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ACHTECK
ATM60-030-Z01-095-W32R-09-012
AA2200288

ACHTECK
ATM60-030-Z03-090-W32R-09
Z0100088

CUTTING TOOL CATALOGUE

Thread Milling Product Range Overview

Tools	Series	ATM60
	Thread depth	2.5XDN
	Designation	Single/multi-row tooth thread milling cutters with indexable inserts
	Insert grade	AP320U
	Insert code	TM60、TM55
	Coolant supply	External/Internal
	Milling thread type	M ; MF ; MJ ; UNC ; UNF ; UNEF; UN ; UNJ ; G;
	Hole with thread	
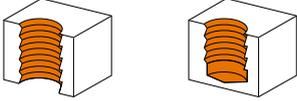
Indexable Thread Milling Cutter Denomination System – Tool Holder

A	TM	60	–	024	–	Z01	–	068	–	W	25	R	–	09	–	007
1	2	3	–	4	–	5	–	6	–	7	8	9	–	10	–	11

1-Company Name	2-Product Group	3-Insert Shape	4-Cutter Diameter	5-Number of Teeth	6-Effective Length of Holder
ACHTECK	Thread milling	T-Type	16	01	52
			19	03	55
			24	04	80
			30		90
			35		……
			……		

7:8-Shank Type and Size	9-Tool Rotation Direction	10-Insert Size	11-Axial Distance Between Rows
W16 Weldon 16	R: Right	06	006
W20 Weldon 20		09	007
W25 Weldon 25		11	012
W32 Weldon 32		14	……
W40 Weldon 40			Without mark means single row

Indexable Thread Milling Cutter Denomination System – Inserts

TM	60	G	–	09	02	02	E	–	MU1	AP320U
1	2	3	–	4	5	6	7	–	8	9

1-Category	2-Insert Code	3-Process	4-Dimensions	5-Thickness
Thread milling inserts	60 Positive triangle insert 60° thread angle	G Ground insert	06	T1=1.98
	55 Positive triangle insert 55° thread angle	M Pressed insert	09	02=2.38
	……		11	03=3.18
			14	

6-Corner Radius	7-Edge Type	8-Chip Breaker	9-Grade
01	E-type	MU1 Universal	AP320U
02			
04			

Thread Milling

Indexable Thread Milling Holder ATM60
Single-Row Tooth Holder
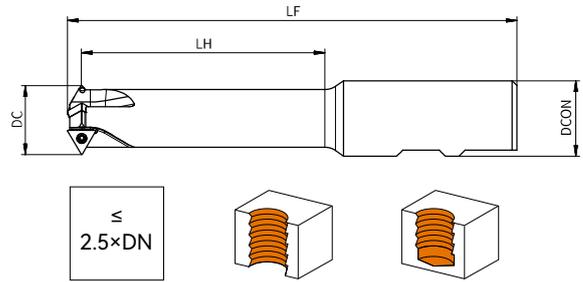
Product code	Dimension (mm)						Z	Coolant	No. of inserts	Insert code
	DN	Pmax mm	DC mm	LH mm	LF mm	DCON mm				
ATM60-016-Z03-052-W16R-06	M20	2.5	16	52	108	16	3	💧	3	TM-06
ATM60-019-Z03-055-W20R-06	M24	3	19	55	115	20	3	💧	3	TM-06
ATM60-024-Z03-080-W25R-09	M30	3.5	24	80	148	25	3	💧	3	TM-09
ATM60-030-Z03-090-W32R-09	M36	4	30	90	162	32	3	💧	3	TM-09
ATM60-035-Z03-110-W32R-11	M42	4.5	35	110	180	32	3	💧	3	TM-11
ATM60-040-Z03-125-W40R-14	M48	5	40	125	208	40	3	💧	3	TM-14
ATM60-044-Z03-150-W40R-14	M56	5.5	44	150	232	40	3	💧	3	TM-14
ATM60-052-Z04-165-W40R-14	M64	6	52	165	248	40	4	💧	4	TM-14

Note: 💧 With internal coolant

✕ Without internal coolant

Dimension (mm)	Spare parts		
D mm	Screw	Wrench	Locking torque
16-19	SP020043	DT-TP06	0.6Nm
24-30	SP022049H	DT-TP07	0.9Nm
35	SP025066	DT-TP07	0.9Nm
40-52	SP030077	DT-TP09	2.0Nm

