



LNEX ***CARBIDE THREADING INSERTS***

For Milling Large Diameter Thread Holes

Economical

Precision

Durable

ALL-NEW



THREADING



ISO

UN

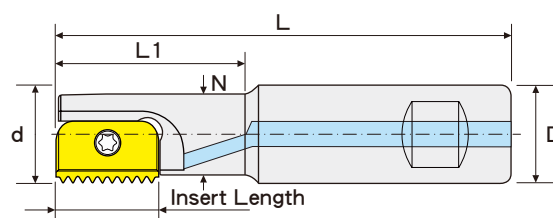
BSPT

NPT

Features

- NEW carbide thread inserts are double-sided with two cutting edges.
- Precise threads ensure your precision components fit together perfectly.
- Indexable thread toolholders are suitable for both right-hand and left-hand threading.
- For threading carbon steel, alloy steel, stainless steel, cast iron, aluminum alloy and high-temperature alloy.

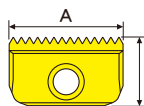
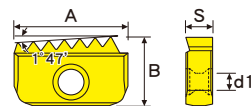
Threading Toolholders Size



Order No.	Dimensions (mm)					Teeth	Insert	Screw 	Wrench 
	d	L1	N	L	D				
ETLN14-01012-075L	12	20	8.9	75	20	1	LNEX14.. LNHT14..	MS3008A	ETF09
ETLN14-01012-075L-C	12	20	8.9	75	20	1			
ETLN14-010145-085L	14.5	25	11	85	20	1			
ETLN14-010145-085L-C	14.5	25	11	85	20	1			
ETLN14-02020-093L	20	41	16	93	20	2			
ETLN14-02020-093L-C	20	41	16	93	20	2			
ETLN21-01021-094L	21	40	16.5	94	20	1	LNEX21.. LNHT21..	MS4011D	ETF15
ETLN21-01021-094L-C	21	40	16.5	94	20	1			
ETLN21-01025-125L	25	28	—	125	20	1			
ETLN21-01025-125L-C	25	28	—	125	20	1			
ETLN21-02030-108L	30	52	24	108	25	2			
ETLN21-02030-108L-C	30	52	24	108	25	2			

※ Product number end in -C are coolant-through design.

