

Carbide Grades

TIN

The TIN grade utilizes an ISO TIN carbide base grade but has the added benefit of a PVDTiN (Titanium Nitride) coating. TIN is our standard stocked grade and satisfies the greatest range of material applications. TIN should be the first choice for most applications.

TLN

TLN grade is a TiAlN (Titanium Aluminum Nitride), PVD coated grade recommended for difficult to machine alloys having work-hardening or abrasive wear characteristics. This could improve wear life in materials such as stainless steels, nickel alloys, most cast irons as well as graphite resin composites.

HSN

Our newest coating is a multi-layer hybrid nano coating. This new coating has very good heat resistance and high hardness. The HSN coating is designed for heat treated materials up to 72 HRc.

Tool Selection

There are 3 critical steps required for optimizing a thread milling operation for any thread to be produced.

1. **Tool Selection**
2. **Speed & Feed Selection**
3. **Preparing the CNC Program**

Selecting the best tool for a given job is made easier when all information is available.

Our technical service engineers will help you with any application you are considering and will guide you through every step of the process at no charge to you.

If you wish, you can fax a request by copying the Program Request form and request a suggested tool and cycle time for any application. (See page 40 for form)

Please fill out the information along with your fax number and a recommendation will be returned to you within 24 hours.



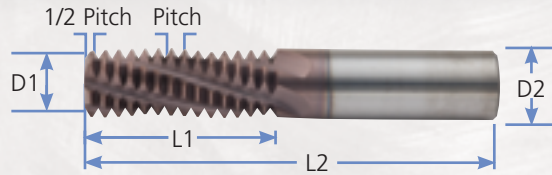
Mini Thread Mills HSN coated



All Single Thread

Thread Sizes	D1	L1	D3	Flutes	L2	D2	SKU
0-80	.045	0.125	0.030	1	1.50	.125	10M1000
2-56 2-64 M2.5x0.45	.064	0.172	0.030	3	1.50	.125	10M1002
4-40 4-48	.081	0.225	0.035	3	1.50	.125	10M1004
5-40 5-44 M3x0.5	.095	0.250	0.050	3	1.50	.125	10M1005
6-32 6-40	.095	0.375	0.050	3	1.50	.125	10M1006
8-32 8-36 M4-0.7	.115	0.350	0.070	3	1.50	.125	10M1008
M5-0.8	.140	0.375	0.100	3	2.00	.187	10M1085
	.165	0.500	0.100	3	2.00	.187	10M1009
10-24 10-32	.130	0.500	0.100	3	2.00	.187	10M1010
1/4-20 1/4-28 M6-1.0	.180	0.600	0.100	3	2.00	.187	10M1011
18-56	.240	1.00	0.115	4	2.50	.250	10M1012
12-32	.300	1.00	0.230	4	3.50	.375	10M1013
11-32	.490	1.25	0.300	5	3.50	.500	10M1014
4-12	.720	2	0.420	6	4.00	.750	10M1015

