

LTE Type Depth of Cut and Number of Passes

LTE Type Standard Depth of Cut

■ With Wiper Edge

| Application | Cat. No. | Reference Cat. No. | Pitch | Depth of cut | Number of Passes | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | | | | |
|-------------------------|-------------------|--------------------|----------------|-----------------|------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|--|--|--|
| 60° metric thread | External grooving | TME 100R | 16ER 100ISO-TE | 1.00 mm | 0.68 | 5 | 0.20 | 0.16 | 0.14 | 0.11 | 0.07 | | | | | | | | | | | | |
| | | TME 125R | 16ER 125ISO-TE | 1.25 | 0.83 | 6 | 0.20 | 0.18 | 0.15 | 0.12 | 0.11 | 0.07 | | | | | | | | | | | |
| | | TME 150R | 16ER 150ISO-TE | 1.50 | 0.96 | 7 | 0.22 | 0.18 | 0.14 | 0.13 | 0.12 | 0.10 | 0.07 | | | | | | | | | | |
| | | TME 175R | 16ER 175ISO-TE | 1.75 | 1.12 | 8 | 0.22 | 0.19 | 0.16 | 0.14 | 0.13 | 0.12 | 0.09 | 0.07 | | | | | | | | | |
| | | TME 200R | 16ER 200ISO-TE | 2.00 | 1.25 | 8 | 0.25 | 0.21 | 0.18 | 0.16 | 0.15 | 0.13 | 0.10 | 0.07 | | | | | | | | | |
| | | TME 250R | 16ER 250ISO-TE | 2.50 | 1.55 | 10 | 0.27 | 0.24 | 0.20 | 0.18 | 0.16 | 0.13 | 0.11 | 0.10 | 0.09 | 0.07 | | | | | | | |
| | | TME 300R | 16ER 300ISO-TE | 3.00 | 1.85 | 12 | 0.28 | 0.25 | 0.20 | 0.19 | 0.17 | 0.15 | 0.13 | 0.12 | 0.10 | 0.10 | 0.09 | 0.07 | | | | | |
| | | TME 350R | 22ER 350ISO-TE | 3.50 | 2.25 | 13 | 0.30 | 0.27 | 0.24 | 0.22 | 0.20 | 0.18 | 0.16 | 0.15 | 0.14 | 0.12 | 0.11 | 0.09 | 0.07 | | | | |
| | | TME 400R | 22ER 400ISO-TE | 4.00 | 2.57 | 14 | 0.35 | 0.32 | 0.29 | 0.26 | 0.23 | 0.20 | 0.17 | 0.15 | 0.14 | 0.12 | 0.10 | 0.09 | 0.08 | 0.07 | | | |
| | Internal grooving | TMI 100R | 16IR 100ISO-TI | 1.00 mm | 0.63 | 5 | 0.18 | 0.16 | 0.12 | 0.10 | 0.07 | | | | | | | | | | | | |
| | | TMI 125R | 16IR 125ISO-TI | 1.25 | 0.77 | 6 | 0.18 | 0.16 | 0.14 | 0.12 | 0.10 | 0.07 | | | | | | | | | | | |
| | | TMI 150R | 16IR 150ISO-TI | 1.50 | 0.90 | 7 | 0.20 | 0.16 | 0.14 | 0.13 | 0.11 | 0.09 | 0.07 | | | | | | | | | | |
