

Mill-Thread Solid Carbide



Advantages of Mill-Thread Solid Carbide

- Thread is generated in one pass.
- Spiral flutes allow smooth cutting action.
- Shorter machining time due to multi, 3 to 6, flutes.
- 2.2 mm and up cutting diameter.
- Threads up to shoulder in blind hole.
- Longer tool life due to special multi-layer coating.
- Same tool can be used for a variety of materials.
- Excellent surface finish.
- Low cutting pressure allows thin wall machining.
- Same tool used for R.H and L.H. threads.

MT - Thread Mills without internal coolant

MTB - Thread Mills with internal coolant bore for blind holes

MTZ - Thread Mills with internal coolant through the flutes

MTQ - Thread Mills that include relieved neck for deep work pieces

FMT - Fast Thread Mills with internal coolant bore

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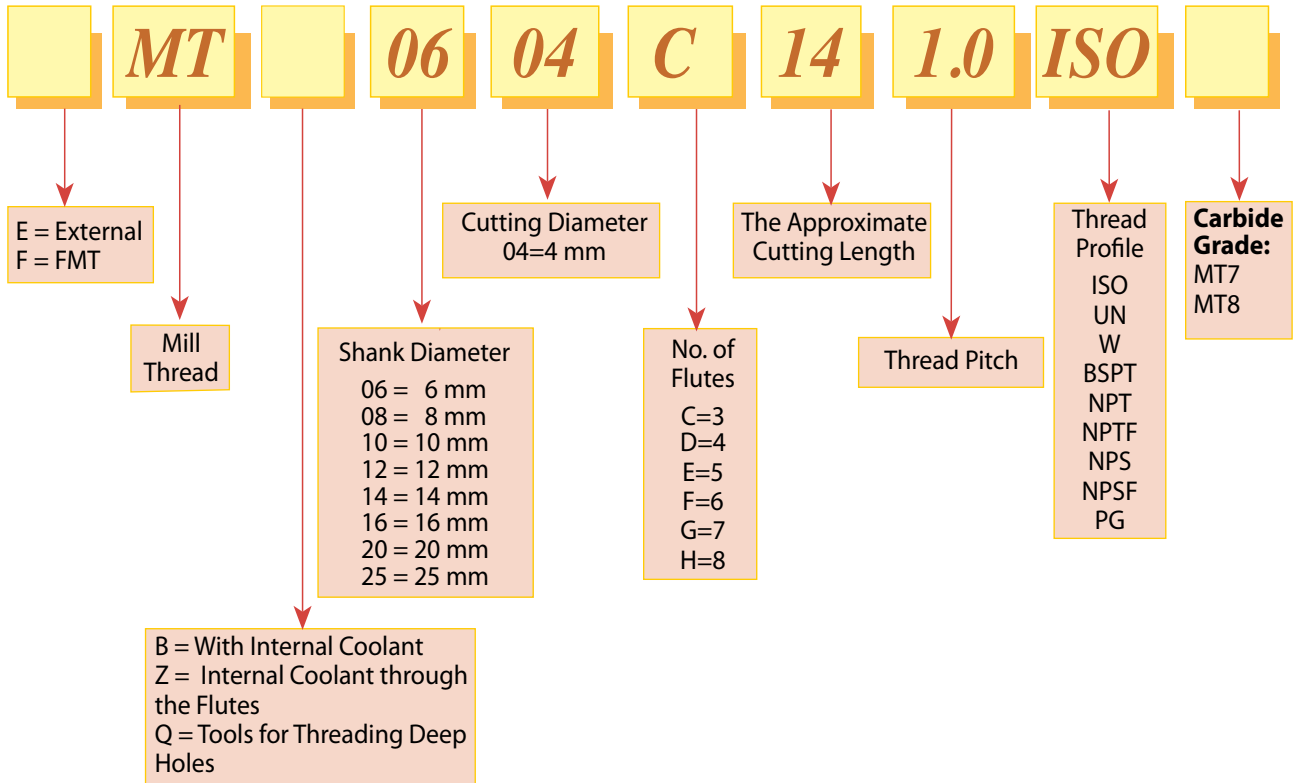
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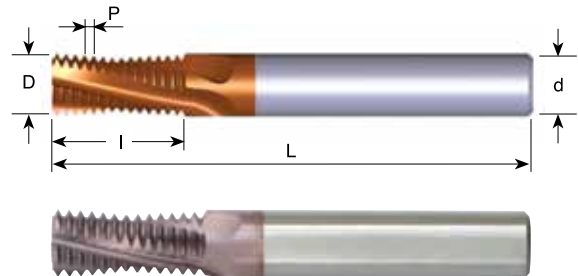
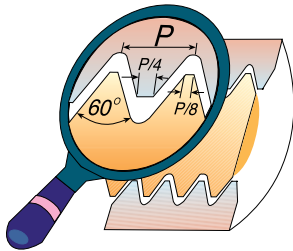
Product Identification

Mill-Thread Solid Carbide Ordering Codes



ISO

Tools for Internal thread



Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	I	L
0.5	M3	$\varnothing \geq 4$	MT06022C5 0.5 ISO	6	2.2	3	5.3	58
0.5		$\varnothing \geq 5$	MT06038C10 0.5 ISO	6	3.8	3	10.3	58
0.7	M4	$\varnothing \geq 5$	MT06031C7 0.7 ISO	6	3.1	3	7.4	58
0.75		$\varnothing \geq 6$	MT06045C10 0.75 ISO	6	4.5	3	10.1	58
0.8	M5	$\varnothing \geq 6$	MT06036C9 0.8 ISO	6	3.6	3	9.2	58
1.0	M6	$\varnothing \geq 7$	MT0604C10 1.0 ISO	6	4.0	3	10.5	58
1.0	M6	$\varnothing \geq 7$	MT0604C14 1.0 ISO	6	4.0	3	14.5	58
1.0		$\varnothing \geq 9$	MT0606C12 1.0 ISO	6	6.0	3	12.5	58
1.0		$\varnothing \geq 10$	MT0808D16 1.0 ISO	8	8.0	4	16.5	64
1.25	M8	$\varnothing \geq 10$	MT0605C14 1.25 ISO	6	5.0	3	14.4	58
1.25	M8	$\varnothing \geq 10$	MT0605C19 1.25 ISO	6	5.0	3	19.4	58
1.5	M10	$\varnothing \geq 12$	MT0807C17 1.5 ISO	8	7.0	3	17.3	64
1.5	M10	$\varnothing \geq 12$	MT0807C24 1.5 ISO	8	7.0	3	24.8	76
1.5		$\varnothing \geq 14$	MT1010D21 1.5 ISO	10	10.0	4	21.8	73
1.5		$\varnothing \geq 20$	MT1616F33 1.5 ISO	16	16.0	6	33.8	105
1.75	M12	$\varnothing \geq 14$	MT0808C20 1.75 ISO	8	8.0	3	20.1	64
1.75	M12	$\varnothing \geq 14$	MT0808C28 1.75 ISO	8	8.0	3	28.9	76
2.0	M16	$\varnothing \geq 17$	MT1010C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M16	$\varnothing \geq 17$	MT1010C39 2.0 ISO	10	10.0	3	39.0	105
2.0		$\varnothing \geq 18$	MT1212D27 2.0 ISO	12	12.0	4	27.0	84
2.0		$\varnothing \geq 26$	MT2020F41 2.0 ISO	20	20.0	6	41.0	105
2.5	M20	$\varnothing \geq 22$	MT1414D33 2.5 ISO	14	14.0	4	33.8	84
2.5	M20	$\varnothing \geq 22$	MT1414D48 2.5 ISO	14	14.0	4	48.8	105
3.0	M24	$\varnothing \geq 25$	MT1616C40 3.0 ISO	16	16.0	3	40.5	105
3.0	M24	$\varnothing \geq 25$	MT1616C58 3.0 ISO	16	16.0	3	58.5	120
3.0	M27	$\varnothing \geq 28$	MT2020D43 3.0 ISO	20	20.0	4	43.5	105

