are being produced, the axial coolant outlet can be closed. This ensures that all the coolant exits through the radial outlets and the chips are evacuated through the pilot hole.

Coolant screw



THE STANDARD RANGE

- Different dimensions: M24–M48/UNC 1–UNC 1 1/2
- Different projection lengths: $2.0 \times D_N$ and $2.5 \times D_N$
- Tools for UN threads also available with one-inch shank



T2711-29-W32-3-09-3-24



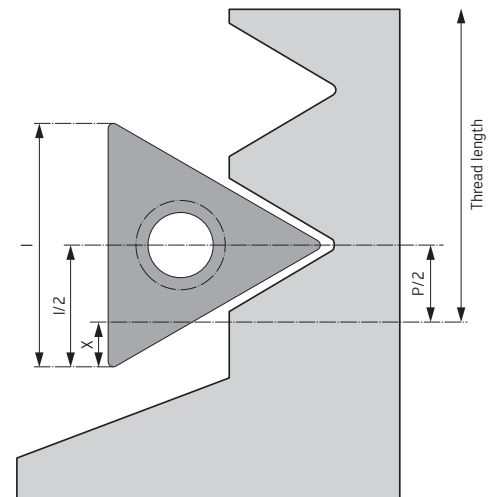
T2712-29-W32-3-09-2-36

UNUSABLE LENGTH:

The thread length includes the last thread ridge plus half a pitch. Since $I/2$ is greater than $P/2$, this results in an "unusable length" (X). This is calculated from half of the insert length ($I/2$) minus half of a thread pitch ($P/2$) and must be taken into consideration when programming.

Example: M36 with P26300-0902.. thread milling cutter insert

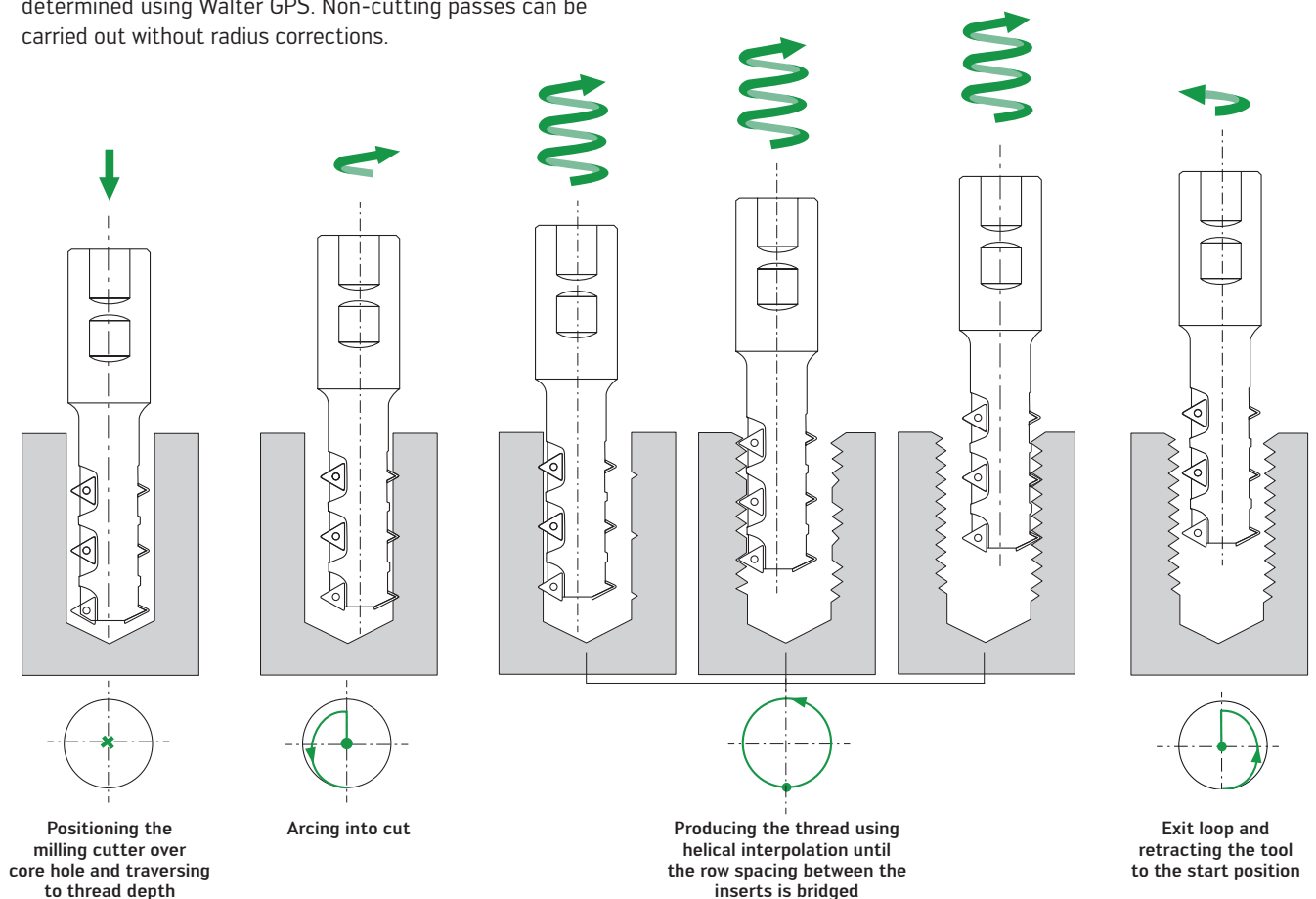
$$\text{Unusable length } X = I/2 - P/2 = \frac{9.34 \text{ mm}}{2} - \frac{4 \text{ mm}}{2} = 2.67 \text{ mm}$$