Carbide Threading Inserts Size

	P	Alloy Steels	●			● First Recommend / ○ Second Recommend : Continuous Cutting ● First Recommend / ○ Second Recommend : General Cutting ✱ First Recommend / ✱ Second Recommend : Interrupted Cutting — NO Recommend						
	M	Stainless Steels	●									
	K	Cast Iron	●									
	N	Aluminum Alloys	○			ISO UN  BSPT NPT 						
	S	High-Temp Alloys	●									
	H	Hardened Steels	○									
Order No.			Grade			Pitch		Dimension (mm)			Thread	
			CM/6433					A	B	S	d1	—
External		Internal		ISO Metric 60°								
LNEX14E075ISO		LNEX14I075ISO		●			0.75 mm	14	7.5	3.1	3.3	—
LNEX14E100ISO		LNEX14I100ISO		●			1.00 mm	14	7.5	3.1	3.3	—
LNEX14E125ISO		LNEX14I125ISO		●			1.25 mm	14	7.5	3.1	3.3	—
LNEX14E150ISO		LNEX14I150ISO		●			1.50 mm	14	7.5	3.1	3.3	—
LNEX14E175ISO		LNEX14I175ISO		●			1.75 mm	14	7.5	3.1	3.3	—
LNEX14E200ISO		LNEX14I200ISO		●			2.00 mm	14	7.5	3.1	3.3	—
LNEX14E250ISO		LNEX14I250ISO		●			2.50 mm	14	7.5	3.1	3.3	—
LNEX21E100ISO		LNEX21I100ISO		●			1.00 mm	21	12	4.7	4.7	—
LNEX21E125ISO		LNEX21I125ISO		●			1.25 mm	21	12	4.7	4.7	—
LNEX21E150ISO		LNEX21I150ISO		●			1.50 mm	21	12	4.7	4.7	—
LNEX21E175ISO		LNEX21I175ISO		●			1.75 mm	21	12	4.7	4.7	—
LNEX21E200ISO		LNEX21I200ISO		●			2.00 mm	21	12	4.7	4.7	—
LNEX21E250ISO		LNEX21I250ISO		●			2.50 mm	21	12	4.7	4.7	—
LNEX21E300ISO		LNEX21I300ISO		●			3.00 mm	21	12	4.7	4.7	—
External		Internal		American UN 60°								
LNEX14E32UN		LNEX14I32UN		●			32 Tpi	14	7.5	3.1	3.3	—
LNEX14E28UN		LNEX14I28UN		●			28 Tpi	14	7.5	3.1	3.3	—
LNEX14E24UN		LNEX14I24UN		●			24 Tpi	14	7.5	3.1	3.3	—
LNEX14E20UN		LNEX14I20UN		●			20 Tpi	14	7.5	3.1	3.3	—
LNEX14E18UN		LNEX14I18UN		●			18 Tpi	14	7.5	3.1	3.3	—
LNEX14E16UN		LNEX14I16UN		●			16 Tpi	14	7.5	3.1	3.3	—
LNEX14E14UN		LNEX14I14UN		●			14 Tpi	14	7.5	3.1	3.3	—
LNEX14E12UN		LNEX14I12UN		●			12 Tpi	14	7.5	3.1	3.3	—
LNEX14E10UN		LNEX14I10UN		●			10 Tpi	14	7.5	3.1	3.3	—
LNEX21E24UN		LNEX21I24UN		●			24 Tpi	21	12	4.7	4.7	—
LNEX21E20UN		LNEX21I20UN		●			20 Tpi	21	12	4.7	4.7	—
LNEX21E18UN		LNEX21I18UN		●			18 Tpi	21	12	4.7	4.7	—
LNEX21E16UN		LNEX21I16UN		●			16 Tpi	21	12	4.7	4.7	—
LNEX21E14UN		LNEX21I14UN		●			14 Tpi	21	12	4.7	4.7	—
LNEX21E12UN		LNEX21I12UN		●			12 Tpi	21	12	4.7	4.7	—
LNEX21E10UN		LNEX21I10UN		●			10 Tpi	21	12	4.7	4.7	—
External / Internal			BSPT Taper Pipe Thread 55°									
LNHT1419BSPT				●			19 Tpi	14	7.5	3.1	3.3	—
LNHT1414BSPT				●			14 Tpi	14	7.5	3.1	3.3	—
LNHT2114BSPT				●			14 Tpi	21	12	4.7	4.7	—
LNHT2111BSPT				●			11 Tpi	21	12	4.7	4.7	—
External / Internal			NPT Taper Pipe Thread 60°									
LNHT1418NPT				●			18 Tpi	14	7.5	3.1	3.3	—
LNHT1414NPT				●			14 Tpi	14	7.5	3.1	3.3	—
LNHT2114NPT				●			14 Tpi	21	12	4.7	4.7	—
LNHT2111NPT				●			11.5 Tpi	21	12	4.7	4.7	—

✱ BSPT & NPT taper pipe thread milling inserts can only use one cutting edge.



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CNC Internal Thread Milling Program

CMTéc / 2024-09-2K-VER. 0.1

Cutting Condition

Work Material	Carbon Steels	Alloy Steels		Hardened Steels		Stainless Steels	Cast Iron	Aluminum Alloys	High-Temp Alloys
	HRC<20	HRC20~30	HRC30~45	HRC45~55	HRC55~63	—	HRC<30	—	HRC<30
V _c (m/min)	100~200	80~150	60~120	20~40	—	60~120	70~130	100~250	20~50
f _z (mm)	0.05~0.15	0.04~0.12	0.03~0.10	0.02~0.06	—	0.02~0.08	0.04~0.12	0.05~0.20	0.02~0.05