Order example: MT 1212D27 2.0 ISO MT7

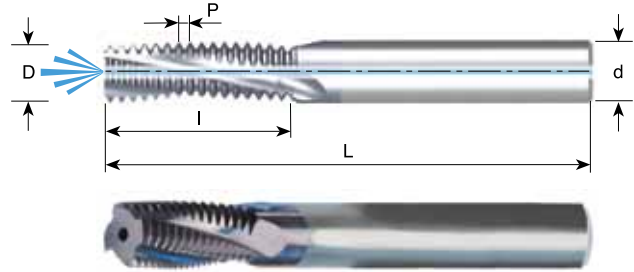
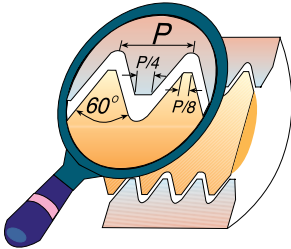
For thread mills with coolant bore see following pages

For small thread mills see pages 227-228, 235 & 245



ISO With internal coolant bore

Tools for Internal thread



Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	I	L
0.5		$\varnothing \geq 5$	MTB06038C10 0.5 ISO	6	3.8	3	10.3	58
0.7	M4	$\varnothing \geq 5$	MTB06031C7 0.7 ISO	6	3.1	3	7.4	58
0.75		$\varnothing \geq 6$	MTB06045C10 0.75 ISO	6	4.5	3	10.1	58
0.75		$\varnothing \geq 12$	MTB1010D24 0.75 ISO	10	10.0	4	24.4	73
0.8	M5	$\varnothing \geq 6$	MTB06038C9 0.8 ISO	6	3.8	3	9.2	58
1.0	M6	$\varnothing \geq 7$	MTB06046C10 1.0 ISO	6	4.6	3	10.5	58
1.0	M6	$\varnothing \geq 7$	MTB06046C14 1.0 ISO	6	4.6	3	14.5	58
1.0		$\varnothing \geq 9$	MTB0606C12 1.0 ISO	6	6.0	3	12.5	58
1.0		$\varnothing \geq 10$	MTB0808D16 1.0 ISO	8	8.0	4	16.5	64
1.0		$\varnothing \geq 12$	MTB1010D24 1.0 ISO	10	10.0	4	24.5	73
1.25	M8	$\varnothing \geq 10$	MTB0606C14 1.25 ISO	6	6.0	3	14.4	58
1.25	M8	$\varnothing \geq 10$	MTB0606C19 1.25 ISO	6	6.0	3	19.4	58
1.5	M10	$\varnothing \geq 12$	MTB08078C17 1.5 ISO	8	7.8	3	17.0	64
1.5	M10	$\varnothing \geq 12$	MTB08078C24 1.5 ISO	8	7.8	3	24.8	76
1.5		$\varnothing \geq 14$	MTB1010D21 1.5 ISO	10	10.0	4	21.8	73
1.5		$\varnothing \geq 16$	MTB1212D26 1.5 ISO	12	12.0	4	26.3	84
1.5		$\varnothing \geq 20$	MTB1616F33 1.5 ISO	16	16.0	6	33.8	105
1.75	M12	$\varnothing \geq 12$	MTB1009C20 1.75 ISO	10	9.0	3	20.1	73
1.75	M12	$\varnothing \geq 12$	MTB1009C28 1.75 ISO	10	9.0	3	28.9	73
2.0	M14	$\varnothing \geq 15$	MTB1010C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M16	$\varnothing \geq 17$	MTB12118D27 2.0 ISO	12	11.8	4	27.0	84
2.0	M16	$\varnothing \geq 17$	MTB12118D39 2.0 ISO	12	11.8	4	39.0	105
2.0		$\varnothing \geq 26$	MTB2020F41 2.0 ISO	20	20.0	6	41.0	105
2.5	M20	$\varnothing \geq 22$	MTB1615E33 2.5 ISO	16	15.0	5	33.8	105
2.5	M20	$\varnothing \geq 22$	MTB1615E48 2.5 ISO	16	15.0	5	48.8	105
3.0	M24	$\varnothing \geq 25$	MTB2018D40 3.0 ISO	20	18.0	4	40.5	105
3.0	M24	$\varnothing \geq 25$	MTB2018D58 3.0 ISO	20	18.0	4	58.5	120
3.0	M27	$\varnothing \geq 27$	MTB2020D43 3.0 ISO	20	20.0	4	43.5	105

Order example: MTB 08078C17 1.5 ISO MT7

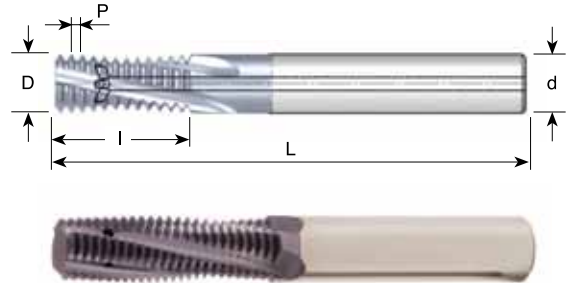
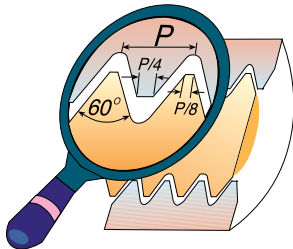
For thread mills with coolant through the flutes see next page

For small thread mills see pages 227-228, 235 & 245



ISO With internal coolant through the flutes

Tools for Internal Thread



Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	I	L
1.0	M6	$\varnothing \geq 7$	MTZ06048C10 1.0 ISO	6	4.8	3	10.5	58
1.0		$\varnothing \geq 9$	MTZ0606C12 1.0 ISO	6	6.0	3	12.5	58
1.0		$\varnothing \geq 10$	MTZ0808D16 1.0 ISO	8	8.0	4	16.5	64
1.25	M8	$\varnothing \geq 10$	MTZ0606C14 1.25 ISO	6	6.0	3	14.4	58
1.25	M8	$\varnothing \geq 10$	MTZ0606C19 1.25 ISO	6	6.0	3	19.4	58
1.5	M10	$\varnothing \geq 12$	MTZ08078C17 1.5 ISO	8	7.8	3	17.0	64
1.5		$\varnothing \geq 14$	MTZ1010D21 1.5 ISO	10	10.0	4	21.8	73
1.5		$\varnothing \geq 16$	MTZ1212D26 1.5 ISO	12	12.0	4	26.3	84
1.5		$\varnothing \geq 20$	MTZ1616E33 1.5 ISO	16	16.0	5	33.8	101
1.75	M12	$\varnothing \geq 12$	MTZ1009C20 1.75 ISO	10	9.0	3	20.1	73
1.75	M12	$\varnothing \geq 12$	MTZ1009C28 1.75 ISO	10	9.0	3	28.9	73
2.0	M14	$\varnothing \geq 15$	MTZ1010C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M16	$\varnothing \geq 17$	MTZ12118D27 2.0 ISO	12	11.8	4	27.0	84
2.5	M20	$\varnothing \geq 22$	MTZ1615E33 2.5 ISO	16	15.0	5	33.8	101