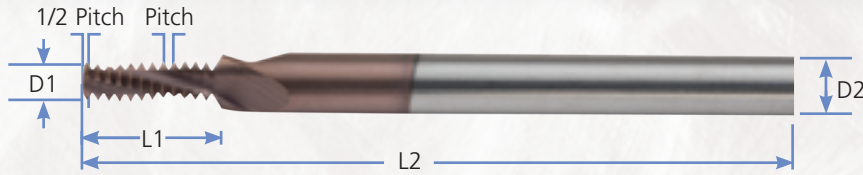
Solid Carbide Thread Mills



Helical Thread Mills HSN Coated

Tool Size	D2	D1	L1	L2	Flutes	SKU
4-40 UN	.125	0.085	0.175	2.00	3	04H1000
6-32 UN	.125	0.095	0.218	2.00	3	04H1001
8-32 UN	.125	0.115	0.25	2.00	3	04H1002
8-36 UN	.125	0.115	0.25	2.00	3	04H1003
10-24 UN	.187	0.12	0.312	2.00	3	04H1004
10-32 UN	.187	0.12	0.312	2.00	3	04H1005
1/4-20 UN	.187	0.18	0.5	2.50	3	04H1006
1/4-28 UN	.187	0.18	0.5	2.50	3	04H1007
5/16-18 UN	.250	0.24	0.625	2.50	3	04H1008
5/16-24 UN	.250	0.24	0.625	2.50	3	04H1009
3/8-16 UN	.312	0.29	0.75	3.00	4	04H1010
3/8-24 UN	.312	0.29	0.75	3.00	4	04H1011
7/16-14 UN	.375	0.34	0.875	3.00	4	04H1012
7/16-20 UN	.375	0.34	0.875	3.00	4	04H1013
1/2-13 UN	.375	0.35	0.875	3.50	4	04H1014
1/2-20 UN	.375	0.35	0.875	3.50	4	04H1015
9/16-12 UN	.500	0.37	0.875	3.50	4	04H1016
9/16-18 UN	.500	0.37	0.875	3.50	4	04H1017
5/8-11 UN	.500	0.47	1.25	3.50	5	04H1018
5/8-18 UN	.500	0.47	1.25	3.50	5	04H1019
3/4-10 UN	.500	0.495	1.25	3.50	5	04H1020
3/4-12 UN	.500	0.495	1.25	3.50	5	04H1021
3/4-16 UN	.500	0.495	1.25	3.50	5	04H1022
7/8-9 UN	.500	0.495	1.25	3.50	5	04H1023
7/8-14 UN	.500	0.495	1.25	3.50	5	04H1024
1-8 UN	.750	0.62	1.375	4.00	5	04H1025
1-12 UN	.750	0.62	1.375	4.00	5	04H1026

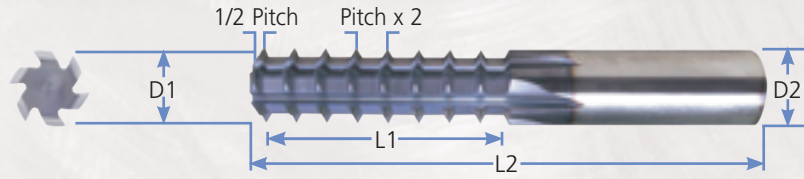
Solid Carbide Thread Mills



Helical Thread Mills HSN Coated - Straight Coolant Through

Tool Size	D2	D1	L1	L2	Flutes	SKU
1/4-20 UN C	.187	0.180	0.500	2.50	3	05H2006
1/4-28 UN C	.187	0.180	0.500	2.50	3	05H2007
5/16-18 UN C	.250	0.240	0.625	2.50	3	05H2008
5/16-24 UN C	.250	0.240	0.625	2.50	3	05H2009
3/8-16 UN C	.312	0.290	0.750	3.00	4	05H2010
3/8-24 UN C	.312	0.290	0.750	3.00	4	05H2011
7/16-14 UN C	.375	0.340	0.875	3.00	4	05H2012
7/16-20 UN C	.375	0.340	0.875	3.00	4	05H2013
1/2-13 UN C	.375	0.350	0.875	3.50	4	05H2014
9/16-12 UN C	.500	0.370	0.875	3.50	4	05H2015
9/16-18 UN C	.500	0.370	0.875	3.50	4	05H2016
5/8-11 UN C	.500	0.470	1.250	3.50	5	05H2017
5/8-18 UN C	.500	0.470	1.250	3.50	5	05H2018
3/4-10 UN C	.500	0.495	1.250	3.50	5	05H2019
3/4-12 UN C	.500	0.495	1.250	3.50	5	05H2020
3/4-16 UN C	.500	0.495	1.250	3.50	5	05H2021
7/8-9 UN C	.500	0.495	1.250	3.50	5	05H2022
7/8-14 UN C	.500	0.495	1.250	3.50	5	05H2023
1-8 UN C	.750	0.620	1.375	4.00	5	05H2024
1-12 UN C	.750	0.620	1.375	4.00	5	05H2025