The unusable length of the T271.. families is less than the chamfer length of a tap.

THE STRATEGY

It is recommended that the thread be produced with a radial cut using synchronous milling. The programming radius can be determined using Walter GPS. Non-cutting passes can be carried out without radius corrections.



Thread milling cutting data

Machining should be carried out synchronously and in a radial cut.

The specified cutting data are target values under good machining conditions. When running in or under unfavorable machining conditions, these may need to be reduced.

Material group	 = Cooling lubricant recommended			Brinell hardness HB	Tensile strength R _m N/mm ²	Machining group ¹		T2711 / T2712			
	E = Emulsion M = MQL A = Compressed air	v _c = Cutting speed [SFM] f _z = Feed rate per tooth [inch]	f _z (inch)								
	Overview of the main material groups and code letters							v _c (SFM)	Insert size		
			06	09 / 11 / 14							
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	428	P1	E M	660	0.012	0.016	
		C > 0.25 ... ≤ 0.55%	Annealed	190	639	P2	E M	660	0.012	0.016	
		C > 0.25 ... ≤ 0.55%	Heat-treated	210	708	P3	E M	660	0.012	0.016	
		C > 0.55%	Annealed	190	639	P4	E M	660	0.012	0.016	
		C > 0.55%	Heat-treated	300	1013	P5	E M	660	0.012	0.016	
		Free cutting steel (short-chipping)	Annealed	220	745	P6	E M	660	0.012	0.016	
	Low-alloyed steel	Annealed		175	591	P7	E M	660	0.012	0.016	
		Heat-treated		285	960	P8	E M	660	0.012	0.016	
		Heat-treated		380	1282	P9	E M	490	0.010	0.014	
		Heat-treated		430	1477	P10	E M	330	0.008	0.012	
	High-alloyed steel and high-alloyed tool steel	Annealed		200	675	P11	E M	660	0.012	0.016	
		Hardened and tempered		300	1013	P12	E M	660	0.012	0.016	
		Hardened and tempered		380	1282	P13	E M	490	0.012	0.016	
	Stainless steel	Ferritic/martensitic, annealed		200	675	P14	E M	660	0.010	0.014	
		Martensitic, heat-treated		330	1114	P15	E M	490	0.010	0.014	
M	Stainless steel	Austenitic, quench hardened		200	675	M1	E	660	0.008	0.012	
		Austenitic, precipitation hardened (PH)		300	1013	M2	E	490	0.008	0.012	
		Austenitic/ferritic, duplex		230	778	M3	E	260	0.008	0.012	
K	Malleable cast iron	Ferritic		200	400	K1	E M	660	0.012	0.016	
		Pearlitic		260	700	K2	E M	660	0.012	0.016	
	Grey cast iron	Low tensile strength		180	200	K3	E M	820	0.012	0.016	
		High tensile strength/austenitic		245	350	K4	E M	660	0.012	0.016	
	Cast iron with spheroidal graphite	Ferritic		155	400	K5	E M	660	0.012	0.016	
		Pearlitic		265	700	K6	E M	660	0.012	0.016	
	GGV (CGI)			230	400	K7	E M	660	0.012	0.016	
N	Aluminum wrought alloys	Cannot be hardened		30	–	N1	E M	–	–	–	
		Hardenable, hardened		100	343	N2	E M	–	–	–	