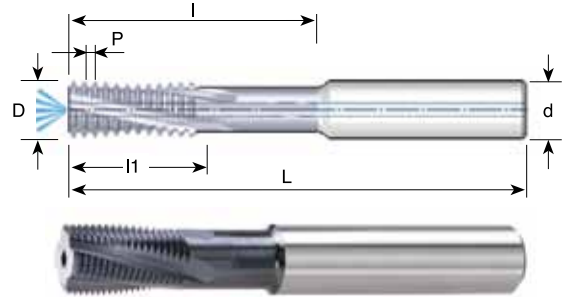
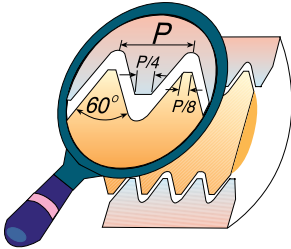
Order example: MTZ 08078C17 1.5 ISO MT7

For small thread mills see pages 227-228, 235 & 245



ISO With relieved neck and internal coolant bore

Tools for Internal Thread



Pitch TPI	M fine	Ordering Code	d	D	No. of Flutes	l1	l	L
1.0	$\emptyset \geq 12$	MTQ1010D32 1.0 ISO	10	10.0	4	18.0	32.0	73
1.0	$\emptyset \geq 14$	MTQ1212D38 1.0 ISO	12	12.0	4	21.0	38.0	84
1.0	$\emptyset \geq 18$	MTQ1616F45 1.0 ISO	16	16.0	6	26.0	45.0	105
1.5	$\emptyset \geq 13$	MTQ1010D30 1.5 ISO	10	10.0	4	18.0	30.0	73
1.5	$\emptyset \geq 15$	MTQ1212D34 1.5 ISO	12	12.0	4	19.5	34.5	84
1.5	$\emptyset \geq 19$	MTQ1616F43 1.5 ISO	16	16.0	6	25.5	43.5	105
1.5	$\emptyset \geq 23$	MTQ2020F60 1.5 ISO	20	20.0	6	36.0	60.0	105
2.0	$\emptyset \geq 16$	MTQ1212D42 2.0 ISO	12	12.0	4	24.0	42.0	84
2.0	$\emptyset \geq 20$	MTQ1616E45 2.0 ISO	16	16.0	5	26.0	45.0	105
2.0	$\emptyset \geq 24$	MTQ2020F56 2.0 ISO	20	20.0	6	34.0	56.0	105
3.0	$\emptyset \geq 22$	MTQ1616D45 3.0 ISO	16	16.0	4	30.0	45.0	105
3.0	$\emptyset \geq 26$	MTQ2020E54 3.0 ISO	20	20.0	5	33.0	54.0	105
3.5	$\emptyset \geq 26$	MTQ2020D45 3.5 ISO	20	20.0	4	28.0	45.5	105
4.0	$\emptyset \geq 31$	MTQ2525D64 4.0 ISO	25	25.0	4	40.0	64.0	160

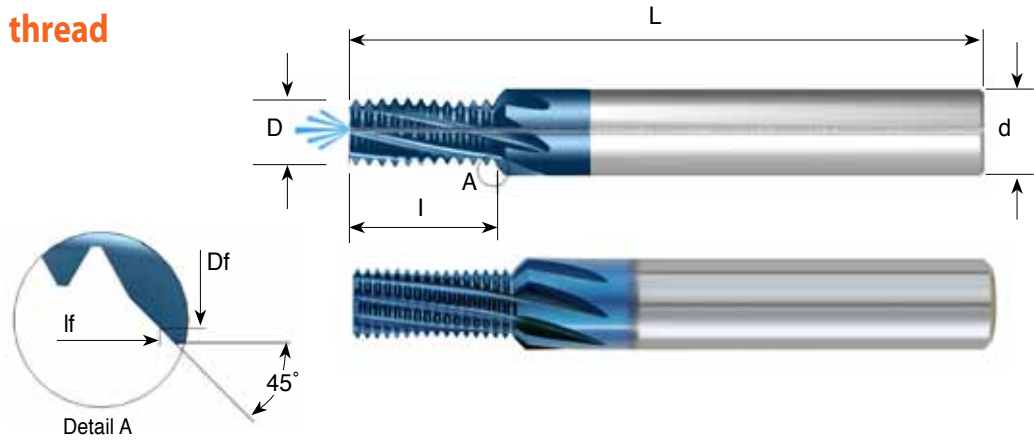
Order example: MTQ 1010D30 1.5 ISO MT7

For small thread mills see pages 227-228, 235 & 245



ISO Fast MT With internal coolant bore

Tools for Internal thread

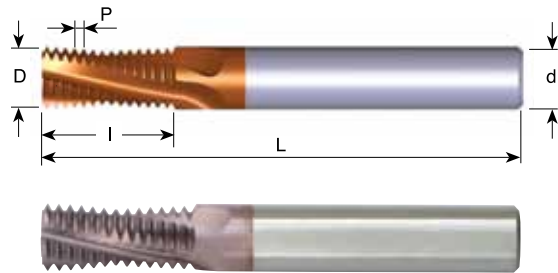
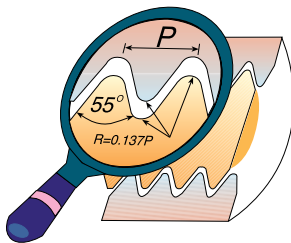


Pitch mm	M coarse	M fine	Ordering Code	d	D	Df	Flutes	I	lf	L
1.0	M6	$\varnothing \geq 7$	FMT 08048 F10 1.0 ISO	8	4.8	6.8	6	10.5	11.5	64
1.25	M8	$\varnothing \geq 10$	FMT 10064 G14 1.25 ISO	10	6.4	9.6	7	14.4	16.0	73
1.5	M10	$\varnothing \geq 12$	FMT 1008 G17 1.5 ISO	10	8.0	9.8	7	17.3	18.2	73
1.75	M12	$\varnothing \geq 12$	FMT 12095 G20 1.75 ISO	12	9.5	11.7	7	20.1	21.2	84

Order example: FMT 1008 G17 1.5 ISO MT8

G (55°) BSF, BSP

Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/16-G1/8	MT0606C9 28 W	6	6.0	3	9.5	58
19	G1/4-3/8	MT0808C14 19 W	8	8.0	3	14.0	64
14	G1/2-7/8	MT1212D19 14 W	12	12.0	4	19.0	84
14	G1/2-7/8	MT1212D26 14 W	12	12.0	4	26.3	84
11	$G \geq 1$	MT1212C24 11 W	12	12.0	3	24.2	84
11	$G \geq 1$	MT1616D38 11 W	16	16.0	4	38.1	105
11	$G \geq 1$	MT2020E47 11 W	20	20.0	5	47.3	105

Order example: MT 1212D19 14 W MT7

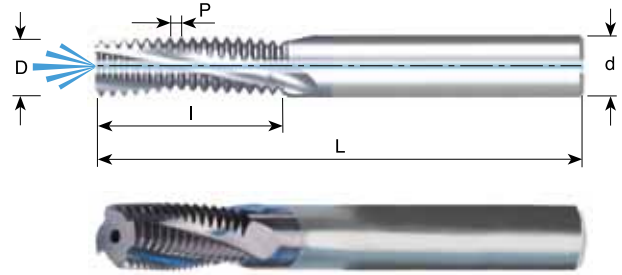
For small thread mills see pages 231, 234 & 247