Indexable Thread Milling Holder ATM60
Multi-Row Tooth Holder
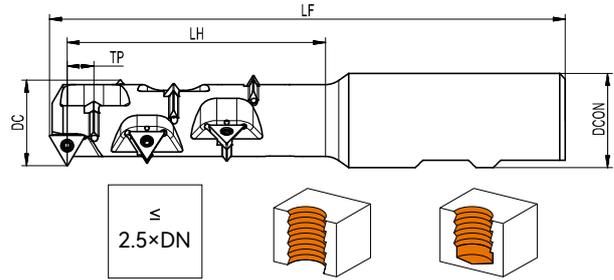
Product code	Dimension (mm)							Z	Coolant	No. of inserts	Insert code
	DN	Pitch P mm	DC mm	LH mm	TP mm	LF mm	DCON mm				
ATM60-013-Z01-035-W12R-06-010	M16/M18	2.5/2	13	35	10	86	12	1	✕	3	TM-06
ATM60-013-Z01-038-W12R-06-009	M16/M18	1.5	13	38	9	88	12	1	✕	4	TM-06
ATM60-017-Z01-047-W16R-06-007.5	M20/M22	2.5/1.5	16.5	47	7.5	103	16	1	⚡	6	TM-06
ATM60-017-Z01-053-W16R-06-010	M20/M22	2.5/2	16.5	53	10	109	16	1	⚡	5	TM-06
ATM60-019-Z01-054-W20R-06-009	M24/M27	3/1.5	19	54	9	114	20	1	⚡	6	TM-06
ATM60-019-Z01-063-W20R-06-012	M24/M27	3/2	19	63	12	123	20	1	⚡	5	TM-06
ATM60-024-Z01-064-W25R-09-010.5	M30/M33	3.5/1.5	24	64	10.5	131	25	1	⚡	6	TM-06
ATM60-024-Z01-079-W25R-09-014	M30/M33	3.5/2	24	79	14	146	25	1	⚡	6	TM-09
ATM60-030-Z01-076-W32R-09-008	M36/M39	4/2	30	76	8	147	32	1	⚡	9	TM-09
ATM60-030-Z01-095-W32R-09-012	M36/M39	4/3/2/1.5	30	95	12	166	32	1	⚡	8	TM-09
ATM60-035-Z01-089-W32R-11-009	M42/M45	4.5/3/1.5	35	89	9	159	32	1	⚡	9	TM-11
ATM60-035-Z01-110-W32R-11-009	M42/M45	4.5/3/1.5	35	110	9	180	32	1	⚡	10	TM-11
ATM60-040-Z01-102-W40R-14-010	M48/M52	5/2	40	102	10	186	40	1	⚡	10	TM-14
ATM60-040-Z01-122-W40R-14-015	M48/M52	5/3/1.5	40	122	15	206	40	1	⚡	8	TM-14
ATM60-044-Z01-119-W40R-14-011	M56/M60	5.5	44	119	11	201	40	1	⚡	10	TM-14
ATM60-044-Z01-146-W40R-14-011	M56/M60	5.5	44	146	11	228	40	1	⚡	10	TM-14
ATM60-052-Z01-135-W40R-14-012	M64/M68	6/3/2	52	135	12	218	40	1	⚡	11	TM-14

Note: ⚡ With internal coolant
✕ Without internal coolant

Dimension (mm)	Spare parts		
D mm	Screw	Wrench	Locking torque
13-19	SP020043	DT-TP06	0.6Nm
24-30	SP022049H	DT-TP07	0.9Nm
35	SP025066	DT-TP07	0.9Nm
40-52	SP030077	DT-TP09	2.0Nm

Thread Milling Insert TM60G、TM55G
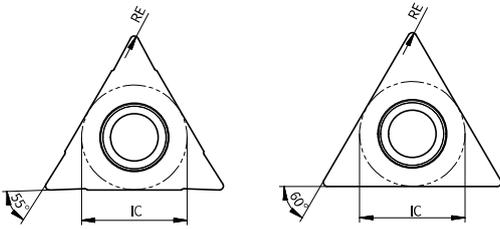
Inserts	Product code	RE mm	Pitch P mm	Pitch P inch	Grade AP320U
	TM60G-06T101E-MU1	0.1	1.5–2.9	18–9	●
	TM60G-06T102E-MU1	0.2	3	8	●
	TM60G-090201E-MU1	0.1	1.5–2.9	18–9	●
	TM60G-090202E-MU1	0.2	3.0–4.0	8–6	●
	TM60G-110201E-MU1	0.1	1.5–2.9	18–9	●
	TM60G-110202E-MU1	0.2	3.0–4.5	8–6	●
	TM60G-140301E-MU1	0.1	1.5–2.9	18–9	●
	TM60G-140302E-MU1	0.2	3.0–5.0	8–5	●
	TM60G-140304E-MU1	0.4	5.0–6.0	5–4	●
	TM55G-090202E-MU1	0.2		11	●
	TM55G-140302E-MU1	0.2		11	●

