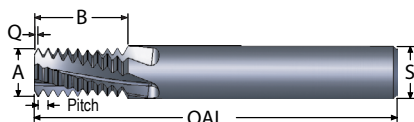


UN THREAD MILLS

15° HELICAL FLUTE SOLID CARBIDE



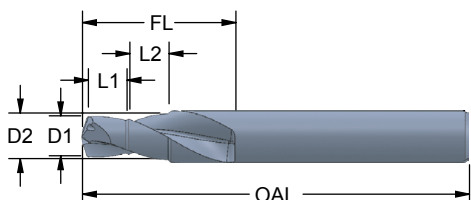
- Cuts UNC, UNF, UNEF, UNS and UNJ (internal only)
- Non-crest cutting allows maximum flexibility for plated and non-standard threads
- Long length-of-cut

MIN ID THREAD / PITCH*	"A" TOOL DIA.	"B" LENGTH OF CUT	"Q" LENGTH	"S" SHANK DIA.	CORRESPONDING PORT SIZE	OAL	FLUTES	ORDER #	EDP #
								AITiN+	AITiN+
5/16-24	0.234	0.641	0.019	0.250	AS5202-2	2.50	3	TMI234-24HA	102964
3/8-24	0.285	0.766	0.019	0.3125	AS5202-3	3.00	4	TMI285-24HA	102994
7/16-20	0.335	0.870	0.023	0.375	AS5202-4	3.00	4	TMI335-20HA	103024
9/16-18	0.370	0.911	0.025	0.375	AS5202-5	3.00	4	TMI370-18HA	103033
1/2-20	0.370	0.870	0.023	0.375	AS5202-6	3.00	4	TMI370-20HA	103034
3/4-16	0.495	1.338	0.028	0.500	AS5202-8	4.00	4	TMI495-16HA	103075

Thread mills can cut any larger size internal thread of the same pitch

ROUGHING STEP DRILLS FOR AS5202 PORT SIZES

SOLID CARBIDE, 140 DEGREE POINT, COOLANT THROUGH

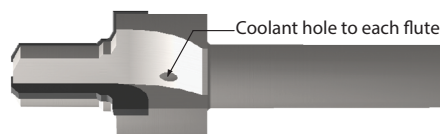
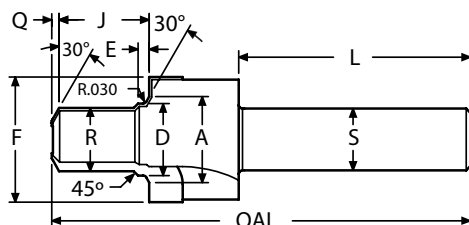


- Prepares hole for the port tool by roughing the minor-thread and sealing diameters
- Coolant through for superior chip evacuation
- 140° self-centering point
- AITiN+ coating extends tool life and thermal stability

SAE SIZE	"S" SHANK DIA.	OAL	"D1"	"D2"	"L1"	"L2"	"FL" FLUTE LENGTH	"SL" SHANK LENGTH	ORDER #	EDP #
									AITiN+	AITiN+
2	8mm	79mm	0.260	0.315	0.499	0.49	1.29	1.82	RD-AS5202-02A	407036
3	10mm	89mm	0.323	0.376	0.505	0.50	1.45	2.06	RD-AS5202-03A	407038
4	12mm	102mm	0.377	0.440	0.561	0.56	1.66	2.35	RD-AS5202-04A	407040
5	14mm	107mm	0.439	0.503	0.561	0.56	1.82	2.39	RD-AS5202-05A	407042
6	14mm	107mm	0.497	0.551	0.603	0.60	1.98	2.23	RD-AS5202-06A	407044
8	20mm	108mm	0.677	0.755	0.713	0.71	2.22	2.03	RD-AS5202-08A	407046

AS5202 (MS33649) - REAMER PILOT PORT TOOL

COOLANT THROUGH - CARBIDE TIPPED



- Reams minor thread diameter to size
- Precision ground for maximum concentricity
- Meets the requirements of AS5202/MS33649
- AITiN+ coated tool for higher cutting speed
- This port requires a UNJ thread which specifies a larger minor thread diameter