For thread mills with coolant see next page



G (55°) BSF, BSP With internal coolant bore

Same Tool for Internal and External Thread



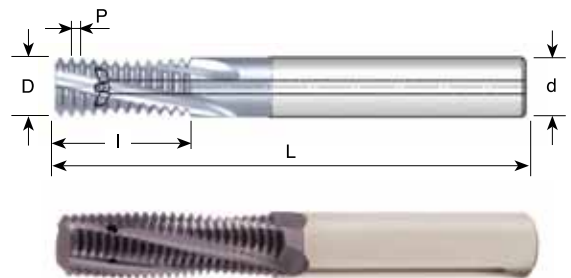
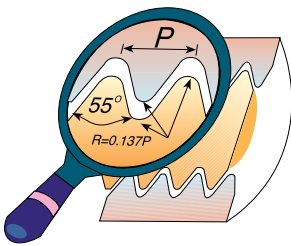
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	MTB08078C14 28W	8	7.8	3	14.1	64
19	G1/4-3/8	MTB1010D16 19W	10	10.0	4	16.7	73
14	G1/2-7/8	MTB1616E26 14W	16	16.0	5	26.3	105
11	G≥1	MTB1616D38 11W	16	16.0	4	38.1	105
11	G≥1	MTB2020E47 11W	20	20.0	5	47.3	105

Order example: MTB 1010D16 19 W MT7

For small thread mills see pages 231, 234 & 247

G 55° BSF, BSP With internal coolant through the flutes

Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	MTZ08078C14 28W	8	7.8	3	14.1	64
19	G1/4-3/8	MTZ1010D16 19W	10	10.0	4	16.7	73
14	G1/2-7/8	MTZ1616E26 14W	16	16.0	5	26.3	101
11	G≥1	MTZ1616D38 11W	16	16.0	4	38.1	101

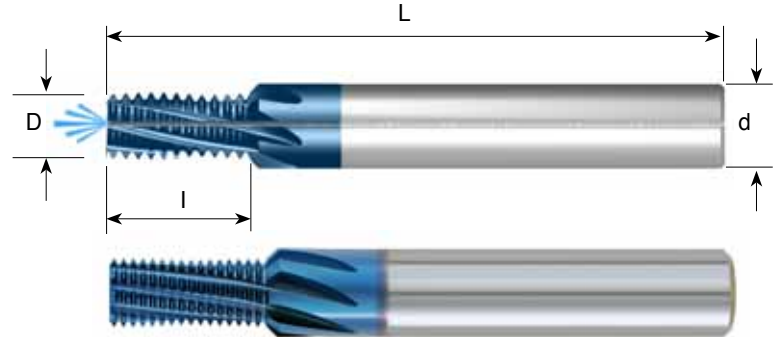
Order example: MTZ 08078C14 28 W MT7

For small thread mills see pages 231, 234 & 247



G 55° Fast MT With internal coolant bore

Same Tool for Internal and External Thread



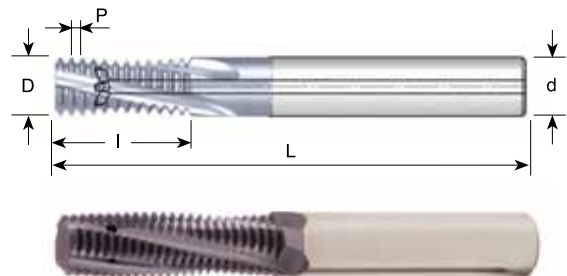
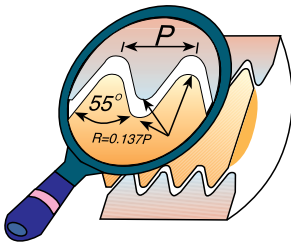
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	FMT08078H14 28W	8	7.8	8	14.1	64
19	G1/4-3/8	FMT1010G16 19W	10	10.0	7	16.7	73
14	G1/2-7/8	FMT1616H26 14W	14	14.0	8	26.3	84
11	G≥1	FMT1616H38 11W	16	16.0	8	38.1	105

Order example: FMT 1616 H38 11W MT8

* Without cutting chamfer

Whitworth BSW With internal coolant through the flutes

Same Tool for Internal and External Thread



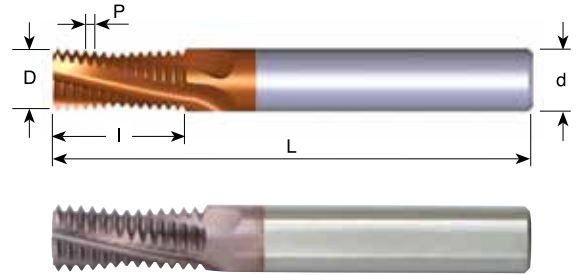
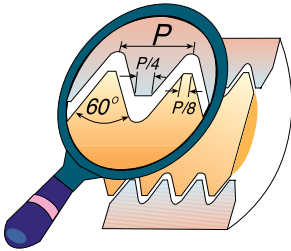
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
* 20	1/4	MTZ06046C12 20W	6	4.6	3	12.1	58
18	5/16	MTZ06053C14 18W	6	5.3	3	14.8	58
16	3/8	MTZ08064C16 16W	8	6.8	3	16.7	64
16	1/2	MTZ10092D24 16W	10	9.2	4	24.6	73
14	7/16	MTZ08078D20 14W	8	7.8	4	20.9	64
12	1/2	MTZ10086D24 12W	10	8.6	4	24.4	73
11	5/8	MTZ12109D28 11W	12	10.9	4	28.9	84

Order example: MTZ 08064C16 16 W MT7

* Cutter without coolant

UN

Tools for Internal Thread



Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
40	5			MT06025C6 40UN	6	2.5	3	6.0	58
32	8	10	12	MT06032C6 32UN	6	3.2	3	6.8	58
28		1/4		MT0604C11 28UN	6	4.0	3	11.3	58
28			7/16-1/2	MT0606C14 28UN	6	6.0	3	14.1	58
24		5/16		MT0605C14 24UN	6	5.0	3	14.3	58
24		3/8	9/16-5/8	MT0807C21 24UN	8	7.0	3	20.6	64
20	1/4			MT06045C12 20UN	6	4.5	3	12.1	58
20		7/16-1/2		MT0807C21 20UN	8	7.0	3	21.0	64
20			3/4-1	MT1212E27 20UN	12	12.0	5	27.3	84
18	5/16			MT0605C14 18UN	6	5.0	3	14.8	58
18		9/16-5/8	1 ^{1/8} -1 ^{5/8}	MT1010D26 18UN	10	10.0	4	26.1	73
16	3/8			MT0606C16 16UN	6	6.0	3	16.7	58
16		3/4		MT1212D31 16UN	12	12.0	4	31.0	84
14	7/16			MT0807C20 14UN	8	7.0	3	20.9	64
14		7/8		MT1615E37 14UN	16	15.0	5	37.2	105
13	1/2			MT0808C22 13UN	8	8.0	3	22.5	64
12	9/16			MT1010C26 12UN	10	10.0	3	26.5	73
12		1-1 ^{1/2}		MT1616E41 12UN	16	16.0	5	41.3	105
11	5/8			MT1010C28 11UN	10	10.0	3	28.9	73
10	3/4			MT1212C34 10UN	12	12.0	3	34.3	84
9	7/8			MT1615C38 9UN	16	15.0	3	38.1	105
8	1			MT1616C42 8UN	16	16.0	3	42.9	105
7	1 ^{1/8} -1 ^{1/4}			MT2020D45 7UN	20	20.0	4	45.3	105

Order example: MT 1615 E37 14 UN MT7

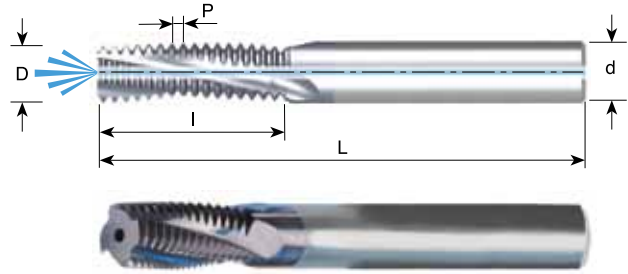
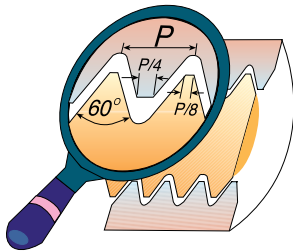
For thread mills with coolant bore see following pages