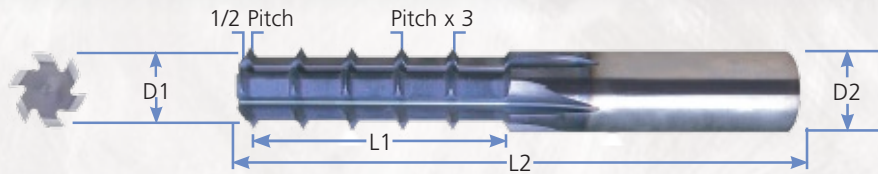
Solid Carbide Thread Mills



UN Internal Threads T2 Long Length

Min. Size	TIN	TLN	Pitch	Flutes	D2	D1	L2	L1
#4 - 40	0270800	0378800	40	3	0.125	0.085	1.50	0.224
#6 - 32	0270801	0378801	32	3	0.125	0.085	1.50	0.250
#8 - 32	0270802	0378802	32	3	0.125	0.120	1.50	0.328
1/4" - 28	0270813	0378813	28	3	0.188	0.160	1.97	0.500
1/4" - 28	0270814	0378814	28	3	0.250	0.180	2.95	0.786
#10 - 24	0270821	0378821	24	3	0.125	0.120	1.50	0.250
#12 - 24	0270815	0378815	24	3	0.187	0.140	2.56	0.500
5/16" - 24	0270816	0378816	24	3	0.250	0.200	2.56	0.833
3/8" - 24	0270822	0378822	24	5	0.250	0.240	2.56	0.750
1/4" - 20	0270803	0378803	20	3	0.187	0.160	2.56	0.500
7/16" - 20	0270817	0378817	20	5	0.313	0.310	3.35	1.000
5/16" - 18	0270804	0378804	18	3	0.250	0.200	2.95	0.625
5/8" - 18	0270819	0378819	18	5	0.500	0.437	3.94	1.375
3/8" - 16	0270805	0378805	16	5	0.250	0.240	2.95	0.750
11/16" - 16	0270820	0378820	16	5	0.500	0.470	3.94	1.375
7/16" - 14	0270806	0378806	14	5	0.313	0.310	3.35	0.875
1/2" - 13	0270807	0378807	13	5	0.313	0.310	3.35	1.000
9/16" - 12	0270808	0378808	12	5	0.375	0.370	3.35	1.125
3/4" - 12	0270818	0378818	12	5	0.500	0.470	3.94	1.500
5/8" - 11	0270809	0378809	11	5	0.500	0.437	3.94	1.250
3/4" - 10	0270810	0378810	10	5	0.500	0.470	3.94	1.500
7/8" - 9	0270811	0378811	9	6	0.625	0.620	4.50	1.750
1" - 8	0270812	0378812	8	6	0.625	0.620	4.50	2.000
1-1/8" - 7	0270823	0378823	7	6	0.625	0.620	4.50	1.857

