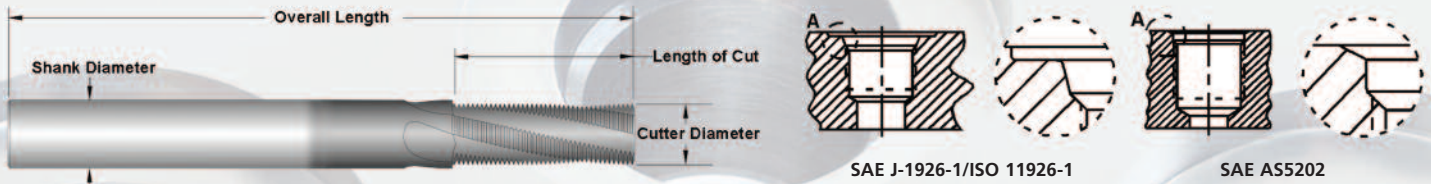




# AccuThread 856®



Accuport Specific – International Unified Series (UN) manufactured specifically for use with AccuPort 432® hydraulic port forms. The length of cut allows full thread with one pass. Conforms to J1926 and SAE AS5202 port form spec.

AccuPort 432® Specific Thread Mills (For use with AccuPort 432® Port Contour Cutter)

Port Size	Pitch	Item Number	Flutes	Cutter Diameter	Shank Diameter	Length of cut	Overall Length	*AM210®
-4 to -5	20	TMAK0438-20M	4	8.51	10.00	15.25	73.00	●
-6	18	TMAK0563-18M	4	9.40	10.00	16.92	73.00	●
-8	16	TMAK0750-16M	4	11.94	12.00	19.05	84.00	●
-10	14	TMAK0875-14M	4	11.94	12.00	21.77	84.00	●
-12 to -32	12	TMAK1063-12M	4	11.94	12.00	23.29	84.00	●

**Stk. - Stock Availability.**

- Stock Item.
- Stocked in limited quantities, advanced planning is recommended
- ◆ Non-Stocked Standard. Normal delivery 5 to 6 weeks



## AccuPort 432® AccuThread 856® Ferrous Material Kit

Tube Dash Number	Port Thread Size	Port Contour Cutter Number	QTY	T-A® Drill Item Number		Port Form Insert Item Numbers		AccuThread 856® Item Numbers		Kit Item Number
				Super Cobalt (AM200®)	QTY	C5 Carbide (TiAlN)	QTY	Solid Carbide (AM200®)	QTY	
- 4	7/16-20 UNF-2B	J1926-04Y-16FM	1	45YH-.386	2	J1926-02-C5A	2	TMAK0438-20M	1	ATK-K-04-M
- 5	1/2-20 UNF-2B	J1926-05Z-16FM	1	45ZH-11.5	2	J1926-02-C5A	2	TMAK0438-20M	1	ATK-K-05-M
- 6	9/16-18 UNF-2B	J1926-06O-20FM	1	45OH-13	2	J1926-02-C5A	2	TMAK0563-18M	1	ATK-K-06-M
- 8	3/4-16 UNF-2B	J1926-08O-20FM	1	45OH-0022	2	J1926-07-C5A	2	TMAK0750-16M	1	ATK-K-08-M
- 10	7/8-14 UNF-2B	J1926-10I-25FM	1	45IH-20.5	2	J1926-07-C5A	2	TMAK0875-14M	1	ATK-K-10-M
- 12	1 1/16-12 UN-2B	J1926-12J-32FM	1	45JH-25	2	J1926-08-C5A	2	TMAK1063-12M	1	ATK-K-12-M
- 14	1 3/16-12 UN-2B	J1926-14K-32FM	1	45KH-28	2	J1926-08-C5A	2	TMAK1063-12M	1	ATK-K-14-M
- 16	1 5/16-12 UN-2B	J1926-16L-32FM	1	45LH-31	2	J1926-08-C5A	2	TMAK1063-12M	1	ATK-K-16-M
- 20	1 5/8-12 UN-2B	J1926-20M-32FM	1	45MH-39	1	J1926-10-C5A	2	TMAK1063-12M	1	ATK-K-20-M
- 24	1 7/8-12 UN-2B	J1926-24N-150F	1	45NH-45.5	1	J1926-10-C5A	2	TMAK1063-12M	1	ATK-K-24-M
- 32	2 1/2-12 UN-2B	J1926-32P-150F	1	45PH-61.5	1	J1926-12-C5A	2	TMAK1063-12M	1	ATK-K-32-M

## AccuPort 432® AccuThread 856® Non-ferrous Material Kit

Tube Dash Number	Port Thread Size	Port Contour Cutter Number	QTY	T-A® Drill Item Number		Port Form Insert Item Numbers		AccuThread 856® Item Numbers		Kit Item Number
				Super Cobalt (TiN)	QTY	C5 Carbide (TiAlN)	QTY	Solid Carbide (Uncoated)	QTY	
- 4	7/16-20 UNF-2B	J1926-04Y-16FM	1	15YT-.386	2	J1926-02-C5A	2	TMAU0438-20M	1	ATK-U-04-M
- 5	1/2-20 UNF-2B	J1926-05Z-16FM	1	15ZT-11.5	2	J1926-02-C5A	2	TMAU0438-20M	1	ATK-U-05-M
- 6	9/16-18 UNF-2B	J1926-06O-20FM	1	15OT-13	2	J1926-02-C5A	2	TMAU0563-18M	1	ATK-U-06-M
- 8	3/4-16 UNF-2B	J1926-08O-20FM	1	15OT-17.5	2	J1926-07-C5A	2	TMAU0750-16M	1	ATK-U-08-M
- 10	7/8-14 UNF-2B	J1926-10I-25FM	1	15IT-20.5	2	J1926-07-C5A	2	TMAU0875-14M	1	ATK-U-10-M
- 12	1 1/16-12 UN-2B	J1926-12J-32FM	1	15JT-25	2	J1926-08-C5A	2	TMAU1063-12M	1	ATK-U-12-M
- 14	1 3/16-12 UN-2B	J1926-14K-32FM	1	15JT-28	2	J1926-08-C5A	2	TMAU1063-12M	1	ATK-U-14-M
- 16	1 5/16-12 UN-2B	J1926-16L-32FM	1	15JT-31	2	J1926-08-C5A	2	TMAU1063-12M	1	ATK-U-16-M
- 20	1 5/8-12 UN-2B	J1926-20M-32FM	1	453T-39	1	J1926-10-C5A	2	TMAU1063-12M	1	ATK-U-20-M
- 24	1 7/8-12 UN-2B	J1926-24N-150F	1	453T-45.5	1	J1926-10-C5A	2	TMAU1063-12M	1	ATK-U-24-M
- 32	2 1/2-12 UN-2B	J1926-32P-150F	1	454T-61.5	1	J1926-12-C5A	2	TMAU1063-12M	1	ATK-U-32-M

\*All other coatings are non-stocked standards 10 to 15 day delivery