For small thread mills see pages 229-230, 235 & 246



UN With internal coolant bore

Tools for Internal Thread



Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
32	8	10	12	MTB06032C6 32 UN	6	3.2	3	6.8	58
32			5/16	MTB0606C14 32 UN	6	6.0	3	14.7	58
32			3/8	MTB0808D18 32 UN	8	8.0	4	18.7	64
28		1/4		MTB0605C11 28 UN	6	5.0	3	11.3	58
28			7/16-1/2	MTB0606C14 28 UN	6	6.0	3	14.1	58
24		5/16		MTB08066C14 24 UN	8	6.6	3	14.3	64
24		3/8	9/16-5/8	MTB0808D21 24 UN	8	8.0	4	20.6	64
20	1/4			MTB06047C12 20 UN	6	4.7	3	12.1	58
20		7/16		MTB0808C21 20 UN	8	8.0	3	21.0	64
20		1/2		MTB1010D22 20 UN	10	10.0	4	22.3	73
20			3/4-1	MTB1212E27 20 UN	12	12.0	5	27.3	84
18	5/16			MTB06056C14 18 UN	6	5.6	3	14.8	58
18		9/16-5/8	1 1/8-1 5/8	MTB12113D26 18 UN	12	11.3	4	26.1	84
16	3/8			MTB08067C16 16 UN	8	6.7	3	16.7	64
16		3/4		MTB1212D31 16 UN	12	12.0	4	31.0	84
14	7/16			MTB08077C20 14 UN	8	7.7	3	20.9	64
14		7/8		MTB1616E37 14 UN	16	16.0	5	37.2	105
13	1/2			MTB10092C22 13 UN	10	9.2	3	22.5	73
12	9/16			MTB12105C26 12 UN	12	10.5	3	26.5	84
12		1-1 1/2		MTB1616E41 12 UN	16	16.0	5	41.3	105
11	5/8			MTB12114C28 11 UN	12	11.4	3	28.9	84
10	3/4			MTB16144D34 10 UN	16	14.4	4	34.3	105
9	7/8			MTB1616C38 9 UN	16	16.0	3	38.1	105
8	1			MTB20195D42 8 UN	20	19.5	4	42.9	105
7	1 1/8-1 1/4			MTB2020D45 7 UN	20	20.0	4	45.3	105

Order example: MTB 1212D31 16 UN MT7

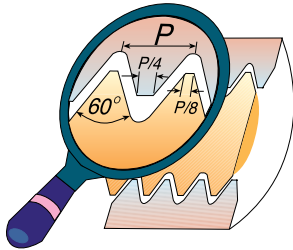
For thread mills with coolant through the flutes see next page

For small thread mills see pages 229-230, 235 & 246



UN With internal coolant through the flutes

Tools for Internal Thread



Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
28		1/4		MTZ0605C11 28 UN	6	5.0	3	11.3	58
28			7/16-1/2	MTZ0606C14 28 UN	6	6.0	3	14.1	58
24		5/16		MTZ08066C14 24 UN	8	6.6	3	14.3	64
24		3/8	9/16-5/8	MTZ0808D21 24 UN	8	8.0	4	20.6	64
20		7/16		MTZ0808C21 20 UN	8	8.0	3	21.0	64
20		1/2		MTZ1010D22 20 UN	10	10.0	4	22.3	73
20			3/4-1	MTZ1212E27 20 UN	12	12.0	5	27.3	84
18	5/16			MTZ06056C14 18 UN	6	5.6	3	14.8	58
18		9/16-5/8	1 ^{1/8} -1 ^{5/8}	MTZ12113D26 18 UN	12	11.3	4	26.1	84
16	3/8			MTZ08067C16 16 UN	8	6.7	3	16.7	64
16		3/4		MTZ1212D31 16 UN	12	12.0	4	31.0	84
14	7/16			MTZ08077C20 14 UN	8	7.7	3	20.9	64
14		7/8		MTZ1616E37 14 UN	16	16.0	5	37.2	101
13	1/2			MTZ10092C22 13 UN	10	9.2	3	22.5	73
12	9/16			MTZ12105C26 12 UN	12	10.5	3	26.5	84
11	5/8			MTZ12114C28 11 UN	12	11.4	3	28.9	84
10	3/4			MTZ16144D34 10 UN	16	14.4	4	34.3	101

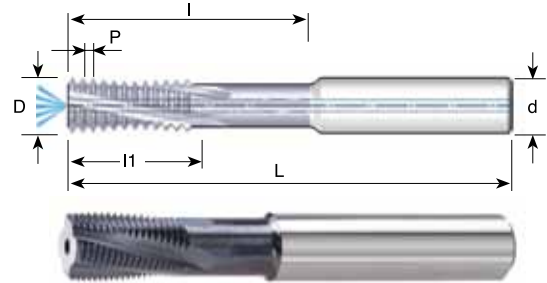
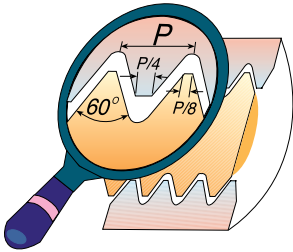
Order example: [MTZ 0808D21 24 UN MT7](#)

For small thread mills see pages 229-230, 235 & 246



UN With relieved neck and internal coolant bore

Tools for Internal Thread



Pitch TPI	Thread size	Ordering Code	d	D	No. of Flutes	l1	l	L
20	$\varnothing \geq 12$	MTQ1010D30 20 UN	10	10.0	4	17.8	30.5	73
20	$\varnothing \geq 14$	MTQ1212E35 20 UN	12	12.0	5	20.3	35.6	84
20	$\varnothing \geq 18$	MTQ1616F43 20 UN	16	16.0	6	25.4	43.2	105
18	$\varnothing \geq 15$	MTQ1212D35 18 UN	12	12.0	4	19.7	35.3	84
16	$\varnothing \geq 15$	MTQ1212D35 16 UN	12	12.0	4	20.7	35.0	84
16	$\varnothing \geq 19$	MTQ1616E42 16 UN	16	16.0	5	25.4	42.9	105
16	$\varnothing \geq 23$	MTQ2020F58 16 UN	20	20.0	6	36.5	58.8	105
14	$\varnothing \geq 20$	MTQ1616E45 14 UN	16	16.0	5	25.4	45.3	105
12	$\varnothing \geq 16$	MTQ1212D42 12 UN	12	12.0	4	25.4	42.3	84
12	$\varnothing \geq 24$	MTQ2020E55 12 UN	20	20.0	5	33.9	55.1	105