	Cast aluminum alloys	≤ 12% Si, cannot be hardened		75	260	N3	E M	–	–	–	
		≤ 12% Si, hardenable, hardened		90	314	N4	E M	–	–	–	
		> 12% Si, cannot be hardened		130	447	N5	E M	660	0.012	0.016	
	Magnesium alloys ³			70	250	N6	A	820	0.012	0.016	
		Copper and copper alloys (bronze/brass)	Non-alloyed, electrolytic copper		100	343	N7	E M	–	–	–
			Brass, bronze, red brass		90	314	N8	E M	–	–	–
			Cu-alloys, short-chipping		110	382	N9	E M	–	–	–
			High-strength, Ampco		300	1013	N10	E M	–	–	–
S	Heat-resistant alloys	Fe-based	Annealed	200	675	S1	E	130	0.010	0.010	
			Hardened	280	943	S2	E	80	0.006	0.006	
		Ni or Co base	Annealed	250	839	S3	E	130	0.010	0.010	
			Hardened	350	1177	S4	E	80	0.006	0.006	
			Cast	320	1076	S5	E	100	0.008	0.008	
	Titanium alloys	Pure titanium		200	675	S6	E	130	0.010	0.010	
		α and β alloys, hardened		375	1262	S7	E	130	0.010	0.010	
		β alloys		410	1396	S8	E	100	0.008	0.008	
	Tungsten alloys			300	1013	S9	E	130	0.010	0.010	
Molybdenum alloys			300	1013	S10	E	130	0.010	0.010		
H	Hardened steel	Hardened and tempered		50 HRC	–	H1	M A	150	0.008	0.012	
		Hardened and tempered		55 HRC	–	H2	M	–	–	–	
		Hardened and tempered		60 HRC	–	H3	M	–	–	–	
	Hardened cast iron	Hardened and tempered		55 HRC	–	H4	M A	150	0.008	0.012	
O	Thermoplastics	Without abrasive fillers				O1	E M	660	0.012	0.016	
	Thermosetting plastics	Without abrasive fillers				O2	E M	490	0.012	0.016	
	Plastic, glass fiber reinforced	GFRP				O3	E M	160	0.012	0.016	
	Plastic, carbon fiber reinforced	CFRP				O4	E M	160	0.012	0.016	
	Plastic, aramid fiber reinforced	AFRP				O5	E M	160	0.012	0.016	
	Graphite (technical)			65		O6	E M	660	0.012	0.016	

¹ The classification of the machining groups can be found in the Walter General Catalog 2012 from page H 8 onwards.

³ Water-miscible coolants must not be used when machining magnesium alloys.

T271.. order code

Example:

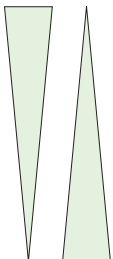
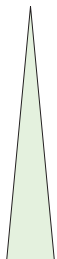
T	2	7	11	–	29	-	W	32	-	3	-	09	-	3	-	24
1	2	3	4	5	6		7	8		9		10		11		12

1	2	3	4	5	6
Tool group	Generation	Tool type	Tool type	1. Delimiters	Cutting diameter
T Threading		7 Indexable insert thread milling cutter	11 Universal With triangular insert 2.0 × D _N 12 Universal With triangular insert 2.5 × D _N	– Metric · Inches	
7	8	9	10	11	12
Adaptor type	Adaptor size	Number of teeth	Insert size	Number of cutting rows	Cutting row spacing
W Weldon shank					

P26300 order code

Example:

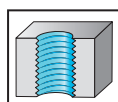
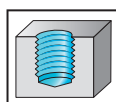
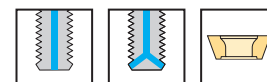
P26300	-	09	02	-	D	6	7	W	SM	37	S
1		2	3		4	5	6	Walter	7	8	9