● : Standard stock   ○ : Made–to–Order

Tool Selection – Single-Row Teeth

Metric thread

Tool holder code	D mm	Inserts	Coarse pitch	Fine pitch
ATM60-016-Z03-052-W16R-06	16	TM60G–06T101	M20;M22;	M20x1.5;M20x2;
ATM60-019-Z03-055-W20R-06	19	TM60G–06T101		M22x1.5;M22x2;M24x1.5;M24x2;M25x1.5; M26x1.5;
		TM60G–06T102	M24;M27;	
ATM60-024-Z03-080-W25R-09	24	TM60G–090201		M27x1.5;M27x2;M28x1.5;M28x2;M30x1.5; M30x2;M32Xx1.5;M32x2;M33x1.5;M33x2;
		TM60G–090202	M30;M33;	
ATM60-030-Z03-090-W32R-09	30	TM60G–090201		M34x1.5;M35x1.5;M36x1.5;M36x2;M38x1.5; M39x1.5;M39x2;
		TM60G–090202	M36;M39;	M36x3;M39x3;
ATM60-035-Z03-110-W32R-11	35	TM60G–110201		M39x1.5;M39x2;M40x1.5;M40x2;M42x1.5; M42x2;
		TM60G–110202	M42;M45;	M40x3;M42x3;
ATM60-040-Z03-125-W40R-14	40	TM60G–140301		M45x1.5;M45x2;M48x2;
		TM60G–140302	M48;M52;	M45x3;M48x3;
ATM60-044-Z03-150-W40R-14	44	TM60G–140301		M50x1.5;M50x2;M52x1.5;M52x2;M56x1.5; M56x2;M58x1.5;M60x1.5;M60x2;
		TM60G–140302		M50x3;M52x3;M56x3;M60x3;M64x3;M68x3;
		TM60G–140304	M56;M60;M64;M68;	
ATM60-052-Z04-165-W40R-14	52	TM60G–140301		M62x1.5;M62x2;M64x2;M68x1.5;M68x2;
		TM60G–140302		M62x3;M62x4;M64x3;M64x4;M68x3;M68x4;
		TM60G–140304	M64;M68;	M70x6;M72x6;

Thread Milling

Thread Machining

Tool Selection – Multi–Row Teeth

Metric thread

Tool holder code	Pitch P	D mm	Insert	Coarse pitch	Fine pitch
ATM60-013-Z01-035-W12R-06-010	2.5/2	13	TM60G–06T101	M16;M17;M18;	M18x2;M17x2;
ATM60-013-Z01-038-W12R-06-009	1.5	13	TM60G–06T101		M16x1.5;M17x1.5;M18x1.5;
ATM60-017-Z01-047-W16R-06-007.5	2.5/1.5	16.5	TM60G–06T101	M20;M22;	M20x1.5;M22x1.5;
ATM60-017-Z01-053-W16R-06-010	2.5/2	16.5	TM60G–06T101	M20;M22;	M20x2;M22x2;
ATM60-019-Z01-054-W20R-06-009	3/1.5	19	TM60G–06T101		M22x1.5;M24x1.5;M25x1.5;M26x1.5;M27x1.5;
			TM60G–06T102	M24;M27;	
ATM60-019-Z01-063-W20R-06-012	3/2	19	TM60G–06T101		M24x2;M25x2;M27x2;
			TM60G–06T102	M24;M27;	
ATM60-024-Z01-064-W25R-09-010.5	3.5/1.5	24	TM60G–090201		M27x1.5;M28x1.5;M30x1.5;M32x1.5;M33x1.5;
			TM60G–090202	M30;M33;	
ATM60-024-Z01-079-W25-09-014	3.5/2	24	TM60G–090201		M28x2;M30x2;M32x2;M33x2;
			TM60G–090202	M30;M33;	
ATM60-030-Z01-076-W32R-09-008	4/2	30	TM60G–090201		M36x2;M39x2;M40x2;M42x2;
			TM60G–090202	M36;M39;	
ATM60-030-Z01-095-W32R-09-012	4/3/2/1.5	30	TM60G–090201		M35x1.5;M36x1.5;M38x1.5;M39x1.5; M36x2;M39x2;M40x2;M42x2;
			TM60G–090202	M36;M39;	M36x3;M39x3;M40x3;
ATM60-035-Z01-089-W32R-11-009	4.5/3/1.5	35	TM60G–110201		M39x1.5;M40x1.5;M42x1.5;M45x1.5;
			TM60G–110202	M42;M45;	M42x3;M45x3;
ATM60-035-Z01-110-W32R-11-009	4.5/3/1.5	35	TM60G–110201		M39x1.5;M40x1.5;M42x1.5;M45x1.5;
			TM60G–110202	M42;M45;	M42x3;M45x3;
ATM60-040-Z01-102-W40R-14-010	5/2	40	TM60G–140301		M45x2;M48x2;M50x2;M52x2;M55x2;M56x2;
			TM60G–140302	M48;M52;	
ATM60-040-Z01-122-W40R-14-015	5/3/1.5	40	TM60G–140301		M45x1.5;M48x1.5;M50x1.5;M52x1.5;M55x1.5; M56x1.5;M58x1.5;M60x1.5;M62x1.5;M64x1.5;
			TM60G–140302	M48;M52;	M48x3;M50x3;M52x3;M55x3;M56x3;
ATM60-044-Z01-119-W40R-14-011	5.5	44	TM60G–140304	M56;M60;	
ATM60-044-Z01-146-W40R-14-011	5.5	44	TM60G–140304	M56;M60;	
ATM60-052-Z01-135-W40R-14-012	6/3/2	52	TM60G–140301		M58x2;M60x2;M62x2;M64x2;M65x2;M68x2; M70x2;M72x2;
			TM60G–140302		M58x3;M60x3;M62x3;M64x3;M65x3;M68x3; M70x3;M72x3;
			TM60G–140304	M64;M68;	M70x6;M72x6;