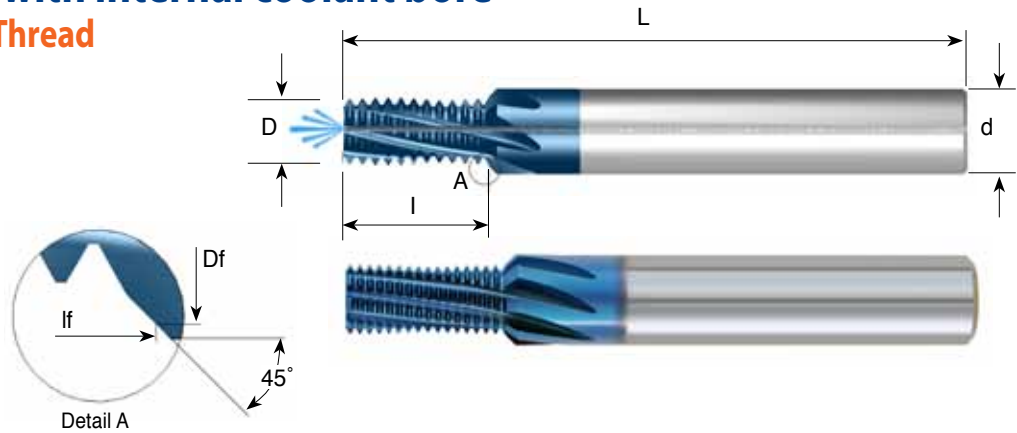
Order example: MTQ 1212D35 16 UN MT7

For small thread mills see pages 229-230, 235 & 246



UN Fast MT with internal coolant bore

Tools for Internal Thread



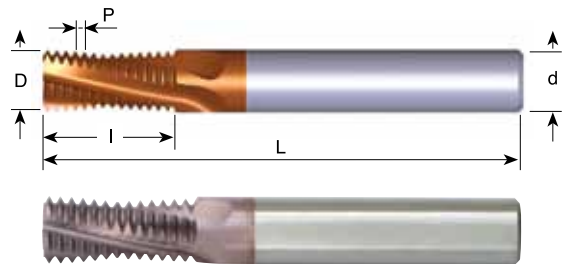
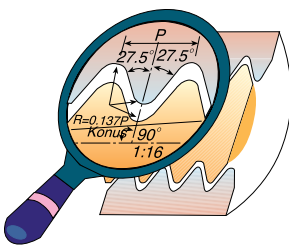
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	Df	Flutes	I	lf	L
24		5/16, 3/8	9/16, 5/8, 11/16	FMT 10066 G14 24 UN	10	6.6	9.6	7	14.3	15.8	73
20	1/4			* FMT 08048 E12 20 UN	8	4.8	6.8	5	12.1	13.1	64
20		7/16, 1/2	3/4, 1	FMT 12092 H21 20 UN	12	9.2	11.4	8	21.0	22.1	84
18	5/16	9/16, 5/8	11/16	FMT 1006 F14 18 UN	10	6.0	8.4	6	14.8	16.0	73
16	3/8	3/4		FMT 10074 F16 16 UN	10	7.4	9.6	6	16.7	17.8	73
14	7/16	7/8		FMT 12085 F20 14 UN	12	8.5	10.7	6	20.9	22.0	84

Order example: FMT 08048 E12 20 UN MT8

* without internal coolant

BSPT

Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	RC1/16-1/8	MT0606C9 28 BSPT	6	6.0	3	9.5	58
19	RC1/4-3/8	MT0808C14 19 BSPT	8	8.0	3	14.0	64
14	RC1/2-7/8	MT1212D19 14 BSPT	12	12.0	4	19.1	84
11	RC1-2	MT1616D28 11 BSPT	16	16.0	4	28.9	105

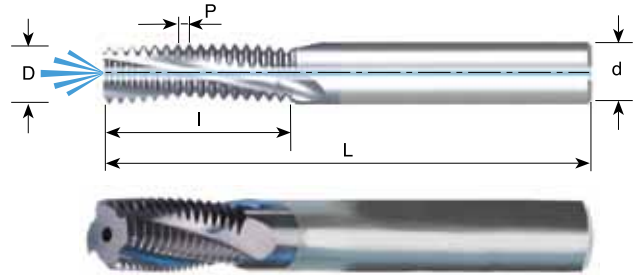
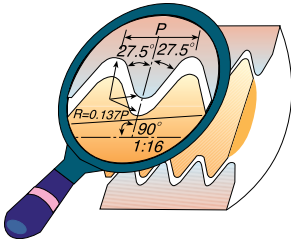
Order example: MT 1616D28 11 BSPT MT7

For thread mills with coolant through the flutes see next page

For conical preparation end mills see page 221

BSPT With internal coolant bore

Same Tool for Internal and External Thread

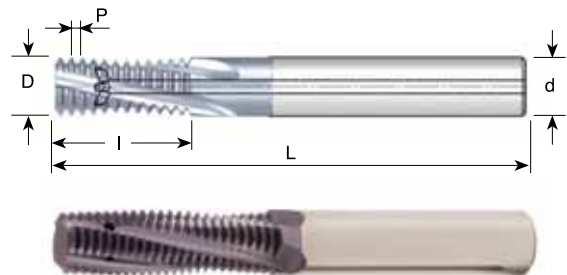
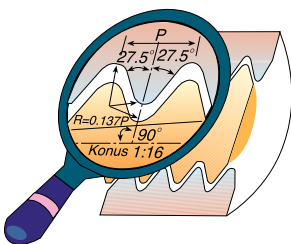


Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	RC1/8	MTB08078C14 28 BSPT	8	7.8	3	14.1	64
19	RC1/4-3/8	MTB1010D16 19 BSPT	10	10.0	4	16.7	73
14	RC1/2-7/8	MTB1616E26 14 BSPT	16	16.0	5	26.3	105
11	RC1-2	MTB1616D28 11 BSPT	16	16.0	4	28.9	105

Order example: MTB 08078C14 28 BSPT MT7

BSPT With internal coolant through the flutes

Same Tool for Internal and External Thread



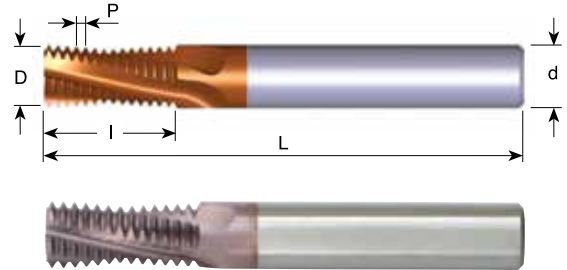
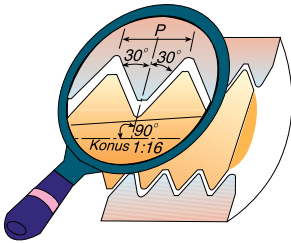
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	RC1/8	MTZ08078C14 28 BSPT	8	7.8	3	14.1	64
19	RC1/4-3/8	MTZ1010D16 19 BSPT	10	10.0	4	16.7	73
14	RC1/2-7/8	MTZ1616E26 14 BSPT	16	16.0	5	26.3	101
11	RC1-2	MTZ1616D28 11 BSPT	16	16.0	4	28.9	101

Order example: MTZ 1010D16 19 BSPT MT7

For conical preparation end mills see page 221

NPT

Same Tool for Internal and External Thread

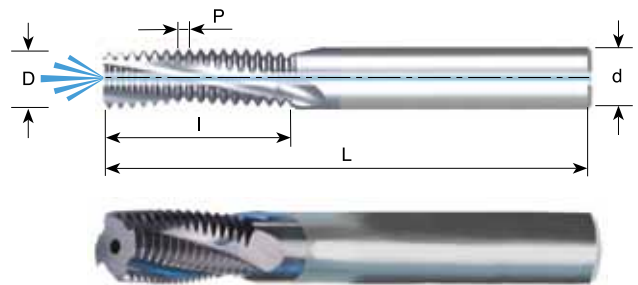


Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/16-1/8	MT0606C9 27 NPT	6	6.0	3	9.9	58
18	1/4-3/8	MT0808C14 18 NPT	8	8.0	3	14.8	64
14	1/2-3/4	MT1212D20 14 NPT	12	12.0	4	20.9	84
11.5	1-2	MT1616D27 11.5 NPT	16	16.0	4	27.6	105
8	≥2 1/2	MT2020D39 8 NPT	20	20.0	4	39.7	105