Solid Carbide Thread Mills

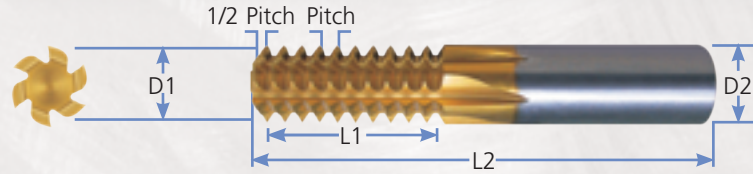


UN Internal Threads T3 Extra Long Length

Min. Size	TIN	TLN	Pitch	Flutes	D2	D1	L2	L1
# 4 - 40	0270900	0378900	40	3	0.125	0.080	1.65	0.336
# 6 - 32	0270901	0378901	32	3	0.125	0.085	1.65	0.375
# 8 - 32	0270902	0378902	32	3	0.125	0.120	1.65	0.492
# 12 - 28	0270913	0378913	28	3	0.187	0.160	2.37	0.750
1/4" - 28	0270914	0378914	28	3	0.250	0.180	2.90	0.750
# 10 - 24	0270921	0378921	24	3	0.125	0.120	1.50	0.375
# 12 - 24	0270915	0378915	24	3	0.187	0.140	2.56	0.625
5/16" - 24	0270916	0378916	24	3	0.250	0.200	2.75	0.958
3/8" - 24	0270920	0378920	24	5	0.250	0.240	2.95	1.000
1/4" - 20	0270903	0378903	20	3	0.187	0.160	2.56	0.750
7/16" - 20	0270917	0378917	20	5	0.312	0.310	3.35	1.200
5/16" - 18	0270904	0378904	18	3	0.250	0.200	2.95	0.937
3/8" - 16	0270905	0378905	16	5	0.250	0.240	2.95	1.125
7/16" - 14	0270906	0378906	14	5	0.312	0.310	3.35	1.286
1/2" - 13	0270907	0378907	13	5	0.312	0.310	3.35	1.500
9/16" - 12	0270908	0378908	12	5	0.375	0.370	3.35	1.687
3/4" - 12	0270918	0378918	12	5	0.500	0.470	3.94	2.000
5/8" - 11	0270909	0378909	11	5	0.500	0.437	4.35	1.909
3/4" - 10	0270910	0378910	10	5	0.500	0.470	3.94	2.250
7/8" - 9	0270911	0378911	9	6	0.625	0.620	5.13	2.333
1" - 8	0270912	0378912	8	6	0.625	0.620	4.10	1.875
1-1/8" - 7	0270919	0378919	7	6	0.625	0.620	4.10	2.000

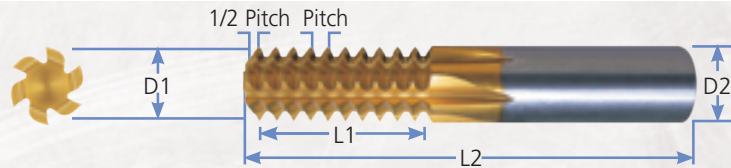
Min. Size: This is the smallest internal major thread diameter a tool of specific pitch and cutting diameter can produce. Any internal mill can be used to produce larger thread diameters as long as the L1 dimension exceeds the required length of full thread. Good machining practices dictate selecting a tool having sufficient mass to mill the desired pitch, thus reducing deflection and premature tool failure.

Solid Carbide Thread Mills



UN External Threads Standard Length

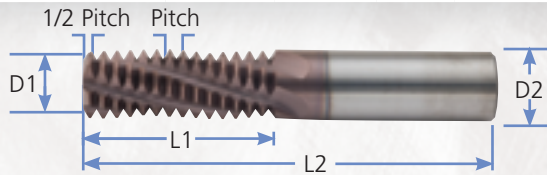
Min. Size	TIN	TLN	Pitch	Flutes	D2	D1	L2	L1
ALL 36 UN	0270208	0378208	36	5	0.250	0.240	2.25	0.2778
ALL 32 UN	0270200	0378200	32	5	0.250	0.240	2.25	0.5625
ALL 32 UN	0270209	0378209	32	5	0.375	0.370	2.84	0.9375
ALL 28 UN	0270201	0378201	28	5	0.312	0.310	2.48	0.7857
ALL 24 UN	0270210	0378210	24	5	0.312	0.310	2.48	0.7917
ALL 24 UN	0270211	0378211	24	5	0.375	0.370	2.84	1.0000
ALL 20 UN	0270202	0378202	20	5	0.375	0.370	2.84	0.9000
ALL 18 UN	0270203	0378203	18	5	0.375	0.370	2.84	0.9444
ALL 16 UN	0270204	0378204	16	5	0.500	0.470	3.27	1.1250
ALL 14 UN	0270212	0378212	14	5	0.312	0.310	2.48	1.6429
ALL 14 UN	0270213	0378213	14	5	0.500	0.470	3.27	1.1429
ALL 12 UN	0270205	0378205	12	5	0.500	0.470	3.27	1.1670
ALL 8 UN	0270206	0378206	8	6	0.625	0.620	3.62	1.5000
ALL 6 UN	0270207	0378207	6	6	0.750	0.745	4.10	1.5000