Tool Selection – Single-Row Teeth

ANSI UN thread

Tool holder code	D mm	Insert	UNC	UNF	UNEF	UN
ATM60-016-Z03-052-W16R-06	16	TM60G-06T101	7/8-9;	3/4-16;7/8-14; 1-12;		7/8-12;7/8-16;
		TM60G-06T102				
ATM60-019-Z03-055-W20R-06	19	TM60G-06T101		1-12;1 1/8-12; 1 1/4-12;	1 1/16-18;	1-16;
		TM60G-06T102	1-8;			1 1/16-8;
ATM60-024-Z03-080-W25R-09	24	TM60G-090201		1 1/8-12; 1 1/4-12;	1 1/8-18; 1 1/4-18;	1 1/8-16;1 1/4-16;
		TM60G-090202	1 1/8-7;1 1/4-7; 1 3/8-6;			1 1/8-8;1 1/4-8;
ATM60-030-Z03-090-W32R-09	30	TM60G-090201		1 3/8-12; 1 1/2-12;	1 3/8-18; 1 1/2-18;	1 3/8-16;1 1/2-16;
		TM60G-090202	1 1/2-6;			1 3/8-8;1 1/2-8;
ATM60-035-Z03-110-W32R-11	35	TM60G-110201			1 5/8-18;	1 5/8-12;1 5/8-16;
		TM60G-110202				1 5/8-6;1 5/8-8;1 3/4-6;1 3/4-8;
ATM60-040-Z03-125-W40R-14	40	TM60G-140301				1 3/4-12;1 3/4-16;1 7/8-12; 1 7/8-16;
		TM60G-140302				1 7/8-6;1 7/8-8;
ATM60-044-Z03-150-W40R-14	44	TM60G-140301				2-12;2-16;2 1/8-12;2 1/8-16; 2 1/4-12;2 1/4-16;2 1/2-12; 2 1/2-16;
		TM60G-140302				2-6;2-8;2 1/8-6;2 1/8-8;2 1/4-6; 2 1/4-8;2 1/2-6;2 1/2-8;
		TM60G-140304	2-4.5;2 1/4-4.5; 2 1/2-4;			
ATM60-052-Z04-165-W40R-14	52	TM60G-140301				2 1/2-12;2 1/2-16;2 3/4-12; 2 3/4-16;3-12;3-16;3 1/4-12; 3 1/4-16;3 1/2-12;3 1/2-16;
		TM60G-140302				2 1/2-6;2 1/2-8;2 3/4-6;2 3/4-8; 3-6;3-8;3 1/4-6;3 1/4-8;3 1/2-6; 3 1/2-8;
		TM60G-140304	2 3/4-4;3-4; 3 1/4-4;3 1/2-4;			

Tool Selection - Single-Row Teeth

G-Thread (BSP)

Tool holder code	D mm	Insert	G
ATM60-024-Z03-080-W25R-09	24	TM55G-090202	G1–11;G1 1/8–11;G1 1/4–11;
ATM60-030-Z03-090-W32R-09	30	TM55G-090202	G1 1/8–11;G1 1/4–11;G1 3/8–11;G1 1/2–11;
ATM60-040-Z03-125-W40R-14	40	TM55G-140302	G1 1/2–11;G1 3/4–11;G2–11;
ATM60-044-Z03-150-W40R-14	44	TM55G-140302	G1 3/4–11;G2–11;G2 1/4–11;G2 1/2–11;G3–11;