Order example: MT 0808C14 18 NPT MT7

NPT With internal coolant

Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTB08076C10 27 NPT	8	7.6	3	10.8	64
18	1/4-3/8	MTB1010D16 18 NPT	10	10.0	4	16.2	73
14	1/2-3/4	MTB16155D22 14 NPT	16	15.5	4	22.7	105
11.5	1-2	MTB2020D29 11.5 NPT	20	20.0	4	29.8	105
8	≥2 1/2	MTB2020D39 8 NPT	20	20.0	4	39.7	105

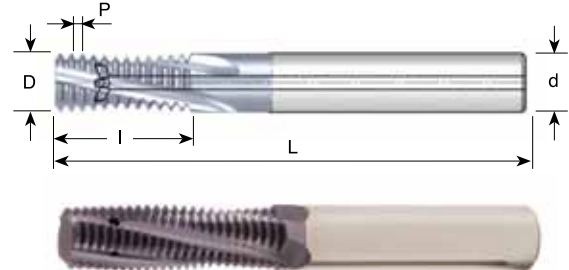
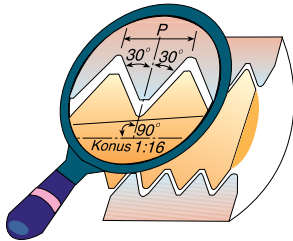
Order example: MTB 1010D16 18 NPT MT7

For thread mills with coolant through the flutes see next page

For conical preparation end mills see page 221

NPT With internal coolant through the flutes

Same Tool for Internal and External Thread

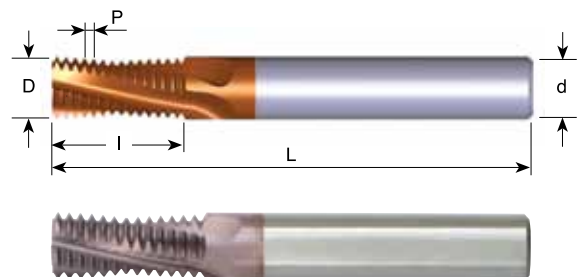
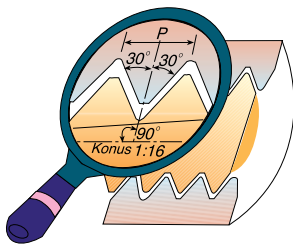


Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTZ08076C10 27NPT	8	7.6	3	10.8	64
18	1/4-3/8	MTZ1010D16 18NPT	10	10.0	4	16.2	73
14	1/2-3/4	MTZ16155D22 14NPT	16	15.5	4	22.7	101

Order example: MTZ 08076C10 27 NPT MT7

NPTF

Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/16-1/8	MT0606C9 27 NPTF	6	6.0	3	9.9	58
18	1/4-3/8	MT0808C14 18 NPTF	8	8.0	3	14.8	64
14	1/2-3/4	MT1212D20 14 NPTF	12	12.0	4	20.9	84
11.5	1-2	MT1616D27 11.5 NPTF	16	16.0	4	27.6	105
8	≥ 2 1/2	MT2020D39 8 NPTF	20	20.0	4	39.7	105

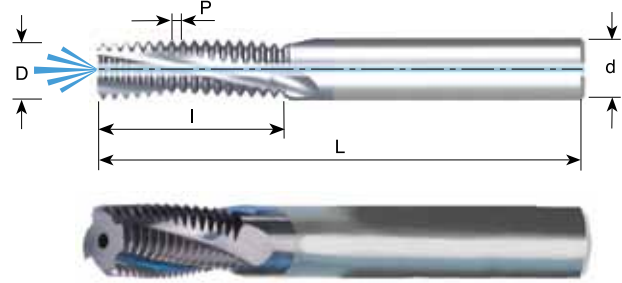
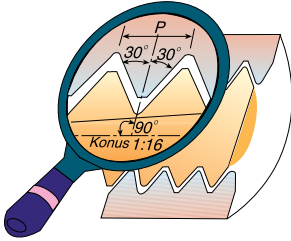
Order example: MT 1212D20 14 NPTF MT7

For thread mills with coolant bore see next page

For conical preparation end mills see page 221

NPTF With internal coolant bore

Same Tool for Internal and External Thread

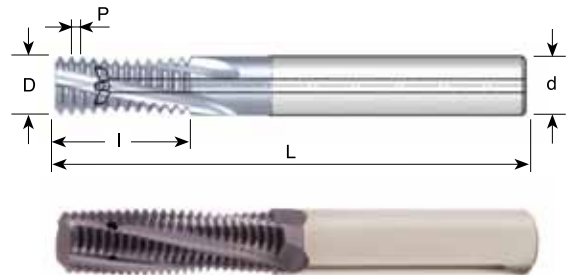
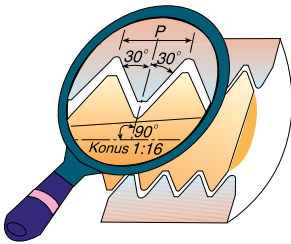


Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTB08076C10 27 NPTF	8	7.6	3	10.8	64
18	1/4-3/8	MTB1010D16 18 NPTF	10	10.0	4	16.2	73
14	1/2-3/4	MTB16155D22 14 NPTF	16	15.5	4	22.7	105
11.5	1-2	MTB2022D29 11.5 NPTF	20	20.0	4	29.8	105
8	≥ 2 1/2	MTB2020D39 8 NPTF	20	20.0	4	39.7	105

Order example: MTB 16155D22 14 NPTF MT7

NPTF With internal coolant through the flutes

Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTZ08076C10 27 NPTF	8	7.6	3	10.8	64
18	1/4-3/8	MTZ1010D16 18 NPTF	10	10.0	4	16.2	73
14	1/2-3/4	MTZ16155D22 14 NPTF	16	15.5	4	22.7	101

Order example: MTZ 1010D16 18 NPTF MT7

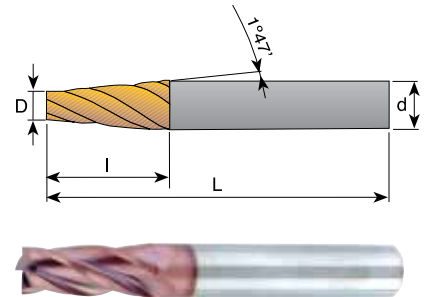
For conical preparation end mills see page 221

Solid Carbide Tapered End Mills

Solid carbide tapered end mills are used for milling preparation of conical threads before the thread milling operation.

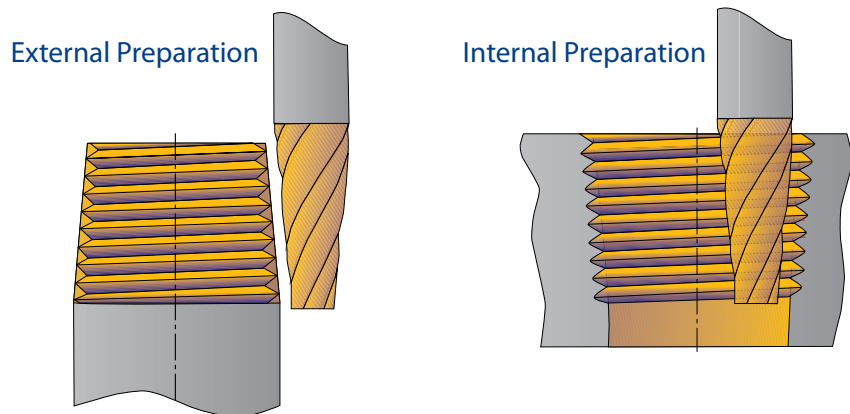
Advantages:

- * Increases the tool life of mill thread cutters and indexable inserts.
- * Equal and uniform load along the cutting edge of the mill thread cutter.
- * Shorter machining time during the mill thread operation, due to the tapered preparation.
- * Same tool for internal and external preparation.