| | | TMI 175R | 16IR 175ISO-TI | 1.75 | 1.03 | 8 | 0.20 | 0.18 | 0.15 | 0.14 | 0.11 | 0.10 | 0.08 | 0.07 | | | | | | | | | |
| | | TMI 200R | 16IR 200ISO-TI | 2.00 | 1.18 | 8 | 0.22 | 0.19 | 0.17 | 0.15 | 0.14 | 0.13 | 0.11 | 0.07 | | | | | | | | | |
| | | TMI 250R | 16IR 250ISO-TI | 2.50 | 1.44 | 10 | 0.25 | 0.22 | 0.19 | 0.16 | 0.14 | 0.12 | 0.10 | 0.10 | 0.09 | 0.07 | | | | | | | |
| TMI 300R | | 16IR 300ISO-TI | 3.00 | 1.70 | 12 | 0.27 | 0.24 | 0.20 | 0.17 | 0.14 | 0.12 | 0.12 | 0.10 | 0.10 | 0.09 | 0.08 | 0.07 | | | | | | |
| 60° unified threads | External grooving | TUE 24R | 16ER 24UN-TE | 24 threads/inch | 0.72 | 5 | 0.20 | 0.18 | 0.15 | 0.12 | 0.07 | | | | | | | | | | | | |
| | | TUE 20R | 16ER 20UN-TE | 20 | 0.85 | 6 | 0.21 | 0.18 | 0.16 | 0.13 | 0.10 | 0.07 | | | | | | | | | | | |
| | | TUE 18R | 16ER 18UN-TE | 18 | 0.95 | 6 | 0.22 | 0.20 | 0.18 | 0.16 | 0.12 | 0.07 | | | | | | | | | | | |
| | | TUE 16R | 16ER 16UN-TE | 16 | 1.05 | 7 | 0.22 | 0.20 | 0.17 | 0.15 | 0.13 | 0.11 | 0.07 | | | | | | | | | | |
| | | TUE 14R | 16ER 14UN-TE | 14 | 1.20 | 8 | 0.22 | 0.20 | 0.18 | 0.16 | 0.14 | 0.12 | 0.11 | 0.07 | | | | | | | | | |
| | | TUE 12R | 16ER 12UN-TE | 12 | 1.38 | 9 | 0.25 | 0.22 | 0.19 | 0.17 | 0.15 | 0.13 | 0.11 | 0.09 | 0.07 | | | | | | | | |
| | | TUE 08R | 16ER 08UN-TE | 8 | 2.05 | 12 | 0.28 | 0.25 | 0.23 | 0.21 | 0.19 | 0.17 | 0.15 | 0.14 | 0.13 | 0.12 | 0.11 | 0.07 | | | | | |
| 55° tapered pipe thread | External grooving | TPE 28R | 16ER 28BSPT-TE | 28 threads/inch | 0.62 | 5 | 0.18 | 0.15 | 0.13 | 0.10 | 0.06 | | | | | | | | | | | | |
| | | TPE 19R | 16ER 19BSPT-TE | 19 | 0.92 | 6 | 0.22 | 0.20 | 0.17 | 0.15 | 0.11 | 0.07 | | | | | | | | | | | |
| | | TPE 14R | 16ER 14BSPT-TE | 14 | 1.04 | 7 | 0.22 | 0.20 | 0.17 | 0.15 | 0.13 | 0.10 | 0.07 | | | | | | | | | | |
| | | TPE 11R | 16ER 11BSPT-TE | 11 | 1.50 | 9 | 0.25 | 0.22 | 0.21 | 0.19 | 0.17 | 0.15 | 0.13 | 0.11 | 0.07 | | | | | | | | |