1	2	3	4	5	6
Family	Insert size	Insert radius	Chip breaker groove	Cutting edge	Flank face design
26300 Triangular thread milling cutter insert, positive	06 09 11 14	01 = 0.1 mm 02 = 0.2 mm 04 = 0.4 mm	 D = 10°	 6	 7
7	8		9		
Application	ISO application range		Generation		
SM Can be used universally with ISO P, M, K, S and H materials	Wear resistance  37 Toughness 		S Tiger-tec® Silver	Cutting tool materials for: 7 thread milling	

Indexable insert thread milling cutter T2711 / T2712



- The programming radius (Rprg.) can be calculated using Walter GPS
- Adjustable internal coolant supply: Radial or axial coolant outlets



	P	M	K	N	S	H	O
T2711	●	●	●	●	●	●	●
T2712	●	●	●	●	●	●	●

$\leq 2.0 \times D_N$		Designation	D_N	P_{max} mm	D_c mm	l_{21} mm	l_3 mm	l_1 mm	d_1 mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B		★ T2711-19-W20-3-06-2-24	M24	3	19	24	51	110	20	3	6	P26300-06 ..
		★ T2711-24-W25-3-09-2-31.5	M30	3.5	24	31.5	64.5	132	25	3	6	P26300-09 ..
Shank DIN 1835 B		★ T2711-29-W32-3-09-3-24	M36	4	29	24	76.5	149	32	3	9	P26300-09 ..
		★ T2711-35-W32-3-11-3-27	M42	4.5	35	27	89.5	160	32	3	9	P26300-11 ..
		★ T2711-40-W40-3-14-3-30	M48	5	40	30	103	187	40	3	9	P26300-14 ..

Bodies and assembly parts are included in the scope of delivery.

★ New addition to the product range

$\leq 2.5 \times D_N$		Designation	D_N	P_{max} mm	D_c mm	l_{21} mm	l_3 mm	l_1 mm	d_1 mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B		★ T2712-24-W25-3-09-2-31.5	M30	3.5	24	31.5	79.5	147	25	3	6	P26300-09 ..
		★ T2712-29-W32-3-09-2-36	M36	4	29	36	94.5	167	32	3	6	P26300-11 ..
		★ T2712-35-W32-3-11-2-40.5	M42	4.5	35	40.5	110.5	180	32	3	6	P26300-11 ..
		★ T2712-40-W40-3-14-2-50	M48	5	40	50	127	211	40	3	6	P26300-14 ..

Bodies and assembly parts are included in the scope of delivery.

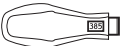
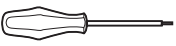
T2712: With neck for bridging interference contours

★ New addition to the product range

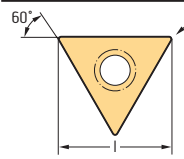
Assembly parts

D _c [mm]	19	24–29	35	40
 Clamping screw for insert Tightening torque	FS2147 (Torx 6IP) 0.5 Nm	FS2111 (Torx 7IP) 0.9 Nm	FS2061 (Torx 7IP) 0.9 Nm	FS1457 (Torx 9IP) 2.0 Nm
Coolant screw Tightening torque	FS2147 (Torx 6IP) 0.5 Nm	FS2111 (Torx 7IP) 0.9 Nm	FS2061 (Torx 7IP) 0.9 Nm	FS1457 (Torx 9IP) 2.0 Nm

Accessories

D _c [mm]	19	24–35	40
 Torque screwdriver, analogue Tightening torque	FS2001 0.4–1.2 Nm	FS2001 0.4–1.2 Nm	FS2003 1.5–5.0 Nm
 Torque screwdriver, digital Tightening torque			FS2248 1.0–6.0 Nm
 Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)	FS2013 (Torx 9IP)
 Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)	FS1484 (Torx 9IP)

Thread milling cutter inserts P26300

Designation	Number of cutting edges	Size	r mm	Pitch		l mm	P	M	K	N	S	H	O				
				P mm	P TPI		HC	HC	HC	HC	HC	HC	HC				
 P26300-0601-D67	3	6	0.1	1.50–2.50	18–10	6.73	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-0602-D67	3	6	0.2	3.00	8	6.58	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-0902-D67	3	9	0.2	3.00–4.00	8–6	9.34	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-1102-D67	3	11	0.2	3.00–4.50	8–6	10.71	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-1404-D67	3	14	0.4	5.00–6.00	5–4	13.43	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				

