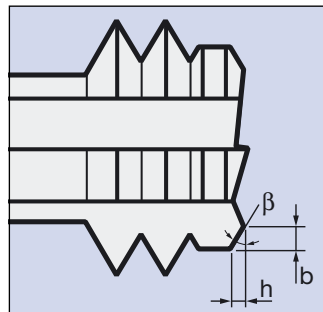
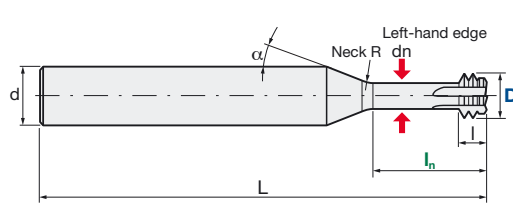
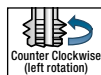




EDT-TH | Epoch Direct Thread Mill TH | $I_n 2.5 \times D_{Nom}$

HRC
66

No. of Teeth
4



Info for chamfering

Carbide
Micro Grain

TH60+
Nano-PVD Coating



Size (mm)																Inner coolant			
ID Code	Item Code	Regular Thread	Z	D	Pitch	I _n	l	dn	L	d	Neck R	α	h	b	β				
EP1595	EDT-0.4-5-TH	M2	4	1.4	0.4	5	1.2	0.91	50	6	1	25°	0.062	0.117	28°	-			
EP1596	EDT-0.45-6.25-TH	M2.5		1.8	0.45	6.25	1.35	1.24					0.089	0.168					
EP1597	EDT-0.5-7.5-TH	M3		2.4	0.5	7.5	1.5	1.78					0.133	0.250					
EP1598	EDT-0.7-10-TH	M4		3.1	0.7	10	2.1	2.24					0.162	0.306					
EP1600	EDT-0.8-12.5-TH	M5		3.8	0.8	12.5	2.4	2.8					0.209	0.394					
EP1601	EDT-1.0-15-TH	M6		4.6	1.0	15	3	3.36					0.247	0.465					
EP1603	EDT-1.25-20-TH	M8		6.2	1.25	20	3.75	4.64	70	10	2		0.346	0.652	28°	•			
EP1599	EDT-0.75-20-TH	*			0.75		2.25	5.16					0.222	0.417					
EP1604	EDT-1.5-25-TH	M10		7.5	1.5	25	4.5	5.61					0.422	0.794					
EP1602	EDT-1.0-25-TH	*			1.0		3	6.11					0.313	0.590					
EP1605	EDT-1.75-30-TH	M12		9.0	1.75	30	5.25	6.78	80	12	0		20°	0.514			0.967	28°	•
EP1606	EDT-2-40-TH	M16		11.5	2.0	40	6	8.87	100					0.690			1.299		
EP1810	EDT-2.5-50-TH	M20		15	2.5	51	7.5	11.71	135	16	0	20°	0.916	1.724					

* is only for fine pitch type thread

EDT-TH | Epoch Direct Thread Mill TH | $I_n 5 \times D_{Nom}$

Carbide
Micro Grain

TH60+
Nano-PVD Coating



Size (mm)																Inner coolant	
ID Code	Item Code	Regular Thread	Z	D	Pitch	I _n	l	dn	L	d	Neck R	α	h	b	β		
EP1803	EDT-0.5-15-TH	M3 long	4	2.4	0.5	15.5	1.5	1.78	60	6	1	25°	0.133	0.250	28°	-	
EP1804	EDT-0.7-20-TH	M4 long		3.1	0.7	21	2.1	2.24					70	0.162			0.306
EP1805	EDT-0.8-25-TH	M5 long		3.8	0.8	26	2.4	2.80						0.209			0.394
EP1806	EDT-1.0-30-TH	M6 long		4.6	1	31	3	3.36	100	10	2		0.247	0.465			•
EP1807	EDT-1.25-40-TH	M8 long		6.2	1.25	41	3.75	4.64					0.346	0.652			
EP1808	EDT-1.5-50-TH	M10 Long		7.5	1.5	51	4.5	5.61					0.422	0.794			
EP1809	EDT-1.75-60-TH	M12 Long		9	1.75	61	5.25	6.78	110				0.514	0.967			

EDT-TH | Epoch Direct Thread Mill TH | G-Type (ISO 228-1)