Note: The smaller the pitch, the lower you should set the cutting speed. Also, for internal diameter without a wiper edge, set the number of passes higher.

■ Recommended Cutting Speed (unit: m/min)

| Work material | Grade | AC225 | T1500A / T130A | A30 | ST10P |
|--------------------------|------------|------------|----------------|------------|-----------|
| | Soft steel | | 150 to 200 | 100 to 150 | 70 to 120 |
| P Carbon steel | | 100 to 170 | 80 to 130 | 70 to 100 | 90 to 150 |
| Alloyed steel | | 90 to 150 | 80 to 120 | 70 to 100 | 80 to 130 |
| M Stainless steel | | 70 to 140 | — | 70 to 100 | — |

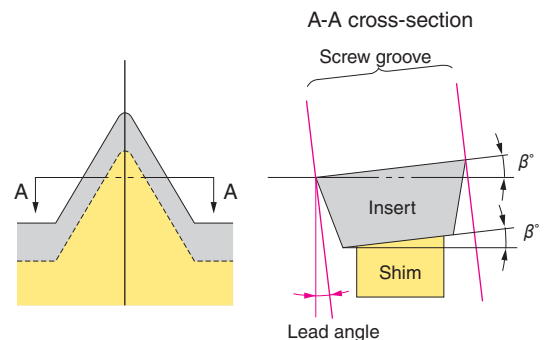
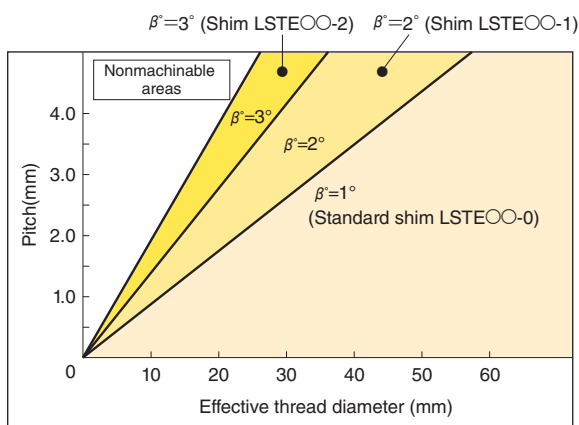
LTE Type Standard Depth of Cut