HC = Coated carbide

New addition to the product range

Tool selection

Metric thread			Coarse pitch thread										Fine pitch thread							
Family	Body designation	l ₃ [mm]	M24	M27	M30	M33	M36	M39	M42	M45	M48	M52	D _N [mm]	P [mm]						
T2711	T2711-19-W20-3-06-2-24	51	0602	0602									≥ 24	0601	0601	0602				
	T2711-24-W25-3-09-2-31.5	64.5			0902	0902							≥ 30				0902			
	T2711-29-W32-3-09-3-24	76.5					0902	0902					≥ 36			0902		0902		
	T2711-35-W32-3-11-3-27	89.5							1102	1102			≥ 42			1102			1102	
	T2711-40-W40-3-14-3-30	103									1404	1404	≥ 48							1404
T2712	T2712-24-W25-3-09-2-31.5	79.5			0902	0902							≥ 30				0902			
	T2712-29-W32-3-09-2-36	94.5					0902	0902					≥ 36			0902		0902		
	T2712-35-W32-3-11-2-40.5	110.5							1102	1102			≥ 42						1102	
	T2712-40-W40-3-14-2-50	127									1404	1404	≥ 48							1404

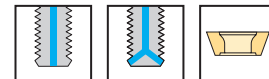
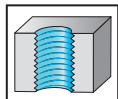
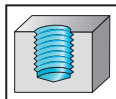
Example: With the T2711-29-W32-3-09-3-24 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902..), an M36 or M39 thread can be produced. Additionally, this body/indexable insert combination can be used to produce fine pitch threads with a pitch of 3 or 4 mm, when the nominal diameter is ≥ 36 mm.

Indexable insert thread milling cutter T2711



- The programming radius (Rprg.) can be calculated using Walter GPS
- Adjustable internal coolant supply: Radial or axial coolant outlets

UNC/UNF/UN
ASME B1.1



	P	M	K	N	S	H	O
T2711	●	●	●	●	●	●	●

$\leq 2.0 \times D_N$		Designation	D_N	P_{max} TPI	D_c mm	l_{21} mm	l_3 mm	l_1 mm	d_1 mm	Z	No. of indexable inserts	Type
Shank DIN 1835 B		★ T2711-20-W20-3-06-2-25.4	UNC 1	8	20	25.4	53.9	113	20	3	6	P26300-06 ..
		★ T2711-26-W25-3-09-2-32.7	UNC 1 1/4	7	26	32.7	68	135	25	3	6	P26300-09 ..
Shank DIN 1835 B		★ T2711-31-W32-3-09-3-25.4	UNC 1 1/2	6	31	25.4	80.7	153	32	3	9	P26300-09 ..

Bodies and assembly parts are included in the scope of delivery.

★ New addition to the product range

Assembly parts

	D _c [mm]	20	26–31
	Clamping screw for insert	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	0.5 Nm	0.9 Nm
	Coolant screw	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	0.5 Nm	0.9 Nm

Accessories

	D _c [mm]	20	26–31
	Torque screwdriver, analogue	FS2001	FS2001
	Tightening torque	0.4–1.2 Nm	0.4–1.2 Nm
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)

Thread milling cutter inserts P26300

Designation	Number of cutting edges	Size	r mm	Pitch		l mm	P	M	K	N	S	H	O				
				P mm	P TPI		HC	HC	HC	HC	HC	HC	HC				
P26300-0601-D67	3	6	0.1	1.50–2.50	18–10	6.73	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-0602-D67	3	6	0.2	3.00	8	6.58	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-0902-D67	3	9	0.2	3.00–4.00	8–6	9.34	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-1102-D67	3	11	0.2	3.00–4.50	8–6	10.71	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
P26300-1404-D67	3	14	0.4	5.00–6.00	5–4	13.43	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				

HC = Coated carbide

New addition to the product range

Tool selection

UN threads			UNC			UNF					UN					
Family	Body designation	l ₃ [mm]	1"	1 1/4"	1 1/2"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	D _N [inch]	18*	16	12	8	6
T2711	T2711-20-W20-3-06-2-25.4	53.9	0602			0601	0601	0601	0601	0601	≥ 1.00"	0601	0601	0601	0602	
	T2711-26-W25-3-09-2-32.7	68		0902							≥ 1.25"					
	T2711-31-W32-3-09-3-25.4	80.7			0902						≥ 1.50"				0902	0902

Example: With the T2711-31-W32-3-09-3-25.4 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902..), a UNC 1 1/2" thread can be produced. Additionally, this body/indexable insert combination can be used to produce UN threads with eight and six TPI, when their nominal diameter is ≥ 1.5".