UNJ External Threads Standard Length

Min. Size	TIN	TLN	Pitch	Flutes	D2	D1	L2	L1
ALL 32 UNJ	0271000	0371800	32	5	0.250	0.240	2.25	0.5313
ALL 24 UNJ	0271001	0371801	24	5	0.375	0.370	2.84	0.9583
ALL 20 UNJ	0271002	0371802	20	5	0.375	0.370	2.84	0.9000
ALL 18 UNJ	0271003	0371803	18	5	0.312	0.310	2.48	0.7778
ALL 18 UNJ	0271004	0371804	18	5	0.500	0.470	3.27	1.1111
ALL 16 UNJ	0271005	0371805	16	5	0.312	0.310	2.48	1.0000
ALL 16 UNJ	0271006	0371806	16	5	0.500	0.470	3.27	1.1250
ALL 14 UNJ	0271007	0371807	14	5	0.500	0.470	3.27	1.1428
ALL 12 UNJ	0271008	0371808	12	5	0.500	0.470	3.27	1.1667

Solid Carbide Thread Mills



Helical NPT(F) Thread Mills - HSN Coated

Tool Size	D2	D1	L1	L2	Flutes	Coated SKU #	Tool Size	Coated SKU #
1/16" - 27 NPT	.250	.245	.437	2.50	3	08H2000		
1/8" - 27 NPT	.312	.310	.437	2.50	4	08H21001	1/8" - 27 NPTH	08H2005
1/4" & 3/8" - 18 NPT	.375	.305	.625	3.00	4	08H2002	1/4", 3/8" - 18 NPTH	08H2006
1/2" & 3/4" - 14 NPT	.500	.495	.875	3.50	4	08H2003	1/2" - 14 NPTH	08H2007
1" - 11.5 NPT	.750	.620	1.125	4.00	5	08H2004		

Helical NPT(F) Thread Mills with Straight Coolant - HSN Coated

Tool Size	D2	D1	L1	L2	Flutes	Coated SKU #	Tool Size	Coated SKU #
1/16" - 27 NPT	.250	.245	.437	2.50	3	08H2008		
1/8" - 27 NPT	.312	.310	.437	2.50	4	08H2009	1/8" - 27 NPTH	08H2013
1/4" & 3/8" - 18 NPT	.375	.305	.625	3.00	4	08H2010	1/4", 3/8" - 18 NPTH	08H2014
1/2" & 3/4" - 14 NPT	.500	.495	.875	3.50	4	08H2011	1/2" - 14 NPTH	08H2015
1" - 11.5 NPT	.750	.620	1.125	4.00	5	08H2012		

Helical BSPP Thread Mills - HSN Coated

Tool Size	D2	D1	L1	L2	Flutes	Coated SKU #
1/16", 1/8" - 28 BSPP	.250	.240	.572	2.50	3	09H2000
1/4" - 19 BSPP	.312	.312	.737	3.00	4	09H2001
1/2" - 14 BSPP	.500	.470	1.143	3.50	4	09H2002
1" - 11 BSPP	.625	.620	1.546	4.00	5	09H2003

Helical BSPP Thread Mills with Straight Coolant - HSN Coated

Tool Size	D2	D1	L1	L2	Flutes	Coated SKU #
1/16", 1/8" - 28 BSPP C	.250	.240	.572	2.50	3	09H2004
1/4" - 19 BSPP C	.312	.312	.737	3.00	4	09H2005
1/2" - 14 BSPP C	.500	.470	1.143	3.50	4	09H2006
1" - 11 BSPP C	.625	.620	1.546	4.00	5	09H2007

Helical BSPT Thread Mills - HSN Coated

Tool Size	D2	D1	L1	L2	Flutes	Coated SKU #
1/16", 1/8" - 28 BSPT	.250	.240	.401	2.50	3	09H2008
1/4" - 19 BSPT	.312	.312	.578	3.00	4	09H2009
1/2" - 14 BSPT	.500	.470	.785	3.50	4	09H2010
1" - 11 BSPTP	.625	.620	1.546	4.00	5	09H2011