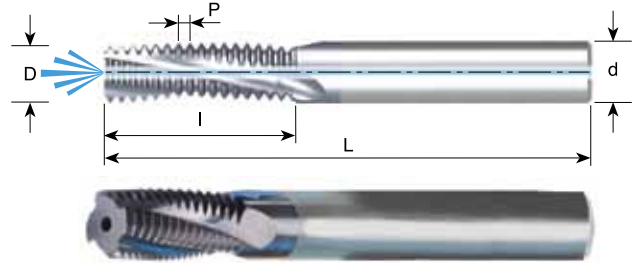
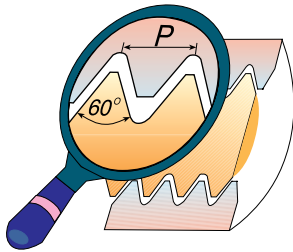
Ordering Code	d	D	l	L	No. of Flutes	Size
SC0652D12	6	5.2	12	58	4	NPT 1/16" - 1/8" NPTF 1/16" - 1/8" BSPT 1/16" - 1/8"
SC1085D24	10	8.5	24	73	4	NPT 1/8" - 1" NPTF 1/8" - 1" BSPT 1/8" - 1"
SC1210D32	12	10	32	84	4	NPT 1/4" - 3" NPTF 1/4" - 3" BSPT 1/4" - 3"

Order example: SC 1085D24 MT7
Carbide grade: MT7



NPS With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank

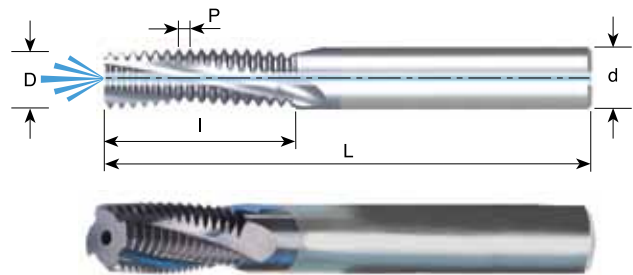
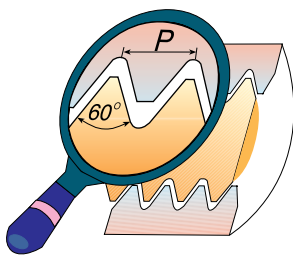


Pitch TPI	Standard	Ordering Code	d inch	D	No. of Flutes	I	L
27	1/8	MTB0312C04 27 NPS	5/16	7.6	3	10.8	63
18	1/4-3/8	MTB0375D06 18 NPS	3/8	9.5	4	16.2	76
14	1/2-3/4	MTB0625D08 14 NPS	5/8	15.5	4	22.7	101
11.5	1-2	MTB0750D11 11.5 NPS	3/4	19.0	4	29.8	101

Order example: MTB 0375D06 18 NPS MT7

NPSF With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank

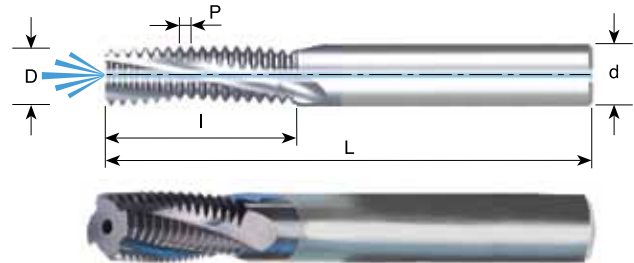
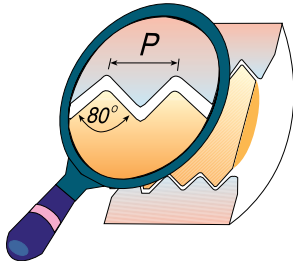


Pitch TPI	Standard	Ordering Code	d inch	D	No. of Flutes	I	L
27	1/8	MTB0312C04 27 NPSF	5/16	7.6	3	10.8	63
18	1/4-3/8	MTB0375D06 18 NPSF	3/8	9.5	4	16.2	76
14	1/2-3/4	MTB0625D08 14 NPSF	5/8	15.5	4	22.7	101
11.5	1-2	MTB0750D11 11.5 NPSF	3/4	19.0	4	29.8	101

Order example: MTB 0312C04 27 NPSF MT7

PG DIN 40430 - With internal coolant bore

Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
20	Pg 7	MTB1010D19 20 PG	10	10.0	4	19.7	73
18	Pg 9, 11, 13.5, 16	MTB1212D20 18 PG	12	12.0	4	20.5	84
16	Pg 21, 29, 36, 42, 48	MTB1212D23 16 PG	12	12.0	4	23.0	84

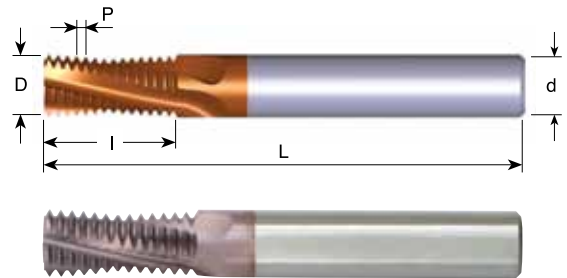
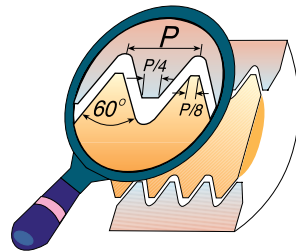
Order example: MTB 1212 D20 18 PG MT7

Mill - Thread Solid Carbide for External Threads

Advantages:

- * Excellent surface finish thanks to the spiral flutes
- * Short machining time due to multi 3 to 5 flutes

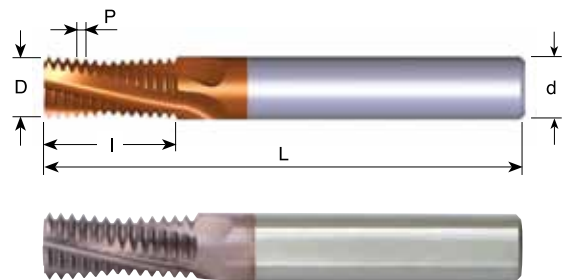
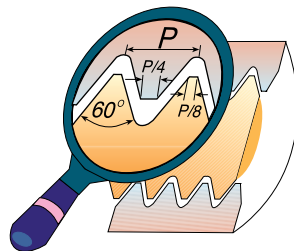
ISO



Pitch mm	Ordering Code	d	D	No. of Flutes	I	L
1.0	EMT1010D16 1.0 ISO	10	10.0	4	16.5	73
1.0	EMT1212E20 1.0 ISO	12	12.0	5	20.5	84
1.25	EMT1010D16 1.25 ISO	10	10.0	4	16.9	73
1.5	EMT1010D15 1.5 ISO	10	10.0	4	15.8	73
1.5	EMT1212D20 1.5 ISO	12	12.0	4	20.3	84
1.75	EMT1212D20 1.75 ISO	12	12.0	4	20.1	84
2.0	EMT1010C17 2.0 ISO	10	10.0	3	17.0	73
2.0	EMT1212D21 2.0 ISO	12	12.0	4	21.0	84

Order example: EMT 1010D15 1.5 ISO MT7

UN



Pitch TPI	Ordering Code	d	D	No. of Flutes	I	L
24	EMT1010D16 24 UN	10	10.0	4	16.4	73
20	EMT1212E21 20 UN	12	12.0	5	21.0	84
18	EMT1212D20 18 UN	12	12.0	4	20.5	84
16	EMT1212D21 16 UN	12	12.0	4	21.4	84
14	EMT1212D20 14 UN	12	12.0	4	20.9	84
12	EMT1212D20 12 UN	12	12.0	4	20.1	84

Order example: EMT 1212D20 18 UN MT7