A	D	E	F	J	Q	R	L	S	OAL	FLUTES	TUBE	THREAD	ORDER #	EDP #
													AITiN+	AITiN+
0.446	0.3305	0.071	0.742	0.597	0.032	0.276	1.75	0.500	3.00	3	0.125	0.3125-24 UNJF-3B	AS5202-02R-X3A	406509
0.508	0.3925	0.071	0.805	0.603	0.040	0.339	1.75	0.500	3.00	3	0.188	0.3750-24 UNJF-3B	AS5202-03R-X3A	406517
0.570	0.4565	0.083	0.888	0.676	0.040	0.393	1.88	0.500	3.12	3	0.250	0.4375-20 UNJF-3B	AS5202-04R-X3A	406525
0.633	0.5195	0.083	0.950	0.676	0.045	0.455	1.88	0.500	3.12	3	0.312	0.5000-20 UNJF-3B	AS5202-05R-X3A	406533
0.696	0.5825	0.091	1.012	0.729	0.060	0.513	1.88	0.500	3.38	3	0.375	0.5625-18 UNJF-3B	AS5202-06R-X3A	406541
0.883	0.7715	0.102	1.240	0.854	0.070	0.693	2.12	0.750	3.84	3	0.500	0.7500-16 UNJF-3B	AS5202-08R-X3A	406553

AS5202 PORT KIT

This all-in-one kit includes a high-performance drill, a port tool for precise hole finishing, and a thread mill. All tools are AlTiN+ coated.



1. Roughing Step Drill
2. AS5202 Port Tool Reamer
3. 15° Helical Thread Mill



1. DFX Drill
2. AS5202 X-Series Port Tool
3. 15° Helical Thread Mill

The SCT 1-2-3 Kit For AS5202

Includes one drill, one port tool, and one thread mill for specific port size.

KIT WITH ROUGHING STEP DRILL, AS5202 PORT TOOL REAMER PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	RD-AS5202-02A	AS5202-02RA	TMI234-24HA	AS5202KIT02RA	410030
AS5202-3	RD-AS5202-03A	AS5202-03RA	TMI285-24HA	AS5202KIT03RA	410032
AS5202-4	RD-AS5202-04A	AS5202-04RA	TMI335-20HA	AS5202KIT04RA	410034
AS5202-5	RD-AS5202-05A	AS5202-05RA	TMI370-20HA	AS5202KIT05RA	410036
AS5202-6	RD-AS5202-06A	AS5202-06RA	TMI370-18HA	AS5202KIT06RA	410038
AS5202-8	RD-AS5202-08A	AS5202-08RA	TMI495-16HA	AS5202KIT08RA	410040

KIT WITH DFX DRILL, AS5202 COOLANT THROUGH PORT TOOL WITHOUT PILOT, AND THREAD MILL

Port Size	Drill	Port Tool	Thread Mill	Kit Order Number	Kit EDP Number
AS5202-2	DFX3-276A	AS5202-02XA	TMI234-24HA	AS5202KIT02XA	410042
AS5202-3	DFX3-338A	AS5202-03XA	TMI285-24HA	AS5202KIT03XA	410044
AS5202-4	DFX3-393A	AS5202-04XA	TMI335-20HA	AS5202KIT04XA	410046
AS5202-5	DFX3-455A	AS5202-05XA	TMI370-20HA	AS5202KIT05XA	410048
AS5202-6	DFX3-513A	AS5202-06XA	TMI370-18HA	AS5202KIT06XA	410050
AS5202-8	DFX3-693A	AS5202-08XA	TMI495-16HA	AS5202KIT08XA	410052

There are two kits available for completing an AS5202 port. One kit includes a coolant through Roughing Step Drill, a Helical Thread Mill, and a Reamer style port tool. The other kit has a coolant through DFX Drill that cuts the minor diameter, a Helical Thread Mill, and an X-Series port tool without a pilot diameter.