Helical BSPT Thread Mills with Straight Coolant - HSN Coated

Tool Size	D2	D1	L1	L2	Flutes	Coated SKU #
1/16", 1/8" - 28 BSPT C	.250	.240	.401	2.50	3	09H2012
1/4" - 19 BSPT C	.312	.312	.578	3.00	4	09H2013
1/2" - 14 BSPT C	.500	.470	.785	3.50	4	09H2014
1" - 11 BSPT C	.625	.620	1.546	4.00	5	09H2015

Suggested Speeds And Feeds

Tool Shank Diameter and Number of Flutes SFPM and Feed, Inches per Tooth

Material	Class	1/8" 3	3/16" 3	1/4" 3	5/16" 4	3/8" 4	1/2" 5	3/4" 5
1. Steel	Plain and Low Carbon to 22 HRc	600 .003	600 .003	600 .004	600 .005	600 .005	600 .006	600 .006
2. Medium Carbon & Alloy Steels	Carbon and Alloys to 32 HRc	575 .001	575 .002	575 .003	575 .003	575 .003	575 .004	575 .004
3. Medium Carbon & Alloy Steels	Carbon and Alloys 32 HRc to 42 HRc	525 .003	525 .003	525 .004	525 .005	525 .005	525 .006	525 .006
4. Stainless Steels	Austenitic	525 .001	525 .001	525 .0015	525 .0015	525 .002	525 .003	525 .004
5. Stainless Steels	Martensitic	550 .001	550 .001	550 .0015	550 .0015	550 .002	550 .003	550 .004
6. Stainless Steels	Precipitation Hardening	300 .001	300 .001	300 .001	300 .0015	300 .0015	300 .002	300 .002
7. Nickel	Nickel Base Alloys	120 .0005	120 .0005	120 .001	120 .001	120 .0015	120 .002	120 .002
8. Titanium	Titanium Alloys	100 .0005	100 .0005	100 .001	100 .001	100 .0015	100 .002	100 .002
9. Cast Iron	Gray, Malleable & Ductile	600 .001	600 .0015	600 .0015	600 .002	600 .003	600 .004	600 .004
10. Non-Ferrous	Low Si Cast & Aluminum	1,700 .002	1,700 .002	1,700 .003	1,700 .003	1,700 .004	1,700 .005	1,700 .005

Carbide Grades

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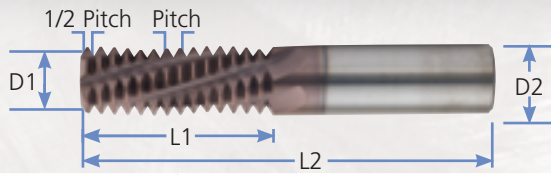
Mini Thread Mills HSN coated



All Single Thread - HSN Coated

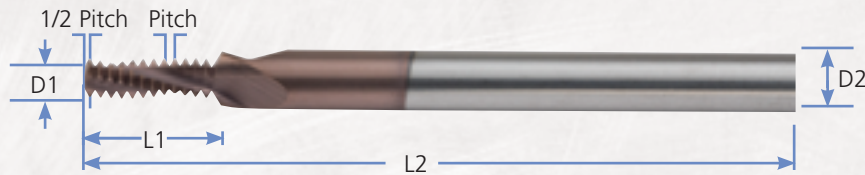
Thread Sizes	D1	L1	D3	Flutes	L2	D2	SKU
0-80	1,1	6,4	0,8	1	51	4	11M1000
2-56 2-64 M2.5x0.45	1,6	6,4	0,8	3	51	4	11M1001
4-40 4-48	2,2	6,4	0,9	3	51	4	11M1002
5-40 5-44 M3x0.5	2,4	6,4	1,3	3	51	4	11M1003
6-32 6-40	2,4	9,5	1,3	3	51	4	11M1004
8-32 8-36 M4-0.7	2,9	9,5	1,8	3	51	4	11M1005
M5-0.8	3,6	9,5	2,5	3	58	6	11M1006
10-24 10-32	3,3	12,7	2,5	3	58	6	11M1007
1/4-20 1/4-28 M6-1.0	4,6	15,2	2,5	3	58	6	11M1008
18-56	6,1	25,4	2,9	3	58	6	11M1009
12-32	7,6	25,4	5,8	4	73	10	11M1010
11-32	11,9	31,8	7,6	5	84	12	11M1011
4-12	15,9	50,8	8,1	6	93	16	11M1012