* = UNEF

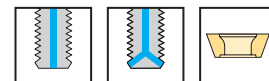
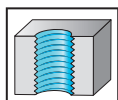
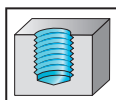
Indexable insert thread milling cutter

T2711 inch



- The programming radius (Rprg.) can be calculated using Walter GPS
- Adjustable internal coolant supply: Radial or axial coolant outlets

UNC/UNF/UN
ASME B1.1



	P	M	K	N	S	H	O
T2711	●	●	●	●	●	●	●

$\leq 2.0 \times D_N$		Designation	D_N	P_{max} TPI	D_c mm	l_{21} mm	l_3 mm	l_1 mm	d_1 inch	Z	No. of indexable inserts	Type
	Weldon inch	★ T2711.20-W19-3-06-2-25.4	UNC 1	8	0.787	1.000	2.122	4.449	3/4	3	6	P26300-06 ..
		★ T2711.26-W26-3-09-2-32.7	UNC 1 1/4	7	1.024	1.287	2.677	5.315	1	3	6	P26300-09 ..
	Weldon inch	★ T2711.31-W31-3-09-3-25.4	UNC 1 1/2	6	1.220	1.000	3.177	5.906	1 1/4	3	9	P26300-09 ..

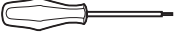
Bodies and assembly parts are included in the scope of delivery.

★ New addition to the product range

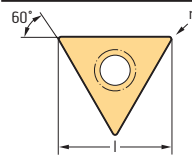
Assembly parts

	D _c [mm]	20	26–31
	Clamping screw for insert	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	4 in lb	8 in lb
	Coolant screw	FS2147 (Torx 6IP)	FS2111 (Torx 7IP)
	Tightening torque	4 in lb	8 in lb

Accessories

	D _c [mm]	20	26–31
	Torque screwdriver, analogue	FS2002	FS2002
	Interchangeable blade	FS2085 (Torx 6IP)	FS2011 (Torx 7IP)
	Screwdriver for indexable insert	FS2086 (Torx 6IP)	FS2088 (Torx 7IP)

Thread milling cutter inserts P26300

	Designation	Number of cutting edges	Size	r mm	Pitch		l mm	P	M	K	N	S	H	O				
					P mm	P TPI		HC	HC	HC	HC	HC	HC	HC				
	P26300-0601-D67	3	6	0.1	1.50–2.50	18–10	6.73	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
	P26300-0602-D67	3	6	0.2	3.00	8	6.58	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
	P26300-0902-D67	3	9	0.2	3.00–4.00	8–6	9.34	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
	P26300-1102-D67	3	11	0.2	3.00–4.50	8–6	10.71	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				
	P26300-1404-D67	3	14	0.4	5.00–6.00	5–4	13.43	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S	WSM37S				

HC = Coated carbide





 New addition to the product range

Tool selection

UN threads			UNC			UNF					UN					
Family	Body designation	l ₃ [mm]	1"	1 1/4"	1 1/2"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	D _N [inch]	TPI				
												18*	16	12	8	6
T2711	T2711.20-W19-3-06-2-25.4	53.9	0602			0601	0601	0601	0601	0601	≥ 1.00"	0601	0601	0601	0602	
	T2711.26-W26-3-09-2-32.7	68		0902							≥ 1.25"					
	T2711.31-W31-3-09-3-25.4	80.7			0902						≥ 1.50"				0902	0902

Example: With the T2711.31-W31-3-09-3-25.4 body and the size 09 indexable insert with 0.2 mm radius (0902 -> P26300-0902..), a UNC 1 1/2" thread can be produced. Additionally, this body/indexable insert combination can be used to produce UN threads with eight and six TPI, when their nominal diameter is ≥ 1.5".

* = UNEF