Without Wiper Edge

| Application | Cat. No. | Reference Cat. No. | Nose R | Pitch | Depth of cut | Number of Passes | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | | | | |
|----------------------|-------------------|--------------------|----------------|-----------------|--------------|------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|--|--|--|--|
| | | | | | | | | | | | | | | | | | | | | | | | | |
| 60° metric thread | TME 1020R | 16ER 102060-TE | 0.13 | 1.00 mm | 0.65 | 5 | 0.20 | 0.16 | 0.12 | 0.10 | 0.07 | | | | | | | | | | | | | |
| | | | | 1.25 | 0.84 | 6 | 0.20 | 0.18 | 0.16 | 0.13 | 0.10 | 0.07 | | | | | | | | | | | | |
| | | | | 1.50 | 1.03 | 7 | 0.22 | 0.20 | 0.17 | 0.15 | 0.12 | 0.10 | 0.07 | | | | | | | | | | | |
| | | | | 1.75 | 1.22 | 8 | 0.22 | 0.21 | 0.18 | 0.16 | 0.15 | 0.13 | 0.10 | 0.07 | | | | | | | | | | |
| | | | | 2.00 | 1.41 | 10 | 0.22 | 0.20 | 0.18 | 0.16 | 0.14 | 0.13 | 0.12 | 0.10 | 0.09 | 0.07 | | | | | | | | |
| | TME 1530R | 16ER 153060-TE | 0.20 | 1.50 mm | 0.95 | 7 | 0.22 | 0.17 | 0.14 | 0.13 | 0.12 | 0.10 | 0.07 | | | | | | | | | | | |
| | | | | 1.75 | 1.14 | 8 | 0.22 | 0.18 | 0.16 | 0.15 | 0.14 | 0.12 | 0.10 | 0.07 | | | | | | | | | | |
| | | | | 2.00 | 1.33 | 9 | 0.25 | 0.20 | 0.18 | 0.16 | 0.15 | 0.13 | 0.10 | 0.09 | 0.07 | | | | | | | | | |
| | | | | 2.50 | 1.71 | 12 | 0.25 | 0.22 | 0.19 | 0.17 | 0.15 | 0.14 | 0.13 | 0.12 | 0.10 | 0.09 | 0.08 | 0.07 | | | | | | |
| | | | | 3.00 | 2.09 | 14 | 0.25 | 0.22 | 0.20 | 0.20 | 0.18 | 0.17 | 0.15 | 0.14 | 0.14 | 0.10 | 0.10 | 0.09 | 0.08 | 0.07 | | | | |
| | Internal grooving | TMI 1020R | 16IR 102060-TI | 0.06 | 1.00 mm | 0.59 | 6 | 0.16 | 0.12 | 0.10 | 0.08 | 0.08 | 0.05 | | | | | | | | | | | |
| | | | | | 1.25 | 0.75 | 7 | 0.16 | 0.14 | 0.12 | 0.10 | 0.10 | 0.08 | 0.05 | | | | | | | | | | |
| | | | | | 1.50 | 0.92 | 8 | 0.18 | 0.15 | 0.14 | 0.12 | 0.10 | 0.10 | 0.08 | 0.05 | | | | | | | | | |
| | | | | | 1.75 | 1.08 | 9 | 0.18 | 0.16 | 0.14 | 0.13 | 0.12 | 0.12 | 0.10 | 0.08 | 0.05 | | | | | | | | |
| | | TMI 1530R | 16IR 153060-TI | 0.09 | 1.50 mm | 0.91 | 8 | 0.18 | 0.14 | 0.14 | 0.12 | 0.10 | 0.10 | 0.08 | 0.05 | | | | | | | | | |
| | | | | | 1.75 | 1.07 | 9 | 0.18 | 0.16 | 0.13 | 0.13 | 0.12 | 0.12 | 0.10 | 0.08 | 0.05 | | | | | | | | |
| 2.00 | | | | | 1.23 | 10 | 0.20 | 0.18 | 0.14 | 0.14 | 0.12 | 0.12 | 0.10 | 0.10 | 0.08 | 0.05 | | | | | | | | |
| 2.50 | | | | | 1.56 | 12 | 0.20 | 0.18 | 0.16 | 0.16 | 0.15 | 0.13 | 0.13 | 0.11 | 0.11 | 0.10 | 0.08 | 0.05 | | | | | | |
| 55° Whitworth thread | TWE 2416R | 16ER 241655-TE | 0.13 | 20 threads/inch | 0.80 | 6 | 0.20 | 0.17 | 0.15 | 0.12 | 0.09 | 0.07 | | | | | | | | | | | | |
| | | | | 19 | 0.84 | 6 | 0.20 | 0.18 | 0.16 | 0.13 | 0.10 | 0.07 | | | | | | | | | | | | |
| | | | | 18 | 0.90 | 7 | 0.20 | 0.18 | 0.15 | 0.12 | 0.10 | 0.08 | 0.07 | | | | | | | | | | | |
| | | | | 16 | 1.03 | 7 | 0.22 | 0.20 | 0.17 | 0.15 | 0.12 | 0.10 | 0.07 | | | | | | | | | | | |
| | | | | 14 threads/inch | 1.07 | 8 | 0.20 | 0.17 | 0.15 | 0.14 | 0.13 | 0.12 | 0.09 | 0.07 | | | | | | | | | | |
| | TWE 1410R | 16ER 141055-TE | 0.23 | 12 | 1.29 | 9 | 0.22 | 0.20 | 0.17 | 0.15 | 0.14 | 0.13 | 0.12 | 0.09 | 0.07 | | | | | | | | | |
| | | | | 11 | 1.43 | 10 | 0.22 | 0.21 | 0.18 | 0.16 | 0.14 | 0.13 | 0.12 | 0.11 | 0.09 | 0.07 | | | | | | | | |
| | | | | 10 | 1.60 | 11 | 0.22 | 0.21 | 0.18 | 0.17 | 0.16 | 0.14 | 0.13 | 0.12 | 0.11 | 0.09 | 0.07 | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | |
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Note: The smaller the pitch, the lower you should set the cutting speed. Also, for internal diameter without a wiper edge, set the number of passes higher.

SumiGrip LTE Type Holder Shim Selection



LTE type comes with $\beta = 1^\circ$ shim in its standard parts.
 $\beta = 2^\circ$ and 3° shim are sold separately.
 Additionally, STE and STI types do not have shim.