Solid Carbide Thread Mills



Helical Thread Mills HSN Coated

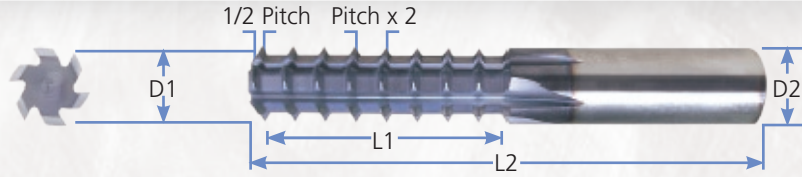
Tool Size	D2	D1	L1	L2	Flutes	SKU
M4-0.70M	4	2,8	8,4	51	3	06H2000
M5-0.80M	4	3,5	10,4	51	3	06H2001
M6-1.00M	4	3,9	12	51	3	06H2002
M8-0.75M	6	5,9	16	58	3	06H2003
M8-1.00M	6	5,9	16	58	3	06H2004
M8-1.25M	6	5,9	16,25	58	3	06H2005
M10-1.25M	8	7,7	20	64	4	06H2006
M10-1.50M	8	7,7	21	64	4	06H2007
M12-1.00M	10	9,9	24	73	4	06H2008
M12-1.50M	10	9,4	24	73	4	06H2009
M12-1.75M	10	8,7	24,5	73	4	06H2010
M14-1.50M	12	11,2	28,5	84	4	06H2011
M16-2.00M	12	11,9	32	84	5	06H2012
M18-2.5M	16	13,9	40	93	5	06H2013
M20,M24-3.00M	16	15,9	42	93	5	06H2014



Helical Thread Mills HSN Coated - Straight Coolant Through

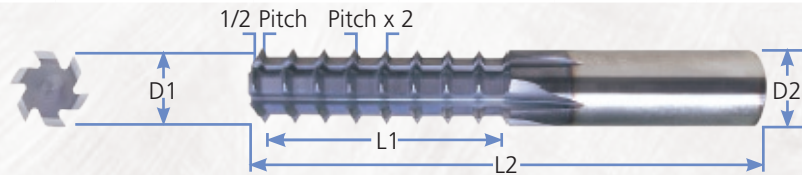
Tool Size	D2	D1	L1	L2	Flutes	SKU
M8-0.75M-C	6	5,9	16	58	3	07H2003
M8-1.00M-C	6	5,9	16	58	3	07H2004
M8-1.25M-C	6	5,9	16,25	58	3	07H2005
M10-1.25M-C	8	7,7	20	64	4	07H2006
M10-1.50M-C	8	7,7	21	64	4	07H2007
M12-1.00M-C	10	9,9	24	73	4	07H2008
M12-1.50M-C	10	9,4	24	73	4	07H2009
M12-1.75M-C	10	8,7	24,5	73	4	07H2010
M14-1.50M-C	12	11,2	28,5	84	4	07H2011
M16-2.00M-C	12	11,9	32	84	5	07H2012
M18-2.5M-C	16	13,9	40	93	5	07H2013
M20,M24-3.00M-C	16	15,9	42	93	5	07H2014