Carbide
Micro Grain

TH60+
Nano-PVD Coating

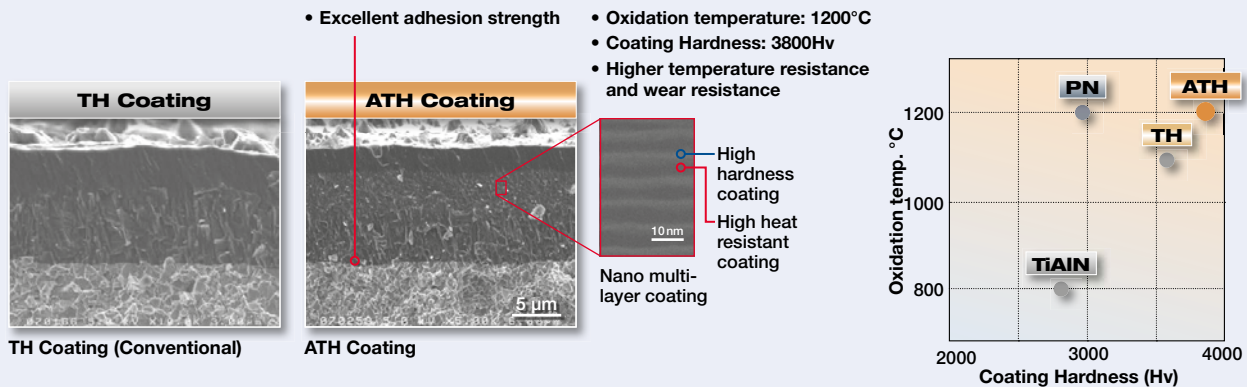


Size (mm)																Inner coolant
ID Code	Item Code	Regular Thread	Z	D	Pitch	I _n	l	dn	L	d	Neck R	α	h	b	β	
EP1811	EDT-G1/16-18-ATH	G 1/16	4	5.8	0.9071	18	2.721	4.31	70	6	1	20°	0.277	0.580	25.5°	-
EP1812	EDT-G1/8-19-ATH	G 1/8		7.3		19		5.81	80	10	2		0.272	0.570		
EP1813	EDT-G1/4-28-ATH	G 1/4		9.8		28		4.011					7.59	110		
EP1814	EDT-G3/8-28-ATH	G 3/8		11.8	1.3368	28	4.011	9.60	110	12	0.384		0.805			
EP1815	EDT-G1/2-35-ATH	G 1/2		15.7	1.8143	35	5.443	12.75	135	16	-		0.513	1.075		
EP1816	EDT-G1-45-ATH	G 1		15.8	2.3091	45	6.927	12.16					0.637	1.335		

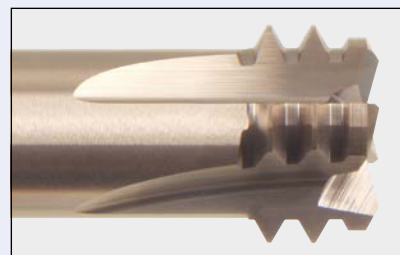
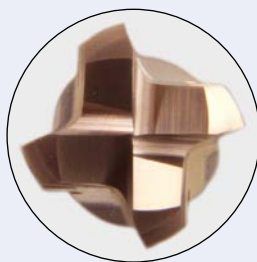
Note: G1/2 EDT can be used to machine G5/8, G3/4 and G7/8 (same pitch)

EDT-TH | Epoch Direct Thread Mill TH

ATH (Advanced TH) Coating – Characteristics



Optimized EDT cutting edges for thread milling



End cutting edges

- Threading without the need for initial core hole.
- If core hole already exists EDT achieves final size hole without the need for several cuts.
- When core hole already exists EDT works without the need for exact core hole diameter.

Thread cutting edges

- Strong cutting edges reduce the risk of chipping.
- Minimizes the cutting edge wear and guarantees the correct size of thread.

Cutting Conditions | Schnittwerte | Condizioni di taglio | Condiciones de Corte | Conditions de coupe | Valores de corte:

Cutting Conditions without Pilot Hole	2.5xD: Page 6	Cutting Conditions with Pilot Hole	2.5xD: Page 7
	5xD: Page 8		5xD: Page 9
	G-Type: Page 10		G-Type: Page 10