Solid Carbide Thread Mills



ISO Metric Straight Flute Internal TLN Coated - Long Length

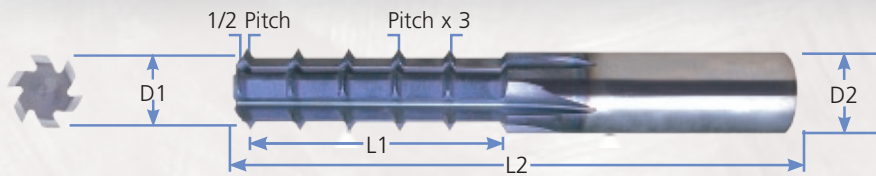
Min. Size	SKU	Pitch	L2	L1	D2	D1	Flutes
M 4	78850	0,70 ISO-T2	38	8,40	3,0	2,60	3
M 5	78851	0,80 ISO-T2	42	11,20	4,0	3,60	3
M 6	78852	1,00 ISO-T2	57	12,00	6,0	4,00	3
M 8	78853	1,25 ISO-T2	62	17,50	6,0	5,00	3
M 10	78854	1,50 ISO-T2	62	21,00	6,0	5,90	5
M 12	78855	1,75 ISO-T2	74	24,50	8,0	7,90	5
M 14	78856	2,00 ISO-T2	86	28,00	10,0	9,90	5
M 16	78857	2,00 ISO-T2	95	32,00	12,0	11,90	5
M 20	78858	2,50 ISO-T2	95	40,00	12,0	11,90	5



ISO Internal Fine Pitch TLN Coated - Long Length

Min. Size	SKU	Pitch	L2	L1	D2	D1	Flutes
M8	78859	0,75 ISO-T2	62	16,50	6,0	5,90	5
M12	78860	1,00 ISO-T2	74	24,00	8,0	7,90	5
M16	78861	1,00 ISO-T2	95	32,00	12,0	11,90	5
M14	78862	1,50 ISO-T2	86	30,00	10,0	9,90	5
M16	78863	1,50 ISO-T2	95	36,00	12,0	11,90	5
M18	78864	2,00 ISO-T2	95	32,00	12,0	11,90	5

Solid Carbide Thread Mills



ISO Metric Straight Flute Internal TLN Coated - Extra Long Length

Min. Size	SKU	Pitch	L2	L1	D2	D1	Flutes
M4	78950	0,70 ISO-T3	42	12,60	3,0	2,60	3
M5	78951	0,80 ISO-T3	47	16,80	4,0	3,60	3
M6	78952	1,00 ISO-T3	60	18,00	6,0	4,00	3
M8	78953	1,25 ISO-T3	65	26,25	6,0	5,00	3
M10	78954	1,50 ISO-T3	72	31,50	6,0	5,90	5
M12	78955	1,75 ISO-T3	86	36,75	8,0	7,90	5
M14	78956	2,00 ISO-T3	95	42,00	10,0	9,90	5
M16	78957	2,00 ISO-T3	115	48,00	12,0	11,00	5
M20	78958	2,50 ISO-T3	115	80,00	12,0	11,90	5

Suggested Speeds And Feeds

Tool Shank Diameter and number of flutes Cutting Speed and Feed per Tooth

Material	Class	4mm	6mm	8mm	10mm	12mm	16mm
		3	3	3	4	4	5
1. Steel	Plain and Low Carbon to 22 HRc	185 0,075	185 0,075	185 0,100	185 0,125	185 0,125	185 0,150
2. Medium Carbon & Alloy Steels	Carbon and Alloys to 32 HRc	175 0,025	175 0,050	175 0,075	175 0,075	175 0,075	175 0,125
3. Medium Carbon & Alloy Steels	Carbon and Alloys 32 HRc to 42 HRc	160 0,075	160 0,075	160 0,100	160 0,125	160 0,125	160 0,150
4. Stainless Steels	Austentic	160 0,025	160 0,025	160 0,038	160 0,038	160 0,050	160 0,075
5. Stainless Steels	Martensitic	165 0,025	165 0,025	165 0,038	165 0,038	165 0,050	165 0,075
6. Stainless Steels	Precipitation Hardening	90 0,025	90 0,025	90 0,025	90 0,038	90 0,038	90 0,050
7. Nickel	Nickel Base Aloys	36 0,012	36 0,012	36 0,025	36 0,025	36 0,038	36 0,050
8. Titanium	Titanium Alloys	30 0,012	30 0,012	30 0,025	30 0,025	30 0,038	30 0,050
9. Cast Iron	Gray, Malleable & Ductile	185 0,025	185 0,038	185 0,038	185 0,050	185 0,075	185 0,100
10. Non-Ferrous	Low Si Cast & Aluminum	500 0,050	500 0,050	500 0,075	500 0,075	500 0,100	500 0,150